

CIMCOOL[®]

METALWORKING FLUIDS

ADDITIVE 2AST-1

METALWORKING FLUID ADDITIVE

DESCRIPTION	<p>ADDITIVE 2AST-1 may be used to temporarily control excessive foam in water-based metalworking fluid. The additive incorporates a proprietary blend of organosiloxane polymers that when used as recommended, should not exhibit silicone associated painting and plating adhesion problems, per the manufacturer.</p>
WHEN TO USE	<p>Put ADDITIVE 2AST-1 into CIMCOOL[®] metalworking fluid mixes as recommended by CIMCOOL[®] Technical Services. Use in the mix when foam is a problem.</p> <p>A typical use would be to temporarily control foam in a new charge (fresh mix). Typically as metalworking fluid mixes age they become less foamy.</p>
HOW TO USE	<p>Follow the recommended dilution range (see below). Shake or stir prior to using.</p> <p>ADDITIVE 2AST-1 can be used with soluble oil, semisynthetic, or synthetic mixes. Overuse, however, can create additional foam.</p> <p>Pour ADDITIVE 2AST-1 directly into the "clean" side of a central filtration system where contamination is the lowest to maximize effectiveness.</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 1:5,000 (0.02%)(25.6 ounces per 1,000 gallons) maximum as an additive.</p> <p>ADDITIVE 2AST-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: < 1% Weight, lb/gal, 60°F (15.6°C): 8.61 Specific gravity, (H₂O = 1): 1.032 Boiling point, °F (°C): Not determined 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): (-18) If frozen, product separates. Thaw completely at room temperature and stir thoroughly. pH, concentrate: Not Determined pH, 50.0% mix, typical operating conditions: 7.0 - 8.5 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 2AST-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>	

