

# CIMSTAR® MB604-02

Cutting and grinding fluid for  
medium to heavy-duty applications



## Description

Cimstar MB604-02 is a clear, amber, water miscible, preformed microfine emulsion type cutting fluid concentrate.

## Application

Cimstar MB604-02 is a general-purpose cutting fluid recommended for medium to heavy duty grinding and machining of all ferrous and most non-ferrous metals. Cimstar MB604-02 is a product designed for use in individual machines and central systems.

## Features and benefits

- No increased disposal costs - free of chlorine
- Excellent emulsion stability - can be used in water up to 10 - 30°dH
- Carefully selected raw materials ensure a long fluid life.
- Very mild product
- Very economical - low topping up concentration
- Clean product - keeps grinding wheels open and machines clean
- Low foaming

## Methods of application

Cimstar 604-02 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.

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## Recommended starting concentration

	Aluminium and copper alloys	Cast iron and carbon steel	Steel alloys and stainless steel
Grinding	4.0%	4.0%	5.0%
Standard machining	5.0%	5.0%	6.0%
Heavy duty machining	6.0%	6.0%	8.0%
Reaming, tapping, broaching	-	8.0%	-

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: 1.6

If the refractometer is used, the resultant reading multiplied by a factor of 1.6 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	0.87	0.76	0.65	0.54	0.43	0.32	0.21	0.10	*.99	*.88

## Handling and storage

Protect from freezing, direct sun and store between 5 - 30°C.

## Packaging type

5, 25, 1000 and 200 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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