TRIM® E850 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 robust enough to deliver extended useful life and avoid rancid odours normally associated with traditional emulsions. The optimised lubricity and extreme pressure package delivers exceptional surface finish and tool life on difficult to machine aluminium alloys, inconel, titanium, stainless and high tensile strength steels.

**Soluble Oils**

**A case for E850:**
Geared up for production: A major producer of precision commercial and military aerospace components has seen impressive results using E850 for their classified titanium forging machining of under-carriage steering equipment for military aircraft such as the F-16, F-22, F-35, AH-64, B1, C130, CH47, UH 60, S70i, and T38.

After a successful trial, another general machining company made the switch to E850 because they needed a chlorine-free product — and chose E850 for its superior lubricity on stainless steel and aluminum.

Performance soars with E850.

**Choose E850:**
- Delivers exceptional 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
- 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

**E850 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, thread rolling and turning

**Metals** — aerospace aluminium alloys, brass, bronze, cast aluminium, composites, copper, exotic alloys, heat-treated steel, high tensile-strength steel, high-carbon steel, nickel alloys, plastics, stainless steels and titanium

**Industries** — aerospace, automotive and energy

**E850 is free of** — boron, chlorine, copper, formaldehyde releasers, halogens, nitrates and phenols
E850

**Premium Emulsion**

**Application Guidelines**
- It can run at lower concentrations for higher speed operations (where heat removal is the key issue).
- Higher concentrations are recommended on soft, gummy materials and for lower speed operations where friction reduction and control of built-up edge are critical.
- 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 +49 211 77 92 85 - 13.

**Physical Properties Typical Data**

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Colour (Concentrate)</td>
<td>Light brown</td>
</tr>
<tr>
<td>Colour (Working Solution)</td>
<td>Opaque white</td>
</tr>
<tr>
<td>Odour (Concentrate)</td>
<td>Mild amine</td>
</tr>
<tr>
<td>Form (Concentrate)</td>
<td>Liquid</td>
</tr>
<tr>
<td>Flash Point (Concentrate) (ASTM D93-08)</td>
<td>&gt; 120°C</td>
</tr>
<tr>
<td>pH (Concentrate as Range)</td>
<td>9.5 - 10.0</td>
</tr>
<tr>
<td>pH (Typical Operating as Range)</td>
<td>9.0 - 9.5</td>
</tr>
<tr>
<td>Coolant Refractometer Factor</td>
<td>1.0</td>
</tr>
</tbody>
</table>

**Recommended Metalworking Concentrations**

<table>
<thead>
<tr>
<th>Duty</th>
<th>Concentration</th>
</tr>
</thead>
<tbody>
<tr>
<td>Light duty</td>
<td>5.0% - 8.0%</td>
</tr>
<tr>
<td>Moderate duty</td>
<td>8.0% - 10.0%</td>
</tr>
<tr>
<td>Heavy duty</td>
<td>10.0% - 15.0%</td>
</tr>
</tbody>
</table>

**Concentration by % Brix**

![Graph showing concentration by refractive reading](image)

% 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.
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.
- 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.
- 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=E850*en*eu

Hasselsstraße 6-14
Düsseldorf, 40597
Germany
+49 211 77 92 85 - 0
info-eu@masterfluidsolutions.com
masterfluidsolutions.com/eu/en/