



TRIM[®] SC230 nd

Oil-rejecting Semisynthetic - No Dye

GENERAL DESCRIPTION

TRIM[®] SC230 nd is a low oil, semisynthetic fluid which meets the needs of the modern and demanding job shops. SC230 nd makes use of the latest in synthetic coolant formulations and a specially synthesized oil to produce a versatile product ready to meet the demands of the 21st century. This combination of a proprietary chemical formulation and new synthetic oil technology results in a semisynthetic product that will not foam, rejects tramp oil, has great sump life, and is kind to both machines and operators. This product will perform well in centerless and cylindrical form grinding as well as on high-speed, single point turning, and down-the-hole work on vertical and horizontal machining centers.

ADVANTAGES

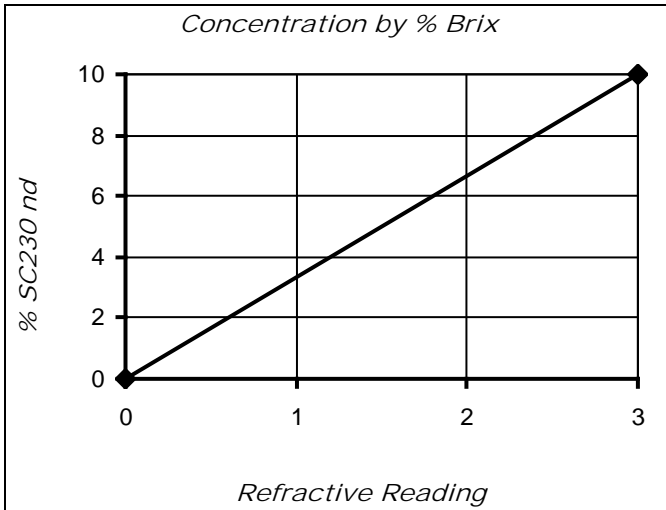
- Compatible with a very wide range of materials including cast iron, steels, and copper alloys, as well as plastics and composites
- Has the lubricity to do form grinding, drilling, tapping, and reaming operations without the use of chlorine or sulfur-based EP additives
- Will not foam, even at very high pressures and flow rates
- Is a water-clear fluid to allow easy viewing of parts during grinding and machining
- Has good flushing action so that chips and fines are readily flushed into the machine's chip removal system
- Very low carryoff to reduce the need for makeup coolant for low, long term operating costs
- Easily recycled to reduce coolant purchase and disposal costs

APPLICATION GUIDELINES

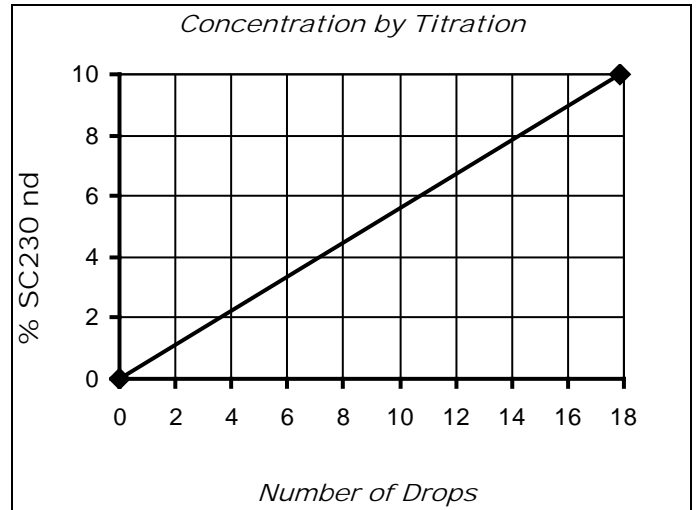
- SC230 nd is not recommended in machine tools that rely on the splash of the coolant to lubricate the mechanical portions of the machine tool, e.g. older screw machines, etc.
- This product is a superior cleaning agent so it may "wash out" dirt and residues when a machine is first charged.
- The minimum recommended concentration is 5% on cast iron and 4% on steel.
- Concentrations above 7.5% seem to be better for corrosion inhibition, tool life, and sump life. However, the best concentration for your operation can be determined by on-site testing.
- 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	>212°F (100°C) (ASTM D92-12B)
Color (Working Solution)	Colorless	pH (Typical Operating as a Range)	8.7-9.2
Odor	Mild, Sweet	Coolant Refractometer Factor % Brix	3.3
Form	Liquid	Titration Factor (CGF-1 Titration Kit)	0.561



$\% \text{ Concentration} = \text{Refractive Reading} \times \text{Refractive Factor}$
Coolant Refractometer Factor % Brix = 3.3



$\% \text{ Concentration} = \text{No. of Drops} \times \text{Titration Factor}$
Titration Factor = 0.561

RECOMMENDED METALWORKING CONCENTRATIONS

Moderate-duty machining and grinding5%-7%
Heavy-duty machining and grinding7%-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 & SAFETY

See the most recent SDS 2trim.us/s/?i=1045-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 and 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.

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=10245

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