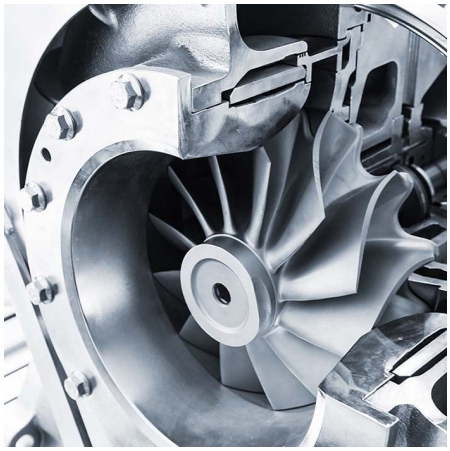
# TRIM® E860

## *Low-foam, High-lubricity Emulsion*

TRIM E860 is a high-quality, general purpose emulsion for use on a broad range of ferrous and nonferrous metals, effective in most cutting and grinding operations. The stable and predictable performance of E860 makes it a first choice for precision and consistent parts manufacturing.

***Leading Indian Auto and Aerospace Parts Manufacturer Lowers Coolant Consumption by 22% with TRIM®***



*The customer established their operation in India in 1991 to manufacture aftermarket brake parts for the North American market. In 1995, the company expanded to include master cylinder castings, turbocharger components, and numerous other specialty automotive and aerospace products. Dedicated to fostering talent, a majority of their team has been with the company for more than a decade, helping them grow into a global leader with over $100 million in annual revenue.*

### Choose E860:

- Very wide application range
- Good hard water tolerance
- Keeps machine tools clean
- Works very well in general machining
- Very stable formula provides good operational life with consistent performance
- High tramp oil resistance for easy oil removal and longer coolant life
- Easily recycled or disposed of using conventional techniques and equipment
- Good balance of cooling and lubrication providing good tool life and surface finishes
- Leaves a very light, oily, non-gumming residue to prevent sticky ways, chucks, tool holders, and fixtures
- Extremely stable fine particle size emulsion allows for reduced carry-off and super-high penetrability to get the fluid to the point of cut

### E860 especially for:

**Applications** — boring, centerless grinding, deep hole drilling, drilling, high-speed milling, high-speed turning, machining, milling, reaming, sawing, tapping, and turning

**Materials** — aluminum, brass, cast aluminum, cast iron, ferrous metals, nonferrous metals, stainless steels, and steels

**Industries** — aerospace, automotive, energy, general fabrication, and medical

**E860 is free of —** biocides, phenolic compounds, and sulfur

Master Fluid SOLUTIONS®

# TRIM® E860

***Low-foam, High-lubricity Emulsion***

## Application Guidelines

- Machining copper may cause coolant to develop a bluish tint.
- Running at or above 7.5% offers the best sump life and corrosion inhibition.
- In mixed metal situations, keep concentration above 7.5% to minimize galvanic corrosion.
- Foam can be caused due to mechanical reasons, so if foam appears, diagnose the cause of foaming before adding antifoam.
- For additional product application information, including performance optimization, please contact your Master Fluid Solutions' Authorized Distributor at https://www.masterfluids.com/na/en-us/distributors/index.php, your District Sales Manager, or call our Tech Line at 1-800-537-3365.

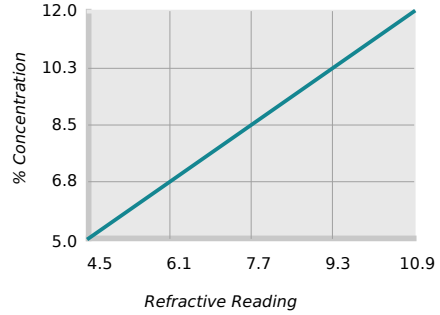
## Physical Properties Typical Data

| | |
|---|---|
| Color (Concentrate) | Yellow |
| Color (Working Solution) | Opaque |
| Odor (Concentrate) | Mild |
| Form (Concentrate) | Liquid |
| Flash Point (Concentrate) (ASTM D92-90) | > 212°F |
| pH (Typical Operating as Range) | 8.8 - 9.8 |
| Coolant Refractometer Factor | 1.1 |
| V.O.C. Content (ASTM E1868-10) | 142 g/l |

## Recommended Metalworking Concentrations

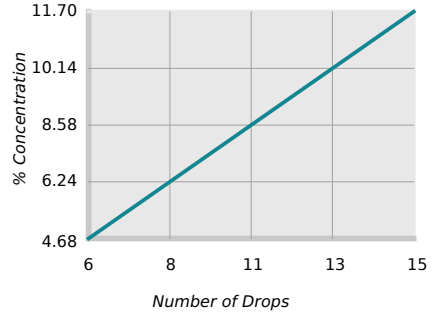
| | |
|---|---|
| Light Duty | 5.0% - 7.0% |
| Moderate Duty | 7.0% - 9.0% |
| Heavy Duty | 9.0% - 12.0% |
| Design Concentration Range | 5.0% - 12.0% |

## Concentration by % Brix




% Concentration = Refractive Reading x Refractive Factor
Coolant Refractometer Factor % Brix = 1.1

## Concentration by Titration




% Concentration = No. of Drops x Titration Factor
Titration Factor = 0.78

Request SDS

Master Fluid SOLUTIONS®

# TRIM® E860

## *Low-foam, High-lubricity Emulsion*

## Mixing Instructions

- Recommended usage concentration in water: 5.0% - 12.0%.
- To help ensure the best possible working solution, add the required amount of concentrate to the required amount of water (never the reverse) and stir until uniformly mixed.
- Use premixed coolant as makeup to improve coolant performance and reduce coolant purchases. The makeup you select should balance the water evaporation rate with the coolant carryout rate. Use our Coolant Makeup Calculator to find the best ratio for your machine: apps.masterfluids.com/makeup/.
- Use mineral-free water to improve sump life and corrosion inhibition while reducing carryoff and concentrate usage.



1-gallon jug
SKU: E860-1G
UPC-12: 641238081845



5-gallon pail
SKU: E860-5G
UPC-12: 641238081869




54-gallon drum
SKU: E860-54G
UPC-12: 641238081876



270-gallon tote
SKU: E860-270G
UPC-12: 641238081883

## Additional Information

- Use Master STAGES™ Whamex™ for a quick and thorough precleaning of your machine tool and coolant system.
- Consult Master Fluid Solutions before using on any metals or applications not specifically recommended.
- This product should not be mixed with other metalworking fluids or metalworking fluid additives, except as recommended by Master Fluid Solutions, as this may reduce overall performance, result in adverse health effects, or damage the machine tool and parts. If contamination occurs, please contact Master Fluid Solutions for recommended action.
- TRIM® is a registered trademark of Master Chemical Corporation d/b/a Master Fluid Solutions.
- Master STAGES™ and Whamex™ are trademarks of Master Chemical Corporation d/b/a Master Fluid Solutions.
- The information herein is given in good faith and believed current as of the date of publication 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 Fluid Solutions for further information. For the most recent version of this document, please go to this URL:

https://2trim.us/di/?i=na_en-us_E860



501 West Boundary Street
Perrysburg, OH 43551-1200
United States
+1 419-874-7902

info@masterfluids.com

masterfluids.com/na/en-us/