



**listercut**  
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**Specification Sheet**

**listercut  
CNC Ultra 400  
Soluble Cutting  
Oil**

James Lister & Sons Ltd. Spon Lane South, Smethwick, West Midlands. B66 1QJ

### General

listercut CNC Ultra 400 Soluble Cutting Oil is a high-performance semi synthetic watermix fluid specifically designed for the machining of tough ferrous and non-ferrous alloys. listercut CNC Ultra 400 Soluble Cutting Oil is a medium oil content product and uses a unique combination of chlorine free lubricity additives to give superb machining performance. listercut CNC Ultra 400 Soluble Cutting Oil is an extremely low foaming product and performs well in through spindle and high coolant volume delivery applications. listercut CNC Ultra 400 Soluble Cutting Oil is an extremely robust coolant and gives extended service life in the most difficult conditions.

### Features

Secondary amine free  
 Boron free  
 Biocide free – therefore formaldehyde release biocide free  
 Chlorine free

### Machining operations

Turning, Milling & Drilling  
 Tapping & Threading  
 Reaming And deep hole drilling

### Material suitability

Ferrous alloys  
 Aluminium alloys  
 Yellow metals

### Recommended Dilutions

Turning, Milling & Drilling	4-6%
Tapping & Threading	5-7%
Reaming & deep hole drilling	7-10%

### Typical data

Emulsion appearance	Semi Translucent
pH at 5% in distilled water	9.6
IP 287 Corrosion break point	2.0
Refractometer correction factor	1.4