

CIMPERIAL[®] 1311

**HIGH PERFORMANCE METALWORKING FLUID
ADVANCED SOLUBLE EMULSION**



Product Information Flyer

DESCRIPTION

CIMPERIAL[®]1311 is a heavy-duty, soluble metalworking fluid blending the reliability of traditional soluble fluids with industry leading technology to deliver performance which meets the market. CIMPERIAL[®]1311 is developed for all operation machining, sawing and grinding of ferrous and most non-ferrous metals including Cast/Ductile Iron.

APPLICATION

CIMPERIAL[®]1311 is recommended for turning, drilling, milling, reaming, boring, tapping, roll/form tapping, broaching, sawing and most grinding applications. It should not be used on magnesium alloys.

FEATURES & BENEFITS

VERSATILE:

CIMPERIAL[®]1311 is ideally suited when one metalworking fluid, all metals, all operations is required throughout the machine shop and is formulated to withstand extremely hard water.

FOAM CONTROL:

CIMPERIAL[®]1311 is recommended for use in a wide range of water qualities, has excellent foam control in soft water, and general high pressure applications.

EXCELLENT RANCIDITY CONTROL:

Excellent fluid life. Minimizes the need for additives.

CORROSION PROTECTION:

Outstanding rust protection for the work-piece and machine tool surfaces

COMPATIBLE MATERIALS:

Steels, Stainless Steels, Alloy Steels most Aluminiums

RECOMMENDED STARTING DILUTIONS

CIMPERIAL[®]1311 is to be mixed with water for use. Always add concentrate to water. Fluid may be more difficult to mix when water temperature is below 55F. Add no other materials to the concentrate or mix unless approved by your CIMCOOL[®] District Manager.

Grinding	5% - 10%	(1:20 to 1:10)
Machining	5% - 10%	(1:20 to 1:10)

CONCENTRATION

MI Titration, Non-solvent Titration, Total Alkalinity, CIMCHEK[™] Test Strip or Refractometer can be used.

The Refractometer Factor is 1.2

A refractometer is only recommended for use in checking the concentration of a fresh charge. Multiply the scale reading obtained on your CIMCOOL[®] Refractometer by this factor to obtain the mix concentration in percent. Calibrate the refractometer so that it reads 0.0 with water before testing the sample mix. Remove gross contaminants from the sample mixes before testing.

TYPICAL PHYSICAL AND CHEMICAL PROPERTIES

Physical State: Liquid

Solubility in water: 100% miscible

Viscosity (SUS) @ 100°F: N/A

pH Concentrate: 10.1

Total Chlorine/Chloride, wt%: None

Silicones: Yes

Appearance and Odor: Hazy/Chemical

Weight, lb/gal, 60°F (15.6 °C): 8.4

Flash Point /Sp.Gr./Boiling Point: SEE SDS

pH Mix 5%, Typical Operating: 9.4

Total Sulfur, wt%: None

Borons: None

HANDLING and STORAGE

If frozen, thaw completely at room temperature. Inside storage is recommended.

SAFETY DATA SHEET

Request at www.cimcool.com.au

For additional information refer to its WHMIS MSDS, website or contact CIMCOOL[®] Technical Services at 1-513-458-8199 in Ohio or 1-800-050-469 in Australia.

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