



TRIM[®] MicroSol[®] 585XT

Extended-life, Nonchlorinated Semisynthetic

GENERAL DESCRIPTION

TRIM[®] MicroSol[®] 585XT is a high-lubricity, semisynthetic, microemulsion coolant. The formula delivers extended sump life versus previous generation semisynthetics. It provides excellent cooling and mechanical lubricity, along with the machine friendly characteristics you expect from a premium TRIM[®] coolant. While it is particularly well suited for machining and grinding gray iron, it does very well in mixed metal situations. MicroSol 585XT has proven to be an exceptional machining fluid for titanium alloys.

ADVANTAGES

- Dramatically extends useful life without the need for tank-side biocides or fungicides
- Compatible with a very wide range of material including cast iron, steels, copper, titanium, and aluminum alloys, and many plastics and composites
- Optimized combination of cooling and lubricity for titanium machining applications
- Provides superior corrosion inhibition on cast iron and eliminates "hot chip" and clinkering problems
- Excellent alternative to chlorinated soluble oils on high-silica aluminum alloys
- Contains no nitrites, triazines, phenols, chlorinated or sulfurized EP additives
- Provides superior corrosion inhibition on all ferrous and nonferrous metals
- Keeps machines very clean while leaving a soft fluid film for ease of cleaning and reduced maintenance
- Requires no special disposal or recycling techniques

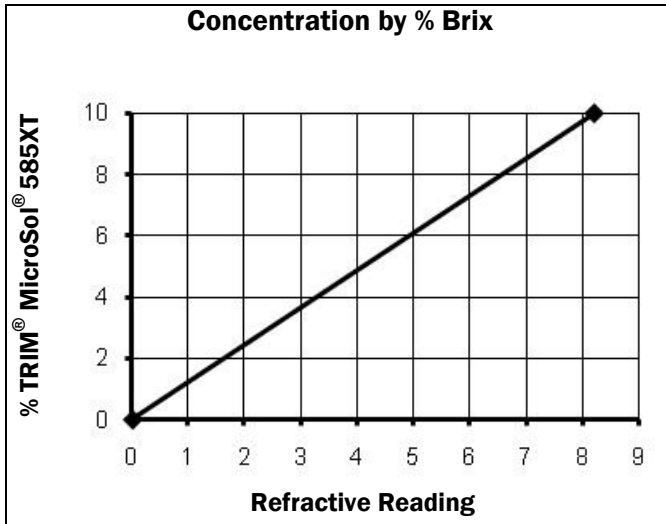
APPLICATION GUIDELINES

- MicroSol 585XT performs well where traditional soluble oils may not cool sufficiently.
- In mixed-metal situations, concentration control is critical to fight galvanic corrosion (7.5% plus).
- Running at or above 7.5% offers the best sump life and corrosion inhibition on cast iron chips.
- MicroSol 585XT is not recommended for use on very reactive metals such as magnesium.
- Your Master Chemical Authorized Distributor or District Sales Manager will be happy to assist you in optimizing the performance of this product.
- For additional applications information, please contact your Master Chemical Authorized Distributor, District Sales Manager, the Tech Line at 1-800-537-3365, or visit our web site at www.masterchemical.com.

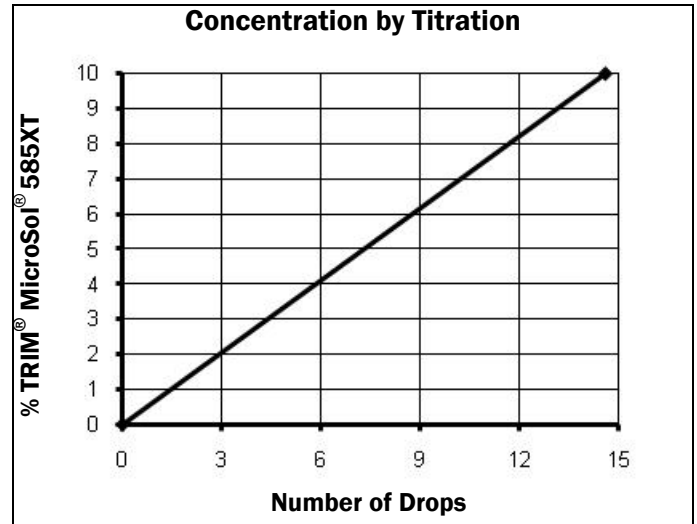
PHYSICAL PROPERTIES (TYPICAL DATA)

Form	Liquid	Flash Point	Nonflammable (PMCC)
Color (concentrate).....	Amber	Typical Operating pH (as a range).....	9.3-9.6
Odor.....	Mild	Titration Factor (CGF-1 Titration Kit)0685
Coolant Refractometer Factor % Brix	1.2	pH of Concentrate (as a range)	9.6-10.0





% Concentration = Refractive Reading x Refractive Factor
Coolant Refractometer Factor % Brix = 1.2



% Concentration = No. of Drops x Titration Factor
Titration Factor = 0.685

RECOMMENDED METALWORKING CONCENTRATIONS

Light-duty machining and grinding.....5%-7%
Moderate-duty machining.....7%-10%
Design concentration range.....4%-10%

MIXING INSTRUCTIONS

- Using premixed coolant as makeup will improve coolant performance and reduce coolant purchases. The makeup you select should balance the water evaporation rate with the coolant carryout rate. Adding makeup coolant at one-third to one-half 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.
- Microemulsion products, like MicroSol 585XT, work best if they are mixed by adding the coolant concentrate to the water (never the reverse) to help insure that the best possible microemulsion is formed.

HEALTH AND SAFETY

See the most recent MSDS, which is available directly from Master Chemical Corporation, your Master Chemical Authorized Distributor, or may be printed from our web site at www.masterchemical.com.

NOTES

- Use Whamex™ for a quick and thorough pre-cleaning of your machine tool and coolant system prior to charge-up.
- Before using this product on any metals and applications not specifically recommended, consult Master Chemical Corporation.
- This product is designed to be added directly on top of MicroSol® 585 but 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.
- MicroSol® 585XT working solution is a white microemulsion and is not available with dye.
- Packaging: North America – 5-gallon pail, 54-gallon drum, and 270-gallon nonreturnable bin.
- Europe/Asia – 20-litre pail, 204-litre drum, and 1000-litre IBC.