

CIMCOOL®

METALWORKING FLUIDS

CIMTECH® 610

(Formerly CX-610A)

SYNTHETIC, METALWORKING FLUID CONCENTRATE

APPLICATIONS	<p>CIMTECH® 610 is an innovative new metalworking fluid featuring a hybrid blend of patented and synthetic lubricants. This unique blend of lubricants provides synergistic performance on difficult-to-machine-ferrous and non-ferrous alloys without corrosion or stain.</p> <p>CIMTECH® 610 is uniquely formulated to be used on hard, brittle metals that “ordinary” fluids have difficulties with, such as inconel, titanium, stainless steel, aerospace alloys and hardened steels. CIMTECH® 610 is an exceptional product for milling, drilling, and cut tapping these materials, as well as for operations on aerospace and aluminum alloys.</p> <p>Metals: Aluminum Alloys, Hard Steels, Stainless Steels, Titanium, Inconel, Beryllium Copper and other specialty alloys</p> <p>Duty Range: For heavy-duty to severe-duty machining operations</p>
FEATURES & BENEFITS	<ul style="list-style-type: none">• Excellent heavy-duty performance without chlorine, sulfur or phosphorus EP lubricants• Near neutral pH• Good corrosion control on ferrous metals and non-staining to aluminum and other exotic alloys• Works best in tough operations• Low foam• Good part visibility for operators• Contains a Milacron patented lubricant
TESTIMONIALS	<p>#1 High stock removal milling of 6A4V Titanium – 500% increase in tool life, at a lower mix concentration, compared to both a high-oil containing semi synthetic and a chlorinated soluble oil product.</p> <p>#2 Turning and milling 13-8 steel, 45 Rockwell – 500% increase in tool life compared to a heavy-duty synthetic coolant</p> <p>#3 Tapping M4 stainless steel, 4-40 taps – 400% increase in the tool life compared to a heavy-duty synthetic</p>

RECOMMENDED STARTING DILUTIONS	<p>FOR INDUSTRIAL USE ONLY Recommended Starting Dilution: 5% (1:20) Typical Operating Range: 5% (1:20) to 10% (1:10) For concentrations outside this range contact CIMCOOL® Technical Service at 513-458-8199.</p> <p>CIMTECH® 610 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.</p> <p>Not recommended for use with magnesium or alloyed magnesium.</p> <p>For concentration analysis, use the MI Titration Procedure, Non-Solvent Titration Procedure, Total Alkalinity Titration Procedure, CIMCHEK™ Test Strip, or Refractometer.</p>
TYPICAL PHYSICAL AND CHEMICAL PROPERTIES	<p>Physical state: Liquid Appearance and odor: Clear / Chemical Colors available: Undyed Solubility in water: 100% Miscible Weight, lb/gal, 60°F (15.6° C): 9.1 Specific gravity, (H₂O = 1): 1.09 Viscosity (SUS) @ 100° F, Typical: 395 Boiling point, °F (°C): 212 (100) Flash point, COC, °F (°C): None, Self Extinguishing Fire point, COC, °F (°C): None, Self Extinguishing Freezing point, °F, (°C): 30 (-34) If frozen, product separates. Thaw completely at room temperature and stir thoroughly. pH, concentrate: 8.2 pH, 5.0% mix, typical operating conditions: 7.8 Total chlorine/chloride, wt%, calculated: 0.00 / < 50 ppm Total sulfur, wt%, calculated: 0.07 Silicones: None</p>
PACKAGING	Available in 5-gallon pails, 55-gallon drums, and bulk containers.
<p>REFRACTOMETER FACTOR = 1.3 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.</p> <p>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.</p>	
<p>For additional information concerning CIMTECH® 610, 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.</p> <p><small>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.</small></p> <p style="text-align: center;"><small>CIMCOOL® Global Industrial Fluids / Milacron Marketing Company 3000 Disney Street Cincinnati, Ohio 45209</small></p> <p>PC-9829 3/26/08</p>	

