

CIMCOOL®

METALWORKING FLUIDS

CIMPERIAL® HD 265

PREMIUM WATER SOLUBLE METALWORKING FLUID DESIGNED FOR HEAVY DUTY GRINDING AND MACHINING OPERATIONS

APPLICATIONS	<p>CIMPERIAL® HD 265 is a water soluble, “super-lubricant” metalworking fluid designed for heavy-duty grinding and machining operations. Its patented Extreme Pressure lubricant package provides outstanding stock removal, permitting high productivity increases. CIMPERIAL® HD 265 can be used in individual machines or central systems.</p> <p>CIMPERIAL® HD 265 excels in traditional “heavy-duty” operations-such as bearing, strut, and valve grinding- to provide large increases in process throughputs and tool life. In many cases, only changing the metalworking fluid has provided dramatic productivity increases.</p> <p>Metals: Carbon Steels, High Speed Steels, High Alloy Steels, Stainless Steels, Tool Steels (CIMPERIAL® HD 265 should not be used on copper, copper alloys, brass, or bronze)</p> <p>Duty Range: For heavy-duty operations</p>
FEATURES & BENEFITS	<p>EXCELLENT LUBRICITY - A patented lubricant provides exceptional lubricity for grinding and machining, especially with “heavy-duty” type operations - A series of extreme pressure lubricants are activated at various temperatures to permit high stock removals that are not possible with conventional water based fluids</p> <p>ENHANCED PRODUCTIVITY - Improves part quality - Lowers wheel and tool usage - Lowers fluid makeup rates - Increases machine uptime</p> <p>PROCESS IMPROVEMENTS - Reduced cycle times - Longer wheel and tool life - Decreased machine horsepower - Improved part finish</p> <p>EXCELLENT MICROBIAL CONTROL - Good bacteria and mold control resulting in long fluid life</p> <p>ENVIRONMENTALLY FRIENDLY - Provides a clean work environment with minimal oil mist in the air, cleaner machines, floors, and parts</p> <p>OPERATOR AND MACHINE FRIENDLY - Can be used in a broad concentration range (5 to 10%) - Mild and clean - Provides corrosion protection to both the machine and parts</p> <p>Note: CIMPERIAL® HD 265B has the same performance characteristics as CIMPERIAL® HD 265 but in addition, is designed to be low foaming in soft water (50 ppm hardness)</p>

<p>RECOMMENDED STARTING DILUTIONS</p>	<p>FOR INDUSTRIAL USE ONLY Recommended Starting Dilution: 5% (1:20) Typical Operating Range: 5% (1:20) to 10% (1:10) For concentrations outside this range contact CIMCOOL® Technical Service at 513-458-8199.</p> <p>CIMPERIAL® HD 265 is to be mixed with water for use (add concentrate to water).</p> <p>Add no other substances to the concentrate or mix unless approved by CIMCOOL® Technical Services. Not recommended for use with magnesium or alloyed magnesium.</p> <p>For concentration analysis, use the NS Titration Procedure, MI Titration Procedure, Total Alkalinity Titration Procedure, CIMCHEK™ Test Strip, or Refractometer.</p>
<p>TYPICAL PHYSICAL AND CHEMICAL PROPERTIES</p>	<p>Physical state: Liquid Appearance and odor: Clear / Chemical Colors available: Undyed Solubility in water: 100% Miscible Weight, lb/gal, 60°F (15.6°C): 8.42 Specific gravity, (H₂O = 1): 1.009 Boiling point, °F (°C): 170 (77) Flash point, COC, °F (°C): 315 (157) Fire point, COC, °F (°C): 330 (166) Freezing point, °F, (°C): 5 (-15) If frozen, product separates. Thaw completely at room temperature and stir thoroughly. pH, concentrate: Not Applicable pH, 5.0% mix, typical operating conditions: 8.8 Total chlorine/chloride, wt%, calculated: 0.00/< 50 ppm Total sulfur, wt%, calculated: 15.0 Silicones: Yes</p>
<p>PACKAGING</p>	<p>Available in 5-gallon pails, 55-gallon drums, and bulk containers.</p>
<p>REFRACTOMETER FACTOR = 0.8 Multiply the scale reading obtained on your CIMCOOL® Metalworking Fluid or other acceptable refractometer by the Refractometer Factor to obtain the mix concentration in percent.</p> <p>NOTE: Calibrate the refractometer so that it reads 0.0 with water, before testing the sample mix. Remove gross contaminants from the sample mix before testing.</p> <p>This product to be used within six months of its manufacture date indicated by the lot number on the container label.</p>	
<p>For additional information concerning CIMPERIAL® HD 265, refer to its OSHA MSDS or contact CIMCOOL® Technical Services at 1-513-458-8199. Reprints/Updates of this Product Information Flyer (PIF) can be found on our web site, WWW.CIMCOOL.COM or from your Milacron representative.</p> <p>Minor formulation changes or normal variations in the manufacture of this product may cause slight variances in the data presented on this sheet. Consumable Products Division/ Milacron Marketing Company Cincinnati, Ohio 45209</p> <p>PC-9932 8/10/06</p>	

