



# TECHNICAL DATA

## GB KUTILUBE 5

A multipurpose, bio-stable, semi-synthetic, water-soluble cutting and grinding fluid, which, when mixed with water, produces a semi-translucent fluid with medium oil content and good lubricity

## APPLICATIONS

GB KUTILUBE 5 is a long-life fluid, formulated for a high quality surface finish on difficult machining operations, with low staining characteristics on aluminium alloys. In addition, it is designed to give ultra-low foam performance in applications where the coolant is delivered at high pressure.

GB KUTILUBE 5 is used for turning, milling, drilling, threading, boring, deep hole drilling, reaming (including Mapal reaming) and creep feed grinding.

## MATERIAL COMPATIBILITY

GB KUTILUBE 5 is primarily designed for use on materials which are difficult to machine, including aluminium alloys, and can be used on a wide variety of ferrous materials.

## WATER COMPATIBILITY AND PRODUCT MIXING

GB KUTILUBE 5 is suitable for a wide water hardness range, typically between 50 and 250 ppm. Above 250 ppm, small amounts of scum can be formed and the GB Lubricants Technical Department should be consulted. GB Lubricants Ltd 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	%
General machining of ferrous metals	5 – 6
General machining of aluminium alloys	5 – 6
Deep hole drilling, boring, tapping	6 – 8
Mapal reaming	8 – 10
Creep feed grinding	5 – 10

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## **GB LUBRICANTS**

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Q 06093  
ISO 9001



EMS 72776  
ISO 14001



OHS 88475  
OHSAS 18001

**CHARACTERISTICS**

CONCENTRATE		EMULSION	
TEST	TYPICAL PHYSICAL CHARACTERISTICS	TEST	TYPICAL PHYSICAL CHARACTERISTICS
Appearance	Amber Fluid	Appearance	Semi-translucent
Specific Gravity	970 kg/m <sup>3</sup>	pH @ 3%	9.1
Mineral Oil Content %	40	Corrosion Test %	2.0
		Defoam ml (3% in 50 ppm water)	Nil (15 secs)
		Refractometer Factor	1.1
Flash Point	Not applicable	Flash Point	Not applicable

**STORAGE, HANDLING AND SHELF-LIFE**

GB KUTILUBE 5 should be stored under cover and protected from extreme temperatures (below 0°C and above 40°C). Avoid water collecting in the rim of upturned barrels. GB KUTILUBE 5 has a shelf-life of 6 months from the date of supply.

**HEALTH, SAFETY AND THE ENVIRONMENT**

GB KUTILUBE 5 is classified as hazardous under current UK Health & Safety and Environmental Legislation and should only be used in the application for which it is intended. It is free from Triazines, Chlorine, Sulphur, Sodium Nitrite and Phenols.

For guidance on storage and handling of all lubricants and related products, GB Lubricants recommend the Environment Agency, [www.environment-agency.gov.uk](http://www.environment-agency.gov.uk), as an excellent source of advice.

If you have any queries, please do not hesitate to contact either your local Technical Sales Representative or our Technical Department.

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 and specifications, without prior notice.