

CIMPERIAL® 181FF

Heavy duty cutting and grinding fluid
without formaldehyde releasing biocides



Description

Cimperial 181FF is a clear, water miscible, formaldehyde releasing biocides free emulsion type cutting fluid concentrate.

Application

Cimperial 181FF is a general-purpose emulsion type cutting fluid for machining and grinding of aluminium and aluminium alloys. It can also be used on cast iron and steel. Cimperial 181FF is designed for use in individual machines and in central systems.

Features and benefits

- Long fluid life due to the unique product composition.
- Free from formaldehyde releasing biocides.
- Mild chlorine free product with milky appearance
- Clean product - keeps grinding wheels open and machines clean.
- Provides a high quality finish.
- Can be used in water up to 5 - 15° dH.

Methods of application

Cimperial 181FF is easy to mix, normal stirring only. For automatic mixing, the use of the Cimcool Mix Master S is recommended. Typical starting water temperature conditions should be 5 - 25°.

Recommended starting concentration

	Aluminium (alloys)	Cast iron and carbon steel	Steel alloys and stainless steel
Grinding	4%	4%	5%
Standard machining	6%	5%	6%
Heavy duty machining	8%	8%	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:	1.1
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If the refractometer is used, the resultant reading multiplied by a factor of 1.1 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	0.76	0.66	0.56	0.46	0,36	0.26	0.16	0.06	*.96

Handling and storage

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

Packaging type

200 and 1.000 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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