



PRODUCT INFORMATION FLYER

Description

Cimperial 861FF is a formaldehyde releasing agent (FRA) free, reliable emulsion type heavy-duty metalworking fluid specifically designed for the machining and grinding of aluminium and aluminium alloys.

Application

Although specifically developed for use on aluminium, Cimperial 861FF can be used for a wide range of other materials ranging from carbon steel up to exotic alloys like titanium and inconel.

Cimperial 861FF is developed for use in soft water (5 to 15°dH in starting water). For use in harder water, Cimperial 812FF is recommended.

Features and benefits

Cimperial 861FF is a very clean and low foaming fluid, resulting in cleaner machines, better operator acceptance and lower consumption. The excellent fluid stability ensures a long fluid life and makes Cimperial 861FF a very cost effective formaldehyde releasing biocide free aluminium machining product.

Methods of application

Cimperial 861FF 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	4 - 6 %
Standard machining	5 - 8 %
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:	1.1
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If the refractometer is used, the resultant reading multiplied by a factor of 1.1 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	0.73	0.63	0.52	0.42	0.31	0.20	0.10	*.99	*.89

Handling and storage

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

Packaging type

5, 20, 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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