



# TRIM<sup>®</sup> SC410

## *Chlorine-free Semisynthetic Coolant*

### GENERAL DESCRIPTION

TRIM<sup>®</sup> SC410 is a chlorine-free, semisynthetic coolant using vegetable-derived and ester lubricants. It is very clean running in moderate-duty machining and grinding of both ferrous and nonferrous materials. In addition to its broad range of machining qualities, it has been specially optimized for machining "gray iron" castings and for surface and cylindrical grinding of ferrous materials.

### ADVANTAGES

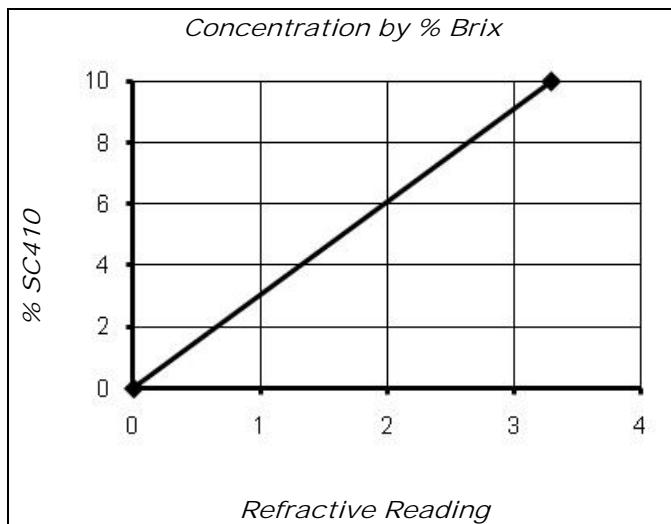
- Based on our exclusive ester lubricant technology, contains no mineral (petroleum) oil
- Low foaming in most operations
- Compatible with a very wide range of materials including ferrous, nonferrous, and nonmetallic material
- Will provide superior sump life and corrosion inhibition for long periods of time without adds
- Prevents chip "clinkering" and "hot" chip hoppers when machining cast iron
- Will keep the machine and work environment clean even when machining or grinding gray iron
- Contains no chlorine or sulfur-based additives
- Contains no nitrites, sulfonates, Alkylphenol Ethoxylates, or phenols and is not SARA 313 reportable
- Very low carryoff and long sump life, delivering low operating costs
- Hard water tolerant up to 30 grains

### APPLICATION GUIDELINES

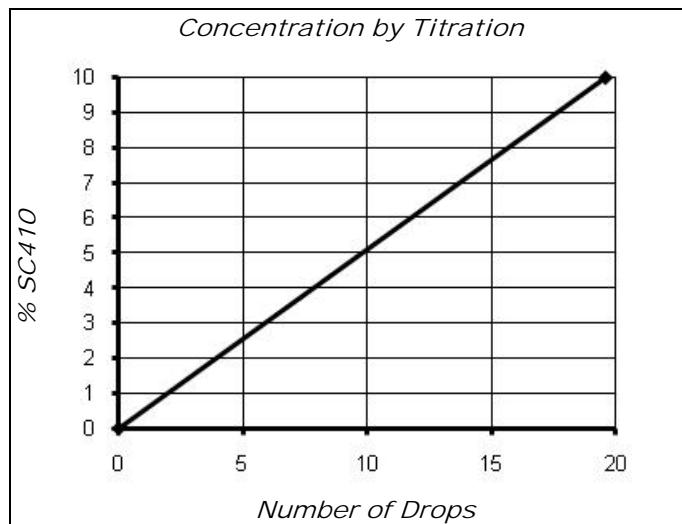
- The minimum recommended concentration is 5% on cast iron and 4% on steel. Running at or above 5% offers better corrosion inhibition, tool life, and sump life. However, the best concentration for your operation should be determined by on-site testing.
- SC410 is not recommended on magnesium or zirconium without special precautions.
- For additional product applications information including performance optimization, please contact your Master Chemical Authorized Distributor at [2trim.us/distributors.php](http://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](http://www.masterchemical.com).

### PHYSICAL PROPERTIES (TYPICAL DATA)

Color (concentrate) .....	Yellow/Orange	Flash Point .....	Nonflammable (COC)
Color (working solution) .....	Light Yellow	pH (Typical Operating as a range).....	8.8-9.2
Odor .....	Mild	Coolant Refractometer Factor % Brix .....	3.0
Form.....	Liquid	Titration Factor (CGF-1 Titration Kit) .....	0.510



% Concentration = Refractive Reading x Refractive Factor  
Coolant Refractometer Factor % Brix = 3.0



% Concentration = No. of Drops x Titration Factor  
Titration Factor = 0.510

## RECOMMENDED METALWORKING CONCENTRATIONS

Moderate-duty machining and grinding ..... 4%-10%

## MIXING INSTRUCTIONS

- Using DI or mineral-free water will improve sump life, reduce concentrate usage, reduce carryoff, and improve corrosion inhibition.
- Using premixed coolant as makeup will improve performance and reduce coolant purchases. The makeup concentration you use 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.

## HEALTH & SAFETY

See the most recent SDS at [2trim.us/s/?i=1173-en-US-US](http://2trim.us/s/?i=1173-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.
- SC410 working solution is a light yellow.
- Packaging: North America – 5-gallon pail, 54-gallon drum, 270-gallon recyclable bin, and tank wagon lot; Europe/Asia – 20-litre pail, 204-litre drum, and 1000-litre IBC.

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