

CIMCOOL®

METALWORKING FLUIDS

CIMSTAR® 3865Z

SEMISYNTHETIC, METALWORKING FLUID CONCENTRATE

APPLICATIONS	<p>CIMSTAR® 3865Z is designed for general-purpose machining and grinding of nonferrous and ferrous metals. CIMSTAR® 3865Z is also recommended for general-purpose machining of cast and wrought aluminum metals.</p> <p>Metals: Aluminum, Cast Iron, Carbon Steels, High Speed Steel, High Alloy Steels, Stainless Steels and some Exotic Alloys</p> <p>Duty Range: For moderate to heavy-duty operations</p>
FEATURES & BENEFITS	<p>EXCELLENT LUBRICITY - Contains a chlorinated extreme pressure lubricant which will allow difficult operations such as "Roll Tapping" aluminum to be accomplished - Excellent tool life and surface finish</p> <p>EXCELLENT MICROBIAL CONTROL - Excellent bio-stability - Provides long sump life</p> <p>EXCELLENT FOAM CONTROL - Very low foaming, without the use of silicone antifoam</p> <p>GOOD CLEANLINESS - Good tramp oil rejection, provides clean parts and keeps machines clean</p> <p>FORGIVING RESIDUE - The product is easily rinsed off parts for post-machining operations</p> <p>EXCELLENT CORROSION CONTROL - Specialized non-ferrous corrosion inhibitors eliminate part staining and prevent bi-metallic corrosion</p> <p>SUPERIOR MATERIAL and APPLICATION COMPATIBILITY - Designed to meet requirements for aluminum wheel machining - Compatible with many titanium alloys and other exotic alloys - Can be used on ferrous and non-ferrous metals where one product is needed for a variety of jobs</p> <p>OPERATOR-FRIENDLY - No smoke - No slippery film on parts, machinery or floor - Low misting - Mild to the skin</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>CIMSTAR® 3865Z 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): 8.7 Specific gravity, (H₂O = 1): 1.04 Boiling point, °F (°C): 212 (100) Flash point, COC, °F (°C): None, Self Extinguishing Fire point, COC, °F (°C): None, Self Extinguishing Freezing point, °F, (°C): 22 (-6) If frozen, product separates. Thaw completely at room temperature and stir thoroughly. pH, concentrate: 8.8 pH, 5.0% mix, typical operating conditions: 8.6 Total chlorine/chloride, wt%, calculated: 3.02/< 50 ppm Total sulfur, wt%, calculated: 0.10 Silicones: None Dicyclohexylamine: None</p>
PACKAGING	Available in 5-gallon pails, 55-gallon drums, and bulk containers.
<p>REFRACTOMETER FACTOR = TBD 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 CIMSTAR® 3865Z, 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-9815 5/10/07</p>	

