



# CoolPAK™ S4209 nd

**Semisynthetic for Cast Iron Machining - No Dye**

CoolPAK S4209 nd is a semisynthetic coolant which provides cooling, rust inhibition, and lubricity needed for cast iron machining and grinding. It is well suited for pipe forming applications and compatible with galvanized pipe as well as general, high-speed machining and grinding.

## Application Guidelines

- It is not recommended for use on reactive metals like magnesium, zirconium, or zinc
- Running at or above 6% offers the best sump life and corrosion inhibition.
- For additional product application information, including performance optimization, please contact your Master Fluid Solutions' Authorized Distributor at <https://www.masterfluids.com/in/en-in/distributors/index.php>, your District Sales Manager, or email us at [india-info@masterfluids.com](mailto:india-info@masterfluids.com).

## Physical Properties Typical Data

Color (Concentrate)	Clear, light yellow
Color (Working Solution)	White translucent
Odor (Concentrate)	Mild
Form (Concentrate)	Liquid
Flash Point (Concentrate)	> 100°C (ASTM D92-90)
pH (Typical Operating as Range)	9.0 - 10.0
Coolant Refractometer Factor	1.6

## Choose CoolPAK S4209 nd:

- Low odor and mist
- Best suited for all types of cast iron and galvanized pipe
- Has good sump life and low makeup for low, total operating cost
- Easy recycling or disposal with conventional techniques and equipment
- Works well in general machining where a more traditional soluble oil may not cool sufficiently
- Keeps machines clean and leaves a soft fluid film for easy cleaning and less machine maintenance
- Provides corrosion inhibition on cast iron and other ferrous materials and eliminates the "hot chip" and clinkering problems often seen when machining cast iron

## 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' Authorized Distributor.

## Packaging

20-litre pail  
204-liter drum  
1000-litre IBC



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## Recommended Concentrations

Light Duty	5.0% - 6.5%
Moderate Duty	6.5% - 8.5%
Heavy Duty	8.5% - 10.0%
Design Concentration Range	5.0% - 10.0%

## Mixing Instructions

- Recommended usage concentration in water: 5.0% - 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.

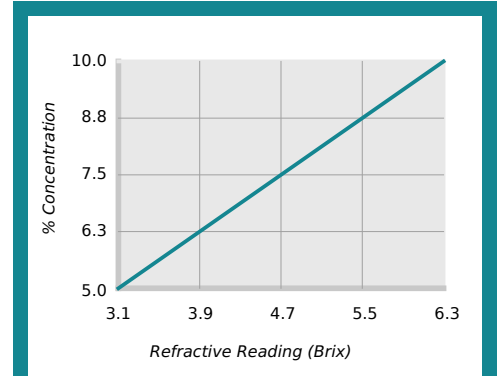
## Additional Information

- 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



$\% \text{ Concentration} = \text{Refractive Reading} \times \text{Refractive Factor}$   
Coolant Refractometer Factor % Brix = 1.6

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