

CIMCOOL[®]

METALWORKING FLUIDS

CIMTECH[®] 400

SYNTHETIC, METALWORKING FLUID CONCENTRATE

APPLICATIONS	<p>CIMTECH[®] 400 is a clear, water-based synthetic metalworking fluid. It is recommended for heavy-duty machining and grinding of steel and cast iron to replace cutting oils and soluble oils. Especially effective for machining and grinding alloy steels and exotic metals.</p> <p>Metals: Ferrous metals such as Cast Iron, Carbon Steels, High Speed Steel, High Alloy Steels, Stainless Steels</p> <p>Duty Range: For moderate to heavy-duty operations</p>
FEATURES & BENEFITS	<p>EXCELLENT LUBRICITY - Provides a wide range of machining capabilities varying from high-speed operations to such slow-speed operations as tapping and sawing - Displays good grinding capabilities in G-Ratio tests</p> <p>SUPERIOR TOOL LIFE - Allows high speeds and feeds to increase production - Reduces heat in the chip formation process - Provides excellent cooling properties, resulting in more precise part geometry - Exhibits good settling properties - Effectively settles both cast iron and steel fines, preventing the recirculation of finish-marring swarf and clogging lines</p> <p>EXCELLENT RANCIDITY CONTROL - Long product life - Greatly reduces odor problems even in individual machines</p> <p>LIGHT RESIDUAL FILM - Product leaves soft liquid film that is easily rinsed off of parts for post-machining operations - Excellent cleanliness - Less residue buildup in low flow and splash zones than with other synthetics - Has good washing action to keep machine tools clean</p> <p>OTHER ADVANTAGES - No smoke - No slippery film on parts, machinery or floor - Low misting - Mild to the skin - Rejects tramp oil - Very low foaming, without the use of silicone antifoam - Provides corrosion protection for ferrous metals</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[®] 400 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, CIMCHEK[™] Test Strip, or Refractometer.</p>
<p>TYPICAL PHYSICAL AND CHEMICAL PROPERTIES</p>	<p>Physical state: Liquid Appearance and odor: Slightly hazy, sassafras Colors available: Undyed, blue, pink Solubility in water: 100% Miscible Weight, lb/gal, 60°F (15.6°C): 8.83 Specific gravity, (H₂O = 1): 1.058 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): 15 (-9) If frozen, product separates. Thaw completely at room temperature and stir thoroughly. pH, concentrate: 9.6 pH, 4.0% mix, typical operating conditions: 9.1 Total chlorine/chloride, wt%, calculated: 0.00/< 50 ppm 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 = 2.3 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[®] 400, 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-910 12/20/01</p>	