

CIMSTAR[®] S520FF

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



Description

Cimstar S520FF is a water miscible, formaldehyde releasing agent free (FRA) semi-synthetic cutting fluid concentrate.

Application

Cimstar S520FF is a general-purpose cutting fluid recommended for medium to heavy duty grinding and machining operations on ferrous and some non-ferrous metals. Cimstar S520FF is designed for use in individual machines and central systems.

Features and benefits

- Suitable for use in harder water (15 - 30 dH starting water hardness).
- Formaldehyde Releasing Agent free (FRA).
- Good emulsion stability, rust control and long fluid life.
- Suitable for all coolant filters and clarifiers.
- Permits higher feeds and speeds and is recommended for operations where tool life and high finish are important.
- Will not stain copper or copper alloys.
- Excellent cleanliness - keeps machine tools clean and grinding wheels open.

Methods of application

Cimstar S520FF is easy to mix, normal stirring only. For automatic mixing, the use of the Cimcool Mix Master S is recommended. Typical starting water temperature conditions should be 5 - 25°.

Recommended starting concentration

Grinding	4 - 6 %
Machining	6 - 8 %

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.

Concentration analysis

For concentration analysis, use the below given method or an appropriate laboratory procedure available from your local stockist.

Refractometer factor:	2.8
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If the refractometer is used, the resultant reading multiplied by a factor of 2.8 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	0.85	0.72	0.58	0.45	0.32	0.19	0.06	*.93	*.80	*.66

Handling and storage

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

Packaging type

200 and 1.000 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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