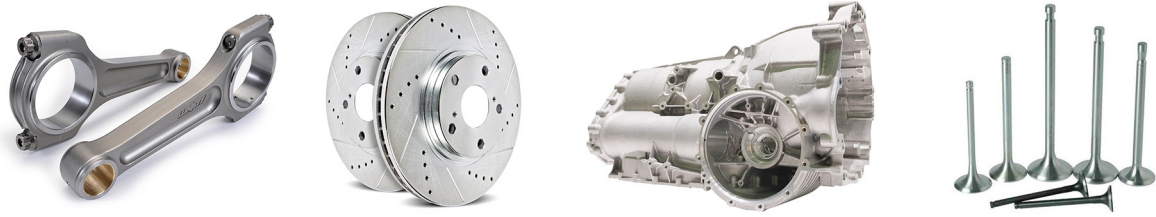


# CIMPERIAL® 31-81FF

Heavy duty cutting fluid without formaldehyde releasing biocides



## Description

Cimperial 31-81FF is an emulsion type heavy-duty metalworking fluid specifically designed for the machining and grinding of aluminium and aluminium alloys. Cimperial 31-81FF is free from formaldehyde releasing biocides.

## Application

Although specifically developed for use on aluminium Cimperial 31-81FF can be used for a wide range of other materials ranging from higher alloyed steels up to exotic alloys like titanium and inconel. Cimperial 31-81FF is developed for use in soft water (5 to 12°dH in starting water).

## Features and benefits

- Cimperial 31-81FF is a clean and low foaming fluid, resulting in cleaner machines, better operator acceptance and lower consumption.
- The excellent fluid stability ensures a long fluid life.
- Cimperial 31-81FF is a very cost effective aluminium machining product.
- Does not stain aluminium alloys.

## Methods of application

Cimperial 31-81FF is easy to mix, normal stirring only. For automatic mixing, the use of the Cimcool® Mix Master or Cimcool Mix Master S is recommended. Typical starting water temperature conditions should be 5 - 25°C.

## Recommended starting concentration

Grinding & machining	5 - 10%
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## 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 or TA Kit.

## Concentration analysis

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

Refractometer factor:	1.1
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If the refractometer is used, the resultant reading multiplied by a factor of 1.1 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	0.86	0.75	0.64	0.53	0.42	0.31	0.19	0.08	*.97	*.86

## Handling and storage

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

## Packaging type

20, 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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