



TRIM[®] SC520

General-purpose Semisynthetic

GENERAL DESCRIPTION

TRIM[®] SC520 is a low-odor, value-priced semisynthetic. SC520 is a general-purpose, cutting and grinding fluid concentrate for the multi-material, multi-operational shop. SC520 uses a proven EP-additive package to control built-up edge, improve tool life, and has the wetting and cooling characteristics necessary for superior machining results on high-speed milling and turning operations. It also controls chip welding on soft, gummy materials like aluminum.

ADVANTAGES

- Good sump life in “stand-alone” machines
- Low odor and mist
- Effective in most grinding, sawing, drilling, and CNC turning and milling operations by varying concentrations
- Provides sufficient lubricity to do down-the-hole operations in aluminum, cast iron, and most steels, including many stainless steels
- Compatible with a very wide range of materials including cast iron, steels, copper, and aluminum alloys as well as most plastics and composites
- Low-to-moderate foam with normal “flood” coolant application
- Rejects tramp oils rapidly for easy recycling with good sump life
- Easily recycled or disposed of using conventional techniques and equipment

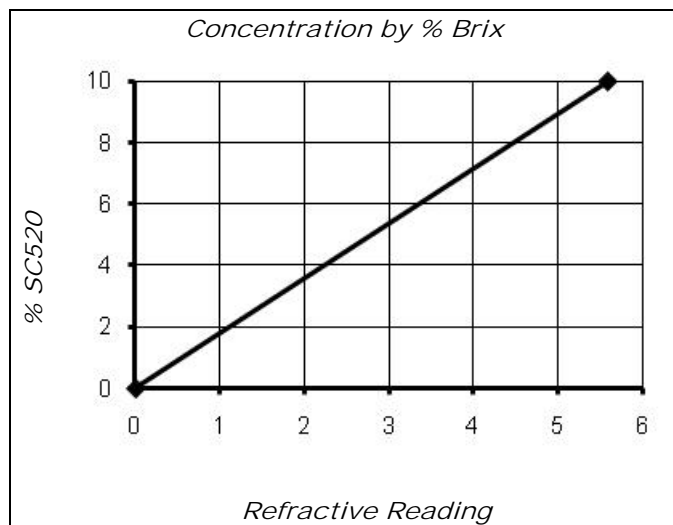
APPLICATION GUIDELINES

- SC520 is a superior product for surface and cylindrical grinding as well as through feed centerless grinding.
- High-torque operations or operations on soft material often benefit from higher concentrations.
- Concentrations in excess of 7% typically offer the best sump life and tool life. However, the optimum concentration for your operations is best determined by on-site testing.
- The minimum recommended concentration is 5% on cast iron and 4% on steel.
- Not recommended on materials that chemically react with water (i.e., magnesium and zirconium).
- 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.

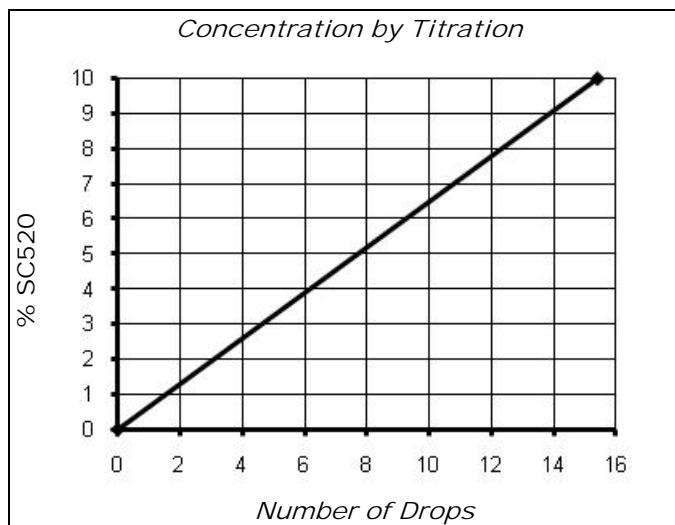
PHYSICAL PROPERTIES (TYPICAL DATA)

Color (concentrate)..... Blue
Color (working solution)..... Light Blue
Odor..... Mild amine
Form Liquid

Flash Point >200°F (93°C) (ASTM D-93)
pH (Typical operating as a range) 9.6-10.0
Coolant Refractometer Factor % Brix 1.8
Titration Factor (CGF-1 Titration Kit) 0.648



% Concentration = Refractive Reading x Refractive Factor
Coolant Refractometer Factor % Brix = 1.8



% Concentration = No. of Drops x Titration Factor
Titration Factor = 0.648

RECOMMENDED METALWORKING CONCENTRATIONS

- Light-duty machining and grinding 4%-6%
- Moderate- to heavy-duty machining and grinding..... 7%-10%
- Design concentration range 4%-10%

MIXING INSTRUCTIONS

- Using premixed coolant as makeup will substantially improve coolant performance and reduce coolant concentrate purchases. The specific makeup concentration selected for your situation should balance the water evaporation rate with the coolant carryout rate. Adding makeup coolant at 10%-25% of the desired working concentration will generally maintain the proper concentration in the sump.
- The use of DI or mineral-free water to mix this product will improve sump life, reduce concentrate usage, reduce carryoff, improve corrosion inhibition, etc.
- Percent concentration may be calculated by multiplying the refractometer factor by the refractometer reading or by multiplying the number of drops of acid by the titration factor.

HEALTH & SAFETY

See the most recent SDS at 2trim.us/s/?i=1028-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.
- Normally a light blue product
- Available in: 5-gallon pail, 54-gallon drum, 270-gallon recyclable bin, and tank wagon lot.

The information herein is given in good faith and believed current as of the date of this Data & Information sheet 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 Chemical Corporation for further information. For the most recent version of this document, please go to this

URL: 2trim.us/di/?i=234

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