

CIMCOOL®

METALWORKING FLUIDS

CIMTECH® 280

SYNTHETIC, METALWORKING FLUID CONCENTRATE

APPLICATIONS	<p>CIMTECH® 280 metalworking fluid is a clear, water-based synthetic product. It is recommended for light to moderate-duty grinding and machining of steel and cast iron. It is an excellent choice for dealing with hard water. It is also recommended for grinding ceramics.</p> <p>Metals: Cast Iron, Nodular Iron, Carbon Steels, Ferrous Metals, Ceramics</p> <p>Duty Range: For moderate to heavy-duty operations</p>
FEATURES & BENEFITS	<p>CIMTECH® 280 is an excellent choice for central system applications or individual machines.</p> <p>CORROSION CONTROL - Provides good corrosion control on steel and cast iron</p> <p>MIX STABILITY - Has excellent hard water stability</p> <p>LOW FOAMING – Has excellent foam control properties even in soft water</p> <p>CLEANLINESS - Rejects tramp oil completely - Tramp oil floats on top of the mix and can be removed easily by an oil skimmer</p> <p>RESIDUE - Leaves a soft liquid residual film that is easily rinsed off</p> <p>OPERATOR & MACHINE FRIENDLY - Provides extraordinary mildness properties</p> <p>RANCIDITY CONTROL - Resistant to attack by mold and bacteria - Greatly reduces odor problems associated with soluble oils in individual machines</p> <p>ECONOMICAL - Low makeup rate (1:60 – 1:100)</p>

<p>RECOMMENDED STARTING DILUTIONS</p>	<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>CIMTECH® 280 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 Total Alkalinity Titration Procedure, BCG Titration Procedure, CIMCHEK™ Test Strip, or Refractometer.</p>
<p>TYPICAL PHYSICAL AND CHEMICAL PROPERTIES</p>	<p>Physical state: Liquid Appearance and odor: Clear, Chemical Colors available: Undyed, Blue Solubility in water: 100% Miscible Weight, lb/gal, 60°F (15.6°C): 8.81 Specific gravity, (H₂O = 1): 1.056 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): 20 (-7) If frozen, product separates. Thaw completely at room temperature and stir thoroughly. pH, concentrate: 9.7 pH, 5.0% mix, typical operating conditions: 9.0 Total chlorine/chloride, wt%, calculated: 0.00/0.096 Total sulfur, wt%, calculated: 0.00 Silicones: None</p>
<p>PACKAGING</p>	<p>Available in 5-gallon pails, 55-gallon drums, and bulk containers.</p>
<p>REFRACTOMETER FACTOR = 2.8 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® 280, 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. Consumable Products Division/ Milacron Marketing Company Cincinnati, Ohio 45209</p> <p>PC-3100 4/6/07</p>	

