



#80901

DIRECTIONS FOR USE:

For general purpose, use a dilution of 1-part oil to 40-parts water. For grinding and light duty work, a 1-to-60 dilution is adequate.

For true emulsion, OIL SHOULD BE ADDED TO WATER and mixed with agitation in a container outside of the machine tool sump.

Do not use with magnesium.

DESCRIPTION:

LUBEGARD Cutting Oil is a heavy duty water emulsion coolant designed for use in all metal cutting processes. Made without any chlorinated components that can leave machined parts weaker, it is approved by the aerospace industry for the most difficult machining jobs, such as titanium, chrome moly and tool steels. The LXE Technology made from renewable agricultural resources, resists the absorption of tramp oils, which contributes to a longer sump life. Dilution ratios are greater than other coolants (up to 40:1 for machining operation, up to 80:1 for grinding) allowing some distinct cost advantages.

For use in a wide range of metal working operations such as; fabricating, forming, stamping, turning, milling sawing, bending, broaching and tapping.

BENEFITS:

- Safe and easy to use and clean up
- Works at lower concentrations, saves on makeup and disposal
- Extends sump drain intervals
- Reduces worker dermatitis and asthma-related symptoms
- Water washable
- Non-flammable
- No obnoxious fumes
- Reduces friction for longer tool life
- Improves tool performance
- Effective for all cutting operations on transition metals
- Non-hazardous; relieving the hassle of storing regulated chemicals
- Does not contain chlorine compounds, phenols, toxic metals
- Allows for an easier & lower cost disposal
- Resists rusting
- Better high temperature cooling with less smoking
- Suitable for the most demanding machine operations
- SAVES MONEY! Commonly runs at 40:1 so you buy, and dispose of less oil

AVAILABILITY:

| Stock No. | Unit Size | Case Weight/QNTY |
|-----------|-----------|------------------|
| 80901 | 1 gal. | 12.5 lbs. (4/c) |
| 80905 | 5 gal. | NA |
| 80955 | 55 gal. | NA |



Bob Warnke

"If you don't have access to a continuous flow reaming station, LUBEGARD Bio-Tap (#81915) has excellent cutting and

lubrication qualities. Bio-Tap is often used during reaming demonstrations, when a continuous coolant is not available. With these add-in fluids, the chips must be flushed manually to obtain the proper finish and extend reamer life.



#81915

I prefer the water soluble reaming fluids. The continuous flow removes chips, (when mixed properly), improves the surface finish, and extends the life of the reamer. In this instance, I use **LUBEGARD Heavy Duty Water Soluble Cutting Oil (#80901)**, and mix it slightly higher than the 1-20 water ratio."

If you ream often enough, you can make your own reaming station. For more information on how to make your own station, go to: www.sonnax.com/technical-library/transmission



INTERNATIONAL LUBRICANTS, INC.

7930 Occidental South ■ Seattle, WA 98108 ■ PO Box 24743 ■ Seattle, WA 98124

206-762-5343 ■ 800-333-LUBE (5823) ■ Fax: 206-762-7989 ■ www.Lubegard.com

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