

Heavy-duty synthetic metal working fluid



Application

Cimtech 31-24 is a latest generation synthetic fluid for heavy duty machining operations on a wide range of materials. It is designed primarily for demanding operations on aluminium used in the automotive industry but other hard and difficult alloys have proven to be no problem either. Cimtech 31-24 can be used in individual machines as well as in central systems. Cimtech 31-24 should be used in combination with soft water (0 - 15° dH).

Features and benefits

Cimtech 31-24 is designed primarily to improve productivity in demanding machining operations on high silicon containing (automotive) aluminium alloys used for example in the production of rims and pistons and materials such as stainless steel. For use with other metals and processes please consult your local Cimcool representative.

Cimtech 31-24 is highly cost effective, due to its low make-up rates and long fluid life. Cimtech 31-24 provides excellent lubrication and cooling, and does not foam when used at recommended concentration. The complete transparency of the mix enables good visibility in the cutting zone, and it has a magnificent washing action and superior cleanliness. In addition, Cimtech 31-24 rejects tramp oil and is low misting. The ingredients in Cimtech 31-24 provide no nourishment for bacteria ensuring exceptional long fluid life. Operators, otherwise sensitive to traditional fluids, generally appreciate the low pH (7.8), complete transparency and neutral smelling properties of Cimtech 31-24.

Cimtech 31-24 does not contain sulphur, chlorine, formaldehyde, diethanolamine or boron.

Additives should only be used after consulting a Cimcool representative.

Methods of application

Cimtech 31-24 is easy to mix, normal stirring only. For automatic mixing, the use of the Cimcool® Mix Master is recommended. Typical starting water temperature conditions should be 5 - 25°C.

Recommended starting concentration

Milling, drilling, turning, reaming and grinding	5 - 8%
Wrought and cast aluminium alloys, carbon and stainless steel.	5 - 8%

Use of lower concentrations than recommended above may cause foaming, corrosion and/or rancidity.

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:	1.2
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If the refractometer is used, the resultant reading multiplied by a factor of 1.2 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	0.81	0.61	0.41	0.21	0.01	*.81	*.61	*.40	*.20	*.00

Handling and storage

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

Packaging type

200, 1000 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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