



Product Information Flyer

DESCRIPTION

CIMPERIAL[®] 20Z is a premium soluble oil metalworking fluid.

APPLICATION

CIMPERIAL[®] 20Z was developed for use on carbon steels, high speed steel, alloy steels, tool steel, and stainless steel.

For heavy to extremely heavy-duty operations such as threading, tapping, broaching, reaming, gun drilling, and gear hobbing. It also recommended for diamond dressed form grinding operations such as ball track grinding of bearing races and bar grinding.

FEATURES & BENEFITS

LUBRICITY:

Contains a high degree of extreme pressure (EP) lubricity package. Exhibits an excellent grinding ratio when compared with straight oils and conventional soluble oils. Increased productivity because high speeds and feeds can be used. Better cooling and cleaning ability provide high stock removal rates and better finishes than straight oils.

CORROSION PROTECTION:

Excellent protection by a combination of chemical corrosion inhibitors and the physical protection of oil. No black staining problems like those associated with sulfurized cutting oils.

COST EFFECTIVE:

Provides higher productivity and improved cleanliness compared to straight oils. Avoids housekeeping problems and fire hazards of straight oils. Residues can be removed with water or alkaline cleaners, no solvent degreasers required with straight oils.

MICROBIAL CONTROL:

Maintains control of bacteria and mold, resulting in extended fluid life.

RECOMMENDED STARTING DILUTIONS

CIMPERIAL® 20Z 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.

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|-----------|----------|----------------|
| 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 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.

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%: 5.5/<50ppm

Silicones: No

Appearance and Odor: Clear/Chemical

Weight, lb/gal, 60°F (15.6 °C): 8.3

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

pH Mix 5%, Typical Operating: 8.8

Total Sulfur, wt%: 3.2

HANDLING and STORAGE

If frozen, product separates. Thaw completely at room temperature and stir thoroughly. 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.

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