



TRIM[®] E850

Premium Emulsion

GENERAL DESCRIPTION

TRIM[®] E850 is a proprietary blend of new “green” vegetable-based technology and premium traditional lubricity additives to yield a very high-performance, easy-to-maintain metal removal fluid. This premium emulsion is operator friendly because of its mild contact nature and low chemical initial-charge odor. E850 is robust enough to deliver extended useful life and avoid rancid odors normally associated with traditional emulsions. The unparalleled physical lubricity delivers exceptional surface finish on difficult-to-machine aluminum alloys, exotics, stainless, and high-tensile strength steels.

ADVANTAGES

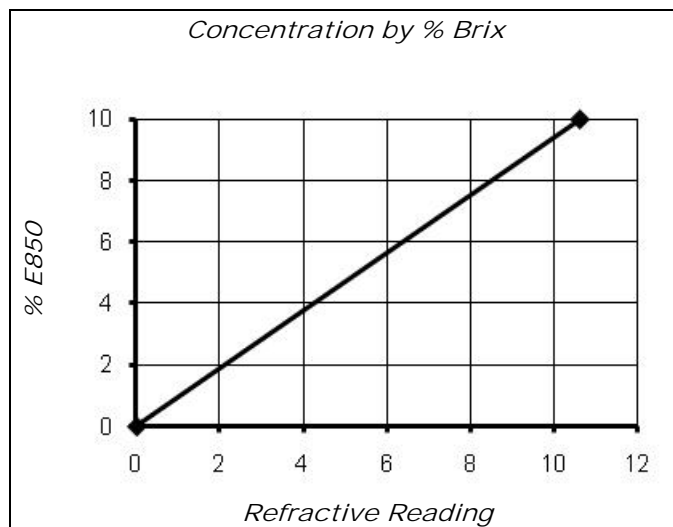
- Delivers unparalleled lubricity
- Boron and halogen free
- Very long sump life and low carryoff rates result in low operating cost
- Low product odor
- Mild operator contact properties
- Provides superior results in a wide range of operations
- Excellent corrosion resistance on both nonferrous and ferrous materials
- Superior wetting and penetration to the point of cut
- Soft fluid film protects ways, chucks, and tool holders
- Product contains no chlorine, phenol, nitride, copper, or triazine
- Easily removed from parts for easy cleanup before assembly, painting, or plating operations
- High performance without the use of chlorinated paraffins

APPLICATION GUIDELINES

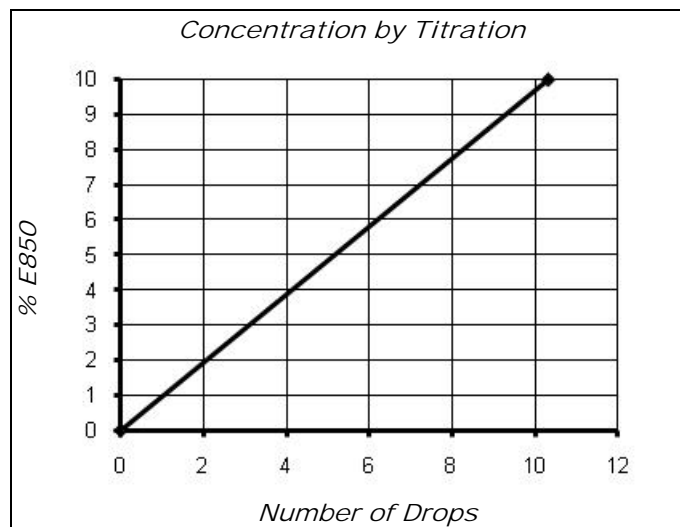
- Maintaining concentration from 7.5%-10% provides the best sump life and corrosion inhibition.
- E850 is not recommended on magnesium or other reactive materials.
- For additional product applications information including performance optimization, please contact your Master Chemical Authorized Distributor 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).....	Amber	Flash Point.....	>200°F (93°C) (PMCC)
Color (working solution).....	White	pH (Typical Operating as a range)	8.8-9.8
Odor.....	Mild	Coolant Refractometer Factor % Brix	0.9
Form	Liquid	Titration Factor (CGF-1 Titration Kit).....	.0.970



% Concentration = Refractive Reading x Refractive Factor
Coolant Refractometer Factor % Brix = 0.9



% Concentration = No. of Drops x Titration Factor
Titration Factor = 0.970

RECOMMENDED METALWORKING CONCENTRATIONS

Light and moderate-duty machining and grinding..... 5%-7.5%
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.
- Emulsion products, such as E850, work best if mixed with room temperature water. Add the coolant concentrate to the water; NEVER THE REVERSE.
- Using premixed coolant as makeup will improve performance and reduce coolant purchases. The makeup concentration you use, typically 40%-60% of the desired working concentration, will generally maintain the proper concentration in the sump.

HEALTH AND SAFETY

See the most recent MSDS at 2trim.us/ms/?i=10030.



NOTES

- Use Master STAGES™ Whamex™ for a quick and thorough pre-cleaning of your machine tool and coolant system. 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.
- E850 working solution is a white emulsion.
- 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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