



## Product Information Flyer

### DESCRIPTION

CIMPERIAL HD 265 is a premium water soluble “super lubricant” metal working fluid.

### APPLICATION

CIMPERIAL HD 265 was developed for use on carbon steels, high speed steels, high alloy steels, stainless steel, and tool steel. Should not be used on copper, copper alloys, brass, bronze or magnesium alloys. Designed for use in heavy-duty operations such as bearing, strut, and valve grinding.

### FEATURES & BENEFITS

#### LUBRICITY:

CIMPERIAL HD 265 contains a Patented Extreme Pressure (EP) additive which provides outstanding stock removal permitting high productivity increases. A series of extreme pressure lubricants are activated at various temperatures to permit high stock removals that are not possible with conventional water based fluids.

#### PRODUCTIVITY:

CIMPERIAL HD 265 improves part quality, lowers wheel and tool usage. Lower fluid makeup rates and increased machine uptime increases productivity.

#### PROCESS IMPROVEMENTS:

CIMPERIAL HD 265 provides reduced cycle times along with longer wheel and tool life, decreased machine horsepower and improved part finish.

**Note:** CIMPERIAL<sup>®</sup> HD 265B has the same performance characteristics but in addition, is designed to be low foaming in soft water (50ppm hardness)

### RECOMMENDED STARTING DILUTIONS

CIMPERIAL HD 265 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:** 600

**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):** 8.4

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

**pH Mix 5%, Typical Operating:** 8.8

**Total Sulfur, wt%:** 15.0

### 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](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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