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## Lubie® Low Foam Coolant #427

Lubie® 427 Low Foam Coolant is an economical water diluteable synthetic grinding coolant formulated for all types of manual and automatic grinders that demand extremely low foaming properties. It is formulated with wetting agents, lubricity additives, detergents, water conditioners, rust inhibitors and bactericides. It does not contain any materials that are detrimental to plant personnel or machinery.

Lubie® 427 is especially formulated for high speed centrifugal centrifuge systems. It is economical, transparent, and can be used on all ferrous and aluminum metals. It was designed to overcome the many disadvantages associated with other synthetic coolants and soluble oils.

- The clear color will not obscure vision while machining or grinding.
- Extremely resistant to bacterial growth.
- Excellent chip and metallic dust settling properties, preventing recirculation in the coolant, plugged filters, damaged pumps and damage to the work piece.
- Contains a very efficient detergent system that will keep the coolant tank and grinder clean.
- Reduces wheel loading and glazing, thus eliminating frequent wheel dressing while increasing wheel life and production.
- No gummy or sticky residue on machines or work piece.
- Keeps chucks, slides, ways and other moving parts free of dirt, chips and fines, thereby increasing machine life and allowing for closer tolerances.
- Exhibits effective rust protection on steels and cast iron.
- Inhibited for use on aluminum.

427 will perform well in Sanborn and other high speed separating systems. Dilution ratios will depend upon the depth of cut, tool or wheel speed and feed rate.

### PHYSICAL DATA

Use Dilution	40:1 to 10:1	Color	Yellow/Clear
COD mg/l	496,000	BOD mg/l	105,000
Foam	Low to None	Specific Gravity	1.04
Chip Settling	Rapid	Odor	Slight to Mild
Refractometer Readings:	10:1 = 3.3	15:1 = 2.7	
	20:1 = 1.7	30:1 = 1.2	40:1 = 0.9

UNIT (Gallons)	CATALOG #
CASE (4 Gallons)	BL 427-1
PAIL (5 Gallons)	BL 427-5
DRUM (55 Gallons)	BL 427-55