



TRIM[®] SC536

Low-oil Semisynthetic

GENERAL DESCRIPTION

TRIM[®] SC536 is a low oil, semisynthetic coolant that delivers significant performance improvements over previous generations of metalworking fluids. SC536 is a proprietary formula of specially synthesized oil and synthetic technologies blended to deliver unbeatable performance in a variety of machining and grinding operations. This innovative blend keeps machines clean and provides the longest sump life available.

ADVANTAGES

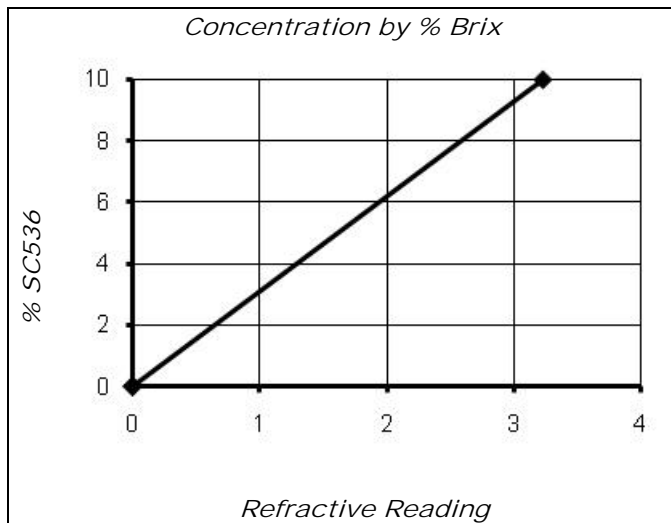
- Compatible with a very wide range of materials including cast iron, steels, copper alloys, plastics, and composites
- Very low foam and mist
- Provides excellent corrosion inhibition on all common ferrous alloys
- Keeps your machines clean while leaving a soft fluid film that protects the bare metal parts of your machine tools - this film is easily washed off with coolant working solution for easy machine cleaning
- Excellent extreme pressure (EP) lubricity to do many form grinding, drilling, tapping, and reaming operations without the need for chlorine or sulfur-based EP additives
- Extremely low carryoff for very low total operating costs
- Exceptional sump life and very good tramp oil rejection
- Very low initial odor level which usually disappears after one-to-two days
- Minimizes the buildup of sticky residues

APPLICATION GUIDELINES

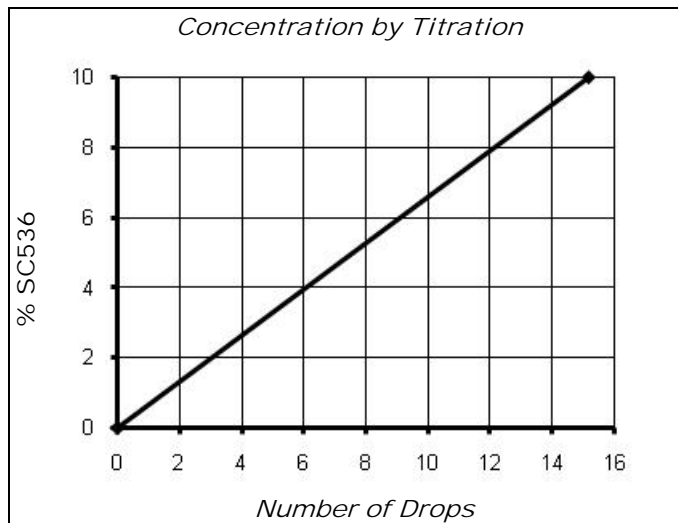
- The minimum recommended concentration is 5% on cast iron and 4% on steel. Concentrations in excess of 7.5% typically provide the best corrosion inhibition, tool life, and sump life; however, the optimum concentration for your operation can best be determined by on-site testing.
- SC536 is not recommended on magnesium or zirconium without special precautions. SC536 is a superior cleaning agent so it may “wash out” dirt and residues when a machine is first charged.
- 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).....	Colorless to pale yellow	Flash Point	Nonflammable (COC)
Color (working solution)....	Colorless to pale yellow	pH (Typical Operating as a range).....	9.4-9.8
Odor.....	Mild chemical	Coolant Refractometer Factor % Brix	3.1
Form	Liquid	Titration Factor (CGF-1 Titration Kit)	0.660



% Concentration = Refractive Reading x Refractive Factor
Coolant Refractometer Factor % Brix = 3.1



% Concentration = No. of Drops x Titration Factor
Titration Factor = 0.660

RECOMMENDED METALWORKING CONCENTRATIONS

- Light-duty machining and grinding..... 4%-6%
- Moderate-duty machining and grinding 5%-7%
- Heavy-duty machining and grinding 7%-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 5%-15% 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.

HEALTH AND SAFETY

See the most recent SDS at 2trim.us/s/?i=1091-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.
- Packaging: North America- 1-gallon pail, 5-gallon pail, 54-gallon drum, 270-gallon nonreturnable bin, and tank wagon lot; Europe/Asia – 20-litre pail and 204-litre drum.

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URL: 2trim.us/di/?i=154

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