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LUBRISTAY™ 315

Metal Processing

Lubricity agent and multi-functional additive

Application

Lubristay 315 is a water dispersible lubricity additive, emulsifier and coupling agent for metalworking fluids. It is comprised of esters of vegetable oils and triglycerides.

Lubristay 315 exhibits an HLB about 3.0 which makes it highly effective oil dispersable additive.

Lubristay 315 provides good thermal, oxidative and bio-stability. In addition to providing lubricity, it helps stabilize emulsions in hard water. Its low viscosity and easy handling make it an excellent tool for formulating soluble, semi-synthetic metalworking fluids and emulsifiable rust preventives.

Typical Properties

Test	Typical
Appearance	Clear, reddish liquid
Specific gravity at 25° C	0.97
Water, wt. %	<2.0
Total acid number, mg KOH/g	<1.0
Active, wt. %	98
HLB	3.0

Benefits

- Imparts excellent lubricity and extreme pressure properties.
- Increased falex test results by 100% when incorporated into a simple soluble oil system.
- Can be used as part of the emulsifier package in soluble oils and semi-synthetics. Approximate HLB 3.0
- Easy to handle.

Suggested Formulation Details

General-purpose soluble oil

<u>Components</u>	<u>% by Weight</u>
100 SUS Naphthenic or Paraffinic oil	80
Primary emulsifier	5 - 10
Counter Rust T-18 (Amine borate)	5
Lubristay 315	4 - 8
Biocide	1 - 3
Fungicide.....	0.5 - 1
Water.....	balance

Storage and Handling

Recommended Maximum Long Term Storage Temperature*	Ambient
Recommended Minimum Temperature for Use	Ambient
Flash Point	93.9° C COC



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