



CoolPAK™ C1278 bd

High-performance Synthetic Fluid - Blue Dye

CoolPAK™ C1278 bd is a high-performance, blue-dye synthetic fluid for working cast iron and mild steels. This technology provides excellent cooling and chip settling, good tramp oil rejection, and machine cleanliness, contributing to operational efficiency. The formulation is an ideal fluid for machining and grinding.

Application Guidelines

- Not recommended in machine tools that rely on coolant splash to lubricate the mechanical portions of the machine tool; e.g., older screw machines, etc
- Foam may increase if the temperature is below 80°F (27°C) at the point of agitation
- Not recommended on materials 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 for the first time
- The minimum recommended concentration is 5% on cast iron, 4% on steel, and 5% in glass grinding
- Concentrations above 7.5% provide the best corrosion inhibition, tool life, and sump life; however, on-site testing is usually the best way to set your concentration
- For additional product application information, including performance optimization, please contact your Master Fluid Solutions' Authorized Distributor at <https://www.2trim.us/distributors.php>, your District Sales Manager, or call our Tech Line at 1-800-537-3365.

Physical Properties Typical Data

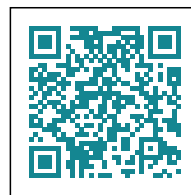
Color (Concentrate)	Blue
Color (Working Solution)	Light blue
Odor (Concentrate)	Mild
Form (Concentrate)	Liquid
Flash Point (Concentrate)	> 334°F (ASTM D93-08)
pH (Concentrate as Range)	8.8 - 9.5
pH (Typical Operating as Range)	8.7 - 9.2
Coolant Refractometer Factor	3.7
Titration Factor (CGF-1 Titration Kit)	0.56
Digital Titration Factor	0.0175
V.O.C. Content (ASTM E1868-10)	84 g/l

Choose CoolPAK C1278 bd:

- Compatible with cast iron, steels, plastics, and composites
- Excellent for glass, ceramic, and composite grinding
- Excellent corrosion inhibition on most common ferrous materials
- Low carryoff
- Low foam and mist
- Low odor
- Runs clean
- Exceptional sump life and very good tramp oil rejection

Health and Safety

See the most recent SDS at:
2trim.us/s/?i=4787-0-en-US-US



Packaging

5-gallon pail
SKU: CPC1278BD/5
UPC-12: 641238078388

54-gallon drum
SKU: CPC1278BD/54
UPC-12: 641238078371

270-gallon tote
SKU: CPC1278BD/NR270P
UPC-12: 641238078364





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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.

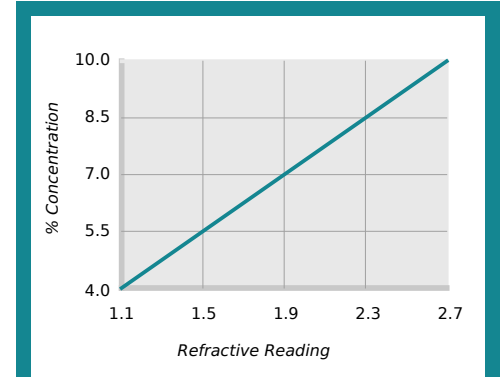
Additional Information

- 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.

The information herein is given in good faith and believed current as of the date of publication and should apply to the current formula version. Because conditions of use are beyond our control, no guarantee, representation, or warranty expressed or implied is made. Consult Master Fluid Solutions for further information. Contact your Master Fluid Solutions' District Sales Manager for the latest version of this document. Master STAGES™, CoolPAK™, and Whamex XT™ are trademarks of Master Chemical Corporation d/b/a Master Fluid Solutions.

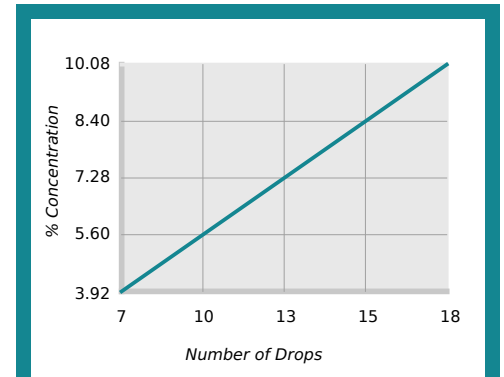
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Concentration by % Brix



$\% \text{ Concentration} = \text{Refractive Reading} \times \text{Refractive Factor}$
Coolant Refractometer Factor % Brix = 3.7

Concentration by Titration



$\% \text{ Concentration} = \text{No. of Drops} \times \text{Titration Factor}$
Titration Factor = 0.56

Master Fluid Solutions
501 West Boundary Street
Perrysburg, OH 43551-1200
USA

+1 419-874-7902
info@masterchemical.com
masterfluidsolutions.com/na/en-us/

