



# Product Information Flyer

### DESCRIPTION

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

### APPLICATION

CIMPERIAL 10-1077CF 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:** Excellent grinding ability where wheel life and part quality are vital.

**MACHINING:** CIMPERIAL 10-1077CF will perform well in most machining applications, including drilling, turning, reaming, boring and sawing.

**UNIQUE FORMULATION:** This product has a unique blend of mineral oil-based and bio-based additives that provides excellent lubricity without the use of extreme pressure lubricants.

#### MICROBIAL CONTROL:

Good microbial control.

#### VERSATILE:

CIMPERIAL 10-1077CF can be used in virtually any operation on a variety of metals.

### RECOMMENDED STARTING DILUTIONS

CIMPERIAL 10-1077CF 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:** 800

**pH Concentrate:** NA

**Total Chlorine/Chloride, wt%:** 0.0/<50ppm

**Silicones:** YES

**Appearance and Odor:** Hazy/Chemical

**Weight, lb/gal, 60°F (15.6 °C):** 8.1

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

**pH Mix 5%, Typical Operating:** 8.5

**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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