



## LUBRO SINT LF

Lubro-refrigerant free of mineral oil

### FEATURES

High performing synthetic lubro-refrigerant liquid soluble in water, indicated for all operations where the quality of the surface finish and lubricating properties are an essential requirement.

LUBRO SINT LF does not contain mineral oil, but exclusively synthetic lubricants; it is emulsifiable in water and boasts a low environmental impact. It allows performing any type of cutting process on any material.

Recommended for demanding operations on cast iron, steel, stainless steel and aluminium.

- Free of mineral oil
- Free of chlorine
- Bio resistant
- Free of secondary amines
- Excellent anti-foam properties
- High anti-rust performances

### METHODS OF USE

	1	2	3	4	5	1: Turning 2: Milling 3: Threading 4: drilling 5: broaching
STEEL	0	0	0	0	0	
STAINLESS STEEL	0	0	0	0	0	
TITANIUM	X	X	X	X	X	
CAST IRON	0	0	0	0	0	
ALUMINIUM	0	0	0	0	0	
0: highly recommended				X: usable		

The essential rule to follow when using a lubro-refrigerant consists in cleaning the vats thoroughly before loading them. Any residue of dirt, pollutant and previous processes must be removed, and the entire circuit must be washed. After rinsing thoroughly, the new solution can be poured in the vat in suitable concentration, according to the type of process that will be performed. The percentages of use of the product cannot be established beforehand, since many contingent factors influence them. The concentration of use ranges from 4 to 7%.

These values must also be adapted to the type of process and water hardness. In case of particularly hard waters, the ratio must be increased by few percentage points. The best performances are obtained with water hardness between 25°-40°F.

### **PHYSICAL- CHEMICAL DATA (PRODUCT)**

Aspect: clear

Viscosity: 42 (mm<sup>2</sup>/s, 40°C)

Density: 990 (mm<sup>3</sup>, 15°C)

Pour point: <4 (°C)

### **PHYSICAL- CHEMICAL DATA (EMULSION)**

Aspect: whitish

pH: 9.30 (5% in water)

Corrosion: 4.0 (%DIN 51362 T2)

Alkalinity factor: 3.3 (ml0.1N HCl% 25 ml)

Refractometric factor: 1.5 (% Brix)