

KLOR-FREE 100
Polymeric Ester Additive
Oil Soluble Lubricant Additive

Klor-Free 100 is an oil soluble, non-staining, proprietary polymeric ester additive for metalworking fluids and lubricant applications. **Klor-Free 100** exhibits excellent hydrolytic stability, oxidative resistance, and does not promote foam formation. It can be recommended as a replacement for chlorinated paraffin in almost every metalworking operation.

Klor-Free 100 is an excellent lubricant shown to replace chlorine based additives in various machining fluids. It is soluble in both naphthenic and paraffinic base oils. **Klor-Free 100** is compatible with most ingredients in soluble oils and exhibits a stabilizing effect on emulsions. Additionally, **Klor-Free 100** offers low residue. Recommended use levels are:

	<u>% Treat</u>
Cutting Oils (Ferrous Metals) Light Duty	5-10
Cutting Oils (Ferrous Metals) Medium Duty	2-8*
Cutting Oils (Ferrous Metals) Heavy Duty	2-10**
Drawing and Stamping (Aluminum)	5-20
Machining (Aluminum)	5-8
Machining (Heavy Duty Ferrous)	3-8***

* In combination with EM-706 (0.5-2%)

** In combination with Mayco Base 1540 (2-5%)

*** In combination with Mayco Base 1540 (1-4%)

TYPICAL PROPERTIES

Property	Result
Appearance	Clear, Viscous Liquid
Specific Gravity @ 60/60°F (15.6°C)	.092
Density, lb/gal	7.64
Viscosity, SUS @ 100°C (210°F)	16,700 (1150)
Viscosity, cSt @ 40°C (100°C)	2,900 (227)
Color, ASTM	3.5
Flash Point, PMCC, °F (°C)	390 (199)
Pour Point, °F (°C)	28 (-2) No Cloud at Pour Point
Acid Value, mgKOH/g	5

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