



Product Information Flyer

DESCRIPTION

MILFORM 6277 is a sulfurized synthetic stamping and drawing fluid for heavy duty duty.

APPLICATION

MILFORM 6277 is formulated for heavy duty stamping and drawing of ferrous and some non-ferrous metals and aluminum alloys. MILFORM 6277 is not recommended for use with magnesium or alloyed magnesium.

FEATURES & BENEFITS

VERSATILITY:

MILFORM 6277 provides excellent lubricity for ferrous metals and aluminum and contains a patented lubricant. It offers excellent corrosion control and extreme pressure where chlorine is not acceptable. MILFORM 6277 has good cleanliness characteristics and washes easily.

RECOMMENDED STARTING DILUTIONS

The proper concentration of MILFORM 6277 will vary dependent upon the type of metal, gauge of metal, process involved and method of lubricant application. MILFORM 6277 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.

Stamping & Drawing Applications: Typical Range is 10% (1:10) to 50% (1:2)

CONCENTRATION

The Refractometer Factor is TBD

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: Complete

Viscosity SUS @ 100 F:

pH Concentrate: 8.5

Total Chlorine/Chlorides, wt%: 0.0/<50 ppm

Silicones: None

Appearance and Odor: Slightly Hazy/Vanilla

Weight, lb/gal, 60°F (15.6 °C): 8.8

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

pH Mix 10%, Typical Operating: 8.2

Total Sulfur, wt%: 3.87

HANDLING AND STORAGE

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