

# CIMCOOL<sup>®</sup>

## METALWORKING FLUIDS

### ADDITIVE 18

#### METALWORKING FLUID ADDITIVE

<b>DESCRIPTION</b>	<b>ADDITIVE 18</b> is a metalworking fluid additive used to improve cleaning action and as a residue modifier. It can be used in emulsion-type CIMCOOL <sup>®</sup> metalworking fluid mixes.
<b>WHEN TO USE</b>	Add to cutting fluid mixes as directed by CIMCOOL <sup>®</sup> Technical Services
<b>HOW TO USE</b>	Pour <b>ADDITIVE 18</b> directly into the "clean" side of a central filtration system where contamination is lowest and will be less likely to reduce its effectiveness. For individual machines, add directly to the sump (machine reservoir).

<b>RECOMMENDED STARTING DILUTIONS</b>	<p><b>FOR INDUSTRIAL USE ONLY</b>  <b>Recommended Starting Dilution: 0.1% (1:1,000)</b>  <b>Typical Operating Range: 0.1% (1:1,000) to 0.2% (1:500)</b>  <b>For concentrations outside this range contact CIMCOOL® Technical Service at 513-458-8199.</b></p> <p><b>ADDITIVE 18</b> is to be added to emulsion-type CIMCOOL® metalworking fluid mixes as described above.</p>
<b>TYPICAL PHYSICAL AND CHEMICAL PROPERTIES</b>	<p><b>Physical state:</b> Liquid  <b>Appearance and odor:</b> Colorless, Chemical  <b>Colors available:</b> NA  <b>Solubility in water:</b> 100% Miscible  <b>Weight, lb/gal, 60°F (15.6°C):</b> 7.94  <b>Specific gravity, (H<sub>2</sub>O = 1):</b> 0.9520  <b>Boiling point, °F (°C):</b> 446 (230)  <b>Flash point, COC, °F (°C):</b> 210 (99)  <b>Fire point, COC, °F (°C):</b> 212 (100)  <b>Freezing point (or pour point), °F, (°C):</b> -90 (-68)          If frozen, thaw completely at room temperature.  <b>pH, concentrate:</b> 7.0  <b>pH, 0.1% mix, typical operating conditions:</b> 7.0  <b>Total chlorine/chloride, wt%, calculated:</b> 0.0/0  <b>Total sulfur, wt%, calculated:</b> 0.0  <b>Silicones:</b> None</p>
<b>PACKAGING</b>	<b>Available in 5-gallon pails and 55-gallon drums.</b>
<p>For additional information concerning ADDITIVE 18, refer to its OSHA MSDS or contact CIMCOOL® Technical Services at 1-513-458-8199. Reprints/Updates of this Product Information Flyer (PIF) can be found on our web site, <a href="http://WWW.CIMCOOL.COM">WWW.CIMCOOL.COM</a> or from your Milacron representative.</p> <p>Minor formulation changes or normal variations in the manufacture of this product may cause slight variances in the data presented on this sheet.          Consumable Products Division/ Milacron Marketing Company          Cincinnati, Ohio 45209</p> <p><b>PC-9968 3/14/05</b></p>	

