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 odour. TRIM E950 is robust enough to deliver extended useful life and avoid rancid odours normally associated with traditional emulsions. The unparalleled lubricity delivers exceptional surface finish and tool life on difficult to machine aluminium alloys, inconel, titanium, stainless and high tensile strength steels.

Soluble Oils

Geared up for production:

With superior mechanical lubricity and a higher oil content, TRIM® 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 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 work piece 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 aluminium, copper, nickel alloys, steel alloys, titanium, wrought aluminium and yellow metals

Industries — aerospace, automotive, energy and medical

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

Master Fluid SOLUTIONS™

E950

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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.

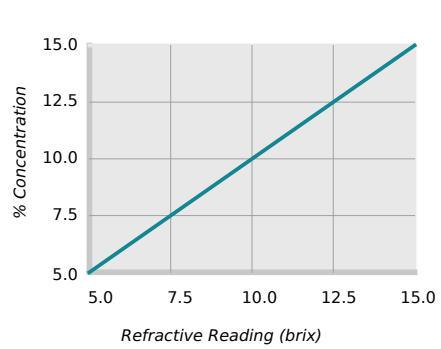
Physical Properties Typical Data

Colour (Concentrate)	Amber
Odour (Concentrate)	Mild amine
Form (Concentrate)	Liquid
Flash Point (Concentrate) (ASTM D93-08)	> 160°C
pH (Concentrate as Range)	8.9 - 9.9
pH (Typical Operating as Range)	8.8 - 9.4
Coolant Refractometer Factor	1.0

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

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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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/
- 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

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.

https://2trim.us/di/?plr=E950*en*eu

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