

CIMCOOL® Metalworking Fluid Application Guide

MACHINING

1. Select type of metal to be machined
2. Determine severity of operation
3. Select appropriate fluid, contact CIMCOOL Technical Service for more in-depth details
4. Customer should always verify compatibility with alloy/application

1 Metal	STEELS 400 Series Stainless Carbon Alloys Tool Steels	IRON	ALUMINUM High Silicon (Automotive)	ALUMINUM Low Silicon (Aerospace)	NON-FERROUS Copper Brass Other	STAINLESS STEEL 300 Series	HIGH TEMP ALLOYS Nickel Base Iron Base
2 Severity	3 Appropriate Fluid						
VHD	CIMPERIAL 1060CF-HFP		CIMPERIAL 1060CF-HFP	CIMTECH 320-HFP	CIMPERIAL 1060CF-HFP		
HD	CIMTECH 400 with MSL		CIMSTAR 700		CIMTECH 400 with MSL	CIMTECH 410C	
MD	CIMTECH 410C CIMSTAR QUAL STAR XL CIMSTAR 700		CIMSTAR 10-565 VLCB		CIMTECH 410C CIMSTAR QUAL STAR XL		

KEY	
VHD	Very Heavy Duty (Example: Broaching, Form Tapping, Reaming)
HD	Heavy Duty (Example: Drilling, Cut Tapping, Sawing)
MD	Medium Duty (Example: Turning)

CIMCOOL® Metalworking Fluid Application Guide

GRINDING

1. Select type of metal for grinding
2. Determine severity of operation
3. Select appropriate fluid, contact CIMCOOL Technical Service for more in-depth details
4. Customer should always verify compatibility with alloy/application

1 Metal	STEELS 400 Series Stainless Carbon Alloys Tool Steels	IRON	ALUMINUM High Silicon (Automotive)	ALUMINUM Low Silicon (Aerospace)	NON-FERROUS Copper Brass Other	STAINLESS STEEL 300 Series	HIGH TEMP ALLOYS Nickel Base Iron Base
2 Severity	3 Appropriate Fluid						
VHD	Contact CIMCOOL Technical Service at 513.458.8196						
HD							
Form	CIMPERIAL 1060CF-HFP		CIMPERIAL 1060CF-HFP	CIMTECH 320-HFP	CIMPERIAL 1060CF-HFP		
Thread/Flute	CIMTECH 410C		CIMSTAR 700				
Creep Feed	CIMTECH 410C						
MD							
Centerless/ Shoe Type	CIMSTAR 700		CIMSTAR 10-565 VLCB	CIMTECH 320-HFP	CIMPERIAL 1060CF-HFP		
Centertype	CIMSTAR QUAL STAR XL						
Internal							
Tool Room/ General Purpose	CIMSTAR QUAL STAR XL CIMPERIAL 1060CF-HFP CIMTECH 410C		CIMPERIAL 1060CF-HFP CIMSTAR QUAL STAR XL				

KEY	
VHD	Very Heavy Duty
HD	Heavy Duty
MD	Medium Duty