

CIMCOOL®

METALWORKING FLUIDS

CIMTECH® 304MA

SYNTHETIC, METALWORKING FLUID CONCENTRATE

APPLICATIONS	<p>CIMTECH® 304MA metalworking fluid is recommended for machining and grinding operations on non-ferrous or ferrous metals.</p> <p>Metals: Aluminum Alloys (2024, 6061, 7050, 7075, 7475, 380, 390), Cast Iron, Nodular Iron, Carbon Steels, Stainless Steels, Titanium, Other Exotic Alloys, Copper Alloys, Brass Alloys and Bronze Alloys</p> <p>Duty Range: For moderate-duty operations</p>
FEATURES & BENEFITS	<p>CIMTECH 304MA is a unique, low pH synthetic fluid designed for the aerospace industry.</p> <p>CORROSION CONTROL - Provides excellent bimetallic corrosion control especially on 7475 and 6061 aluminum, and steel</p> <p>EXCELLENT CLEANLINESS - Rejects tramp oil to keep product clean, which extends sump life</p> <p>OPERATOR - FRIENDLY - Provides excellent part visibility - A fresh mix is transparent - No Smoke - Low misting - Mild to the skin</p> <p>EXCELLENT MACHINE COMPATIBILITY - Very low foaming even when used with deionized water</p> <p>EXCELLENT RANCIDITY CONTROL - Excellent fluid life - Minimizes the need for additives</p> <p>ENVIRONMENTALLY FRIENDLY - Easily recycled</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 and nonferrous metals.</p> <p>CIMTECH® 304MA 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): 8.92 Specific gravity, (H₂O = 1): 1.069 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): 16 (-9) If frozen, thaw completely at room temperature. pH, concentrate: 8.2 pH, 5.0% mix, typical operating conditions: 8.0 Total chlorine/chloride, wt%, calculated: 0.00/0.09 Total sulfur, wt%, calculated: 0.00 Silicone: None</p>
<p>PACKAGING</p>	<p>Available in 5-gallon pails, 55-gallon drums, and bulk containers.</p>
<p>REFRACTOMETER FACTOR = 2.0 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® 304MA, 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><small>LIMITATION OF LIABILITY: Under no circumstances shall we or any affiliate of ours have any liability whatsoever for loss of use or for any indirect or consequential damages. Minor formulation changes or normal variations in the manufacture of this product may cause slight variances in the data presented on this sheet.</small></p> <p style="text-align: center;"><small>Milacron Marketing Company LLC Cincinnati, Ohio 45209</small></p> <p>PC-10068 1/6/2009</p>	

