

Product Information Flyer



DESCRIPTION

CIMTECH 310 metalworking fluid is recommended for machining and grinding operations, including creep feed grinding, on non-ferrous or ferrous metals.

APPLICATION

CIMTECH 310 can be used on wrought aluminum alloys (2024, 6061, 7050, 7075), cast aluminum alloys (380, 390), cast iron, nodular iron, carbon steels, stainless steels, titanium and other exotic alloys. It should not be used on magnesium alloys.

For moderate to heavy duty grinding applications, CIMTECH 310 metalworking fluid is a unique, low pH synthetic fluid designed for the aerospace industry.

FEATURES & BENEFITS

MEETS AEROSPACE REQUIREMENTS:

CIMTECH 310 Passes bi-metallic and aluminum (7075) “sandwich” corrosion tests. Approved product for many aerospace manufacturers.

EXCELLENT LUBRICITY:

CIMTECH 310 provides excellent tool life and surface finish.

EXCELLENT RANCIDITY CONTROL:

CIMTECH 310 rejects tramp oil, which extends sump life.

OPERATOR – FRIENDLY:

Provides excellent part visibility - A fresh mix is transparent - No Smoke - Low misting - Mild to the skin.

EXCELLENT FOAM CONTROL:

Very low foaming product, even when used with de-ionized water.

RECOMMENDED STARTING DILUTIONS

CIMTECH 310 is to be mixed with water for use. Always add concentrate to water. Fluid may be more difficult to mix when water temperature is below 55 F. Add no other materials to the concentrate or mix unless approved by your CIMCOOL® District Manager.

Grinding	5% - 10%	(1:20 to 1:10)
Machining	5% - 10%	(1:20 to 1:10)

CONCENTRATION

BCG Titration, Total Alkalinity, CIMCHEK™ Test Strip or Refractometer can be used.

The Refractometer Factor is 1.7. A refractometer is only recommended for use in checking the concentration of a fresh charge. Multiply the scale reading obtained on your CIMCOOL® Refractometer by this factor to obtain the mix concentration in percent. Calibrate the refractometer so that it reads 0.0 with water before testing the sample mix. Remove gross contaminants from the sample mixes before testing.

TYPICAL PHYSICAL AND CHEMICAL PROPERTIES:

Physical State: Liquid

Solubility in water: 100% miscible

Viscosity (SUS) @ 100°F: 110

pH Concentrate: 8.2

Total Chlorine/Chloride, wt%: 0.0/< 900 ppm

Silicones: None

Appearance and Odor: Clear/Chemical

Weight, lb/gal, 60°F (15.6 °C): 9

Flash Point /Sp.Gr./Boiling Point: SEE MSDS

pH Mix 5%, Typical Operating: 7.8

Total Sulfur, wt%: 0

HANDLING and STORAGE

If frozen, product separates. Thaw completely at room temperature and stir thoroughly before use. Inside storage is recommended.

SAFETY DATA SHEET

Available at www.cimcool.com

For additional information refer to its OSHA MSDS, website or contact your local CIMCOOL TECHNICAL SPECIALIST OR DISTRICT MANAGER, or you may contact CIMCOOL® Technical Services at 1-513-458-8199.

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