



# TRIM® C275

*Synthetic*

## GENERAL DESCRIPTION

TRIM® C275 is a synthetic coolant that excels where the primary operations are high-speed turning and milling on ferrous metals. New nonchlorinated technology ensures maximum performance and compliance with the most demanding environmental standards, high levels of cooling, and control of chip welding and built-up edge. C275 has the mechanical lubricity previously found only in high-oil semisynthetics. This increased mechanical lubricity facilitates tapping and reaming operations in some materials. C275 provides excellent cooling and chip settling, good tramp oil rejection, and machine cleanliness while leaving a fluid, resoluble protective film.

## ADVANTAGES

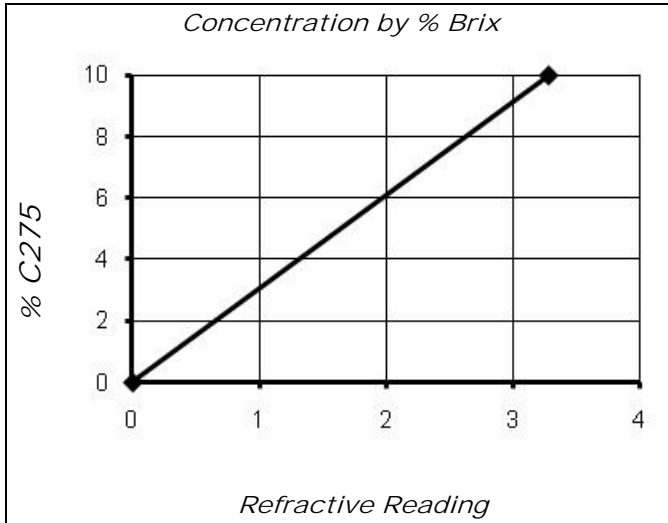
- Compatible with a very wide range of materials including cast iron, steels, copper alloys, plastics, and composites
- Provides excellent corrosion inhibition on all common ferrous and nonferrous alloys
- Excellent extreme pressure (EP) lubricity to do many form grinding, drilling, tapping, and reaming operations without the need for chlorine or sulfur-based EP additives
- Extremely low carryoff for very low total operation costs
- Very 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 the bare metal parts of your machine tools. This film is easily washed off with coolant working solution for easy machine cleaning
- Minimizes the buildup of sticky residues that can hold machine-destroying chips
- Exceptional sump life and very good tramp oil rejection

## APPLICATION GUIDELINES

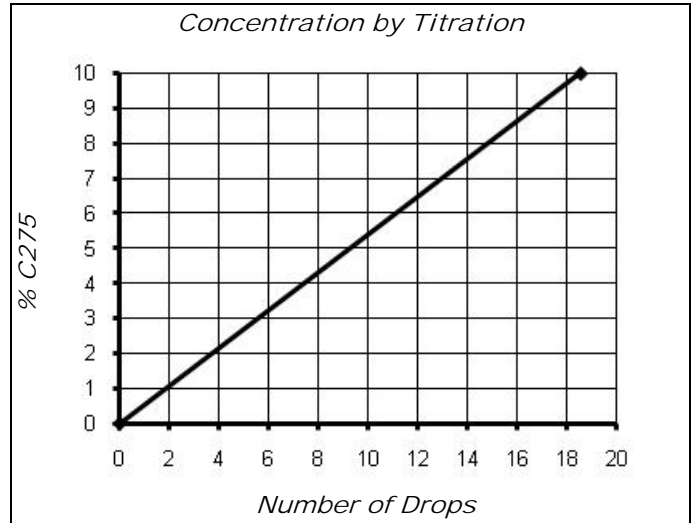
- The harder you work this product, the better the results will be.
- C275 is not recommended in machine tools that rely on the splash of the coolant to lubricate the mechanical portions of the machine tool; e.g., older screw machines, etc.
- C275 is not recommended on materials like magnesium or zirconium 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 the first time.
- The minimum recommended concentration is 5% on cast iron and 4% on steel. Concentrations in excess of 7.5% typically provide the best corrosion inhibition, tool life and sump life; however, the optimum concentration for your operation can best be determined by on-site testing.
- 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).....	Opaque to Yellow	Flash Point .....	>210°F (99°C)(ASTM D92-12B COC)
Color (working solution).....	Clear to light yellow	pH (Typical Operating as a range).....	9.0-9.3
Odor.....	Mild	Coolant Refractometer Factor % Brix .....	3.1
Form .....	Liquid	Titration Factor (CGF-1 Titration Kit) .....	0.540



% Concentration = Refractive Reading x Refractive Factor  
Coolant Refractometer Factor % Brix = 3.1



% Concentration = No. of Drops x Titration Factor  
Titration Factor = 0.540

### RECOMMENDED METALWORKING CONCENTRATIONS

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

### MIXING INSTRUCTIONS

- Using premixed coolant as makeup will substantially improve coolant performance and reduce coolant concentrate 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 AND SAFETY

See the most recent SDS at [2trim.us/s/?i=1021-en-US-US](http://2trim.us/s/?i=1021-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.
- C275 is a clear- to light-yellow product and not available with dye.
- 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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URL: [2trim.us/di/?i=12](http://2trim.us/di/?i=12)

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