



DO 8110
Chlorinated Olefin
Extreme Pressure
Additive

DO 8110 is a chlorinated olefin. It is a nonflammable, non-corrosive, low volatile liquid at room temperature. It contains a stabilizer to maintain product integrity during transport and storage. It is used in a wide variety of applications including flame retardants, plasticizers, and EP metalworking packages.

DO 8110 is typically applied in machining, drawing, and stamping fluids. The following information represents typical starting point formulation guidelines:

	<u>% Weight</u>
Straight Oil (Machining)	3 – 10
Straight Oil (Drawing and Stamping)	5 – 30
Soluble Oil (Machining)	2 – 10
Soluble Oil (Drawing and Stamping)	5 – 15

DO 8110 may be stored in an original container, or bulk storage tank. Exposure to 0°F for an extended period will cause significant viscosity increases. To reverse this, drums need to be returned to 80-90°F. Recommended storing temperatures range from 80-100°F. Blending should not exceed 130°F. Prolonged exposure to temperatures in excess of 100°F may result in darkening of product and release of corrosive by-products.

TYPICAL PROPERTIES

Property	Typical Result
Chlorine, %	52
Specific Gravity @ 25°C	1.258
Density (lb/gal)	10.5
Viscosity @ 100°F; SUS	820
Viscosity @ 210°F; SUS	57
Color, Gardner	1

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330-343-7711 · 800-321-8805 · Facsimile 330-365-3926 · www.doverchem.com