



TRIM[®] VHP[®] E812

Very High-pressure, Chlorine-free Emulsion

GENERAL DESCRIPTION

TRIM[®] VHP[®] E812 is a low- to no-foam, chlorine-free emulsion. It is ideally suited for those operations that utilize high-pressure, high-volume coolant. VHP[®] E812 is a fluid that will allow you to get maximum benefits from high velocity through-the-tool coolant delivery systems on VMCs and HMCs and will assist in achieving the maximum productivity from creepfeed grinders as well. While VHP[®] E812 is very stable and is both operator and environmentally “friendly”, its greatest strength comes from its ability to help you get the job done. It is compatible with all metals and many nonmetallic materials as well. Even with a product as “gutsy” as VHP[®] E812 it will run for extended periods of time without adds and will do so in a very clean manner. VHP[®] E812 has a Pratt Whitney approval (PMC 9393).

ADVANTAGES

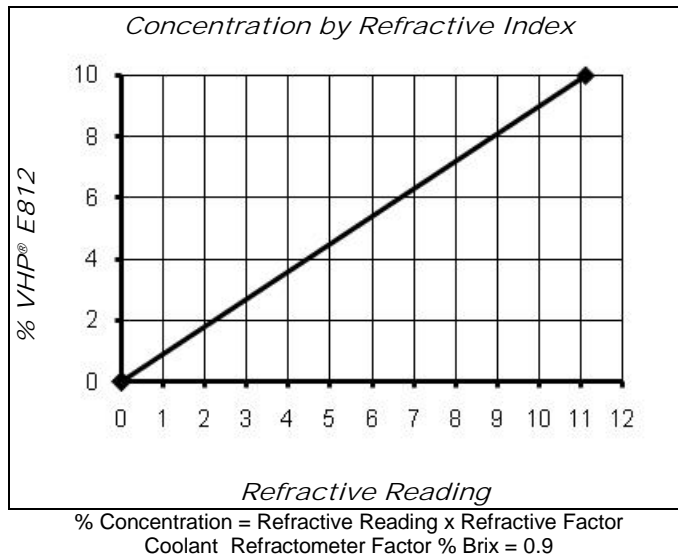
- A very versatile product that works well in a wide range of operations such as production, creepfeed grinding and milling, turning, drilling, and tapping
- Proven performer in difficult creepfeed grinding operations
- Extremely fine soluble oil emulsion reduces carryoff for low total operating cost
- Fast wetting to get the fluid to the point of cut and fully coat the work piece and chips for superior corrosion prevention
- Very low foam, without the use of conventional defoamers
- Easily recycled or disposed of without special handling or equipment
- Contains no DEA, chlorine, nitrites, triazine, or phenolic compounds

APPLICATION GUIDELINES

- VHP[®] E812 can be recycled and run effectively for long periods of time.
- It can run at lower concentrations for higher speed operations (where heat removal is the key issue).
- Higher concentrations are recommended on soft, gummy materials and for lower speed operations where friction reduction and control of built-up edge are critical.
- Concentrations above 7% provide the best sump life.
- 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).....	Dark amber	Flash Point.....	None to boiling (ASTM D93-08)
Color (Working Solution).....	Milky white	pH (Typical Operating Range).....	8.0-9.5
Odor.....	Mild amine	Coolant Refractometer Factor % Brix.....	0.9
Form.....	Liquid	Titration Factor (CGF-1 Titration Kit).....	N/A



RECOMMENDED METALWORKING CONCENTRATIONS

Light-duty machining and grinding	3%-5%
Moderate-duty machining.....	5%-7%
Heavy-duty machining.....	7%-10%
Very heavy-duty machining.....	10%
Recommended concentration range	3%-10%

MIXING INSTRUCTIONS

- Using DI or mineral-free water will improve sump life, reduce concentrate usage, reduce carryoff, and improve corrosion inhibition. As a general rule, this product should not be mixed with water harder than 10 grains.
- Emulsion products such as VHP® E812 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 select should balance the water evaporation rate with the coolant carryout rate. (Adding makeup coolant at 30%-40% of the desired working concentration will generally maintain the proper concentration in the sump.)

HEALTH & SAFETY

See the most recent SDS 2trim.us/s/?i=1031-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.
- 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 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.
- VHP® E812 working solution is a milky white emulsion.
- Packaging: North America – 5-gallon pail, 54-gallon drum, 270-gallon recyclable bin, and tank wagon lot; Europe/Asia – 20-litre pail, 204-litre drum, 1000-litre IBC.

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