

# CIMTECH<sup>®</sup> M27-02

High performance synthetic  
metal working fluid



## Application

Cimtech M27-02 is a mild synthetic coolant developed for high fluid pressure and high fluid volume machining and grinding operations. It is suitable for steel alloys and aerospace materials like titanium and nickel alloys. Cimtech M27-02 can be used in individual machines and in central systems.

## Features and benefits

Cimtech M27-02 is a clear and clean metalworking fluid recommended for grinding and machining operations whereby excellent foam control and air release are essential (creep feed and VIPER grinding). Cimtech M27-02 offers high cooling and washing action and leaves grinding wheels open.

Cimtech M27-02 provides good lubrication and is highly cost effective, due to its low make-up rates and extremely long fluid life. It also has superior cleanliness and rejects tramp oil.

Cimtech M27-02 contains no sulphur, chlorine or formaldehyde releasing biocides. Since, it is also boron free this improves the fluid's residue characteristics and reduces waste water treatment concerns were applicable.

Carefully selected raw materials ensure a long fluid life.

## Methods of Application

CIMTECH® M27-02 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

Medium duty grinding and machining operations	5%
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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: 2.5

If the refractometer is used, the resultant reading multiplied by a factor of 2.5 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	0.81	0.63	0.46	0.29	0.12	*.95	*.78	*.61	*.44	*.27	

## Handling and storage

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

## Packaging type

5, 25, 200, 1000 litre.

## 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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