

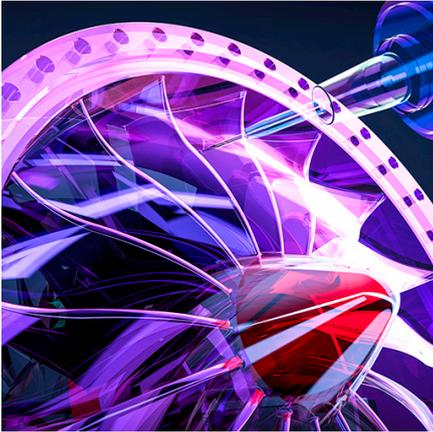
# C272

## Cutting and Grinding Fluid Concentrate



TRIM<sup>®</sup> C272 is a synthetic coolant concentrate designed to operate at very high fluid pressures and volumes with little or no foam. TRIM C272 is ideally suited to situations where high coolant velocities or volumes are necessary to achieve maximum productivity. TRIM C272 is designed to have the superior cooling and chip settling characteristics of a premium synthetic product with the improved residues and mechanical lubricity of a semi-synthetic coolant. This product utilises an extremely effective and proprietary non-chlorine, non-sulphur extreme pressure additive for good tool life and improved surface finishes

### Synthetics



#### **Viper Grinding with TRIM<sup>®</sup> C272**

*A manufacture of Aerospace turbines blades had poor coolant filtration caused by foaming of fluid. Additionally they had burning issues on their parts. Their 10 micron filter cartridge was being changed every day until it was removed altogether. This led to other production problems, including premature high pressure pump wear.*

*Changing coolant to TRIM C272, the 10 micron filter cartridge could be re-introduced and filter life went from 1 per day to 1 per 3 months! Coolant foaming disappeared, grinding wheel life increased and burning parts were eliminated. Now sump life is in excess of 2 years.*

### Choose C272:

- Approved by the following aero engine OEMs – Rolls-Royce, GE and Safran Aero Engines, contact your Master Fluid Solutions representative for the relevant approval documentation
- Very stable formula provides long operational life with consistent performance
- Extremely low foam in mineral free water
- Excellent tramp oil rejection
- Water clear dilution aids filterability, reduces carryoff and facilitates getting the fluid to the point of cut
- Protects machine and tool surfaces while also preventing sticky ways, chucks, tool holders and fixtures
- Easy recycling or disposal with conventional techniques and equipment

### C272 especially for:

**Applications** — grinding, high-speed milling and high-speed turning

**Metals** — cast iron, nickel alloys, stainless steels, steel alloys and titanium

**Industries** — aerospace

**C272 is free of** — boron, chlorine, DEA, formaldehyde releasers, nitrites, phenolic compounds and sulphurised EP additives

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## Cutting and Grinding Fluid Concentrate



### Application Guidelines

- Minimum concentration for ferrous alloy machining and grinding is 4%.
- Concentrations above 7% provide the best sump life.
- For additional product application information, including performance optimisation, please contact your Master Fluid Solutions Authorised Distributor at <https://www.2trim.us/distributors.php>, your District Sales Manager, or call our Tech Line at +44 (0)1449 726808.

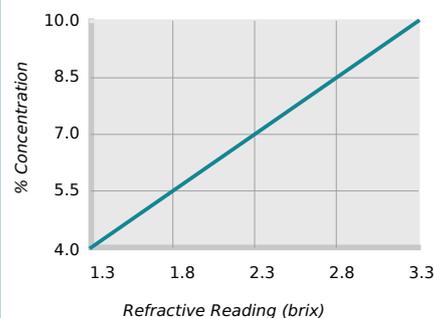
### Physical Properties Typical Data

Colour (Concentrate)	Pale straw
Odour (Concentrate)	Mild amine
Form (Concentrate)	Liquid
Flash Point (Concentrate) (ASTM D93-08)	> 160°C
pH (Concentrate as Range)	9.1 - 10.1
pH (Typical Operating as Range)	8.8 - 9.4
Coolant Refractometer Factor	3.0
Digital Titration Factor	0.0249

### 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



$\% \text{ Concentration} = \text{Refractive Reading} \times \text{Refractive Factor}$   
Coolant Refractometer Factor % Brix = 3.0

### Health and Safety

For further information, see the most recent SDS, which is available directly from Master Fluid Solutions or from your Master Fluid Solutions Authorised Distributor.

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## Cutting and Grinding Fluid Concentrate



### 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.masterfluidsolutions.com/makeup/](https://apps.masterfluidsolutions.com/makeup/)
- Use mineral-free water to improve sump life and corrosion inhibition while reducing carryoff and concentrate usage.

### Ordering Information

20-litre pail

204-litre drum

1000-litre IBC

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### Additional Information

- Use Master STAGES™ Whamex XT™ for a quick and thorough precleaning of your machine tool and coolant system.
- Before using on any metals or applications not specifically recommended, consult Master Fluid Solutions.
- 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/?plr=C272\\*en\\*eu](https://2trim.us/di/?plr=C272*en*eu)



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