



TRIM SOL[®] LC sf

General-purpose Emulsion-Nonchlorinated, Siloxane Free

GENERAL DESCRIPTION

TRIM SOL[®] LC sf is a siloxane-free chemical emulsion or soluble oil coolant concentrate designed for light and moderate machining and grinding. This product is designed for a wide variety of metal removal operations on most ferrous metals and many nonferrous metals, such as brass, copper, and aluminum. This product is particularly effective in situations where reactive alloying agents like lead (Pb) are present.

ADVANTAGES

- For wide range job, applications from tough assignments such as gear hobbing and broaching to lighter duties like turning, TRIM SOL[®] LC sf has proven equally effective
- Does not contain any chlorinated EP additives
- Easily adaptable to nonferrous and ferrous metals
- Stability - TRIM SOL[®] LC sf forms an extremely tight emulsion of fine particle size and can be run for extended periods without pumpouts
- Machine stays clean with TRIM SOL[®] LC sf's built-in cleaning action - metal chips and dirt will not build up
- Fluid residue prohibits sticky ways and slides which is a very important consideration in the operation of automatic and numerically controlled machines
- Coolant residue is easily removed with either water, working solution, or aqueous cleaners
- Easy recycling or disposal with conventional techniques and equipment

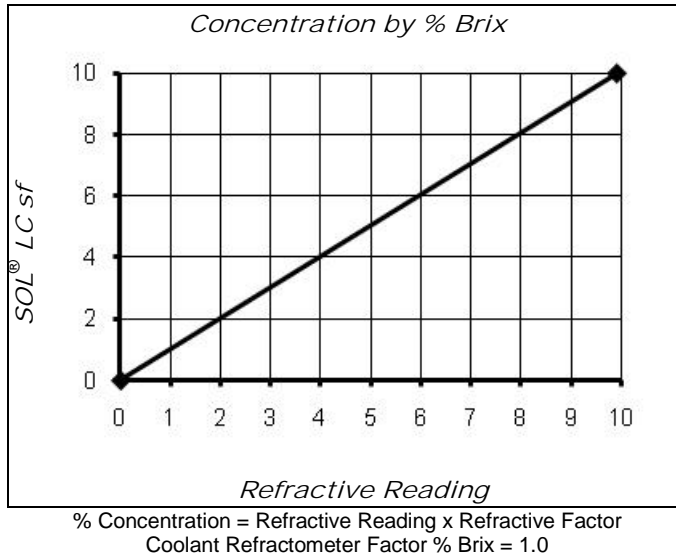
APPLICATION GUIDELINES

- 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)Dark green
 Color (Working solution)..... Blue
 OdorMild, sweet
 Form Liquid

Flash Point210°F (98°C) (ASTM D-92-90)
 pH (Typical Operating as a range)..... 8.0-9.0
 Coolant Refractometer Factor % Brix 1.0
 Titration Factor (CGF-1 Titration 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 LC 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=1139-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 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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URL: 2trim.us/di/?i=10215

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