

# TRIM<sup>®</sup> REGULAR

## Synthetic

TRIM REGULAR is a chemical surface active or synthetic coolant concentrate designed for general machining and grinding of ferrous materials. It is particularly well suited for machining cast iron, but is an exceptional grinding and high velocity turning and milling fluid. REGULAR contains no sulfur, chlorine, or phosphorus, and meets the requirements of even the most restrictive chemical specifications.

### Synthetics



#### Peak your performance:

*TRIM<sup>®</sup> clean-running synthetics contain little-to-no oil. They are hard-water tolerant with good corrosion protection. Plus, synthetics leave very low residue for easy cleaning. Paired with extremely low carryoff, synthetics translate to less maintenance and lower operational costs, saving you time and money.*

*Run clean and long with TRIM synthetics.*



#### Choose REGULAR:

- Provides rapid and effective cooling
- Keeps grinding wheels clean and free of loading
- Has significant levels of specialized wetting agents for boundary lubrications even at very high SFPM
- Has superior anti-weld action to control built-up edge and chip welding
- Compatible with ferrous and nonferrous metals as well as most nonmetallic materials
- Is exceptionally clean and oil free to promote a clean, safe work environment
- Will keep your machines clean while leaving a soft, fluid film that protects the bare metal parts of your machine tools

#### REGULAR especially for:

**Applications** — general purpose, grinding, high-speed milling, high-speed turning, and machining

**Metals** — cast iron, ferrous metals, nonferrous metals, and nonmetallic materials

**Industries** — aerospace and automotive

**REGULAR is free of** — chlorine, oil, phosphorous, and sulfur

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## Application Guidelines

- REGULAR is not recommended for use on reactive metals like magnesium or zirconium.
- The minimum recommended concentration is 5% on all materials; however, higher concentrations give better sump life, tool life, and corrosion control.
- REGULAR will foam more at higher concentrations, but care should be used to prevent adding too much antifoam.
- REGULAR is best when used in high-speed machining situations; however, at higher concentrations (7.5%+; plus) it exhibits significant levels of slip lubrication as well.
- REGULAR works as a light to moderate-duty stamping and drawing fluid at higher concentrations or in its neat form.
- 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.

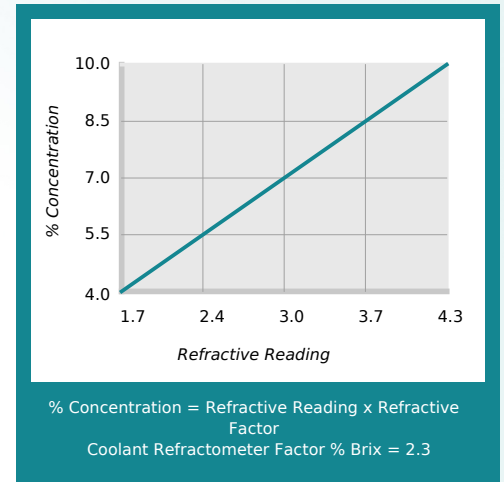
## Physical Properties Typical Data

Color (Concentrate)	Straw
Color (Working Solution)	Colorless
Odor (Concentrate)	Mild pine
Form (Concentrate)	Liquid
Flash Point (Concentrate) (ASTM D93-08)	> 216°F
pH (Typical Operating as Range)	8.3 - 8.9
Coolant Refractometer Factor	2.3
Titration Factor (CGF-1 Titration Kit)	0.77
Digital Titration Factor	0.0159
V.O.C. Content (ASTM E1868-10)	62 g/l

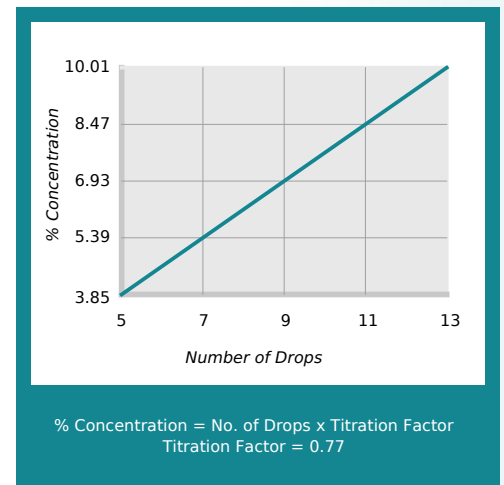
## Recommended Metalworking Concentrations

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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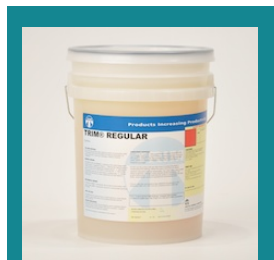


## Mixing Instructions

- 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: REGULAR/1  
UPC-12: 641238006824



5-gallon pail  
SKU: REGULAR/5  
UPC-12: 641238006855



54-gallon drum  
SKU: REGULAR/54  
UPC-12: 641238006862




270-gallon tote  
SKU: REGULAR/NR270P  
UPC-12: 641238006893


## 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<sup>®</sup> is a registered 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:


[https://2trim.us/di/?i=na\\_en-us\\_REGULAR](https://2trim.us/di/?i=na_en-us_REGULAR)



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