



CoolPAK™ C2000 bd

Synthetic Metalworking Fluid – Blue dye

CoolPAK™ C2000 bd is a blue-dye synthetic coolant that rejects tramp oils, settles fines, provides cooling, and keeps machines clean. This versatile formula performs well on nearly all machining operations.

Application Guidelines

- Not recommended in machine tools that rely on the splash of the coolant to lubricate the mechanical portions of the machine tool, e.g. older screw machines, etc
- Not recommended on materials like magnesium or zirconium without special precautions
- Product may "wash out" dirt and residues when a machine is first charged; a thorough cleaning of older machines is required when installing this product the first time
- The minimum recommended concentration is 5% on cast iron and 4% on steel
- Concentrations above 7.5% provide excellent corrosion inhibition, tool life and sump life; however, the best concentration for your operation should be determined by on site experience
- For additional product application information including performance optimization, please contact your Master Fluid Solutions' Authorized Distributor at 2trim.us/distributors.php, your District Sales Manager, or call our Tech Line at 1-800-537-3365

Physical Properties Typical Data

Color (Concentrate)	Clear blue
Color (Working Solution)	Clear blue
Odor (Concentrate)	Mild amine
Form (Concentrate)	Liquid
Flash Point (Concentrate)	> 199°F (ASTM D93-08)
pH (Concentrate as Range)	10.2 - 10.6
pH (Typical Operating as Range)	9.0 - 9.8
Coolant Refractometer Factor	3.4
Titration Factor (CGF-1 Titration Kit)	0.6
Digital Titration Factor	0.0189
V.O.C. Content (EPA Method 24)	118 lb/g

CoolPAK C2000 bd

- Low carryoff
- Low foam and mist
- Compatible with cast iron, steels, copper alloys, and plastics
- Provides corrosion inhibition on all common ferrous and nonferrous alloys
- For grinding, drilling, tapping, and reaming
- Very good sump life and tramp oil rejection
- Low odor
- Runs clean

Health and Safety

See the most recent SDS at:
2trim.us/s/?i=1052-en-US-US



Packaging

5-gallon pail
SKU: COOLPAKC2000BD/5
UPC-12: 641238070955

54-gallon drum
SKU: COOLPAKC2000BD/54
UPC-12: 641238070382

270-gallon tote
SKU: COOLPAKC2000BD/NR270
UPC-12: 641238070375

Master Fluid Solutions™
—Cutting Edge Metalworking Solutions™



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Recommended Concentrations

Light duty	4.0% - 6.5%
Moderate duty	6.5% - 8.5%
Heavy duty	8.5% - 10.0%
Design Concentration Range	4.0% - 10.0%

Mixing Instructions

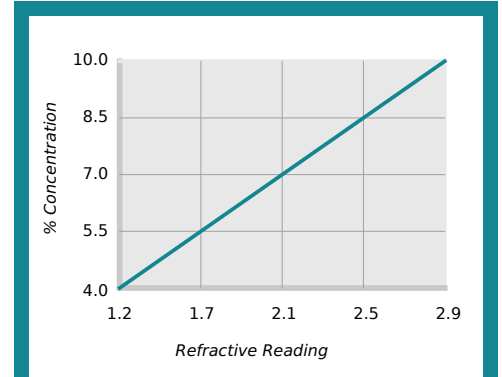
- Recommended usage concentration in water: 4.0% - 10.0%
- To help ensure the best possible working solution, add the required amount of concentrate to the required amount of water (never the reverse) and stir until uniformly mixed.
- Use mineral-free water to improve sump life and corrosion inhibition while reducing carryoff and concentrate usage.

Additional Information

- Use Master STAGES™ Whamex XT™ for a quick and thorough precleaning of your machine tool and coolant system.
- Before using on any metals or applications not specifically recommended, consult Master Fluid Solutions.
- This product should not be mixed with other metalworking fluids or metalworking fluid additives, except as recommended by Master Fluid Solutions, as this may reduce overall performance, result in adverse health effects, or damage the machine tool and parts. If contamination occurs, please contact Master Fluid Solutions for recommended action.

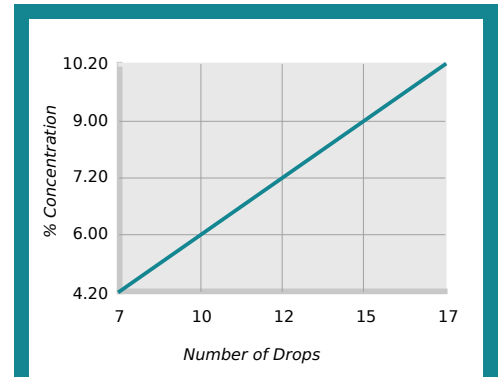
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Concentration by % Brix



$\% \text{ Concentration} = \text{Refractive Reading} \times \text{Refractive Factor}$
Coolant Refractometer Factor % Brix = 3.4

Concentration by Titration



$\% \text{ Concentration} = \text{No. of Drops} \times \text{Titration Factor}$
Titration Factor = 0.60

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