

# TRIM<sup>®</sup> C270 bd

## High-performance Synthetic - Blue Dye



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.

### Synthetics



*TRIM<sup>®</sup> C270 provided excellent parts finish and very low operating costs for a mega-manufacturer of air conditioners.*

#### **A case for C270:**

*A mega-manufacturer of air conditioners, getting only four to six months of life from their coolant, was also having problems with rust on parts, bacteria, fungus, odor, sticky residue, and machine cleanliness. After tests and data analysis, the plant switched to synthetic C270.*

*After 12 months, the C270 was still going strong with an expectation it would run a full 18 months. Machines are clean, there's no fungus or odor problem, or rust on parts.*

*With excellent parts finish, very low operating costs, and no costly downtime to date, C270 has a perfect track record with this manufacturer.*

#### **Choose C270 bd:**

- 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 resolvable 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

#### **C270 bd especially for:**

**Applications** — band sawing, belt grinding, Blanchard grinding, cooling, corrosion inhibition, creep-feed grinding, cylindrical grinding, double disc grinding, drilling, form cylindrical grinding, form grinding, grinding, internal grinding, plain grinding, reaming, surface grinding, surface milling, tapping, and turning

**Metals** — cast iron, composites, copper alloys, exotic alloys, plastics, steels, and tool steels

**Industries** — aerospace, compressor, energy, and machine tool

**C270 bd is free of** — animal derived materials, chlorinated EP additives, DCHA, nitrites, NPEs, phosphorous, siloxane, and sulfurized EP additives

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## 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 application information, including performance optimization, please contact your Master Fluid Solutions' Authorized Distributor at <https://www.2trim.us/distributors.php>, your District Sales Manager, or call our Tech Line at 1-800-537-3365.

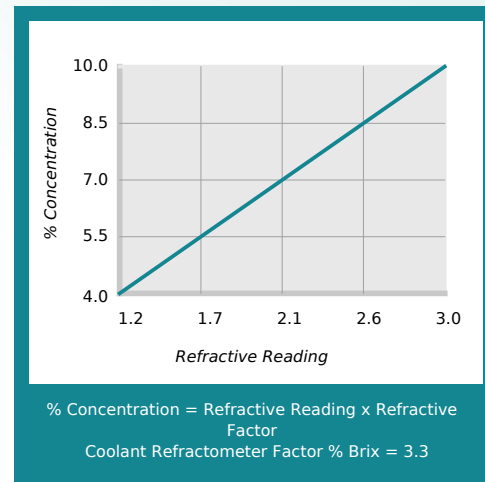
## Physical Properties Typical Data

Color (Concentrate)	Blue
Color (Working Solution)	Blue
Odor (Concentrate)	Mild, sweet
Form (Concentrate)	Liquid
Flash Point (Concentrate) (ASTM D93-08)	> 226°F
pH (Concentrate as Range)	9.0 - 9.3
pH (Typical Operating as Range)	8.7 - 9.2
Coolant Refractometer Factor	3.3
Titration Factor (CGF-1 Titration Kit)	0.56
Digital Titration Factor	0.0175
V.O.C. Content (ASTM E1868-10)	110 g/l

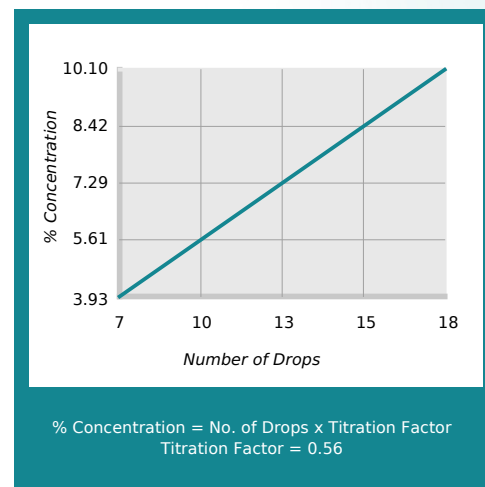
## Recommended Metalworking Concentrations

Light duty	4.0% - 6.5%
Moderate duty	6.5% - 8.5%
Heavy duty	8.5% - 10.0%
Design Concentration Range	4.0% - 10.0%

## Concentration by % Brix



## Concentration by Titration



## Health and Safety

Request SDS



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## Mixing Instructions

- Recommended usage concentration in water: 4.0% - 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/](https://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: C270BD/1  
UPC-12: 641238066743



5-gallon pail  
SKU: C270BD/5  
UPC-12: 641238001300



54-gallon drum  
SKU: C270BD/54  
UPC-12: 641238001317



270-gallon tote  
SKU: C270BD/NR270P  
UPC-12: 641238034018

## 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.
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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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