

MILFORM™

METALFORMING FLUIDS

MILFORM™ 6277

<p>APPLICATIONS</p>	<p>MILFORM™ 6277 is a sulfurized synthetic fluid for moderate to heavy-duty stamping and drawing of ferrous metals and aluminum alloys.</p>
<p>FEATURES & BENEFITS</p>	<p>EXCELLENT LUBRICITY FOR FERROUS METALS AND ALUMINUM.</p> <p>EXCELLENT CORROSION CONTROL</p> <p>CONTAINS A MILACRON PATENTED LUBRICANT</p> <p>GOOD MICROBIAL CONTROL</p> <p>EXCELLENT EP WHERE CHLORINE IS NOT ACCEPTABLE</p> <p>GOOD CLEANLINESS CHARACTERISTICS</p> <p>EASILY WASHES OFF PARTS</p>
<p>RECOMMENDED STARTING DILUTIONS</p>	<p>FOR INDUSTRIAL USE ONLY</p> <p>Use between 10% and 50% for moderate to heavy-duty stamping and drawing of ferrous and some non-ferrous metals.</p> <p>MILFORM™ 6277 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 Technical Services (1-513-841-8133).</p> <p>Not recommended for use with magnesium or alloyed magnesium.</p> <p>For concentration analysis, use the MI Titration Procedure or Non Solvent Titration Procedure.</p>

TYPICAL PHYSICAL AND CHEMICAL PROPERTIES

Physical state: Liquid

Appearance and odor: Slightly hazy, Vanilla

Colors available: Undyed

Solubility in water: Complete

Weight, lb/gal, 60°F (15.6°C): 8.8

Specific gravity, (H₂O =1): 1.05

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): -14 F (-26)

If frozen, thaw completely at room temperature.

pH, concentrate: 8.5

pH, 10.0% mix, typical operating conditions: 8.2

Total chlorine/chloride, wt%, calculated: none

Total sulfur, wt%, calculated: 3.87

Mercurials, phenols, phosphates, PCB's, PTBBA, nitrite, diethanolnitrosamine, chlorinated paraffins, chlorinated solvents, mineral oil: none.

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

For additional information concerning **MILFORM™ 6277** refer to its OSHA MSDS or contact Technical Services at 1-513-841-8133.

Milacron Consumable 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 amount of customer use; no credit will be granted for products over one year old as determined by the laboratory control number. These terms do not in any way extend to any product 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 or part. **NO WARRANTY OF MERCHANTABILITY OR FITNESS FOR PURPOSE SHALL APPLY. 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.

Consumable Products Division/Milacron Marketing Company
Cincinnati, Ohio 45209

FS: 11/22/99:1990:330

PC 9847

