



# TRIM<sup>®</sup> MicroSol<sup>®</sup> 606

*Long-life Microemulsion*

## GENERAL DESCRIPTION

TRIM<sup>®</sup> MicroSol<sup>®</sup> 606 is a microemulsion semisynthetic coolant made specifically for machining aluminum, steel, and alloy steel. It provides excellent cooling and mechanical lubricity, along with the machine friendly characteristics you expect from a premium TRIM<sup>®</sup> coolant.

## ADVANTAGES

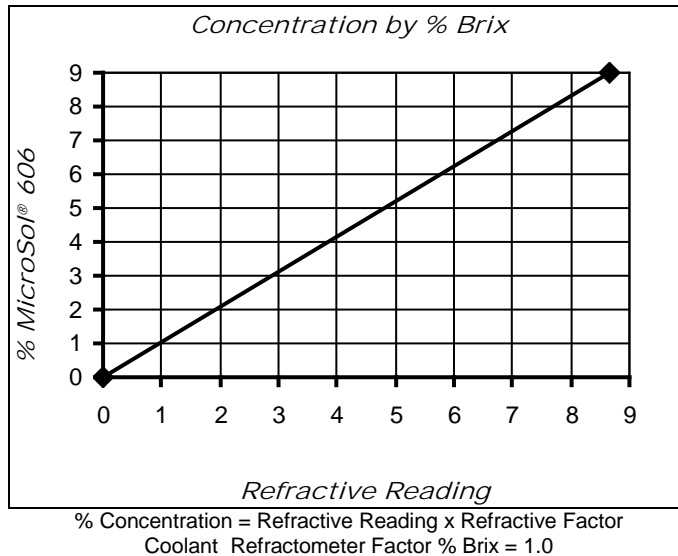
- MicroSol<sup>®</sup> 606 is a very versatile product that does an outstanding job in milling, drilling, and tapping cast or wrought aluminum, vertical or horizontal machining center work on alloy steel, surface and centerless grinding, and in general-purpose, job shop operations
- MicroSol<sup>®</sup> 606 contains very effective, extreme-pressure additives to control built-up edge
- It is compatible with all ferrous and nonferrous materials
- This product has a very fine emulsion, which helps to get the fluid to the point of cut
- MicroSol<sup>®</sup> 606 rejects tramp oil to help extend sump life and increase recycling options
- A soft fluid film prevents sticky ways, chucks, tool holders, and fixtures
- Coolant residue is easily removed with water, working solution, or Master STAGES<sup>™</sup> aqueous cleaners
- Easily recycled or disposed of with conventional techniques and equipment
- MicroSol<sup>®</sup> 606 is a very stable product with long sump life and minimal carryoff

## APPLICATION GUIDELINES

- MicroSol<sup>®</sup> 606 will run for long periods without the need for costly additives.
- MicroSol<sup>®</sup> 606 can run at lower concentrations for higher speed operations where heat removal is the key issue. Or, can be run at higher concentrations on soft, gummy materials and for lower speed operations where friction reduction and control of built-up edge are critical.
- Keeping MicroSol<sup>®</sup> 606 at 7% or higher concentration provides the best sump life.
- For additional product applications information including performance optimization, please contact your Master Chemical Authorized Distributor at [2trim.us/distributors.php](http://2trim.us/distributors.php), your District Sales Manager, the Tech Line at 1-800-537-3365, or visit our web site at [www.masterchemical.com](http://www.masterchemical.com).

## PHYSICAL PROPERTIES (TYPICAL DATA)

Color (Concentrate) .....	Greenish-brown	Flash Point.....	185°F (85°C) (ASTM D93-08)
Color (Working Solution) .....	Light green	pH (Typical Operating as a Range).....	8.8-9.2
Odor.....	Mild	Coolant Refractometer Factor % Brix.....	1.0
Form .....	Liquid	Titration Factor (CGF-1 Titration Kit).....	.N/A



## RECOMMENDED METALWORKING CONCENTRATIONS

Light-duty machining and grinding .....	3%-5%
Moderate-duty machining .....	5%-7%
Heavy-duty machining .....	7%-9%
Recommended concentration range .....	3%-9%

## MIXING INSTRUCTIONS

- Using DI or mineral-free water will improve sump life, reduce concentrate usage, reduce carryoff, and improve corrosion inhibition.
- Microemulsion products such as MicroSol® 606 work best if mixed with room temperature water. Add the coolant concentrate to the water; NEVER THE REVERSE.
- Using premixed coolant as makeup will improve performance and reduce coolant purchases. The makeup concentration you use should balance the water evaporation rate with the coolant carryout rate. (Adding makeup coolant at 30%-40% of the desired working concentration will generally maintain the proper concentration in the sump.)

## HEALTH AND SAFETY

See the most recent SDS at [2trim.us/s/?i=1294-en-US-US](https://2trim.us/s/?i=1294-en-US-US).



## NOTES

- Use Master STAGES™ Whamex™ for a quick and thorough pre-cleaning of your machine tool and coolant system.
- Before using on any metals or applications not specifically recommended, consult Master Chemical.
- This product should not be mixed with other metalworking fluids or metalworking fluid additives, except as recommended by Master Chemical Corporation, as this may reduce overall performance, result in adverse health effects, or damage the machine tool and parts. If contamination occurs, please contact Master Chemical Corporation for recommended action.
- MicroSol® 606 working solution is a light green emulsion, but is available with blue dye by ordering MicroSol® 606 bd.
- Packaging: North America – 1-gallon jug, 5-gallon pail, 54-gallon drum, and 270-gallon tote bin.
- Packaging: Europe/Asia – 20-litre pail, 204-litre drum, and 1000-litre IBC.

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