

CIMSTAR® 146FF

Formaldehyde releasing biocide free cutting and grinding fluid for medium duty applications



APPLICATION SHEET

Description

Cimstar 146FF is a clear, water miscible, semi-synthetic type cutting fluid concentrate free of formaldehyde releasing biocides.

Application

Cimstar 146FF is a clean, general-purpose cutting fluid developed for medium duty grinding and machining of all ferrous and most non-ferrous metals. Cimstar 146FF is designed for use in individual machines and central systems. Cimstar 146 is suitable for starting water hardness 10 – 25° dH.

Features and benefits

- Exceptional long fluid life and corrosion control.
- Excellent washing action, keeping grinding wheels open and free cutting.
- Good settling characteristics.
- Clean product giving a pleasant working environment.
- Low fluid consumption due to low top-up rate.
- Formaldehyde releasing biocide free.

Methods of application

Cimstar 146FF 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 and machining	4 - 10 %
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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:	2.3
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If the refractometer is used, the resultant reading multiplied by a factor of 2.3 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	0.65	0.54	0.43	0.32	0.21	0.11	0.00	*.89	

Handling and storage

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

Packaging type

5, 25, 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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