

# CIMSTAR® 620FF

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



## Description

Cimstar 620FF is a clear, amber, water miscible, preformed microfine emulsion type cutting fluid concentrate.

## Application

Cimstar 620FF 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 620FF is a product designed for use in individual machines and central systems.

Cimstar 620FF is specifically designed for use in soft water (5 to 10dH 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 620FF 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	0.74	0.62	0.49	0.37	0.24	0.12	0.00	*.87	*.75

## Handling and storage

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

## Packaging type

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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