

CIMTECH[®] M21-02

Cutting and grinding fluid
for general applications



Application

Cimtech M21-02 is a product not only suitable for general grinding, but may be confidently used in machining and honing operations of cast iron. Cimtech M21-02 contains a unique lubricant developed and patented by Milacron LLC.

Features and benefits

- Designed to cover a wide variety of grinding operations.
- Exceptional cleanliness - keeps machines clean and grinding wheels open and free of cutting.
- Suitable for application in soft and hard water up to 25°GH (450 ppm).
- Good grid settling properties. Can be used with most filtration units.
- Provides long fluid life.
- Excellent rust control.
- Will not smoke or burn.

Methods of Application

Cimtech M21-02 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

	Copper and copper alloys	Titanium alloys	Cast iron	Carbon steel, steel alloys and stainless steel	Tool steel heat resistant alloys and carbides
General grinding	3.0%	3.0%	3.0%	3.0%	3.5%
Standard machining	4.0%	5.0%	4.0%	6.0%	-

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:	4.7
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If the refractometer is used, the resultant reading multiplied by a factor of 4.7 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	0.54	0.39	0.24	0.09	*.94	*.79	*.64	*.49	

Handling and storage

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

Packaging type

5, 20, 200 and 1000 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.



Cimcool Industrial Products
Schiedamsedijk 20
3134 KK Vlaardingen
The Netherlands
Tel: (0)10-4600660
cimcool.eu@duboischemicals.com
www.cimcool.com

