

CIMSTAR® 621FF

Cutting and grinding fluid for medium to heavy-duty applications without formaldehyde releasing biocide



Description

Cimstar 621FF is a clear, amber, water miscible, preformed microfine emulsion type cutting fluid concentrate.

Application

Cimstar 621FF is a general-purpose cutting fluid recommended for medium to heavy duty grinding and machining of all ferrous and most non-ferrous metals. It is especially suitable for aluminium alloys. Cimstar 621FF is a product designed for use in individual machines and central systems.

Cimstar 621FF is specifically designed for use in soft water (4 to 10°dH in starting water).

Features and benefits

- Long fluid life due to the special product composition.
- Suitable for a wide range of materials and operations.
- Does not stain aluminium and aluminium alloys.
- Clean product giving a pleasant working environment
- Excellent emulsion stability.
- Clean and mild product.
- Free from formaldehyde releasing biocides.
- Will not smoke or burn.
- Excellent foam control.

Methods of application

Cimstar 621FF 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 %
Machining	5 - 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:	1.4
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If the refractometer is used, the resultant reading multiplied by a factor of 1.4 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	0.73	0.61	0.48	0.36	0.23	0.10	*.98	*.85	*.73

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.



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