

FORANE® 134a

Forane® 134a refrigerant (R-134a) is a non-ozone depleting HFC refrigerant with properties very similar to R-12. It can be used both as a pure refrigerant in a number of traditional R-12 applications and as a component in refrigerant blends targeted to replace R-502 and R-22.

- Application** Applications include automotive air conditioning, chillers, medium temperature commercial refrigeration, refrigeration appliances, and transport refrigeration.
- Compressor and system manufacturers are selling new equipment specifically designed for R-134a. In addition, Arkema's laboratory testing and field trials have indicated R-134a will work in the retrofit of many existing R-12 and R-500 installations.
- Properties & Performance** R-134a is designed to meet the needs of many air conditioning and medium temperature refrigeration systems. R-134a is a single component refrigerant rated A1 by ASHRAE (lowest levels of toxicity and flammability), having zero ozone depletion potential.
- Lubrication** POE or PAG (polyalkylene glycol, auto only) lubricants must be used with R-134a since it is not miscible with mineral oil or alkylbenzene lubricants found in many systems. Special care must be taken when using POE or PAG oils due to their hygroscopicity (moisture absorption) when left exposed to the atmosphere. When retrofitting, a lubricant flush procedure is necessary to reduce the original oil content below 5% of the total oil charge. New R-134a equipment will be charged with the OEM recommended lubricant, ready to use with R-134a.
- Charging** Charging with R-134a can be done either as a vapor or a liquid. End-users should check with their equipment manufacturers guidelines for specific charging instructions.
- Retrofit** R-134a can be used to retrofit certain, existing R-12 systems. Applications include refrigeration, automotive A/C and many commercial A/C systems.
- When retrofitting R-12 systems to R-134a, it is necessary to replace the existing lubricant with POE oil, except in some automotive retrofit applications, which require PAG oil. In most cases, the mineral oil or alkylbenzene oil levels must be reduced below 5% of the new POE charge. Check with OEMs for any specific recommendations regarding oils or procedures. Remove as much of the existing lubricant as possible, add POE, and run the system on R-12 for some time. When the residual oil concentration is appropriate, remove R-12, replace the filter-drier, and charge R-134a.

PROPERTIES	R-134a
Average Molecular Weight (g/mol)	102.0
Normal Boiling Point (°F)	-14.9
Critical Temperature (°F)	214.1
ASHRAE Safety Group Classification	A1
Ozone Depletion Potential (ODP)	0
Global Warming Potential (GWP)	1,430

DEFINITIONS

Bubble Point (Saturated Liquid Temperature)	The temperature (for a given pressure) at which the liquid of a refrigerant blend (any 400 or 500 series refrigerant) begins to evaporate or boil. This is similar to the saturated liquid temperature of a single component refrigerant.
Dew Point (Saturated Vapor Temperature)	The temperature (for a given pressure) at which the vapor of a given refrigerant blend (any 400 or 500 series refrigerant) begins to condense or liquefy. This is similar to the saturated vapor temperature of a single component refrigerant.
Fractionation	The change in composition of a refrigerant blend (any 400 or 500 series refrigerant) when it changes phase from liquid to vapor (evaporation) or from vapor to liquid (condensation). This behavior in blends explains the permanent changes to refrigerant composition from leaks, causing the blend to deviate outside the tolerances of the designed composition.
Glide	The difference in temperature between the evaporator outlet and inlet due to fractionation of the blend. Theoretically, this can be calculated by finding the difference between the dew and bubble temperatures at constant pressure. Actual measurements may differ slightly depending on the state of the liquid refrigerant at either end of the evaporator (or condenser). Pressure losses through the evaporator may also affect glide.
Normal Boiling Point (NBP)	The temperature at which a given refrigerant begins to boil while at atmospheric pressure (14.7 psia).
Abbreviations	AB – alkylbenzene GWP – global warming potential MO – mineral oil ODP – ozone depletion potential OEM – original equipment manufacturer POE – polyolester PAG – polyalkylene glycol

OTHER TOPICS

Refrigerant Lubricants

The phase-out of ozone depleting refrigerants has impacted air-conditioning and refrigeration equipment design in many ways. One of the most significant changes to these systems is the transition of the compressor lubricants. Use of an appropriate lubricant is important when servicing, installing, or retrofitting a system. The following information may be helpful as general background information on refrigerant lubricants; however, always follow OEM recommendations for proper lubricant selection.

Mineral Oil: Mineral oil has been the lubricant of choice for systems utilizing many of the CFC and HCFC refrigerants. Both the CFCs and HCFCs tend to have adequate miscibility with mineral oil, helping to ensure acceptable oil return under normal operating conditions. Sometimes a synthetic lubricant (i.e. AB or POE) is required under certain conditions, such as reduced miscibility with CFC retrofit blends or high discharge temperatures with products like R-22.

Alkylbenzene: Alkylbenzene is a synthetic refrigerant compressor lubricant used in new refrigeration systems and for retrofits from CFCs to HCFCs. Typically, Alkylbenzene has better miscibility with HCFCs than mineral oil, resulting in more reliable oil return. For retrofits of older CFC equipment, a partial oil change from mineral oil to alkylbenzene may be acceptable.

Polyolester: HFC refrigerants serve as the replacements for the ozone-depleting CFCs and HCFCs. However, both mineral oil and alkylbenzene have poor miscibility with HFCs, making oil return with these products unreliable in many systems. POEs are synthetic oils commonly used in new HFC systems and for retrofitting older CFC and HCFC equipment to HFC refrigerants. Special care must be taken when using POE oils due to their quick absorption of moisture when left exposed to the atmosphere (hygroscopic).

Polyalkylene Glycol: In addition to POE oils, polyalkylene glycol (PAG) lubricants are used with R-134a in automotive air-conditioning applications. Like POEs, PAGs are hygroscopic synthetic oils and must be treated with care to minimize exposure to moisture. While both POEs and PAGs are used with R-134a in automotive systems, the two oil types are not interchangeable and should not be mixed.

Material Compatibility

Whenever retrofitting an air-conditioning or refrigeration system, compatibility of system materials is always a concern. Items such as elastomers, hoses, and filter-driers respond differently to different refrigerants and oils. For these reasons, before performing any refrigerant retrofit, Arkema recommends contacting the OEM for specific recommendations. Arkema's Technical Service hotline can also be reached at (800) 738-7695.

Leak Detection

Leak checking should be a routine practice whenever performing maintenance on or servicing an air-conditioning or refrigeration system. As elastomers and other sealing components may react differently to new refrigerants and oils, leak checking should always be performed after any refrigerant retrofit.

Certain older style leak detectors have difficulty detecting newer refrigerants. It is important to verify whether or not your leak detector is rated for the type of refrigerant (CFC, HCFC, or HFC) you will be working with. Also, some refrigerant dyes are only compatible with specific refrigerant oils. Always check with the manufacturer before using a leak dye in an air-conditioning or refrigeration system.

Forane® Refrigerant Pressure Temperature Chart

PRESSURE (PSIG)																		
Sat. Temp (°F)	R-22	R-407C Liquid Pressure	R-407C Vapor Pressure	R-410A Liquid Pressure	R-427A Liquid Pressure	R-427A Vapor Pressure	R-407A Liquid Pressure	R-407A Vapor Pressure	R-123	R-12	R-134a	R-409A Liquid Pressure	R-409A Vapor Pressure	R-401A Liquid Pressure	R-401A Vapor Pressure	R-401B Liquid Pressure	R-401B Vapor Pressure	Sat. Temp (°C)
-50	6.2	2.9	11.4	5.3	3.8	11.9	0.8	9.0	29.2	15.4	18.7	12.4	17.2	13.5	17.9	12.2	16.8	-45.6
-45	2.7	0.4	8.5	8.0	0.1	9.0	1.7	5.7	29.0	13.3	16.9	9.7	15.2	11.1	16.0	9.6	14.7	-42.8
-40	0.5	2.5	5.2	11.0	1.9	5.9	3.9	2.0	28.9	11.0	14.8	6.8	13.1	8.4	13.8	6.7	12.4	-40.0
-35	2.6	4.8	1.5	14.2	4.1	2.4	6.4	1.0	28.7	8.4	12.5	3.5	10.7	5.3	11.4	3.4	9.7	-37.2
-30	4.9	7.3	1.3	17.8	6.6	0.8	9.2	3.3	28.4	5.5	9.8	0.0	8.1	2.0	8.7	0.1	6.8	-34.4
-25	7.4	10.1	3.6	21.8	9.3	2.9	12.2	5.8	28.1	2.3	6.9	2.0	5.1	0.8	5.6	2.0	3.5	-31.7
-20	10.1	13.1	6.1	26.1	12.2	5.3	15.6	8.5	27.8	0.6	3.7	4.1	1.9	2.9	2.2	4.1	0.1	-28.9
-15	13.2	16.5	8.8	30.8	15.4	7.9	19.2	11.5	27.4	2.4	0.1	6.5	0.8	5.1	0.7	6.5	2.0	-26.1
-10	16.5	20.1	11.9	35.9	18.9	10.8	23.2	14.9	27.0	4.5	1.9	9.0	2.8	7.5	2.8	9.1	4.2	-23.3
-5	20.0	24.0	15.2	41.5	22.8	14.0	27.5	18.5	26.5	6.7	4.1	11.8	4.9	10.1	5.0	11.9	6.6	-20.6
0	23.9	28.3	18.9	47.5	26.9	17.5	32.2	22.5	25.9	9.1	6.5	14.8	7.2	13.0	7.4	14.9	9.2	-17.8
5	28.2	33.0	22.9	54.1	31.4	21.2	37.3	26.9	25.3	11.8	9.1	18.1	9.7	16.1	10.1	18.2	12.1	-15.0
10	32.8	38.0	27.3	61.2	36.3	25.4	42.8	31.6	24.6	14.6	11.9	21.7	12.5	19.5	13.0	21.8	15.2	-12.2
15	37.7	43.5	32.0	68.8	41.5	29.9	48.7	36.7	23.7	17.7	15.0	25.5	15.4	23.1	16.2	25.7	18.6	-9.4
20	43.0	49.3	37.2	77.1	47.2	34.7	55.1	42.3	22.8	21.0	18.4	29.6	18.7	27.1	19.6	29.9	22.3	-6.7
25	48.7	55.7	42.7	86.0	53.3	40.0	62.0	48.3	21.8	24.6	22.1	34.0	22.2	31.4	23.4	34.4	26.3	-3.9
30	54.9	62.5	48.7	95.5	59.8	45.7	69.3	54.8	20.7	28.4	26.0	38.7	26.0	36.0	27.4	39.3	30.6	-1.1
35	61.5	69.8	55.2	105.7	66.8	51.9	77.2	61.8	19.5	32.5	30.3	43.8	30.1	40.9	31.8	44.5	35.2	1.7
40	68.5	77.6	62.1	116.6	74.3	58.7	85.6	69.4	18.1	36.9	35.0	49.2	34.5	46.2	36.5	50.1	40.2	4.4
45	76.0	86.0	69.5	128.3	82.3	65.6	94.6	77.4	16.6	41.6	40.0	54.9	39.2	51.8	41.6	56.0	45.6	7.2
50	84.0	94.9	77.5	140.8	90.8	73.3	104.2	86.1	15.0	46.7	45.4	61.0	44.3	57.9	47.0	62.4	51.4	10.0
55	92.5	104.5	86.0	154.1	99.9	81.5	114.4	95.3	13.1	52.0	51.1	67.6	49.8	64.3	52.8	69.2	57.5	12.8
60	101.6	114.6	95.1	168.2	109.6	90.3	125.2	105.2	11.2	57.7	57.3	74.5	55.6	71.2	59.0	76.5	64.1	15.6
65	111.2	125.4	104.8	183.2	119.9	99.6	136.7	115.7	9.0	63.7	63.9	81.8	61.9	78.5	65.7	84.2	71.2	18.3
70	121.4	136.9	115.2	199.2	130.8	109.6	148.8	127.0	6.6	70.2	71.0	89.5	68.6	86.3	72.8	92.3	78.7	21.1
75	143.6	149.1	126.2	216.1	142.4	120.3	161.7	138.9	4.0	76.9	78.6	97.7	75.8	94.5	80.3	101.0	86.7	23.9
80	143.6	162.1	137.8	234.0	154.6	131.6	175.3	151.6	1.2	84.1	86.6	106.4	83.4	103.2	88.4	110.2	95.2	26.7
85	155.7	175.8	150.2	253.0	167.6	143.7	189.7	165.1	0.9	91.7	95.1	115.5	91.5	112.4	96.9	119.8	104.2	29.4
90	168.4	190.2	163.4	273.0	181.2	156.4	204.8	179.3	2.5	99.7	104.2	125.2	100.2	122.2	106.0	130.1	113.8	32.2
95	181.8	205.5	177.4	294.1	195.6	170.0	220.8	194.4	4.2	108.2	113.8	135.3	109.4	132.5	115.6	140.9	123.9	35.0
100	195.9	221.6	192.1	316.4	210.8	184.4	237.6	210.4	6.1	117.1	124.1	146.0	119.2	143.3	125.7	152.3	134.7	37.8
105	210.7	238.5	207.8	339.9	226.8	199.6	255.3	227.4	8.1	126.5	134.9	157.2	129.6	154.8	136.5	164.3	146.0	40.6
110	226.3	256.4	224.4	364.6	243.6	215.7	273.9	245.2	10.3	136.4	146.3	169.0	140.6	166.8	147.8	176.9	158.0	43.3
115	242.7	275.1	241.9	390.5	261.2	232.7	293.5	264.1	12.6	146.7	158.4	181.4	152.3	179.4	159.8	190.1	170.6	46.1
120	259.9	294.7	260.5	417.7	279.7	250.6	314.0	284.0	15.1	157.6	171.1	194.4	164.7	192.7	172.4	204.0	183.9	48.9
125	277.9	315.2	280.1	446.3	299.1	269.5	335.4	305.0	17.7	169.0	184.5	208.0	177.8	206.6	185.7	218.6	197.9	51.7
130	296.8	336.7	300.9	476.3	319.4	289.5	357.9	327.1	20.6	180.9	198.7	222.3	191.6	221.2	199.7	233.9	212.6	54.4
135	316.5	359.2	322.9	507.6	340.7	310.5	381.5	350.5	23.6	193.5	213.6	237.2	206.3	236.5	214.5	250.0	228.1	57.2
140	337.2	382.6	346.2	540.5	362.9	332.6	406.2	375.1	26.8	206.5	229.3	252.9	221.8	252.5	229.9	266.7	244.3	60.0
145	358.8	407.0	370.8	574.8	386.1	355.9	431.9	401.0	30.2	220.2	245.7	269.3	238.2	269.3	246.2	284.3	261.4	62.8
150	381.5	432.4	396.9	610.6	410.3	380.4	458.9	428.3	33.8	234.5	263.0	286.4	255.5	286.8	263.2	302.6	279.3	65.6

Red Numerals (in bold and italics) - Inches Hg. Below 1 ATM

PRESSURE (PSIG)

Sat. Temp (°F)	R-502	R-408A Liquid Pressure	R-402A Liquid Pressure	R-402B Liquid Pressure	R-404A Liquid Pressure	R-507A	Sat. Temp (°C)
-50	<i>0.2</i>	<i>1.6</i>	2.5	1.1	0.6	1.1	-45.6
-45	1.9	1.1	4.9	3.2	2.7	3.3	-42.8
-40	4.1	3.3	7.4	5.6	5.0	5.7	-40.0
-35	6.5	5.6	10.3	8.2	7.6	8.3	-37.2
-30	9.2	8.2	13.4	11.1	10.4	11.2	-34.4
-25	12.1	11.0	16.7	14.2	13.4	14.3	-31.7
-20	15.3	14.1	20.4	17.6	16.8	17.8	-28.9
-15	18.8	17.5	24.5	21.4	20.5	21.6	-26.1
-10	22.6	21.2	28.8	25.4	24.5	25.7	-23.3
-5	26.7	25.2	33.6	29.8	28.8	30.1	-20.6
0	31.1	29.5	38.7	34.6	33.5	34.9	-17.8
5	35.9	34.2	44.2	39.8	38.6	40.2	-15.0
10	41.0	39.3	50.1	45.3	44.0	45.8	-12.2
15	46.5	44.8	56.5	51.3	49.9	51.8	-9.4
20	52.5	50.7	63.4	57.6	56.2	58.3	-6.7
25	58.8	57.0	70.7	64.5	63.0	65.3	-3.9
30	65.6	63.7	78.5	71.8	70.3	72.8	-1.1
35	72.8	71.0	86.9	79.6	78.1	80.8	1.7
40	80.5	78.7	95.8	88.0	86.4	89.3	4.4
45	88.7	87.0	105.3	96.9	95.2	98.4	7.2
50	97.4	95.8	115.4	106.3	104.7	108.1	10.0
55	106.6	105.1	126.1	116.3	114.7	118.5	12.8
60	116.4	115.1	137.4	127.0	125.3	129.4	15.6
65	126.7	125.6	149.4	138.2	136.6	141.1	18.3
70	137.6	136.8	162.1	150.1	148.6	153.4	21.1
75	149.1	148.7	175.5	162.7	161.2	166.4	23.9
80	161.2	161.2	189.7	176.0	174.6	180.2	26.7
85	174.0	174.4	204.6	189.9	188.8	194.8	29.4
90	187.4	188.4	220.2	204.7	203.7	210.1	32.2
95	201.4	203.1	236.8	220.2	219.4	226.3	35.0
100	216.2	218.7	254.2	236.5	235.9	243.4	37.8
105	231.7	235.4	272.4	253.6	253.4	261.3	40.6
110	247.9	252.1	291.6	271.6	271.7	280.2	43.3
115	264.9	270.2	311.7	290.5	290.9	300.0	46.1
120	282.7	289.1	332.8	310.3	311.1	320.8	48.9
125	301.4	308.9	354.9	331.0	332.3	342.6	51.7
130	320.8	329.7	378.1	352.7	354.5	365.5	54.4
135	341.2	351.5	402.4	375.4	377.8	389.4	57.2
140	362.6	374.3	427.8	399.2	402.2	414.5	60.0
145	385.0	398.1	454.4	424.0	427.7	440.7	62.8
150	408.4	423.0	482.3	450.0	454.4	468.1	65.6

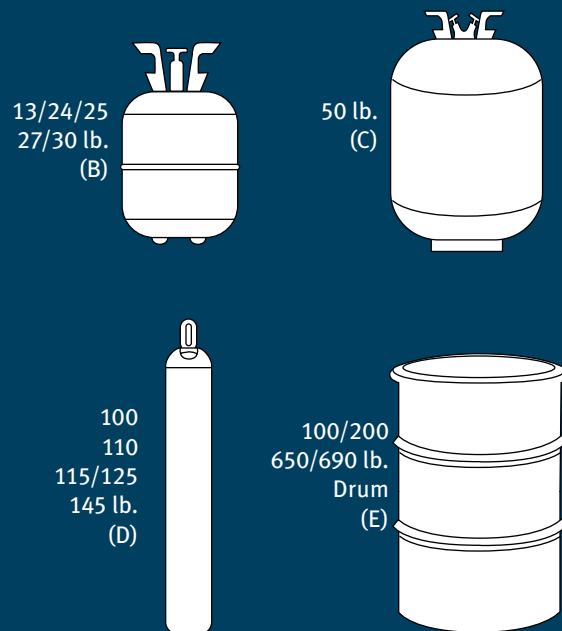
Red Numerals (in bold and italics) - Inches Hg. Below 1 ATM

Forane® Refrigerant Cylinder Identification

Type	Color Code	Sizes (Net lbs.)	
R-12	CFC	White	30 (B), 50 (C), 145 (D), 2000
R-502	CFC	Lavender	30 (B), 125 (D)
R-22	HCFC	Light Green	30 (B), 50 (C), 125 (D), 1000, 1750
R-123	HCFC	Light Blue Grey	100 (E), 200 (E)
R-401A	HCFC	Pinkish Red	30 (B), 125 (D)
R-401B	HCFC	Mustard	30 (B), 125 (D)
R-402A	HCFC	Sand	27 (B), 110 (D)
R-402B	HCFC	Olive	13 (B)
R-408A	HCFC	Medium Purple	24 (B), 100 (D), 1300
R-409A	HCFC	Tan	30 (B), 125 (D), 1800
R-134a	HFC	Light Blue	30 (B), 125 (D), 1000, 1750
R-404A	HFC	Orange	24 (B), 100 (D), 1300 tons
R-407A	HFC	Lime Green	25 (B), 115 (D)
R-407C	HFC	Brown	25 (B), 115 (D), 1000, 1600
R-427A	HFC	Green	25 (B) 110 (D)
R-410A	HFC	Rose	25 (B), 100 (D), 850, 1350
R-507A	HFC	Teal	25 (B), 100 (D), 800, 1400

Container Types

Size not to scale



Forane® Refrigerant Basic Property Data Chart

Properties	R-410A	R-427A	R-407A	R-407C	R-134a	R-404A	R-507A	R-22	R-408A	R-409A	R-123
Average Molecular Weight (g/mol)	72.6	90.4	90.1	86.2	102.0	97.6	98.8	86.5	87.0	97.4	152.9
Normal Boiling Point (NBP) (°F)	-61.9	-44.8	-49.0	-46.1	-14.9	-51.5	-52.8	-41.3	-47.9	-30.1	82.1
Latent Heat of Vaporization at NBP (BTU/lb)	116.7	102.0	101.3	107.4	92.8	86.0	84.3	100.5	97.6	94.6	73.7
Critical Temp (°F)	162.0	185.6	180.1	187.2	214.1	161.6	159.8	204.8	182.6	224.2	362.7
Critical Pressure (psia)	717.9	637.1	654.9	670.1	590.3	539.5	539.5	722.3	629.5	667.2	532.9
Density of Saturated Vapor @ NBP (lb/ft³)	0.26	0.30	0.30	0.29	0.33	0.34	0.34	0.29	0.30	0.31	0.40
Density of Saturated Liquid at 77°F (lb/ft³)	66.3	71.9	71.5	71.1	75.3	65.2	65.0	74.5	66.3	75.9	91.3
Specific Heat of Saturated Vapor at NBP (BTU/lb °R)	0.17	0.18	0.18	0.17	0.19	0.18	0.18	0.14	0.16	0.15	0.16
Specific Heat of Saturated Liquid at 77°F (BTU/lb °R)	0.44	0.38	0.36	0.38	0.34	0.39	0.39	0.30	0.37	0.30	0.23
Ozone Depletion Potential (ODP) (CFC-11 = 1.0)	0	0	0	0	0	0	0	0.055	0.026	0.05	0.02
ASHRAE Safety Group Classification	A1	A1	A1	A1	A1	A1	A1	A1	A1	A1	B1
Occupational Exposure Limits (8 hr time/wt. Avg.) (ppm)	1,000	1,000	1,000	1,000	1,000	1,000	1,000	1,000	1,000	1,000	50
Global Warming Potential (GWP)	2,100	2,130	2,100	1,800	1,430	3,900	4,000	1,810	2,650	1,290	77

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Arkema Inc.
 2000 Market Street
 Philadelphia, PA 19103-3222
 Tel.: 215-419-7000
 www.arkema-inc.com