TRIM™ C115

Synthetic

TRIM C115 is a high-performance, synthetic fluid for working cast iron and mild steels. State-of-the-art chemical technology provides excellent cooling and chip settling, good tramp oil rejection, and machine cleanliness while leaving a protective film on the machine tool.

Manufacturer Eliminates Coolant Concerns with TRIM™ C115RT



Established in 1982, the customer, a leading manufacturer of industrial machinery, performs precision machining operations such as shaft and surface grinding in steel alloys.

Aerospace Approvals

Company	Specification
General Dynamics	HSDS070234-01
Goodrich	No specification available
Lockheed Martin/Sikorsky	No specification available

Choose C115:

- Does an excellent job in most glass, ceramic, and composite grinding applications
- Excellent corrosion inhibition on most common ferrous and nonferrous alloys
- Extremely low carryoff keeps operating costs down
- Low foam and mist
- Very low initial odor level which usually disappears after one-to-two days
- Keeps your machines clean while leaving a soft, fluid film that protects bare metal parts
- Exceptional sump life and very good tramp oil rejection

C115 especially for:

Applications — belt grinding, Blanchard grinding, cooling, cutting, cylindrical grinding, double disc grinding, drilling, form cylindrical grinding, grinding, internal grinding, plain grinding, reaming, surface grinding, surface milling, tapping, and turning

Materials — cast iron, ceramic, composites, glass, plastics, steels, and tool steels

Industries — aerospace, automotive, compressor, and job shop

C115 is free of — animal derived materials, boron, chlorinated EP additives, DCHA, formaldehyde releasers, nitrites, NPEs, phosphorous, siloxane, and sulfurized EP additives

Master Fluid SOLUTIONS™

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Application Guidelines

- C115 is not recommended in machine tools that rely on coolant splash to lubricate the mechanical portions of the machine tool; e.g., older screw machines, etc.
- Foam may increase if the temperature is below 80°F (27°C) at the point of agitation.
- C115 is not recommended on materials (i.e., magnesium or zirconium) without special precautions.
- This product is a superior cleaning agent so it may "wash out" dirt and residues when a machine is first charged; a thorough cleaning of older machines is required when installing this product for the first time.
- The minimum recommended concentration is 5% on cast iron, 4% on steel, and 5% in glass grinding.
- Concentrations above 7.5% provide the best corrosion inhibition, tool life, and sump life; however, on-site testing is usually the best way to set your concentration.
- For additional product application information, including performance optimization, please contact your Master Fluid Solutions' Authorized Distributor at https://www.masterfluids.com/th/en-th/distributors/index.php or your District Sales Manager, or email us at thailand-info@masterfluids.com.

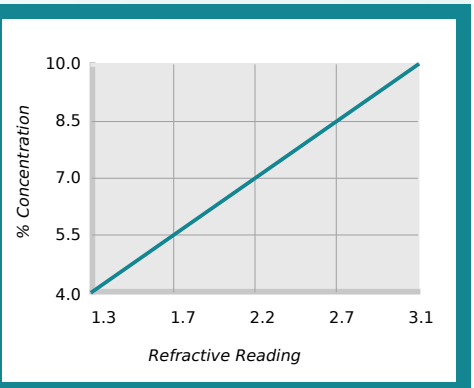
Physical Properties Typical Data

Color (Concentrate)	Pale yellow
Color (Working Solution)	Colorless
Odor (Concentrate)	Mild, sweet
Form (Concentrate)	Liquid
Flash Point (Concentrate) (ASTM D93-08)	> 104°C
pH (Concentrate as Range)	9.6 - 9.8
pH (Typical Operating as Range)	8.8 - 9.6
Coolant Refractometer Factor	3.2
V.O.C. Content (ASTM E1868-10)	100 g/l

Recommended Metalworking Concentrations

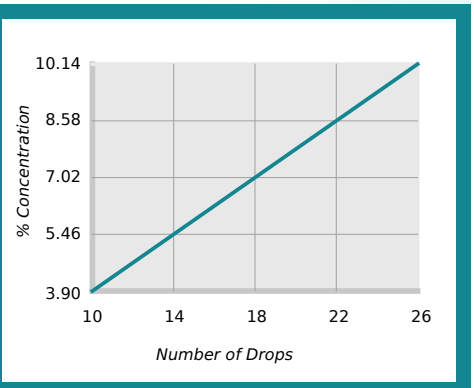
Light Duty	4.0% - 6.5%
Moderate Duty	6.5% - 8.5%
Heavy Duty	8.5% - 10.0%
Design Concentration Range	4.0% - 10.0%

Concentration by % Brix



% Concentration = Refractive Reading x Refractive Factor
Coolant Refractometer Factor % Brix = 3.2

Concentration by Titration



% Concentration = No. of Drops x Titration Factor
Titration Factor = 0.39

Request SDS

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Mixing Instructions

- Recommended usage concentration in water: 4.0% - 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.

Ordering Information

20-liter pail

204-liter drum

Additional Information

- Use Master STAGES™ Whamex XT™ 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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- Master STAGES™ and Whamex XT™ are trademarks of Master Chemical Corporation d/b/a Master Fluid Solutions.
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