

# LUBRICUT 4250

## SYNTHETIC METALWORKING FLUID FOR FERROUS MACHINING OPERATIONS

### ▷ PRODUCT DESCRIPTION

**Lubricut 4250** is a moderate duty, synthetic coolant formulated for general machining operations on ferrous alloys and powdered metals only. Lubricut 4250 provides an optimum balance of cooling, detergency, corrosion protection and work-piece visibility in turbulent machining operations. Lubricut 4250 exhibits low foaming properties in most machining operations. A balanced corrosion inhibitor blend offers excellent protection against corrosion and staining of gray iron, cast iron, and ferrous alloys. Lubricut 4250 dilutions are stable in both hard and soft water.

Lubricut 4250 does not leave a sticky or tacky residue on machined parts with a fluid-like residue that will not gum up ways or stick switches. Lubricut 4250 readily rejects most tramp oils which can then be easily removed with an oil skimmer. Lubricut 4250 can also be utilized as a light duty grinding fluid for ferrous alloys or as a leak detection or non-destructive test fluid for ferrous metals or ferrous alloy assemblies.

Lubricut 4250 is also available in a blue version as Lubricut 4250 Blue. For operations requiring moderate lubrication and balanced corrosion protection on ferrous alloys and powdered metals, Lubricut 4250 is an ideal choice.

### ▷ FEATURED BENEFITS

- Updated technology, synthetic fluid based upon polymeric lubricants
- Offers exceptional wetting and coverage properties on ferrous alloys and powdered metals
- Enhanced biostability for long performance life
- Formulated with reserve alkalinity for stable pH values
- Excellent corrosion protection for ferrous metals
- Readily rejects all tramp oil contaminants.
- Low residue properties for effective housekeeping
- Low consumption rates
- Outstanding product selection for fluid recycling systems
- Disperses swarf for effective removal by standard filtering methods
- Very versatile multi-purpose synthetic for all machining applications
- Triazine and formaldehyde free

### APPLICATION



#### COMPATIBLE METALS

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

#### MACHINING CAPABILITIES

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

#### HIGH PRESSURE COOLANT CAPABILITY

Yes

#### ALL METAL SAFE

Yes

#### REFRACT INDEX

2.7





## TYPICAL PROPERTIES

Fluid Type	Synthetic
Appearance	Clear amber liquid
Odor	Neutral / mild chemical odor
Specific Gravity, 60°F (15.6°C)	1.05
Weight, lb/gal., 60°F (15.6°C)	8.75
pH (concentrate)	9.70
pH (10% dilution)	9.20
Rust Test: CIC (3% in 27 grain H2O)	None
Freeze/Thaw	Stable
Heat stability	Pass

## PRODUCT APPLICATION / USAGE

Lubricut 4250 metalworking fluid is designed to be used for light to moderate duty machining operations for ferrous alloys and powdered metals only. Suggested starting concentrations are presented in the accompanying table. Optimal use concentrations should always be determined by use conditions (water chemistry, system design, metallurgical composition, type of operation, finish requirements and filtering parameters). Lubricut 4250 can also be utilized as light duty grinding fluid or as a leak detection or non-destructive test fluid for ferrous metals or ferrous alloy assemblies.

Operation	Cast Iron	Carbon Steels	High Alloy Steels
Milling, Drilling, Turning	6–8%	6–11%	6–12%
Reaming, Light Duty Broaching, Tapping, Sawing	6–10%	6–13%	6–15%
Grinding: I.D., O.D.	6–8%	6–8%	6–9%

## MIXING DATA

Lubricut 4250 metalworking fluid is to be mixed with water for use. Always add product concentrate to the water, not water to product concentrate. Add with mild agitation. Product concentration can easily be monitored by refractometer.

Concentration	14.0%	12.0%	10.0%	8.0%	4.0%
Refractometer Reading	5.2	4.4	3.7	3.0	1.5

## PRODUCT CODE

2666600000

## HEALTH AND SAFETY

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