

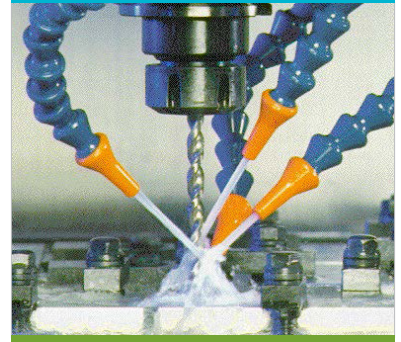
LUBRICUT 4235

METALWORKING FLUID

▷ PRODUCT DESCRIPTION

Lubricut 4235 is a synthetic metalworking fluid designed for grinding and light duty machining of ferrous metals such as cast iron, grey iron, and high alloy steel. Lubricut 4235 can also be used for light to medium duty operations on copper alloys. This product has very good fines settling characteristics that prevent build up on grinding wheels. It provides an optimum balance of lubricity and detergency for quality finishes on machined parts. A special corrosion inhibitor package gives excellent protection against rust and corrosion of grey-iron while leaving a very light, fluid film. Performance characteristics can be optimized by controlling concentration between 3% and 6%.

APPLICATION



COMPATIBLE METALS

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

MACHINING CAPABILITIES

- Milling
- Turning
- Sawing
- Drilling
- Reaming
- Tapping
- OD/ID/Centerless Grinding

ALL METAL SAFE

No

REFRACT INDEX

2.9





TYPICAL PROPERTIES

| | |
|---------------------------------|----------------------|
| Fluid Type | Synthetic |
| Appearance | Clear liquid or blue |
| Odor | Mild chemical odor |
| Specific Gravity, 60°F (15.6°C) | 1.045 |
| Weight, 60°F (15.6°C) | 8.70 lbs/gal. |
| Freezing Point | 32°F (0°C) |
| pH (concentrate) | 9.40 |
| pH (5% dilution) | 9.00 |
| Alkalinity, concentrate | 1.8 meq/gram |

NOTE: Product remains stable through five (5) freeze/thaw cycles

PRODUCT APPLICATION / USAGE

Lubricut 4235 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, Cast Iron | High Alloy Steels | Copper Alloys |
|----------------------------------|--------------------------|-------------------|---------------|
| Milling, Drilling, Turning | 4% | 5% | 4% |
| Form Milling, Sawing | 5% | 5 – 6% | 4 – 5% |
| Grinding: I.D., O.D., Centerless | 4% | 5% | 4% |

MIXING DATA

Lubricut 4235 metalworking fluid with water for use. Add product to water with moderate agitation for mixing. The ideal concentration ratio should fall between 3% 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 | 3.7 | 2.3 | 1.9 | 1.6 | 1.2 |
| Drops 0.5N HCl | 23 | 14 | 12 | 10 | 8 |

PRODUCT CODE

2668200000

HEALTH AND SAFETY

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