

ADDITIVE 2AST-1

METALWORKING FLUID ADDITIVE



Product Information Flyer

ADDITIVE 2AST-1 may be used to temporarily control excessive foam in water-based metalworking fluids. The additive incorporates a proprietary blend of organosiloxane polymers that when used as recommended, should not exhibit silicone associated painting and plating adhesion problems, per the manufacturer.

WHEN TO USE:

Put ADDITIVE 2AST-1 into CIMCOOL[®] metalworking fluid mixes as recommended by CIMCOOL[®] Technical Services. Use in mix when foam is a problem.

A typical use would be to temporarily control foam in a new charge (fresh mix). Typically as metalworking fluid mixes age they become less foamy.

HOW TO USE:

Follow the recommended dilution range. Shake or stir prior to using.

ADDITIVE 2AST-1 can be used with soluble oil, semi-synthetic, or synthetic mixes. Overuse, however, can create additional foam.

Pour ADDITIVE 2AST-1 directly into the “clean” side of a central filtration system where contamination is the lowest to maximize effectiveness.

ADDITIVE 2AST-1

METALWORKING FLUID ADDITIVE

RECOMMENDED STARTING DILUTIONS FOR INDUSTRIAL USE ONLY

Use dilution is from 1:20,000 (0.005%)(6.4 ounces per 1,000 gallons) to 1:5000 (0.02%) (25.6 ounces per 1,000 gallons) maximum as an additive.

ADDITIVE 2AST-1 is to be added to CIMCOOL® metalworking fluid mixes as described above.

TYPICAL PHYSICAL AND CHEMICAL PROPERTIES

Physical state: Liquid

Appearance and odor: Hazy / Chemical

Solubility in water: < 1%

Weight, lb/gal, 60°F (15.6°C): 8.6

Specific gravity, (H₂O = 1): 1.04

Boiling point, °F (°C): Not Determined

Flash point, PMCC, °F (°C): 400 (204)

Unusual fire & explosion hazards: Exposure to extreme heat builds up pressure in closed containers. Cool with water stream.

Freezing point (or pour point), °F, (°C): -10 (-18)

pH, concentrate / pH 50% mix: Not Determined / 7.0 – 8.5

Total Chlorine/Chloride, wt%: 0/< 50 ppm

Total Sulfur, wt%: None

Silicones: Yes

HANDLING and STORAGE

If frozen, product separates. Thaw completely at room temperature and stir thoroughly. Inside storage is recommended.

SAFETY DATA SHEET

Available at www.cimcool.com

For additional information refer to its OSHA MSDS, website or contact your local CIMCOOL TECHNICAL SPECIALIST OR DISTRICT MANAGER, or you may contact CIMCOOL® Technical Services at 1-513-458-8199.

Limitation of Liability: Under no circumstances, shall we or any affiliate of ours have any liability whatsoever for loss of use, or for any indirect or consequential damages. Minor formulation changes or normal variations in the manufacture of this product may cause slight variances in the data presented on this sheet.



3000 Disney Street
Cincinnati, OH 45209
1-513-458-8199
Fax 1-513-458-8179