

Cutting and grinding fluid for medium duty applications



Description

Cimstar MB278FF is a clear, water miscible, formaldehyde releasing biocide free, semi-synthetic cutting fluid concentrate.

Application

Cimstar MB278FF is a general-purpose, formaldehyde releasing biocide free, cutting fluid recommended for light to medium duty grinding and machining of all ferrous and most non-ferrous metals. Cimstar MB278FF is suitable for a (starting) water hardness range between 10-25 dH.

Cimstar MB278FF is designed for use in individual machines and central systems.

Features and benefits

- Covers a wide range of materials and operations.
- Keeps grinding wheels open and free cutting.
- Provides excellent fluid stability and good corrosion control.
- Good settling characteristics.
- Will not smoke or burn.
- Clean, pleasant to use and low misting.
- Fulfils the latest Health, Safety and Environmental regulations.

Methods of application

Cimstar MB278FF 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

	Aluminium and aluminium alloys	Copper, bronze and other copper alloys	Cast iron and carbon steel	Stainless steel, tool steel and steel alloys
Grinding	3.0%	3.0%	3.0%	3.5%
Standard machining	3.0%	3.0%	3.5%	4.0%
Medium duty reaming, tapping	5.0%	5.0%	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:	3
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If the refractometer is used, the resultant reading multiplied by a factor of 3 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	0.93	0.85	0.77	0.70	0.62	0.54	0.46	0.39	0.31	0.23	

Handling and storage

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

Packaging type

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.



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