

**Typical Properties**

Appearance	Clear Light Amber Liquid
Specific Gravity@60/60°F	1.070
Density,lb/gal	8.92
Viscosity@100°F(210°F),SUS	100000 (1850)
Viscosity@100°F(210°F),cSt	21500 (400)
Phosphorus Content,%wt	5.5
Neutralization Number, meqKOH/g	200
Flash Point C.O.C.,°F(°C)	380 (193)
Std Packaging (NW / GW, Kg)	217.0 / 200.0

**Product Description**

**MAYPHOS 45** is an oil-soluble phosphate ester. While it is water insoluble, incorporation into water dutiable products can be accomplished if partially neutralized with alkaline components, such as amines. Excellent performance, on especially nonferrous materials, has been achieved on such manner.

Synergisms have been noted between **MAYPHOS 45** and PEG esters and/or cloud point possessing nonionic surfactants.

**MAYPHOS 45** is highly recommended in flute grinding applications as the commonly used diatomaceous earth filtration units do not strip the additive from the oil carrier thus extending the overall life and performance of the cutting oil.

**Applications**

Groove milling  
Screw Machining  
Cold Heading  
Drawing / Stamping  
General Machining (Antiwear)

**Suggested Treat Rates, %wt**

2 - 4  
4 - 6  
5 - 10  
10 - 25  
0.5 - 2