

# CIMCOOL®

## METALFORMING FLUIDS

### MILDRAW® 6985

SYNTHETIC, METALFORMING FLUID CONCENTRATE

<b>APPLICATIONS</b>	<p><b>MILDRAW® 6985</b> is a heavy-duty, synthetic stamping and drawing lubricant for non-ferrous and ferrous metals. MILDRAW® 6985, when added to water, forms a transparent solution with exceptional film strength and friction reducing properties. It works exceptionally well in hard water.</p> <p><b>MILDRAW® 6985</b> is used to draw, stamp, roll form, bend and knurl steel the following metals: Steel, Stainless Steel, Aluminum, and Copper</p> <p><b>Duty Range:</b> For heavy-duty drawing operations</p>
<b>FEATURES &amp; BENEFITS</b>	<ul style="list-style-type: none"><li>▪ Stable in hard or soft water</li><li>▪ Superior die and tool life</li><li>▪ High detergency keeps press and tooling clean</li><li>▪ Chlorine-free, Sulfur-free</li><li>▪ Non-foaming for recirculating systems</li><li>▪ Excellent corrosion control on ferrous metals</li><li>▪ Excellent film strength to maximize part coverage and formability</li><li>▪ Outstanding tramp oil rejection properties to prevent solution rancidity and to extend sump life</li><li>▪ Dependant on concentration, deposited film is dry to the touch</li></ul>

<p><b>RECOMMENDED STARTING DILUTIONS</b></p>	<p><b>FOR INDUSTRIAL USE ONLY</b>  <b>Recommended Starting Dilution: 10% (1:10)</b>  <b>Typical Operating Range: 10% (1:10) to 40% (1:2.5)</b>  <b>For concentrations outside this range contact CIMCOOL® Technical Service at 513-458-8199.</b></p> <p><b>MILDRAW® 6985</b> 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><b>For concentration analysis, use the BCG, Total Alkalinity Titration Procedure, or Refractometer.</b></p>
<p><b>TYPICAL PHYSICAL AND CHEMICAL PROPERTIES</b></p>	<p><b>Physical state:</b> Liquid  <b>Appearance / Odor:</b> Clear / Chemical  <b>Colors available:</b> Undyed  <b>Solubility in water:</b> Complete  <b>Weight, lb/gal, 68°F (20°C):</b> 8.6  <b>Specific gravity, 68°F (20°C):</b> 1.03  <b>Viscosity, S.U.S at 100°F (38°C):</b> 422  <b>Flash point, COC, °F (°C):</b> None, Self Extinguishing  <b>Fire point, COC, °F (°C):</b> None, Self Extinguishing  <b>Freezing point (or pour point), °F, (°C):</b> 31 (-1)          If frozen, product separates. Thaw completely at room temperature and stir thoroughly.  <b>pH, concentrate:</b> 8.3  <b>pH, 30.0% mix, typical operating conditions:</b> 8.2  <b>Total chlorine/chloride, wt%, calculated:</b> 0.0/&lt;50  <b>Total sulfur, wt%, calculated:</b> 0.0  <b>Silicones:</b> Yes</p>
<p><b>PACKAGING</b></p>	<p><b>Available in 5-gallon pails, 55-gallon drums, and bulk containers.</b></p>
<p><b>REFRACTOMETER FACTOR = 2.4</b> Multiply the scale reading obtained on your CIMCOOL® Metalworking Fluid or other acceptable refractometer by the <b>Refractometer Factor</b> to obtain the mix concentration in percent.</p> <p><b>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.</b></p>	
<p>For additional information concerning MILDRAW® 6985, 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, <a href="http://WWW.CIMCOOL.COM">WWW.CIMCOOL.COM</a> 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><b>PC-9820 6/4/07</b></p>	

