

LUBRICUT 5460

SEMI-SYNTHETIC METALWORKING FLUID: HIGH PERFORMANCE FOR FERROUS METALS AND ALUMINUM ALLOYS - CHLORINATED

▷ PRODUCT DESCRIPTION

Lubricut 5460 is a high performance, extreme pressure, chlorinated 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 5460 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 while maintaining superior machine cleanliness and long lasting sump life. Lubricut 5460 is enhanced with specialized corrosion inhibitors, which offer outstanding corrosion protection/anti-staining properties on aluminum alloys. Lubricut 5460 contains a balanced lubrication regime of both chlorine and synthetic surface lubricant technology for optimal performance.

▷ FEATURED BENEFITS

- **Sulfonate Free Chemistry:** Biostable chemistry maintains pH and alkalinity, eliminating objectionable “Monday Morning Odors”
- **Hard Water Stable:** Lubricut 5460 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:** Lubricut 5460 combines the need for chlorine with a unique blend of highly effective boundary lubricants.
- **Balanced corrosion inhibition system** for both non-ferrous and ferrous metals
- **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
- **Excels at maintaining tolerances and finishes** at very high speeds & feed rates above 10,000 RPM

APPLICATION



COMPATIBLE METALS

Cast Iron
Carbon Steel
Tool Steel
Stainless Steel
Aluminum
Titanium
Inconel

MACHINING CAPABILITIES

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

HIGH PRESSURE COOLANT CAPABILITY

Yes

REFRACT INDEX

1.26



TYPICAL PROPERTIES

Fluid Type	Semi-synthetic
Appearance	Amber liquid
Odor	Mild
Specific Gravity, 60°F (15.6°C)	1.0350
Weight, 60°F (15.6°C)	8.625 lbs/gal.
pH (10% dilution)	9.50
Biostability	Excellent

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

PRODUCT APPLICATION / USAGE

Lubricut 5460 is recommended for heavy-duty 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, Broaching, Tapping, Sawing	6 – 8%	8 – 12%	7 – 15%
Grinding: I.D., O.D.	6 – 7%	6 – 7%	6 – 7%

MIXING DATA

Lubricut 5460 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	12.5	10.0	7.5	5.5	3.6

PRODUCT CODE

231390000

HEALTH AND SAFETY

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