



TRIM[®] C350

Premium Synthetic Metalworking Fluid

GENERAL DESCRIPTION

TRIM[®] C350 is a synthetic or chemical coolant optimized for the chemical, environmental, and machining requirements of the North American aerospace industry. C350 uses the best of the new ester technology to yield a very high performance, easy to use and maintain metal removal fluid. The combination of the proven synthetic ester technology and nonchlorinated EP package produce very high levels of usable lubricity at the point of cut. C350's unique chemical formula allows superior, nonferrous corrosion prevention particularly on aerospace aluminum alloys.

ADVANTAGES

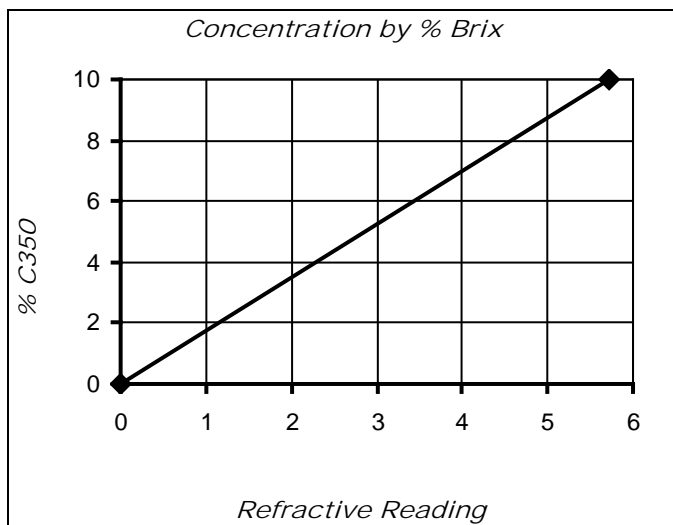
- Meets the most stringent nuclear and aerospace chemical content and machining requirements
- Superior resistance to corrosion on both nonferrous and ferrous materials including aerospace aluminums 7075, 2024, 3000, titanium, inconel, brass, and high-strength alloy steels
- Water clear, low foaming and misting, C350 is a joy to work with and manage
- Provides superior results in a wide range of operations from general grinding to spar milling and turbine blade manufacture
- Easily removed from parts for easy cleanup before assembly, painting, or plating operations
- PRTR compliant, no SARA 313 reportable chemistry. Product contains no chlorine, phenol, nitrites, copper, triazine, or silicone
- Very low carryoff and long sump life results in low operating cost

APPLICATION GUIDELINES

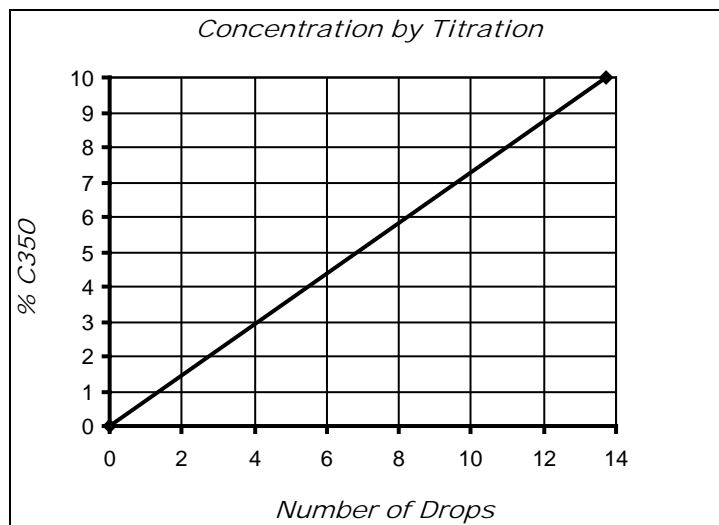
- Higher concentrations of C350 increase both boundary and EP lubrication.
- Very low foam at working temperatures above 80°F (27°C).
- Maintaining concentration from 7.5% to 10% provides the best sump life and corrosion inhibition.
- C350 is not recommended on cast irons.
- C350 should not be used on magnesium or other reactive metals without special precautions.
- 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).....	Colorless to Pale Yellow	Flash Point.....	>195°F (91°C) (ASTM D92-90
Color (working solution).....	Colorless to Pale Yellow	pH (Typical Operating as a range)	7.8-8.2
Odor.....	Mild amine	Coolant Refractometer Factor % Brix.....	1.8
Form	Liquid	Titration Factor (CGF-1 Titration Kit).....	0.730



% Concentration = Refractive Reading x Refractive Factor
Coolant Refractometer Factor % Brix = 1.8



% Concentration = No. of Drops x Titration Factor
Titration Factor = 0.730

RECOMMENDED METALWORKING CONCENTRATIONS

- Light and moderate-duty machining and grinding..... 6%-8%
- Moderate to heavy-duty machining and grinding..... 8%-10%
- Design concentration range 6%-10%

MIXING INSTRUCTIONS

- Using DI or mineral-free water will improve sump life, reduce concentrate usage, reduce carryoff, and improve corrosion inhibition.
- Synthetic products, such as C350, work best if mixed with room temperature water. Add the coolant concentrate to the water.
- Using premixed coolant as makeup will improve performance and reduce coolant purchases. The makeup concentration you use would typically be 5%-15% of the desired working concentration to maintain the proper concentration in the sump.

HEALTH AND SAFETY

For further information, see the most recent SDS at 2trim.us/s/?i=1066-en-US-US.



NOTES

- Use Master STAGES™ Whamex™ for a quick and thorough pre-cleaning of your machine tool and coolant system
- Before using on any metals or applications not specifically recommended, consult Master Chemical.
- This product should not be mixed with other metalworking fluids or metalworking fluid additives, except as recommended by Master Chemical Corporation, as this may reduce overall performance, result in adverse health effects, or damage the machine tool and parts. If contamination occurs, please contact Master Chemical Corporation for recommended action.
- C350 is colorless to pale yellow and is 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.

The information herein is given in good faith and believed current as of the date of this Data & Information sheet 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 Chemical Corporation for further information. For the most recent version of this document, please go to this URL: 2trim.us/di/?i=184

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