

CIMCOOL[®]

METALWORKING FLUIDS

CIMTECH[®] 108 (formerly CIMFREE[®] 108) SYNTHETIC, METALWORKING FLUID CONCENTRATE

APPLICATIONS	<p>CIMTECH[®] 108 is a synthetic metalworking fluid formulated for machining and grinding of ferrous metals.</p> <p>Metals: Cast Iron and Carbon Steels</p> <p>Duty Range: Light duty operations</p>
FEATURES & BENEFITS	<p>EXCELLENT FILTRATION and SETTLING PROPERTIES – forms a good cake on positive filters, which removes fines and reduces media usage. Settles cast iron and graphite fines readily in settling systems. Mixes stay clean; finish-marring chips and grit do not circulate.</p> <p>EXCEPTIONAL ODOR CONTROL – no offensive odors caused by excessive growth of bacteria and mold is formulated to resist depletion by micro-organisms and chips, minimal concentrate additions will maintain the recommended concentration.</p> <p>DEPLETION RESISTANT – lean make-up rates keeps concentration at the recommended dilution since the CIMTECH 108 is not easily degraded by bacteria or heavy chip loads. Saves money by reducing the amount of concentrate that must be purchased or kept on hand, and by providing long-term trouble free performance.</p> <p>EXCELLENT CORROSION CONTROL - Protects cast iron and steel from rust using a unique proprietary combination of rust inhibitors prevents corrosion of cast iron and steel</p> <p>COMPATIBLE WITH BOTH HARD AND SOFT WATER - Good foam control and mix stability</p> <p>REJECTS tramp oil</p>

RECOMMENDED STARTING DILUTIONS	<p>FOR INDUSTRIAL USE ONLY Recommended Starting Dilution: 3% (1:33) Typical Operating Range: 3% (1:33) to 5% (1:20) For concentrations outside this range contact CIMCOOL® Technical Service at 513-458-8199.</p> <p>CIMTECH® 108 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 BCG 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): 9.0 Specific gravity, (H₂O = 1): 1.18 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): 12 F (-11) If frozen, product separates. Thaw completely at room temperature and stir thoroughly. pH, concentrate: 10.2 pH, 3.3% mix, typical operating conditions: 9.0 Total chlorine/chloride, wt%, calculated: 0.00 / < 50 ppm Total sulfur, wt%, calculated: 0.2 Silicones: 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 CIMTECH® 108, 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. Milacron Marketing Company LLC Cincinnati, Ohio 45209</p> <p>PC-9897 10/21/2008</p>	

