

# CIMSTAR® 35-659-03

Boron and formaldehyde releasing agent free product for heavy duty aerospace applications equipped with CimShield Technology



## Description

Cimstar 35-659-03 is a water-miscible, micro fine emulsion type cutting fluid concentrate. This high-performance emulsion is free of boron, nitrite, chlorine and formaldehyde releasers. The Cimstar 35-659-03 is equipped with Cimcool's unique CimShield Technology. This innovative technology will secure the product stability, the pH buffering of the mix and gives excellent corrosion protection.

## Application

Cimstar 35-659-03 is a specialized cutting fluid recommended for heavy duty machining and grinding operations on difficult to machine aerospace alloys like titanium, and nickel based superalloys. Cimstar 35-659-03 is designed for use in individual machines and central systems, and performs extremely well when used in water of medium hardness (8 to 20° dH).

## Features and benefits

- CimShield Technology - Based on a unique formulation and contains a special blend of new innovative materials. These materials work in synergy providing product stability, pH buffering and corrosion protection. The results equal traditional products which contained boron and formaldehyde releasing agents. The CimShield Technology not only protects the product from outside influences but also shields the product from evaporation, resulting in low top up rates and thus reducing overall consumption.
- Aerospace material compatibility - Excellent compatibility with high nickel based alloys and titanium used in Aeroengine manufacturing.
- Operator friendly - Mild to the skin, clean, no smell, no mist and excellent foam control.
- Economical - Exceptionally low top up rate, long tool life, long fluid life, excellent results.

## Methods of application

Cimstar 35-659-03 is easy to mix, normal stirring only. For automatic mixing, the use of the Cimcool® MixMaster or Cimcool MixMaster S is recommended. Typical starting water temperature conditions should be 5 - 25°C.

## Recommended starting concentration

	Grinding and Machining
Starting concentration	6 - 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.

## Concentration analysis

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

Refractometer factor:	1.6
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If the refractometer is used, the resultant reading multiplied by a factor of 1.6 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	0.80	0.71	0.58	0.45	0.32	0.18	0.05	*.92	*.79	*.65

## Handling and storage

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

## Packaging type

5, 20, 1000 and 200 litre and bulk.

## 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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