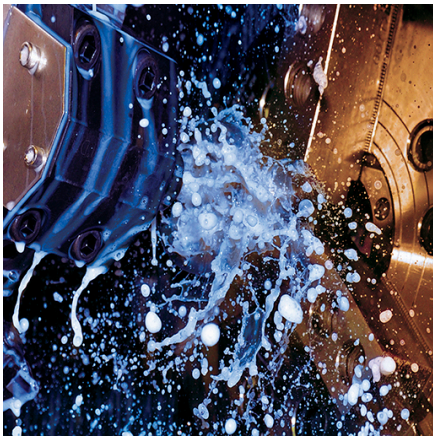


# E806

## Magnesium and multi-metal machining emulsion

TRIM<sup>®</sup> E806 is a truly unique metalworking fluid emulsion concentrate with unparalleled metal compatibility and all round machining performance characteristics. The product is primarily designed for machining magnesium alloys used in the aerospace, automotive and general industry sectors. TRIM E806 does not tarnish the most sensitive magnesium alloys even after relatively long exposure times plus it is impervious to magnesium salt build-up in the sump - something which splits normal emulsions in a matter of days. Another problem with magnesium machining, hydrogen gas evolution, is virtually nil with TRIM E806. The product also has the lubricity and extreme pressure performance to machine other alloys commonly seen in the aerospace industry such as wrought aluminiums, stainless steels, inconel<sup>®</sup> and titanium.

### Soluble Oils



#### Geared up for production:

*With superior mechanical lubricity and a higher oil content, TRIM<sup>®</sup> emulsions provide a greater boundary layer between the tool and the material. Emulsions are ideal for lower, less than 600 SFPM, applications such as broaching, reaming, deep hole drilling, drilling, tapping and centerless grinding.*

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

*Gear up with the TRIM emulsion designed to meet your production needs.*



#### Choose E806:

- Safe for use on even the most sensitive magnesium alloys
- Little or no hydrogen gas evolution when machining magnesium
- Bio package extends useful life without the need for tank-side biocides or fungicides
- Low foaming for today's demanding high-pressure, high-volume applications

#### E806 especially for:

**Applications** — boring, centerless grinding, deep hole drilling, drilling, heavy-duty machining center work, high-pressure, high-volume, high-speed milling, high-speed turning, milling, reaming, roll threading, sawing, tapping, thread forming and turning

**Metals** — aluminium alloys, magnesium alloys, nickel alloys, steel alloys and titanium alloys

**Industries** — aerospace, automotive, energy and general industry

**E806 is free of** — boron, chlorine, formaldehyde releasers, phenolic compounds and sulphurised EP additives

# E806

## Magnesium and multi-metal 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 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

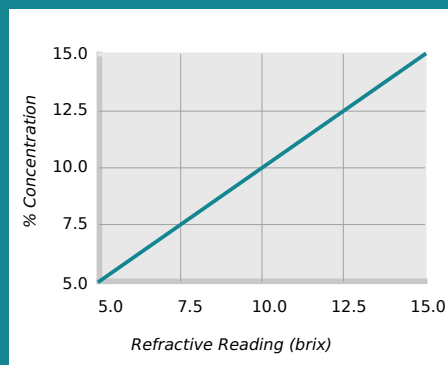
Colour (Concentrate)	Brown
Colour (Working Solution)	Milky white
Odour (Concentrate)	Mild amine
Form (Concentrate)	Liquid
Flash Point (Concentrate) (ASTM D93-08)	> 160°C
pH (Concentrate as Range)	9.6 - 9.9
pH (Typical Operating as Range)	9.2 - 10.0
Coolant Refractometer Factor	1.0

### Recommended Metalworking Concentrations

Light duty	5.0% - 7.5%
Moderate duty	7.5% - 9.5%
Heavy duty	9.5% - 15.0%
Design Concentration Range	5.0% - 15.0%



### Concentration by % Brix



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

### 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.

# E806

## Magnesium and multi-metal machining emulsion



### 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.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

TRIM® E806 | ©2017-2019 Master Fluid Solutions™ | 2019-07-08

### Additional Information

- Use Master STAGES™ Whamex™ 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.

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/?plr=E806\\*en\\*eu](https://2trim.us/di/?plr=E806*en*eu)



Master Fluid Solutions  
33 Maitland Road, Lion Barn Business Park  
Needham Market  
Suffolk, IP6 8NZ  
United Kingdom

+44 (0) 1449-726800  
[info@masterchemical.co.uk](mailto:info@masterchemical.co.uk)  
[masterfluidsolutions.com/eu/en/](https://masterfluidsolutions.com/eu/en/)

