



### Application

Cimtech A35 is a new type of synthetic fluid for heavy duty machining operations on a wide range of materials. It is designed primarily for demanding operations in hard and difficult alloys but aluminium alloys have proven to be no problem either. Cimtech A35 can be used in individual machines as well as in central systems. Cimtech A35 can be used with demineralised and good quality tap water.

### Features and benefits

Cimtech A35 is designed primarily to improve productivity in demanding machining operations on stainless steel, titanium, nickel and other aerospace alloys including aluminium. For use with other metals and processes please consult the compatibility guide on page two, or contact your local Cimcool representative.

Cimtech A35 is highly cost effective, due to its low make-up rates and long fluid life. Cimtech A35 provides excellent lubrication and cooling, and does not foam when used at recommended concentration. The complete transparency of the mix enables good visibility in the cutting zone, and it has a magnificent washing action and superior cleanliness. In addition, Cimtech A35 rejects tramp oil and is low misting. The ingredients in Cimtech A35 provide no nourishment for bacteria ensuring exceptional long fluid life. Operators, otherwise sensitive to traditional fluids, generally appreciate the low pH (8.3), complete transparency and neutral smelling properties of Cimtech A35.

Cimtech A35 does not contain MEA, DEA, TEA, chlorine, formaldehyde releasers, boron or BIT.

Additives should only be used after consulting a Cimcool representative.

### Physical and chemical properties

Density 20°C Kg/m <sup>3</sup> :	1052
pH (concentrate):	8,6
pH (operating):	8,3

## Recommended starting concentration

Machining and grinding	5%
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## Metal and water compatibility

Type of metal	Copper and Copper alloys such as brass and bronze	Aluminium	Cast iron	Steel, carbon- & stainless steel
<b>Compatibility</b>	Compatible only for occasional application, but beware of risk of staining of parts, residue formation in machines and/or discoloration of mix. Regular addition of Inhibitor EC can reduce, but not eliminate this risk.	Excellent with hard Al (typically wrought and cast Al). In soft Al beware of chip build up on tools in high-speed threading, tapping and deep hole drilling operations compared to oil based fluids. For use with very special grades of Al a staining test is recommended before using the product. Mixing with demineralised water will give improved Al corrosion protection.	Compatible, but beware of increased risk of corrosion - in particular chip corrosion - compared to conventional oil based fluids.	Excellent
<b>Water compatibility</b>	It is advised to mix only with demineralised water or good quality tap water: maximum 10°GH. Exceeding this limit may, in time, cause lime deposits and/or corrosion. It is recommended to keep the chloride concentration in the mix below 350 ppm to ensure satisfactory ferrous corrosion control.			
<b>Remarks</b>	Being free of mineral oil Cimtech A35 may have a tendency of leaving a more sticky residue than traditional oil based fluids, in particular on open machines. However, regular spraying with a 1% solution of Cimclean 51 followed by wiping with a cloth (prevent fluid contamination) will easily remove such residue. Beware of residue when using measuring instruments and clean moving parts frequently. Applying a thin coat of Cimguard 20 may prevent such problems, and will not interfere with instrument measuring accuracy.			

The above are general guidelines for single use on the above metals only. For suitability on materials not mentioned, or suitability for mixed machining of various metals with the same fluid in the same machine/system, contact your local Cimcool representative.

## 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:	1.5
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If the refractometer is used, the resultant reading multiplied by a factor of 1.5 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	0.74	0.62	0.50	0.37	0.25	0.13	0.01	*.88	*.76

## 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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