

# LUBRICUT 4215

SYNTHETIC METAL WORKING FLUID FOR FERROUS ROLL GRINDING OPERATIONS

## ▶ PRODUCT DESCRIPTION

**Lubricut 4215** is a light duty, synthetic coolant formulated for general roll grinding operations on ferrous alloys only. Lubricut 4215 provides an optimum balance of cooling, detergency, corrosion protection, and work-piece visibility for turbulent roll grinding operations.

Lubricut 4215 offers low foaming properties in most grinding operations. A special corrosion inhibitor blend offers excellent protection against corrosion and staining of grey iron, cast iron, and ferrous alloys and for freshly ground ferrous surfaces. Lubricut 4215 is stable in both hard and soft water. Lubricut 4215 comes packaged as a highly concentrated form.

Lubricut 4215 does not leave a sticky or tacky residue on machined surfaces. The residue is very fluid-like and will not gum up ways or stick switches. Lubricut 4215 readily rejects most tramp oils, which may be easily removed with standard skimmers and other removal systems. Lubricut 4215 contains no triazine biocides. Lubricut 4215 can also be utilized as a leak detection or non-destructive test fluid for ferrous metals or ferrous alloy assemblies. Lubricut 4215 is also available in a blue version. For operations requiring additional alkalinity or enhanced corrosion protection, Lubricut 4125-M is recommended.

## ▶ FEATURED BENEFITS

- True solution chemistry and low foaming properties assure clean, clear workpiece visibility
- Imperceptible thin film corrosion preventative provides excellent tack free in-process rust protection
- Exceptional hard water stability keeps windows clean and grinding wheels free from buildup
- Additive Independent: No need for tank side pH buffers, emulsifiers, or costly and hazardous biocide
- Oil rejecting properties keep the sump clean and free of odor causing bacteria and fungus
- Freeze-thaw stable
- Low to non-foaming use dilutions
- Contains no Triazine or Formaldehyde releasers

## ▶ APPROVALS

- Super-compliant for California SCAQMD Rule 1144

## APPLICATION



### COMPATIBLE METALS

Cast Iron  
Carbon Steel  
Tool Steel  
Stainless Steel  
Titanium  
Bronze  
Copper  
Brass

### MACHINING CAPABILITIES

OD/ID/Centerless Grinding

### ALL METAL SAFE

No

### REFRACT INDEX

2.7





## TYPICAL PROPERTIES

Fluid Type	Synthetic
Appearance	Clear to slight haze
Odor	Mild chemical
Specific Gravity, 60°F (15.6°C)	1.05 – 1.08
Weight, 60°F (15.6°C)	8.96 lbs/gal.
Freezing Point	32°F (0°C)
pH (concentrate)	9.2 – 10.2
pH (5% dilution)	8.6 – 9.6
Alkalinity, concentrate (meq/gram)	2.3 – 2.6
VOC, ASTM E 1868	39.8 grams/liter

## PRODUCT APPLICATION / USAGE

Lubricut 4215 is recommended for general purpose machining of aluminum alloys, non-ferrous and aluminum alloys, and tougher exotic alloys (both non-ferrous and ferrous).

Operation	Carbon Steels	Malleable Iron, Cast Iron
Grinding: I.D., O.D., Blanchard, Double Disk	4 – 6%	4 – 6%

## MIXING DATA

Lubricut 4215 metalworking fluid is to be mixed with water for use. Add product to water with moderate agitation for mixing. The ideal concentration ratio should fall between 4% and 6% and can easily be monitored by refractometer or alkaline titration using the Chemtool titration kit.

Concentration	10%	6%	5%	4%	3%
Refractometer Reading	3.6	2.3	1.9	1.5	1.2
Alkalinity (factor = 0.30) Titration Test Kit	31	20	15	13	12

## PRODUCT CODE

2667900000

## HEALTH AND SAFETY

For health and safety guidance, please refer to the Chemtool SDS (Safety Data Sheets).