

LUBRICUT 1144 TM

SEMI-SYNTHETIC METALWORKING FLUID:
HIGH PERFORMANCE FOR ALL METALS – CHLORINATED

▶ PRODUCT DESCRIPTION

Lubricut 1144 TM is a high performance, versatile EP (extreme pressure) fortified semi-synthetic based, metalworking fluid designed specifically for demanding precision applications on both ferrous and aluminum alloys. Formulated with the latest chemical innovations for lubricity, wetting, and corrosion prevention available, Lubricut 1144 TM sets the standard for superior performance. The unique emulsifier and detergency package prevents bacterial problems and hard water soap formation typical of traditional soluble oil metalworking fluids. Lubricut 1144 TM also incorporates a very high viscosity base oil blend for increased boundary film lubrication and superior film strength on all machined/ground surfaces. Lubricut 1144 TM is enhanced with specialized corrosion inhibitors, which offer outstanding corrosion protection/anti-staining properties on aluminum alloys. Lubricut 1144 TM contains a balanced lubrication regime of both chlorine and esters for optimal performance.

▶ FEATURED BENEFITS

- Sulfonate Free Chemistry: Biostable chemistry maintains pH and alkalinity, eliminating objectionable “Monday Morning Odors”
- Hard Water Stable: LC 1144 TM exhibits twice the hard water stability of traditional soluble oils, thereby maintaining a stable emulsion for better wetting and lubricity
- Additive Independent: No need for tank side pH buffers, emulsifiers, or costly and hazardous biocides
- Optimal Lubrication Regime: LC 1144 TM combines the need for chlorine with a unique blend of synthetic esters and high molecular weight base oils
- Balanced corrosion inhibition system for both non-ferrous and ferrous metals
- Triazine free
- Can be used as a general forming lubricant for all metals reducing the need for multiple products
- Enhanced secondary emulsifier system for rapid bloom and mixing characteristics: enhanced emulsion integrity
- Excellent tolerance and micro-finish capabilities
- Triazine free

APPLICATION



COMPATIBLE METALS

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

MACHINING CAPABILITIES

Milling
Turning
Sawing
Drilling
Reaming
Tapping
OD/ID/Centerless Grinding
Burnishing
Light Duty Hobbing & Broaching
Roll Forming
Medium-Duty Stamping & Drawing

HIGH PRESSURE COOLANT CAPABILITY

Yes

ALL METAL SAFE

Yes

REFRACT INDEX

1.25





TYPICAL PROPERTIES

Fluid Type	Semi-synthetic
Appearance	Amber liquid
Odor	Mild odor
Specific Gravity, 60°F (15.6°C)	1.035
Weight, lb/gal., 60°F (15.6°C)	8.53
pH (10% dilution)	9.70
Biostability	Excellent

Product separates upon freezing. Thaw completely at room temperature and mix thoroughly prior to use.

PRODUCT APPLICATION / USAGE

Lubricut 1144™ is recommended for general purpose and high performance machining and grinding of ferrous and non-ferrous alloys.

Operation	Carbon Steels, Cast Iron	High Alloy Steels	Aluminum Alloys
Milling, Drilling, Turning	6–7%	8–12%	7–13%
Reaming, Light Duty Broaching, Tapping, Sawing	6–8%	8–12%	7–15%
Grinding: I.D., O.D.	6–7%	6–7%	6–7%

MIXING DATA

Lubricut 1144™ 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	15.0%	12.5%	10.0%	7.5%	5.0%
Refractometer Reading	11.5	9.6	7.7	5.8	3.8

PRODUCT CODE

2312000000

HEALTH AND SAFETY

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