CIMCOOL®

METALWORKING FLUIDS

CIMTECH® 18

SYNTHETIC, METALWORKING FLUID CONCENTRATE

APPLICATIONS		**CIMTECH® 18** 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. **Metals:** Cast Iron, Nodular Iron, Carbon Steels, Ferrous Metals **Duty Range:** For light to moderate-duty operations
FEATURES & BENEFITS		**CIMTECH® 18** can be used in central systems as well as individual machines on ferrous applications. It is stable in both hard and soft water. **RANCIDITY CONTROL** - Exceptionally good bacteria and mold control **CLEANLINESS** - 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 **EXCELLENT FOAM CONTROL** - Even in operations with high agitation **EXCELLENT SETTLING PROPERTIES** - Cast iron and graphite fines settle readily; Mix stays clean; finish-marring chips and grit do not re-circulate throughout the system **DEPLETION RESISTANT** - Lean make-up keeps the concentration at the recommended dilution, since CIMTECH® 18 is not easily degraded by bacteria, or depleted by high chip loads - Reduces costs by reducing the amount of concentrate required for makeup **OPERATOR & MACHINE FRIENDLY** - Pleasant to use - Does not smoke or leave a slippery, oily film on parts, machines or surrounding areas - Stable and transparent **CORROSION CONTROL** - Excellent rust control on cast iron and steel due to its unique proprietary combination of rust inhibitors

RECOMMENDED STARTING DILUTIONS		**FOR INDUSTRIAL USE ONLY** **Use between 5.0% (1:20) and 10.0% (1:10) for machining and grinding ferrous metals.** **CIMTECH® 18** 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. Not recommended for use with magnesium or alloyed magnesium. **For concentration analysis, use** the Total Akalinity Titration Procedure, BCG Titration Procedure, CIMCHEK® Test Strip, or Refractometer.
TYPICAL PHYSICAL AND CHEMICAL PROPERTIES		**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, (H_2O = 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 (or pour point), °F, (°C):** 18 (-8) If frozen, thaw completely at room temperature. **pH, concentrate:** 10.0 **pH, *5.0%* mix, typical operating conditions:** 9.1 **Total chlorine/chloride, wt%, calculated:** 0.00 / < 50 ppm **Total sulfur, wt%, calculated:** 0.00 **Silicones:** None
PACKAGING		**Available in 5-gallon pails, 55-gallon drums, and bulk containers.**

REFRACTOMETER FACTOR = 4.2 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.

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.

For additional information concerning CIMTECH® 18, 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.

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