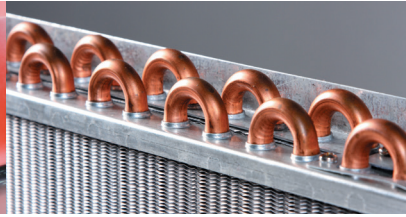
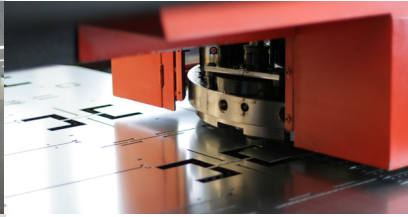


MILFORM® 645

Micro emulsion forming fluid for
medium to heavy-duty operations



PRODUCT INFORMATION FLYER

Description

Milform 645 is a clear micro emulsion containing a high percentage of chlorinated and extreme pressure additives for effective lubrication. The product provides good cleanliness and long term corrosion control on all the metals.

Application

Milform 645 is a forming fluid having excellent EP characteristics is recommended for moderate to heavy-duty blanking, piercing, bending, deep drawing, ... on all the metals. It can be applied by roller coater or spray application. Parts are easier and quicker cleaned.

Features and benefits

Features	Benefits
Best heavy duty multi purpose, product, all metals.	Reduce number of products. Reduce inventory.
Versatile.	Can be used over a wide range of dilutions.
Excellent carbide corrosion control.	Very low cobalt leaching of carbide dies.
High quality additive package.	Prevents scrap - Extends tool life - Better surface finish.
Excellent hard water stability.	Up to 600 ppm.
Long term corrosion control.	Parts can be stored indoors for an extended period.
Good cleanliness.	No gummy deposits. When necessary use alkaline or vapour degreasing systems.
Good rancidity control.	Mix lasts longer. Less fluid consumption
Mild to the skin.	Proven by toxicological testing by independent laboratory.

Recommended starting dilution

Percentages used initially have to be somewhat higher than lower.

Notching	5 mm = 30% - 0.75 mm =10%
Piercing/punching	5 mm = 30% - 0.5 mm =10%
Blanking	5 mm = 30% - 0.5 mm =10%
Shearing/slitting	5 mm = 30% - 0.5 mm =10%
Bending	5 mm = 30% - 0.5 mm =10%
Shallow drawing	3.75 mm = 30% - 0.5 mm =10%
Deep drawing	2.5 mm = 30% - 0.5 mm =10%
Swaging	5 mm = 30% - 0.5 mm =10%
Spinning	10% - 20%
Coining	5 mm = 30% - 0.5 mm =10%
Embossing	2.5 mm = 30% - 0.5 mm =10%
Roll forming	7% - 12%
Tube rolling	7% - 12%

Concentration Analysis

For concentration analysis, use one of the below given methods or an appropriate laboratory procedure available from your local stockist. Refractometer factor: 1.0

If the refractometer is used, the resultant reading multiplied by a factor of 1.0 will only be relevant when applied to a fresh mix.

Handling and storage

Keep at temperatures between 5°C and 30°C in original container.

Packaging type

5, 25, 200 and 1.000 liter and bulk.

Safety Data Sheet

The Safety Data Sheet should be consulted for specific information and information on Health, Safety and Environmental matters when handling this product.



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