

**CIMSTAR® 70-HFP**  
**METALWORKING FLUID for HIGH PRESSURE**  
**APPLICATIONS**



# Product Information Flyer

## DESCRIPTION

CIMSTAR 70-HFP is a chlorine-free premium semi-synthetic for moderate duty operations.

## APPLICATION

CIMSTAR 70-HFP is recommended for High Fluid Pressure and High Volume Flow Applications where minimization of foam is critical for part quality and machine operations. It is recommended for general purpose machining of ferrous and most non-ferrous applications. It can be used for turning, drilling, reaming, boring, milling and tapping as well as some grinding operations.

## FEATURES & BENEFITS

### CORROSION PROTECTION:

The oily residue keeps machine tools and work-piece materials free of corrosion and staining. Good on most non-ferrous alloys as well.

### MICROBIAL CONTROL:

CIMSTAR 70-HFP has good rancidity control if product concentration is properly controlled.

### RECOMMENDED STARTING DILUTIONS

CIMSTAR 70-HFP 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

Non-solvent Titration, Total Alkalinity, CIMCHEK™ Test Strip or Refractometer can be used.

The Refractometer Factor is 1.4

A refractometer is only recommended for use in checking the concentration of a fresh charge. 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):** 270

**pH Concentrate:** 9.4

**Total Chlorine/Chloride, wt%:** 0/<50ppm

**Silicones:** Yes

**Appearance and Odor:** Hazy/Chemical

**Weight, lb/gal, 60°F (15.6°C):** 8.4

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

**pH Mix 5%, Typical Operating:** 9.0

**Total Sulfur, wt%:** 0.2

### HANDLING and STORAGE

If frozen product separates, thaw completely at room temperature and stir thoroughly. 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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