

CIMCOOL®

METALWORKING FLUIDS

CIMPERIAL® 20-8S

PREMIUM SOLUBLE OIL, METALWORKING FLUID CONCENTRATE

APPLICATIONS	<p>CIMPERIAL® 20-8S metalworking fluid is a premium soluble oil designed for heavy-duty machining and grinding of ferrous and non-ferrous material. It can be used in individual machines or central systems.</p> <p>Metals: Carbon Steels, High Speed Steel, Cast Steels, Alloy Steels, Tool Steel, Stainless Steel, Titanium, Cast Iron, Most Aluminum Alloys, Copper</p> <p>Duty Range: For heavy-duty operations</p>
FEATURES & BENEFITS	<p>EXCELLENT LUBRICITY - Contains a unique blend of sulfurized and chlorinated Extreme Pressure (EP) lubricant additives to perform a variety of machining and grinding applications</p> <p>LOW FOAMING - Excellent foam control</p> <p>STABILITY - Makes a very stable mix and can be used in applications where hard water build-up is a problem</p> <p>VERY GOOD RANCIDITY CONTROL - The microbial control package extends fluid life for long-lasting, trouble-free performance</p> <p>WIDE APPLICATION RANGE - Can be used on a wide variety of metals and operations</p> <p>WASTE TREATABLE - Is compatible with most conventional waste treatment methods</p> <p>OPERATOR FRIENDLY - Very mild to skin - Easy to mix - Pleasant odor</p>

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® 20-8S 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>For concentration analysis, use the MI Titration Procedure, Non-Solvent Titration Procedure, Total Alkalinity Titration Procedure, CIMCHEK™ Test Strip, or Refractometer.</p>
TYPICAL PHYSICAL AND CHEMICAL PROPERTIES	<p>Physical state: Liquid Appearance and odor: Clear / Chemical Colors available: Undyed Solubility in water: 100% Miscible Weight, lb/gal, 60°F (15.6°C): 8.4 Specific gravity, (H₂O = 1): 1.01 Viscosity (SUS) @ 100° F, Typical: 1,200 Boiling point, °F (°C): Not Applicable Flash point, COC, °F (°C): 320 (160) Fire point, COC, °F (°C): 345 (174) Freezing point, °F, (°C): 30 (-1) 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: 7.8 / < 50 ppm Total sulfur, wt%, calculated: 3.2 Silicones: Yes</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® 20-8S, 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>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-9824 4/22/08</p>	