

CIMCOOL[®]

METALWORKING FLUIDS

ADDITIVE 24ANF-1

METALWORKING FLUID ADDITIVE

DESCRIPTION	<p>Additive 24ANF-1, water-based antifoam specially developed for use with water-based metalworking fluids. The additive incorporates a organosiloxane polymer chemistry that when used as recommended, should not exhibit silicone associated painting and plating adhesion problems, per the manufacturer.</p>
WHEN TO USE	<p>Use in a water-based metalworking fluid mix when foam is a problem. Add to CIMCOOL[®] metalworking fluid mixes as recommended by CIMCOOL[®] Technical Services. Additive 24ANF-1 can be used with any water-based CIMCOOL[®] metalworking fluid. Note: constant use of this additive may cause the foam problem to worsen.</p>
HOW TO USE	<p><u>For central systems:</u> Pour Additive 24ANF-1 directly into the “clean” side of a central system where contamination is minimal, and will be less likely to reduce effectiveness. <u>For individual machines:</u> Pour Additive 24ANF-1 into the machine sump at a location that will provide thorough mixing.</p> <p>Use Additive 24ANF-1 at the leanest dilution first. If foam is still a problem, add additional 24ANF-1 but do not exceed the recommended maximum dilution. Follow the recommended dilution range (see below). Shake or stir prior to using.</p>

RECOMMENDED STARTING DILUTIONS	<p>FOR INDUSTRIAL USE ONLY Use dilution is from 1:20,000 (0.005%)(6.4 ounces per 1,000 gallons) to 1:10,000 (0.01%)(12.8 ounces per 1,000 gallons) maximum as an additive.</p> <p>Additive 24ANF-1 is to be added to CIMCOOL® metalworking fluid mixes as described above.</p>
TYPICAL PHYSICAL AND CHEMICAL PROPERTIES	<p>Physical state: Liquid Appearance and odor: Hazy, chemical Colors available: Undyed Solubility in water: Dispersible Weight, lb/gal, 60°F (15.6°C): 8.90 Specific gravity, (H₂O = 1): 1.067 Boiling point, °F (°C): 210 (99) Flash point, COC, °F (°C): 400 (204) Fire point, COC, °F (°C): NA Extinguishing media: Chemical foam, carbon dioxide, dry chemical Unusual fire & explosion hazards: Exposure to extreme heat builds up pressure in closed containers. Cool with water stream. Freezing point (or pour point), °F, (°C): 32 (0) If frozen, product separates. Thaw completely at room temperature and stir thoroughly. pH, concentrate: NA pH, 50.0% mix, typical operating conditions: 7.5 - 9.0 Total chlorine/chloride, wt%, calculated: 0.00/< 50ppm Total sulfur, wt%, calculated: 0.00 Silicones: Yes</p>
PACKAGING	Available in 5-gallon pails and 55-gallon drums.
<p>For additional information concerning Additive 24ANF-1, refer to its OSHA MSDS or contact CIMCOOL® Technical Services at 1-513-458-8199.</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. Milacron Marketing Company Cincinnati, Ohio 45209</p> <p>PC-9909 1/6/09</p>	

