

# MILFORM<sup>®</sup>

## METALFORMING FLUIDS

### MILFORM<sup>®</sup> 610

<b>APPLICATIONS</b>	<b>MILFORM<sup>®</sup> 610</b> is a soluble oil designed for use on all metals for light to medium-duty stamping and drawing
<b>FEATURES &amp; BENEFITS</b>	<ul style="list-style-type: none"><li>• EXCELLENT FERROUS AND NON-FERROUS CORROSION CONTROL</li><li>• MULTI-METAL COMPATIBILITY</li><li>• GOOD LUBRICITY</li><li>• NON-STAINING ON COPPER AND ALUMINUM</li><li>• EASILY WASHED OFF PARTS IN EITHER AQUEOUS OR SOLVENT CONCENTRATION SYSTEMS</li><li>• GOOD HARD WATER STABILITY UP TO 400 PPM</li></ul>

**RECOMMENDED  
STARTING  
DILUTIONS****FOR INDUSTRIAL USE ONLY.**

Use between 10% (1:10) and 40% (1:2.5) for general purpose stamping and drawing of ferrous and some non-ferrous metals.

**MILFORM<sup>®</sup> 610** is to be mixed with water for use (add concentrate to water).

Add no other substances to the concentrate or mix unless approved by Technical Services (1-513-458-8199).

Not recommended for use with magnesium or alloyed magnesium.

For concentration analysis, use Acid Split Method, MI Titration or Refractometer.

**TYPICAL  
PHYSICAL  
AND  
CHEMICAL  
PROPERTIES**

**Physical state:** Liquid

**Appearance and odor:** Clear / Chemical

**Solubility in water:** Complete

**Weight, lb/gal, 60°F (15.6°C):** 7.8

**Specific gravity, (H<sub>2</sub>O=1):** 0.94

**Boiling point, °F (°C):** Not Applicable

**Flash point, COC, °F (°C):** 365 (185)

**Fire point, COC, °F (°C):** 385 (196)

**Freezing point (or pour point), °F (°C):** -13 (-25)

If frozen, thaw completely at room temperature.

**pH, concentrate:** Not Applicable

**pH, 20.0% mix, typical operating conditions:** 8.3

**Total chlorine/chloride, wt%, calculated:** 0.00/<50 ppm

**Total sulfur, wt%, calculated:** 0.46

**Silicone:** None

**PACKAGING**

Available in 5-gallon pails, 55-gallon drums, and bulk containers.

**REFRACTOMETER FACTOR = 1.0** Multiply the scale reading obtained on your CIMCOOL<sup>®</sup> Metalworking Fluid or other acceptable refractometer by the **Refractometer Factor** to obtain the mix concentration in percent.

**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.**

**WARRANTY:** Milacron Products Division will grant credit on any product which proves defective in material or workmanship as determined by us subject to the following conditions: all material is subject to our inspection prior to issuing credit; any refund will be adjusted based on the volume of product used; no credit will be granted for used or unused product(s) over one year old as determined by the batch number. The terms in this warranty do not in any way extend to any product thereof covered by this agreement, which has a life, under normal usage, inherently shorter than the one-year period indicated above. Except as set forth expressly in writing herein, there are no other warranties express or implied in respect of any product. No warranty of merchantability or fitness for purpose shall apply.

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Minor formulation changes or normal variations in the manufacture of this product may cause slight variances in the data presented on this sheet.

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