



TECHNICAL DATA

GB KUTILUBE 1 FF

A general purpose water soluble cutting fluid, which when mixed with water, produces a milky emulsion.

APPLICATIONS

GB KUTILUBE 1 FF is a conventional white watermix fluid with a high oil content, formulated to provide excellent defoam characteristics, good corrosion protection and a long sump life for this type of product. GB KUTILUBE 1 FF is free from formaldehyde release biocides.

GB KUTILUBE 1 FF performs in general purpose applications, such as surface, cylindrical and centreless grinding, sawing, turning, milling, drilling and threading in easy to medium machining operations.

MATERIAL COMPATIBILITY

GB KUTILUBE 1 FF is designed for machining a wide variety of materials, including mild steel, most medium tensile ferrous metals, copper alloys and other materials which are moderately easy to machine. When machining easily stained materials or in heavy duty machining operations, other products from the GB Lubricants range may be more appropriate.

WATER COMPATIBILITY AND PRODUCT MIXING

GB KUTILUBE 1 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 adding the concentrate. 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	%
Sawing, Turning, Milling and Drilling	4 – 6
Tapping and Threading	5 – 8
Surface, Cylindrical and Centreless Grinding	3 – 5

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GB LUBRICANTS

Albany Road Gateshead NE8 3BP

Tel: 0191 490 4312

Fax: 0191 477 9544

e-mail: gblsales@gb lubricants.co.uk

www.gblubricants.co.uk

A division of Goodall Bates & Todd Ltd



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 Liquid	Appearance	Milky
Density @ 20°C	901 kg/m ³	pH @ 5%	9.1
		Cast Iron Corrosion Test	4.5%
		Refractometer Factor	1.0

STORAGE, HANDLING AND SHELF-LIFE

GB KUTILUBE 1 FF should be stored under cover preferably inside, 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 1 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.