

CRC LUB 21

Universal cutting fluid for all cutting operations

Ref. : 20249-30405

1. GENERAL DESCRIPTION

CRC LUB 21 is a semi synthetic cutting fluid for rectification and cutting operations on all kinds of metal parts (steel, copper, 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, CRC LUB 21 has a 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 provide well maintained tools and fast cutting speeds.
- Easy to clean at low temperatures with the CRC degreasers.
- Does not contain nitrites or heavy metals.
- CRC Lub 21 is slightly caustic.

3. APPLICATIONS

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

4. DIRECTIONS

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

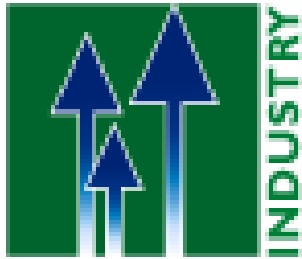
Lt / 100 Litres water	Metals to be machined				
	Steel	Cast iron	Aluminum*	bronze	Stainless steel
Boring out	4-6	4-6	5-7	4-6	5-7
Drifting	6-10	6-8	6-10	6-10	6-10
Thread cutting with chisel	4-6	4-6	5-7	4-6	5-7
Drilling	6-10	6-8	6-10	6-10	6-10
Milling	4-6	3-5	4-6	3-5	4-6
Mortising	6-10	6-8	6-10	6-10	6-10
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

**Test prior to use on aluminium alloys. Might cause staining on certain alloys.*



Manufactured by :
CRC Industries Europe BVBA
Touwslagerstraat 1 – 9240 Zele – Belgium
Tel (32) (0) 52/45.60.11 Fax (32) (0) 52/45.00.34
www.crcind.com





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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 EC Regulation N° 1907/2006 Art.31 and amendments is available for all CRC products.

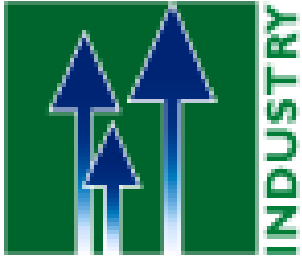
5. TYPICAL PRODUCT DATA (without propellant)

Aspect:	liquid with average viscosity
Color:	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)
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.



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TECHNICAL DATA
3/3

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6. PACKAGING

Bulk	2 x 5 Lt
	1 x 25 Lt
	1 x 200 Lt

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.

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