

# CT 118-B1

METAL WORKING FLUID

## ▷ PRODUCT DESCRIPTION

**CT 118-B1** is a concentrated synthetic forming fluid for ferrous and non-ferrous metals. It can be utilized for all medium to severe forming applications such as deep drawing, forming, roll forming, stamping, tube drawing, and bending of cold rolled steel, carbon steel, aluminum, copper and brass alloys. CT 118-B1 offers a balanced lubrication package containing both boundary and extreme pressure additives for enhanced forming performance. CT 118-B1 contains no chlorinated additives.

CT 118-B1 is also well suited for a broad range of machining and grinding operations on ferrous and nonferrous metals. Having the versatility to machine, grind, draw and stamp ferrous and nonferrous metals with one product maximizes your total metal working capabilities.

## ▷ FEATURED BENEFITS

- Water extend-able synthetic fluid
- Offers exceptional wetting and coverage properties on ferrous and non-ferrous surfaces
- Enhanced corrosion protection on all ferrous and non-ferrous alloys
- Easily removable with hot water or mild alkaline cleaners
- Good compatibility with a variety of types of process water chemistries
- Designed for both once-through and circulating systems
- Completely free of all chlorinated additives
- Formaldehyde free
- No chelants
- No petroleum oil/solvents
- No heavy metals

## APPLICATION



## COMPATIBLE METALS

Cold Rolled Steel  
 Hot Rolled Steel  
 Stainless Steel  
 Copper  
 Brass  
 Aluminum





## TYPICAL PROPERTIES

Fluid Type	Synthetic
Appearance	Amber liquid
Odor	Mild chemical
Specific Gravity, 60°F (15.6°C)	0.985
Weight, lb/gal., 60°F (15.6°C)	8.20
Boiling Point	212°F (100°C)
Flash Point	None, self-extinguishing
Freezing Point	32°F (0°C)
pH, concentrate	9.5
pH, 5% dilution	9.2

\*Product may separate upon freezing. Thaw completely at room temperature and mix thoroughly prior to use.

## PRODUCT APPLICATION / USAGE

CT 118-B1 may be applied to the work piece by any conventional method (manually, dip, spray, flood, roll coater, proportioning unit, etc.).

Operation	Recommended Concentration Range	Operation	Recommended Concentration Range
Milling, Drilling, Turning	5 – 10%	Light to Medium Forming	10 – 35%
Reaming, Broaching	7 – 15%	Light to Medium Stamping	7 – 15%
Form Milling, Tapping, Sawing	7 – 25%	Tube Drawing & Bending	10 – 30%
Grinding	3 – 10%	Severe Drawing & Forming	50% – Neat

## MIXING DATA

CT 118-B1 metalworking fluid can be used neat in severe drawing and forming applications, as well as, diluted with water in most other machining applications. When diluting the CT 118-B1 always add product concentrate to the water, NOT water to the product concentrate. Product concentration can easily be monitored by refractometer.

Concentration	50.0%	30.0%	15.0%	10.0%	7.0%	5.0%	3.0%
Refractometer Reading	27.0	16.2	8.1	5.4	3.8	2.7	1.7

## PRODUCT CODE

2302200000

## HEALTH AND SAFETY

For health and safety guidance, please refer to the Chemtool SDS (Safety Data Sheets).