

MILFORM[®]

METALFORMING FLUIDS

MILFORM[®] 645

APPLICATIONS	MILFORM[®] 645 is a soluble oil product designed for moderate to heavy-duty stamping and drawing of steels, galvanized steels and stainless steel.
FEATURES & BENEFITS	<ul style="list-style-type: none">• Excellent hard water stability• Excellent long-term corrosion control for steel, galvanized steel and stainless steel• Good cleanliness – Light residue• Extends tool life• Good microbial control• Excellent carbide corrosion control

MILFORM[®] 645

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[®] 645 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): 8.5

Specific gravity, (H₂O = 1): 1.02

Viscosity (SUS) @ 100° F, Typical: 1,290

Boiling point, °F (°C): NA

Flash point, COC, °F (°C): 355 (179)

Fire point, COC, °F (°C): 375 (191)

Freezing point, °F (°C): < 0 < (- 18)

If frozen, thaw completely at room temperature.

pH, concentrate: NA

pH, 20.0% mix, typical operating conditions: 8.8

Total chlorine/chloride wt%, calculated: 13.9 / < 50 ppm

Total sulfur, wt%, calculated: 0.4

Silicones: None

PACKAGING

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

For additional information concerning MILFORM[®] 645, 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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