# TRIM® E925

## *Chlorine-free, High-performance Emulsion*

TRIM E925 utilizes a proprietary lubricity package to deliver exceptional surface finish and tool life on difficult-to-machine aerospace materials. Designed to lower total cost and improve manufacturing efficiency thanks to extended sump life. Environmentally friendly emulsion is free of boron, chlorinated paraffins, and other halogens. Mild contact nature and low initial-charge odor provide an operator friendly environment.

## *Emulsions*



***Geared up for production:***

*With superior lubricity and a higher oil content, TRIM emulsions provide a greater boundary layer between the tool and the material, and are ideal for heavy-duty applications such as broaching, reaming, deep hole drilling, drilling, tapping, and centerless grinding.*

*TRIM emulsions work well for machining copper, yellow metals, steel alloys, cast aluminums, wrought aluminums, and tough-to-machine titanium and nickel-based alloys.*

## *Aerospace Approvals*

| Company | Specification |
|---|---|
| Raytheon Technologies/Collins Aerospace/Pratt & Whitney | PMC 9313 |

## Choose E925:

- Extended sump life for lower operating costs
- Protects sensitive aluminum and nonferrous alloys
- Excellent lubricity without chlorinated paraffins
- Provides superior results in a wide range of operations
- Superior corrosion resistance
- Appropriate for most high-pressure systems
- Low product odor
- Mild operator contact properties
- Soft fluid film protects chucks, ways, and tool holders
- Rinses off for easy parts cleanup before assembly, painting, or plating

## E925 especially for:

**Applications** — band sawing, centerless grinding, corrosion inhibition, creep-feed grinding, drilling, form cylindrical grinding, internal grinding, reaming, sawing, surface grinding, tapping, through-feed centerless grinding, and turning

**Materials** — 6000 series aluminum, aerospace alloys, aerospace aluminum alloys, aluminum, brass, bronze, cast aluminum, composites, copper, glass, heat-treated steel, high-carbon steel, high-nickel alloys, nonferrous metals, plastics, stainless steels, steels, and titanium

**Industries** — aerospace and firearms

**E925 is free of —** boron, chlorinated paraffin, chlorine, and halogens

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## Application Guidelines

- Maintaining concentration from 7.5%-10% provides the best sump life and corrosion inhibition.
- Not recommended on magnesium or other reactive materials.
- 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.

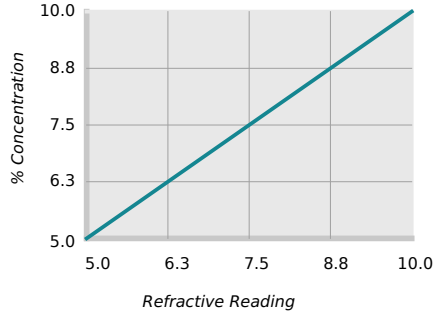
## Physical Properties Typical Data

| | |
|---|---|
| Color (Concentrate) | Yellow to amber |
| Color (Working Solution) | White |
| Odor (Concentrate) | Mild amine |
| Form (Concentrate) | Liquid |
| Flash Point (Concentrate) (ASTM D93-08) | > 248°F |
| pH (Concentrate as Range) | 9.6 - 10.1 |
| pH (Typical Operating as Range) | 8.8 - 10.0 |
| Coolant Refractometer Factor | 1.0 |
| V.O.C. Content (ASTM E1868-10) | 156 g/l |

## Recommended Metalworking Concentrations

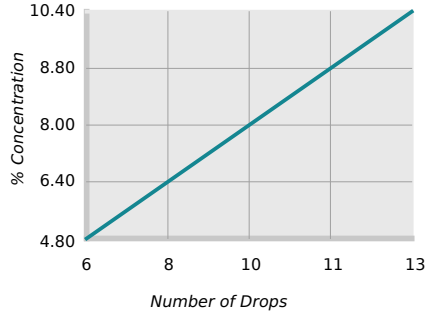
| | |
|---|---|
| Light Duty | 5.0% - 6.5% |
| Moderate Duty | 6.5% - 8.5% |
| Heavy Duty | 8.5% - 10.0% |
| Design Concentration Range | 5.0% - 10.0% |

## Concentration by % Brix




% Concentration = Refractive Reading x Refractive Factor
Coolant Refractometer Factor % Brix = 1.0

## Concentration by Titration




% Concentration = No. of Drops x Titration Factor
Titration Factor = 0.80

Request SDS

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## Mixing Instructions

- Recommended usage concentration in water: 5.0% - 10.0%.
- 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: E925-1G
UPC-12: 641238073703



5-gallon pail
SKU: E925-5G
UPC-12: 641238073697




54-gallon drum
SKU: E925-54G
UPC-12: 641238073680



270-gallon tote
SKU: E925-270G
UPC-12: 641238073741

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## 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.
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