

CIMCOOL®

METALWORKING FLUIDS

CIMPERIAL® 1073

SOLUBLE OIL, METALWORKING FLUID CONCENTRATE

APPLICATIONS	<p>CIMPERIAL® 1073 metalworking fluid is a premium soluble oil designed for machining aluminum, but can also be used on other materials, including magnesium.</p> <p>CIMPERIAL® 1073 can be used in individual machines or central systems</p> <p>Metals: Aluminums, Carbon Steels, High Speed Steel, Cast Steels, Alloy Steels, Tool Steel, Stainless Steel, Titanium, Cast Iron, Magnesium*</p> <p>Duty Range: For moderate to heavy-duty operations</p>
FEATURES & BENEFITS	<p>EXCELLENT LUBRICITY - CIMPERIAL® 1073 can perform a variety of machining applications on magnesium, aluminum and steel - An exceptional product for form tapping aluminum - Can be used on a wide variety of metals and operations</p> <p>MAGNESIUM COMPATIBILITY* - Using CIMPERIAL® 1073 for machining magnesium results in minimal hydrogen evolution - Reduces magnesium dust creation</p> <p>GOOD CORROSION CONTROL - Good corrosion control on ferrous and nonferrous metals, including magnesium</p> <p>LOW FOAMING - Can be used in high turnover, high-pressure applications where foam control is required</p> <p>VERY GOOD RANCIDITY CONTROL - Contains a microbial control package which extends fluid life for long lasting, trouble-free performance</p> <p>WASTE TREATABLE - Compatible with most conventional waste treatment methods</p> <p>OPERATOR FRIENDLY - Mild to skin - Easy to mix</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® 1073 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.</p> <p>For concentration analysis, use the MI Titration Procedure, Non-Solvent Titration Procedure, BCG Titration Procedure, Total Alkalinity 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): 7.8 Viscosity SUS @ 100F: 290 Specific gravity, (H₂O = 1): 0.93 Boiling point, °F (°C): Not Applicable Flash point, COC, °F (°C): 315 (157) Fire point, COC, °F (°C): 325 (163) Freezing point, °F, (°C): < 0 (< -18) If frozen, thaw completely at room temperature. pH, concentrate: Not Applicable pH, 5.0% mix, typical operating conditions: 8.5 Total chlorine/chloride, wt%, calculated: 0.000/< 50 ppm Total sulfur, wt%, calculated: 0.5 Silicones: Yes</p>
<p>PACKAGING</p>	<p>Available in 5-gallon pails, 55-gallon drums, and bulk containers.</p>
<p>REFRACTOMETER FACTOR = 0.94 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® 1073, refer to its OSHA MSDS or contact CIMCOOL® Technical Services at 1-513-458-8199.</p> <p>* - OTHER PRECAUTIONS: When using this product on magnesium or alloys of magnesium proper safety procedures must be followed. These include: 1) providing ample flooding of the part with the metalworking fluid; 2) minimizing magnesium chip accumulation in machines, sumps and tanks; 3) promptly separating magnesium chips from the fluid; and 4) providing ventilation for hydrogen gas. For more information on machining of magnesium with water based metalworking fluids, please refer to the "Hydro Magnesium" website, http://www.hydromagnesium.com, in their brochure section under "Machining Magnesium" or the International Magnesium Association brochure "Safe Machining And Handling Of Magnesium Chips, Turnings & Grindings" that can be found in their "Publication and Video" section of their website, http://www.intlmag.org/brochures.aspx</p> <p>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.</p> <p style="text-align: center;">Milacron Marketing Company LLC Cincinnati, Ohio 45209</p> <p>PC-10105 5/7/2010</p>	

