



Product Information Flyer

DESCRIPTION

CIMSTAR 66EP semi-synthetic metalworking fluid is recommended for grinding and machining operations of ferrous and most non-ferrous metals where hard water conditions exist.

APPLICATION

CIMSTAR 66EP can be used on cast iron, nodular iron, carbon steels, high speed steels, high alloy steels, and most aluminum alloys. It should not be used on magnesium alloys.

Designed for moderate to heavy duty machining and grinding operations.

FEATURES & BENEFITS

HARD WATER TOLERANCE:

CIMSTAR 66EP was designed to be used in metalworking fluid systems with high water hardness, typically exceeding 400 ppm.

VERSATILE:

CIMSTAR 66EP is designed to provide good lubrication in a variety of operations on a variety of materials.

EXCELLENT RANCIDITY CONTROL:

Superior fluid life - Minimizes the need for additives.

CORROSION PROTECTION:

Excellent ferrous and non-ferrous rust protection for the work-piece and machine tool.

RECOMMENDED STARTING DILUTIONS

CIMSTAR 66EP 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% - 10%	(1:20 to 1:10)
Machining	5% - 10%	(1:20 to 1:10)

CONCENTRATION

BCG Titration, Total Alkalinity, CIMCHEK™ Test Strip or Refractometer can be used.

The Refractometer Factor is 1.7

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): 2085

pH Concentrate: 9.1

Total Chlorine/Chloride, wt%: 3.7/< 50 ppm

Silicones: No

Appearance and Odor: Clear/Chemical

Weight, lb/gal, 60°F (15.6°C): 8.3

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

pH Mix 5%, Typical Operating: 8.9

Total Sulfur, wt%: 0.3

HANDLING and STORAGE

If frozen thaw completely at room temperature 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.

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