



# Product Information Flyer

### DESCRIPTION

CIMTECH 46C synthetic metalworking fluid is specifically designed for carbide grinding applications. It is also recommended for moderate duty machining and grinding operations of ferrous metals.

### APPLICATION

CIMTECH 46C can also be used to machine and grind cemented carbide, cast iron, nodular iron, carbon steels and tool steels. It should not be used on magnesium alloys or non-ferrous materials.

### FEATURES & BENEFITS

#### **SUPERIOR COBALT CORROSION INHIBITION:**

CIMTECH 46C is designed to maintain low levels of dissolved cobalt in the mix.

#### **EXCELLENT RANCIDITY CONTROL:**

Excellent fluid life, minimizing the need for additives.

#### **EXCELLENT FOAM CONTROL:**

CIMTECH 46C has good foam control.

#### **CORROSION PROTECTION:**

Outstanding rust protection for the work-piece and machine tool.

### RECOMMENDED STARTING DILUTIONS

CIMTECH 46C 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 1.9

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):** 40

**pH Concentrate:** 10.3

**Total Chlorine/Chloride, wt%:** 0.0/0.1

**Silicones:** None

**Appearance and Odor:** Clear/Chemical

**Weight, lb/gal, 60°F (15.6°C):** 9.0

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

**pH Mix 5%, Typical Operating:** 9.1

**Total Sulfur, wt%:** 0

### 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](http://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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