# Master STAGES™ Whamex XT™

***Low-foam Machine Tool Sump and System Cleaner***

Master STAGES™ Whamex XT™ is a low foam, safe, fast-acting, concentrated formula that will save machine cleaning downtime while removing the oily residues, scums, and insoluble soap deposits that reduce coolant life. Whamex XT is made for cleaning out machine tool sumps and larger systems, coolant supply lines, and coolant recycling equipment. Whamex XT is compatible with most waste treatment (including ultrafiltration) and will not degrade TRIM metalworking fluids when used as directed.

## *Maintenance*



*Whether cleaning true grit or light soil from machines, work surfaces, glass, or floors, there's a highly-concentrated, cost-effective Master STAGES cleaner to get the job done and save hours of maintenance. So, don't just get it clean — get it Master STAGES clean! Master STAGES highly concentrated Whamex™ sump and central system cleaners for interim and full cleanouts extend sump life, are very cost effective, and greatly reduce downtime.*

*All Master STAGES environmentally-friendly products are safe for human contact and free of harmful, corrosive chemicals and troublesome SARA 313 ingredients.*

## Choose Whamex XT:

- A very specialized formula that draws on many years of hands-on experience in machine cleanouts
- Quickly breaks down and lifts off insoluble scum deposits hidden in lines and difficult to reach areas — getting rid of these residues is one of the best ways to extend coolant life in your system
- Very hard water tolerant allowing it to be effective in raw water or used coolant
- Environmental approvals are simplified because Whamex XT contains no nitrites, phosphates, barium, phenols, or butyl cellosolve; this formula has very low V.O.C. content and no SARA 313 reportable ingredients
- When used as directed below, this product is compatible with TRIM brand synthetic, semisynthetic, and soluble oil coolants, as well as, most competitive coolants. Will remove heavy soils from machines without affecting paints, coatings, seals, hoses, or skirting, and it won't leave a slippery residue
- Short-term corrosion inhibitors prevent flash rusting of machine surfaces and ways

## Whamex XT especially for:

**Applications** — machine cleaning inside and machine cleaning outside

**Soils** — coolant residues, heavy oils, and light oils

**Materials** — cast iron and steels

**Industries** — aerospace, automotive, machine tool, and medical

**Whamex XT is free of —** 2-butoxyethanol (Butyl), barium, nitrites, phenols, phosphate, and SARA 313 listed ingredients

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## Application Guidelines

- Machine cleaning for machines using synthetic or semisynthetic cutting fluids
- Use a high-flow sump cleaner such as a Yellow Bellied Sump Sucker™, to quickly remove spent fluids and residues.
- Add up to 0.1% Master STAGES™ CLEAN DF1 to control foam in high-pressure, high-flow systems.
- All used coolant or rinse water must be recycled or disposed of in accordance with local, state, or provincial, and national environmental regulations.
- To learn about the "Preferred Cleaning Method" and the "Quick-Clean Method for Interim/Noncritical Cleaning" check out pages 10-12 of the The Handy Pocket Guide to a Clean Shop.
- For additional product application information, including performance optimization, please contact your Master Fluid Solutions' Authorized Distributor at https://www.masterfluids.com/na/en-us/distributors/index.php, your District Sales Manager, or call our Tech Line at 1-800-537-3365.

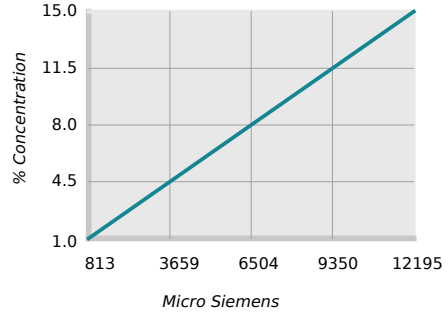
## Physical Properties Typical Data

| | |
|---|---|
| Color (Concentrate) | Straw yellow |
| Color (Working Solution) | Cloudy, white |
| Odor (Concentrate) | Slight |
| Form (Concentrate) | Liquid |
| Flash Point (Concentrate) (ASTM D93-08) | > 212°F |
| pH (Concentrate as Range) | 10.5 - 11.5 |
| pH (Typical Operating as Range) | 9.8 - 10.5 |
| Coolant Refractometer Factor | 2.8 |
| V.O.C. Content (EPA Method 24) | 1.0 lbs/gal |
| Cleaner Conductivity Factor | 0.00123 |
| Titration Factor (CL-1 Titration Kit) | 0.25 |
| Number of Cleaner Vials (CL-1 Titration Kit) | 2 |
| Cleaner Indicator A or B (CL-1 Titration Kit) | B |

## Recommended Metalworking Concentrations

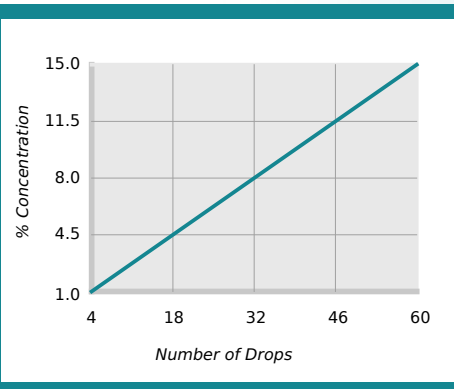
| | |
|---|---|
| Design Concentration Range | 1.0% - 15.0% |

## Concentration by Conductivity




% Concentration = Conductivity in Micro Siemens x Factor
Conductivity Factor = 0.00123

## Concentration by Titration




% Concentration = No. of Drops x Titration Factor
Titration Factor = 0.25

Request SDS

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## Mixing Instructions

- Recommended usage concentration in water: 1.0% - 15.0%.
- 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.



1-gallon jug
SKU: WHMXXT-1G
UPC-12: 641238069416



5-gallon pail
SKU: WHMXXT-5G
UPC-12: 641238069409



54-gallon drum
SKU: WHMXXT-54G
UPC-12: 641238069393



270-gallon tote
SKU: WHMXXT-270G
UPC-12: 641238070771



## Additional Information

- Industrial use only
- 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.
- Master STAGES™ is a trademark of Master Chemical Corporation d/b/a Master Fluid Solutions.
- The information herein is given in good faith and believed current as of the date of publication and should apply to the current formula version. Because conditions of use are beyond our control, no guarantee, representation, or warranty expressed or implied is made. Consult Master Fluid Solutions for further information. For the most recent version of this document, please go to this URL:

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