



TRI-X-100

- **HELPS KEEP METAL COOL**
- **PROVIDES EXCELLENT LUBRICITY**
- **OIL/WATER MIX IS STABLE**
- **INHIBITS RUST AND ODOR**
- **VERSATILE**
- **ECONOMICAL**

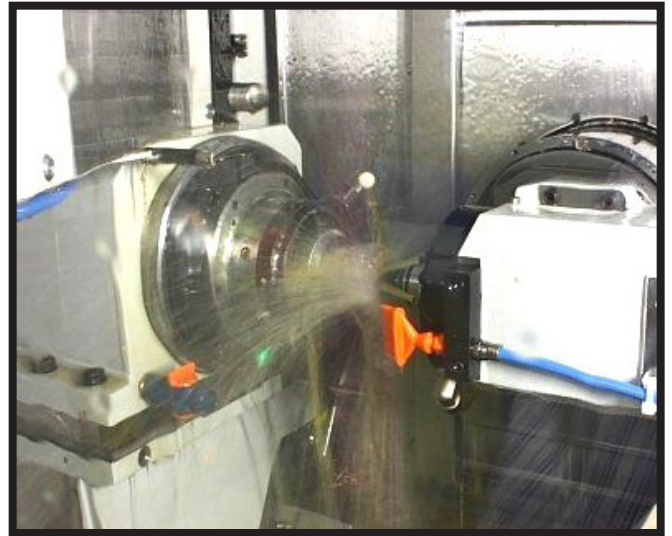
TRI-X-100 is a water soluble machine coolant developed especially for the metal working and machine tooling industry. TRI-X-100 is a superior coolant that extends tool life, permits higher or increased speeds in machining operations. TRI-X-100 is an amber, oil based compound with a pleasant characteristic oil odor.

TRI-X-100 Helps Keep Metal Cool

TRI-X-100 keeps the metal being machined at a reasonable temperature which prevents undue expansion. This is important where tolerances are in tens of thousands of an inch, since even the slightest heating causes expansion and inaccurate machining. TRI-X-100 prevents dry welding of chips by maintaining low temperatures. You should notice a trace of smoke going down from the tool when using TRI-X-100. If the smoke goes up, it means the tool is hot and the coolant is not performing satisfactorily. The coolant is working only fair if the smoke hangs around the tool.

TRI-X-100 Provides Excellent Lubricity

TRI-X-100 contains a special oil giving the product enough lubricity to reduce the forces in a machining operation, thereby cutting the power consumption to a minimum. The excellent lubricity of TRI-X-100 speeds up production work and helps the tool give a high mirror finish. The excellent lubricity of TRI-X-100 helps prevent dry



welding of chips, and this means the chip scraps bring more money for salvage because they are not burned.

TRI-X-100 Oil/Water Mix Is Stable

TRI-X-100 contains an enormous amount of a special emulsifying agent so the oil/water mix is complete and stable. The emulsifier prevents the tiny oil droplets from rejoining into big drops. The emulsifier also helps TRI-X-100 to have excellent dispersing properties. The dispersing properties of TRI-X-100 keep the small chips, which tend to cling together, from accumulating and congesting the coolant system. TRI-X-100 picks up the chips immediately as they are formed and flushes them away from the cutting area.

TRI-X-100 Inhibits Rust and Odor

TRI-X-100 contains a unique inhibitor known as "phos-x" that imparts outstanding rust proofing properties. TRI-X-100 inhibits rust on parts and machinery at concentrations as low as 1 part TRI-X-100 to 75 parts water. "Phos-x" also adds to the EP qualities of TRI-X-100 at the point where the cutting tool comes in contact with the material being machined, thereby giving longer life and a smoother finish. Also incorporated into TRI-X-100 are additives to inhibit the breakdown of oil products when mixed with water. This helps eliminate odors and bacteria growth. TRI-X-100 is formulated to reduce dermatitis.

TRI-X-100 **Is Versatile**

TRI-X-100 is suitable for machining a wide variety of metals in such operations as turret lathes, drill presses, grinders, reamers, broaches, milling machines, and saws. TRI-X-100 is mixed at the rate of 1 gallon per 20 to 30 gallons of water for most operations. As always, the type of metal, the type of machining operation and the water hardness must be taken into consideration.

For good success, the pump and lines of the entire coolant system should be cleaned prior to the introduction of TRI-X-100. This is necessary to avoid a rancid condition that may be present from the coolant previously used in the system. The use of BIG RED - - a multi-purpose concentrated cleaner - - is recommended for this cleaning. Use 4 - 6 oz. of BIG RED to each gallon of water. This removes the tramp oils, scums, etc. Some mechanical cleaning may be necessary. Rinse well with clear water containing a bleach to ensure starting out fresh and clean. The amount of bleach should be about 2 oz. per gallon.

TRI-X-100 **Is Economical**

TRI-X-100 is economical to use. For example, it is used at one part TRI-X-100 to 50 or even 70 parts of water for grinding operations. Naturally, the hardness of the water will influence how much TRI-X-100 to use. Soft water is always preferred.

SPECIFICATIONS

TRI-X-100
Product Code #5360

Gravity, Specific	0.915
-------------------	-------

Flash, COC, °F.	None to Boiling Point Above 212°F.
-----------------	------------------------------------

Pour Point, °F., Max.	0
-----------------------	---

Viscosity, SUS at 210°F.	44/48
--------------------------	-------

Rust Test	Pass
-----------	------

Emulsion Stability	Excellent
--------------------	-----------

Odor	Mild, Bland Petroleum
------	-----------------------

Appearance	Brown, Oily-Like Liquid
------------	-------------------------

***NEVER USE TRI-X-100 FOR MACHINING MAGNESIUM.**

Handling Information: For safe handling of the product, read the Safety Data Sheet (SDS).

Toll Free: 1-800-827-0711
Toll Free Fax: 1-800-582-3329
www.texasrefinery.com
E-mail: lube1@texasrefinery.com

TEXAS REFINERY CORP

Fort Worth, Texas
Toronto, Ontario • Moose Jaw, Saskatchewan

PRINTED IN U.S.A. 5/2014
L505361