

Supplier - DOVER  
**Mayfree 133**

*Phosphorus Nitrogen Compound  
Chlorine Replacement Additives*

### Typical Properties

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

Print date: 24-01-26

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