



# Product Information Flyer

### DESCRIPTION

CIMSTAR 55 is a semi-synthetic metalworking fluid.

### APPLICATION

CIMSTAR 55 was developed for use on ferrous and most non-ferrous materials. It can be used on mild steels, stainless steels, hardened steels and most aluminum alloys. It should not be used on magnesium alloys.

For use in light to moderate duty machining and grinding applications, such as milling, drilling, cut tapping, reaming, boring and surface grinding.

### FEATURES & BENEFITS

#### VERSATILE PRODUCT:

Good lubricity – physical and chemical lubricant agents provide good machining and grinding ability.

#### CORROSION PROTECTION:

The oily residue keeps machine tools and work-piece materials free of corrosion and staining.

#### MICROBIAL CONTROL:

CIMSTAR 55 has good rancidity control if product concentration is properly maintained.

#### FOAM CONTROL:

CIMSTAR 55 has good foam control, CIMSTAR 55B has additional foam control for soft water conditions.

### RECOMMENDED STARTING DILUTIONS

CIMSTAR 55 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® District Manager.

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

### CONCENTRATION

Non-solvent Titration, Total Alkalinity or Refractometer can be used.

The Refractometer Factor is 2.1

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. A refractometer is only recommended for use in checking the concentration on a fresh charge.

### TYPICAL PHYSICAL AND CHEMICAL PROPERTIES

**Physical State: Liquid**

**Solubility in water: 100% miscible**

**Flash Point /Boiling Point: See SDS**

**Specific Gravity: See SDS**

**Silicones: None for CIMSTAR 55 / Yes for CIMSTAR 55B**

**Appearance and Odor: Hazy/Chemical**

**Weight, lb/gal, 60°F (15.6 °C): 8.5**

**pH Concentrate: 9.5**

**pH Mix 5%, Typical Operating: 8.9**

### HANDLING and STORAGE

If frozen, thaw completely at room temperature. Inside storage is recommended.

This product is to be used within six months of its manufacture date as indicated by the lot number on the container label.

### SAFETY DATA SHEET

Available at [www.cimcool.com](http://www.cimcool.com)

For additional information refer to its OSHA MSDS, website or contact your local CIMCOOL TECHNICAL SPECIALIST OR DISTRICT MANAGER, or you may contact CIMCOOL® Technical Services at 1-513-458-8199.

***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.***



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