

Medium to heavy duty general purpose cutting fluid without formaldehyde releasing biocide.



## Description

Cimstar 631 is a clear, water miscible, preformed microfine emulsion type cutting fluid concentrate, without formaldehyde releasing biocide.

## Application

Cimstar 631 is a general purpose, biostatic cutting fluid recommended for medium to heavy duty machining and grinding of all ferrous and most non-ferrous metals. It is especially suitable for the general making of aerospace (aluminium) alloys. Cimstar 631 is a product designed for use in individual machine and central systems. Cimstar 631 is suitable for a (starting) water hardness range between 5-20 dH.

## Features and benefits

- Free of formaldehyde releasing biocide.
- Suitable for a wide range of materials and operations.
- Does not stain aluminium and (aerospace) aluminium alloys.
- Excellent emulsion stability.
- Clean and mild product.
- Will not smoke or burn.
- Excellent foam control in the give water hardness range.
- Fulfils the latest H, S & E requirements.

## Methods of application

Cimstar 631 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	8.0%	8.0%	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
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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.



**Cimcool Industrial Products**  
Schiedamsedijk 20  
3134 KK Vlaardingen  
The Netherlands  
Tel: (0)10-4600660  
cimcool.eu@duboischemicals.com  
[www.cimcool.com](http://www.cimcool.com)

