



Product Information Flyer

DESCRIPTION

CIMFREE VG-3900H is an emulsifiable synthetic for moderate to heavy-duty operations.

APPLICATION

CIMFREE VG-3900H is recommended for use in high production machining and grinding of non-ferrous metals. Designed to maximize the performance of high speed steel, carbide and diamond tooling applications. Formulated to reduce “built up edge” and provide lubrication against the abrasive properties of high silicon aluminum. Engineered to provide lubrication in cut tapping and roll tapping operations where thread integrity is critical. Delivers consistent low surface finishes in operations where this is a critical quality characteristic.

FEATURES & BENEFITS

ENVIRONMENTALLY FRIENDLY:

Product formula is derived from natural, renewable resources and does not contain mineral oil.

EXCELLENT CORROSION CONTROL:

Non-staining on non-ferrous and ferrous metals. CIMFREE VG-3900H also provides corrosion control for machine parts and bi-metallic parts.

CIMFREE® VG-3900H VEGETABLE BASED METALWORKING FLUID

RECOMMENDED STARTING DILUTIONS

CIMFREE VG-3900H is to be mixed with water for use. Always add concentrate to water. Fluid may be more difficult to mix when water temperature is below 55°F (13°C). Add no other materials to the concentrate or mix unless approved by your CIMCOOL® Territory Manager.

Grinding	5% - 7%	(1:20 to 1:15)
Machining	5% - 7%	(1:20 to 1:15)

CONCENTRATION

An MI Titration, Non-solvent Titration, Total Alkalinity, CIMCHEK™ Test Strip or Refractometer can be used.

The Refractometer Factor is 1.0

Multiply the scale reading obtained on your CIMCOOL® Refractometer by this factor to obtain the mix concentration in percent. Calibrate the refractometer so that it reads 0.0 with water before testing the sample mix. Remove gross contaminants from the sample mixes before testing. A refractometer is only recommended for use in checking the concentration on a fresh charge.

TYPICAL PHYSICAL AND CHEMICAL PROPERTIES

Physical State: Liquid

Solubility in water: 100% miscible

Viscosity (SUS) @ 100°F (38°C): 290

pH Concentrate: NA

Total Chlorine/Chloride, wt%: 0.0/<50ppm

Silicones: Yes

Appearance and Odor: Hazy/Chemical

Weight, lb/gal, 60°F (15.6°C): 7.9

Flash Point /Sp.Gr./Boiling Point: SEE MSDS

pH Mix 5%, Typical Operating: 8.7

Total Sulfur, wt%: 0.3

HANDLING and STORAGE

If frozen, product separates. Thaw completely at room temperature and stir thoroughly before use. Inside storage is recommended.

SAFETY DATA SHEET

Available at www.cimcool.ca

For additional information refer to its WHMIS MSDS, website or contact CIMCOOL® Technical Services at 1-513-458-8199 in Ohio or 1-888-254-1919 in Canada.

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.