



Product Information Flyer

DESCRIPTION

CIMSTAR QUAL STAR XL is a semi-synthetic metalworking fluid. It is a chlorine free general purpose product for machining and grinding.

APPLICATION

CIMSTAR QUAL STAR XL* was developed for use on ferrous and most non-ferrous materials. It can be used on mild steels, stainless steels, hardened steels, and most non-ferrous alloys. It should not be used on magnesium alloys.

For use in moderate duty machining and grinding applications, such as milling, drilling, cut tapping, reaming, boring and in most grinding applications.

FEATURES & BENEFITS

VERSATILE PRODUCT:

This new generation bio-stable semi-synthetic blends the technical advantages of modern day synthetics fluids with the performance of soluble oils. Because of the unique formulation, this product can be used on tough applications like sawing but also versatile enough for surface grinding, milling or turning.

CORROSION PROTECTION:

The oily residue keeps machine tools and work-piece materials free of corrosion and staining.

MICROBIAL CONTROL:

CIMSTAR QUAL STAR XL has excellent rancidity control.

* CIMSTAR QUAL STAR XLB has the same performance characteristics as CIMSTAR QUAL STAR XL but has additional foam control.

RECOMMENDED STARTING DILUTIONS

CIMSTAR QUAL STAR XL is to be mixed with water for use. Always add concentrate to water. Fluid may be more difficult to mix when water temperature is below 55 F (13 C). Add no other materials to the concentrate or mix unless approved by your CIMCOOL® District Manager.

Grinding	5% - 10%	(1:20 to 1:10)
Machining	5% - 10%	(1:20 to 1:10)

CONCENTRATION

An MI Titration, Non-solvent Titration, Total Alkalinity or Refractometer can be used.

The Refractometer Factor is 1.7

Multiply the scale reading obtained on your CIMCOOL® Refractometer by this factor to obtain the mix concentration in percent. Calibrate the refractometer so that it reads 0.0 with water before testing the sample mix. Remove gross contaminants from the sample mixes before testing. A refractometer is only recommended for use in checking the concentration of a fresh charge.

TYPICAL PHYSICAL AND CHEMICAL PROPERTIES:

Physical State: Liquid

Solubility in water: 100% miscible

Viscosity (SUS) @ 100°F: 450

pH Concentrate: 10.0

Total Chlorine/Chloride, wt%: 0.0/<50ppm

Silicones: NO for CIMSTAR QUAL STAR XL / Yes for CIMSTAR QUAL STAR XLB

Appearance and Odor: Hazy/Chemical

Weight, lb/gal, 60°F (15.6 °C): 8.5

Flash Point /Sp.Gr./Boiling Point: SEE MSDS

pH Mix 5%, Typical Operating: 8.8

Total Sulfur, wt%: 0.4

HANDLING and STORAGE

If frozen, product separates. Thaw completely at room temperature and stir. Inside storage is recommended.

SAFETY DATA SHEET

Available at www.cimcool.com

For additional information refer to its OSHA MSDS, website or contact your local CIMCOOL TECHNICAL SPECIALIST OR DISTRICT MANAGER, or you may contact CIMCOOL® Technical Services at 1-513-458-8199.

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