

# MILFORM<sup>®</sup>

## METALFORMING FLUIDS

### MILFORM<sup>®</sup> 635

<b>APPLICATIONS</b>	<b>MILFORM<sup>®</sup> 635</b> is a water soluble stamping and drawing fluid for moderate to heavy-duty applications on ferrous and non-ferrous metals.
<b>FEATURES &amp; BENEFITS</b>	<ul style="list-style-type: none"><li>• Versatile soluble oil used on ferrous and non-ferrous metals</li><li>• Excellent lubricity and extreme pressure (EP) performance</li><li>• Very clean – Washes off parts easily</li><li>• Good microbial control</li><li>• Excellent tool and die life</li></ul>

**RECOMMENDED  
STARTING  
DILUTIONS****FOR INDUSTRIAL USE ONLY.**

Use between 10% (1:10) and 40% (1:2.5) for light to heavy-duty stamping and drawing.

**MILFORM<sup>®</sup> 635** is to be mixed with water for use (add concentrate to water). Add no other substances to the concentrate or mix unless approved by CIMCOOL<sup>®</sup> Technical Services (513-458-8199)

Not recommended for use with magnesium or alloyed magnesium.

For concentration analysis, use Acid Split Method or the MI Titration Method.

**TYPICAL  
PHYSICAL AND  
CHEMICAL  
PROPERTIES**

**Physical state:** Liquid

**Appearance and odor:** Clear / Chemical

**Colors available:** Undyed

**Solubility in water:** 100% Miscible

**Weight, lb/gal, 60°F (15.6°C):** 8.5

**Specific gravity, (H<sub>2</sub>O = 1):** 1.02

**Viscosity (SUS) @ 100° F, Typical:** 1,085

**Boiling point, °F (°C):** NA

**Flash point, COC, °F (°C):** 375 (191)

**Fire point, COC, °F (°C):** 380 (193)

**Freezing point, °F (°C):** 0 (- 18)

If frozen, thaw completely at room temperature.

**pH, concentrate:** NA

**pH, 20.0% mix, typical operating conditions:** 7.2

**Total chlorine/chloride wt%, calculated:** 12.4 / < 50 ppm

**Total sulfur, wt%, calculated:** 0.3

**Silicones:** None

**PACKAGING**

Available in 5-gallon pails, 55 gallon drums, and bulk containers

**REFRACTOMETER FACTOR = 1.0** Multiply the scale reading obtained on your CIMCOOL<sup>®</sup> Metalworking Fluid or other acceptable refractometer by the **Refractometer Factor** to obtain the mix concentration in percent.

**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.**

For additional information concerning MILFORM<sup>®</sup> 635, refer to its OSHA MSDS or contact CIMCOOL<sup>®</sup> 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](http://WWW.CIMCOOL.COM) or from your Milacron representative.

LIMITATION OF LIABILITY: Under no circumstances shall we or any affiliate of ours have any liability whatsoever for loss of use or for any indirect or consequential damages. Minor formulation changes or normal variations in the manufacture of this product may cause slight variances in the data presented on this sheet.

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