



BIOLUBE INC.

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Lubie® Carbide Grinder Coolant 329

Lubie® 329 Carbide Grinder Coolant is an economical high performance "soft" water diluteable synthetic transparent grinding coolant formulated to resist cobalt leaching from carbide in all carbide grinding and machining operations.. Special inhibitors have been added to make it much less irritating to the skin of sensitive employees. 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.

Lubie® 329 is generally reformulated in the tank with small amounts of Lubie® Cohib A to replenish its cobalt anti-leaching activity. Adjusting the tank to the appropriate refractometer reading is very cost effective and simple.

- 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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