

CIMCOOL[®]

METALWORKING FLUIDS

ADDITIVE 44

METALWORKING FLUID ADDITIVE

DESCRIPTION	<p>ADDITIVE 44 is a metalworking fluid additive used to raise and/or buffer the mix pH in central system reservoirs. ADDITIVE 44 typically raises the pH of a used metalworking fluid mix by 0.2 to 0.3 units. A secondary effect is improved ferrous corrosion control.</p>
WHEN TO USE	<p>Add to CIMCOOL[®] metalworking fluid mixes as directed by CIMCOOL[®] Technical Services. Use when the pH is below recommended operating specification, as determined by laboratory testing. If the pH must be raised more than 0.3 units, then ADDITIVE LC may be required.</p>
HOW TO USE	<p>Raise the pH on a test sample of the metalworking fluid mix in the lab first to see how much ADDITIVE 44 is required. Then scale up.</p>

RECOMMENDED STARTING DILUTIONS	<p>FOR INDUSTRIAL USE ONLY Recommended Starting Dilution: 0.01% (1:10,000) Typical Operating Range: 0.01% (1:10,000) to 0.15% (1:650) For concentrations outside this range contact CIMCOOL® Technical Service at 513-458-8199.</p> <p>ADDITIVE 44 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: Clear, water-like/Chemical Colors available: Undyed Solubility in water: 100% Miscible Weight, lb/gal, 60°F (15.6°C): 0.9650 Specific gravity, (H₂O = 1): 8.05 Boiling point, °F (°C): 320 (160) Flash point, COC, °F (°C): 170 (77) Fire point, COC, °F (°C): NA Freezing point (or pour point), °F, (°C): 37 (3) If frozen, thaw completely at room temperature. pH, concentrate: 11.4 pH, 1.0% mix, typical operating conditions: 9.0 Total chlorine/chloride, wt%, calculated: 0.0 Total sulfur, wt%, calculated: 0.0 Silicones: None</p>
PACKAGING	Available in 5-gallon pails and 55-gallon drums.
<p>For additional information concerning ADDITIVE 44, 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, WWW.CIMCOOL.COM 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>PC-9970 3/9/05</p>	

