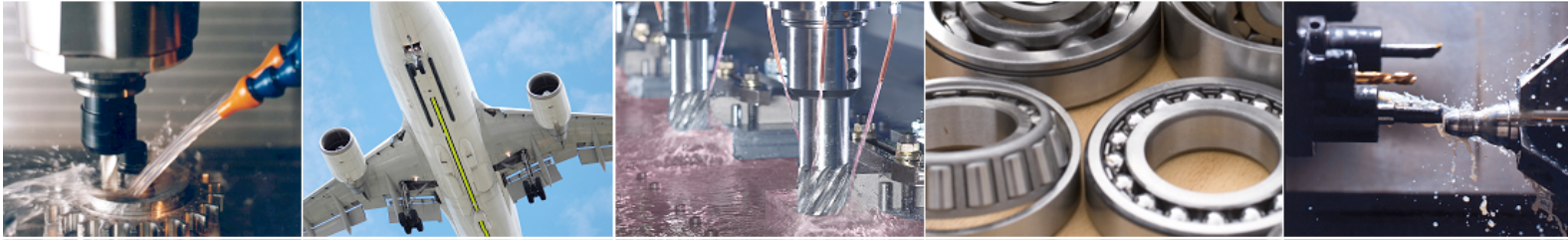


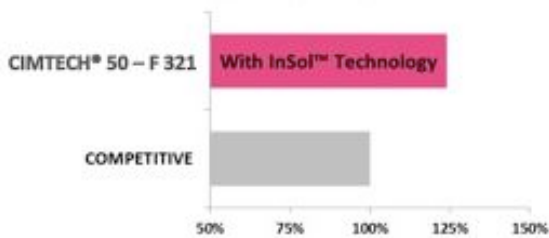
# CIMTECH® 50-F321 with InSol™ Technology METALWORKING FLUID



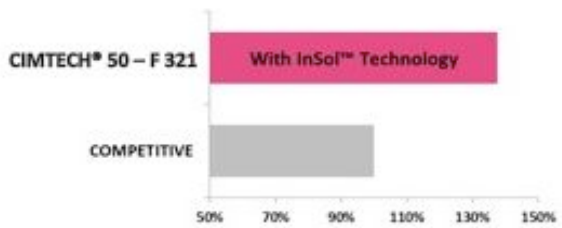
## What is InSol™ Technology....?

InSol Technology puts lubricant at the cut zone-tooling interface so that lubrication and cooling are optimized. Since InSol Technology is water soluble, this great performance lasts longer due to lower depletion rates. Best of all, InSol Technology can help with tough alloys and even form tapping of aluminum. Using CIMTECH fluids with InSol Technology can improve machining and grinding ratios significantly compared to conventional fluids.

### MACHINING IMPROVEMENT



### GRINDING RATIO IMPROVEMENT



A Milacron LLC Company

## Product Information Flyer

### DESCRIPTION

**CIMTECH® 50 – F321 with InSol™ Technology** metalworking fluid is a unique, low pH synthetic fluid designed for the aerospace industry and is recommended for heavy to severe duty machining and grinding operations, including creep feed grinding, on non-ferrous or ferrous metals. Suitable for use where extreme lubricity is required such as deep hole drilling and roll form tapping.

### APPLICATION

**CIMTECH® 50 – F321 with InSol™ Technology** can be used on wrought aluminum alloys (2024, 6061, 7050, 7075), cast aluminum alloys (380, 390), carbon steels, stainless steels, titanium and other exotic alloys. It should not be used on magnesium alloys.

### FEATURES & BENEFITS

- Excellent lubricity, tool life and surface finish
- Unlike most synthetics, this fluid can be used to roll/form tap Aluminium and some Steels
- Up to 20% productivity gains over competitors
- Excellent rancidity control
- Rejects tramp oil which extends sump life
- Minimal need for additives
- Provides excellent part visibility
- Low misting
- Mild to skin
- Very low foaming even when used with de-ionized water

*“Compatible and formulated for use with CIMGLIDE® series Slideway oils meeting CINCINNATI MILACRON P47, P50 specification”*



### RECOMMENDED STARTING DILUTIONS

**CIMTECH® 50 – F321 with InSol™ Technology** 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 55°F (13°C). Add no other materials to the concentrate or mix unless approved by your CIMCOOL® Territory Manager.

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

### CONCENTRATION

BCG Titration, Total Alkalinity, CIMCHEK™ Test Strip or Refractometer can be used.

The Refractometer Factor is 1.6

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. A refractometer is only recommended for use in checking the concentration on a fresh charge.

### TYPICAL PHYSICAL AND CHEMICAL PROPERTIES:

**Physical State:** Liquid

**Solubility in water:** 100% miscible

**Viscosity (SUS) @ 100°F (38°C):** 110

**pH Concentrate:** 8.2

**Total Chlorine/Chloride, wt%:** 0.0/< 900 ppm

**Silicones:** None

**Appearance and Odor:** Clear/Chemical

**Weight, lb/gal, 60°F (15.6°C):** 9.0

**Flash Point /Sp.Gr./Boiling Point:** N/A

**pH Mix 5%, Typical Operating:** 7.5

**Total Sulfur, wt%:** 0

### HANDLING and STORAGE

If frozen, product separates. Thaw completely at room temperature and stir thoroughly before use. Inside storage is recommended.

### SAFETY DATA SHEET

Available at [www.cimcool.com.au](http://www.cimcool.com.au)

For additional information refer to product SDS, website or contact CIMCOOL® Technical Services at 1800 050 469.

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