

### INTRODUCTION

PC-1644 Defoamer is a 40 % solution of an acrylic polymer in a petroleum solvent. It was developed to offer improved defoaming performance versus PC-1244 in non-aqueous organic fluids. PC-1644 is a general purpose defoamer which offers superior foam control at low use levels, generally 10 to 20 % lower use level versus PC-1244. PC-1644 is silicone-free and exhibits very low odor.

PC-1644 defoamer applications include usage in gear oils, specialty lubricants, and shock absorber, hydraulic, turbine or transmission oils. Typical use levels of the solutions range from 50 - 500 ppm (20 - 200 ppm active polymer). The optimum level is dependent upon the nature of the oil and it is therefore necessary to run a concentration profile for each oil. The defoamer is most typically employed at 200 - 250 ppm of solution (80 - 100 ppm active polymer).

### AVAILABLE REGION(S)

Asia-Pacific, Europe/Africa, North America, South America

### PUBLICATION NUMBER

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### PHYSICAL PROPERTIES

Property	Limits	Test Method
Appearance	Clear, colorless to light yellow liquid	001
Refractive Index, nD25 @ 25 °C	1.4380 - 1.4405	36-A
Non-Volatiles, % (2 hrs. @ 105 °C)	38 - 42	010
Viscosity, SUS @ 100 °F	150 - 330	098
Specific Gravity @ 60 °F	0.84 - 0.86	005
Color, APHA	150 max	D0016000

### USEFUL INFORMATION

Flash Point, (Pensky-Martens, closed cup)	144 °F (62 °C)
Brookfield Viscosity, cps @ 25 °C	30 - 80
Solvent	Hydrocarbon
Solubility in water	Negligible

### SHELF-LIFE

At temperatures up to 35 °C storage stability packed in original containers amounts to at least 1460 days.