



Lub 21

New formula

Universal cutting fluid for all cutting operations.

1. GENERAL DESCRIPTION

LUB 21 is a semi synthetic cutting fluid for cutting and rectification operations on all kind of metal parts (steel, copper, aluminium, stainless steel, etc...).

This cutting fluid provides a significant extension of the life time of the cutting tool and gives a superb anti corrosion coating to the machined parts. The cuttings are evacuated easily..

Compared to traditional fluids, LUB 21 has an considerable extended life time.

- Fast decantation of the cuttings, maintaining a clean lubricating fluid and an elevated cutting speed.
- Transparent solution in order not to disturb a clear view on the machining operation.
- The cutting fluid contains excellent surfactants, which provides well maintained tools and fast cutting speeds.
- Easy to clean at low temperatures with the KF degreasers.
- Does not contain nitrites or heavy metals.
- Lub 21 is slightly caustic.

3. APPLICATIONS

Suitable for all current cutting operations and machining of average difficulty.

4. INSTUCTIONS

To set up a cutting fluid reservoir, add LUB 21 to water , following the below instructions :

| Cutting operation | Metals to be machined | | | | |
|----------------------------|-----------------------|-----------|-----------|--------|-----------------|
| | Steel | Cast iron | Aluminium | bronze | Stainless steel |
| Boring out | 4-6 | 4-6 | 5-7 | 4-6 | 5-7 |
| Drifting | 6-10 | 6-8 | 6-10 | 6-10 | 6-10 |
| Thread cutting with chisel | 4-6 | 4-6 | 5-7 | 4-6 | 5-7 |
| Drilling | 6-10 | 6-8 | 6-10 | 6-10 | 6-10 |
| Milling | 4-6 | 3-5 | 4-6 | 3-5 | 4-6 |
| Mortising | 6-10 | 6-8 | 6-10 | 6-10 | 6-10 |
| Piercing | 4-6 | 4-6 | 5-7 | 4-6 | 5-7 |
| Planing | 4-6 | 4-6 | 5-7 | 4-6 | 4-6 |
| Grinding | 2-3 | 2-3 | 2-3 | 2-3 | 2-3 |
| Sawing | 4-6 | 4-6 | 5-7 | 5-7 | 4-6 |
| Edge cutting with moulds | 4-6 | 4-6 | 5-7 | 4-6 | 5-7 |
| Edge cutting with chisel | 6-10 | 6-8 | 6-10 | 6-10 | 6-10 |
| Thread cutting | 6-10 | 6-8 | 6-10 | 6-10 | 6-10 |
| Turning | 4-6 | 3-5 | 4-6 | 3-5 | 4-6 |
| Cutting of cylinders | 4-6 | 4-6 | 4-6 | 4-6 | 4-6 |



CRC Industries France S.A.

12, Bld des Martyrs de Chateaubriant – Z.I. du Val d'Argent – B.P. 90028

F-95102 Argenteuil Cedex. - France

Tél.: + 33 (0)1 34 11 20 00 Fax.:+ 33 (0)1 34 11 09 96

S.A au capital de 1.936.667 €- R.C.S. Pontoise B 391 513 314 – APE 515 L

www.crcind.com





Lub 21

New formula

Universal cutting fluid for all cutting operations.

Control of the cutting fluid solution by a refracto-meter.

1. Once a day: control of the concentration with a refractometer.

| | | | | | | | | | |
|--------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|
| display | 1,5 | 2,2 | 3,0 | 3,7 | 4,4 | 5,2 | 5,9 | 6,7 | 7,4 |
| Concentration in % | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 |

2. Once a week: control of pH.
3. Once a month: control on bacterial growth.

A safety data sheet (MSDS) according to EU directive 91/155/EEC and amendments is available for all CRC products.

5. CARACTERISTIQUES TYPIQUES DU PRODUIT

| | |
|------------------------------|---|
| Aspect: | liquid with average viscosity |
| Colour: | amber |
| Density: | 1,1 |
| Flash point: | non flammable |
| pH of concentrate : | 9,5 |
| pH of a 5% solution: | 9 |
| Viscosity: @ 20 °C: | 32,6 mm ² /s |
| @ 40 °C: | 13,3 mm ² /s |
| Saponification factor: | 65 mg KOH/g |
| Refraction factor: | 1,35 |
| Resistance to be emulsified: | 0 |
| Rest stability: | 0 |
| Anti-corrosion efficiency: | 0 -1 |
| Foaming: | foaming (water TH 20): 70/1000 |
| Foaming test: | < 800 (water TH 0) |
| Extreme pressure property: | with charge: 80 daN - imprint: 0,6 mm |
| Tendency to form gum: | Procedure A : 40 mN/m ² Procedure B (redissolution): 0 mN/m. (water TH 20) |



CRC Industries France S.A.

12, Bld des Martyrs de Chateaubriant – Z.I. du Val d'Argent – B.P. 90028
F-95102 Argenteuil Cedex. - France
Tél.: + 33 (0)1 34 11 20 00 Fax.:+ 33 (0)1 34 11 09 96
S.A au capital de 1.936.667 €- R.C.S. Pontoise B 391 513 314 – APE 515 L
www.crcind.com





Lub 21

New formula

Universal cutting fluid for all cutting operations.

Resistance to centrifugation:

-Centrifugation without other oils: variation of concentration: 0%.

-Centrifugation with other oils: variation of concentration: 8,8% (acceleration 7500 g).

Wetting properties:

good.

6. PACKINGS

Réf. : **6702** – 5 Lt pail.

Unit.

Réf. : **6706** - 25 Lt pail.

Unit

Réf. : **6710** - 200 Lt drum

Unit

All statements in this publication are based on service experience and/or laboratory testing. Because of the wide variety of equipment and conditions and the unpredictable human factors involved, we recommend that our products be tested on-the-job prior to use. All information is given in good faith but without warranty neither expressed nor implied.

This Technical Data Sheet may already have been revised at this moment for reason such as legislation, availability of components and newly acquired experiences. The latest and only valid version of this Technical Data Sheet will be sent to you upon simple request or can be found on our website: www.crcind.com.

We recommend you to register on this website for this product so you will be able to receive any future updated version automatically.

Version : 03670 02 1200 03

Date : 11 May 2006



CRC Industries France S.A.

12, Bld des Martyrs de Chateaubriant – Z.I. du Val d'Argent – B.P. 90028
F-95102 Argenteuil Cedex. - France
Tél.: + 33 (0)1 34 11 20 00 Fax.:+ 33 (0)1 34 11 09 96
S.A au capital de 1.936.667 €- R.C.S. Pontoise B 391 513 314 – APE 515 L
www.crcind.com

