

CIMCOOL®

METALWORKING FLUIDS

CIMTECH® 46C

LOW-FOAMING SYNTHETIC, CARBIDE GRINDING FLUID

APPLICATIONS	<p>CIMTECH® 46C is designed specifically for carbide grinding applications, and will maintain very low dissolved cobalt levels if maintained properly.</p> <p>Metals: Designed for Cemented Carbide; Can also be used on: Cast Iron, Nodular Iron, Carbon Steels, High Speed Steels, High Alloy Steels Stainless Steels, Tool Steels</p> <p>Duty Range: For moderate-duty operations</p>
FEATURES & BENEFITS	<p>SUPERIOR COBALT CORROSION INHIBITION - Maintains low levels of dissolved cobalt in the mix</p> <p>EXCELLENT CLARITY, CLEANLINESS, AND FOAM CONTROL</p> <p>EXCEPTIONALLY GOOD BACTERIA AND MOLD CONTROL - No offensive odors caused by excessive bacteria</p> <p>DEPLETION RESISTANT - Lean make-up keeps the concentration at the recommended dilution, since bacteria do not easily degrade CIMTECH® 46C - Reduces costs by minimizing the amount of concentrate required for makeup</p> <p>EXCELLENT RUST CONTROL - A unique proprietary combination of corrosion inhibitors prevents corrosion of cast iron and steel machine tool components</p> <p>EMULSIFIES VERY LITTLE TRAMP OIL - Tramp oil floats on top of the mix and can be removed easily by an oil-skimming device</p> <p>PLEASANT TO USE - Does not smoke or leave a slippery, oily film on parts, machines, or surrounding areas - Low misting</p>

<p>RECOMMENDED STARTING DILUTIONS</p>	<p>FOR INDUSTRIAL USE ONLY Recommended Starting Dilution: 5% (1:20) Typical Operating Range: 5% (1:20) to 10% (1:10) For concentrations outside this range contact CIMCOOL® Technical Service at 513-458-8199.</p> <p>CIMTECH® 46C 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 Total Alkalinity Titration Procedure, BCG Titration Procedure, CIMCHEK™ Test Strip, or Refractometer.</p>
<p>TYPICAL PHYSICAL AND CHEMICAL PROPERTIES</p>	<p>Physical state: Liquid Appearance and odor: Clear / Chemical Colors available: Undyed Solubility in water: 100% Miscible Weight, lb/gal, 60°F (15.6°C): 9.03 Specific gravity, (H₂O = 1): 1.082 Boiling point, °F (°C): 212 (100) Flash point, COC, °F (°C): None, Self Extinguishing Fire point, COC, °F (°C): NA Freezing point (or pour point), °F, (°C): 22 (-6) If frozen, product separates. Thaw completely at room temperature and stir thoroughly. pH, concentrate: 10.3 pH, 5.0% mix, typical operating conditions: 9.1 Total chlorine/chloride, wt%, calculated: 0.00/0.10 Total sulfur, wt%, calculated: 0.00 Silicones: None Triazine: None</p>
<p>PACKAGING</p>	<p>Available in 5-gallon pails, 55-gallon drums, and bulk containers.</p>
<p>REFRACTOMETER FACTOR = 1.9 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 CIMTECH® 46C, refer to its OSHA MSDS or contact CIMCOOL® Technical Services at 1-513-458-8199. Reprints/Updates of this Product Information Flyer (PIF) can be found on our web site, WWW.CIMCOOL.COM or from your Milacron representative.</p> <p style="text-align: center;">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-9604 4/7/05</p>	

