



TRIM[®] E206

Long-life Emulsion

GENERAL DESCRIPTION

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

ADVANTAGES

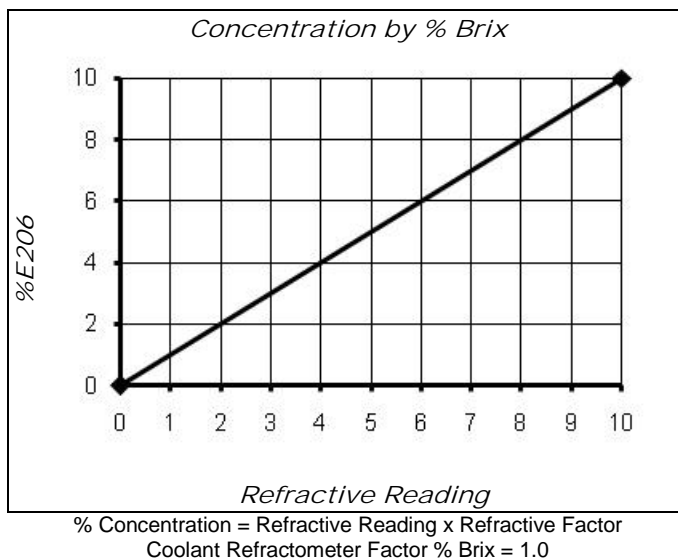
- A very versatile product which works in a wide range of operations such as heavy-duty broaching, gear hobbing, production, surface and centerless grinding, and replacing straight oil on some types of screw machines
- Contains highly effective, extreme-pressure additives to control built-up edge
- Compatible with all ferrous and nonferrous materials
- Extremely stable and fine 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

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 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)	Dark Blue	Flash Point	>185°F (85°C) (ASTM D93-08)
Color (Working Solution)	Blue	pH (Typical Operating as a Range)	8.8-9.2
Odor	Mild	Coolant Refractometer Factor % Brix	1.0
Form	Liquid	Titration Factor (CGF-1 Titration Kit)	N/A



RECOMMENDED METALWORKING CONCENTRATIONS

Light-duty machining and grinding	3%-5%
Moderate-duty machining	5%-7%
Heavy-duty machining	7%-10%
Very heavy-duty machining	10%
Recommended concentration range	3%-10%

MIXING INSTRUCTIONS

- Using DI or mineral-free water will improve sump life, reduce concentrate usage, reduce carryoff, and improve corrosion inhibition.
- Emulsion products such as E206 work best if mixed with room temperature water. Add the coolant concentrate to the water; NEVER THE REVERSE.
- Using premixed coolant as makeup will improve performance and reduce coolant purchases. The makeup concentration you use should balance the water evaporation rate with the coolant carryoff rate. (Adding makeup coolant at 30%-40% of the desired working concentration will generally maintain the proper concentration in the sump.)

HEALTH AND SAFETY

See the most recent SDS 2trim.us/s/?i=1071-en-US-US.



NOTES

- Use Master STAGES™ Whamex™ for a quick and thorough pre-cleaning of your machine tool and coolant system.
- Before using on any metals or applications not specifically recommended, consult Master Chemical.
- This product should not be mixed with other metalworking fluids or metalworking fluid additives, except as recommended by Master Chemical Corporation, as this may reduce overall performance, result in adverse health effects, or damage the machine tool and parts. If contamination occurs, please contact Master Chemical Corporation for recommended action.
- E206 working solution is a blue emulsion, but is available without dye by ordering TRIM® E206 nd.
- 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.

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