

# EDGE MASTER

## DESCRIPTION

EDGE MASTER is a premium quality, heavy duty, soluble oil concentrate containing multiple lubricant additives. Mixing with good quality water produces an extremely fine oil in water emulsion, stable over long periods of tough machining operations yet will not go rancid or separate when left standing. EDGE MASTER is formulated to produce superior quality finishes on a wide range of metals, and provide corrosion inhibition on finished parts, fixtures, and machine tools. It also provides cleaning action to move chips and dirt away from the machining zone, inhibits bacteria and mold growth, eliminates foul odors and damaging residue formation. EDGE MASTER is well suited for all stamping and drawing operations where heavy duty performance is required.

## FEATURES

- Wide job range application
- Fluid, resoluble residue -- *No gumming*
- Corrosion protection on parts, fixtures, and machine tools
- Stable emulsion in good to moderate water -- Resists separation
- Mild to operator's skin -- No strong perfume odor
- No nitrites, phenols, or toxic materials

## PHYSICAL PROPERTIES

Form:	<i>Liquid</i>	Fire point:	<i>360° F (COC)</i>
Appearance:	<i>Dark amber</i>	Viscosity:	<i>315 SUS @ 100° F</i>
Specific gravity:	<i>1.01</i>	Residue:	<i>Liquid</i>
pH @ 5% solution:	<i>9.4</i>	Flash point:	<i>320° F (COC)</i>
pH @ 10% solution:	<i>9.5</i>	Pour point:	<i>-20° F</i>
Odor:	<i>None</i>	Refractometer factor:	<i>1.0</i>

## MACHINING OPERATIONS

Turning	Drilling	Gear cutting	Cylindrical grinding
Broaching	Boring	Milling	Gear shaving
Centerless grinding		Sawing	

### 32-1 REF. READING:

3 %	3.4
5%	5.4
7%	7.2
10%	10.4

## COMPATIBLE MATERIALS

Plain carbon steels	Alloy steels	Cast steels
Stainless steels		
Aluminum alloys	Copper alloys	Titanium alloys

## STORAGE AND HANDLING

Use at room temperature. If frozen, allow to thaw completely before use. Do not expose to extreme high temperatures due to possible drum rupture. Do not pressurize drum or reuse empty container.