

# CIMCOOL®

## METALWORKING FLUIDS

### CIMPERIAL® 16EP

SOLUBLE OIL, METALWORKING FLUID CONCENTRATE

<b>APPLICATIONS</b>	<p><b>CIMPERIAL® 16EP</b> metalworking fluid is a premium soluble oil designed for moderate to heavy-duty machining and grinding of ferrous and non-ferrous materials.</p> <p><b>CIMPERIAL® 16EP</b> can be used in individual machines or central systems</p> <p><b>Metals:</b> Carbon Steels, High Speed Steel, Cast Steels, Alloy Steels, Tool Steel, Stainless Steel, Cast Iron, Titanium, Aluminum, Bronze, Brass, Copper</p> <p><b>Duty Range:</b> For moderate to heavy-duty operations</p>
<b>FEATURES &amp; BENEFITS</b>	<p><b>EXCELLENT LUBRICITY</b> - CIMPERIAL® 16EP contains a chlorinated extreme pressure lubrication package to perform on a variety of machining and grinding applications.</p> <p><b>LOW FOAMING</b> - Can be used in high turnover, high-pressure applications where foam control is required</p> <p><b>VERY GOOD RANCIDITY CONTROL</b> - Contains a microbial control package which extends fluid life for long lasting, trouble-free performance</p> <p><b>WIDE APPLICATION RANGE</b> - Can be used on a wide variety of metals and operations</p> <p><b>WASTE TREATABLE</b> - Compatible with most conventional waste treatment methods</p> <p><b>OPERATOR FRIENDLY</b> - Mild to skin - Easy to mix</p>

<b>RECOMMENDED STARTING DILUTIONS</b>	<p><b>FOR INDUSTRIAL USE ONLY</b>  <b>Recommended Starting Dilution: 5% (1:20)</b>  <b>Typical Operating Range: 5% (1:20) to 10% (1:10)</b>  <b>For concentrations outside this range contact CIMCOOL® Technical Service at 513-458-8199.</b></p> <p><b>CIMPERIAL® 16EP</b> is to be mixed with water for use (add concentrate to water). Add no other substances to the concentrate or mix unless approved by CIMCOOL® Technical Services.</p> <p>Not recommended for use with magnesium or alloyed magnesium.</p> <p><b>For concentration analysis, use</b> the MI Titration Procedure, Non-Solvent Titration Procedure, Total Alkalinity Titration Procedure, CIMCHEK™ Test Strip, or Refractometer.</p>
<b>TYPICAL PHYSICAL AND CHEMICAL PROPERTIES</b>	<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> 8.4  <b>Specific gravity, (H<sub>2</sub>O = 1):</b> 1.00  <b>Boiling point, °F (°C):</b> NA  <b>Flash point, COC, °F (°C):</b> 360 (182)  <b>Fire point, COC, °F (°C):</b> 380 (193)  <b>Freezing point (or pour point), °F, (°C):</b> 28 (- 2)  If frozen, thaw completely at room temperature.  <b>pH, concentrate:</b> Not Applicable  <b>pH, 5.0% mix, typical operating conditions:</b> 8.6  <b>Total chlorine/chloride, wt%, calculated:</b> 7.3/&lt; 50 ppm  <b>Total sulfur, wt%, calculated:</b> 0.13  <b>Silicones:</b> Yes</p>
<b>PACKAGING</b>	<b>Available in 5-gallon pails, 55-gallon drums, and bulk containers.</b>
<p><b>REFRACTOMETER FACTOR = 0.9</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 CIMPERIAL® 16EP, 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 style="text-align: center;">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-9843 12/18/07</p>	

