

CIMTECH[®] 410C

SYNTHETIC METALWORKING FLUID



Product Information Flyer

DESCRIPTION

CIMTECH 410C is a synthetic metalworking fluid recommended for moderate to heavy duty machining and grinding operations of ferrous metals.

APPLICATION

CIMTECH 410C can be used on cast iron, nodular iron, carbon steels, and stainless steels. It should not be used on magnesium alloys or non-ferrous materials.

Designed for machining applications such as milling, drilling, boring and reaming. It can also be used in light to moderate duty grinding operations such as surface, double disc, center-type and internal grinding.

FEATURES & BENEFITS

GOOD LUBRICITY: CIMTECH 410C has good lubricity and will extend tool and wheel life

EXCELLENT FOAM CONTROL: CIMTECH 410C is low foaming even in turbulent grinding systems

EXCELLENT CLEANLINESS: Rejects tramp oil to keep product clean, which extends sump life

EXCELLENT RANCIDITY CONTROL: Excellent fluid life, minimizing the need for additives

CORROSION PROTECTION: Excellent rust protection for the work-piece and machine tool

RECOMMENDED STARTING DILUTIONS

CIMTECH 410C 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 2.5

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: 9.8

Total Chlorine/Chloride, wt%: 0.0/< 1300ppm

Silicones: None

Appearance and Odour: Clear/Chemical

Weight, lb/gal, 60°F (15.6°C): 8.8

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

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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