

**CIMCOOL® METALWORKING FLUID SUGGESTED METERING TIP CHART\***

**MIX MASTER II, AUTOMATIC MIX MASTER AND MIX STATION. ALWAYS TEST MIX CONCENTRATION WITH REFRACTOMETER OR TITRATION.**

Product	Concentration Mix Ratio (%)**													SUS-100F	DATE		
	1:10 (10%)	1:15 (6.6%)	1:20 (5.0%)	1:25 (4.0%)	1:30 (3.3%)	1:35 (2.8%)	1:40 (2.5%)	1:45 (2.2%)	1:50 (2.0%)	1:60 (1.7%)	1:65 (1.5%)	1:70 (1.4%)	1:100 (1.0%)				
CIMTECH 46C	LT. BROWN	RED	WHITE	BLUE	MD. BROWN			GREEN		ORANGE	DK. BROWN		YELLOW	PURPLE	35	Feb-97	
CIMTECH 95		RED	WHITE	BLUE				MD. BROWN		GREEN	DK. BROWN			YELLOW	35	Feb-97	
CIMTECH 100	BLACK	LT. BROWN	RED		WHITE	BLUE			MD. BROWN		GREEN			ORANGE	32	Feb-97	
CIMTECH 190 / 200	LT. BROWN	RED	WHITE	BLUE	MD. BROWN					GREEN		DK. BROWN		YELLOW	45	Feb-97	
CIMTECH 250	LT. BROWN	RED	WHITE	BLUE	MD. BROWN					GREEN		ORANGE		DK. BROWN	32	Feb-97	
CIMTECH 280	LT. BROWN	RED	WHITE	BLUE	MD. BROWN					GREEN	ORANGE		DK. BROWN	YELLOW	32	Feb-97	
CIMTECH 290	LT. BROWN	RED	WHITE	BLUE	MD. BROWN					GREEN		DK. BROWN		YELLOW	32	Feb-97	
CIMTECH 305	BLACK	LT. BROWN	RED		WHITE	BLUE				MD. BROWN		GREEN		ORANGE	43	Apr-98	
CIMTECH 310		WHITE	BLUE		MD. BROWN			GREEN		ORANGE	DK. BROWN			YELLOW	112	Jan-98	
CIMTECH 315		WHITE	BLUE	MD. BROWN				GREEN		ORANGE	DK. BROWN			YELLOW	130	Oct-99	
CIMTECH 3900	BLACK	LT. BROWN	RED					WHITE		BLUE		MD. BROWN		GREEN	245	Feb-97	
CIMTECH 400	BLACK	LT. BROWN	RED			WHITE	BLUE			MD. BROWN		GREEN		ORANGE	49	Feb-97	
CIMTECH 410, 410C	LT. BROWN	WHITE	BLUE	MD. BROWN			GREEN	DK. BROWN			YELLOW	PURPLE	PINK		59	Feb-97	
CIMTECH 420	BLACK	LT. BROWN	RED		WHITE	MD. BROWN				ORANGE		DK. BROWN		YELLOW	50	Feb-97	
CIMTECH 495	LT. BROWN	WHITE	BLUE	MD. BROWN			GREEN	DK. BROWN			YELLOW	PURPLE	PINK		61	Feb-00	
CIMTECH 500	LT. BROWN	RED	WHITE	BLUE	MD. BROWN					GREEN		ORANGE	DK. BROWN	YELLOW	100	Feb-97	
CIMTECH GL 2015	LT. BROWN	RED	WHITE	BLUE	MD. BROWN					GREEN	ORANGE			YELLOW	32	Feb-97	
CIMSTAR S2	LT. BROWN	RED	WHITE	BLUE	MD. BROWN					GREEN		DK. BROWN		YELLOW	36	Feb-97	
CIMSTAR 30	LT. BROWN	RED	WHITE	BLUE	MD. BROWN					GREEN		DK. BROWN		YELLOW	25	Feb-97	
CIMSTAR 40, 40B, 40F	BLACK	LT. BROWN	RED					WHITE		BLUE		GREEN		DK. BROWN	37	Feb-97	
CIMSTAR 540	LT. BROWN	RED	WHITE	MD. BROWN				GREEN		ORANGE		DK. BROWN	YELLOW		50	Jan-98	
CIMSTAR 55		RED	WHITE	BLUE	MD. BROWN			GREEN	DK. BROWN			YELLOW		PURPLE	PINK	420	Jan-98
CIMSTAR 60			GRAY	BLACK	LT. BROWN	RED	WHITE	BLUE			MD. BROWN		GREEN		DK. BROWN	950	Feb-98
CIMSTAR 60LF, LFB	LT. BROWN	RED	WHITE	BLUE	MD. BROWN				GREEN			ORANGE	DK. BROWN		YELLOW	520	Mar-00
QUAL STAR			GRAY	BLACK	LT. BROWN			RED			WHITE	BLUE		MD. BROWN	545	Feb-98	
QUAL STAR LF, LFB	LT. BROWN	RED	WHITE	BLUE	MD. BROWN				GREEN			ORANGE	DK. BROWN	YELLOW	720	Feb-98	
QUAL STAR XL	BLACK		RED	WHITE	BLUE	MD. BROWN						ORANGE		DK. BROWN	YELLOW	450	Jan-99
CIMSTAR 3700T	LT. BROWN		RED		WHITE			BLUE			MD. BROWN		DK. BROWN		YELLOW	76	Feb-97
CIMSTAR 3733	LT. BROWN	WHITE	BLUE		MD. BROWN	GREEN	ORANGE					DK. BROWN			PURPLE	58	Feb-97
CIMSTAR 3800	LT. BROWN	RED	WHITE	BLUE	MD. BROWN			GREEN								161	Feb-00
CIMSTAR 3865		LT. BROWN	RED	WHITE	BLUE	MD. BROWN			GREEN							283	1-Jan
CIMSTAR 3890	LT. BROWN	RED	WHITE	BLUE	MD. BROWN			GREEN								122	Sep-00
CIMPERIAL 1010		GRAY	BLACK	LT. BROWN				RED		WHITE		BLUE		MD. BROWN	640	Feb-97	
CIMPERIAL 1011	NONE	NONE		GRAY	LT. BROWN			RED	WHITE	BLUE			MD. BROWN	ORANGE	990	Feb-97	
CIMPERIAL 1060CF		GRAY	RED		BLUE			GREEN							305	Feb-97	
CIMPERIAL 1070	NONE	NONE		GRAY	LT. BROWN			RED	WHITE	BLUE			MD. BROWN	ORANGE	990	Feb-97	
CIMPERIAL 1070CF	NONE	GRAY	LT. BROWN	RED			WHITE			BLUE	MD. BROWN		GREEN	YELLOW	432	Aug-00	
CIMPERIAL 14	NONE	GRAY	LT. BROWN	RED			WHITE	BLUE		MD. BROWN		ORANGE		DK. BROWN	990	Feb-97	
CIMPERIAL 16			GRAY			BLACK		LT. BROWN				RED		BLUE	430	Feb-97	
CIMPERIAL 20				GRAY	BLACK						LT. BROWN			RED	975	Feb-97	
CIMPERIAL HD90		GRAY	BLACK	LT. BROWN				RED		WHITE		BLUE		MD. BROWN	660	Feb-97	
QUANTALUBE 270XL	BLACK	LT. BROWN	RED	WHITE	BLUE			MD. BROWN				GREEN	ORANGE	DK. BROWN	850	Jun-99	
QUANTALUBE 275	BLACK			WHITE	YELLOW										428	Jun-99	
CIMCLEAN 30						GREEN				ORANGE		YELLOW		PURPLE	40	NA	
CIMCLEAN 40	LT. BROWN	RED		BLUE	MD. BROWN				ORANGE			YELLOW	PINK		40	Feb-98	
CIMCLEAN 50	LT. BROWN	RED		BLUE	MD. BROWN				ORANGE			YELLOW	PINK		40	Jun-00	

\* NOTE: Chart is a guide. Actual concentrations may vary. **Checking the actual mix ratio or concentration obtained at startup with a titration kit is recommended. Use CIMCOOL Metalworking Fluid concentrate at room temperature (-80°F).**

\*\* Mix ratios obtained at a flow pressure of 40 psig (275 KPa)

\*\*\* If the CIMCOOL product you are using is not listed on this chart, please contact CIMCOOL Technical Services (1-513-458-8199).

RED items are best estimates based on viscosity