



CoolPAK™ C2640

Low-foam Synthetic

CoolPAK™ C2640 uses the latest synthetic coolant formulation and specially synthesized oil to produce a versatile product that runs clean, has great sump life, and is kind to both machines and operators.

Application Guidelines

- The minimum recommended concentration is 5% on cast iron and 4% on steel
- Concentrations in excess of 7.5% typically provide the best corrosion inhibition, tool life, and sump life; however, the optimum concentration for your operation can best be determined by on-site testing
- Not recommended on magnesium or zirconium without special precautions
- C2640 may "wash out" dirt and residues when a machine is first charged
- A thorough cleaning of older machines is required when installing this product for the first time
- For additional product application information including performance optimization, please contact your Master Fluid Solutions' Authorized Distributor at 2trim.us/distributors.php, your District Sales Manager, or call our Tech Line at 1-800-537-3365

Physical Properties Typical Data

Color (Concentrate)	Colorless to light yellow
Color (Working Solution)	Colorless to light yellow
Odor (Concentrate)	Mild chemical
Form (Concentrate)	Liquid
Flash Point (Concentrate)	> 216°F (ASTM D93-08)
pH (Concentrate as Range)	9.5 - 10.5
pH (Typical Operating as Range)	9.4 - 9.8
Coolant Refractometer Factor	3.1
Titration Factor (CGF-1 Titration Kit)	0.66
Digital Titration Factor	0.0173
V.O.C. Content (EPA Method 24)	119 lb/g

CoolPAK C2640

- Compatible with cast iron, steels, copper alloys, and plastics
- Low foam and mist
- Provides great corrosion inhibition on all common ferrous alloys
- For grinding, drilling, tapping, and reaming
- Low carryoff
- Exceptional sump life and very good tramp oil rejection
- Low odor
- High-pressure machining
- Runs clean

Health and Safety

See the most recent SDS at:
2trim.us/s/?i=2588-en-US-US



Packaging

5-gallon pail
SKU: CPC2640/5
UPC-12: 641238076001

54-gallon drum
SKU: CPC2640/54
UPC-12: 641238075998

270-gallon tote
SKU: CPC2640/NR270P
UPC-12: 641238075981



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Recommended 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%

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 mineral-free water to improve sump life and corrosion inhibition while reducing carryoff and concentrate usage.

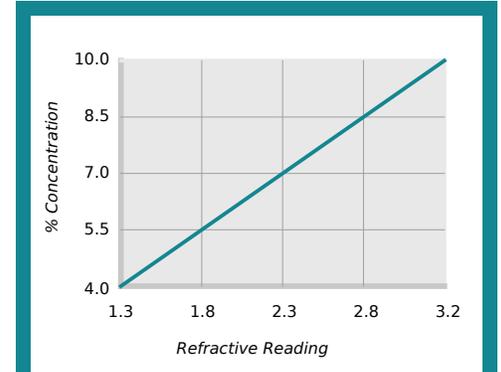
Additional Information

- Use Master STAGES™ Whamex XT™ for a quick and thorough precleaning of your machine tool and coolant system.
- Before using on any metals or applications not specifically recommended, consult Master Fluid Solutions.
- 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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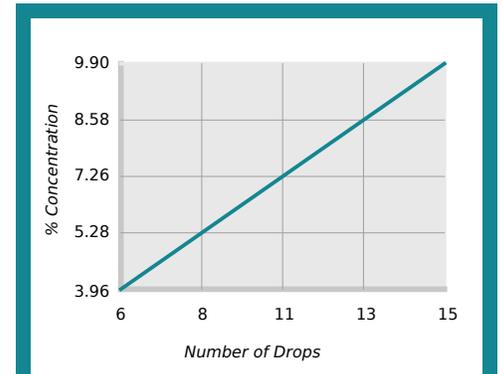
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Concentration by % Brix



% Concentration = Refractive Reading x Refractive Factor
Coolant Refractometer Factor % Brix = 3.1

Concentration by Titration



% Concentration = No. of Drops x Titration Factor
Titration Factor = 0.66

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Master Fluid Solutions™
—Cutting Edge Metalworking Solutions™