

CIMCOOL[®]

METALWORKING FLUIDS

CIMTECH[®] 315

SYNTHETIC, METALWORKING FLUID CONCENTRATE

APPLICATIONS	<p>CIMTECH[®] 315 metalworking fluid is recommended for heavy-duty machining and grinding operations on non-ferrous or ferrous metals.</p> <p>Metals: Aluminum Alloys (2024, 6061, 7050, 7075, 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 to heavy-duty operations</p>
FEATURES & BENEFITS	<p>CIMTECH[®] 315 is a unique, low pH synthetic fluid designed for the aerospace industry.</p> <p>EXCELLENT LUBRICITY - Provides excellent tool life and surface finish</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® 315 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 Solubility in water: 100% Miscible Weight, lb./gal., 60°F (15.6°C): 9.05 Specific gravity, (H₂O = 1): 1.084 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): 13 (-11) If frozen, product separates. Thaw completely at room temperature and stir thoroughly. pH, concentrate: 8.3 pH, 5.0% mix, typical operating conditions: 7.9 Total chlorine/chloride, wt%, calculated: 0.00/0.12 Total sulfur, wt%, calculated: 0.00 Silicone: None Triazine: None</p>
<p>PACKAGING</p>	<p>Available in 5-gallon pails, 55-gallon drums, and bulk containers.</p>
<p>REFRACTOMETER FACTOR = 2.3 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® 315, 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-9939 6/26/07</p>	

