



CIMPERIAL® HD821FF



Description

Cimperial 821FF is an easy to use and reliable heavy-duty metalworking fluid. It is an excellent all-round emulsion suitable for many heavy-duty machining operations including grinding. Cimperial 821FF is free from formaldehyde releasing biocides.

Application

Cimperial 821FF can be used without problems for a great number of metals ranging from aluminium to steel and stainless steel. The potential aluminium staining has been minimised making Cimperial 821FF suitable for most used aluminium types.

Cimperial 821FF is especially developed for use in soft water (5 to 15°dH in starting water). For use in harder water, Cimperial HD812FF is recommended.

Features and benefits

Cimperial 821FF is an excellent multipurpose and absolutely hassle-free fluid. It provides a high quality finish and excellent stability. This stability ensures a long fluid life, which makes Cimperial 821FF a very cost-effective product.

Cimperial 821FF is a mild and clean product. It will keep grinding wheels open and maintains machine cleanliness.

Cimperial 821FF notably improves production. Effective lubricants reduce the amount of heat generated in the cutting zone permitting higher speeds and feeds, thereby increasing production while maintaining or improving overall part quality.

Finally, Cimperial 821FF is chlorine free, which - where applicable - decreases disposal costs.

Methods of application

Cimperial 821FF 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.

MILACRON® PRODUCT LINE APPLICATION SHEET



Recommended starting concentration

Grinding & machining	5 - 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:	1.1
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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	0.86	0.75	0.64	0.53	0.42	0.31	0.19	0.08	*.97	*.86

Handling and storage

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

Packaging type

5, 25, 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.

