



TRIM[®] REGULAR

Synthetic

GENERAL DESCRIPTION

TRIM[®] REGULAR is a chemical surface active or synthetic coolant concentrate designed for general machining and grinding of ferrous materials. It is particularly well suited for machining cast iron, but is an exceptional grinding and high velocity turning and milling fluid. REGULAR contains no sulfur, chlorine, or phosphorus, and meets the requirements of even the most restrictive chemical specifications.

ADVANTAGES

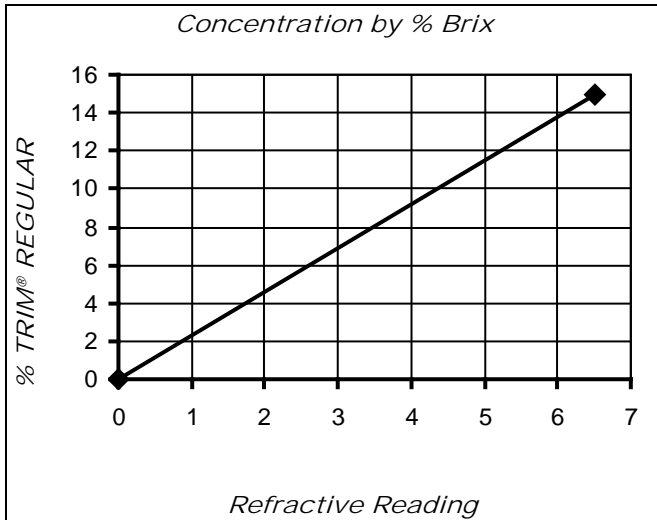
- Provides rapid and effective cooling
- Keeps grinding wheels clean and free of loading
- Has significant levels of specialized wetting agents for boundary lubrications even at very high SFPM
- Has superior anti-weld action to control built-up edge and chip welding
- Compatible with ferrous and nonferrous metals as well as most nonmetallic materials
- Is exceptionally clean and oil free to promote a clean, safe work environment
- Will keep your machines clean while leaving a soft, fluid film that protects the bare metal parts of your machine tools

APPLICATION GUIDELINES

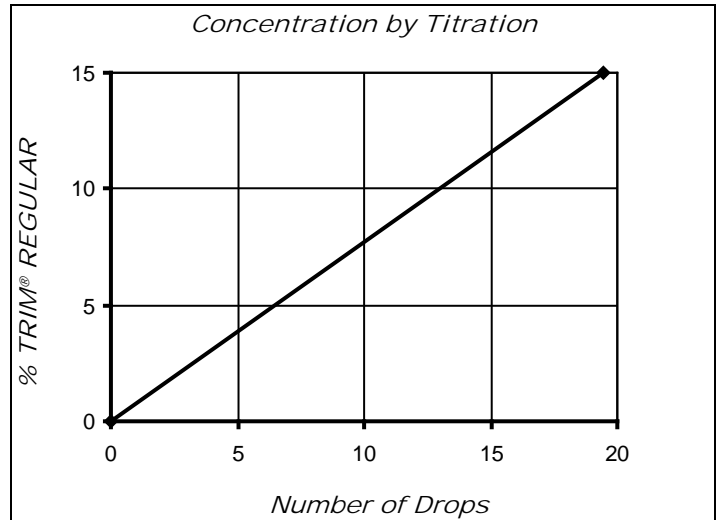
- REGULAR is not recommended for use on reactive metals like magnesium or zirconium.
- The minimum recommended concentration is 5% on all materials; however, higher concentrations give better sump life, tool life, and corrosion control.
- REGULAR will foam more at higher concentrations, but care should be used to prevent adding too much antifoam.
- REGULAR is best when used in high-speed machining situations; however, at higher concentrations (7.5% plus) it exhibits significant levels of slip lubrication as well.
- REGULAR works as a light to moderate-duty stamping and drawing fluid at higher concentrations or in its neat form.
- 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).....	Straw	Flash Point.....	>216°F (102°C) (ASTM D93-08)
Color (Working Solution).....	Colorless	pH (Typical Operating as a Range).....	8.3-8.9
Odor.....	Mild pine	Coolant Refractometer Factor % Brix.....	2.3
Form.....	Gel	Titration Factor (CGF-1 Titration Kit).....	0.770



% Concentration = Refractive Reading x Refractive Factor
Coolant Refractometer Factor % Brix = 2.3



% Concentration = No. of Drops x Titration Factor
Titration Factor = 0.770

RECOMMENDED METALWORKING CONCENTRATIONS

Light-duty machining and grinding	5%-6%
Moderate-duty machining and grinding	6%-8%
Heavy-duty machining and grinding	8%-10%
Design application range	4%-15%

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. However, adding makeup coolant at 20%-40% of the desired working concentration will generally maintain the proper working concentration.
- 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=1027-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, except as 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.
- REGULAR is a colorless product 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.

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