

CIMCOOL®

METALWORKING FLUIDS

QUANTALUBE® 275

PREMIUM WATER SOLUBLE METALWORKING FLUID DESIGNED
FOR HEAVY-DUTY GRINDING AND MACHINING OPERATIONS

APPLICATIONS	<p>QUANTALUBE® 275 is an extremely heavy-duty metalworking fluid containing a patented lubrication package. It is designed to replace straight oils in many applications, and give greatly improved performance over conventional water-soluble products. QUANTALUBE® 275 can be used in individual machines or central systems.</p> <p>QUANTALUBE® 275 is recommended for heavy-duty grinding operations such as, centerless, in-feed, groove, internal and thread. Typical operations are strut, valve and bearing grinding. It is also recommended for use on machining operations such as gun drilling, sawing, hobbing, drilling, reaming, broaching and milling.</p> <p>Metals: All Steels, Aluminum alloys</p> <p>Duty Range: For heavy-duty to extremely heavy-duty operations</p>
FEATURES & BENEFITS	<p>SUPERIOR LUBRICATION -The patented lubrication package provides lubricity equal to or exceeding most straight oil products. QUANTALUBE® 275 can be used to replace straight oil in many applications and to greatly improve the performance of other metalworking fluids, when it is used as an additive (LUBRICANT G).</p> <p>PRODUCTIVITY IMPROVEMENTS - Lower cutting forces and higher grinding performance - Increased part production, lower machine down-time for tool and wheel changes - Better part quality - Outstanding productivity improvements and cost savings when QUANTALUBE® 275 is used with Milacron MSB™ or CBN wheels.</p> <p>ENVIRONMENTALLY FRIENDLY - When used to replace straight oils, QUANTALUBE® 275 provides a much cleaner work environment, lower oil mist in the air, and less risk of fire hazards.</p> <p>OPERATOR FRIENDLY - Very mild product - Easy to mix and control</p> <p>EXCELLENT MICROBIAL CONTROL - Controls bacteria and mold to provide long sump life</p>

<p>RECOMMENDED STARTING DILUTIONS</p>	<p>FOR INDUSTRIAL USE ONLY Use between 5.0% (1:20) and 10.0% (1:10) for grinding and machining.</p> <p>QUANTALUBE® 275 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, alloyed magnesium, cast iron, brass, or copper.</p> <p>For concentration analysis, use the MI Titration Procedure, Non-Solvent Titration Procedure, Total Alkalinity Titration Procedure, or Refractometer.</p>
<p>TYPICAL PHYSICAL AND CHEMICAL PROPERTIES</p>	<p>Physical state: Liquid Appearance and odor: Clear, sassafras Colors available: Undyed Solubility in water: 100% Miscible Weight, lb/gal, 60°F (15.6°C): 8.69 Specific gravity, (H₂O = 1): 1.0418 Boiling point, °F (°C): NA Flash point, COC, °F (°C): 315 (157) Fire point, COC, °F (°C): 330 (166) Extinguishing media: Chemical foam, carbon dioxide, water fog, dry chemical Unusual fire & explosion hazards: None Freezing point (or pour point), °F, (°C): -5 (-21) If frozen, thaw completely at room temperature. pH, concentrate: NA pH, 5.0% mix, typical operating conditions: 8.5 Total chlorine/chloride, wt%, calculated: 0.00/< 50 ppm Total sulfur, wt%, calculated: 28.99 Silicones: Yes</p>
<p>PACKAGING</p>	<p>Available in 5-gallon pails, 55-gallon drums, and bulk containers.</p>
<p>REFRACTOMETER FACTOR =0.8 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 QUANTALUBE® 275, 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>2/26/01</p>	