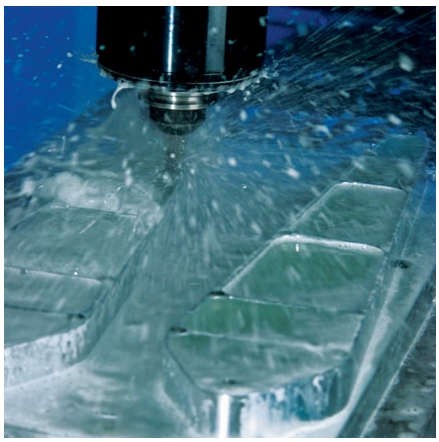
TRIM™ SC538

High-performance Semisynthetic Fluid

TRIM SC538 a high-performance semisynthetic coolant. Provides superior aluminum machinability, boundary lubrication, and produces a very high quality surface finish. Can also be utilized for ferrous and non-ferrous metal materials, stainless steel, and aerospace alloy materials. SC538 has good lubricity and friction reducing qualities in high-speed cutting and grinding applications.

Semisynthetics



Cutting edge solutions:

TRIM® semisynthetics offer the cooling and lubricity of a synthetic without the higher oil content of an emulsion. Designed to operate at higher SFPM, semisynthetics perform well on many operations including face milling, cut-off turning, grinding, tapping, and drilling — depending on the specific product.

Semisynthetics are compatible with aluminum alloys, alloy steels, tool steels, cast irons, copper alloys, as well as plastics and composites. With less carryoff, semisynthetics use less material — it all adds up to lower costs.

Choose SC538:

- Provides superior aluminum machinability
- Very high quality surface finish
- Has exceptional sump life and very low makeup for extremely low total operating cost
- Keeps machines very clean while leaving a soft fluid film for ease of cleaning and reduced maintenance
- Low odor and mist makes for an operator friendly product
- Easy recycling and disposal with conventional techniques and equipment

SC538 especially for:

Applications — drilling, grinding, milling, and turning

Materials — aluminum alloys, ferrous metals, nonferrous metals, and stainless steels

Industries — automotive, compressor, diecast, general fabrication, and job shop

SC538 is free of — boron, chlorine, and sulfur

Master Fluid SOLUTIONS™

TRIM™ SC538

High-performance Semisynthetic Fluid

Application Guidelines

- For high speed machining and high heat situations, use a lower concentration
- Running at or above 7% offers the best sump life and corrosion inhibition
- For additional product application information, including performance optimization, please contact your Master Fluid Solutions' Authorized Distributor at https://www.masterfluids.com/ap/en-ap/distributors/index.php, your District Sales Manager, or email us at apac-info@masterfluids.com.

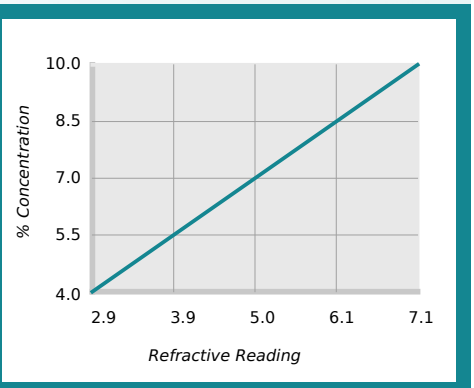
Physical Properties Typical Data

Color (Concentrate)	Yellow
Odor (Concentrate)	Mild, pleasant
Form (Concentrate)	Liquid
Flash Point (Concentrate) (ASTM D92-90)	> 100°C
pH (Typical Operating as Range)	9.4 - 10.4
Coolant Refractometer Factor	1.4

Recommended Metalworking Concentrations

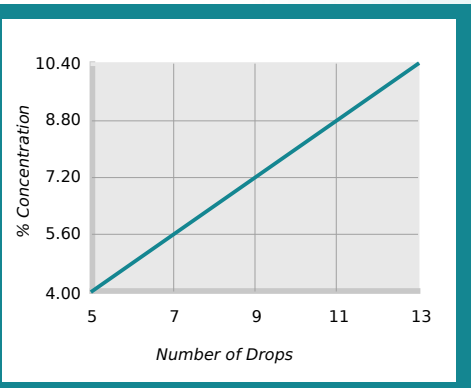
Light Duty	4.0% - 6.5%
Moderate Duty	6.5% - 8.5%
Heavy Duty	8.5% - 10.0%
Design Concentration Range	4.0% - 10.0%

Concentration by % Brix



% Concentration = Refractive Reading x Refractive Factor
Coolant Refractometer Factor % Brix = 1.4

Concentration by Titration



% Concentration = No. of Drops x Titration Factor
Titration Factor = 0.80

Health and Safety

Request SDS

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Mixing Instructions

- Recommended usage concentration in water: 4.0% - 10.0%.
- To help ensure the best possible working solution, add the required amount of concentrate to the required amount of water (never the reverse) and stir until uniformly mixed.
- Use premixed coolant as makeup to improve coolant performance and reduce coolant purchases. The makeup you select should balance the water evaporation rate with the coolant carryout rate. Use our Coolant Makeup Calculator to find the best ratio for your machine: apps.masterfluids.com/makeup/.
- Use mineral-free water to improve sump life and corrosion inhibition while reducing carryoff and concentrate usage.

Ordering Information

20-liter pail

204-liter drum

Additional Information

- Use Master STAGES™ Whamex XT™ for a quick and thorough precleaning of your machine tool and coolant system.
- Consult Master Fluid Solutions before using on any metals or applications not specifically recommended.
- This product should not be mixed with other metalworking fluids or metalworking fluid additives, except as recommended by Master Fluid Solutions, as this may reduce overall performance, result in adverse health effects, or damage the machine tool and parts. If contamination occurs, please contact Master Fluid Solutions for recommended action.
- TRIM™ is a trademark of Master Chemical Corporation d/b/a Master Fluid Solutions.
- Master STAGES™ and Whamex XT™ are trademarks of Master Chemical Corporation d/b/a Master Fluid Solutions.
- The information herein is given in good faith and believed current as of the date of publication 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 Fluid Solutions for further information. For the most recent version of this document, please go to this URL:

https://2trim.us/di/?i=ap_en-ap_SC538

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