

CIMCOOL®

METALWORKING FLUIDS

CIMSTAR® 60LF

SEMISYNTHETIC, METALWORKING FLUID CONCENTRATE

APPLICATIONS	<p>CIMSTAR® 60LF is a general-purpose fluid recommended for machining and grinding aluminum, iron and steel.</p> <p>It has the performance capabilities of soluble oils. It is also recommended for tapping, reaming, turning, drilling, internal grinding, and centerless grinding.</p> <p>Metals: Cast Iron, Nodular Iron, Carbon Steels, High Speed Steel, High Alloy Steels, Stainless Steels, Aluminum</p> <p>Duty Range: For moderate to heavy-duty operations</p>
FEATURES & BENEFITS	<p>CIMSTAR® 60LF metalworking fluid is a clean, completely water soluble, phenol-free, silicone-free, semi synthetic product that contains an extreme pressure (EP) lubricant for superior machining and grinding capability.</p> <p>Designed to be low foaming in soft water (less than 125 ppm total hardness)</p> <p>Advantages: Economical, Excellent lubricity, Excellent rancidity and mold control, Outstanding cleanliness, Leaves a soft residue</p> <p>Biostable: Exceptionally good bacteria and mold control - Resists attack by mold and bacteria</p> <p>Is easily waste treatable using standard fluid treatment procedures and systems. It can also be recycled for reuse using appropriate metalworking fluid recycling equipment.</p> <p>Very Cost effective</p> <p>Versatile: Specially designed for excellent machining and grinding of aluminum, iron and steel</p> <p>Parts and machines stay very clean</p> <p>Excellent corrosion control on both ferrous and nonferrous metals</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® 60LF 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, dark amber/vanilla Colors available: Undyed, pink, blue Solubility in water: 100% Miscible Weight, lb/gal, 60°F (15.6°C): 8.67 Specific gravity, (H₂O = 1): 1.039 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): 24 (-4) If frozen, thoroughly thaw prior to using. pH, concentrate: 9.2 pH, 5.0% mix, typical operating conditions: 8.9 Total chlorine/chloride, wt%, calculated: 3.50/< 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 = 1.7 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® 60LF, refer to its OSHA MSDS or contact CIMCOOL® Technical Services at 1-513-458-8199.</p> <p><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>11/29/00</p>	