



Product Information Flyer

DESCRIPTION

CIMTECH 410C metalworking fluid is recommended for machining and grinding operations of ferrous metals.

APPLICATION

CIMTECH 410C can be used on cast iron, nodular iron, carbon steels, and stainless steels. It should not be used on magnesium alloys or non-ferrous materials.

Designed for moderate to heavy duty machining applications such as milling, drilling, boring and reaming. It can also be used in light to moderate duty grinding operations such as surface, double disc, center-type and internal grinding.

FEATURES & BENEFITS

GOOD LUBRICITY – CIMTECH 410C has good lubricity and will extend tool and wheel life.

EXCELLENT FOAM CONTROL: CIMTECH 410C is low foaming even in turbulent grinding systems.

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.

EXCELLENT RANCIDITY CONTROL: Excellent fluid life, minimizing the need for additives.

CORROSION PROTECTION: Excellent rust protection for the work-piece and machine tool.

ENVIRONMENTALLY FRIENDLY: Easily recycled.

RECOMMENDED STARTING DILUTIONS

CIMTECH 410C is to be mixed with water for use. Always add concentrate to water. 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 BCG Titration, Total Alkalinity, CIMCHEK™ Test Strip or Refractometer can be used.

The Refractometer Factor is 2.5.

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: 45

pH Concentrate: 9.8

Total Chlorine/Chloride, wt%: 0.0/< 1300ppm

Silicones: None

Appearance and Odor: Clear/Chemical

Weight, lb/gal, 60°F (15.6 °C): 8.8

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

pH Mix 5%, Typical Operating: 9.1

Total Sulfur, wt%: 0

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

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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