



TRIM® C270 bd

High-performance Synthetic - Blue Dye

GENERAL DESCRIPTION

TRIM® C270 bd is a state-of-the-art synthetic coolant. C270 bd provides excellent cooling and chip settling, good tramp oil rejection, and machine cleanliness, and meets the need of the modern job shop for a single premium synthetic coolant for virtually all machining operations.

ADVANTAGES

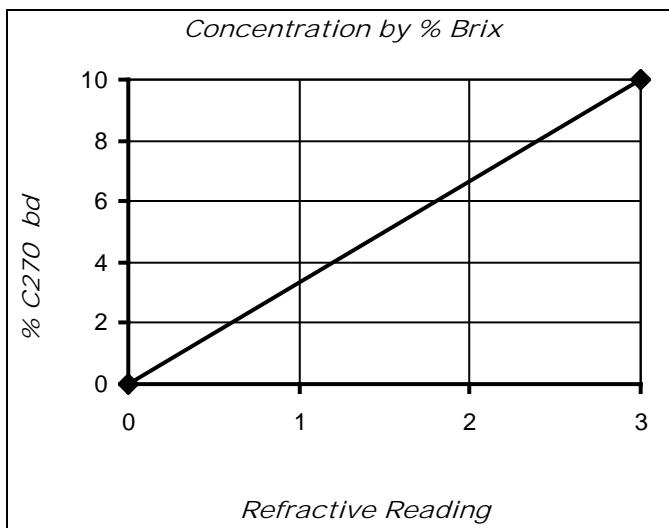
- C270 bd is compatible with a very wide range of materials including: cast iron, steels, and copper alloys, as well as plastics and composites
- Provides excellent corrosion inhibition on all common ferrous alloys
- Does a great job in form grinding, drilling, tapping, and reaming operations without chlorine or sulfur-based EP additives
- Extremely low carryoff for very low total operation costs
- Very low foam and mist
- Keeps your machines clean while leaving a soft, fluid film that protects the bare metal parts. This residual film is easily resoluble in coolant working solution to facilitate easy machine cleaning and minimize the buildup of sticky residues that can hold machine-destroying chips
- Exceptional sump life and very good tramp oil rejection
- A very low initial odor level which usually disappears after one-to-two days

APPLICATION GUIDELINES

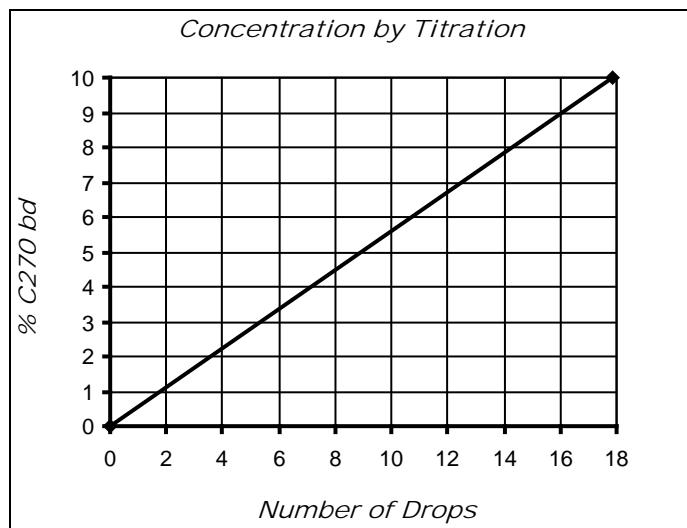
- The harder you work this product the better the results will be.
- C270 bd is not recommended in machine tools that rely on the splash of the coolant to lubricate the mechanical portions of the machine tool, e.g. older screw machines, etc.
- C270 bd is not recommended on materials like magnesium or zirconium without special precautions.
- This product is a superior cleaning agent so it may "wash out" dirt and residues when a machine is first charged; a thorough cleaning of older machines is required when installing this product the first time.
- The minimum recommended concentration is 5% on cast iron and 4% on steel.
- Concentrations above 7.5% provide excellent corrosion inhibition, tool life, and sump life; however, the best concentration for your operation should be determined by on-site experience.
- For additional product applications information including performance optimization, please contact your Master Chemical Authorized Distributor at 2trim.us/distributors.php, your District Sales Manager, the Tech Line at 1-800-537-3365, or visit our web site at www.masterchemical.com.

PHYSICAL PROPERTIES (TYPICAL DATA)

Color (Concentrate)	Blue	Flash Point	212°F (100°C) (ASTM D92-12B)
Color (Working Solution)	Blue	pH (Typical Operating as a Range)	8.7-9.2
Odor.....	Mild, Sweet	Coolant Refractometer Factor % Brix	3.3
Form	Liquid	Titration Factor (CGF-1 Titration Kit)	0.561



% Concentration = Refractive Reading x Refractive Factor
Coolant Refractometer Factor % Brix = 3.3



% Concentration = No. of Drops x Titration Factor
Titration Factor = 0.561

RECOMMENDED METALWORKING CONCENTRATIONS

Moderate-duty machining and grinding 5%-7%
Heavy-duty machining and grinding 7%-10%

MIXING INSTRUCTIONS

- Using premixed coolant as makeup will improve coolant performance and reduce coolant purchases. The makeup concentration that you select should balance the water evaporation rate with the coolant carryout rate. Adding makeup coolant at 5%-15% of the desired working concentration will generally maintain the proper concentration in the sump.
- The use of DI or mineral-free water will improve sump life, reduce concentrate usage, reduce carryoff, and improve corrosion inhibition.

HEALTH AND SAFETY

See the most recent SDS at 2trim.us/s/?i=1039-en-US-US.



NOTES

- Before using this product on any metals and applications not specifically recommended, consult Master Chemical Corporation.
- This product should not be mixed with other metalworking fluids or metalworking fluid additives, except as specifically recommended by Master Chemical Corporation, as this may reduce the overall performance of the product as well as result in adverse health effects and damage to the machine tool and parts. If inadvertent contamination should occur, please contact Master Chemical Corporation for recommended action.
- Packaging: North America – 1-gallon jug, 5-gallon pail, 54-gallon drum, and 270-gallon tote bin.
- Packaging: Europe/Asia – 20-litre pail, 204-litre drum, and 1000-litre IBC.

The information herein is given in good faith and believed current as of the date of this Data & Information sheet 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 Chemical Corporation for further information. For the most recent version of this document, please go to this URL: 2trim.us/di/?i=11

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