

CIMCOOL®

METALWORKING FLUIDS

CIMTECH® 290

SYNTHETIC, METALWORKING FLUID CONCENTRATE

APPLICATIONS	<p>CIMTECH® 290 metalworking fluid is an extremely low foaming, clear, biostable synthetic for central systems and individual machines.</p> <p>Metals: Cast Iron, Nodular Iron, Carbon Steels, Ferrous Metals</p> <p>Duty Range: For moderate to heavy-duty operations</p>
FEATURES & BENEFITS	<p>CIMTECH® 290 is especially well suited for applications where foam and ferrous corrosion control are critical in individual machines, or central systems.</p> <p>RANCIDITY CONTROL - Very resistant to attack by mold and bacteria</p> <p>LOW FOAMING - Even under high agitation conditions</p> <p>EXCELLENT SETTLING PROPERTIES - Cast iron and graphite fines settle readily - The mix stays clean; finish-marring chips and grit do not re-circulate throughout the system - Effectively settles both cast iron and steel fines, which improves the finish and prevents the clogging of lines</p> <p>CLEANLINESS - Exceptional Tramp Oil Rejection - Tramp oil floats on top of the mix and can be removed easily by an oil skimmer.</p> <p>EXCELLENT FERROUS CORROSION CONTROL - A unique proprietary combination of rust inhibitors prevent corrosion of cast iron and steel</p> <p>OPERATOR & MACHINE FRIENDLY - Pleasant to use - Does not smoke or leave a slippery, oily film on parts, machines or surrounding areas - Stable and transparent</p>

<p>RECOMMENDED STARTING DILUTIONS</p>	<p>FOR INDUSTRIAL USE ONLY Use between 5.0% (1:20) and 10.0% (1:10) for machining and grinding ferrous metals.</p> <p>CIMTECH® 290 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): 8.76 Specific gravity, (H₂O = 1): 1.050 Boiling point, °F (°C): 212 (100) Flash point, COC, °F (°C): None, self extinguishing Fire point, COC, °F (°C): NA Extinguishing media: NA Unusual fire & explosion hazards: None Freezing point (or pour point), °F, (°C): 20 (-7) If frozen, product separates. Thaw completely at room temperature and stir thoroughly. pH, concentrate: 9.2 pH, 5.0% mix, typical operating conditions: 8.8 Total chlorine/chloride, wt%, calculated: 0.00/0.16 Total sulfur, wt%, calculated: 0.00 Silicones: None Triazine: None</p>
<p>PACKAGING</p>	<p>Available in 5-gallon pails, 55-gallon drums, and bulk containers.</p>
<p>REFRACTOMETER FACTOR = 2.6 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® 290, 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-C-2101 7/16/04</p>	

