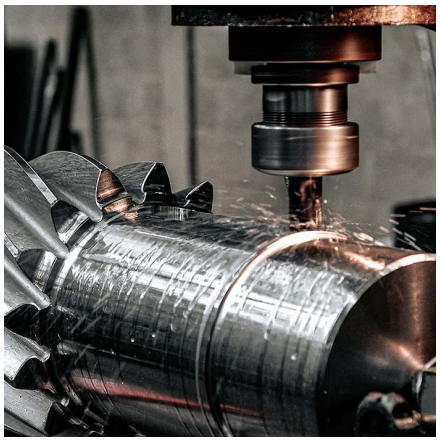
TRIM® C385

High-lubricity Honing Synthetic

TRIM C385 is a state-of-the-art synthetic coolant which provides excellent cooling and chip removal, good tramp oil rejection and machine cleanliness. C385 meets the need of the modern job shop for a single premium synthetic coolant for honing and virtually all machining operations.

Indonesian Auto Manufacturer Doubles Coolant and Tool Life with TRIM® C385



Founded in 1973, the customer is a leading automotive manufacturer based in Indonesia. Formed as a joint venture between a globally recognized automotive brand and local manufacturers, the company originally focused on producing parts and accessories. Over time, operations expanded to create production automotive parts for various markets.

Choose C385:

- Very low foam and mist
- Great for form grinding, honing, boring, rolling, etc
- Exceptional sump life and very good tramp oil rejection
- Extremely low carry-off for very low total operating costs
- Very low initial odor which usually disappears after 1-2 days
- Compatible with dirty or grey cast iron cutting, grinding, and honing
- Keeps your machines clean while leaving a soft, fluid film that protects the bare metal parts
- The residual film is easily resoluble in the coolant working solution to facilitate easy machine cleaning and to minimize the buildup of sticky residues that can hold machine-destroying chips

C385 especially for:

Applications — band sawing, creep-feed grinding, cutting, cylindrical grinding, drilling, form cylindrical grinding, form grinding, grinding, heavy-duty machining center work, honing, internal grinding, plain grinding, reaming, surface grinding, surface milling, tapping, through-feed centerless grinding, and turning

Metals — cast iron, composites, exotic alloys, ferrous metals, glass, heat-treated steel, high-carbon steel, high-nickel alloys, high-strength alloy steels, Inconel®, plastics, stainless steels, steels, titanium, and tool steels

Industries — aerospace, electronics, and medical

C385 is free of — animal derived materials, chlorinated EP additives, DCHA, nitrites, NPEs, phosphorous, siloxane, and sulfurized EP additives

Master Fluid SOLUTIONS®

TRIM® C385

High-lubricity Honing Synthetic

Application Guidelines

- A higher concentration of C385 will increase the lubrication providing better finish results.
- Not recommended in machine tools that rely on the splash of the coolant to lubricate the mechanical portions of the machine tool, such as older screw machines, etc.
- This product is a superior cleaning agent so it may "wash out" dirt and residues when a machine is first charged, therefore a thorough cleaning of older machines is required when installing this product the first time.
- Concentrations above 7.5% provide excellent corrosion inhibition, tool life and sump life; however, the best concentration for your operation should be determined onsite.
- For additional product application information, including performance optimization, please contact your Master Fluid Solutions' Authorized Distributor at https://www.masterfluids.com/in/en-in/distributors/index.php, your District Sales Manager, or email us at india-info@masterfluids.com.

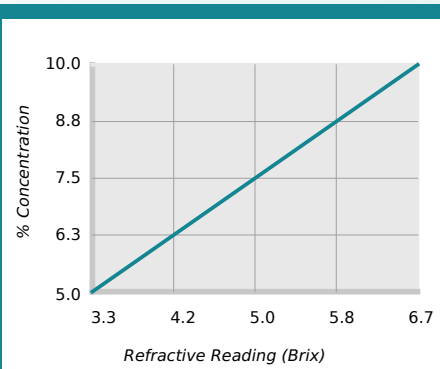
Physical Properties Typical Data

Color (Concentrate)	Light yellow
Color (Working Solution)	Colorless to light yellow
Odor (Concentrate)	Mild, pleasant
Form (Concentrate)	Liquid
Flash Point (Concentrate) (ASTM D92-90)	> 100°C
pH (Concentrate as Range)	10.0 - 10.5
pH (Typical Operating as Range)	9.0 - 10.0
Coolant Refractometer Factor	1.5

Recommended Metalworking Concentrations

Light Duty	5.0% - 6.5%
Moderate Duty	6.5% - 8.5%
Heavy Duty	8.5% - 10.0%
Design Concentration Range	5.0% - 10.0%

Concentration by % Brix



% Concentration = Refractive Reading x Refractive Factor
Coolant Refractometer Factor % Brix = 1.5

Health and Safety

Request SDS

TRIM® C385

High-lubricity Honing Synthetic

Mixing Instructions

- Recommended usage concentration in water: 5.0% - 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-litre pail

204-liter drum

1000-litre IBC

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.
- TRIM™ is a trademark of Master Chemical Corporation d/b/a Master Fluid Solutions.
- Master STAGES™ and Whamex XT™ 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/?i=in_en-in_C385

B-41, Chakan MIDC Phase - 2, Village Bhambuli,
Post Vasuli, Tal. Khed, Pune -410 501.
Maharashtra,
India

india-info@masterfluids.com

masterfluids.com/in/en-in/