

# CIMSTAR® HD650FF

Formaldehyde releasing agent free cutting and grinding fluid for medium to heavy duty applications



## Description

Cimstar HD650FF is a clear, water miscible, preformed microfine emulsion type cutting fluid concentrate. Cimstar HD650FF is free from formaldehyde releasing biocides.

## Application

Cimstar HD650FF is a general-purpose cutting fluid recommended for medium to heavy duty grinding and machining of all ferrous and most non-ferrous metals. It is especially suitable for aluminium alloys. Cimstar HD650FF is a product designed for use in individual machines and central systems.

## Features and benefits

- Free from formaldehyde releasing biocides.
- Long fluid life due to the special product composition.
- Suitable for a wide range of materials and operations.
- Does not stain aluminium and aluminium alloys.
- Excellent emulsion stability.
- Clean and mild product.
- Will not smoke or burn.
- Excellent foam control.
- Can be used in water up to 10 - 25° dH.

## Methods of application

Cimstar HD650FF 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

Grinding	4 - 6%
Machining	6 - 10%

## 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.

## Concentration analysis

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

Refractometer factor:	1.5
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If the refractometer is used, the resultant reading multiplied by a factor of 1.5 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	0.87	0.77	0.67	0.57	0.46	0.36	0.26	0.16	0.05	*.95	

## 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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