

Accu-Lube[®]

Minimum Quantity Lubricants
& Applicator Systems for
Near-Dry Machining

the natural choice in metalworking lubricants



TW Rocol[®] North America

Accu-Lube[®]

HISTORY OF EXCELLENCE

Since 1979 Accu-Lube has been the industry leader in manufacturing lubricants and equipment for Minimum Quantity Lubrication (MQL). Today, Accu-Lube continues to be at the forefront of near-dry machining through our dedication to innovation, safety and service.

COMMITTED TO RESPONSIBLE MANUFACTURING

Accu-Lube manufactures a complete line of environmentally safe metalworking lubricants using renewable raw materials. These fluids are specially formulated to provide superior performance and economy while helping to keep the planet safe from industrial contaminants by getting rid of the toxins required in flood coolant and eliminating harmful waste. Our mission is to help customers create cleaner, safer, greener facilities with our non-toxic, biodegradable lubricants that are second to none in performance, quality and value.

QUALITY OVER QUANTITY

Accu-Lube Minimum Quantity Lubrication applicator systems use advanced technology to focus droplets of lubricant directly onto the tool's cutting edge, providing lubrication and protection precisely where it is needed. Our minimum quantity approach allows manufacturers to conserve fluid and cut down on waste. With a small amount of our premium lubricant, tools last longer and parts come out cleaner. By eliminating flood coolant, shops stay clean and fluid maintenance is a thing of the past.

This is Near-Dry Machining.

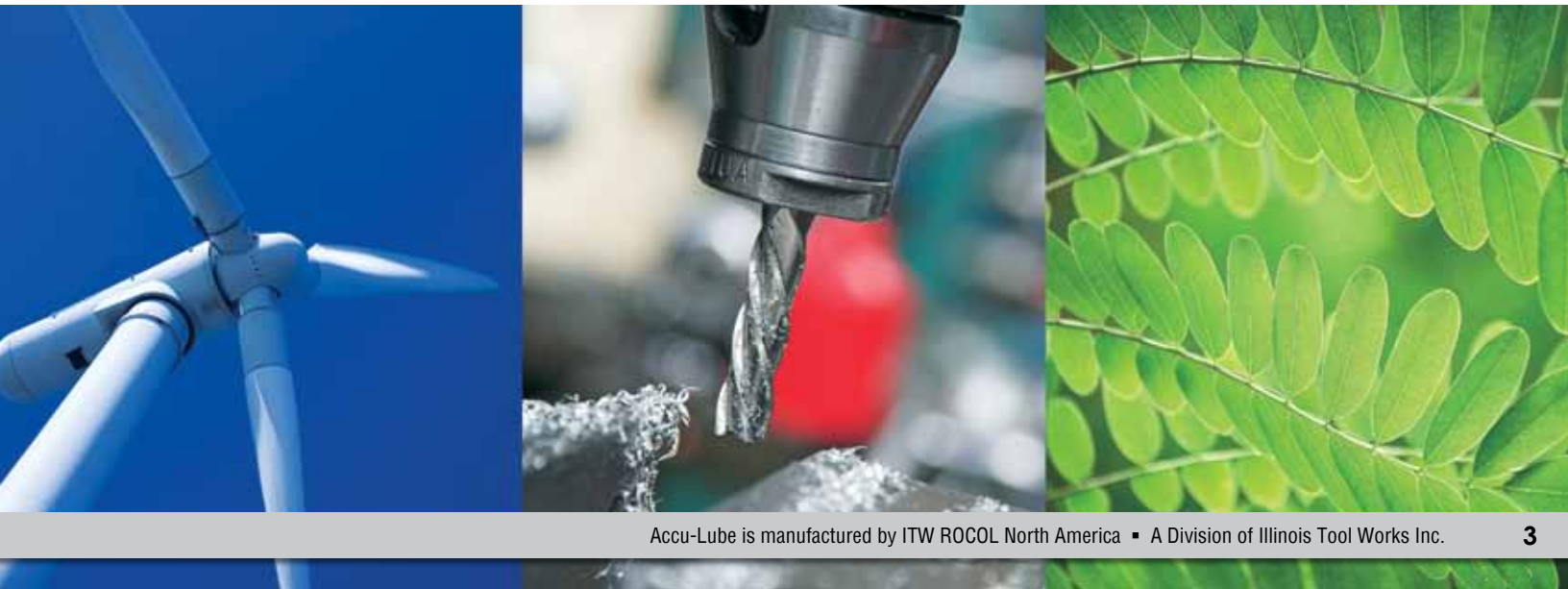


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ITW **ROCOL® North America**

ITW ROCOL North America, a division of Illinois Tool Works Inc. (ITW), is an industry leader in the development and production of scientifically advanced fluid products and equipment for the metalworking industry. These include eco-friendly lubricants & tapping fluids, cutting & grinding fluids, rust preventatives, stamping lubricants, aqueous cleaners, coolant maintenance equipment and minimum quantity lubrication systems. By continually focusing on advancements in production, safety and service we strive to uphold the Guiding Principles of ITW.



GENERAL-PURPOSE LUBRICANTS

Safe to use with all metals, cleaning recommended before heat treating

LB-1000

Premium, heavy-duty minimum quantity lubricant with chlorinated extreme pressure additives.

CHARACTERISTICS

- Extra heavy-duty
- Vegetable-based, biodegradable lubricant
- 5% chlorinated EP additives, also available with 10 or 30% EP
- For ferrous & nonferrous metals, including aluminum
- Not recommended for titanium
- Clean before heat treating with soap and water

APPLICATIONS

- Heavy-duty machining, sawing and cutting
- Difficult steel & hardened metal operations
- Large diameter tapping
- Deep hole drilling
- High heat operations
- Sawing large diameter solids

Part No. Size

LB1000 1 gal. jug (4/case)
LB1055 55 gal. drum



LB-1100

Premium, heavy-duty minimum quantity lubricant with non-chlorinated extreme pressure additives.

CHARACTERISTICS

- Heavy-duty
- Vegetable-based, biodegradable lubricant
- For ferrous & nonferrous metals, aluminum and titanium
- Water-washable
- Clean before heat treating with rinse water

APPLICATIONS

- Heavy-duty machining, sawing and cutting
- Exotic and high nickel alloys
- Aerospace industry
- Large diameter tapping
- Deep hole drilling
- Carbide die stamping
- Sawing large diameter solids

Part No. Size

LB1100 1 gal. jug (4/case)
LB1155 55 gal. drum



FLAGSHIP PRODUCT!

LB-2000

Superior, moderate to heavy-duty minimum quantity lubricant for general-purpose near-dry machining.

CHARACTERISTICS

- Moderate to heavy-duty
- Vegetable-based, biodegradable lubricant
- For ferrous & nonferrous metals, aluminum and titanium
- Accu-Lube's #1 product for over twenty years
- Clean before heat treating with soap and water

APPLICATIONS

- General machining, sawing and cutting
- Drilling & tapping small holes
- Sawing large diameter solids
- Large diameter tapping
- Broaching & spline rolling

Part No. Size

LB2000 1 gal. jug (4/case)
LB2055 55 gal. drum



FG-2000

Superior, food-grade minimum quantity lubricant with non-chlorinated anti-wear additives for moderate to heavy-duty near-dry machining.

CHARACTERISTICS

- Moderate to heavy-duty
- Vegetable-based, biodegradable lubricant
- NSF H1 approved for incidental food contact
- For ferrous & nonferrous metals, aluminum and titanium
- Clean before heat treating with soap and water

APPLICATIONS

- General machining, sawing and cutting
- Food-grade applications
- Medical device manufacturing
- Swiss style CNC machining centers
- Milling, drilling and tapping

Part No. Size

FG2001 1 gal. jug (4/case)
FG2055 55 gal. drum



GENERAL-PURPOSE LUBRICANTS



Power Stamp III

Superior, heavy-duty minimum quantity lubricant with non-chlorinated anti-wear and extreme pressure additives.

CHARACTERISTICS

- Heavy-duty
- Vegetable-based, biodegradable lubricant
- For ferrous & nonferrous metals, aluminum and titanium
- Water-washable
- Clean before heat treating with rinse water

APPLICATIONS

- Carbide die stamping
- Drawing and fine blanking
- Stamping sheet metal up to 0.125" thick (gauge 8 and higher, depending on the type of metal)

Part No. Size

LBSTIII01.....1 gal. jug (4/case)
LBSTIII55.....55 gal. drum



LB-3000

Economical, moderate-duty minimum quantity lubricant.

CHARACTERISTICS

- Moderate-duty
- Vegetable-based, biodegradable lubricant
- For ferrous & nonferrous metals, aluminum and titanium
- Clean before heat treating with soap and water

APPLICATIONS

- General machining and sawing
- Replacement for "mist" type lubricant and coolant
- Lumber & wood cutting applications

Part No. Size

LB30001 gal. jug (4/case)
LB305555 gal. drum



Synthetic

Multi-purpose, water-based minimum quantity lubricant with non-chlorinated extreme pressure additives for moderate-duty near-dry machining.

CHARACTERISTICS

- Multi-purpose
- Water-based, synthetic lubricant
- Cools like flood coolant, lubricates like straight oil
- Rapid heat dissipation
- For ferrous metals
- Clean before heat treating with rinse water

APPLICATIONS

- General machining, sawing and cutting
- Replacement for straight oil

Part No. Size

LBSYNT01 ...1 gal. jug (4/case)
LBSYNT55 ...55 gal. drum



Synthetic II

NEW

Economical, water-based minimum quantity lubricant with non-chlorinated extreme pressure and boundary additives for moderate-duty near-dry stamping and machining.

CHARACTERISTICS

- Economical
- Water-based, synthetic lubricant
- Provides excellent corrosion protection
- Boron free with superior lubricity
- For ferrous & nonferrous metals and aluminum
- Clean before heat treating with rinse water

APPLICATIONS

- Stamping
- General machining, sawing and cutting

Part No. Size

LBSY2011 gal. jug (4/case)
LBSY25555 gal. drum



LIGHT-VISCOSITY LUBRICANTS



Safe to use with all metals, biodegradable, ideal for thru-tool applications

LB-6000

Premium, moderate to heavy-duty minimum quantity lubricant.

CHARACTERISTICS

- Moderate to heavy-duty
- Vegetable-based, biodegradable lubricant
- Non-staining, burns off cleanly in post heat treating
- For ferrous & nonferrous metals, aluminum and titanium
- Clean with soap and water

APPLICATIONS

- Aluminum machining, cutting and sawing
- Moderate-duty milling, drilling, tapping and punching
- Replacing "mist" type lubricant and coolant
- Aluminum applications with post-heat treating
- Thru-tool applications

Part No. Size

- LB6000 1 gal. jug (4/case)
- LB6055 55 gal. drum



LB-6100

Premium, heavy-duty minimum quantity lubricant with non-chlorinated extreme pressure additives.

CHARACTERISTICS

- Heavy-duty
- Vegetable-based, biodegradable lubricant
- Non-staining, burns off cleanly in post heat treating
- For ferrous & nonferrous metals, aluminum and titanium
- Clean with soap and water

APPLICATIONS

- Moderate-duty milling, drilling, tapping, stamping and punching
- Heavy-duty machining, sawing and cutting
- Sawing large diameter solids
- Large diameter tapping
- Deep hole drilling
- Operations that generate a lot of heat
- Thru-tool applications

Part No. Size

- LB6100 1 gal. jug (4/case)
- LB6155 55 gal. drum



LB-5000

Superior, moderate-duty minimum quantity lubricant.

CHARACTERISTICS

- Moderate-duty
- Vegetable-based, biodegradable lubricant
- Non-staining, burns off cleanly in post heat treating
- For ferrous & nonferrous metals
- Clean with soap and water

APPLICATIONS

- General machining, sawing and cutting
- Post-heat treating aluminum

Part No. Size

- LB5000 1 gal. jug (4/case)
- LB5055 55 gal. drum



LB-6800

Moderate-duty minimum quantity lubricant.

CHARACTERISTICS

- Moderate-duty
- Vegetable-based, biodegradable lubricant
- Non-staining, burns off cleanly in post heat treating
- For ferrous & nonferrous metals, aluminum and titanium
- Clean with soap and water

APPLICATIONS

- General machining, sawing and cutting
- Sawing aluminum castings

Part No. Size

- LB6800 1 gal. jug (4/case)
- LB6855 55 gal. drum



LIGHT-VISCOSITY LUBRICANTS

Power Stamp II

Superior, heavy-duty minimum quantity lubricant with non-chlorinated extreme pressure and anti-wear additives.

CHARACTERISTICS

- Heavy-duty
- Vegetable-based, biodegradable lubricant
- Non-staining, burns off cleanly in post heat treating
- For ferrous & nonferrous metals, aluminum and titanium
- Clean with rinse water

APPLICATIONS

- Stamping
- Operations that generate a lot of heat
- Machining aluminum and titanium
- Carbide die stamping

Part No. Size

LBSTII01 1 gal. jug (4/case)
LBSTII55 55 gal. drum



LB-4600

Economical, light-duty minimum quantity lubricant.

CHARACTERISTICS

- Light-duty
- Vegetable-based, biodegradable lubricant
- Non-staining, burns off cleanly in post heat treating
- For ferrous & nonferrous metals, aluminum and titanium
- Clean with soap and water

APPLICATIONS

- Light-duty machining, sawing and cutting
- Aluminum extrusion machining and sawing

Part No. Size

LB4600 1 gal. jug (4/case)
LB4655 55 gal. drum



LB-7400

NEW

Superior, high-performance minimum quantity lubricant for thru-tool near-dry machining.

CHARACTERISTICS

- High performance
- Biodegradable lubricant
- For ferrous & nonferrous metals, aluminum and titanium
- Clean before heat treating with soap and water

APPLICATIONS

- General milling, drilling, sawing, tapping and turning
- Thru-tool applications
- Deep hole drilling
- Hard milling
- With Accu-Lube's MiniBooster applicator or BlueBe's EcoBooster applicator

Part No. Size

LB7401 1 gal. jug (4/case)
LB7455 55 gal. drum



MINIMUM QUANTITY LUBRICATION (MQL) SYSTEMS



Minimum Quantity Lubrication applicators systems focus droplets of lubricant directly onto the tool's cutting edge, providing lubrication & protection precisely where it is needed.

BOX APPLICATORS

The gold standard in Near-Dry Machining, featuring Accu-Lube's patented precision pumps and a lockable steel security box.

SPECIAL FEATURES

- Exclusive positive displacement pump technology deliver precisely metered amount of lubricant
- Air filter/regulator gives added control and precision
- Lockable security box with front and back door access
- Individually controlled airflow valve, lubricant control and frequency generator
- No misting! Coaxial hose assembly atomizes lubricant at the nozzle tip to prevent misting
- Custom configurations available



Box Applicator – Automatic On/Off, Fixed

- 110 VAC electronic solenoid on/off control
- Fixed applicator mounting
- 12" copper nozzle(s), fixed mounting
- 12' hose assembly
- Reservoir included

Part No.	Size
01A1-STD1 pump
02A1-STD2 pumps
03A1-STD3 pumps
04A1-STD4 pumps

Box Applicator – Manual On/Off, Fixed

- Manual on/off control
- Fixed applicator mounting
- 12" copper nozzle(s), fixed mounting
- 12' hose assembly
- Reservoir included

Part No.	Size
01A0-STD1 pump
02A0-STD2 pumps
03A0-STD3 pumps
04A0-STD4 pumps

Box Applicator – Manual On/Off, Portable

- Manual on/off control
- Magnetic applicator mounting
- 18" Loc-Line nozzle(s), magnetic mounting
- 12' hose assembly
- 10 oz. reservoir

Part No.	Size
01A0-DMO	...1 pump
02A0-DMO	...2 pumps

JUNIOR APPLICATOR

The perfect solution for small production operations with the same precision pump and frequency generator as the Box Applicator.

SPECIAL FEATURES

- Compact applicator with magnetic mounts for easy placement
- Precision pumps deliver precisely metered lubrication
- No misting! Coaxial hose assembly atomizes the lubricant at the nozzle tip prevents misting



Junior Applicator – Portable Nozzles

- Manual on/off control
- Magnetic applicator mounting
- 18" Loc-Line nozzle(s), magnetic mounting
- 12' hose assembly
- 10 oz. reservoir

Part No.	Size
01D0-STD1 pump
02D0-STD2 pumps

Junior Applicator – Fixed Nozzles

- Manual on/off control
- Fixed applicator mounting
- 12" copper nozzle(s), fixed mounting
- 12' hose assembly
- 10 oz. reservoir

Part No.	Size
01D0-COP1 pump
02D0-COP2 pumps

NEAR-DRY SAWING

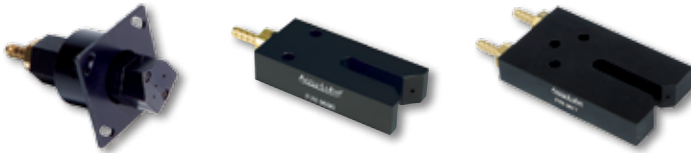
Increase blade life, reduce fluid consumption, maximize sawing productivity.

Every sawing nozzle has three angled outlets to lubricate the blade's teeth and sides. One or more internal atomizing chambers break up the lubricant for an even, consistent spray and continuous lubrication.

Band Saw Nozzles

- Better chip removal
- Improves blade life
- Cut tubes of all sizes and solids up to 10" wide

Nozzle	Size	Part No.
V-Nozzle.....	Blades 0.75-1.5" wide	9692
N-Nozzle.....	Blades 0.75-1.75" wide	9696
RL-Nozzle.....	Blades up to 2" wide (needs 2 feeds)	9877



Circular Saw Nozzles

- Unique design allows one nozzle to work like three
- Lubricates the cutting face and into the gullet
- Cleaner blades that last longer

Nozzle	Size	Part No.
C-Nozzle.....	Blades up to 20" (angled head)	9878
CM-Nozzle....	Blades 22-36" (needs 2-3 feeds)	379165
CL-Nozzle.....	Blades 36-120" (needs 3 feeds)	9045



NEAR-DRY SAWING SYSTEMS

BOX APPLICATOR SAWING SYSTEMS For more automation and control

Box Systems for Band Sawing

- 110 VAC electronic solenoid on/off control
- Fixed applicator mounting
- 12' hose assembly
- 10 oz. reservoir

Nozzle	Part No.
V-Nozzle.....	01A1-SAW
N-Nozzle.....	01A1-NNZ
RL-Nozzle.....	02A1-RLZ

Box Systems for Circular Sawing

- 110 VAC electronic solenoid on/off control
- Fixed applicator mounting
- 12' hose assembly
- 10 oz. reservoir

Nozzle	Part No.
C-Nozzle.....	01A1-CIR

JUNIOR APPLICATOR SAWING SYSTEMS For easy sawing applications

Junior Systems for Band Sawing

- Manual on/off control
- Fixed applicator mounting
- 12' hose assembly
- 10 oz. reservoir

Nozzle	Part No.
V-Nozzle.....	01D0-SAW
N-Nozzle.....	01D0-NNZ
RL-Nozzle.....	02D0-RLZ

Junior Systems for Circular Sawing

- Manual on/off control
- Fixed applicator mounting
- 12' hose assembly
- 10 oz. reservoir

Nozzle	Part No.
C-Nozzle.....	01D0-CIR

HAND-APPLIED LUBRICANTS



Made with natural ingredients, environmentally-safe

Pump Spray

LB-2000 vegetable-based, biodegradable lubricant in a convenient pump spray bottle for mess-free lubrication without an applicator.

CHARACTERISTICS

- Vegetable-based, biodegradable lubricant
- For ferrous & nonferrous metals, aluminum and titanium
- Clean before heat treating with rinse water

APPLICATIONS

- Moderate to heavy-duty operations
- Short-run and hand-held machining
- Drilling, tapping and milling
- When compressed air is not available

Part No. Size

79026.....8 oz. spray (16/case)



#10 Perfect Tap

Natural-based cutting oil tough enough to handle repeated cuts without reapplication with a thick consistency that allows the tap to cut several holes before recoating.

CHARACTERISTICS

- Vegetable-based lubricant
- For ferrous & nonferrous metals, aluminum and titanium

APPLICATIONS

- Tapping, drilling and reaming

Part No. Size

7583.....8 oz. bottle (16/case)
7584.....1 gal. jug



Gel Paste

Natural-based gel lubricant works on a wide variety of cutting applications. The workable texture makes it easy to apply to small and large tools with a soft brush without risk of damaging the tool.

CHARACTERISTICS

- Vegetable-based lubricant
- For ferrous & nonferrous metals, aluminum and titanium

APPLICATIONS

- Horizontal applications
- Short-run machining
- Tapping, reaming and drilling

Part No. Size

79030.....8 oz. jar (16/case)



LS-10

Solid paste lubricant reduces friction for cleaner cutting and better finish. Apply LS-10 directly to the tool or work area with a stiff brush.

CHARACTERISTICS

- Vegetable-based lubricant
- For ferrous & nonferrous metals, aluminum and titanium
- Clean with soap and water

APPLICATIONS

- Short-run machining
- Burring, tapping and drilling

Part No. Size

7603.....8 oz. jar (16/case)



Stick Lubricant

Lubricating stick for rotating or stationary cutting tools, grinding wheels and belts. Reduces heat build-up in belt, disc and wheel grinding applications. Apply directly to tool or work area for instant lubrication.

CHARACTERISTICS

- Vegetable-based lubricant
- For ferrous & nonferrous metals, aluminum and titanium
- Clean with soap and water

APPLICATIONS

- Short-run machining
- Rotating or stationary cutting tools
- Belt, disc and wheel grinding

Part No. Size

79042.....2.2 oz. push-up stick (24/case)
79045.....13 oz. tube (24/case)



Block Lubricant

Hand-held solid lubricant reduces heat build-up in belt, disc and wheel grinding applications. Designed to be applied directly to the tool or work area for immediate lubrication.

CHARACTERISTICS

- Vegetable-based lubricant
- For ferrous & nonferrous metals, aluminum and titanium
- Clean with soap and water

APPLICATIONS

- Short-run machining
- Belt, disc and wheel grinding

Part No. Size

79037.....2.6 oz. block (120/case)



PRODUCT TECHNICAL DATA

LUBRICANT TECHNICAL DATA

Product	Type of Operations	EP Additives	Rinse Water Wash	Soap & Water Wash	Pin & Vee Block (lbs.)	Flash Point	Pour Point	Viscosity at 40°C (cSt)	1 gal. (4/cs)	55 gal.
FG-2000	Moderate - Heavy	Non-Cl		✓	2000	608°F (320°C)	-4°F (-20°C)	40	FG2001	FG2055
LB-1000	Extra Heavy	Cl		✓	> 4500	535°F (279°C)	5°F (-15°C)	39	LB1000	LB1055
LB-1100	Heavy	Non-Cl	✓		> 4500	593°F (312°C)	5°F (-15°C)	48	LB1100	LB1155
LB-2000	Moderate - Heavy			✓	1750	608°F (320°C)	-4°F (-20°C)	37	LB2000	LB2055
LB-3000	Moderate			✓	1500	608°F (320°C)	-4°F (-20°C)	37	LB3000	LB3055
LB-4600	Light			✓	900	335°F (168°C)	40°F (4°C)	7.3	LB4600	LB4655
LB-5000	Moderate			✓	1000	374°F (190°C)	40°F (4°C)	18	LB5000	LB5055
LB-6000	Moderate - Heavy			✓	1250	418°F (214°C)	-40°F (-40°C)	8.9	LB6000	LB6055
LB-6100	Heavy	Non-Cl		✓	> 4500	400°F (204°C)	-40°F (-40°C)	10.4	LB6100	LB6155
LB-6800	Moderate			✓	1250	400°F (204°C)	-40°F (-40°C)	9	LB6800	LB6855
LB-7400	Moderate - Heavy			✓	Not avail	527°F (275°C)	-17°F (-27°C)	24	LB7401	LB7455
Power Stamp II	Heavy	Non-Cl	✓		> 4500	400°F (204°C)	-38°F (-39°C)	15	LBSTII01	LBSTII55
Power Stamp III	Heavy	Non-Cl	✓		> 4500	598°F (314°C)	5°F (-15°C)	48	LBSTIII01	LBSTIII55
Synthetic	Moderate	Non-Cl	✓		> 4500	Not applicable	30°F (-1°C)	8	LBSYNT01	LBSYNT55
Synthetic II	Moderate	Non-Cl	✓		> 4500	Not applicable	35°F (2°C)	2	LBSY201	LBSY255

APPLICATOR TECHNICAL DATA

Part No.	MQL Applicator	# of Pumps	Nozzle	Manual On/Off	Solenoid On/Off	Steel Security Box	Nozzle Mounting	Applicator Mounting	Reservoir Size
01A0-STD	Box	1 Pump	12" Copper	✓		✓	Fixed	Fixed	10 oz.
02A0-STD	Box	2 Pump	12" Copper	✓		✓	Fixed	Fixed	10 oz.
03A0-STD	Box	3 Pump	12" Copper	✓		✓	Fixed	Fixed	10 oz.
04A0-STD	Box	4 Pump	12" Copper	✓		✓	Fixed	Fixed	1 qt.
01A1-STD	Box	1 Pump	12" Copper		✓	✓	Fixed	Fixed	10 oz.
02A1-STD	Box	2 Pump	12" Copper		✓	✓	Fixed	Fixed	10 oz.
03A1-STD	Box	3 Pump	12" Copper		✓	✓	Fixed	Fixed	10 oz.
04A1-STD	Box	4 Pump	12" Copper		✓	✓	Fixed	Fixed	1 qt.
01A0-DMO	Box	1 Pump	18" Loc-Line	✓		✓	Magnetic	Magnetic	10 oz.
02A0-DMO	Box	2 Pump	18" Loc-Line	✓		✓	Magnetic	Magnetic	10 oz.
01D0-COP	Junior	1 Pump	12" Copper	✓			Fixed	Fixed	10 oz.
02D0-COP	Junior	2 Pump	12" Copper	✓			Fixed	Fixed	10 oz.
01D0-STD	Junior	1 Pump	18" Loc-Line	✓			Magnetic	Magnetic	10 oz.
02D0-STD	Junior	2 Pump	18" Loc-Line	✓			Magnetic	Magnetic	10 oz.

NEAR-DRY SAWING SYSTEMS

Part No.	Type of Sawing	MQL Applicator	# of Pumps	Nozzle	Manual On/Off	Solenoid On/Off	Security Box
01A1-SAW	Band	Box	1 Pump	V-Nozzle	✓		✓
01A1-NNZ	Band	Box	1 Pump	N-Nozzle	✓		✓
02A1-RLZ	Band	Box	2 Pumps	RL-Nozzle		✓	✓
01A1-CIR	Circular	Box	1 Pump	C-Nozzle		✓	✓
01D0-SAW	Band	Junior	1 Pump	V-Nozzle	✓		
01D0-NNZ	Band	Junior	1 Pump	N-Nozzle	✓		
02D0-RLZ	Band	Junior	2 Pumps	RL-Nozzle	✓		
01D0-CIR	Circular	Junior	1 Pump	C-Nozzle	✓		

NEAR-DRY SAWING NOZZLES

Part No.	Type of Sawing	Nozzle	Specifications
9692	Band	V-Nozzle	Blades 0.75-1.5" wide
9696	Band	N-Nozzle	Blades 0.75-1.75" wide, 1.625" throat
9877	Band	RL-Nozzle	Blades up to 2" wide, requires 2 feeds
9878	Circular	C-Nozzle	Blades up to 20", 45° angled head
379165	Circular	CM-Nozzle	Blades 22-36", requires 2-3 feeds
9045	Circular	CL-Nozzle	Blades 36-120", requires 3 feeds

Accu-Lube®



TW **ROCOL® North America** *A Division of Illinois Tool Works Inc.*

TEL: (800) 452-5823 or (847) 657-5278

FAX: (800) 952-5823 or (847) 657-4897

info@rocolnorthamerica.com

www.rocolnorthamerica.com

3650 West Lake Ave, Glenview, IL 60026

