



# Product Information Flyer

### DESCRIPTION

CIMSTAR 60 is a semi-synthetic metalworking fluid.

### APPLICATION

CIMSTAR 60 was developed for use on ferrous and most non-ferrous materials. It can be used on mild steels, stainless steels, hardened steels, most aluminum alloys and exotic materials. It should not be used on magnesium alloys.

For use in moderate to heavy duty machining and grinding applications, such as milling, drilling, cut tapping, reaming, boring and CBN, ID and centerless grinding.

### FEATURES & BENEFITS

#### VERSATILE PRODUCT:

Good lubricity – physical, chemical, and extreme pressure 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. Good on most non-ferrous alloys as well.

#### MICROBIAL CONTROL:

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

#### FOAM CONTROL:

CIMSTAR 60 has good foam control.

### RECOMMENDED STARTING DILUTIONS

CIMSTAR 60 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

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

The Refractometer Factor is 1.8

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 of a fresh charge.

### TYPICAL PHYSICAL AND CHEMICAL PROPERTIES

**Physical State:** Liquid

**Solubility in water:** 100% miscible

**Viscosity (SUS) @ 100°F:** 200

**pH Concentrate:** 9.8

**Total Chlorine/Chloride, wt%:** 3.6/<50ppm

**Silicones:** YES

**Appearance and Odor:** Hazy/Chemical

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

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

**pH Mix 5%, Typical Operating:** 8.8

**Total Sulfur, wt%:** 0.3

### HANDLING and STORAGE

If frozen, product separates. Thaw completely at room temperature and stir thoroughly before use. Inside storage is recommended.

### 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.

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