

CIMCOOL®

METALWORKING FLUIDS

CIMTECH® 410

SYNTHETIC, METALWORKING FLUID CONCENTRATE

APPLICATIONS	<p>CIMTECH® 410 is recommended for machining and grinding operations on ferrous metals. It is an excellent choice for central system applications.</p> <p>Metals: Cast Iron, Nodular Iron, Carbon Steels, High Speed Steels, High Alloy Steels Stainless Steels, Tool Steels, Titanium, Other Exotic Metals</p> <p>Duty Range: For moderate to heavy-duty operations</p>
FEATURES & BENEFITS	<p>CIMTECH® 410 - Is a clear, water-based synthetic product containing a unique synthetic lubricant</p> <p>EXCELLENT LUBRICITY - Contains a synthetic lubricant which outperforms the cut zone lubricity obtained with oil-based extreme pressure cutting fluids - Applicable operations include tapping, reaming, milling, drilling, sawing, turning, etc. - Superior tool life - Allows high speeds and feeds, which increase productivity - Excellent cooling properties resulting in precise part geometry</p> <p>EXCELLENT CLEANLINESS - The product rejects tramp oil and leaves a soft, non-sticky liquid residue that is easily rinsed off</p> <p>OPERATOR-FRIENDLY - Excellent visibility - A fresh mix is transparent – No smoke - Low misting</p> <p>EXCELLENT MACHINE COMPATIBILITY - Low foaming even when used with deionized water</p> <p>EXCELLENT RANCIDITY CONTROL - Provides long fluid life - Minimizes biocide usage - Greatly reduces odor problems compared to soluble oils</p> <p>ECONOMICAL - Low carry-off on parts and chips result in lower concentrate usage compared to soluble oil and semisynthetic metalworking fluids - Good filterability--forms a good cake on positive filters, reducing media usage - Can be used in any type of filter system - The product can be recycled</p>

RECOMMENDED STARTING DILUTIONS	<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>CIMTECH® 410 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 Total Alkalinity Titration Procedure, CIMCHEK™ Test Strip, or Refractometer.</p>
TYPICAL PHYSICAL AND CHEMICAL PROPERTIES	<p>Physical state: Liquid Appearance and odor: Clear / Chemical Colors available: Undyed, Pink Solubility in water: 100% Miscible Weight, lb/gal, 60°F (15.6°C): 8.90 Specific gravity, (H₂O = 1): 1.067 Boiling point, °F (°C): 212 (100) Flash point, COC, °F (°C): None, Self Extinguishing Fire point, COC, °F (°C): NA Freezing point (or pour point), °F, (°C): 20 (-7) If frozen, product separates. Thaw completely at room temperature and stir thoroughly. pH, concentrate: 9.7 pH, 5.0% mix, typical operating conditions: 9.0 Total chlorine/chloride, wt%, calculated: 0.00/0.10 Total sulfur, wt%, calculated: 0.00 Silicones: None</p>
PACKAGING	Available in 5-gallon pails, 55-gallon drums, and bulk containers.
<p>REFRACTOMETER FACTOR = 2.0 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® 410, 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-2091 3/29/06</p>	

