

CIMPERIAL® HD225FF

Formaldehyde releasing biocide free cutting and grinding fluid for heavy-duty applications



Description

Cimperial HD225FF is a reliable cutting and grinding fluid with excellent performance in heavy-duty operations. It contains EP additives, which make Cimperial HD225FF specifically suitable for the most difficult operations. Cimperial HD225FF is free from formaldehyde releasing agents (FRA's).

Application

Cimperial HD225FF is a cutting fluid developed for heavy duty machining and grinding suitable for many applications, including thread rolling, deep hole drilling, broaching, tapping and reaming. Cimperial HD225FF can be used for both ferrous and non-ferrous metals, like inconel and other nickel alloys, steel and aluminium. Can be used in water up to 10 - 30° dH.

Features and benefits

Cimperial HD225FF is a mild and trouble free product. It has a low alkalinity, which makes Cimperial HD225FF very operator friendly. In addition, working with Cimperial HD225FF offers clean machines, keeps grinding wheels open and allows free cutting.

Cimperial HD225FF shows excellent performance in extreme heavy-duty operations due to the use of EP additives. It will not smoke or burn and shows good rust characteristics and foam control. Cimperial HD225FF is free from formaldehyde releasing biocides.

Methods of application

Cimperial HD225FF 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

Heavy duty grinding	5 - 6 %
Heavy duty machining	6 - 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:	1.0
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If the refractometer is used, the resultant reading multiplied by a factor of 1.0 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	0.95	0.89	0.83	0.78	0.72	0.67	0.61	0.55	0.50	0.44	

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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