

CIMCOOL®

METALWORKING FLUIDS

CIMSTAR® 3865

SEMISYNTHETIC, METALWORKING FLUID CONCENTRATE

APPLICATIONS	<p>CIMSTAR® 3865 is designed for general-purpose machining and grinding of nonferrous and ferrous metals. CIMSTAR® 3865 is also recommended for general-purpose machining of cast and wrought aluminum metals.</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 moderate to heavy-duty operations</p>
FEATURES & BENEFITS	<p>EXCELLENT LUBRICITY - Contains a chlorinated extreme pressure lubricant which will allow difficult operations such as "Roll Tapping" aluminum to be accomplished - 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>Note: CIMSTAR® 3865B has the same performance characteristics as CIMSTAR® 3865 but in addition, is designed to be low foaming.</p>

<p>RECOMMENDED STARTING DILUTIONS</p>	<p>FOR INDUSTRIAL USE ONLY Use between 5.0% (1:20) and 10.0% (1:10) for moderate to heavy-duty machining and grinding of nonferrous and ferrous metals.</p> <p>CIMSTAR® 3865 is to be mixed with water for use (add concentrate to water). Add no other substances to the concentrate or mix unless approved by CIMCOOL® Technical Services.</p> <p>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): 8.78 Specific gravity, (H₂O = 1): 1.052 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): 28 (-2) Protect from freezing. pH, concentrate: 9.0 pH, 5.0% mix, typical operating conditions: 8.7 Total chlorine/chloride, wt%, calculated: 3.48/< 50 ppm Total sulfur, wt%, calculated: 0.20 Silicones: No for CIMSTAR® 3865 / Yes for CIMSTAR® 3865B</p>
<p>PACKAGING</p>	<p>Available in 5-gallon pails, 55-gallon drums, and bulk containers.</p>
<p>REFRACTOMETER FACTOR = 2.0 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® 3865, 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>PC-9870-1 10/24/01</p>	