METHYL ESTER 165

Fully Formulated Synthetic Fluid
Heavy Duty Machining

Methyl Ester 165 is a low viscosity fatty ester that offers superior metal wetting characteristics and boundary lubricity compared to conventional animal-based fatty additives.

Methyl Ester 165 is recommended for use in precision operations such as drilling, tapping, form grinding, and Swiss-Type Automatics. The treat levels for these applications would be 5-15%, depending on the severity.

The low neutralization number provides excellent resistance to oxidative degradation due to the heat generated in the machining process. Also, lack of acidity allows the cutting fluid formulator to use this boundary lubricant in combination with overbased sulfonate technology chemistry, such as **Mayco Base CF-74** and **Mayco Base CF-95**. This chemical approach has shown very good success in the development of chlorine free oils for stainless steel applications.

TYPICAL PROPERTIES

Property	Result
Appearance	Clear, Light Yellow Liquid
Pour Point, °F (°C)	39 (3.9)
Specific gravity @ 60/60°F	0.87
Density, lb/gal	7.26
Viscosity @ 100°F (210°F), SUS	42 (32)
Flash Point, C.O.C. °F (°C)	375 (191)
Neutralization Number, meqKOH/g	<1

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