

CIMCOOL[®]

METALWORKING FLUIDS

CIMSTAR[®] 3800

SEMISYNTHETIC, METALWORKING FLUID CONCENTRATE

APPLICATIONS	<p>CIMSTAR[®] 3800 is designed for general machining of automotive aluminum parts. It is also recommended for general-purpose aluminum wheel machining on cast and wrought aluminum alloys</p> <p>Metals: Aluminum, Titanium, Exotic Alloys, Cast Iron, Carbon Steels, High Speed Steel, High Alloy Steels, Stainless Steels, Copper, Brass, Bronze</p> <p>Duty Range: For light to moderate duty operations</p>
FEATURES & BENEFITS	<p>Excellent Lubricity - Provides excellent tool life and surface finish</p> <p>Excellent Foam Control - Very low foaming, without the use of silicone antifoam</p> <p>Excellent Cleanliness - Rejects tramp oil, provides clean parts and keeps machines clean</p> <p>Forgiving Residue - The product is easily rinsed off parts for post-machining operations</p> <p>Excellent Microbial Control - Excellent bio-stability - Provides long sump life</p> <p>Excellent Corrosion Control - Specialized non-ferrous corrosion inhibitors eliminate part staining and prevent bi-metallic corrosion</p> <p>Superior Material and Application Compatibility - Designed to meet requirements for aluminum wheel machining - Compatible with titanium and other exotic alloys - Can be used on ferrous and non-ferrous metals where one product is needed for a variety of jobs</p> <p>Operator-Friendly - No smoke - No slippery film on parts, machinery or floor - Low misting - Mild to the skin</p>

<p>RECOMMENDED STARTING DILUTIONS</p>	<p>FOR INDUSTRIAL USE ONLY Use between 5.0% (1:20) and 10.0% (1:10) for machining of aluminum wheels.</p> <p>CIMSTAR[®] 3800 is to be mixed with water for use (add concentrate to water).</p> <p>Add no other substances to the concentrate or mix unless approved by CIMCOOL[®] Technical Services. Not recommended for use with magnesium or alloyed magnesium.</p> <p>For concentration analysis, use the MI Titration Procedure, Non-Solvent Titration Procedure, Total Alkalinity Titration Procedure, CIMCHEK[™] Test Strip, or Refractometer.</p>
<p>TYPICAL PHYSICAL AND CHEMICAL PROPERTIES</p>	<p>Physical state: Liquid Appearance and odor: Clear, chemical Colors available: Undyed, pink Solubility in water: 100% Miscible Weight, lb/gal, 60°F (15.6°C): 8.65 Specific gravity, (H₂O = 1): 1.036 Boiling point, °F (°C): 212 (100) Flash point, COC, °F (°C): None, self extinguishing Fire point, COC, °F (°C): NA Extinguishing media: NA Unusual fire & explosion hazards: None Freezing point (or pour point), °F, (°C): 30 (-1) If frozen, thoroughly thaw prior to using. pH, concentrate: 9.2 pH, 5.0% mix, typical operating conditions: 8.9 Total chlorine/chloride, wt%, calculated: 0.00/< 50 ppm Total sulfur, wt%, calculated: 0.09 Silicones: None</p>
<p>PACKAGING</p>	<p>Available in 5-gallon pails, 55-gallon drums, and bulk containers.</p>
<p>REFRACTOMETER FACTOR = 2.4 Multiply the scale reading obtained on your CIMCOOL[®] Metalworking Fluid or other acceptable refractometer by the Refractometer Factor to obtain the mix concentration in percent.</p> <p>NOTE: Calibrate the refractometer so that it reads 0.0 with water, before testing the sample mix. Remove gross contaminants from the sample mix, before testing.</p>	
<p>For additional information concerning CIMSTAR[®] 3800, refer to its OSHA MSDS or contact CIMCOOL[®] Technical Services at 1-513-458-8199.</p> <p><small>Minor formulation changes or normal variations in the manufacture of this product may cause slight variances in the data presented on this sheet. Consumable Products Division/ Milacron Marketing Company Cincinnati, Ohio 45209</small></p> <p>9/29/00</p>	