



Product Information Flyer

DESCRIPTION

CIMTECH 410Z is a synthetic metalworking fluid.

APPLICATION

CIMTECH 410Z can be used on cast iron, nodular iron, carbon steels, high speed steels, high alloy steels, stainless steels, tool steels, titanium and other exotic metals. It should not be used on magnesium alloys or non-ferrous materials.

For moderate to heavy-duty operations.

FEATURES & BENEFITS

LUBRICITY:

Contains a synthetic lubricant which outperforms the lubricity of many oil-based cutting fluids. Superior tool life, allows high speeds and feeds which increase productivity. Excellent cooling properties resulting in precise part geometry.

CLEANLINESS:

Rejects tramp oil to keep product clean, which extends sump life. Provides excellent part visibility, fresh mix is transparent. No smoke, low misting.

MICROBIAL CONTROL:

Provides long fluid life. .

FOAMING:

Low foaming even when used with deionized water.

ECONOMICAL:

Low carry-off on parts and chips resulting in lower concentrate usage. Good filterability; forms a good cake on positive filters, reducing media usage. Can be used in any type of filter system. The product can be recycled.

RECOMMENDED STARTING DILUTIONS

CIMTECH 410Z 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

A BCG Titration, Total Alkalinity or Refractometer can be used.

The Refractometer Factor is 2.1.

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: 48

pH Concentrate: 9.5

Total Chlorine/Chloride, wt%: 0.0/0.1

Silicones: None

Appearance and Odor: Clear/Chemical

Weight, lb/gal, 60°F (15.6 °C): 8.8

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

pH Mix 5%, Typical Operating: 9.0

Total Sulfur, wt%: 0

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.

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