

# CIMCOOL®

## METALWORKING FLUIDS

### CIMTECH® 410C

#### SYNTHETIC, METALWORKING FLUID CONCENTRATE

<b>APPLICATIONS</b>	<p><b>CIMTECH® 410C</b> is recommended for machining and grinding operations on ferrous metals. It is an excellent choice for central system applications.</p> <p><b>Metals:</b> Cast Iron, Nodular Iron, Carbon Steels, High Speed Steels, High Alloy Steels Stainless Steels, Tool Steels, Titanium, Other Exotic Metals</p> <p><b>Duty Range:</b> For moderate to heavy-duty operations</p>
<b>FEATURES &amp; BENEFITS</b>	<p><b>CIMTECH® 410C</b> - Is a clear, water-based synthetic product containing a unique synthetic lubricant</p> <p><b>EXCELLENT LUBRICITY</b> - Applicable operations include tapping, 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><b>EXCELLENT CLEANLINESS</b> - The product rejects tramp oil and leaves a soft, non-sticky liquid residue that is easily rinsed off</p> <p><b>OPERATOR-FRIENDLY</b> - Excellent visibility - A fresh mix is transparent - No smoke - Low misting</p> <p><b>EXCELLENT MACHINE COMPATIBILITY</b> - Low foaming even when used with deionized water</p> <p><b>EXCELLENT RANCIDITY CONTROL</b> - Provides long fluid life - Minimizes biocide usage - Greatly reduces odor problems compared to soluble oils</p> <p><b>ECONOMICAL</b> - 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>

<p><b>RECOMMENDED STARTING DILUTIONS</b></p>	<p><b>FOR INDUSTRIAL USE ONLY</b>  <b>Recommended Starting Dilution: 5% (1:20)</b>  <b>Typical Operating Range: 5% (1:20) to 10% (1:10)</b>  <b>For concentrations outside this range contact CIMCOOL® Technical Service at 513-458-8199.</b></p> <p><b>CIMTECH® 410C</b> 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><b>For concentration analysis, use</b> the Total Alkalinity Titration Procedure, BCG Titration Procedure, CIMCHEK™ Test Strip, or Refractometer.</p>
<p><b>TYPICAL PHYSICAL AND CHEMICAL PROPERTIES</b></p>	<p><b>Physical state:</b> Liquid  <b>Appearance and odor:</b> Clear / Chemical  <b>Colors available:</b> Undyed, Pink, Blue  <b>Solubility in water:</b> 100% Miscible  <b>Weight, lb/gal, 60°F (15.6°C):</b> 8.8  <b>Specific gravity, (H<sub>2</sub>O = 1):</b> 1.06  <b>Boiling point, °F (°C):</b> 212 (100)  <b>Flash point, COC, °F (°C):</b> None, Self Extinguishing  <b>Fire point, COC, °F (°C):</b> None, Self Extinguishing  <b>Freezing point (or pour point), °F, (°C):</b> 20 (-7)          If frozen, product separates. Thaw completely at room temperature and stir thoroughly.  <b>pH, concentrate:</b> 9.8  <b>pH, 5.0% mix, typical operating conditions:</b> 9.1  <b>Total chlorine/chloride, wt%, calculated:</b> 0.00/0.10  <b>Total sulfur, wt%, calculated:</b> 0.00  <b>Silicone:</b> None</p>
<p><b>PACKAGING</b></p>	<p><b>Available in 5-gallon pails, 55-gallon drums, and bulk containers.</b></p>
<p><b>REFRACTOMETER FACTOR = 2.5</b> Multiply the scale reading obtained on your CIMCOOL® Metalworking Fluid or other acceptable refractometer by the <b>Refractometer Factor</b> to obtain the mix concentration in percent.</p> <p><b>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.</b></p>	
<p>For additional information concerning CIMTECH® 410C, 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, <a href="http://WWW.CIMCOOL.COM">WWW.CIMCOOL.COM</a> 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><b>PC-9904 4/21/06</b></p>	

