

CIMCOOL®

METALWORKING FLUIDS

CIMSTAR® 30

SEMISYNTHETIC, METALWORKING FLUID CONCENTRATE

APPLICATIONS	<p>CIMSTAR® 30 is a translucent, water soluble, semisynthetic metalworking fluid. It is designed to be a general-purpose machining and grinding fluid for use on a variety of materials and operations.</p> <p>Metals: Carbon steels, Alloy steels, Cast iron, Copper alloys, and some Aluminum alloys with medium machinability ratings (For aluminum applications, test the specific alloy in a mix to ensure that staining does not occur)</p> <p>Duty Range: For light to moderate-duty operations</p>
FEATURES & BENEFITS	<p>EXCEPTIONALLY MILD - A good choice for individual machine applications</p> <p>EXCELLENT CLEANLINESS - Provides clean parts and keeps machines clean - Good residue characteristics - Residue is easily removed with an alkaline cleaner or just warm water</p> <p>LOW OIL EMULSIFICATION - Extraneous oil can be skimmed from the mix to maximize fluid performance and life</p> <p>EXCELLENT FOAM CONTROL - low foaming, even in soft water (less than 125-ppm total hardness)</p> <p>GOOD RANCIDITY CONTROL - Inhibits the growth of bacteria and mold - Helps to eliminate "Monday morning odor"</p> <p>ENVIRONMENTALLY-FRIENDLY - Good sump life and operator acceptance - Easy to maintain and control - Waste treatable using standard fluid treatment procedures and systems - Can also be recycled for reuse using appropriate recycling equipment</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 and nonferrous metals.</p> <p>CIMSTAR® 30 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 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, amber/almond Colors available: Undyed Solubility in water: 100% Miscible Weight, lb/gal, 60°F (15.6°C): 8.31 Specific gravity, (H₂O = 1): 0.995 Boiling point, °F (°C): 212 (100.0) 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): 32 (0.0) Protect from freezing. pH, concentrate: 9.9 pH, 5.0% mix, typical operating conditions: 8.7 Total chlorine/chloride, wt%, calculated: 0.00/< 50 ppm Total sulfur, wt%, calculated: 0.20 Silicones: None</p>
<p>PACKAGING</p>	<p>Available in 5-gallon pails, 55-gallon drums, and bulk containers.</p>
<p>REFRACTOMETER FACTOR = 3.8 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 CIMSTAR® 30, 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-2050 12/14/06</p>	