

CIMSTAR[®] 70-HFP with FACT
METALWORKING FLUID for HIGH PRESSURE
APPLICATIONS



Product
Information
Flyer

DESCRIPTION

CIMSTAR 70-HFP is a semi-synthetic metalworking fluid.

APPLICATION

CIMSTAR 70-HFP is a premium semi-synthetic for moderate duty operations. It is recommended for High Fluid Pressure and High Volume Flow Applications where minimization of foam is critical for part quality and machine operations. It is recommended for general purpose machining of ferrous and most non-ferrous applications. It can be used for turning, drilling, reaming, boring, milling and tapping as well as some grinding operations.

FEATURES & BENEFITS

CIMCOOL[®]-HFP Fluids with FACT:

Provides superior foam control through the combination of product design, raw material selection and innovative antifoam technology. These fluids are the result of years of experience that have identified creative methods to prevent, control, and reduce foam, even when fluids are used in high pressure delivery systems. This expertise and extreme is only available in CIMCOOL[®]-HFP Fluids with FACT.

CORROSION PROTECTION:

The oily residue keeps machine tools and work-piece materials free of corrosion and staining. Good on most non-ferrous alloys as well.

MICROBIAL CONTROL:

CIMSTAR 70-HFP has good rancidity control if product concentration is properly controlled.

RECOMMENDED STARTING DILUTIONS

CIMSTAR 70-HFP 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

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

The Refractometer Factor is 1.4. 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: 270

pH Concentrate: 9.4

Total Chlorine/Chloride, wt%: 0/<50ppm

Silicones: Yes

Appearance and Odor: Hazy/Chemical

Weight, lb/gal, 60°F (15.6 °C): 8.4

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

pH Mix 5%, Typical Operating: 9.0

Total Sulfur, wt%: 0.2

HANDLING and STORAGE

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

SAFETY DATA SHEET

Available at www.cimcool.com

For additional information refer to its OSHA MSDS, website or contact your local CIMCOOL TECHNICAL SPECIALIST OR DISTRICT MANAGER, or you may contact CIMCOOL® Technical Services at 1-513-458-8199.

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