

CIMCOOL[®]

METALWORKING FLUIDS

CIMSTAR[®] 55

SEMISYNTHETIC, METALWORKING FLUID CONCENTRATE

APPLICATIONS	<p>CIMSTAR[®] 55 is recommended for general-purpose machining and grinding of ferrous and nonferrous metals.</p> <p>Metals: Carbon/Cast Steel, Cast/Nodular/Malleable/Gray Iron, Copper, Aluminum, High Speed Steel, High Alloy Steels, Stainless Steels</p> <p>Duty Range: For light to moderate-duty operations</p>
FEATURES & BENEFITS	<p>CIMSTAR[®] 55 metalworking fluid blends the advantages of synthetics with the performance of soluble oils.</p> <p>EXCELLENT BIOLOGICAL CONTROL - Effective protection against bacteria and mold. No "Monday Morning" odors - This ensures long fluid life, minimizes the use of additives, and increases operator satisfaction</p> <p>OPERATOR AND MACHINE-FRIENDLY - No smoke - No slippery film on parts, machines or floors - Mild to skin when used as recommended - Liquid residue keeps machine tool components free-moving regardless of equipment age</p> <p>CORROSION CONTROL – Contains nonferrous corrosion inhibitors</p> <p>VERSATILE - Its broad concentration range 1:20 (5%) to 1:10 (10%) and performance capabilities allow CIMSTAR[®] 55 to perform well in both individual machine sump and central system applications.</p> <p>ENVIRONMENTALLY-FRIENDLY - Easy to maintain and can be recycled for extended life</p> <p>Note: CIMSTAR[®] 55B has the same performance characteristics as CIMSTAR[®] 55 but in addition, is designed to be low foaming in soft water (50 ppm hardness)</p>

<p>RECOMMENDED STARTING DILUTIONS</p>	<p>FOR INDUSTRIAL USE ONLY Recommended Starting Dilution: 5% (1:20) Typical Operating Range: 5% (1:20) to 10% (1:10) For concentrations outside this range contact CIMCOOL® Technical Service at 513-458-8199.</p> <p>CIMSTAR® 55 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 / Chemical Colors available: Undyed Solubility in water: 100% Miscible Weight, lb/gal, 60°F (15.6°C): 8.54 Specific gravity, (H₂O = 1): 1.0236 Boiling point, °F (°C): 212 (100) Flash point, COC, °F (°C): None, self extinguishing Fire point, COC, °F (°C): None, self extinguishing Freezing point (or pour point), °F, (°C): 30 (-1) If frozen, thaw completely at room temperature. pH, concentrate: 9.6 pH, 5.0% mix, typical operating conditions: 9.0 Total chlorine/chloride, wt%, calculated: 0.000 / < 50 ppm Total sulfur, wt%, calculated: 0.155 Silicones: No for CIMSTAR® 55 / Yes for CIMSTAR® 55B</p>
<p>PACKAGING</p>	<p>Available in 5-gallon pails, 55-gallon drums, and bulk containers.</p>
<p>REFRACTOMETER FACTOR = 2.1 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 CIMSTAR® 55, 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, WWW.CIMCOOL.COM or from your Milacron representative.</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-3103 12/13/07</p>	

