

# CIMCOOL®

## METALWORKING FLUIDS

### CIMSTAR® 540

#### SEMISYNTHETIC, METALWORKING FLUID CONCENTRATE

<b>APPLICATIONS</b>	<p><b>CIMSTAR® 540</b> is a clear, water soluble, semi synthetic product having good rust control and excellent rancidity control.</p> <p><b>Metals:</b> Cast Iron, Nodular Iron, Carbon Steels, Some Aluminum, Copper, Brass, Bronze</p> <p><b>Duty Range:</b> For light to moderate duty operations</p>
<b>FEATURES &amp; BENEFITS</b>	<p><b>CIMSTAR® 540</b> is one of a new generation of biostable, metalworking fluids that control biological growth without bactericides. It uniquely blends the newest technological advances to deliver superior performance.</p> <p><b>GOOD MICROBIAL CONTROL</b> - Contains no bactericides - Bacteria control is achieved through technical advances, which are patented, therefore CIMSTAR® 540 has extended sump life.</p> <p><b>GENERAL-PURPOSE PRODUCT</b> - Can be used on a variety of metals and operations - Field testing showed no problems that could not be addressed by simply maintaining good concentration control - Excellent pH control</p> <p><b>OPERATOR / MACHINE FRIENDLY</b> - Excellent operator acceptance - No odor - Residue is easily removed - Excellent Cleanliness - Excellent foam control characteristics</p> <p><b>ENVIRONMENTALLY FRIENDLY</b> - Easy to maintain and control - Waste treatable using standard fluid treatment procedures and systems - Can also be recycled for reuse using appropriate metalworking fluid recycling equipment</p>

<p><b>RECOMMENDED STARTING DILUTIONS</b></p>	<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>CIMSTAR® 540</b> 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><b>For concentration analysis, use the MI Titration Procedure, Non-Solvent Titration Procedure, Total Alkalinity Titration Procedure, CIMCHEK™ Test Strip, or Refractometer.</b></p>
<p><b>TYPICAL PHYSICAL AND CHEMICAL PROPERTIES</b></p>	<p><b>Physical state:</b> Liquid  <b>Appearance and odor:</b> Clear / Chemical  <b>Colors available:</b> Undyed, Pink, Blue  <b>Solubility in water:</b> 100% Miscible  <b>Weight, lb/gal, 60°F (15.6°C):</b> 8.59  <b>Specific gravity, (H<sub>2</sub>O = 1):</b> 1.029  <b>Boiling point, °F (°C):</b> 212 (100)  <b>Flash point, COC, °F (°C):</b> None, Self Extinguishing  <b>Fire point, COC, °F (°C):</b> NA  <b>Freezing point (or pour point), °F, (°C):</b> 32 (0)          If frozen, product separates. Thaw completely at room temperature and stir thoroughly.  <b>pH, concentrate:</b> 10.0  <b>pH, 5.0% mix, typical operating conditions:</b> 8.9  <b>Total chlorine/chloride, wt%, calculated:</b> 0.00/&lt; 50 ppm  <b>Total sulfur, wt%, calculated:</b> 0.01  <b>Silicones:</b> None  <b>Triazine:</b> None</p>
<p><b>PACKAGING</b></p>	<p><b>Available in 5-gallon pails, 55-gallon drums, and bulk containers.</b></p>
<p><b>REFRACTOMETER FACTOR = 3.1</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 CIMSTAR® 540, 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>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><b>PC-6000 3/9/06</b></p>	

