



BIOLUBE INC.

PO Box 9732 Fort Wayne, IN 46899

www.biolube1.com sales@biolube1.com

260-414-9633 Fax 260-440-3163

Lubie® Carbide Grinder Coolant 325

Lubie® 325 Carbide Grinder Coolant is an economical water diluteable synthetic grinding coolant formulated to resist cobalt leaching. Special inhibitors have been added to inhibit cobalt leaching from carbide. It is formulated with wetting agents, lubricity additives, detergents, water conditioners, rust inhibitors and bactericides. It does not contain any materials that are detrimental to plant personnel or machinery.

325 is especially formulated to fill the need for an economical transparent grinding coolant to be used in all carbide grinding and machining operations. It was designed to overcome the many disadvantages associated with other synthetic carbide coolants.

- The clear color will not obscure vision while machining or grinding.
- Extremely resistant to bacterial growth.
- Excellent chip and metallic dust settling properties, preventing recirculation in the coolant, plugged filters, damaged pumps and damage to the work piece.
- Contains a very efficient detergent system that will keep the coolant tank and grinder clean.
- Reduces wheel loading and glazing, thus eliminating frequent wheel dressing while increasing wheel life and production.
- No gummy or sticky residue on machines or work pieces.
- Keeps chucks, slides, ways and other moving parts free of dirt, chips and fines, thereby increasing machine life and allowing for closer tolerances.
- Exhibits effective rust protection on steels and cast iron.

Dilution ratios will depend upon the depth of cut, tool or wheel speed and feed rate.

PHYSICAL DATA

Use Dilution	40:1 to 10:1	Color	Blue/Clear
COD mg/l	516,000	BOD mg/l	110,000
Foam	Low to None	Lbs. per gallon	8.7
Chip Settling	Rapid	Odor	Slight-Mild
Refractometer Readings:	10:1 = 3.3	15:1 = 2.7	
	20:1 = 1.7	30:1 = 1.2	40:1 = 0.9

UNIT (Gallons)	CATALOG #
CASE (4 Gallons)	BL 325-1
PAIL (5 Gallons)	BL 325-5
DRUM (55 Gallons)	BL 325-55

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