

# CIMTECH<sup>®</sup> BFF921R

Mineral oil and formaldehyde releasing biocide free metalworking fluid for aluminium rim manufacturing.



## Description

Cimtech BFF921R is a clear, water miscible, mineral oil free, preformed microfine emulsion type cutting fluid concentrate, with a unique non-mineral oil lubricant. Cimtech BFF921R is free from formaldehyde releasing biocides.

## Application

Cimtech BFF921R is designed primarily to improve productivity in machining operations on casted (high) silicon containing aluminium alloys used in aluminium RIM manufacturing. Cimtech BFF921R is a product designed for use in individual machines and central systems.

## Features and benefits

- Carefully selected raw materials ensure a long fluid life.
- Excellent mix stability.
- Provides excellent lubrication over a wide range of applications.
- Reduces heat generation in heavy duty cutting applications.
- Good washing action resulting in low top concentrations.
- Clean, mild and pleasant to use: no oil mist.
- Will not smoke or burn.
- Can be used in water up to 10 - 25° dH.

## Methods of application

Cimtech BFF921R 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

Machining	4 - 6 %
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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.

## Concentration analysis

For concentration analysis, use the below given method 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	0.88	0.76	0.64	0.52	0.41	0.29	0,17	0,06	*.94	*.82

## 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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