CIMCOOL® FLUID TECHNOLOGY

CIMPERIAL® 1880M-LF

METALWORKING FLUID

Product Information Flyer

DESCRIPTION

CIMPERIAL 1880M-LF is a premium soluble oil metalworking fluid.

APPLICATION

CIMPERIAL 1880M-LF was develped for use on Magnesium*****, aluminum, carbon steels, high speed steel, cast steels, alloy steels, tool steel, stainless steel, cast iron and other non-ferrous metals . Designed for moderate to heavy-duty machining and grinding operations.

FEATURES & BENEFITS

MAGNESIUM COMPATIBILITY*:

CIMPERIAL 1880M-LF results in the lowest level of hydrogen evolution when compared to all other water-based products tested. Reduces magnesium dust creation.

VERSATILE PRODUCT:

CIMPERIAL 1880M-LF proveds excellent mix stability and mix cleanliness even in the presence of high levels of magnesium.

CORROSION PROTECTION:

CIMPERIAL 1880M-LF provides excellent corrosion control on magnesium, ferrous and other nonferrous metals.

MICROBIAL CONTROL:

CIMPERIAL 1880M-LF contains a microbial control package which extends fluid life for long lasting, trouble-free performance.

LOW FOAMING:

CIMPERIAL 1880M-LF can be used in high turnover, high pressure applications.

WASTE TREATABLE:

CIMPERIAL 1880M-LF is compatible with most conventional waste treatment methods.

RECOMMENDED STARTING DILUTIONS

CIMPERIAL 1880M-LF 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 (13 C). 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
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. A refractometer is only recommended for use in checking the concentration of a fresh charge.

TYPICAL PHYSICAL AND CHEMICAL PROPERTIES

Physical State: Liquid
Solubility in water: 100% miscible
Viscosity (SUS) @ 100°F: 725
pH Concentrate: NA
Total Chlorine/Chloride, wt%: 0.0/<50ppm
Silicones: NO
Appearance and Odor: Clear/Chemical
Weight, lb/gal, 60°F (15.6 °C): 7.8
Flash Point /Sp.Gr./Boiling Point: SEE MSDS
pH Mix 5%, Typical Operating: 8.5
Total Sulfur, wt%: 0.22

HANDLING AND STORAGE

If frozen, thaw completely at room temperature. 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.

* - **OTHER PRECAUTIONS:** When using this product on magnesium or alloys of magnesium proper safety procedures must be followed. These include: 1) providing ample flooding of the part with the metalworking fluid; 2) minimizing magnesium chip accumulation in machines, sumps and tanks; 3) promptly separating magnesium chips from the fluid; and 4) providing ventilation for hydrogen gas. For more information on machining of magnesium with water based metalworking fluids, please refer to the "Hydro Magnesium" website, http://www.hydromagnesium.com, in their brochure section under "Machining Magnesium" or the International Magnesium Association brochure "Safe Machining And Handling Of Magnesium Chips, Turnings & Grindings" that can be found in their "Publication and Video" section of their website, http://www.intlmag.org/brochures.aspx

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