

# CIMCOOL®

## METALWORKING FLUIDS

### CIMTECH® 100

#### SYNTHETIC, METALWORKING FLUID CONCENTRATE

<b>APPLICATIONS</b>	<p><b>CIMTECH® 100</b> is an extremely low foaming, clear, synthetic metalworking fluid. It should be used for applications where foam control is critical, such as double disc, surface grinding, roll grinding, and Blanchard grinding.</p> <p><b>Metals:</b> Cast Iron, Nodular Iron, Carbon Steels, Ferrous Metals</p> <p><b>Duty Range:</b> For light to moderate-duty operations</p>
<b>FEATURES &amp; BENEFITS</b>	<p><b>CIMTECH® 100</b> can be used in central systems as well as individual machines on ferrous applications. It is stable in both hard and soft water.</p> <p><b>RANCIDITY CONTROL</b> - Exceptionally good bacteria and mold control</p> <p><b>CLEANLINESS</b> - Excellent clarity and cleanliness - Emulsifies very little tramp oil - Tramp oil floats on top of the mix and can be removed easily by an oil skimmer</p> <p><b>EXCELLENT FOAM CONTROL</b> - Even in operations with high agitation</p> <p><b>EXCELLENT SETTLING PROPERTIES</b> - Cast iron and graphite fines settle readily; Mix stays clean; finish-marring chips and grit do not recirculate throughout the system</p> <p><b>DEPLETION RESISTANT</b> - Lean make-up keeps the concentration at the recommended dilution, since CIMTECH® 100 is not easily degraded by bacteria, or depleted by high chip loads - Reduces costs by reducing the amount of concentrate required for makeup</p> <p><b>OPERATOR &amp; MACHINE FRIENDLY</b> - Pleasant to use - Does not smoke or leave a slippery, oily film on parts, machines or surrounding areas - Stable and transparent</p> <p><b>CORROSION CONTROL</b> - Excellent rust control on cast iron and steel due to its unique proprietary combination of rust inhibitors</p>

<p><b>RECOMMENDED STARTING DILUTIONS</b></p>	<p><b>FOR INDUSTRIAL USE ONLY</b>  <b>Use between 5.0% (1:20) and 10.0% (1:10) for machining and grinding ferrous metals.</b></p> <p><b>CIMTECH® 100</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</b> the Total Alkalinity Titration Procedure, BCG Titration Procedure, CIMCHEK™ Test Strip, or Refractometer.</p>
<p><b>TYPICAL PHYSICAL AND CHEMICAL PROPERTIES</b></p>	<p><b>Physical state:</b> Liquid  <b>Appearance and odor:</b> Clear, slight chemical  <b>Colors available:</b> Undyed, Pink, Green, Blue  <b>Solubility in water:</b> 100% Miscible  <b>Weight, lb/gal, 60°F (15.6°C):</b> 8.74  <b>Specific gravity, (H<sub>2</sub>O = 1):</b> 1.048  <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>Extinguishing media:</b> NA  <b>Unusual fire &amp; explosion hazards:</b> None  <b>Freezing point (or pour point), °F, (°C):</b> 28 (-2)          If frozen, thaw completely at room temperature.  <b>pH, concentrate:</b> 10.0  <b>pH, 5.0% mix, typical operating conditions:</b> 9.1  <b>Total chlorine/chloride, wt%, calculated:</b> 0.00/0.06  <b>Total sulfur, wt%, calculated:</b> 0.00  <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 = 4.0</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 CIMTECH® 100, 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-2001 9/21/06</b></p>	

