



CoolPAK™ S5628

Mixed Metal Semisynthetic

CoolPAK™ S5628 provides good cooling and medium to high mechanical lubricity. For machining and grinding cast iron as well as a wide range of mixed metals, including aluminium, inconel and titanium alloys.

Application Guidelines

- Concentrations above 7% provide the best sump life
- Run effectively for long periods without the need for costly additives
- Run at lower concentrations for higher speed operations where heat removal is the key issue
- Run at higher concentrations on soft, gummy materials and for lower speed operations where friction reduction and control of built-up edge are critical
- 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)	Amber
Colour (Working Solution)	Light amber
Odour (Concentrate)	Mild amine
Form (Concentrate)	Liquid
Flash Point (Concentrate)	> 160°C (ASTM D93-08)
pH (Concentrate as Range)	9.1 - 10.1
pH (Typical Operating as Range)	9.0 - 9.5
Coolant Refractometer Factor	1.6
Viscosity	31.7 mm ² /s @40°C

Choose CoolPAK S5628:

- Low carry off
- Hard water tolerant
- No aggressive biocides
- Multi metal compatible
- Medium to high mechanical lubricity
- Machines high silica aluminium alloys
- Does not require special disposal or recycling
- Contains no DEA, chlorine, sulphur, nitrites, formaldehyde releasers, or phenolic compounds

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.

Packaging

1000-litre IBC
SKU: CPS5628/1000L



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Recommended Concentrations

Light duty	3.0% - 6.5%
Moderate duty	6.5% - 8.5%
Heavy duty	8.5% - 10.0%
Design Concentration Range	3.0% - 10.0%

Mixing Instructions

- Recommended usage concentration in water: 3.0% - 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 mineral-free water to improve sump life and corrosion inhibition while reducing carryoff and concentrate usage.

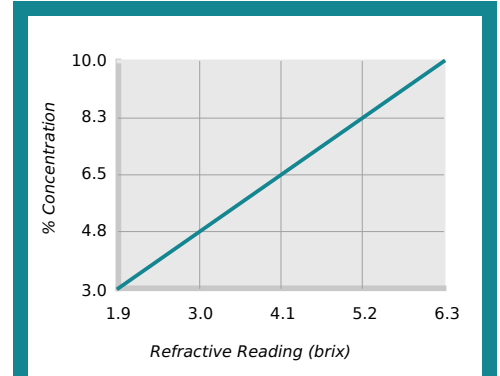
Additional Information

- 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.

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Concentration by % Brix



% Concentration = Refractive Reading x Refractive Factor
Coolant Refractometer Factor % Brix = 1.6

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