

CIMSTAR® 60C-HFP
METALWORKING FLUID for HIGH PRESSURE
APPLICATIONS



Product Information Flyer

DESCRIPTION

CIMSTAR 60C-HFP is a premium semi-synthetic that contains a chlorinated EP (extreme pressure) lubricant for heavy duty operations.

APPLICATION

CIMSTAR 60C-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 60C-HFP has good rancidity control if product concentration is properly controlled.

RECOMMENDED STARTING DILUTIONS

CIMSTAR 60C-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.

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|-----------|----------|----------------|
| Grinding | 5% - 10% | (1:20 to 1:10) |
| Machining | 5% - 10% | (1:20 to 1:10) |

CONCENTRATION

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

The Refractometer Factor is 1.6

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): 400

pH Concentrate: 9.7

Total Chlorine/Chloride, wt%: 3.3/<50ppm

Silicones: Yes

Appearance and Odor: Hazy/Chemical

Weight, lb/gal, 60°F (15.6°C): 8.7

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

pH Mix 5%, Typical Operating: 8.8

Total Sulfur, wt%: 0.4

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

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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