

Synthetic metalworking fluid specially designed for heavy to extremely heavy duty machining operations



Application

Cimtech A61 is an innovative new metalworking fluid featuring a hybrid blend of patented and synthetic lubricants. This unique blend of lubricants provides synergistic performance on difficult-to-machine-ferrous and some non-ferrous alloys without corrosion or stain.

Cimtech A61 is uniquely formulated to be used on hard, brittle metals that “ordinary” fluids have difficulties with, such as inconel, titanium (including Ti-5553), stainless steel, aerospace alloys and hardened steels. Cimtech A61 is an exceptional product for milling, drilling, and cut tapping these materials, as well as for operations on aerospace and aluminium alloys (e.g. 2024, 6061, 7050, 7075).

Recommended is to use demi or soft (<5°dH) make up water.

Features and benefits

- Excellent heavy-duty performance without chlorine, sulphur or phosphorus EP lubricants.
- Near neutral pH.
- Good corrosion control for both ferrous and most non-ferrous metals.
- Works best in tough operations.
- Low foam.
- Good part visibility for operations.
- Contains a Milacron patented lubricant.
- Operator friendly: fresh mix is transparent (no smoke, low, misting, mild to skin).

Methods of Application

Cimtech A61 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

Heavy duty grinding	5%
Heavy duty machining	5% (1:20) to 10% (1:10)

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 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:	1.3
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If the refractometer is used, the resultant reading multiplied by a factor of 1.3 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	0.84	0.67	0.51	0.34	0.18	0.01	*0.85	*0.68	*0.52	*0.35

Handling and storage

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

Packaging type

5, 25, 200, 1000 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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