

Doverphos 253 is diolel hydrogen phosphite. It has the perfect combination of an oleyl group for machining characteristics and phosphorus for antiwear properties. **Doverphos 253** is oil-soluble, light in color, and compatible with all common metalworking additives. It also is compatible with typical crankcase additives.

Doverphos 253 is used at levels ranging from 1-10% in straight oil formulations. It can be used with all metals. Below are 4-Ball wear test results - 40kg load & 1200rpm for 60 minutes at 70°C. No residue was seen using **Doverphos 253**.

Product	Formula 1	Formula 2	Formula 3
Paroil 152	10.0	-	-
Mayfree 133	-	5.0	-
Doverphos 253	-	-	5.0
Methyl Ester 165	5.0	5.0	5.0
Base Oil (blends)* 20cSt	85.0	90.0	90.0

Ball	Wear Scar (mm)		
1	0.45	0.34	0.17
2	0.47	0.32	0.19
3	0.48	0.31	0.17
Average	0.47	0.32	0.18

Typical Properties

Property	Typical Result
Specific Gravity	0.910
Appearance	Amber Liquid
Viscosity @ 25°C, cPs	35
Color, Gardner	6 max
Phosphorus, %	5.3
Copper Strip (24 hours @ 210° F)	1a

Doverphos 253 can become hazy or solidify when exposed to cold temperatures (<32oF; <0oC). If that occurs, gently warm with mild agitation to >60oF; >15oC, or until the product clarifies. No performance detriment is expected.

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