

CIMSTAR[®] 70-HFP with FACT[™]

Semi-Synthetic, Metalworking Fluid Concentrate for High Fluid Pressure Applications

<p>APPLICATIONS</p>	<p>CIMSTAR[®] 70-HFP is a semi-synthetic recommended for High Fluid Pressure and High Volume Flow Applications where minimization of foam is critical for part quality and machine operations. It can be used for machining and grinding operations of ferrous and some non-ferrous materials, where a moderate to heavy-duty fluid is desired. The product is chlorine free.</p> <p>Metals: Most Aluminum Alloys, Cast Iron, Nodular Iron, Carbon Steels, High Speed Steels, High Alloy Steels, Stainless Steels, Most Non-Ferrous Alloys</p> <p>Duty Range: For moderate to heavy-duty operations</p>																												
<p>FEATURES & BENEFITS</p>	<p>CIMCOOL[®] – HFP Fluids <small>with FACT[™]</small> provide superior foam control through the combination of product design, raw material selection and innovative antifoam technology. These fluids are the result of years of experience that have identified creative methods to prevent, control and reduce foam, even when fluids are used in high pressure delivery systems. This expertise is only available in CIMCOOL[®] – HFP Fluids <small>with FACT[™]</small>.</p> <div data-bbox="690 982 1188 1430" data-label="Figure"> <p>High Pressure Foam Test 600 psi @ 5% in 50 ppm water CIMSTAR[®] 70 – HFP</p> <table border="1"> <caption>Approximate data from High Pressure Foam Test graph</caption> <thead> <tr> <th>Minutes</th> <th>Competitor A (%)</th> <th>Competitor B (%)</th> <th>CIMSTAR 70-HFP (%)</th> </tr> </thead> <tbody> <tr> <td>0</td> <td>0</td> <td>0</td> <td>0</td> </tr> <tr> <td>2</td> <td>45</td> <td>45</td> <td>25</td> </tr> <tr> <td>4</td> <td>60</td> <td>60</td> <td>35</td> </tr> <tr> <td>6</td> <td>65</td> <td>65</td> <td>45</td> </tr> <tr> <td>8</td> <td>68</td> <td>68</td> <td>55</td> </tr> <tr> <td>10</td> <td>70</td> <td>70</td> <td>65</td> </tr> </tbody> </table> </div> <p>LUBRICITY – A combination of lubricants provides good machining and grinding properties- Keeps parts and tools cool</p> <p>EXCELLENT FERROUS CORROSION CONTROL – Rust inhibitor package is extremely effective in preventing in-process rust on machines and parts-Also very effective on cast/malleable/gray and nodular iron</p> <p>SUPERIOR RANCIDITY CONTROL – Effective protection against bacteria and mold gives long fluid life</p> <p>OPERATOR FRIENDLY – Mild to skin – Easy to mix – Pleasant odor – Keeps machines clean</p> <p>VERSATILE – Suitable for a wide range of materials and operations-Can be used on aluminum alloys</p> <p>ENVIRONMENTALLY FRIENDLY – is easy to maintain and control-Compatible with most conventional waste treatment methods</p>	Minutes	Competitor A (%)	Competitor B (%)	CIMSTAR 70-HFP (%)	0	0	0	0	2	45	45	25	4	60	60	35	6	65	65	45	8	68	68	55	10	70	70	65
Minutes	Competitor A (%)	Competitor B (%)	CIMSTAR 70-HFP (%)																										
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<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[®] 70-HFP is to be mixed with water for use (add concentrate to water).</p> <p>Add no other substances to the concentrate 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 to slight haze/Chemical Colors available: Undyed Solubility in water: 100% Miscible Weight, lb/gal, 60° F (15.6° C): 8.4 Specific gravity, H₂O = 1): 1.01 Boiling point, °F (°C): 212 (100) Flash point, COC, °F (°C): None, Self Extinguishing Fire point COC, °F (°C): None, Self Extinguishing Freezing point, °F (°C): 23 (-5) If frozen, thaw completely at room temperature. pH, concentrate: 9.4 pH, 5.0% mix, typical operating conditions: 9.0 Total chlorine/chloride, wt%, calculated: 0.00/< 50ppm Total sulfur, wt%, calculated: 0.16 Dicyclohexylamine: None</p>
<p>PACKAGING</p>	<p>Available in 5-gallon pails, 55-gallon drums, and bulk containers.</p>
<p>REFRACTOMETER FACTOR = 1.4 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[®] 70-HFP, 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 variations in the data presented on this sheet. Consumable Products Division/Milacron Marketing Company Cincinnati, Ohio 45209</p> <p>ISO Certified Company 9001/14001</p> <p>PC-HFP-103</p> 	