



TRIM SOL[®] sf

General-purpose Emulsion – Siloxane Free



GENERAL DESCRIPTION

TRIM SOL[®] sf is a siloxane free soluble oil (emulsion) coolant concentrate which is the world standard general-purpose, multi-metal coolant for general machining of ferrous and nonferrous materials. It has the lubricity and “guts” necessary to do heavy-duty machining center work and still provide the wetting and cooling necessary for high-speed turning and grinding operations.

ADVANTAGES

- Siloxane free
- Proven to be highly effective in controlling built-up edge (BUE)
- Has a very wide application range and is often used in such diverse operations as production surface and centerless grinding, heavy-duty broaching, gear hobbing, and replacing straight oil on some types of screw machines
- Leaves a fluid, nongumming film to prevent sticky ways, chucks, tool holders, and fixtures
- Coolant residue is easily removed with either water, working solution, or aqueous cleaners
- Easy recycling or disposal with conventional techniques and equipment

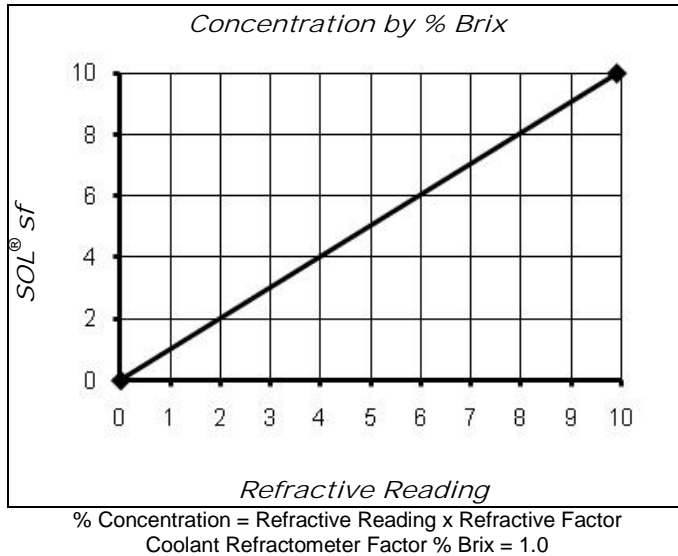
APPLICATION GUIDELINES

- Runs effectively for long periods without the need for costly additives.
- Compatible with all ferrous and nonferrous materials, but not normally intended for use on long runs of gray cast iron or grades 40 or 60 nodular iron.
- Can run at lower concentrations for higher speed operations where heat removal is the key issue.
- Higher concentrations are recommended on soft, gummy materials and for lower speed operations where friction reduction and control of the BUE are critical.
- Concentrations of 7% and higher provide the best sump life with this product.
- 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 green
 Color (Working Solution) Milky white
 Odor Mild, sweet
 Form Liquid

Flash Point > 200°F (93°C) (ASTM D93-08)
 Ph (Typical Operating as a Range)..... 8.0-9.0
 Coolant Refractometer Factor % Brix 1.0
 Titration Factor (CGF-1Titration Kit).....N/A



RECOMMENDED CONCENTRATIONS

Light-duty machining and grinding.....	3%-5%
Moderate-duty machining	5%-7%
Heavy-duty machining	7%-10%
Very heavy-duty machining	10%-20%
Design concentration range.....	3%-20%

MIXING INSTRUCTIONS

- The use of pure, mineral-free (never softened) water to mix this product will improve sump life, reduce concentrate usage, and reduce carryoff.
- Chemical emulsions like SOL sf work best if they are mixed with room temperature water and by adding the coolant concentrate to the water; NEVER THE REVERSE.
- 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 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=1056-en-US-US.



NOTES

- Before using this product on any metals and applications not specifically recommended, consult Master Chemical Corporation.
- 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 the overall performance of the product as well as result in adverse health effects and damage to the machine tool parts. If inadvertent contamination should occur, please contact Master Chemical Corporation for recommended action.
- 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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