

CIMCOOL®

METALWORKING FLUIDS

CIMPERIAL® 600

SOLUBLE OIL, METALWORKING FLUID CONCENTRATE

APPLICATIONS	<p>CIMPERIAL® 600 metalworking fluid is a premium soluble oil designed for moderate to heavy-duty machining and grinding of ferrous and non-ferrous materials.</p> <p>CIMPERIAL® 600 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, Aluminum</p> <p>Duty Range: For moderate to heavy-duty operations</p>
FEATURES & BENEFITS	<p>EXCELLENT LUBRICITY - CIMPERIAL® 600 can perform a variety of machining and grinding applications.</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>WIDE APPLICATION RANGE - Can be used on a wide variety of metals and operations</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® 600 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: Hazy / Chemical Colors available: Undyed Solubility in water: 100% Miscible Weight, lb/gal, 60°F (15.6°C): 7.8 Specific gravity, (H₂O = 1): 0.94 Boiling point, °F (°C): Not Applicable Flash point, COC, °F (°C): 315 (157) Fire point, COC, °F (°C): 325 (163) Freezing point (or pour point), °F, (°C): 20 (-7) If frozen, thaw completely at room temperature. pH, concentrate: Not Applicable pH, 5.0% mix, typical operating conditions: 8.9 Total chlorine/chloride, wt%, calculated: 0.00/< 50 ppm Total sulfur, wt%, calculated: 0.06 Silicones: Yes</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® 600, 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>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-9805 1/12/07</p>	

