

MILFORM[®]

METALFORMING FLUIDS

MILFORM[®] 633

APPLICATIONS	<p>MILFORM[®] 633 stamping and drawing fluid is recommended for a variety of applications. It is especially well suited for wheel rim rolling applications. This versatile product has excellent lubricity characteristics for stamping and drawing applications and can also be used as a machining and grinding fluid. MILFORM[®] 633 can be used on ferrous and non-ferrous metals. It can be used in individual sumps and recirculating central systems because of its biological control.</p>
FEATURES & BENEFITS	<ul style="list-style-type: none">• A MULTI-PURPOSE PRODUCT - MILFORM[®] 633 is a versatile product used on a wide variety of operations to provide one fluid to meet most metalworking requirements• EXCELLENT LUBRICITY - Contains mineral oil to provide physical lubricity, and a chlorinated extreme pressure additive to generate lubricity for heavy-duty operations - MILFORM[®] 633 provides excellent tool life and surface finish• EXCELLENT BIOLOGICAL CONTROL – Maintains control of bacteria and mold, resulting in extended fluid life• OPERATOR FRIENDLY - Mild to skin - Easy to mix - Low foaming - Pleasant odor• MACHINE FRIENDLY - Compatible with machine components and materials - Liquid residue keeps machine tool components free moving• EXCELLENT CORROSION CONTROL - Rust inhibitors combined with the physical protection of oil prevent in-process corrosion on parts and machine components• ECONOMICAL - “One fluid - All operations” MILFORM[®] 633 minimizes requirements for storage, mixing, charging, make-up, and maintenance - Its long sump life and minimal make-up rates result in an economical product for plants of all sizes

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PART 2

RECOMMENDED STARTING DILUTIONS

FOR INDUSTRIAL USE ONLY.

Use between 10% (1:10) and 40% (1:2.5) for light to heavy-duty stamping and drawing.

MILFORM[®] 633 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 (513-458-8199)

Not recommended for use with magnesium or alloyed magnesium.

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

TYPICAL PHYSICAL AND CHEMICAL PROPERTIES

Physical state: Liquid

Appearance and odor: Clear / Chemical

Colors available: Undyed

Solubility in water: 100% Miscible

Weight, lb/gal, 60°F (15.6°C): 8.7

Specific gravity, (H₂O = 1): 1.04

Viscosity (SUS) @ 100° F, Typical: 400

Boiling point, °F (°C): NA

Flash point, COC, °F (°C): 350 (177)

Fire point, COC, °F (°C): 385 (196)

Freezing point, °F (°C): 30 (-1)

If frozen, thaw completely at room temperature.

pH, concentrate: NA

pH, 5.0% mix, typical operating conditions: 9.0

Total chlorine/chloride wt%, calculated: 10.9 / < 50 ppm

Total sulfur, wt%, calculated: 0.1

Silicones: Yes

PACKAGING

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

For additional information concerning MILFORM[®] 633, 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.

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.

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