



# Product Information Flyer

### DESCRIPTION

CIMPERIAL 1045 is a soluble oil metalworking fluid.

### APPLICATION

CIMPERIAL 1045 was developed for use in moderate to heavy-duty operations. It can be used on carbon steels, high speed steel, cast steels, alloy steels, tool steel, stainless steel, cast iron, and most non-ferrous alloys.

### FEATURES & BENEFITS

#### VERSATILE PRODUCT:

CIMPERIAL 1045 is a chlorine-free, general purpose formulation designed for a wide variety of metals and operations.

#### LUBRICITY:

CIMPERIAL 1045 contains mineral oil for physical lubricity and organic lubricants for heavy-duty operations. Provides excellent tool life and surface finishes.

#### CORROSION PROTECTION:

CIMPERIAL 1045 has excellent corrosion protection on ferrous and non-ferrous parts and machining components.

#### MICROBIAL CONTROL:

CIMPERIAL 1045 maintains control of bacteria and mold, resulting in extended fluid life.

### RECOMMENDED STARTING DILUTIONS

CIMPERIAL 1045 is to be mixed with water for use. Always add concentrate to water. Fluid may be more difficult to mix when water temperature is below 55°F. 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

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

The Refractometer Factor is 0.9

A refractometer is only recommended for use in checking the concentration of a fresh charge. 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: 890**

**pH Concentrate: NA**

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

**Silicones: Yes**

**Appearance and Odor: Clear/Chemical**

**Weight, lb/gal, 60°F (15.6 °C): 7.94**

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

**pH Mix 5%, Typical Operating: 8.7**

**Total Sulfur, wt%: 0.27**

### HANDLING AND STORAGE

If frozen, thaw completely at room temperature prior to use. 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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