

CIMCOOL[®]

METALWORKING FLUIDS

CIMTECH[®] 420

SYNTHETIC, METALWORKING FLUID CONCENTRATE

APPLICATIONS	<p>CIMTECH[®] 420 metalworking fluid is a water-based synthetic fluid having excellent lubricity, cleanliness, and microbial control.</p> <p>Metals: Ferrous metals such as Cast Iron, Carbon Steels, High Speed Steel, High Alloy Steels, Stainless Steels, Some alloys of aluminum and other non-ferrous materials</p> <p>Duty Range: For moderate to heavy-duty operations</p>
FEATURES & BENEFITS	<p>LUBRICITY - Excellent lubricity provides good tool life and surface finish - In applications where fluid pressures are high, minimizes pump wear</p> <p>EXCELLENT MICROBIAL CONTROL - Excellent biological control - Provides long sump life -</p> <p>EXCELLENT CORROSION CONTROL - Good corrosion control for ferrous metals - Also protects machine components from rusting</p> <p>EXCELLENT CLEANLINESS - Provides clean parts and keeps machines clean - Rejects tramp oil - The product is easily rinsed off of parts for post-machining operations</p> <p>OTHER ADVANTAGES - No smoke - No slippery film on parts, machinery or floor - Low misting - Mild to the skin - Very low foaming, without the use of silicone antifoam - Very economical due to low makeup rate</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[®] 420 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, vanilla Colors available: Undyed, pink Solubility in water: 100% Miscible Weight, lb/gal, 60°F (15.6°C): 8.54 Specific gravity, (H₂O = 1): 1.024 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): 20 (-7) If frozen, product separates. Thaw completely at room temperature and stir thoroughly. pH, concentrate: 9.9 pH, 5.0% mix, typical operating conditions: 9.0 Total chlorine/chloride, wt%, calculated: 0.00/< 50 ppm Total sulfur, wt%, calculated: 0.23 Silicones: None</p>
<p>PACKAGING</p>	<p>Available in 5-gallon pails, 55-gallon drums, and bulk containers.</p>
<p>REFRACTOMETER FACTOR = 3.1 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[®] 420, refer to its OSHA MSDS or contact CIMCOOL[®] Technical Services at 1-513-458-8199.</p> <p>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</p> <p>PC-2066 12/20/01</p>	