INVERSOL 140

Fatty Acid Ester
Inversely Soluble Lubricity Additive

Inversol 140 is a water soluble, complex ester based, lubricity additive designed for synthetic, water dilutable metalworking fluids. **Inversol 140** does NOT contain sulfur, phosphorus, or chlorine based components.

Inversol 140 is inversely soluble, forming an insoluble layer at elevated temperatures to impart a lubricating film at the tool/workpiece interface.

Inversol 140 works well with both ferrous and non-ferrous metals. Recommended treat rates are indicated below:

	% Treat
Synthetic metalworking fluid	3-10

Inversol 140 should be stored in an original container or bulk storage tank. Prolonged exposure to 0°F may result in solidification. Warming drums between 80-110°F should reverse solidification. Bulk storage should be maintained between 75-90°F with material being recirculated or mixed to avoid localized heating. Blending temperatures should not exceed 130°F.

TYPICAL PROPERTIES

Property	Result
Flash Point, C.O.C., °F (°C)	>350 (>177)
Specific Gravity @ 77°C	1.06
Density (lb/gal)	8.8
pH Value, 1% in water	7.1
Viscosity, SUS, @ 100°F (210°F)	7600 (600)
Viscosity, cSt, @ 40°C (100°C)	1,600 (125)
Acid Value (mgKOH/g)	15
Pour Point, °F (°C)	60 (16)
Color, ASTM	3.5
Inverse Solubility Temperature, °F (°C)	140 (60)

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