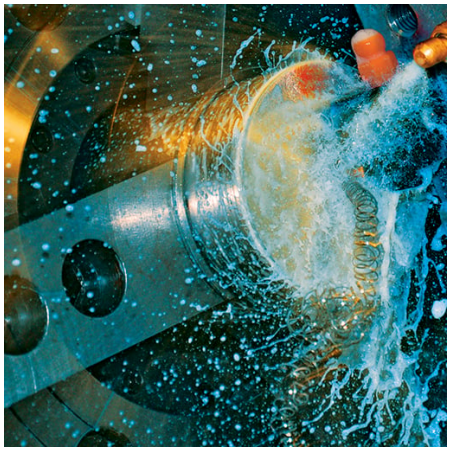
# TRIM® MicroSol® 606 bd

## *Long-life Microemulsion - Blue Dye*

TRIM MicroSol 606 bd is a blue dyed, microemulsion semisynthetic coolant made specifically for machining aluminum, steel, and alloy steel. It provides excellent cooling and mechanical lubricity, along with the machine friendly characteristics you expect from a premium TRIM coolant.

## *MicroSol*



***For ultimate performance:***

*TRIM® MicroSol® semisynthetic microemulsion coolants deliver high-performance lubricity and ultimately lower costs. Achieve precision parts, exceptional tool life, extended sump life, assured regulatory compliance, and greater profitability with the MicroSol product just right for your production.*

*Designed to meet the rigorous demands of the aerospace, medical, automotive, and high production, precision parts manufacturing industries, there's a MicroSol to answer your concerns, ramp up your production, and boost your bottom line.*

## Choose MicroSol 606 bd:

- Versatile product that does an outstanding job in milling, drilling, and tapping cast or wrought aluminum, vertical or horizontal machining center work on alloy steel, surface and centerless grinding, and in general-purpose, job shop operations
- Contains very effective, extreme-pressure additives to control built-up edge
- Compatible with all ferrous and nonferrous materials
- Very fine emulsion gets to the point of cut
- Rejects tramp oil to extend sump life and increase recycling options
- Leaves a soft fluid film to prevent sticky ways, chucks, tool holders, and fixtures
- Coolant residue is easily removed with water, working solution, or Master STAGES™ aqueous cleaners
- Easily recycled or disposed of with conventional techniques and equipment
- Very stable with long sump life and minimal carryoff
- Runs for long periods without the need for costly additives

## MicroSol 606 bd especially for:

**Applications** — centerless grinding, general purpose, horizontal machining, job shop operations, machining, surface grinding, tapping, and vertical machining

**Materials** — aluminum, cast aluminum, ferrous metals, nonferrous metals, steel alloys, and steels

**Industries** — aerospace and job shop

**MicroSol 606 bd is free of —** formaldehyde releasers and NPEs

Master Fluid SOLUTIONS®

# TRIM® MicroSol® 606 bd

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## Application Guidelines

- Can run at lower concentrations for higher speed operations where heat removal is the key issue, or run at higher concentrations on soft, gummy materials for lower speed operations where friction reduction and control of built-up edge are critical.
- Keeping MicroSol 606 bd at 7% or higher concentration provides the best sump life.
- For additional product application information, including performance optimization, please contact your Master Fluid Solutions' Authorized Distributor at https://www.masterfluids.com/na/en-us/distributors/index.php, your District Sales Manager, or call our Tech Line at 1-800-537-3365.

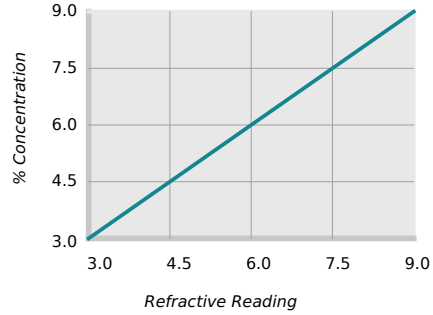
## Physical Properties Typical Data

| | |
|---|---|
| Color (Concentrate) | Dark blue |
| Color (Working Solution) | Blue |
| Odor (Concentrate) | Mild |
| Form (Concentrate) | Liquid |
| Flash Point (Concentrate) (ASTM D93-08) | > 210°F |
| pH (Typical Operating as Range) | 8.8 - 9.2 |
| Coolant Refractometer Factor | 1.0 |
| V.O.C. Content (ASTM E1868-10) | 95 g/l |

## Recommended Metalworking Concentrations

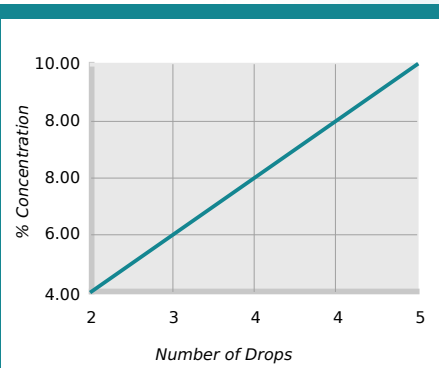
| | |
|---|---|
| Light Duty | 3.0% - 6.0% |
| Moderate Duty | 6.0% - 8.0% |
| Heavy Duty | 8.0% - 9.0% |
| Design Concentration Range | 3.0% - 9.0% |

## Concentration by % Brix




% Concentration = Refractive Reading x Refractive Factor
Coolant Refractometer Factor % Brix = 1.0

## Concentration by Titration




% Concentration = No. of Drops x Titration Factor
Titration Factor = 2.00

Request SDS

# TRIM® MicroSol® 606 bd

## *Long-life Microemulsion - Blue Dye*

## Mixing Instructions

- Recommended usage concentration in water: 3.0% - 9.0%.
- 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.



1-gallon jug
SKU: MS606BD-1G
UPC-12: 641238003052



5-gallon pail
SKU: MS606BD-5G
UPC-12: 641238038450




54-gallon drum
SKU: MS606BD-54G
UPC-12: 641238038467



270-gallon tote
SKU: MS606BD-270G
UPC-12: 641238033882

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## Additional Information

- Use Master STAGES™ Whamex™ 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.
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- 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=na_en-us_MS606BD

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