Supplier - DOVER

Mayfree 133

Phosphorus Nitrogen Compound

Chlorine Replacement Additives

Typical Properties

Appearance	Dark Amber Fluid
Specific Gravity@60/60℉	0.990
Density, lb/gal	8.25
Viscosity@100℉(210℉),SUS	44000 (750)
Viscosity@100℉(210℉),cSt	9500 (162)
Phosphorus Content,%wt	4.0
Neutralization Number, meqKOH/g	155
Flash Point C.O.C.,℉(℃)	460 (238)

Product Description

MAYFREE 133 is recommended as a replacement of chlorinated paraffin in almost every metalworking operation.

MAYFREE 133 is oil soluble, however it can be incorporated also into water dilutable formulations. The rule of thumb to follow when trying to replace a chlorinated paraffin is to work on a one for one basis of **MAYFREE 133** for percent chlorine. As an example, a cutting oil contains 6% of a 50% chlorinated paraffin bringing to the formula 3% chlorine. Therefore, one would substitute in the product 3% **MAYFREE 133**.

MAYFREE 133 does possess a high acid number, so the addition of or increase in the alkaline components, such as triethanolamine must be made. In oil systems, **MAYFREE 133** is not compatible with other chlorine replacement additives, such as overbased sulphonates.

MAYFREE 133 is recommended for all metalworking applications, with the exception of very severe or stainless operations which are normally performed with cutting oils containing in excess of 20% chlorine. MAYFREE 133 has, in the field, successfully replaced chlorine at levels up to 15 % in the formulations.

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