



CORTEC

CORPORATION

Environmentally Safe VpCI®/MCI® Technologies

M-251 Anticorrosion Additive to Synthetic Cutting Fluids

DESCRIPTION

M-251 is an environmentally friendly, low foaming water soluble corrosion inhibiting additive for synthetic cutting fluids. It provides corrosion protection to carbon steel, copper, galvanized steel, and other ferrous and non-ferrous metals and their alloys. M-251 provides both contact and vapor phases corrosion protection during and after operation.

M-251 is compatible with most water-based lubricants and with a range of biocides. It is compatible with sea water, which allows the use of this additive in off-shore conditions.

PACKAGING & STORAGE

M-251 is available in 5 gallon (19 L) plastic pails and 55 gallon (208 L).

To ensure best product performance, store in original packaging, indoors, and out of direct sunlight at 40-100 °F (4-38 °C).

Shelf life: 2 years

VpCI® METALWORKING PRODUCTS



FEATURES

- Stable in aqueous systems with a pH of 6 or above
- Can be used with fresh and salt water
- Soluble in water, glycol, and alcohols
- Non-phenolic
- Biodegradable
- Non-hazardous, environmentally friendly
- UFI: P940-5052-M00F-RX0F

TYPICAL PROPERTIES

Appearance	Clear Yellow/Amber Liquid	
pH	8-9 (1% solution in water)	
Density	8.5-8.7 lb/gal (1.02-1.03 kg/L)	
Non-Volatile Content	50-60%	
Cast Iron Chip Test ASTM D-4627 (1% concentration)	Pass	
Immersion Test ASTM G 31	Fresh Water	(0.5%) Pass
	Salt Water	(5%) Pass

TYPICAL APPLICATION

As an additive to synthetic cutting fluids M-251 should be added in the following concentrations:

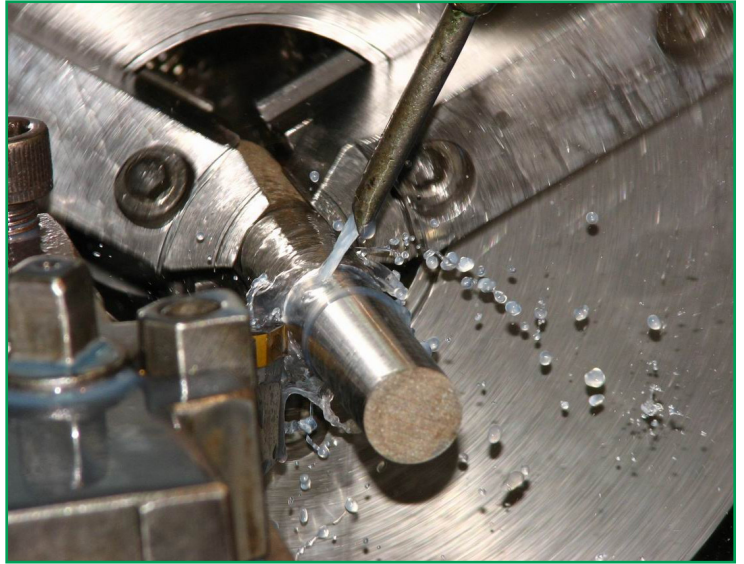
- Operation and short term (up to 30 days) protection after the operation - 0.75-1.0%
- Operation and longer term (up to 90 days) protection after the operation - 1-5%
- Operation with salt water - 2.5-5%

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- Operation with salt water and short term of protection after the operation - 5-10%

Other applications

- Water-based lubricants
- Alkaline metal cleaners
- Water-based drilling muds
- Water-based hydraulic fluids



LIMITED WARRANTY

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Cortec® Corporation warrants Cortec® products will be free from defects when shipped to customer. Cortec® Corporation's obligation under this warranty shall be limited to replacement of product that proves to be defective. To obtain replacement product under this warranty, the customer must notify Cortec® Corporation of the claimed defect within six months after shipment of product to customer. All freight charges for replacement products shall be paid by customer.

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