

CIMCOOL[®]

METALWORKING FLUIDS

CIMSTAR[®] 40

SEMISYNTHETIC, METALWORKING FLUID CONCENTRATE

APPLICATIONS	<p>CIMSTAR[®] 40 is designed to be used in machines and operations where long fluid life is needed, such as in large individual machine or central system reservoirs. It is recommended for moderate-duty machining and grinding of ferrous metals, and some nonferrous metals.</p> <p>Metals: Cast Iron, Nodular Iron, Carbon Steels, High Speed Steel, High Alloy Steels, Stainless Steels, Aluminum</p> <p>Duty Range: For light to moderate-duty operations</p>
FEATURES & BENEFITS	<p>CIMSTAR[®] 40 is a clear, water soluble, semisynthetic product.</p> <p>Advantages - Exceptional rancidity control - Effective lubrication and cooling - Good settling properties - No nitrite</p> <p>Effective Lubrication and Cooling - A combination of chemical lubricants and wetting agents provide good machining and grinding properties - Keeps parts and tools cool - Extends tool life - Allows high speeds and feeds that increase production</p> <p>Stable - Can be used in individual machines as well as central system applications</p> <p>Good Settling Properties - Efficiently settles chips and grit - Produces a good cake on positive filters which removes recirculating fines and also lowers media usage - Parts and machines stay clean</p> <p>Excellent Corrosion Control - Organic and inorganic corrosion inhibitors protect machines and parts from rust</p> <p>Environmentally Friendly - Is easy to maintain and control - It is waste treatable - It can also be recycled for reuse</p> <p>Note: CIMSTAR[®] 40B has the same performance characteristics as CIMSTAR[®] 40 but in addition, is designed to be low foaming in soft water (50 ppm hardness)</p>

<p>RECOMMENDED STARTING DILUTIONS</p>	<p>FOR INDUSTRIAL USE ONLY Use between 5.0% (1:20) and 10.0% (1:10) for machining and grinding ferrous and nonferrous metals.</p> <p>CIMSTAR® 40 is to be mixed with water for use (add concentrate to water).</p> <p>Add no other substances to the concentrate or mix unless approved by CIMCOOL® Technical Services. Not recommended for use with magnesium or alloyed magnesium.</p> <p>For concentration analysis, use the MI Titration Procedure, Non-Solvent Titration Procedure, Total Alkalinity Titration Procedure, CIMCHEK™ Test Strip, or Refractometer.</p>
<p>TYPICAL PHYSICAL AND CHEMICAL PROPERTIES</p>	<p>Physical state: Liquid Appearance and odor: Clear, yellow/chemical Colors available: Undyed, pink, blue Solubility in water: 100% Miscible Weight, lb/gal, 60°F (15.6°C): 8.83 Specific gravity, (H₂O = 1): 1.058 Boiling point, °F (°C): 210 (99) Flash point, COC, °F (°C): None, self extinguishing Fire point, COC, °F (°C): NA Extinguishing media: NA Unusual fire & explosion hazards: None Freezing point (or pour point), °F, (°C): 32 (0) If frozen product separates. Thaw completely and stir thoroughly before using. pH, concentrate: 10.2 pH, 5.0% mix, typical operating conditions: 9.0 Total chlorine/chloride, wt%, calculated: 0.00/< 50 ppm Total sulfur, wt%, calculated: 0.01 Silicones: No for CIMSTAR® 40 / Yes for CIMSTAR® 40B</p>
<p>PACKAGING</p>	<p>Available in 5-gallon pails, 55-gallon drums, and bulk containers.</p>
<p>REFRACTOMETER FACTOR = 3.1 Multiply the scale reading obtained on your CIMCOOL® Metalworking Fluid or other acceptable refractometer by the Refractometer Factor to obtain the mix concentration in percent.</p>	
<p>NOTE: Calibrate the refractometer so that it reads 0.0 with water, before testing the sample mix. Remove gross contaminants from the sample mix, before testing.</p>	
<p>For additional information concerning CIMSTAR® 40, refer to its OSHA MSDS or contact CIMCOOL® Technical Services at 1-513-458-8199.</p> <p>Minor formulation changes or normal variations in the manufacture of this product may cause slight variances in the data presented on this sheet. Consumable Products Division/ Milacron Marketing Company Cincinnati, Ohio 45209</p> <p>PC-794 12/14/06</p>	