

CIMCOOL®

METALWORKING FLUIDS

CIMPERIAL® 1060CF

SOLUBLE OIL, METALWORKING FLUID CONCENTRATE

APPLICATIONS	<p>CIMPERIAL® 1060CF metalworking fluid is recommended for a wide variety of "heavy-duty" machining and grinding operations including turning, drilling, tapping, reaming, gear cutting, and broaching.</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 heavy-duty operations</p>
FEATURES & BENEFITS	<p>CIMPERIAL® 1060CF is a chlorine-free, general-purpose formulation designed for a wide variety of metals and operations.</p> <p>EXCELLENT 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® 1060CF minimizes requirements for storage, mixing, charging, makeup and maintenance</p> <p>Note:</p> <ul style="list-style-type: none">- Requires thorough stirring to insure complete mixing.- CIMPERIAL® 1060CFB has the same performance characteristics as CIMPERIAL® 1060CF but in addition, is designed to be low foaming in soft water (50 ppm hardness)

RECOMMENDED STARTING DILUTIONS	<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® 1060CF 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>
TYPICAL PHYSICAL AND CHEMICAL PROPERTIES	<p>Physical state: Liquid Appearance and odor: Hazy / Chemical Colors available: Undyed, Blue Solubility in water: 100% Miscible Weight, lb/gal, 60°F (15.6°C): 7.8 Specific gravity, (H₂O = 1): 0.94 Viscosity (SUS) @ 100° F, Typical: 411 Boiling point, °F (°C): Not Applicable Flash point, COC, °F (°C): 345 (174) Fire point, COC, °F (°C): 355 (179) Freezing point, °F, (°C): < 0 (< -18) If frozen product separates. Thaw completely at room temperature and stir thoroughly. pH, concentrate: Not Applicable pH, 5.0% mix, typical operating conditions: 8.6 Total chlorine/chloride, wt%, calculated: 0.00/< 50 ppm Total sulfur, wt%, calculated: 0.2 Silicones: No for CIMPERIAL® 1060CF / Yes for CIMPERIAL® 1060CFB</p>
PACKAGING	Available in 5-gallon pails, 55-gallon drums, and bulk containers.
<p>REFRACTOMETER FACTOR = 1.0 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® 1060CF, 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><small>LIMITATION OF LIABILITY: Under no circumstances shall we or any affiliate of ours have any liability whatsoever for loss of use or for any indirect or consequential damages. Minor formulation changes or normal variations in the manufacture of this product may cause slight variances in the data presented on this sheet.</small></p> <p style="text-align: center;"><small>Milacron Marketing Company LLC Cincinnati, Ohio 45209</small></p> <p>PC-10071 1/26/2010</p>	

