



Description

Cimtech 46C synthetic metalworking fluid is specifically designed for carbide grinding applications. It is also used for moderate duty machining and grinding operations of ferrous metals.

Application

Especially well-suited for carbide grinding applications where cobalt leaching is a major consideration and recommended for moderate duty grinding of hard metals such as cobalt, stellite and titanium alloys, including chrome plated and HVOF Thermal Spray Coating components

Cimtech 46C can also be used to machine and grind cemented carbide, cast iron, nodular iron, carbon steels and tool steels. It should not be used on magnesium alloys or non-ferrous materials.

Features and benefits

- Superior cobalt corrosion inhibition: Cimtech 46C is designed to maintain low levels of dissolved cobalt in the mix.
- Fluid life: Excellent fluid life, minimizing the need for additives. Stable, ideal for Central systems as well as individual tanks.
- Excellent foam control: Cimtech 46C has good foam control.
- Corrosion protection: Outstanding rust protection for the work-piece and machine tool.
- Cimtech 46C Metalworking Fluid received BOEING approval for under BAC 5008REVr - Areas 5 and 6, including titanium alloys. The approval number is BOEING PSD 6-124.

Methods of application

Cimtech 46C 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 and light machining	4 - 6%
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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.

Concentration analysis

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

Refractometer factor:	2.0
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If the refractometer is used, the resultant reading multiplied by a factor of 2.0 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	0.85	0.73	0.61	0.49	0.36	0.24	0.12	0.00	*.88	*.75

Handling and storage

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

Packaging type

5, 20, 200 and 1000 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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