



## *Product Information Flyer*

### **DESCRIPTION**

CIMTECH 304MA is a synthetic metalworking fluid recommended for light to moderate duty machining and grinding operations. This product is a unique, low pH synthetic fluid approved for use in the aerospace industry.

### **APPLICATION**

CIMTECH 304MA can be used on wrought aluminum alloys (2024, 6061, 7050, 7075), cast aluminum alloys (380, 390), cast iron, nodular iron, carbon steels, stainless steels, titanium and other exotic alloys. It should not be used on magnesium alloys.

### **FEATURES & BENEFITS**

#### **EXCELLENT LUBRICITY:**

Provides excellent tool life and surface finish.

#### **EXCELLENT CLEANLINESS:**

Rejects tramp oil to keep product clean, which extends sump life.

#### **EXCELLENT MACHINE COMPATIBILITY:**

CIMTECH 304MA is a low foaming product, even when used with de-ionized water.

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

CIMTECH 304MA has excellent fluid life, minimizing the need for additives.

### RECOMMENDED STARTING DILUTIONS

CIMTECH 304MA 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 2.0

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):** 45

**pH Concentrate:** 8.2

**Total Chlorine/Chloride, wt%:** 0.0/0.09%

**Silicones:** None

**Appearance and Odour:** Clear/Chemical

**Weight, lb/gal, 60°F (15.6°C):** 8.9

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

**pH Mix 5%, Typical Operating:** 8.0

**Total Sulfur, wt%:** 0

### HANDLING and STORAGE

If frozen, thaw completely at room temperature then 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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