TRIM® E206

Long-life Emulsion

TRIM E206 is a soluble oil (emulsion) coolant that performs extremely well in a wide range of machining operations on both ferrous and nonferrous materials. It has the lubricity and "guts" necessary for heavy-duty machining center work and still provide the wetting and cooling necessary for high-speed turning and grinding operations.

Emulsions



Geared up for production:

With superior lubricity and a higher oil content, TRIM emulsions provide a greater boundary layer between the tool and the material, and are ideal for heavy-duty applications such as broaching, reaming, deep hole drilling, drilling, tapping, and centerless grinding.

TRIM emulsions work well for machining copper, yellow metals, steel alloys, cast aluminums, wrought aluminums, and tough-to-machine titanium and nickel-based alloys.

Aerospace Approvals

Company	Specification
Applied Materials	UHV
Boeing	BAC5008
Bombardier Aerospace	BAMS 569-001
GE Aerospace	No specification available
General Dynamics	No specification available
Goodrich	No specification available
Lockheed Martin/Sikorsky	No specification available
Lord Corporation	MTL-S-0136
Raytheon Technologies/Collins Aerospace/Pratt & Whitney	No specification available
SAFRAN	PR6300

Choose E206:

- A very versatile product which works in a wide range of operations such as heavy-duty broaching, gear hobbing, surface and centerless grinding, and replacing straight oil on some types of screw machines
- Contains highly effective extreme-pressure additives to control built-up edge
- Compatible with all ferrous and nonferrous materials
- Extremely stable emulsion to reduce carryoff and to facilitate getting the fluid to the point of cut
- Rejects tramp oil to help extend sump life and increase recycling options
- Leaves a soft fluid film to prevent sticky ways, chucks, tool holders, and fixtures
- Coolant residue is easily removed with water, working solution, or aqueous cleaners
- Easy recycling or disposal with conventional techniques and equipment

E206 especially for:

Applications — band sawing, centerless grinding, cutting, drilling, gear hobbing, grinding, heavy-duty broaching, heavy-duty machining center work, high-speed turning, in-feed centerless grinding, internal grinding, plain grinding, production grinding, reaming, roll threading, surface grinding, surface milling, tapping, thread forming, and turning

Materials — 6000 series aluminum, aerospace aluminum alloys, brass, bronze, cast aluminum, copper, exotic alloys, ferrous metals, heat-treated steel, high-carbon steel, high-nickel alloys, nonferrous metals, stainless steels, steels, titanium, tool steels, wrought aluminum, and yellow metals

Industries — aerospace, automotive, diecast, energy, general fabrication, medical, and semiconductor equipment

E206 is free of — formaldehyde releasers and NPEs

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Application Guidelines

- E206 is designed to run effectively for long periods without the need for costly additives.
- 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 of 7% or higher provide the best sump life.
- For additional product application information, including performance optimization, please contact your Master Fluid Solutions' Authorized Distributor at https://www.masterfluids.com/na/en-us/distributors/index.php, your District Sales Manager, or call our Tech Line at 1-800-537-3365.

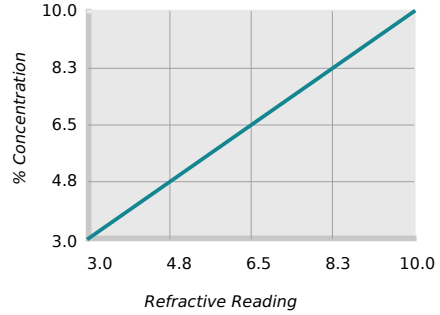
Physical Properties Typical Data

Color (Concentrate)	Dark blue
Color (Working Solution)	Blue
Odor (Concentrate)	Mild
Form (Concentrate)	Liquid
Flash Point (Concentrate) (ASTM D93-08)	> 210°F
pH (Typical Operating as Range)	8.8 - 9.2
Coolant Refractometer Factor	1.0
V.O.C. Content (ASTM E1868-10)	95 g/l

Recommended Metalworking Concentrations

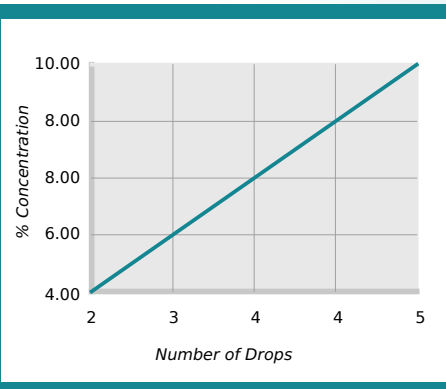
Light Duty	3.0% - 6.0%
Moderate Duty	6.0% - 8.0%
Heavy Duty	8.0% - 10.0%
Design Concentration Range	3.0% - 10.0%

Concentration by % Brix



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

Concentration by Titration



% Concentration = No. of Drops x Titration Factor
Titration Factor = 2.00

Request SDS

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Mixing Instructions

- Recommended usage concentration in water: 3.0% - 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.



1-gallon jug
SKU: E206-1G
UPC-12: 641238038443



5-gallon pail
SKU: E206-5G
UPC-12: 641238003083



54-gallon drum
SKU: E206-54G
UPC-12: 641238003090



270-gallon tote
SKU: E206-270G
UPC-12: 641238038504

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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.
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