TRIM® E925AE

DCHA-free, High-performance Emulsion

TRIM E925AE utilizes a proprietary lubricity package to deliver exceptional surface finish and tool life on difficult-to-machine aerospace materials. Designed to lower total cost and improve manufacturing efficiency thanks to extended sump life. Environmentally friendly emulsion is free of DCHA, boron, chlorinated paraffins, and other halogens. Mild contact nature and low initial-charge odor provide an operator-friendly environment.

Aerospace Manufacturer's Holes per Drill Soar with Master Fluid Solutions®



At 30,000 feet, there's no room for error. Aerospace companies have to meet that high standardwhen they design, manufacture, and support products that keep airline passengers safe in flight. One aerospace components manufacturer based in the Northeast focuses on aerospace propulsion components, flight control components, and aero engine components - all of which require high quality and precision to meet safety standards and specifications. The company machines a variety of alloys, including low carbon, hardened steel, aluminum, titanium, and nickel, as well as stainless steel, using drilling, reaming, tapping, milling, turning, and grinding operations.

Aerospace Approvals

Company	Specification
Raytheon Technologies/Collins Aerospace/Pratt & Whitney	PMC 9313
Safran Group	PCS-4001/4002, PR6300

Choose E925AE:

- DCHA free
- Extended sump life for lower operating costs
- Protects sensitive aluminum and nonferrous alloys
- Excellent lubricity without chlorinated paraffins
- Provides superior results in a wide range of operations
- Superior corrosion resistance
- Appropriate for most high-pressure systems
- Low product odor
- Mild operator contact properties
- Soft fluid film protects chucks, ways, and tool holders
- Rinses off for easy parts cleanup before assembly, painting, or plating

E925AE especially for:

Applications — band sawing, centerless grinding, corrosion inhibition, creep-feed grinding, drilling, form cylindrical grinding, internal grinding, reaming, and sawing

Metals — 6000 series aluminum, aerospace alloys, aerospace aluminum alloys, aluminum, brass, bronze, cast aluminum, cast iron, composites, copper, glass, heat-treated steel, high-carbon steel, high-nickel alloys, nonferrous metals, plastics, stainless steels, steels, and titanium

Industries — aerospace and firearms

E925AE is free of — boron, chlorinated paraffin, chlorine, DCHA, and halogens

Master Fluid SOLUTIONS®

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Application Guidelines

- Maintaining concentration from 7.5%-10.0% provides the best sump life and corrosion inhibition.
- E925AE is not recommended on magnesium or other reactive materials.
- For additional product application information, including performance optimization, please contact your Master Fluid Solutions' Authorized Distributor at https://www.masterfluids.com/na/en-us/distributors/index.php, your District Sales Manager, or call our Tech Line at 1-800-537-3365.

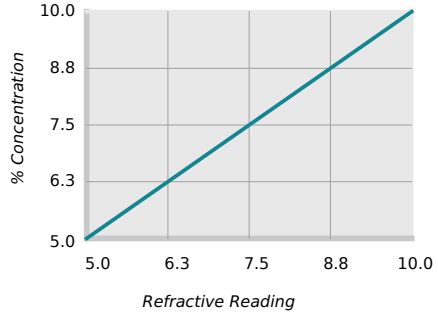
Physical Properties Typical Data

Color (Concentrate)	Light yellow to amber
Color (Working Solution)	White
Odor (Concentrate)	Mild amine
Form (Concentrate)	Liquid
Flash Point (Concentrate) (ASTM D93-08)	> 223°F
pH (Concentrate as Range)	9.0 - 9.6
pH (Typical Operating as Range)	8.8 - 10.0
Coolant Refractometer Factor	1.0
Titration Factor (CGF-1 Titration Kit)	0.69
Digital Titration Factor	0.0244
V.O.C. Content (ASTM E1868-10)	151 g/l

Recommended Metalworking Concentrations

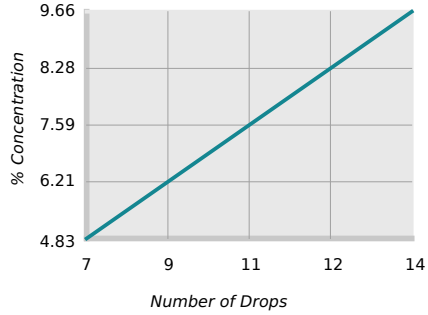
Light Duty	5.0% - 6.5%
Moderate Duty	6.5% - 8.5%
Heavy Duty	8.5% - 10.0%
Design Concentration Range	5.0% - 10.0%

Concentration by % Brix



% Concentration = Refractive Reading x Refractive Factor
Coolant Refractometer Factor % Brix = 1.0

Concentration by Titration



% Concentration = No. of Drops x Titration Factor
Titration Factor = 0.69

Health and Safety

Request SDS

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Mixing Instructions

- Recommended usage concentration in water: 5.0% - 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/.
- Use mineral-free water to improve sump life and corrosion inhibition while reducing carryoff and concentrate usage.



1-gallon jug
SKU: E925AE-1G
UPC-12: 641238077121



5-gallon pail
SKU: E925AE-5G
UPC-12: 641238077114



54-gallon drum
SKU: E925AE-54G
UPC-12: 641238077107



270-gallon tote
SKU: E925AE-270G
UPC-12: 641238077145

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