



TRIM[®] C380

Premium Ferrous Machining Synthetic

GENERAL DESCRIPTION

TRIM[®] C380 is a premium, synthetic, metalworking fluid optimized for high-tech ferrous materials including stainless steel and Inconel[®] which are widely used in aerospace, medical, and the electronics industries. C380 uses the best of the new ester technology to yield a very-high performance metal removal fluid that is, easy-to-use and maintain. The combination of the proven synthetic ester technology and nonhalogenated EP package produce very high levels of usable lubricity at the point of cut. C380 utilizes unique low-foam detergents to keep process soils from redepositing on machines and parts.

ADVANTAGES

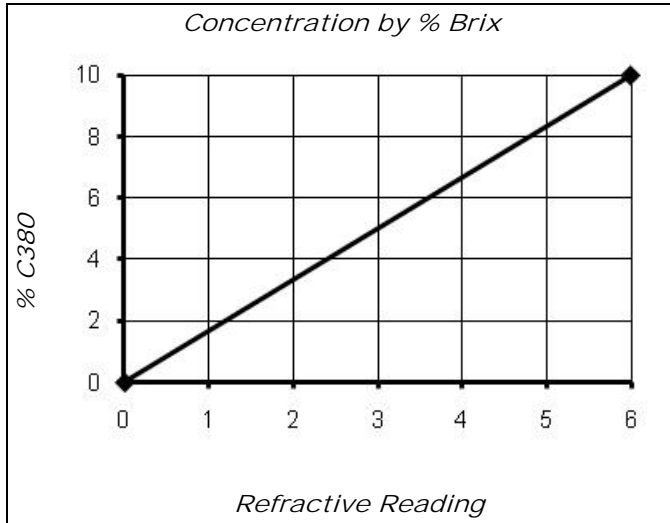
- Ease of maintenance, low carryoff, and long sump life result in low operating cost
- Clear, low foaming, low odor, and low mist create a clean manufacturing environment
- High performance in a wide range of operations from general grinding to heavy-duty machining
- Superior resistance to corrosion on ferrous materials including, titanium, Inconel, and high strength alloy steels
- Easily removed from parts for easy cleanup before assembly, painting, or plating operations
- Product readily rejects process oils such as hydraulic and way oils
- Excellent surface finish in finish-grinding operations
- PRTR compliant, no SARA 313 reportable chemistry
- Product contains no chlorine, phenol, nitrites, copper, triazine, silicone, or phosphorous

APPLICATION GUIDELINES

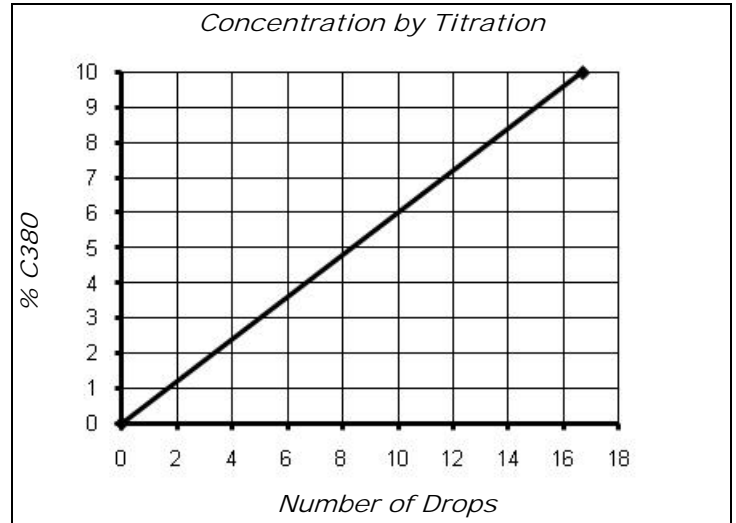
- Verify compatibility with specific nonferrous alloys before use.
- A higher concentration of C380 increases boundary lubrication.
- Operates with very low foam at working temperatures above 80°F.
- Maintaining concentration from 7.5%-10% provides the best sump life and corrosion inhibition.
- C380 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)	Light Yellow	Flash Point	Nonflammable (COC)
Color (working solution)	Clear	pH (Typical Operating as a range)	8.5-9.0
Odor	Mild amine	Coolant Refractometer Factor % Brix	1.7
Form	Liquid	Titration Factor (CGF-1 Titration Kit)	0.600



% Concentration = Refractive Reading x Refractive Factor
Coolant Refractometer Factor % Brix = 1.7



% Concentration = No. of Drops x Titration Factor
Titration Factor = 0.600

RECOMMENDED METALWORKING CONCENTRATIONS

- Light and moderate-duty machining and grinding..... 5%-7%
- Moderate to heavy-duty machining and grinding..... 7%-10%
- Design concentration range 5%-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 C380, 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=1067-en-US-US.



NOTES

- Use Master STAGES™ Whamex™ for a quick and thorough precleaning of your machine tool and coolant system prior to charge-up. Ensure all Whamex is completely rinsed from the system before charging to ensure low foam operating characteristics.
- 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.
- C380 working solution is typically clear 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=236