

# CIMSTAR® 31-785

Cutting and grinding fluid for medium  
to heavy-duty applications



## Application

Cimstar 31-785 is a general-purpose amine free cutting fluid recommended for medium to heavy duty grinding and machining. It is suitable for ferrous and non-ferrous materials and can be applied in a wide variety of applications ranging from turning and sawing to milling and drilling. Cimstar 31-785 is designed for use in individual machines and central systems.

## Features and benefits

- Cimstar 31-785 is an excellent oil-containing metal working fluid, which is free from amine, formaldehyde releasers and boron. This reduces the chance of any skin and/or throat irritation. The use of Cimstar 31-785 improves working conditions and reduces health and safety concerns.
- Cimstar 31-785 gives good corrosion protection and does not foam in the indicated water hardness range. Carefully selected raw materials ensure a longer fluid life compared to other amine-free metal working fluids. Cimstar 31-785 has excellent emulsion stability and can be used in starting water hardness 5 - 25°dH.
- Cimstar 31-785 is a clean product. It keeps grinding wheels open and machines clean.
- Additives should only be used after consulting a Cimcool representative.

## Methods of application

Cimstar 31-785 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 and machining	6 - 10 %
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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 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:	1.0
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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	0.90	0.85	0.80	0.75	0.71	0.66	0.61	0.56	0.51	

## Handling and storage

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

## Packaging type

5, 20, 200 and 1.000 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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