

4119 White Bear Parkway, St. Paul, MN 55110 USA Phone (651) 429-1100, Fax (651) 429-1122 Toll Free (800) 4-CORTEC, E-mail info@cortecvci.com Internet http://www.cortecvci.com

Evaluation and Recommendation of Cortec Additives to Hydraulic Fluid and Cutting Fluid for Customer

Background: Hydraulic Fluid and Cutting Fluid samples were sent by customer for recommendation of the best additives for corrosion protection.

The Hydraulic Fluid, Castrol Blue Hydraulic Plus 46 manufactured by BP, contains 95-100% highly refined base oil. PAR-KOOL SS387 LF and 92% water. PAR-KOOL SS 387 LF (manufactured by Parent Petroleum, Inc) is a high oil semi-synthetic micro emulsion. It is alkaline and contains 5-10% Triethanolamine and 1-3% Monoethanolamine.

Purpose: Evaluate and recommend the best additives for the above samples.

Materials:

- 1) Submitted hydraulic fluid sample
- 2) Submitted PAR-KOOL cutting fluid sample
- 3) Carbon Steel Panels
- 4) Methanol-lab grade
- 5) Cortec M-530
- 6) Cortec M-528
- 7) Cortec M-95
- 8) Cortec M-370

Method: ASTM D 1748 (Humidity Cabinet at 50°C, RH 99%)

Procedure:

- 1) Make solution of 3% M-530 in the submitted hydraulic fluid sample.
- 2) Make solutions of 1% M-95, 1% M-528, 5% M-528, 2% M-370, and 3% M-370 in the submitted PAR-KOOL cutting fluid sample, respectively.
- 3) Observe compatibility of the above solutions, also the submitted samples (as controls).
- 4) Clean the carbon steel panels with methanol.
- 5) Coat the cleaned carbon steel panels with the above solutions, also the submitted samples (as controls), respectively. Let air dry overnight, and subject them to Humidity Cabinet. Observe the panels daily for signs of corrosion.





Results:

Compatibility Observation

Material	Compatibility at Room	Compatibility at 40°C,
	Temperature	48hrs
3% M-530 in Castrol Blue	Compatible	Compatible
Hydraulic Fluid		
Castrol Blue Hydraulic Fluid		
(control)		
PAR-KOOL Cutting Fluid	Stable emulsion	Separated; but emulsified
(control)		again when stirred
1% M-95in PAR-KOOL	Stable emulsion	Separated; but emulsified
Cutting Fluid		again when stirred
1% M-528 in PAR-KOOL	Stable emulsion	Stable emulsion
Cutting Fluid		
5% M-528 in PAR-KOOL	Stable emulsion	Stable emulsion
Cutting Fluid		
3% M-370 in PAR-KOOL	Stable emulsion	Stable emulsion
Cutting Fluid		

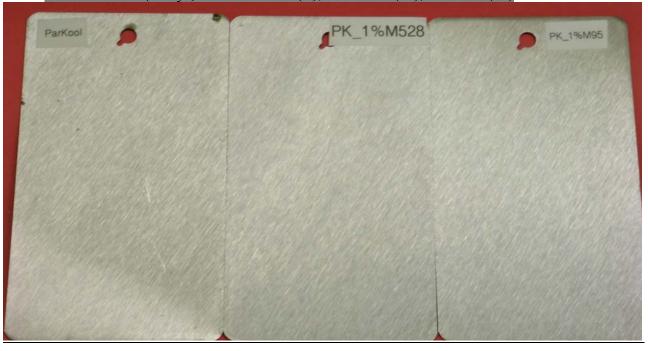
ASTM D 1748 (4 days)

TISTITE THE CHARGE		
Material	Corrosion Observation	
3% M-530 in Hydraulic	No sign of corrosion	
Fluid		
Hydraulic Fluid (control)	Corrosion	
1% M-95 in PAR-KOOL	No sign of corrosion	
Cutting Fulid	_	
1% M-528 in PAR-KOOL	No sign of corrosion	
Cutting Fluid	_	
5% M-528 in PAR-KOOL	No sign of corrosion	
Cutting Fluid	_	
2% M-370 in PAR-KOOL	Signs of corrosion	
Cutting Fluid	_	
3% M-370 in PAR-KOOL	No sign of corrosion	
Cutting Fluid		
PAR-KOOL Cutting Fluid	Corrosion after 1 day	
(control)		

ASTM D 1748 (4 days) – Hydraulic Fluid (L) and 3% M-530 (R)



ASTM D 1748 (4 days) - PAR-KOOL (L), 1% M-528(M),1% M-95 (R)



ASTM D 1748 (4 days) – 2% M-370 (L), 3% M-370(M),5% M-528 (R)



Conclusion:

For Hydraulic Fluid, addition of 3% of M-530 provided corrosion protection in 50°C, 99% RH Humidity Cabinet for 4+ days; it is also compatible to the Hydraulic Fluid. Thus, 3% of Cortec M-530 is recommended as additive for corrosion protection.

For PAR-KOOL Cutting Fluid Sample, 1% M-95, 1% M-528, and 3% M-370 all provided excellent corrosion protection in 50°C, 99% RH Humidity Cabinet for 4+ days. In addition, M-528 and M-370 also added emulsion stability of the PAR-KOOL Cutting Fluid sample. The customer can choose any of the above options as anti-corrosion additive.

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From: Ming Shen

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cc: Boris Miksic

Anna Vignetti Rita Kharshan Mike Morin