



TRIM[®] MicroSol[®] 690XT

High-lubricity, Low-foam, Premium Semisynthetic

GENERAL DESCRIPTION

TRIM[®] MicroSol[®] 690XT is a high-lubricity, semisynthetic, microemulsion coolant. The formula delivers extended sump life and better foam control versus previous generation semisynthetics. It provides excellent cooling and mechanical lubricity, along with the machine friendly characteristics you expect from a premium TRIM[®] coolant. It does very well in mixed metal situations and is compatible with a very wide range of materials including titanium, high nickel alloys, steels, copper, and aluminum alloys.

ADVANTAGES

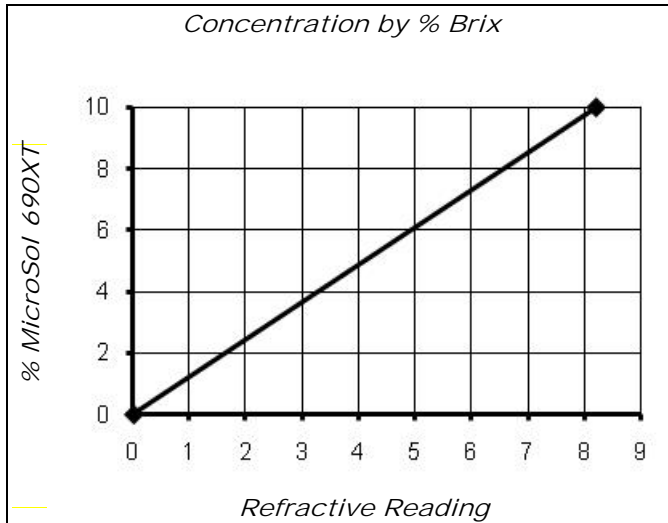
- Dramatically extends useful life without the need for tank-side biocides or fungicides
- Boron and halogen free
- Low foaming for todays demanding high-pressure, high-volume applications
- Compatible with a very wide range of materials including titanium, high nickel alloys, steels, copper, and aluminum alloys
- Excellent alternative to chlorinated soluble oils on high-silica aluminum alloys
- Contains no nitrites, triazines, phenols, chlorinated, or sulfurized EP additives
- Provides superior corrosion inhibition on all ferrous and nonferrous metals
- Keeps machines very clean while leaving a soft fluid film for ease of cleaning and reduced maintenance
- Requires no special disposal or recycling techniques

APPLICATION GUIDELINES

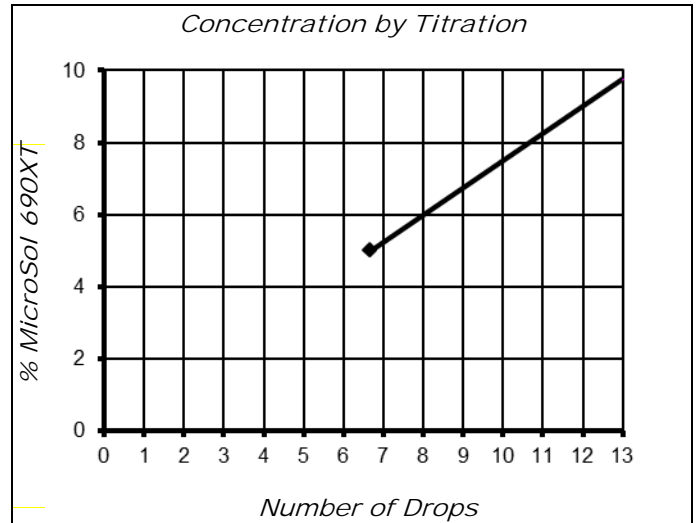
- MicroSol 690XT performs well where traditional soluble oils may not cool sufficiently.
- In mixed-metal situations, concentration control is critical to fight galvanic corrosion (7.5% plus).
- Running at or above 7.5% offers the best sump life and corrosion inhibition on cast iron chips.
- MicroSol 690XT is not recommended for use on very reactive metals such as magnesium.
- For additional product applications information including performance optimization, please contact your Master Chemical Authorized Distributor at 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.

PHYSICAL PROPERTIES (TYPICAL DATA)

Color (Concentrate)	Amber	Flash Point	>220°F (104°C) (ASTM D93-08)
Color (Working Solution)	White Microemulsion	pH (Typical Operating as a Range)	8.8-9.6
Odor	Mild Amine	Coolant Refractometer Factor % Brix	1.2
Form	Liquid	Titration Factor (CGF-1 Titration Kit)0.750



% Concentration = Refractive Reading x Refractive Factor
Coolant Refractometer Factor % Brix = 1.2



% Concentration = No. of Drops x Titration Factor
Titration Factor = 0.750

RECOMMENDED METALWORKING CONCENTRATIONS

- Light-duty machining and grinding.....5%-7%
- Moderate-duty machining.....7%-10%
- Design concentration range.....5%-10%

MIXING INSTRUCTIONS

- Use premixed coolant as makeup to improve coolant performance and reduce coolant purchases. The makeup you select should balance the water evaporation rate with the coolant carryout rate. Adding makeup coolant at one-third to one-half of the desired working concentration will generally maintain the proper sump concentration.
- Use mineral-free water to improve sump life and corrosion inhibition while reducing carryoff and concentrate usage.
- Microemulsion products, like MicroSol 690XT, work best if they are mixed by adding the coolant concentrate to the water (never the reverse) to help insure that the best possible microemulsion is formed.

HEALTH AND SAFETY

See the most recent SDS at 2trim.us/s/?i=1284-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 690XT working solution is a white microemulsion and is not available with dye.
- 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 1,000-litre IBC.

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URL: 2trim.us/di/?i=10247

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