



Product Information Flyer

DESCRIPTION

CIMSTAR 3865 is a semi-synthetic metalworking fluid.

APPLICATION

CIMSTAR 3865 was developed for use on aluminum however it can also be used on mild steels, stainless steels, hardened steels, and exotic materials. It should not be used on magnesium alloys.

For use in moderate duty machining and grinding applications, such as milling, drilling, cut tapping, reaming, boring and surface grinding.

FEATURES & BENEFITS

VERSATILE PRODUCT:

Excellent lubricity – physical, chemical and extreme pressure lubricants provide good machining and grinding ability.

CORROSION PROTECTION:

The oily residue keeps machine tools and work-piece materials free of corrosion and staining. Good on most non-ferrous alloys as well, including some yellow metals.

MICROBIAL CONTROL:

CIMSTAR 3865 has good rancidity control if product concentration is properly controlled.

FAOM CONTROL:

CIMSTAR 3865 has good foam control, CIMSTAR 3865B has improved foam control, especially in applications where higher pressures are employed.

RECOMMENDED STARTING DILUTIONS

CIMSTAR 3865 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. Fluid may be more difficult to mix when water temperature is below 55°F.

Grinding	5% - 10%	(1:20 to 1:10)
Machining	5% - 10%	(1:20 to 1:10)

CONCENTRATION

Non-solvent Titration, Total Alkalinity or Refractometer can be used.

The Refractometer Factor is 2.0

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: 300

pH Concentrate: 9.2

Total Chlorine/Chloride, wt%: 3.1/<50ppm

Silicones: No for 3865, Yes for 3865B

Appearance and Odor: Hazy/Chemical

Weight, lb/gal, 60°F (15.6 °C): 8.8

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

pH Mix 5%, Typical Operating: 8.7

Total Sulfur, wt%: 0.2

HANDLING and STORAGE

If frozen, product separates. Thaw completely at room temperature and stir thoroughly. Inside storage is recommended.

This product is to be used within six months of its manufacture date indicated by the lot number on the container label.

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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