



## Product Information Flyer

### DESCRIPTION

CIMPERIAL 10-1077 is a soluble oil recommended for heavy duty machining and grinding operations.

### APPLICATION

CIMPERIAL 10-1077 is for heavy to severe duty machining and grinding operations such as milling, drilling, boring, reaming, tapping, sawing, broaching, and multiple grinding operations. It can be used on mild steels, stainless steels, hardened steels, exotics and most aluminum alloys. It should not be used on magnesium alloys.

### FEATURES & BENEFITS

#### EXCELLENT LUBRICITY:

**GRINDING:** CIMPERIAL 10-1077 has excellent grinding ability where finish and part quality are vital.

**MACHINING:** CIMPERIAL 10-1077 will perform well in most machining applications, including drilling, reaming, sawing, form tapping, etc.

**UNIQUE FORMULATION:** This product contains a lubricity package which integrates the boundary lubrication of mineral oil and bio-based lubricants with extreme pressure additives to provide increased tool life and versatility for the shop floor.

#### MICROBIAL CONTROL:

Good microbial control.

### RECOMMENDED STARTING DILUTIONS

CIMPERIAL 10-1077 is to be mixed with water for use. Always add concentrate to water. Add no other materials to the concentrate or mix unless approved by your CIMCOOL® District Manager.

Grinding	5% - 10%	(1:20 to 1:10)
Machining	5% - 10%	(1:20 to 1:10)

### CONCENTRATION

MI Titration, Non-solvent Titration, Total Alkalinity, CIMCHEK™ Test Strip or Refractometer can be used.

The Refractometer Factor is 1.0

Multiply the scale reading obtained on your CIMCOOL® Refractometer by this factor to obtain the mix concentration in percent. Calibrate the refractometer so that it reads 0.0 with water before testing the sample mix. Remove gross contaminants from the sample mixes before testing.

### TYPICAL PHYSICAL AND CHEMICAL PROPERTIES

**Physical State:** Liquid

**Solubility in water:** 100% miscible

**Viscosity (SUS) @ 100°F:** 700

**pH Concentrate:** NA

**Total Chlorine/Chloride, wt%:** 5.4/<50ppm

**Silicones:** YES

**Appearance and Odor:** Hazy/Chemical

**Weight, lb/gal, 60°F (15.6 °C):** 8.3

**Flash Point /Sp.Gr./Boiling Point:** SEE MSDS

**pH Mix 5%, Typical Operating:** 8.6

**Total Sulfur, wt%:** 0.2

### 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.

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