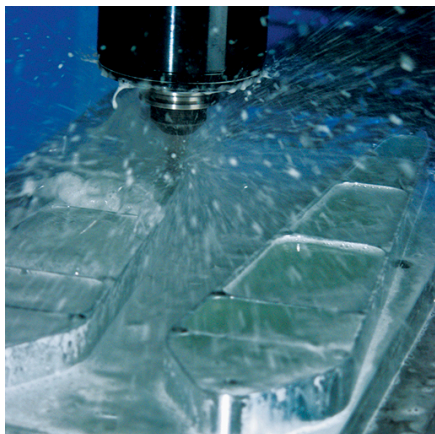


# SC622

## High-lubricity, Premium Semisynthetic

TRIM® SC622 is a revolutionary coolant concentrate specifically formulated for machining and grinding of ferrous alloys, nickel alloys, titanium and aluminium. This unique formulation utilises synthetic additives instead of traditional mineral oil and fatty lubricants resulting in very high levels of lubrication only generally seen with high mineral oil emulsion products. Unlike these emulsion products, TRIM SC622 working solution is translucent in appearance thus ensuring very clean machine tools, very low top up rates and good operator acceptance. These attributes, coupled to excellent tramp oil rejection and biostability, make TRIM SC622 a highly cost effective alternative to traditional milky emulsions.

### Semisynthetics



*TRIM® semisynthetics offer the cooling and lubricity of a synthetic without the higher oil content of an emulsion.*

#### 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 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 SC622:

- Low foaming even in soft water areas
- Excellent lubricity for tough operations on hard steels, exotic alloys and gummy aluminium
- Capable of machining cast iron
- Will keep the machine and work environment extremely clean
- Translucent dilution reduces carry-off for low total operating cost
- Excellent tramp oil rejection
- Hard water tolerant
- Fast wetting to get the fluid to the point of cut and keep grinding wheels clean

#### SC622 especially for:

**Applications** — centerless grinding, cylindrical grinding, deep hole drilling, down the hole work, heavy-duty machining center work, high-speed milling, high-speed turning, internal grinding, milling, reaming, roll threading, sawing, tapping, turning

**Metals** — aluminium, exotic alloys, ferrous metals, hardened steel, high-nickel alloys and titanium

**Industries** — aerospace, automotive, compressor and medical

**SC622 is free of** — boron, chlorine, formaldehyde releasers, mineral oils, sulphurised EP additives

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## Application Guidelines

- TRIM SC622 will run effectively for long periods without the need for costly additives.
- It 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 built-up edge are critical.
- Concentrations above 7% provide the best sump life.
- For additional product application information, including performance optimisation, please contact your Master Fluid Solutions' Authorised Distributor at <https://www.2trim.us/distributors.php>, your District Sales Manager, or call our Tech Line at +49 211 77 92 85 - 13.

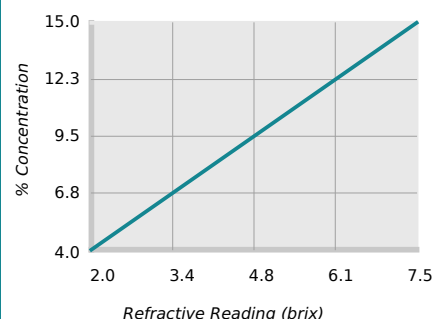
## Physical Properties Typical Data

Colour (Concentrate)	Straw/yellow
Odour (Concentrate)	Mild amine
Form (Concentrate)	Liquid
Flash Point (Concentrate) (ASTM D93-08)	> 160°C
pH (Concentrate as Range)	9.3 - 9.9
pH (Typical Operating as Range)	9.1 - 9.7
Coolant Refractometer Factor	2.0

## Recommended Metalworking Concentrations

Light duty	4.0% - 7.0%
Moderate duty	7.0% - 9.0%
Heavy duty	9.0% - 15.0%
Design Concentration Range	4.0% - 15.0%

## Concentration by % Brix



$\% \text{ Concentration} = \text{Refractive Reading} \times \text{Refractive Factor}$   
Coolant Refractometer Factor % Brix = 2.0

## Health and Safety

For further information, see the most recent SDS which is available directly from Master Fluid Solutions or from your Master Fluid Solutions' Authorised Distributor.

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## Mixing Instructions

- Recommended usage concentration in water: 4.0% - 15.0%.
- 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.masterfluidsolutions.com/makeup/](https://apps.masterfluidsolutions.com/makeup/).
- Use mineral-free water to improve sump life and corrosion inhibition while reducing carryoff and concentrate usage.

## Ordering Information

20-litre pail

204-litre drum

1000-litre IBC


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## 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 registered 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/?plr=SC622\\*en\\*eu](https://2trim.us/di/?plr=SC622*en*eu)



 Hasselsstraße 6-14  
Düsseldorf, 40597  
Germany

 +49 211 77 92 85 - 0

 [info-eu@masterfluidsolutions.com](mailto:info-eu@masterfluidsolutions.com)

 [masterfluidsolutions.com/eu/en/](https://masterfluidsolutions.com/eu/en/)

