



Product Information Flyer

DESCRIPTION

MILFORM 635 is a water soluble oil used for moderate to heavy duty stamping and drawing.

APPLICATION

MILFORM 635 is recommended for use on ferrous and non-ferrous metals. It is an excellent choice for galvanized steel and powdered metal applications.

FEATURES & BENEFITS

LUBRICITY:

MILFORM 635 provides excellent lubricity and extreme pressure (EP) performance.

CORROSION PROTECTION:

MILFORM 635 provides excellent long-term corrosion control.

VERSATILITY:

MILFORM 635 contains an extreme pressure lubricant and extends tool life.

RECOMMENDED STARTING DILUTIONS

The proper concentration of MILFORM 635 will vary dependent upon the type of metal, gauge of metal, process involved and method of lubricant application. MILFORM 635 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.

Roll Forming Applications: Typical Range is 5% (1:20) to 10% (1:10)
Stamping & Drawing Applications: Typical Range is 10% (1:10) to 40% (1:2.5)

CONCENTRATION

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.

TYPICAL PHYSICAL AND CHEMICAL PROPERTIES

Physical State: Liquid

Solubility in water: 100% miscible

Viscosity SUS @ 100 °F (38°C): 1,085

pH Concentrate: NA

Total Chlorine/Chlorides, wt%: 12.4/<50 ppm

Silicones: None

Appearance and Odor: Clear/Chemical

Weight, lb/gal, 60°F (15.6 °C): 8.5

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

pH Mix 20%, Typical Operating: 7.2

Total Sulfur, wt%: 0.3

HANDLING AND STORAGE

If frozen, thaw completely at room temperature. 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.