

CIMCOOL®

METALWORKING FLUIDS

CIMFLO® 78

EMULSIFIABLE SYNTHETIC CAN-DRAWING AND CUPPING FLUID

APPLICATIONS	<p>CIMFLO® 78 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 copper lubricant for tin-plated steel cans.</p> <p>Metals: Tin-plated Steel</p>
FEATURES & BENEFITS	<p>EXCELLENT LUBRICITY - 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>ECONOMICAL WITH EASE OF CONTROL - Can be used over a wide concentration range - Minimal fluid carry-off per can - Easily waste treatable</p> <p>EXCELLENT CORROSION CONTROL - Freedom from corrosion of cans, bodymakers, and other system components even under high humidity conditions in an enclosed machine</p> <p>CLEAN - 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>RECOMMENDED STARTING DILUTIONS</p>	<p>FOR INDUSTRIAL USE ONLY Typical Operating Ranges: - For Drawing and Ironing: 3.0% (1:30) to 5% (1:20) - For cupping: 10.0% (1:10) to 33% (1:3) For concentrations outside this range contact CIMCOOL® Technical Service at 513-458-8199.</p> <p>CIMFLO® 78 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>For concentration analysis, use the Acid Split Procedure, Non-Solvent Titration Procedure, or Refractometer.</p>
<p>TYPICAL PHYSICAL AND CHEMICAL PROPERTIES</p>	<p>Physical state: Liquid Appearance and odor: Hazy / Chemical Colors available: Undyed Solubility in water: 100% Miscible Weight, lb/gal, 60°F (15.6°C): 8.46 Specific gravity, (H₂O = 1): 1.0134 Boiling point, °F (°C): 212 (100.0) Flash point, COC, °F (°C): None, Self Extinguishing Fire point, COC, °F (°C): None, Self Extinguishing Freezing point, °F, (°C): 26 (-3) If frozen, product separates. Thaw completely at room temperature and stir thoroughly. pH, concentrate: 9.6 pH, 10.0% mix, typical operating conditions: 9.2 Total chlorine/chloride, wt%, calculated: 0.00/< 50 ppm Total sulfur, wt%, calculated: 0.00 Silicones: None</p>
<p>PACKAGING</p>	<p>Available in 5-gallon pails, 55-gallon drums, and bulk containers.</p>
<p>REFRACTOMETER FACTOR = 2.1 Multiply the scale reading obtained on your CIMCOOL® Metalworking Fluid or other acceptable refractometer by the Refractometer Factor to obtain the mix concentration in percent.</p> <p>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.</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, 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-970 4/13/05</p>	

