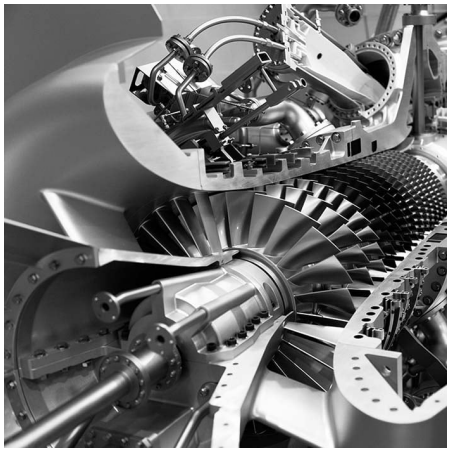
TRIM® E950

High Performance Machining Emulsion

TRIM E950 is a proprietary blend of new vegetable-based technology and premium traditional lubricity additives to yield a very high performance, low management metal removal fluid. This premium emulsion product is operator friendly because of its mild contact nature and low chemical initial-charge odor. TRIM E950 is robust enough to deliver extended useful life and avoid rancid odors normally associated with traditional emulsions. The unparalleled lubricity delivers exceptional surface finish and tool life on difficult to machine aluminum alloys, inconel, titanium, stainless, and high tensile strength steels.

Precision Parts Manufacturer Saves 40% on Cutting Fluid With TRIM® E950



The customer is a large-scale precision parts manufacturer that serves the aerospace and energy sectors. Their high- volume facility includes more than 40 CNC machines that carry out turning, drilling, machining, and grinding operations on challenging materials including aluminum, Inconel®, titanium, and stainless steel.

Aerospace Approvals

Company	Specification
GE AVIO	TN0989
Rolls-Royce	CSS 129, CSS 131
Safran Group	PR6300

Choose E950:

- Delivers unparalleled lubricity
- Very long sump life and low carry-off rates result in low operating cost
- Low foam even in soft water areas
- Hard water tolerant
- Non-chlorinated and non-sulphurised extreme pressure (EP) additives control built-up edge (BUE) in tough operations on aerospace materials
- Fine emulsion ensures fast wetting to get the fluid to the point of cut and fully coat the workpiece and chips for superior tool life and corrosion prevention
- Compatible with all materials excluding magnesium
- Easily recycled or disposed of without special handling or equipment
- Will run effectively for long periods without the need for costly additives

E950 especially for:

Applications — boring, broaching, deep hole drilling, down the hole work, drilling, gear cutting, heavy-duty machining center work, high-pressure, high-volume, high-speed milling, high-speed turning, honing, milling, reaming, roll threading, tapping, thread forming, thread rolling, and turning

Metals — cast aluminum, cast iron, copper, nickel alloys, nonferrous metals, stainless steels, steel alloys, steels, titanium, wrought aluminum, and yellow metals

Industries — aerospace, automotive, energy, and medical

E950 is free of — boron, chlorine, formaldehyde releasers, nitrites, phenolic compounds, and sulfurized EP additives

Master Fluid SOLUTIONS®

TRIM® E950

High Performance Machining Emulsion

Application Guidelines

- Use higher concentrations for lower speed metal cutting operations where maximum lubricity is required and lower concentrations for operations requiring more cooling.
- Running at concentrations between 7 – 10% offers the best sump life and corrosion inhibition.
- 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.

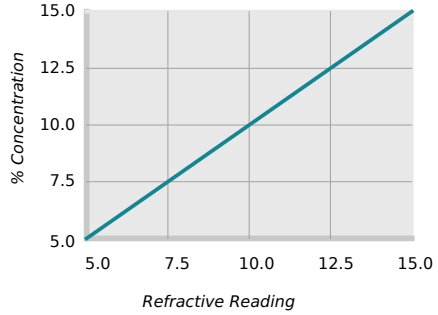
Physical Properties Typical Data

Color (Concentrate)	Light yellow to amber
Color (Working Solution)	Opaque white
Odor (Concentrate)	Mild amine
Form (Concentrate)	Liquid
Flash Point (Concentrate) (ASTM D93-08)	> 212°F
pH (Concentrate as Range)	8.7 - 9.7
pH (Typical Operating as Range)	8.6 - 9.6
Coolant Refractometer Factor	1.0
Titration Factor (CGF-1 Titration Kit)	1.22
Digital Titration Factor	0.0380
V.O.C. Content (ASTM E1868-10)	8.0 g/l

Recommended Metalworking Concentrations

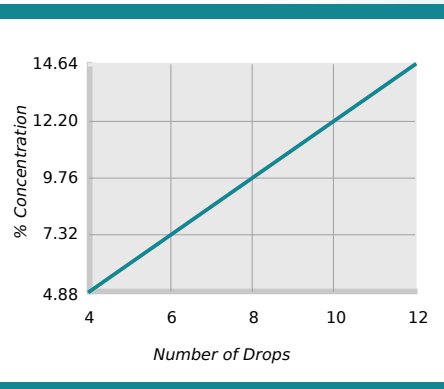
Light Duty	5.0% - 8.0%
Moderate Duty	8.0% - 10.0%
Heavy Duty	10.0% - 15.0%
Design Concentration Range	5.0% - 15.0%

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 = 1.22

Health and Safety

Request SDS

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Mixing Instructions

- Recommended usage concentration in water: 5.0% - 15.0%.
- 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: E950-1G
UPC-12: 641238083320

5-gallon pail
SKU: E950-5G
UPC-12: 641238083375

54-gallon drum
SKU: E950-54G
UPC-12: 641238083382

270-gallon tote
SKU: E950-270G
UPC-12: 641238083399

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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https://2trim.us/di/?i=na_en-us_E950

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

info@masterfluids.com

masterfluids.com/na/en-us/