Developed: July 26, 1961
Tentative Process: P-1127, Job 4013
By: J. D. Sullivan and K. L. McHugh

Product Group: II

Composition:

		Lbs/100 lbs.	
81101	Aroclor 1242	~~75.33~~	75.31
43350	N-phenyl-1-Naphthylamine	~~0.08~~	0.05
80974	FH-139 (50% in 81101)	~~6.82~~	1.80
82611	Aroclor 1232	13.13	12.84
80180	Tricresyl Phosphate	~~10.00~~	10.00
31100	DC 200 fluid, 350 cs	~~0.005~~	0.005
			100.00

Specifications:

Properties	~~Tentative~~ Limits	Procedures
Flash Point	350°F minimum	50-A ok
Fire Point	550°F minimum	50-A
Foam Test		~~54-A~~
Tendency	Less than 100 ml	
Stability	Report in seconds	
Pour Point	0°F maximum	100-A
Viscosities:		121-A
At 100°F	21.5 to 23.5 cs	
At 210°F	3.15 to 3.35 cs	

Special Precautions:

The 1.8% poly-oxybutylene - MDI) diol (FH-139) is the average percent of polymer needed to impart the required viscosities to the final formulations in laboratory runs. FH-139 is prepared as a 50% solution in Aroclor 1242 (TENTATIVE PROCESS P-1216) and its effective thickening power varies from batch to batch. The 1.8% polymer charge is valid - only if the viscosity of a 4% solution of FH-139 in Aroclor 1242 falls into the 35 to 37 cs range at 100°F. If the 4% control solution of FH-139 is outside of this viscosity range the required polymer charge will have to be determined by formulation studies. In adding the FH-139 as a 50% solution of Aroclor 1242, the corresponding correction will have to be made for the Aroclor 1242 required for MCS 153. A given batch of FH-139 should not be formulated into MCS 153 until the corrective dilutions are determined by the Functional Fluid Application Laboratories (St. Louis Research).

Blending:

Charge heated 81101 into blend tank, dissolve 43350 in hot (90°C) 81101 and add to blend with thorough mixing, followed by 80974, 82611, 80180 and 31100. Mix, then circulate through polishing filter prior to packaging. Do not heat above 65°C.

Toxicity and Hazards:

N-phenyl-1-Naphthylamine is a somewhat toxic solid which must not be permitted to come in contact with the skin. Wear chemical respirator, fume goggles and rubber gloves when handling it. All other materials are inert but should be handled with care. Prevent contact with the skin.

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Issue No. 2:

~~Developed~~ by J. D. Sullivan

Approved by:

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