

CIMCOOL[®]

METALWORKING FLUIDS

CIMTECH[®] 100

SYNTHETIC, METALWORKING FLUID CONCENTRATE

APPLICATIONS	<p>CIMTECH[®] 100 is an extremely low foaming, clear, synthetic metalworking fluid. It should be used for applications where foam control is critical, such as double disc, surface grinding, roll grinding, and Blanchard grinding.</p> <p>Metals: Cast Iron, Nodular Iron, Carbon Steels, Ferrous Metals</p> <p>Duty Range: For light to moderate-duty operations</p>
FEATURES & BENEFITS	<p>CIMTECH[®] 100 can be used in central systems as well as individual machines on ferrous applications. It is stable in both hard and soft water.</p> <p>RANCIDITY CONTROL - Exceptionally good bacteria and mold control</p> <p>CLEANLINESS - Excellent clarity and cleanliness - Emulsifies very little tramp oil - Tramp oil floats on top of the mix and can be removed easily by an oil skimmer</p> <p>EXCELLENT FOAM CONTROL - Even in operations with high agitation</p> <p>EXCELLENT SETTLING PROPERTIES - Cast iron and graphite fines settle readily; Mix stays clean; finish-marring chips and grit do not recirculate throughout the system</p> <p>DEPLETION RESISTANT - Lean make-up keeps the concentration at the recommended dilution, since CIMTECH[®] 100 is not easily degraded by bacteria, or depleted by high chip loads - Reduces costs by reducing the amount of concentrate required for makeup</p> <p>OPERATOR & MACHINE FRIENDLY - Pleasant to use - Does not smoke or leave a slippery, oily film on parts, machines or surrounding areas - Stable and transparent</p> <p>CORROSION CONTROL - Excellent rust control on cast iron and steel due to its unique proprietary combination of rust inhibitors</p>

<p>RECOMMENDED STARTING DILUTIONS</p>	<p>FOR INDUSTRIAL USE ONLY Use between 5.0% (1:20) and 10.0% (1:10) for machining and grinding ferrous metals.</p> <p>CIMTECH[®] 100 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 Total Alkalinity Titration Procedure, BCG Titration Procedure, CIMCHEK[™] Test Strip, or Refractometer.</p>
<p>TYPICAL PHYSICAL AND CHEMICAL PROPERTIES</p>	<p>Physical state: Liquid Appearance and odor: Clear, slight chemical Colors available: Undyed, pink, green Solubility in water: 100% Miscible Weight, lb/gal, 60°F (15.6°C): 8.74 Specific gravity, (H₂O = 1): 1.048 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) If frozen, thaw completely at room temperature. pH, concentrate: 10.0 pH, 5.0% mix, typical operating conditions: 9.1 Total chlorine/chloride, wt%, calculated: 0.00/0.06 Total sulfur, wt%, calculated: 0.00 Silicones: None</p>
<p>PACKAGING</p>	<p>Available in 5-gallon pails, 55-gallon drums, and bulk containers.</p>
<p>REFRACTOMETER FACTOR = 4.0 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 CIMTECH[®] 100, 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-2001 11/21/01</p>	