



TRIM[®] SC125

Low-oil Semisynthetic

GENERAL DESCRIPTION

TRIM[®] SC125 is a low-oil, semisynthetic coolant concentrate. It is effective in general-duty machining and grinding of most materials. It is an exceptionally clean fluid and provides superior cooling, lubricity, and corrosion inhibition for grinding cast iron and mild steels. This product does particularly well in machining cast iron and in centerless or cylindrical grinding applications.

ADVANTAGES

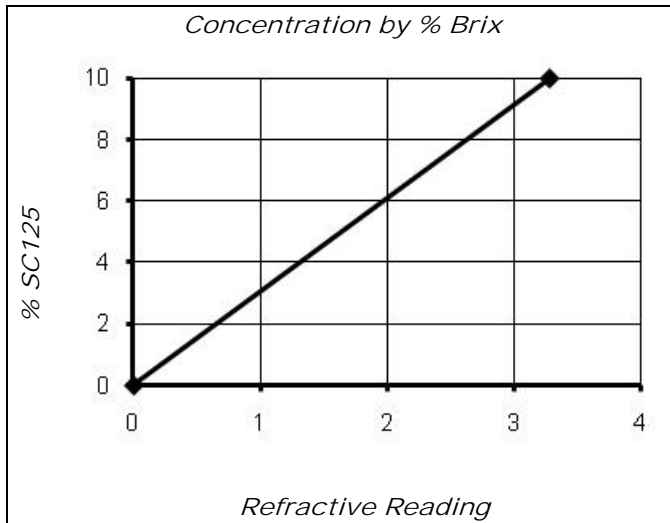
- Compatible with a very wide range of materials including ferrous, nonferrous, and nonmetallic material
- Will run for long periods of time without adds while providing superior sump life and corrosion inhibition
- Prevents chip “clinkering” and “hot” chip hoppers when machining cast iron
- Contains no chlorine, sulfur, or phosphorus-based EP (extreme pressure) additives
- Contains no nitrites, phenols, or formaldehyde-releasing compounds
- Has very low carryoff for low, long-term operating costs
- Easily recycled to reduce coolant purchase and disposal costs

APPLICATION GUIDELINES

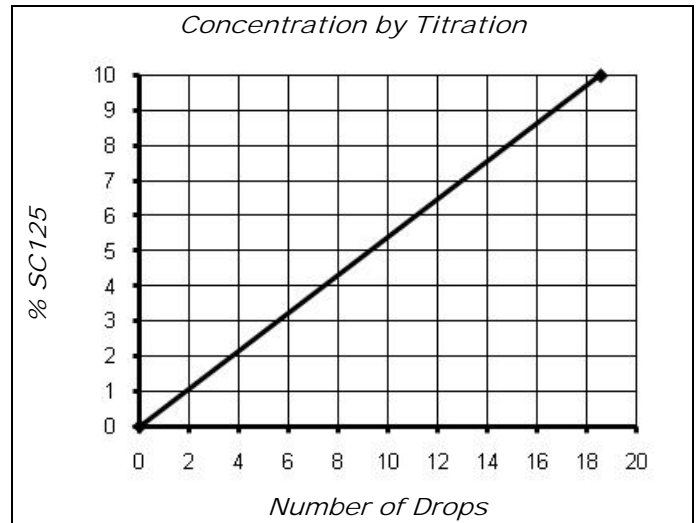
- The working solution of SC125 is compatible with most other semisynthetic and synthetic products for a “running change”. Please consult Master Chemical’s Tech-line for advice on specific situations.
- The minimum recommended concentration is 5% on cast iron and 4% on steel.
- Running at or above 7.5% offers better corrosion inhibition, tool life, and sump life. However, the best concentration for your operation should be determined by on-site testing.
- SC125 is not recommended on reactive materials such as magnesium or 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).....	Yellow/orange	Flash Point	>210°F (99°C) (ASTMD92-90)
Color (working solution).....	Light yellow	pH (Typical Operating as a range)	9.0-9.5
Odor.....	Mild	Coolant Refractometer Factor % Brix	3.1
Form	Liquid	Titration Factor (CGF-1 Titration Kit).....	0.540



$\% \text{ Concentration} = \text{Refractive Reading} \times \text{Refractive Factor}$
Coolant Refractometer Factor % Brix = 3.1



$\% \text{ Concentration} = \text{No. of Drops} \times \text{Titration Factor}$
Titration Factor = 0.540

RECOMMENDED METALWORKING CONCENTRATIONS

Light-to-moderate duty machining and grinding 4%-7%

Heavy-duty machining and grinding 7%-10%

MIXING INSTRUCTIONS

- Using premixed coolant as makeup will improve coolant performance and reduce coolant purchases. The makeup concentration that you select should balance the water evaporation rate with the coolant carryout rate. Adding makeup coolant at 20%-30% of the desired working concentration will generally maintain the proper concentration in the sump.
- Using DI or mineral-free water will improve sump life, reduce concentrate usage, reduce carryoff, and improve corrosion inhibition.

HEALTH AND SAFETY

See the most recent MSDS at 2trim.us/ms/?i=77.



NOTES

- Use Master STAGES™ Whamex™ for a quick and thorough pre-cleaning of your machine tool and coolant system.
- Before using on any metals and 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 jug, 5-gallon pail, 54-gallon drum, 270-gallon tote bin.
- Packaging: Europe/Asia – 20-litre pail, 204-litre drum, and 1000-litre IBC.

Because conditions of use are beyond our control, no warranty, guarantee, or representation is made or intended in connection with the use of this product.

TRIM® is a registered trademark of Master Chemical Corporation
master STAGES™ and Whamex™ are trademarks of Master Chemical Corporation

© 2009-2013 Master Chemical Corporation • Revised May 9, 2013