



TECHNICAL DATA

GB KUTILUBE 5 FF

A premium formaldehyde release biocide free, semi-synthetic, water soluble cutting fluid.

APPLICATIONS

GB KUTILUBE 5 FF is a long-life fluid, formulated for a high quality surface finish on difficult machining operations, with low staining characteristics on aluminium alloys. This medium oil content product contains chlorine-free lubricity additives which give excellent cutting performance and surface finish. In addition, it is designed to give ultra-low foam performance in applications where the coolant is delivered at high pressure.

GB KUTILUBE 5 FF is used for turning, milling, drilling, threading, reaming (including Mapal reaming) and creep feed grinding as well as surface and cylindrical grinding.

MATERIAL COMPATIBILITY

GB KUTILUBE 5 FF is primarily designed for use on materials which are difficult to machine, including aluminium alloys. It can also be used on a wide variety of ferrous materials, high tensile steels, stainless steels, titanium alloys, oil resistant plastics, carbon fibre and other non-ferrous materials.

WATER COMPATIBILITY AND PRODUCT MIXING

GB KUTILUBE 5 FF is suitable for a wide water hardness range, typically between 50 and 350 ppm. GB Lubricants recommend the use of automated mixing systems; however, when mixed manually, the water should be agitated whilst the concentrate is added. The emulsion strength should always be checked prior to application, using a calibrated refractometer. Details of where to purchase equipment and how to use it are available from the GB Lubricants Technical Department.

CONCENTRATIONS

APPLICATION	%
Turning, Milling and Drilling	4 – 6
Tapping and Threading	5 – 7
Mapal reaming and Creep feed Grinding	7 – 8
Surface and Cylindrical Grinding	3 – 4

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Integrated Management System
PAS 99 IMR 560337
ISO 9001
ISO 14001
OHSAS 18001

GB LUBRICANTS

CHARACTERISTICS

CONCENTRATE		EMULSION	
TEST	TYPICAL PHYSICAL CHARACTERISTICS	TEST	TYPICAL PHYSICAL CHARACTERISTICS
Appearance	Amber Fluid	Appearance	Semi translucent
Density	951 kg/m ³	pH @ 5%	9.3
		IP 287 Corrosion Test %	2.0
		Refractometer Factor	1.0

STORAGE, HANDLING AND SHELF-LIFE

GB KUTILUBE 5 FF should be stored inside or under cover out of direct sunlight and protected from extreme temperatures (below 0°C and above 30°C). Avoid water collecting in the rim of upturned barrels.

Further information on GB KUTILUBE 5 FF can be obtained by referring to the corresponding Safety Data Sheet.

The Company policy is to ensure that a range of products is supplied which complies with the latest specifications and codes within the relevant industry. As part of this development process, we therefore reserve the right to amend formulations without prior notice.