

CIMCOOL®

METALWORKING FLUIDS

CIMPERIAL® 1045

(Formerly CX-1045A)

SOLUBLE OIL, METALWORKING FLUID CONCENTRATE

APPLICATIONS	<p>CIMPERIAL® 1045 metalworking fluid is recommended for a wide variety of "heavy-duty" machining and grinding operations including turning, drilling, tapping, reaming and milling.</p> <p>Metals: Carbon Steels, High Speed Steel, Cast Steels, Alloy Steels, Tool Steel, Stainless Steel, Cast Iron, Aluminum, Bronze, Brass, Copper</p> <p>Duty Range: For moderate to heavy-duty operations</p>
FEATURES & BENEFITS	<p>CIMPERIAL® 1045 is a chlorine-free, general-purpose formulation designed for a wide variety of metals and operations.</p> <p>EXCELENT LUBRICITY - Contains mineral oil for physical lubricity - Also contains organic lubricants for heavy-duty operations - Provides excellent tool life and surface finishes</p> <p>EXCELLENT BIOLOGICAL CONTROL - Maintains control of bacteria and mold, resulting in extended fluid life</p> <p>EXCELLENT CORROSION CONTROL – Controls ferrous and non-ferrous corrosion on parts and machine components</p> <p>OPERATOR FRIENDLY - Mild to skin - Easy to mix - Low foaming – Pleasant odor</p> <p>MACHINE FRIENDLY - Cleaner machines and work areas create a more pleasant work environment - Residue can be removed with water or alkaline cleaners – No solvent degreasers required as with straight oils</p> <p>ECONOMICAL - Wide application on metals and operations - CIMPERIAL® 1045 minimizes requirements for storage, mixing, charging, makeup and maintenance</p>

<p>RECOMMENDED STARTING DILUTIONS</p>	<p>FOR INDUSTRIAL USE ONLY Recommended Starting Dilution: 5% (1:20) Typical Operating Range: 5% (1:20) to 10% (1:10) For concentrations outside this range contact CIMCOOL® Technical Service at 513-458-8199.</p> <p>CIMPERIAL® 1045 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 MI Titration Procedure, Non-Solvent Titration Procedure, Total Alkalinity Titration Procedure, or Refractometer.</p>
<p>TYPICAL PHYSICAL AND CHEMICAL PROPERTIES</p>	<p>Physical state: Liquid Appearance and odor: Amber / Chemical Colors available: Undyed Solubility in water: 100% Miscible Weight, lb/gal, 60°F (15.6°C): 7.94 Specific gravity, (H₂O = 1): 0.952 Boiling point, °F (°C): Not Applicable Flash point, COC, °F (°C): 350 (177) Fire point, COC, °F (°C): 375 (191) Extinguishing media: Chemical foam, carbon dioxide, or dry chemical Unusual fire & explosion hazards: None Freezing point, °F, (°C): 28 (-2) If frozen, thaw completely at room temperature. pH, concentrate: Not Applicable pH, 5.0% mix, typical operating conditions: 8.7 Total chlorine / chloride, wt%, calculated: 0.00 / < 50 ppm Total sulfur, wt%, calculated: 0.27 Silicones: Yes Triazine: None</p>
<p>PACKAGING</p>	<p>Available in 5-gallon pails, 55-gallon drums, and bulk containers.</p>
<p>REFRACTOMETER FACTOR = 0.9 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 CIMPERIAL® 1045, 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 style="text-align: center;"><small>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</small></p> <p>PC-9839 6/2/08</p>	

