

# CIMCOOL®

## METALWORKING FLUIDS

### CIMSTAR® 3865

#### SEMISYNTHETIC, METALWORKING FLUID CONCENTRATE

<b>APPLICATIONS</b>	<p><b>CIMSTAR® 3865</b> is designed for general-purpose machining and grinding of nonferrous and ferrous metals. CIMSTAR® 3865 is also recommended for general-purpose machining of cast and wrought aluminum metals.</p> <p><b>Metals:</b> Aluminum, Cast Iron, Carbon Steels, High Speed Steel, High Alloy Steels, Stainless Steels, Copper, Brass, Bronze, and some Exotic Alloys</p> <p><b>Duty Range:</b> For moderate to heavy-duty operations</p>
<b>FEATURES &amp; BENEFITS</b>	<p><b>EXCELLENT LUBRICITY</b> - Contains a chlorinated extreme pressure lubricant which will allow difficult operations such as "Roll Tapping" aluminum to be accomplished - Excellent tool life and surface finish</p> <p><b>EXCELLENT FOAM CONTROL</b> - Very low foaming, without the use of silicone antifoam</p> <p><b>EXCELLENT CLEANLINESS</b> - Rejects tramp oil, provides clean parts and keeps machines clean</p> <p><b>FORGIVING RESIDUE</b> - The product is easily rinsed off parts for post-machining operations</p> <p><b>EXCELLENT MICROBIAL CONTROL</b> - Excellent bio-stability - Provides long sump life</p> <p><b>EXCELLENT CORROSION CONTROL</b> - Specialized non-ferrous corrosion inhibitors eliminate part staining and prevent bi-metallic corrosion</p> <p><b>SUPERIOR MATERIAL and APPLICATION COMPATIBILITY</b> - Designed to meet requirements for aluminum wheel machining - Compatible with many titanium alloys and other exotic alloys - Can be used on ferrous and non-ferrous metals where one product is needed for a variety of jobs</p> <p><b>OPERATOR-FRIENDLY</b> - No smoke - No slippery film on parts, machinery or floor - Low misting - Mild to the skin</p> <p><b>Note:</b> CIMSTAR® 3865B has the same performance characteristics as CIMSTAR® 3865 but in addition, is designed to be low foaming.</p>

<p><b>RECOMMENDED STARTING DILUTIONS</b></p>	<p><b>FOR INDUSTRIAL USE ONLY</b>  <b>Recommended Starting Dilution: 5% (1:20)</b>  <b>Typical Operating Range: 5% (1:20) to 10% (1:10)</b>  <b>For concentrations outside this range contact CIMCOOL® Technical Service at 513-458-8199.</b></p> <p><b>CIMSTAR® 3865</b> is to be mixed with water for use (add concentrate to water). Add no other substances to the concentrate or mix unless approved by CIMCOOL® Technical Services.</p> <p>Not recommended for use with magnesium or alloyed magnesium.</p> <p><b>For concentration analysis, use</b> the MI Titration Procedure, Non-Solvent Titration Procedure, Total Alkalinity Titration Procedure, CIMCHEK™ Test Strip, or Refractometer.</p>
<p><b>TYPICAL PHYSICAL AND CHEMICAL PROPERTIES</b></p>	<p><b>Physical state:</b> Liquid  <b>Appearance and odor:</b> Clear / Chemical  <b>Colors available:</b> Undyed, Pink  <b>Solubility in water:</b> 100% Miscible  <b>Weight, lb/gal, 60°F (15.6°C):</b> 8.78  <b>Specific gravity, (H<sub>2</sub>O = 1):</b> 1.052  <b>Boiling point, °F (°C):</b> 212 (100)  <b>Flash point, COC, °F (°C):</b> None, Self Extinguishing  <b>Fire point, COC, °F (°C):</b> NA  <b>Freezing point (or pour point), °F, (°C):</b> 28 (-2)          If frozen, product separates. Thaw completely at room temperature and stir thoroughly.  <b>pH, concentrate:</b> 9.2  <b>pH, 5.0% mix, typical operating conditions:</b> 8.7  <b>Total chlorine/chloride, wt%, calculated:</b> 3.02/&lt; 50 ppm  <b>Total sulfur, wt%, calculated:</b> 0.20  <b>Silicones:</b> No for CIMSTAR® 3865 / Yes for CIMSTAR® 3865B</p>
<p><b>PACKAGING</b></p>	<p><b>Available in 5-gallon pails, 55-gallon drums, and bulk containers.</b></p>
<p><b>REFRACTOMETER FACTOR = 2.0</b> Multiply the scale reading obtained on your CIMCOOL® Metalworking Fluid or other acceptable refractometer by the <b>Refractometer Factor</b> to obtain the mix concentration in percent.</p> <p><b>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.</b></p> <p>This product to be used within six months of its manufacture date indicated by the lot number on the container label.</p>	
<p>For additional information concerning CIMSTAR® 3865, refer to its OSHA MSDS or contact CIMCOOL® Technical Services at 1-513-458-8199. Reprints/Updates of this Product Information Flyer (PIF) can be found on our web site, <a href="http://WWW.CIMCOOL.COM">WWW.CIMCOOL.COM</a> or from your Milacron representative.</p> <p style="text-align: center;"><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><b>PC-9870 5/9/07</b></p>	

