

Cutting and grinding fluid for medium to heavy-duty applications



Description

Cimstar 536-02 is a clear, amber, water miscible, preformed microfine emulsion type cutting fluid concentrate.

Application

Cimstar 536-02 is a general-purpose cutting fluid recommended for medium to heavy duty grinding and machining of all ferrous and most non-ferrous metals. Cimstar 536-02 is a product designed for use in individual machines and central systems.

Features and benefits

- No increased disposal costs - free of chlorine
- Excellent emulsion stability - can be used in water up to 5 - 20°dH
- Specially selected raw materials ensure a long fluid life
- Very mild product
- Very economical - low topping up concentration
- Clean product - keeps grinding wheels open and machines clean

Methods of application

Cimstar 536-02 is easy to mix, normal stirring only. For automatic mixing, the use of the Cimcool® Mix Master or Cimcool Mix Master S is recommended. Typical starting water temperature conditions should be 5 - 25°C.

Recommended starting concentration

	Aluminium and copper alloys	Cast Iron and carbon steel	Steel alloys and stainless steel
Grinding	4.0%	4.0%	5.0%
Standard machining	5.0%	5.0%	8.0%
Heavy duty machining	6.0%	8.0%	10.0%
Reaming, tapping, broaching	-	10.0%	-

Mix Master S: Concentration** can easily be obtained by setting the regulator to the correct number.

** The concentration may vary depending on local conditions. It is therefore always advised to check using the refractometer or TA Kit.

Concentration analysis

For concentration analysis, use one of the below given methods or an appropriate laboratory procedure available from your local stockist.

Refractometer factor: 1.8

If the refractometer is used, the resultant reading multiplied by a factor of 1.8 will only be relevant when applied to a fresh mix.

Cimcool TA kit	Use 2 ml. Mix										*: next syringe
%	1	2	3	4	5	6	7	8	9	10	
Reading	0.86	0.75	0.64	0.54	0.43	0.33	0.22	0.12	0.01	*.91	

Handling and storage

Protect from freezing, direct sun and store between 5 - 35°C.

Packaging type

5, 25, 1000 and 200 litre and bulk.

Safety Data Sheet

The Safety Data Sheet should be consulted for specific information and information on Health, Safety and Environment when handling this product.



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