

# CIMPERIAL<sup>®</sup> 1880M



## DESCRIPTION

CIMPERIAL 1880M metalworking fluid is a premium soluble oil designed for machining magnesium, but can also be used on other materials, including aluminum.

## APPLICATION

CIMPERIAL 1880M is for moderate to heavy duty machining and grinding applications and can be used on magnesium\*, most Aluminum alloys and other non-ferrous metals, Carbon Steels, High Speed Steel, Cast Steels, Alloy Steels, Tool Steel, Stainless Steel, and Cast Iron.

## FEATURES

- Magnesium compatibility\*: Using CIMPERIAL 1880M for machining magnesium results in the lowest level of hydrogen evolution, when compared to all other water-based products tested - Reduces magnesium dust creation
- Excellent mix stability, even in the presence of high levels of magnesium

## RECOMMENDED STARTING DILUTIONS

CIMPERIAL 1880M is to be mixed with water for use. Always add concentrate to water. Add no other materials to the concentrate or mix unless approved by your CIMCOOL<sup>®</sup> District Manager.

- Machining and Grinding 5% - 10% (5.6 to 11.1 on the refractometer scale)
- Refractometer Factor is 0.9
- 5% Mix pH is typically 8.4
- Shelf life is 7 months

\* - **OTHER PRECAUTIONS:** When using this product on magnesium or alloys of magnesium proper safety procedures must be followed. These include: 1) providing ample flooding of the part with the metalworking fluid; 2) minimizing magnesium chip accumulation in machines, sumps and tanks; 3) promptly separating magnesium chips from the fluid; and 4) providing ventilation for hydrogen gas. For more information on machining of magnesium with water based metalworking fluids, please refer to the "Hydro Magnesium" website, <http://www.hydrumagnesium.com>, in their brochure section under "Machining Magnesium" or the International Magnesium Association brochure "Safe Machining And Handling Of Magnesium Chips, Turnings & Grindings" that can be found in their "Publication and Video" section of their website, <http://www.intlmag.org/brochures.aspx>

## SAFETY DATA SHEET:

Available at [www.cimcool.com](http://www.cimcool.com)

For additional information refer to its OSHA SDS, website or contact your local CIMCOOL TECHNICAL SPECIALIST or DISTRICT MANAGER, or you may contact CIMCOOL<sup>®</sup> Technical Services at 1-888-CIMCOOL.

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