



TRIM[®] C210

Synthetic

GENERAL DESCRIPTION

TRIM[®] C210 is a chemical surface active or synthetic coolant concentrate designed to meet or exceed the chemical approval requirement in most medical, nuclear, and aerospace operations. C210 provides a combination of cooling and lubrication properties to facilitate the cost-effective production of high-volume, high-value parts in the most stringent chemical environments.

ADVANTAGES

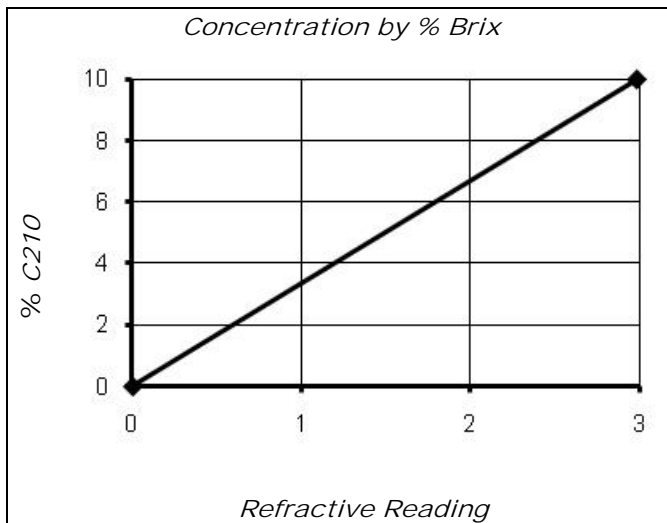
- C210 is compatible with a very wide range of materials including: steels, aluminum, copper alloys, as well as most plastics and composites
- Has the EP lubricity to do form grinding, drilling, tapping, and reaming operations without the need for chlorine or sulfur-based EP additives
- Has extremely low-carryoff for very low total operation costs
- Has very low foam and mist
- Has a very low, initial odor level which usually disappears after use for one to two days
- Will keep your machines clean while leaving a soft, fluid residue that protects the bare metal parts of your machine tools
- Has exceptional sump life and very good tramp oil rejection

APPLICATION GUIDELINES

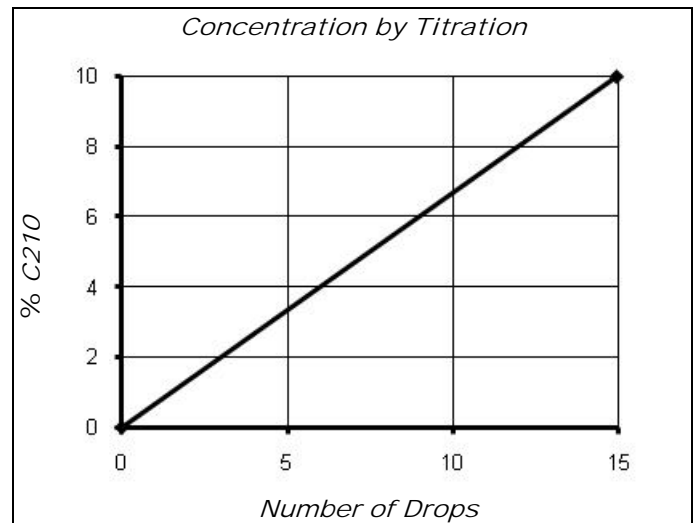
- C210 is not recommended on reactive metals like magnesium or zirconium without special precautions.
- Concentrations in the 4%-6% range are typically used for high-speed turning and face milling. Concentrations in excess of 6% are typically used for milling, drilling, and tapping in softer materials.
- The minimum recommended concentration is 5% on cast iron and 4% on steel and aluminum.
- Concentrations in excess of 7.5% provide optimum corrosion inhibition, tool life, and sump life; however, the optimum concentration for your operation can best be determined by onsite testing.
- For additional product applications information including performance optimization, please contact your Master Chemical Authorized Distributor at 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.

PHYSICAL PROPERTIES (TYPICAL DATA)

Color (concentrate)	Blue	Flash Point	>212°F (>100°C) (ASTM D92-90)
Color (working solution)	Blue	pH (Typical Operating as a range).....	8.3-8.9
Odor	Mild pine	Coolant Refractometer Factor % Brix	3.4
Form.....	Liquid	Titration Factor (CGF-1 Titration Kit)	0.670



% Concentration = Refractive Reading x Refractive Factor
Coolant Refractometer Factor % Brix = 3.4



% Concentration = No. of Drops x Titration Factor
Titration Factor = 0.670

RECOMMENDED METALWORKING CONCENTRATIONS

- Moderate-duty machining and grinding 5%-7%
- Heavy-duty machining and grinding 7%-10%

MIXING INSTRUCTIONS

- Using premixed coolant as makeup will substantially improve coolant performance and reduce coolant concentration purchases. The specific makeup concentration selected for your situation 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 to mix this product will improve sump life, reduce concentrate usage, reduce carryoff, improve corrosion inhibition, etc.

HEALTH & SAFETY

See the most recent SDS at 2trim.us/s/?i=1060-en-US-US.



NOTES

- Before using this product on any metals and applications not specifically recommended, consult Master Chemical Corporation. Misapplication may create potential risks of product deterioration, possible adverse health effects, and corrosion of work materials or the machine tool.
- This product should not be mixed with other metalworking fluids or metalworking fluid additives 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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