

# Whamex™

## Machine Tool Sump and System Cleaner



Master STAGES™ Whamex™ is a safe, fast-acting concentrated formula that will save machine cleaning downtime while removing the oily residues, scums, and insoluble soap deposits that reduce coolant life.

Whamex is made for cleaning out machine tool sumps and larger systems, coolant supply lines, and coolant recycling equipment. Whamex is compatible with most waste treatment (including ultrafiltration) and will not degrade TRIM® metalworking fluids when used as directed.

### Maintenance



*A customer had a 40,000 litre central system for centerless grinding piston pins — where finishes are critical.*

#### **Whamex in action:**

*A customer had a 40,000 litre central system for centerless grinding piston pins — where finishes are critical. They were experiencing problems with a soluble oil coolant: tramp oil was increasing as finishes were decreasing. Rather than dumping the system, 1% Whamex was added with amazing results. Part finish improved from 6 to 2-4 microns; tramp oils split out. After seeing dramatically longer sump life, the production manager stated "instead of dumping the system, it is still running parts with excellent finishes and no coolant problems."*

### Choose Whamex:

- A very specialized formula that draws many years of hands-on experience in machine clean outs
- Quickly breaks down and lifts off insoluble scum deposits hidden in lines and difficult to reach areas — getting rid of these residues is one of the best ways to extend coolant life in your system
- Very hard water tolerant allowing it to be effective in raw water or used coolant
- Environmental approvals are simplified because Whamex contains no nitrites, phosphates, barium, phenols, or butyl cellulose; this formula has very low V.O.C. content
- When used as directed below, this product is compatible with TRIM brand semisynthetic, and soluble oil coolants, as well as most competitive coolants. Will remove heavy soils from machines without affecting paints, coatings, seals, hoses, or skirting, and it won't leave a slippery residue
- Whamex will cause foaming in machines and systems running synthetic products. The use of non-foaming Whamex XT™ is recommended in such cases.
- Short-term corrosion inhibitors prevent flash rusting of machine surfaces and ways

### Whamex especially for:

**Applications** — floor cleaning, immersion tanks, machine cleaning inside, machine cleaning outside

**Soils** — coolant residues, heavy oils and light oils

**Metals** — cast iron and steels

**Industries** — aerospace, automotive, machine tool manufacturers and medical

**Whamex is free of** — 2-butoxyethanol (Butyl), barium, nitrites, phenols, phosphate

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### Application Guidelines

- Use a high-flow sump cleaner such as a Yellow Bellied Sump Sucker™, to quickly remove spent fluids and residues.
- Add up to 0.1% Master STAGES™ CLEAN DF1 to control foam in high-pressure, high-flow systems.
- All used coolant or rinse water must be recycled or disposed of in accordance with local, state, or provincial, and national environmental regulations.
- To learn about the "Preferred Method for Cleaning Machine Tools and Central Systems" and the "Quick Cleaning Method For Noncritical Interim Cleaning" check out pages 10-12 of the [The Handy Pocket Guide to a Clean Shop](#).
- 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.

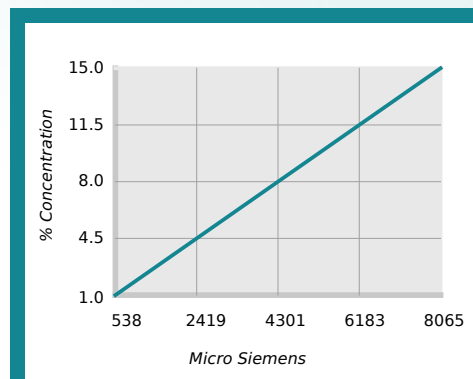
### Physical Properties Typical Data

|   |             |
|---|-------------|
| Colour (Concentrate)                          | Yellow      |
| Colour (Working Solution)                     | Colorless   |
| Odour (Concentrate)                           | Mild        |
| Form (Concentrate)                            | Liquid      |
| Flash Point (Concentrate) (ASTM D93-08)       | > 94°C      |
| pH (Concentrate as Range)                     | 10.5 - 11.0 |
| pH (Typical Operating as Range)               | 10.2 - 10.8 |
| Coolant Refractometer Factor                  | 2.5         |
| Cleaner Conductivity Factor                   | 0.00186     |
| Titration Factor (CL-1 Titration Kit)         | 0.43        |
| Number of Cleaner Vials (CL-1 Titration Kit)  | 2           |
| Cleaner Indicator A or B (CL-1 Titration Kit) | B           |

### Recommended Metalworking Concentrations

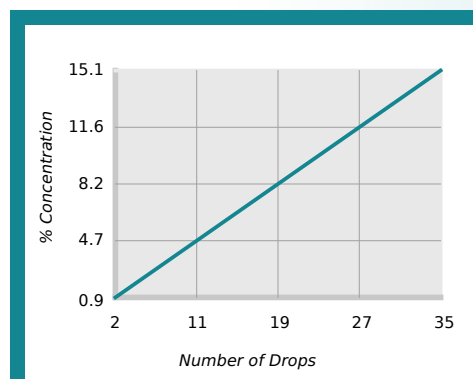
|                            |              |
|----------------------------|--------------|
| Design Concentration Range | 1.0% - 15.0% |
|----------------------------|--------------|

### Concentration by Conductivity



% Concentration = Conductivity in Micro Siemens x Factor  
Conductivity Factor = 0.00186

### Concentration by Titration



% Concentration = No. of Drops x Titration Factor  
Titration Factor = 0.43

### 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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### Ordering Information

20-litre pail

204-litre drum

1000-litre IBC


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### Additional Information

- Industrial Use only
- 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.
- Master STAGES™ is a trademark 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=WHAMEX\\*en\\*eu](https://2trim.us/di/?plr=WHAMEX*en*eu)



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