

# ADDITIVE 63

METALWORKING FLUID ADDITIVE



## Product Information Flyer

**ADDITIVE 63** is a metalworking fluid additive used to raise and/or buffer the mix pH in central system reservoirs. ADDITIVE 63 typically raises the pH of a used metalworking fluid mix by 0.2 to 0.3 units. A secondary effect is improved ferrous corrosion control.

### **OPERATIONS:**

Add to CIMCOOL<sup>®</sup> metalworking fluid mixes as directed by CIMCOOL<sup>®</sup> Technical Services . Use when the pH is below recommended operating specification, as determined by laboratory testing. If the pH must be raised more than 0.3 units then ADDITIVE LC may be required.

### **APPLICATION:**

Raise the pH on a test sample of the metalworking fluid mix in the lab first to see how much ADDITIVE 63 is required. Then scale up.

**RECOMMENDED STARTING DILUTIONS  
FOR INDUSTRIAL USE ONLY**

Typical Operating Range: 0.05% (1:2,000) to 0.1% (1:1,000)

For concentrations outside this range contact CIMCOOL® Technical Service at 513-458-8199.

**TYPICAL PHYSICAL AND CHEMICAL PROPERTIES**

**Physical state:** Liquid

**Appearance and odor:** Clear / Chemical

**Solubility in water:** 100% Miscible

**Weight, lb/gal, 60°F (15.6°C):** 7..86

**Specific gravity, (H<sub>2</sub>O = 1):** 0.942

**Boiling point, °F (°C):** 329 (165)

**Flash point, PMCC, °F (°C):** 188 (87)

**Freezing point (or pour point), °F, (°C):** 30 (-1)

If frozen thaw completely at room temperature.

**pH, concentrate:** 13.0

**pH, 0.1% mix, typical operating conditions:** 11.3

**Total Chlorine/Chloride, wt%:** 0.00/< 50ppm

**Total Sulfur, wt%:** 0.0

**Silicones:** No

**HANDLING and STORAGE**

If frozen thaw completely at room temperature. Inside storage is recommended.

**SAFETY DATA SHEET**

Available at [www.cimcool.com](http://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.*