



Product Information Flyer

DESCRIPTION

MILFORM 645 is a soluble oil used for moderate to heavy duty stamping and drawing.

APPLICATION

MILFORM 645 is a soluble oil used for moderate to heavy duty stamping and drawing of steels, galvanized steels and stainless steel.

FEATURES & BENEFITS

VERSATILITY:

MILFORM 645 provides excellent long-term corrosion control and is hard water stable. It also provides good microbial control and extends tool life.

RECOMMENDED STARTING DILUTIONS

The proper concentration of MILFORM 645 will vary dependent upon the type of metal, gauge of metal, process involved and method of lubricant application. MILFORM 645 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.

Roll Forming Applications: Typical Range is 5% (1:20) to 10% (1:10)
Stamping & Drawing Applications: Typical Range is 10% (1:10) to 40% (1:2.5)

CONCENTRATION

The Refractometer Factor is
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	Appearance and Odor: Clear/Chemical
Solubility in water: 100% miscible	Weight, lb/gal, 60°F (15.6 °C): 8.5
Viscosity SUS @ 100 F: 1,290	Flash Point /Sp.Gr./Boiling Point: SEE MSDS
pH Concentrate: NA	pH Mix 20%, Typical Operating: 8.8
Total Chlorine/Chlorides, wt%: 13.9/<50 ppm	Total Sulfur, wt%: 0.4
Silicones: None	

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.

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.