CIMCOOL®

METALWORKING FLUIDS

CIMTECH® 320

SYNTHETIC, METALWORKING FLUID CONCENTRATE

APPLICATIONS	**CIMTECH® 320** metalworking fluid is recommended for heavy-duty machining and grinding operations on non-ferrous or ferrous metals. **Metals:** Aluminum Alloys (2024, 6061, 7050, 7075, 380, 390), Cast Iron, Nodular Iron, Carbon Steels, Stainless Steels, Titanium, Other Exotic Alloys **Duty Range:** For moderate to heavy-duty operations
FEATURES & BENEFITS	**CIMTECH® 320** is a unique, low pH synthetic fluid designed for the aerospace industry. **EXCELLENT LUBRICITY** - Provides excellent tool life and surface finish - Excellent lubricity for machining non-ferrous metals **EXCELLENT CLEANLINESS** - Rejects tramp oil to keep product clean, which extends sump life **OPERATOR - FRIENDLY** - Provides excellent part visibility - A fresh mix is transparent - No Smoke - Low misting - Mild to the skin **EXCELLENT MACHINE COMPATIBILITY** - Very low foaming even when used with deionized water **EXCELLENT RANCIDITY CONTROL** - Excellent fluid life - Minimizes the need for additives **ENVIRONMENTALLY FRIENDLY** - Easily recycled

RECOMMENDED STARTING DILUTIONS	**FOR INDUSTRIAL USE ONLY** **Use between 5.0% (1:20) and 10.0% (1:10) for machining and grinding ferrous and nonferrous metals.** **CIMTECH® 320** is to be mixed with water for use (add concentrate to water). Add no other substances to the concentrate or mix unless approved by CIMCOOL® Technical Services. Not recommended for use with magnesium or alloyed magnesium. **For concentration analysis, use** the Total Alkalinity Titration Procedure, BCG Titration Procedure, CIMCHEK™ Test Strip, or Refractometer.
TYPICAL PHYSICAL AND CHEMICAL PROPERTIES	**Physical state:** Liquid **Appearance and odor:** Clear / Chemical **Colors available:** Undyed, Blue **Solubility in water:** 100% Miscible **Weight, lb/gal, 60°F (15.6°C):** 9.00 **Specific gravity, (H_2O = 1):** 1.079 **Boiling point, °F (°C):** 212 (100.0) **Flash point,COC,°F (°C):** None, Self extinguishing **Fire point,COC, °F (°C):** , Self extinguishing **Freezing point (or pour point), °F, (°C):** -45 (-42.8) If frozen, thaw completely at room temperature. **pH, concentrate:** 8.2 **pH, *5.0%* mix, typical operating conditions:** 7.9 **Total chlorine/chloride, wt%, calculated:** 0.00/0.09 **Total sulfur, wt%, calculated:** 0.00 **Silicone:** None
PACKAGING	**Available in 5-gallon pails, 55-gallon drums, and bulk containers.**

REFRACTOMETER FACTOR = 1.5 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.

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.

For additional information concerning CIMTECH® 320, 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.

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

PC-9950 7/31/08

CIMCOOL
Global Industrial Fluids