TRIM™ E935 bd

Premium Universal Emulsion - Blue Dye

TRIM E935 bd is a premium universal emulsion for use on a broad range of ferrous and nonferrous metals, effective in most cutting and grinding operations. The stable and predictable performance of E935 bd makes it a first choice for precision and consistent parts manufacturing.

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 aluminiums, wrought aluminiums and tough-to-machine titanium and nickel-based alloys.

Choose E935 bd:

- Very wide application range
- Good hard water tolerance
- Keeps machine tools clean
- Works very well in general machining
- Very stable formula provides good operational life with consistent performance
- High tramp oil resistance for easy oil removal and longer coolant life
- Easily recycled or disposed of using conventional techniques and equipment
- Good balance of cooling and lubrication providing good tool life and surface finishes
- Leaves a very light, oily, non-gumming residue to prevent sticky ways, chucks, tool holders, and fixtures
- Extremely stable fine particle size emulsion allows for reduced carry-off and super-high penetrability to get the fluid to the point of cut

E935 bd especially for:

Applications — boring, centerless grinding, deep hole drilling, drilling, high-speed milling, high-speed turning, machining, milling, reaming, sawing, tapping, and turning

Materials — aluminum, brass, cast aluminum, cast iron, ferrous metals, nonferrous metals, stainless steels, and steels

Industries — aerospace, automotive, energy, general fabrication, and medical

E935 bd is free of — DEA, phenolic compounds, sulfonates, and sulfur-based additives

Master Fluid SOLUTIONS™

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Application Guidelines

- Machining copper may cause coolant to develop a bluish tint.
- Running at or above 7.5% offers the best sump life and corrosion inhibition.
- In mixed metal situations, keep concentration above 7.5% to minimize galvanic corrosion.
- Foam can be caused due to mechanical reasons. If foam does appear, diagnose the cause of foaming before adding antifoam.
- For additional product application information, including performance optimization, please contact your Master Fluid Solutions' Authorized Distributor at https://www.masterfluids.com/th/en-th/distributors/index.php or your District Sales Manager, or email us at thailand-info@masterfluids.com.

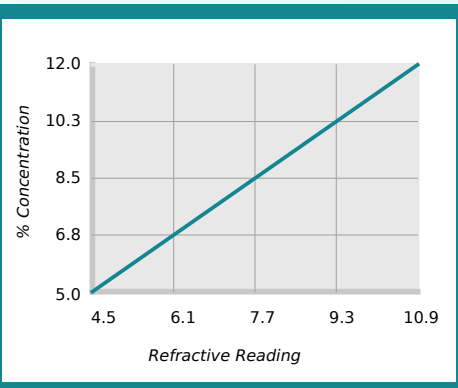
Physical Properties Typical Data

Color (Concentrate)	Blue
Color (Working Solution)	Blue
Odor (Concentrate)	Mild, pleasant
Form (Concentrate)	Liquid
Flash Point (Concentrate) (ASTM D92-90)	> 100°C
pH (Typical Operating as Range)	8.8 - 9.8
Coolant Refractometer Factor	1.1

Recommended Metalworking Concentrations

Light Duty	5.0% - 7.0%
Moderate Duty	7.0% - 9.0%
Heavy Duty	9.0% - 12.0%
Design Concentration Range	5.0% - 12.0%

Concentration by % Brix



% Concentration = Refractive Reading x Refractive Factor
Coolant Refractometer Factor % Brix = 1.1

Health and Safety

Request SDS

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Mixing Instructions

- Recommended usage concentration in water: 5.0% - 12.0%.
- 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-liter pail

204-liter drum

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 trademark of Master Chemical Corporation d/b/a Master Fluid Solutions.
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- 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:

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