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:

	% Treat
Cutting Oils (Ferrous Metals)	2-10*
Drawing and Stamping (Aluminum)	5-20
Machining (Aluminum)	5-8
Machining (Heavy Duty Ferrous)	3-8**
Soluble/Semi-Synthetics	3-6

* Medium duty used in combination with EM-706 (6:1 ratio) and heavy duty used in combination with Mayco Base 1540 (2-5%)
** used 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°F (210°F)	18,000 (1150)
Viscosity, cSt @ 40°C (100°C)	3885 (247)
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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