

# CIMCOOL®

## METALWORKING FLUIDS

### CIMFLO® 78

#### EMULSIFIABLE SYNTHETIC CAN-DRAWING AND CUPPING FLUID

<b>APPLICATIONS</b>	<p><b>CIMFLO® 78</b> is a synthetic emulsion product designed for drawing and ironing tin-plated steel cans. It provides excellent lubricity, rust control, and microbial control. This product may also be used as a cupper lubricant for tin-plated steel cans.</p> <p><b>Metals:</b> Tin-plated Steel</p>
<b>FEATURES &amp; BENEFITS</b>	<p><b>EXCELLENT LUBRICITY</b> - Minimizes or eliminates can wrinkling, ear clipping, and tear-offs resulting in higher production rates - Provides good punch and die life and low machine downtime - Prevents scratching of cans and tin-wipe problems - Furnishes excellent stripping characteristics in steel can-drawing</p> <p><b>ECONOMICAL WITH EASE OF CONTROL</b> - Can be used over a wide concentration range - Minimal fluid carry-off per can - Easily waste treatable</p> <p><b>EXCELLENT CORROSION CONTROL</b> - Freedom from corrosion of cans, bodymakers, and other system components even under high humidity conditions in an enclosed machine</p> <p><b>CLEAN</b> - Product leaves a soft residue that is easily removed in the washing process - Pleasant to use - Mild to skin - No slippery floors or oily mist - Good filtration properties - Low media usage and low oil emulsification - Keeps bodymaker dies extremely clean</p>

<p><b>RECOMMENDED STARTING DILUTIONS</b></p>	<p><b>FOR INDUSTRIAL USE ONLY</b>  <b>Typical Operating Ranges:</b>  - For Drawing and Ironing: 3.0% (1:30) to 5% (1:20)  - For cupping: 10.0% (1:10) to 33% (1:3)  <b>For concentrations outside this range contact CIMCOOL® Technical Service at 513-458-8199.</b></p> <p><b>CIMFLO® 78</b> is to be mixed with water for use (add concentrate to water).</p> <p>Add no other substances to the concentrate or mix unless approved by CIMCOOL® Technical Services. Not recommended for use with magnesium or alloyed magnesium.</p> <p><b>For concentration analysis, use the Acid Split Procedure, Non-Solvent Titration Procedure, or Refractometer.</b></p>
<p><b>TYPICAL PHYSICAL AND CHEMICAL PROPERTIES</b></p>	<p><b>Physical state:</b> Liquid  <b>Appearance and odor:</b> Hazy / Chemical  <b>Colors available:</b> Undyed  <b>Solubility in water:</b> 100% Miscible  <b>Weight, lb/gal, 60°F (15.6°C):</b> 8.46  <b>Specific gravity, (H<sub>2</sub>O = 1):</b> 1.0134  <b>Boiling point, °F (°C):</b> 212 (100.0)  <b>Flash point, COC, °F (°C):</b> None, Self Extinguishing  <b>Fire point, COC, °F (°C):</b> None, Self Extinguishing  <b>Freezing point, °F, (°C):</b> 26 (-3)  If frozen, product separates. Thaw completely at room temperature and stir thoroughly.  <b>pH, concentrate:</b> 9.6  <b>pH, 10.0% mix, typical operating conditions:</b> 9.2  <b>Total chlorine/chloride, wt%, calculated:</b> 0.00/&lt; 50 ppm  <b>Total sulfur, wt%, calculated:</b> 0.00  <b>Silicones:</b> None</p>
<p><b>PACKAGING</b></p>	<p><b>Available in 5-gallon pails, 55-gallon drums, and bulk containers.</b></p>
<p><b>REFRACTOMETER FACTOR = 2.1</b> Multiply the scale reading obtained on your CIMCOOL® Metalworking Fluid or other acceptable refractometer by the <b>Refractometer Factor</b> to obtain the mix concentration in percent.</p> <p><b>NOTE: Calibrate the refractometer so that it reads 0.0 with water, before testing the sample mix. Remove gross contaminants from the sample mix before testing.</b></p>	
<p>For additional information concerning CIMFLO® 78, 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-970 4/13/05</b></p>	

