



# TRIM<sup>®</sup> C115

*Synthetic*

## GENERAL DESCRIPTION

TRIM<sup>®</sup> C115 is a high-performance, synthetic fluid for working cast iron and mild steels. State-of-the-art chemical technology provides excellent cooling and chip settling, good tramp oil rejection, and machine cleanliness while leaving a protective film on the machine tool.

## ADVANTAGES

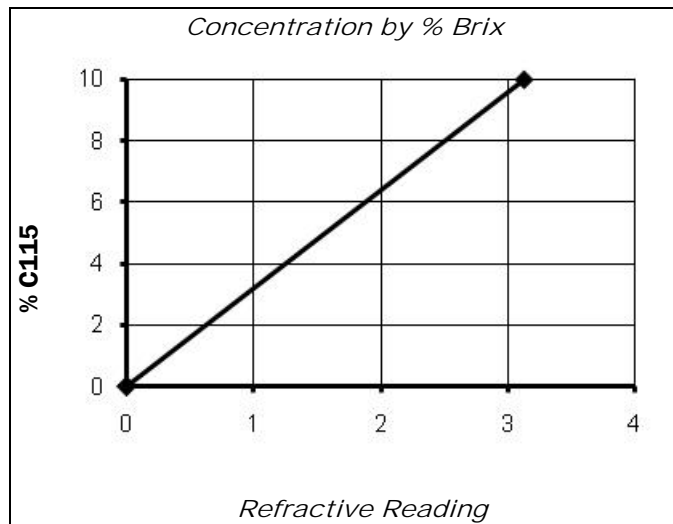
- Compatible with a very wide range of materials including cast iron, steels, plastics, and composites
- Does an excellent job in most glass, ceramic, and composite grinding applications
- Excellent corrosion inhibition on most common ferrous and nonferrous alloys
- Extremely low carryoff keeps operating costs down
- Low foam and mist
- Very low initial odor level which usually disappears after one-to-two days
- Keeps your machines clean while leaving a soft, fluid film that protects bare metal parts
- Exceptional sump life and very good tramp oil rejection

## APPLICATION GUIDELINES

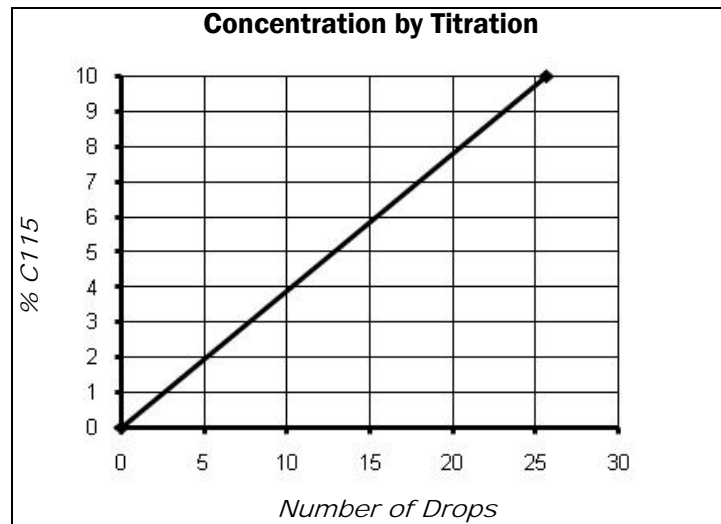
- C115 is not recommended in machine tools that rely on coolant splash to lubricate the mechanical portions of the machine tool; e.g., older screw machines, etc.
- Foam may increase if the temperature is below 80°F (27°C) at the point of agitation.
- C115 is not recommended on materials (i.e., magnesium or zirconium) without special precautions.
- This product is a superior cleaning agent so it 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.
- The minimum recommended concentration is 5% on cast iron, 4% on steel, and 5% in glass grinding.
- Concentrations above 7.5% provide the best corrosion inhibition, tool life, and sump life; however, on-site testing is usually the best way to set your concentration.
- For additional product applications information including performance optimization, please contact your Master Chemical Authorized Distributor at [2trim.us/distributors.php](http://2trim.us/distributors.php), your District Sales Manager, the Tech Line at 1-800-537-3365, or visit our web site at [www.masterchemical.com](http://www.masterchemical.com).

## PHYSICAL PROPERTIES (TYPICAL DATA)

Color (Concentrate) .....	Pale yellow	Flash Point .....	>219°F (104°C) (ASTM D93)
Color (Working Solution) .....	Colorless	pH (Typical Operating as a Range) .....	8.8-9.6
Odor .....	Mild, sweet	Coolant Refractometer Factor % Brix .....	3.2
Form .....	Liquid	Titration Factor (CGF-1 Titration Kit) .....	0.390



% Concentration = Refractive Reading x Refractive Factor  
Coolant Refractometer Factor % Brix = 3.2



% Concentration = No. of Drops x Titration Factor  
Titration Factor = 0.390

### RECOMMENDED METALWORKING CONCENTRATIONS

- Light-duty machining and grinding ..... 5%-7%
- Moderate-duty machining and grinding ..... 7%-10%
- Design concentration range ..... 4%-10%

### MIXING INSTRUCTIONS

- Using premixed coolant as makeup will improve coolant performance and reduce coolant purchases. The makeup concentration that you select should balance the water evaporation rate with the coolant carryout rate. Adding makeup coolant at 5%-15% of the desired working concentration will generally maintain the proper concentration in the sump.
- The use of DI or mineral-free water will improve sump life, reduce concentrate usage, reduce carryoff, and improve corrosion inhibition.

### HEALTH AND SAFETY

See the most recent SDS at [2trim.us/s/?i=1010-en-US-US](http://2trim.us/s/?i=1010-en-US-US).



### NOTES

- Before using this product on any metals and applications not specifically recommended, consult Master Chemical Corporation.
- This product should not be mixed with other metalworking fluids or metalworking fluid additives, except as specifically recommended by Master Chemical Corporation, as this may reduce the overall performance of the product as well as result in adverse health effects and damage to the machine tool and parts. If inadvertent contamination should occur, please contact Master Chemical Corporation for recommended action.
- Packaging: North America – 1-gallon jug, 5-gallon pail, 54-gallon drum, and 270-gallon tote bin.
- Packaging: Europe/Asia – 20-litre pail, 204-litre drum, and 1000-litre IBC.

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