

CIMTECH[®] 600HFP

Synthetic metalworking fluid specially designed for
medium to heavy duty machining operations



Description

CIMTECH 600-HFP is an innovative new non-oil containing metalworking fluid featuring a hybrid blend of patented and synthetic lubricants. This unique blend of lubricants provides synergistic performance on difficult-to-machine-ferrous and non-ferrous alloys without corrosion or stain.

Application

CIMTECH 600-HFP is uniquely formulated to be used on hard metals that “ordinary” fluids have difficulties with, such as Inconel, titanium, stainless steels, aerospace alloys and hardened steels. CIMTECH 600-HFP is an exceptional product for grinding, milling, drilling, and cut tapping these materials, as well as for operations on aerospace and most aluminum alloys. Not for use on magnesium.

Recommended is to use demi or soft (5 - 10°dH) make up water.

Features and benefits

- Excellent medium to heavy-duty performance without EP Lubricants.
- Near neutral pH, typical 7.9.
- Works best in tough operations that generate higher heat conditions at the point of cut
- HFP: Excellent foam control even at high pressure.
- Contains a Cimcool patented lubricant.

Methods of Application

Cimtech 600HFP 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

Heavy duty grinding	5%
Heavy duty machining	5% (1:20) to 10% (1:10)

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 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:	1.5
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If the refractometer is used, the resultant reading multiplied by a factor of 1.5 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	0.84	0.69	0.53	0.38	0.22	0.07	*.91	*.76	*.60	*.45

Handling and storage

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

Packaging type

5, 20, 200, 1000 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.



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