



INVERSOL 170

Fatty Acid Ester
Inversely Soluble Lubricity Additive

Inversol 170 is a lubricity additive designed for water soluble machining fluids. It contains no sulfur or chlorine based components. **Inversol 170** is inversely soluble, forming an insoluble layer at elevated temperatures to impart lubricating film at the tool/workpiece interface.

Inversol 170 reduces the coefficient of friction and surface tension of the final fluid. It is hydrolytically stable and compatible with rust inhibitors. The pH of **Inversol 170** allows for the machining of aluminum and other non-ferrous metals. Recommended treat rates are indicated below:

	<u>% Treat</u>
Synthetic metalworking fluid	3-10

Inversol 170 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 temperatures 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)	7500 (600)
Acid Value (mgKOH/g)	14
Pour Point, °F (°C)	55 (13)
Color, ASTM	3.5
Inverse Solubility Temperature, °F (°C)	160 (71)

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