

CIMCOOL®

METALWORKING FLUIDS

CIMTECH® 3900

EMULSIFIABLE SYNTHETIC, METALWORKING FLUID

APPLICATIONS	<p>CIMTECH® 3900 is recommended for general-purpose and high production machining and grinding of non-ferrous metals. It can also be used in some applications on ferrous metals.</p> <p>Metals: Wrought and Cast Aluminum Alloys (particularly automotive aluminum), Brass, Bronze, Copper, Cast Iron, Carbon Steels, High Speed Steel, High Alloy Steels, Stainless Steels</p> <p>Duty Range: For moderate to heavy -duty operations</p>
FEATURES & BENEFITS	<p>CIMTECH® 3900 - Uniquely blends synthetic technology with the superior non-ferrous lubricating capabilities of premium soluble oils, to deliver unprecedented product lubricity, cleanliness, and sump life in non-ferrous metalworking operations.</p> <p>EXCELLENT LUBRICITY - Designed to maximize performance of high speed steel, carbide and diamond tooling applications - Formulated to reduce "built up edge" and provide lubrication against the abrasive properties of high silicon aluminum - Engineered to provide lubrication in cut tapping and roll tapping operations where thread integrity is critical - Delivers consistent low surface finishes in operations where this is a critical quality characteristic - Provides physical lubrication for machines and transfer lines</p> <p>REDUCES MANUFACTURING COSTS - Provides longer tool life through advanced lubricants - Increases tool life in critical operations such as drilling, reaming and tapping, allowing extended production runs between tool changes</p> <p>EXCELLENT RANCIDITY CONTROL - Effective and reliable control against mold and bacteria - Provides long fluid life - Minimizes the need for biocide additives in central system applications</p> <p>EXCELLENT CORROSION CONTROL - Non-staining on non-ferrous metals - Provides corrosion control for ferrous metals and machine parts, including bi-metallic corrosion control</p> <p>Note: CIMTECH® 3900B has the same performance characteristics as CIMTECH® 3900 but in addition, is lower foaming.</p>

<p>RECOMMENDED STARTING DILUTIONS</p>	<p>FOR INDUSTRIAL USE ONLY Recommended Starting Dilution: 3% (1:30) Typical Operating Range: 3% (1:30) to 7% (1:15) For concentrations outside this range contact CIMCOOL® Technical Service at 513-458-8199.</p> <p>CIMTECH® 3900 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: Hazy / Chemical Colors available: Undyed, Pink Solubility in water: 100% Miscible Weight, lb/gal, 60°F (15.6°C): 7.90 Specific gravity, (H₂O = 1): 0.9469 Boiling point, °F (°C): Not Applicable Flash point, COC, °F (°C): 250 (121) Fire point, COC, °F (°C): 260 (127) Freezing point, °F, (°C): 36 (2) If frozen, thaw completely at room temperature. pH, concentrate: Not Applicable pH, 3.0% mix, typical operating conditions: 8.7 Total chlorine/chloride, wt%, calculated: 0.00/< 50 ppm Total sulfur, wt%, calculated: 0.331 Silicones: Yes</p>
<p>PACKAGING</p>	<p>Available in 5-gallon pails, 55-gallon drums, and bulk containers.</p>
<p>REFRACTOMETER FACTOR = 1.0 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 CIMTECH® 3900, 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-2008 4/6/05</p>	

