

CIMCOOL®

METALWORKING FLUIDS

CIMTECH® 609G

(formerly CX-609G)

SYNTHETIC, METALWORKING FLUID CONCENTRATE

APPLICATIONS	<p>CIMTECH® 609G is a hybrid synthetic developed for superior grinding performance, excellent machining ability and is applicable for some stamping and drawing operations.</p> <p>Metals: Most Aluminum Alloys, Titanium, Exotic Alloys, Cast Iron, Carbon Steels, High Speed Steel, High Alloy Steels, and Stainless Steels.</p> <p>Duty Range: For moderate to heavy-duty operations</p>
FEATURES & BENEFITS	<p>EXCELLENT LUBRICITY – GRINDING - CIMTECH® 609G has an excellent Grinding Ratio without using chlorinated extreme pressure additives. The Grinding Ratio exceeds that of most chlorinated soluble oils. CIMTECH® 609G is excellent for bearing, valve stem and other difficult grinding operations with close tolerance requirements.</p> <p>MACHINING - CIMTECH® 609G has good machining characteristics on most metals and can also be used to form tap most aluminums.</p> <p>STAMPING & DRAWING – CIMTECH® 609G has excellent drawability and with its biological protection can be considered for use in recirculating systems.</p> <p>EXCELLENT CLEANLINESS - Rejects tramp oil, provides clean parts and keeps machines clean</p> <p>RESIDUE - The product is easily rinsed off parts for post-machining operations</p> <p>EXCELLENT MICROBIAL CONTROL - Excellent bio-stability - Provides long sump life</p> <p>EXCELLENT CORROSION CONTROL - Specialized corrosion inhibitors allow for the use of this product on both ferrous and most non-ferrous applications and is compatible with titanium and other exotic alloys.</p> <p>OPERATOR-FRIENDLY - No smoke - No slippery film on parts, machinery or floor - Low misting - Mild to the skin</p>

<p>RECOMMENDED STARTING DILUTIONS</p>	<p>FOR INDUSTRIAL USE ONLY MACHINING & GRINDING: Recommended Starting Dilution: 5% (1:20) Typical Operating Range: 5% (1:20) to 10% (1:10) STAMPING & DRAWING: Recommended Starting Dilution: 20% (1:5) Typical Operating Range: 10% (1:10) to 30% (1:3) For concentrations outside this range contact CIMCOOL® Technical Service at 513-458-8199.</p> <p>CIMTECH® 609G 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.</p> <p>Not recommended for use with magnesium or alloyed magnesium.</p> <p>For concentration analysis, use the MI Titration Procedure, Non-Solvent Titration Procedure, Total Alkalinity Titration Procedure, CIMCHEK™ Test Strip, or Refractometer.</p>
<p>TYPICAL PHYSICAL AND CHEMICAL PROPERTIES</p>	<p>Physical state: Liquid Appearance and odor: Hazy / Chemical Colors available: Undyed Solubility in water: 100% Miscible Weight, lb/gal, 60°F (15.6° C): 8.6 Specific gravity, (H₂O = 1): 1.03 Viscosity (SUS) @ 100° F, Typical: 138 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): 32 (0) If frozen, thaw completely at room temperature. pH, concentrate: 8.9 pH, 5.0% mix, typical operating conditions: 8.8 Total chlorine/chloride, wt%, calculated: 0.00 / < 50 ppm Total sulfur, wt%, calculated: 1.4 Silicones: Yes</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® 609G, 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>CIMCOOL® Global Industrial Fluids / Milacron Marketing Company 3000 Disney Street Cincinnati, Ohio 45209</small></p> <p>01/19/2009 PC-10025</p>	

