

CIMCOOL®

METALWORKING FLUIDS

CIMSTAR® 60XLZ

SEMISYNTHETIC, METALWORKING FLUID CONCENTRATE

APPLICATIONS	<p>CIMSTAR® 60XLZ is recommended for general-purpose machining and grinding of ferrous and non-ferrous metals. It is recommended for turning, reaming, drilling, tapping, milling, as well as internal grinding, centerless and center-type grinding, etc.</p> <p>Metals: Cast Iron, Nodular Iron, Malleable Iron, Gray Iron, Carbon Steels, Cast Steel, High Speed Steel, High Alloy Steels, Stainless Steels, Aluminum</p> <p>Duty Range: For moderate to heavy-duty operations</p>
FEATURES & BENEFITS	<p>CIMSTAR® 60XLZ contains a chlorinated EP lubricant for heavy-duty operations providing the performance capabilities of soluble oils.</p> <p>EXCELLENT RANCIDITY CONTROL - Contains a patented bio-stable microbial control package - Effective protection against bacteria and mold - Provides long life and minimizes the use of additives</p> <p>FOAM CONTROL - Designed to be low foaming in soft water (less than 125 ppm total hardness)</p> <p>LUBRICITY – Physical and chemical lubricants provide good machining and grinding properties - Keeps parts and tools cool</p> <p>EXCELLENT FERROUS CORROSION CONTROL - Rust inhibitor package is extremely effective in preventing in-process rust on machines and parts - Also very effective on cast/malleable/gray/ and nodular iron</p> <p>NON-FERROUS CORROSION CONTROL - Contains non-ferrous corrosion inhibitors which prevent stain on aluminum alloys, brass, copper and bronze</p> <p>GENERAL-PURPOSE PRODUCT - Can be used economically throughout the shop on moderate to heavy-duty operations.</p> <p>OPERATOR FRIENDLY - Easy to maintain and control - Waste treatable using standard fluid treatment procedures and systems - Can be recycled for reuse</p> <p>Note: CIMSTAR® 60XLZB has the same performance characteristics as CIMSTAR® 60XLZ but in addition, is designed to be low foaming in soft water (50 ppm hardness)</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® 60XLZ 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, CIMCHEK™ Test Strip, or Refractometer.</p>
TYPICAL PHYSICAL AND CHEMICAL PROPERTIES	<p>Physical state: Liquid Appearance and odor: Clear / Chemical Colors available: Undyed, Pink Solubility in water: 100% Miscible Weight, lb/gal, 60°F (15.6°C): 8.7 Specific gravity, (H₂O = 1): 1.04 Viscosity (SUS) @ 100° F, Typical: 425 for CS-60XLZ / 700 for CS-60XLZB Boiling point, °F (°C): 212 (100) Flash point, COC, °F (°C): None, Self Extinguishing Fire point, COC, °F (°C): None, Self Extinguishing Freezing point (or pour point), °F, (°C): 26 (-3) If frozen, thaw completely at room temperature. pH, concentrate: 9.8 pH, 5.0% mix, typical operating conditions: 8.9 Total chlorine/chloride, wt%, calculated: 3.60/< 50 ppm Total sulfur, wt%, calculated: 0.28 Silicones: No for CIMSTAR® 60XLZ / Yes for CIMSTAR® 60XLZB Dicyclohexylamine: None</p>
PACKAGING	Available in 5-gallon pails, 55-gallon drums, and bulk containers.
<p>REFRACTOMETER FACTOR = 1.5 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® 60XLZ, 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 style="text-align: center;"><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-9955 4/15/08</p>	

