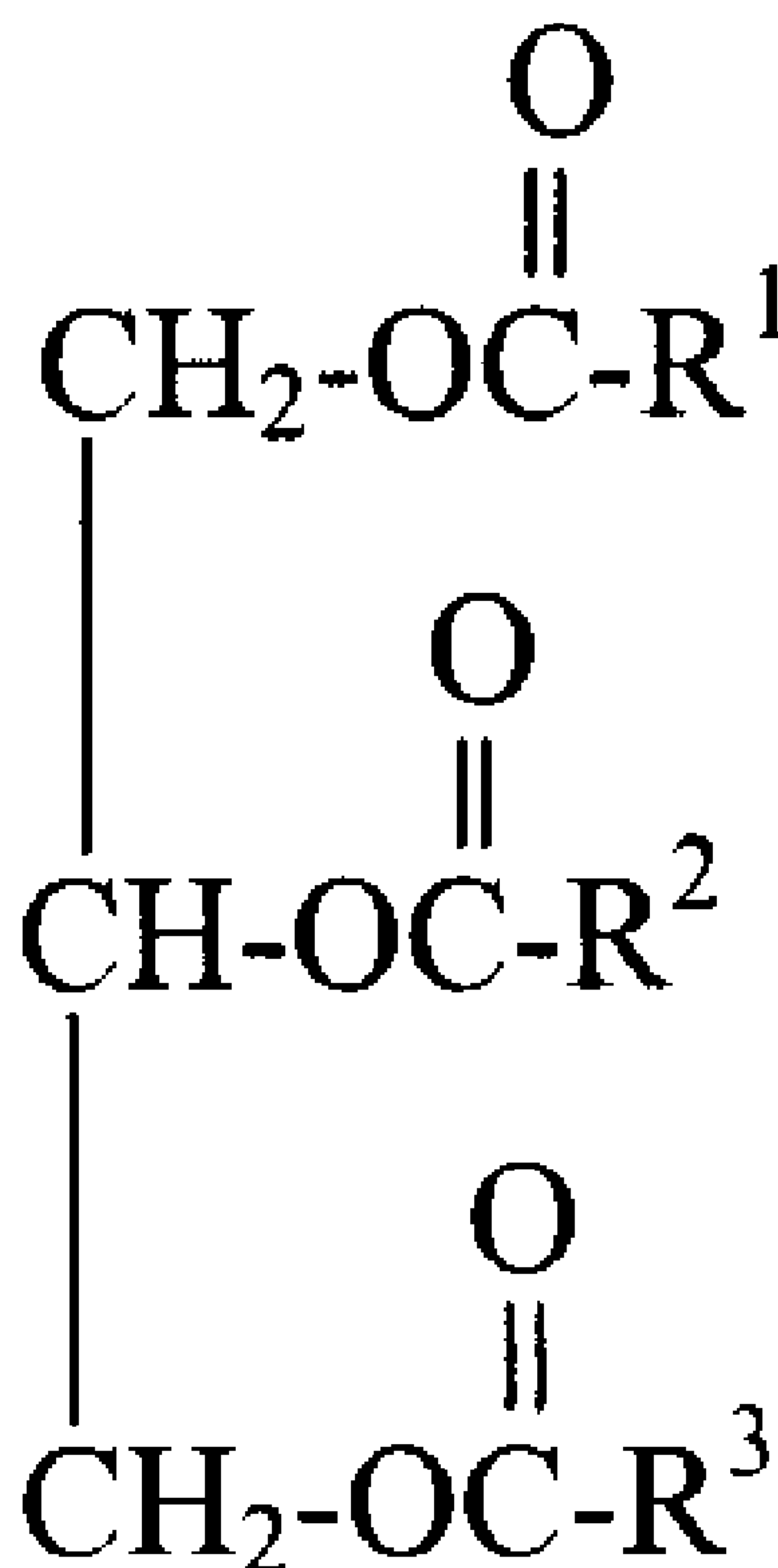




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(54) Titre : LUBRIFIANT DE PENETRATION BIODEGRADABLE
(54) Title: BIODEGRADABLE PENETRATING LUBRICANT



(57) Abrégé/Abstract:

A biodegradable penetrating lubricant, comprised of: (A) at least one triglyceride oil of formula (I), wherein R¹, R², and R³ are aliphatic hydrocarbyl groups containing from about 7 to about 23 carbon atoms; (B) an organic solvent selected from the group comprising: (1) ethyl lactate; (2) methyl ester; and (3) combinations of 1 and 2; (C) an antioxidant; and, (D) a corrosion inhibitor. Optionally, the lubricant may further an additive selected from the group comprising: (E) a viscosity modifier; (F) an anti-wear inhibitor; and, (G) an emulsifier.



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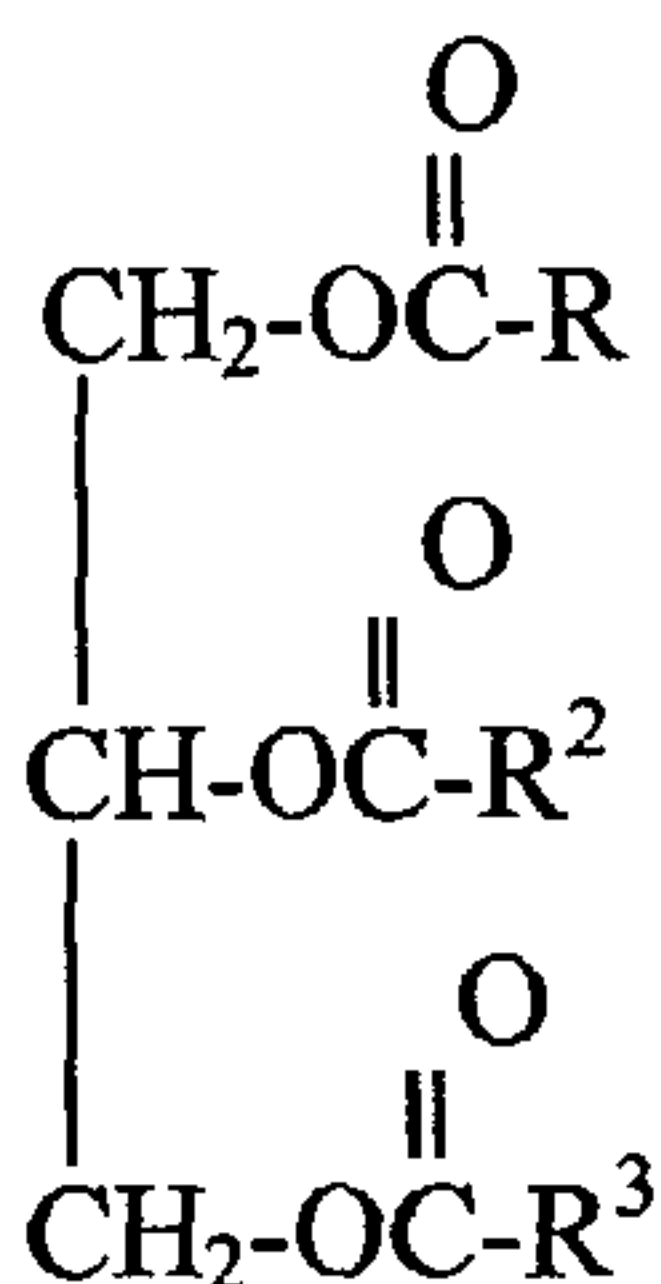
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(54) Title: BIODEGRADABLE PENETRATING LUBRICANT

(57) **Abstract:** A biodegradable penetrating lubricant, comprised of: (A) at least one triglyc-
eride oil of formula (I), wherein R¹, R², and R³ are aliphatic hydrocarbyl groups containing
from about 7 to about 23 carbon atoms; (B) an organic solvent selected from the group com-
prising: (1) ethyl lactate; (2) methyl ester; and (3) combinations of 1 and 2; (C) an antioxidant;
and, (D) a corrosion inhibitor. Optionally, the lubricant may further an additive selected from
the group comprising: (E) a viscosity modifier; (F) an anti-wear inhibitor; and, (G) an emul-
sifier.

(I)

WO 03/106599 A1

BIODEGRADABLE PENETRATING LUBRICANT

5

Background of the Invention**1. Field of Invention**

10 This invention pertains to the art of penetrating lubricants, and more specifically to the art of biodegradable penetrating lubricants.

2. Description of the Related Art

15 A demand exists for liquid compositions that have the ability to penetrate rapidly between metallic surfaces that are in close contact, such as the leaves of springs, hinges, bolts, car door locks, house locks, padlocks, pipe fittings, and the like, and to loosen the adjacent metallic surfaces that have rusted, "frozen", or otherwise become bound together. In the usual situation, a layer or film of rust between the surfaces is so tenacious that it often binds the adjacent metal surfaces so
20 tightly that it is difficult, if not impossible, to loosen the surfaces by the use of mechanical loosening devices, such as wrenches.

A number of oil compositions are offered commercially which have been used for the purpose of lubricating such difficult to loosen surfaces, and such
25 compositions are generally known as penetrating lubricants. These lubricants are generally characterized by having a high degree of penetration, which means that the surface tension and the viscosity of the lubricant is somewhat lower than that of an ordinary lubricant used on rotating parts.

30 Typically, the penetrating lubricants are comprised of petroleum based oils. The petroleum based oils have functioned satisfactorily, but they have several

disadvantages. The petroleum based oils are only minimally biodegradable and, thus, they pose safety and contamination concerns. Further, the petroleum based oils are non-renewable.

5 In contrast, vegetable oils are obtainable in large volumes from renewable resources and in general are characterized as readily biodegradable or "environmentally friendly." As a result, such oils are potentially attractive for use in a wide variety of applications, including use as a penetrating lubricant.

10 Use of vegetable oils as penetrating lubricants has not been thoroughly explored. Many vegetable oils do not possess the desired spectrum of characteristics relating to: pour point; oxidative stability; and compatibility with additives, among others. Vegetable oils do however possess many desirable properties for use as a penetrating lubricant. In particular, vegetable oils typically
15 provide good lubrication, good viscosity, and high flash point. In addition, vegetable oils are generally nontoxic and readily biodegradable. For example, under standard test conditions (e.g., OCED 301D test method), a typical vegetable oil can biodegrade up to 80% into carbon dioxide and water in 28 days, as compared to 25% or less for typical petroleum-based lubricating fluids.

20

Summary of the Invention

In accordance with the present invention, a new and improved biodegradable penetrating lubricant is provided.

25 It is an object of this invention to provide a biodegradable penetrating lubricant, which overcomes or otherwise mitigates the problems of the prior art in this area.

 It is a further object of this invention to provide a biodegradable
30 penetrating lubricant, which is characterized by its excellent penetrating action while still providing the necessary lubricating characteristics to achieve all the advantages required by a penetrating lubricant.

It is still further an object of this invention to provide a biodegradable penetrating lubricant, which is characterized by excellent corrosion inhibiting properties.

5

It is still a further object of this invention to provide a biodegradable penetrating lubricant that penetrates into close tolerant areas, then lubricates and prevents corrosion.

10 It is still a further object of this invention to provide a biodegradable penetrating lubricant that protects deep into the core of a cable or chain link, and is excellent as a light air tool lubricant, and preservative for oil parts.

15 It is still a further object of this invention to provide a biodegradable penetrating lubricant that has exceptional benefits over petroleum oils in the aforementioned applications because there is a direct loss of the lubricant into the water, soil or work environment.

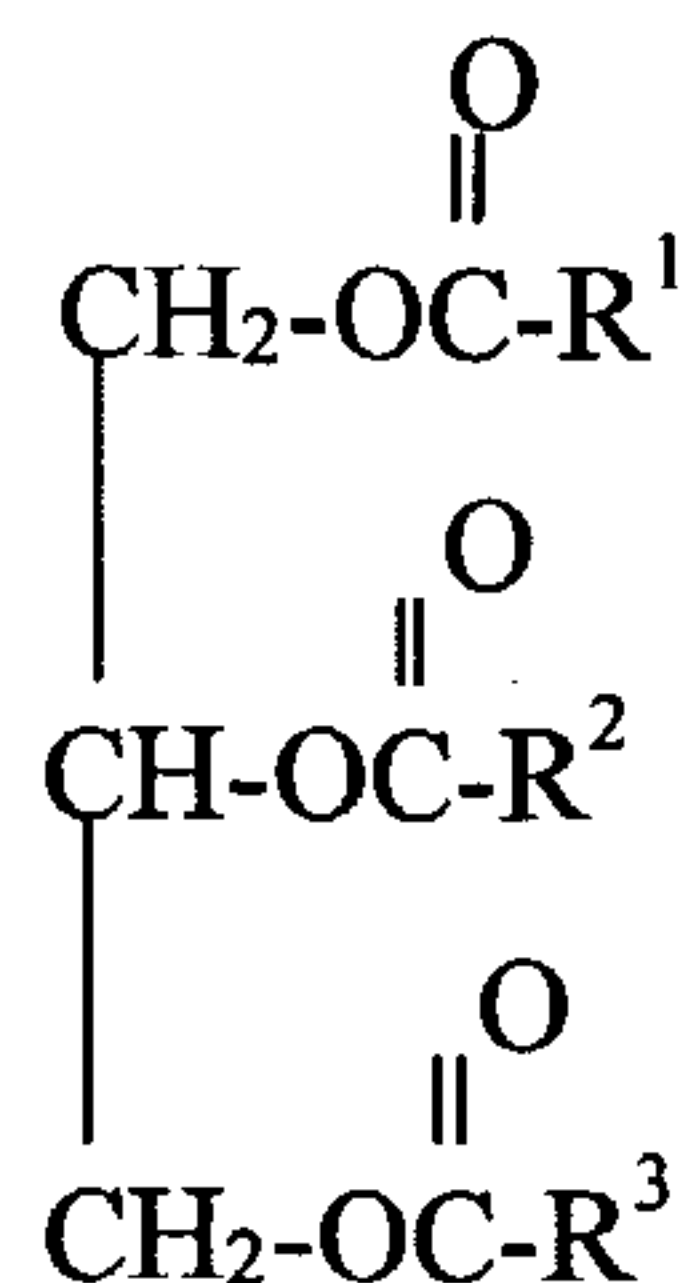
20 Still other benefits and advantages of the invention will become apparent to those skilled in the art to which it pertains upon a reading and understanding of the following detailed specification.

To accomplish these objectives, the present invention provides for a biodegradable penetrating lubricant comprised of:

25

(A) at least one triglyceride oil of the formula:

30



wherein R^1 , R^2 , and R^3 are aliphatic hydrocarbyl groups containing from about 7 to about 23 carbon atoms, which includes but is not limited to 7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 21, 22, and 23 carbon atoms;

(B) an organic solvent selected from the group comprising:

- 5 (1) ethyl lactate,
 (2) at least one mineral spirit, and
 (3) combinations of 1 and 2; and,

(C) an antioxidant

10 Optionally, the lubricant may further include an additive selected from the group comprising:

- (D) an antiwear inhibitor;
 (E) a corrosion inhibitor;
 (F) a pour point depressant; and,
 15 (G) soy methyl ester.

(A) The Triglyceride Oil

In practicing this invention, the base oil is a synthetic triglyceride or a natural oil of the formula



wherein R^1 , R^2 , and R^3 are aliphatic hydrocarbyl groups that contain from about 7 to about 23 carbon atoms. The term "hydrocarbyl group" as used herein denotes a radical having a carbon atom directly attached to the remainder of the molecule.

30 The aliphatic hydrocarbyl groups include the following:

(1) Aliphatic hydrocarbon groups: alkyl groups such as heptyl, nonyl, undecyl, tridecyl, heptadecyl; alkenyl groups containing a single double bond such as heptenyl, nonenyl, undecenyl, tridecenyl, heptadecenyl, heneicosenyl; alkenyl groups containing 2 or 3 double bonds such as 8,11-heptadecadienyl and 8,11,14-heptadecatrienyl. All isomers of these are included, but straight chain groups are preferred.

(2) Substituted aliphatic hydrocarbon groups: groups containing non-hydrocarbon substituents which, in the context of this invention, do not alter the predominantly hydrocarbon character of the group. Those skilled in the art will be aware of suitable substituents. Examples are hydroxy, carbalkoxy, (especially lower carbalkoxy) and alkoxy (especially lower alkoxy), the term, "lower" denoting groups containing not more than 7 carbon atoms.

(3) Hetero groups: groups which, while having predominantly aliphatic hydrocarbon character within the context of this invention, contain atoms other than carbon present in a chain or ring otherwise composed of aliphatic carbon atoms. Suitable hetero atoms will be apparent to those skilled in the art and include, for example, oxygen, nitrogen, and sulfur.

20

The triglyceride oils suitable for use in this invention are vegetable oils and modified vegetable oils. The vegetable oil triglycerides are naturally occurring oils. By "naturally occurring" it is meant that the seeds from which the oils are obtained have not been subjected to any genetic altering. Further, by "naturally occurring" it is meant that the oils obtained are not subjected to hydrogenation or any chemical treatment that alters the di- and tri-unsaturation character. The naturally occurring vegetable oils having utility in this invention comprise at least one of soybean oil, rapeseed oil, sunflower oil, coconut oil, lesquerella oil, canola oil, peanut oil, corn oil, cottonseed oil, palm oil, safflower oil, meadowfoam oil, or castor oil.

25

30

The triglyceride oils may also be modified vegetable oils. Triglyceride oils are modified either chemically or genetically. Hydrogenation of naturally occurring triglycerides is the primary means of chemical modification. Naturally occurring triglyceride oils have varying fatty acid profiles. The fatty acid profile
5 for naturally occurring sunflower oil is

	palmitic acid	70 percent
	stearic acid	4.5 percent
	oleic acid	18.7 percent
	linoleic acid	67.5 percent
10	linolenic acid	0.8 percent
	other acids	1.5 percent

By chemically modifying sunflower oil by hydrogenation, it is meant that hydrogen is permitted to react with the unsaturated fatty acid profile present, such
15 as oleic acid, linoleic acid, and linolenic acid. The object is not to remove all the unsaturation. Further, the object is not to hydrogenate such that the oleic acid profile is reduced to a stearic acid profile. The object of chemical modification via hydrogenation is to engage the linoleic acid profile and reduce or convert a substantial portion of it to an oleic acid profile. The linoleic acid profile of
20 naturally occurring sunflower oil is 67.5 percent. It is a goal of chemical modification to hydrogenate such that the linoleic acid is reduced to about 25 percent. That means that the oleic acid profile is increased from 18.7 percent to about 61 percent (18.7 percent original oleic acid profile + 42.5 percent generated oleic acid from linoleic acid).

25

Hydrogenation is the reaction of a vegetable oil with hydrogen gas in the presence of a catalyst. The most commonly used catalyst is a nickel catalyst. This treatment results in the addition of hydrogen to the oil, thus reducing the linoleic acid profile and linolenic acid profile. Only the unsaturated fatty acid profiles
30 participate in the hydrogenation reaction. During hydrogenation, other reactions also occur, such as shifting of the double bonds to a new position and also twisting from the cis form to the higher melting trans form.

Table I shows the oleic acid (18:1), linoleic acid (18:2), and linolenic acid (18:3) profiles of selected naturally occurring vegetable oils. It is possible to chemically modify, via hydrogenation, a substantial portion of the linoleic acid profile of the triglyceride to increase the oleic acid profile to above 60 percent.

Table I

Oil	18:1	18:2	18:3
Corn oil	25.4	59.6	1.2
10 Cottonseed oil	18.6	54.4	0.7
Peanut oil	46.7	32.0	--
Safflower oil	12.0	77.7	0.4
Soybean oil	23.2	53.7	7.6
Sunflower oil	18.7	67.5	0.8

15

Genetic modification occurs in the seed stock. The harvested crop then contains a triglyceride oil that when extracted has a much higher oleic acid profile and a much lower linoleic acid profile. Referring to Table I above, a naturally occurring sunflower oil has an oleic acid profile of 18.7 percent. A genetically modified sunflower oil has an oleic acid profile of 81.3 percent and linoleic acid profile of 9.0 percent. One can also genetically modify the various vegetable oils from Table I to obtain an oleic acid profile of above 90 percent. The chemically modified vegetable oils comprise at least one of a chemically modified corn oil, chemically modified cottonseed oil, chemically modified peanut oil, chemically modified palm oil, chemically modified castor oil, chemically modified canola oil, chemically modified rapeseed oil, chemically modified safflower oil, chemically modified soybean oil, and chemically modified sunflower oil.

In a preferred embodiment, the aliphatic hydrocarbyl groups of R^1 , R^2 , and R^3 are such that the triglyceride has a monounsaturated character of at least 60 percent, preferably at least 70 percent, and most preferably at least 80 percent. Triglycerides having utility in this invention are exemplified by vegetable oils that

30

are genetically modified such that they contain a higher than normal oleic acid content. Normal sunflower oil has an oleic acid content of 25-30 percent. By genetically modifying the seeds of sunflowers, a sunflower oil can be obtained wherein the oleic content is from about 60 percent up to about 90 percent. That is, the R^1 , R^2 , and R^3 groups are heptadecenyl groups and the R^1COO^- , R^2COO^- , and R^3COO^- to the 1,2,3-propanetriyl group CH_2CHCH_2 are the residue of an oleic acid molecule. U.S. Pat. No. 4,627,192 and U.S. Pat. No. 4,743,402 disclose the preparation of high oleic sunflower oil.

For example, a triglyceride comprised exclusively of an oleic acid moiety has an oleic acid content of 100% and consequently a monounsaturated content of 100%. Where the triglyceride is made up of acid moieties that are 70% oleic acid, 10% stearic acid, 13% palmitic acid, and 7% linoleic acid, the monounsaturated content is 70%. The preferred triglyceride oils are high oleic acid, that is, genetically modified vegetable oils (at least 60 percent) triglyceride oils. Typical high oleic vegetable oils employed within the instant invention are high oleic safflower oil, high oleic canola oil, high oleic peanut oil, high oleic corn oil, high oleic rapeseed oil, high oleic sunflower oil, high oleic cottonseed, high oleic lesquerella oil, high oleic palm oil, high oleic castor oil, high oleic meadowfoam oil, and high oleic soybean oil. Canola oil is a variety of rapeseed oil containing less than 1 percent erucic acid. A preferred high oleic vegetable oil is high oleic sunflower oil obtained from *Helianthus* sp. This product is available from AC Humko, Cordova, TN, 38018 as TriSunTM high oleic sunflower oil. TriSun 80 is a high oleic triglyceride wherein the acid moieties comprise 80 percent oleic acid. Another preferred high oleic vegetable oil is high oleic canola oil obtained from *Brassica campestris* or *Brassica napus*, also available from AC Humko as RS high oleic oil. RS80 oil signifies a canola oil wherein the acid moieties comprise 80 percent oleic acid.

It is further to be noted that genetically modified vegetable oils have high oleic acid contents at the expense of the di-and tri- unsaturated acids. A normal

sunflower oil has from 20-40 percent oleic acid moieties and from 50-70 percent linoleic acid moieties. This gives a 90 percent content of mono- and di-unsaturated acid moieties (20+70) or (40+50). Genetically modifying vegetable oils generate a low di- or tri- unsaturated moiety vegetable oil. The genetically modified oils of this invention have an oleic acid moiety:linoleic acid moiety ratio of from about 2 up to about 90. A 60 percent oleic acid moiety content and 30 percent linoleic acid moiety content of a triglyceride oil gives a ratio of 2. A triglyceride oil made up of an 80 percent oleic acid moiety and 10 percent linoleic acid moiety gives a ratio of 8. A triglyceride oil made up of a 90 percent oleic acid moiety and 1 percent linoleic acid moiety gives a ratio of 90. The ratio for normal sunflower oil is 0.5 (30 percent oleic acid moiety and 60 percent linoleic acid moiety).

Preferably, the triglyceride oil is about 20 to about 90 weight percent of the lubricant, more preferably about 40 to about 70 weight percent, and most preferably about 50 to about 60 weight percent.

(B) The Organic Solvent

In penetrating lubricants, a balance must be reached between the penetrating function and the lubricating function. In the present invention, the triglyceride oil provides the lubricating function, while the organic solvent provides the penetrating function. Preferably, two organic solvents, namely, ethyl lactate and food grade mineral spirits are utilized in this invention.

Ethyl lactate is the ester of natural lactic acid (a natural organic acid) produced by fermentation of corn derived feedstock. Ethyl lactate has great penetration characteristics. It is also 100% biodegradable, breaking down into carbon dioxide and water, non-toxic, and renewable.

Mineral spirits also have great penetration characteristics. As such, any mineral spirit may be utilized in the present invention. Preferably, however, the mineral spirit is a food grade mineral spirit, such as those approved by the FDA

and the USDA, and most preferably, the mineral spirit PD 23, which is manufactured by Witco, is preferred because it is not classified as a volatile organic compound by the California Air Resources Board and, thus, it is considered an environmentally friendly solvent.

5

The organic solvent is preferably about 10 to about 90 weight percent of the lubricant, more preferably about 15 to about 40 weight percent, and most preferably about 20 to about 30 weight percent.

10 (C) The Antioxidant

To improve the oxidative stability of the lubricant, an antioxidant may be included in the lubricant composition. Antioxidants are available off the shelf from a variety of vendors and manufacturers. Any antioxidant may be utilized in the present invention. However, metal free antioxidants are preferred because they enhance the
15 biodegradability of the lubricant. A preferred antioxidant is phenyl alpha naphthylamine (PANA).

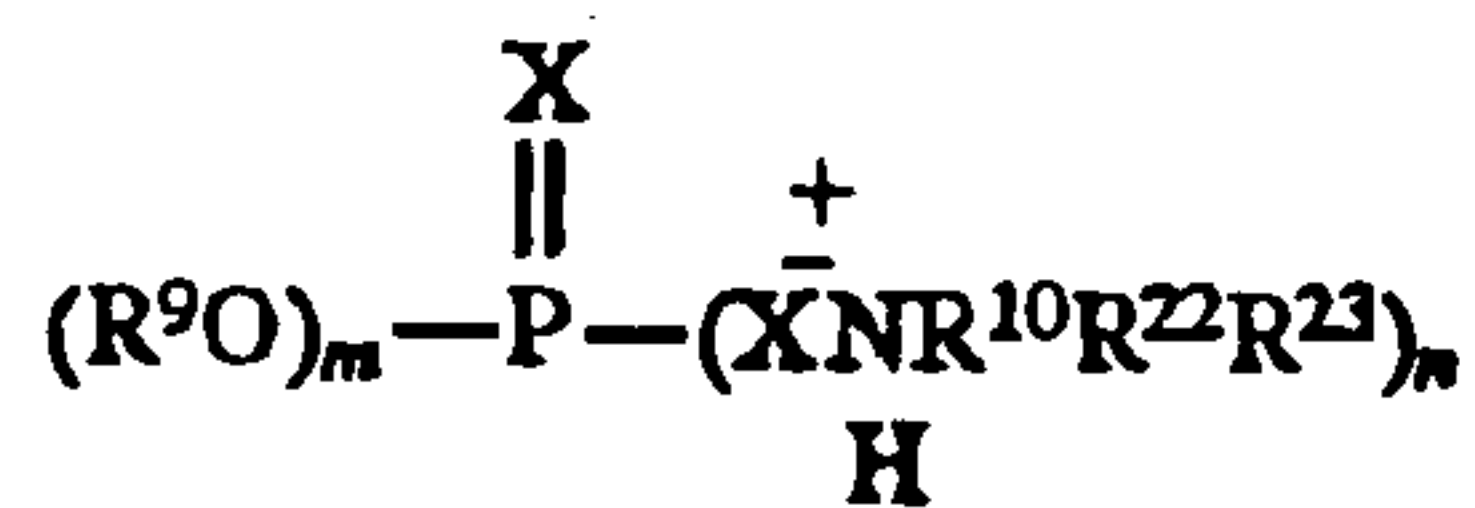
The antioxidant is typically about 0.1 to 4 weight percent of the lubricant composition. If PANA is used as the antioxidant, then the antioxidant is preferably
20 about 0.1 to about 2 weight percent of the lubricant.

(D) The Anti-wear Inhibitor

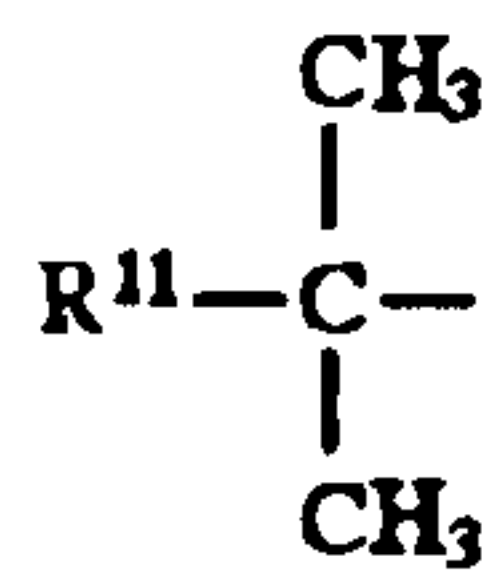
To prevent wear on the metal surface, the present invention utilizes an anti-wear inhibitor. Anti-wear inhibitors are available off the shelf from a variety of
25 vendors and manufacturers. Any anti-wear inhibitor may be utilized in the present invention. However, metal free anti-wear inhibitors are preferred, and phosphorous and sulfur containing metal free anti-wear inhibitors are most preferred.

Preferably, food grade anti-wear inhibitor are utilized in the present invention
30 because they comply with FDA regulations, thereby, making the lubricant more environmentally friendly. One food grade anti-wear inhibitor is phosphorous amine salt of the formula:

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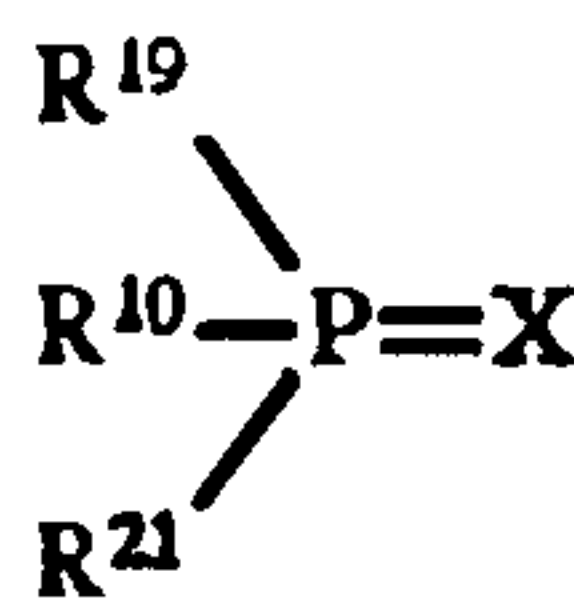


wherein R^9 and R^{10} are independently aliphatic groups containing from about up to about 24 carbon atoms, R^{22} and R^{23} are independently hydrogen or aliphatic groups containing from about 1 up to about 18 aliphatic carbon atoms, the sum of m and n is 3 and X is oxygen or sulfur. In a preferred embodiment, R^9 contains from about 8 up to 18 carbon atoms, R^{10} is



wherein R^{11} is an aliphatic group containing from about 6 up to about 12 carbon atoms, R^{22} and R^{23} are hydrogen, m is 2, n is 1 and X is oxygen. An example of one such phosphorous amine salt is Irgalube® 349, which is commercially available from Ciba-Geigy.

Another food grade anti-wear inhibitor is phosphorous compound of the formula:



15

wherein R^{19} , R^{20} and R^{21} are independently hydrogen, an aliphatic or alkoxy group containing from 1 up to about 12 carbon atoms, or an aryl or aryloxy group wherein the aryl group is phenyl or naphthyl and the aryloxy group is phenoxy or naphthoxy and X is oxygen or sulfur. An example of one such phosphorus compound is triphenyl phosphothionate (TPPT), which is commercially available from Ciba-Geigy under the trade name Irgalube® TPPT.

The anti-wear inhibitor is typically about 0.1 to 30 weight percent of the lubricant composition.

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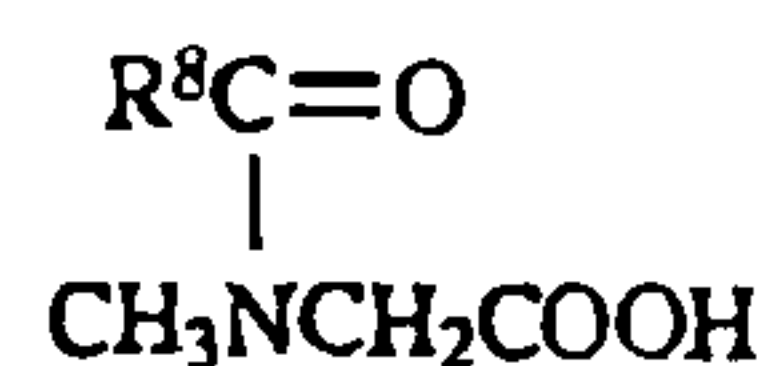
(E) The Corrosion Inhibitor

To prevent corrosion of the metal surfaces, the present invention utilizes a corrosion inhibitor. Corrosion inhibitors are available off the shelf from a variety of vendors and manufacturers. Any corrosion inhibitor may be utilized in the present invention, but metal free corrosion inhibitors are preferred.

The corrosion inhibitor is typically about 0.01 to 25 weight percent of the lubricant composition.

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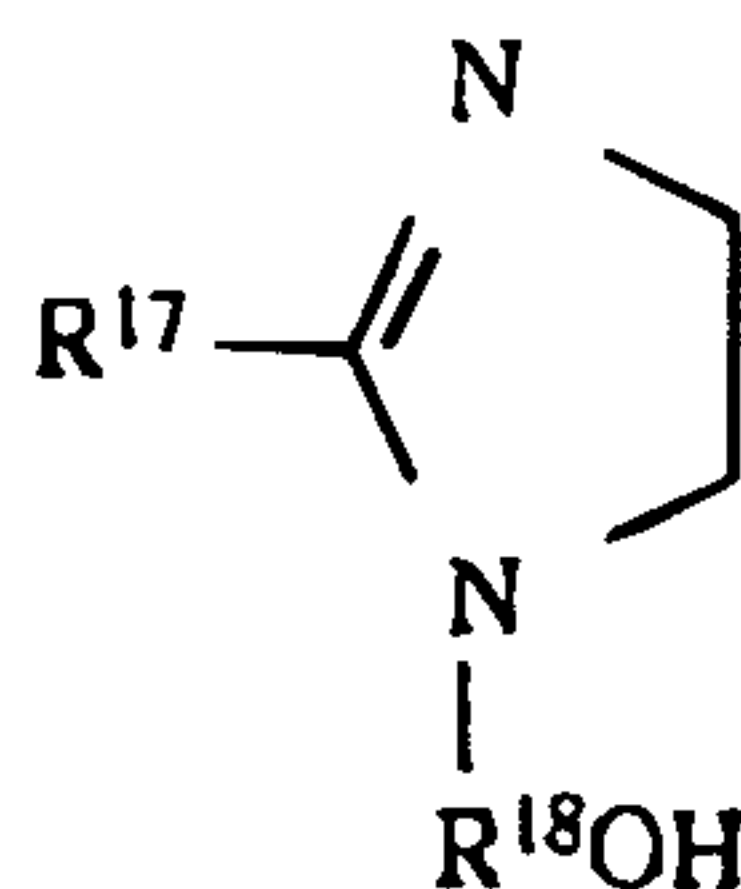
The corrosion inhibitor is preferably comprised of a corrosion additive and a metal deactivator. Preferably, the additive and the metal deactivator are food grade and comply with FDA regulations, thereby, making the lubricant more environmentally friendly. One additive is the N-acyl derivative of sarcosine, which has the formula:



wherein R^8 is an aliphatic group containing from 1 up to about 24 carbon atoms. Preferably R^8 contains from 6 to 24 carbon atoms and most preferably from 12 to 18 carbon atoms. An example of an additive of N-acyl derivative of sarcosine is N-methyl-N-(1-oxo-9-octadecenyl) glycine wherein R^8 is a heptadecenyl group. This derivative is available from Ciba-Geigy under the trade name Sarkosyl® O.

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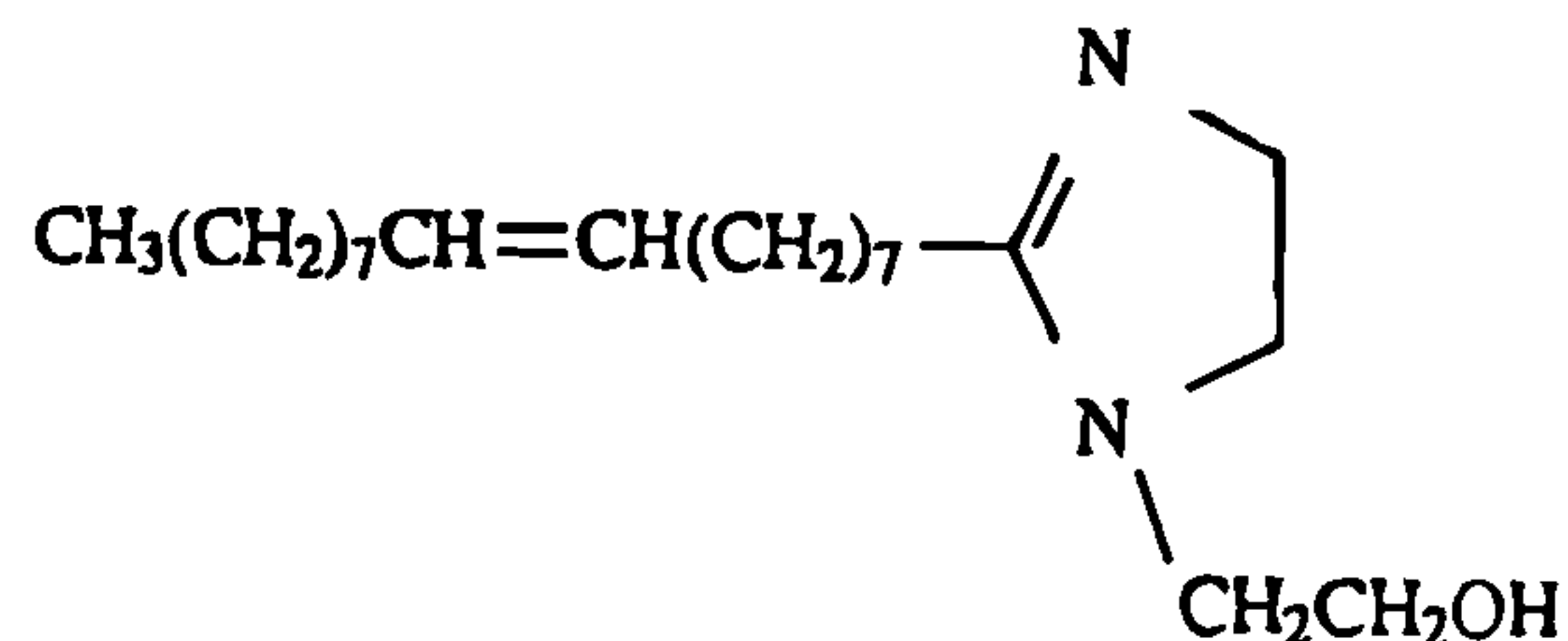
Another additive is imidazoline of the formula:



25

wherein R^{17} is an aliphatic group containing from 1 up to about 24 carbon atoms and

R^{18} is an alkylene group containing from 1 up to about 24 carbon atoms. Preferably R^{17} is an alkenyl group containing from 12 to 18 carbon atoms. Preferably R^{18} contains from 1 to 4 carbon atoms and most preferably R^{18} is an ethylene group. An example of one such imadazoline has the formula:



5

and is commercially available from Ciba-Geigy under the trade name Amine O.

Typically, the corrosion additive is about 0.01 to 4 weight percent of the lubricant composition. If the additive is the N-acyl derivative of sarcosine, then it is preferably about 0.1 to about 1 weight percent of the lubricant composition. If the additive is imidazoline, then it is preferably about 0.05 to about 2 weight percent of the lubricant composition. The lubricant can include more than one corrosion additive. For example, the lubricant can include both the N-acyl derivative of sarcosine and imidazoline.

One metal deactivator is triazole or substituted triazole. For example, toly-triazole or tolu-triazole may be utilized in the present invention. However, a preferred triazole, is tolu-triazole sold commercially by Ciba-Geigy under the trade name Irgamet® 39, which is a food grade triazole and, thus, environmentally friendly.

Typically, the metal deactivator is about 0.05 to 0.3 weight percent of the lubricant composition. If the metal activator is Irgamet 39, then it is preferably about 0.05 to about 0.2 weight percent of the lubricant composition.

Although, the anti-wear inhibitor and the corrosion inhibitor have been described separately, they can be included in a single chemical additive. For example, both the anti-wear inhibitor and the corrosion inhibitor are included in

the non-food grade additive Lubrizol® 5186B, which is available from Lubrizol Corporation. Preferably, Lubrizol® 5186B is about 0.5 to 2 weight percent of the lubricant composition and, most preferably, about 1.25 weight percent of the lubricant.

5

(F) The Pour Point Depressant

There is a natural stiffening at low temperatures of vegetable oils, especially vegetable oils with a high monounsaturated content. This is analogous to the stiffening of honey or molasses at a reduced temperature. To maintain the
10 “pour” or “flow” of a vegetable oil at reduced temperatures, it becomes necessary to add a pour point depressant.

Pour point depressants are available off the shelf from a variety of vendors and manufacturers. Any pour point depressant may be utilized in the present
15 invention. Preferably, however, the pour point depressant is an alkylated polystyrene or a polyalkyl methacrylate.

Two different reaction routes are envisioned in preparing the alkylated polystyrenes. The first route involves reacting either an alkyl chloride or an alkene
20 with styrene to form an alkylated styrene. The alkylated styrene is then polymerized to form an alkylated polystyrene. In the second route styrene is polymerized to form polystyrene and propylene or butylenes or mixtures thereof are polymerized to form polypropylene, polybutylenes or mixtures of polypropylenes and polybutylenes, also known as polyalkylenes. The polystyrene
25 is then alkylated with the polyalkylenes to form the alkylated polystyrenes.

A preferred pour point depressant in the class of alkylated polystyrene is Keil-Flo™ 150, available from Ferro Corporation – Petroleum Additives, 3000 Sheffield Avenue, Hammond, Indiana 46327.

30

The polyalkyl methacrylates suitable for use in the present invention are prepared by the polymerization of C₁ - C₃₀ methacrylates. Preparation of these

polymers may further include the use of acrylic monomers having nitrogen-containing functional groups, hydroxy groups and/or alkoxy groups which provide additional properties to the polyalkyl methacrylates such as improved dispersancy.

The polyalkyl methacrylates preferably have a number average molecular weight of from 10,000 to 250,000 and preferably 20,000 to 200,000. The polyalkyl methacrylates may be prepared by conventional methods of free-radical or anionic polymerization. A preferred pour point depressant in the class of polyalkyl methacrylates is EF 171 available from RohMax, USA, Delran, NJ 08075.

10 The pour point depressant is typically about 0.2 to 4 weight percent of the lubricant composition.

(G) The Soy Methyl Ester

To increase the penetrating function of the lubricant, soy methyl ester can be included in the lubricant composition. Soy methyl ester is a solvent obtained from the esterification of soy bean oil. The soy methyl ester increases the penetrating function of the lubricant by decreasing the volatility and the surface tension, thereby enabling the lubricant to penetrate between adjacent metal surfaces and free the rusted parts.

20

Since the soy methyl ester is a soy bean product it has many desirable properties, in addition to its great penetrating characteristics. For example, it is non-toxic, 100% biodegradable, and renewable.

25 Preferably, the soy methyl ester is about 5 to about 55 weight percent of the lubricant, and more preferably about 10 to about 20 weight percent.

Preferably, all of the chemicals, except for the anti-wear inhibitor, are food grade to enhance the biodegradability of the penetrating lubricant. However, any grade of chemicals chosen within sound judgment may be utilized by the present invention.

30

EXAMPLE

A biodegradable penetrating lubricant was prepared by mixing the following components in the amounts indicated:

5

TABLE II

Component	Weight
Percent	
Triglyceride oil (holly canola)	56.4
PD 23	25.0
10 Lubrizol® 5186B	1.0
Antioxidant (PANA)	0.6
Soy methyl ester	15.0
Pour Point Depressant (polyalkyl methacrylate)	2.0

15 The lubricant was tested by subjecting it to a thread creep test. A rusted 3/8 inch bolt was placed on its head in a beaker filled with approximately ¼ inch of the lubricant. The lubricant vertically walked about 2 inches of the thread in 2 hours, thereby, demonstrating exceptional penetrating characteristics.

20 The lubricant was also found to have the following physical properties:

TABLE III

Specific Gravity @60°F	ASTM D-287	88
Viscosity @ 40°C, cSt	ASTM D-445	14.4
Flash Point, PMCC	ASTM D-93	295°F (146°C)
Pour Point (Rotational)	ASTM D5985	-30°C
Freeze Point	ASTM D5985	-31°C
Rust Prevention	ASTM D 665	
Distilled Water		Pass-Clean
Synthetic Sea Water		Pass-Clean
Copper Corrosion Strip 3hr @100°C	ASTM D 130	1A
4-Ball Wear, 1h, 167°F, 1200 RPM, 40kg	ASTM D 4172	0.40

In another embodiment of this invention, the additive composition and

25 surface tension of the invention can be modified for use in penetrating

applications, wire rope chain and cable lubricants, metal working, fabricating, assembly oils, forming oils, mold release, quench oils, heat transfer oils, slushing oils, acid fume rust preventative, corrosion inhibiting preservative formulas, etc. to protect ferrous and nonferrous metals.

5

The formulas can be very volatile allowing bio-base carrier(s) to dissipate leaving corrosion inhibitors and/or anti-wear-extreme pressure additives to remain on the surface of the metal parts preventing wear and corrosion. The time period of volatile dissipation can be adjusted by varying the base stock selection related to the base oil volatility. Some applications will require more of less surface tension (remaining oily film). Ultra thin, highly protective films can be applied. Film thickness of 0.02 mils or less have been tested in the ASTM D-1748 Humidity Cabinet on polished cold rolled steel panels and test results from 20 to 60 days before failure are typical for these ultra-thin films. The carrier for this more volatile corrosion inhibitor (s) formula is the ethyl lactate. If the volatility needs to be reduced or a more oily or waxy film is necessary, the methyl esters and/or vegetable oil triglycerides are used with the proper additives.

The volatile corrosion inhibitor formulas carry corrosion inhibitors into the air releasing the corrosion inhibiting compounds on metal surfaces, preventing corrosion. This is highly effective when added to packaging or sealed containers where the corrosion inhibition can remain as a volatile corrosion inhibitor for a longer period protecting metal parts. The formula allows the corrosion inhibitors to penetrate into close tolerance areas preventing corrosion and allow for easier cleaning and/or paint preparation. Adjusting these formulas to the application will prevent unnecessary waste, energy, and added expenses.

The formulation viscosity can be modified considerably by using viscosity modifiers to improve low temperature cold flow and thickening to heavier viscosity compositions. Adhesion can also be added with these viscosity modifiers by using tackier polymers and fumed silicas.

In another embodiment of this invention, the present invention provides for a biodegradable penetrating lubricant comprised of:

- A- Triglyceride/organic solvent
 - 5 1. Triglyceride(s)
 - 2. Methyl esters of soybean, canola, etc.
 - 3. Ethyl lactate(s)
 - 4. Combination of 1 and 2
 - 5. Combination of 1, 2, and 3
 - 10 6. Combinations of 2 and 3

The methyl esters help solubilize the additives, particularly sodium and calcium additives. Sulfonates have difficulties solubilizing in ethyl lactate without at least approximately 5% methyl ester.

15

B- Anti-oxidant(s)

- C- 1-Corrosion Inhibitor(s) including, but not limited to, those previously listed and also the following: surface-active organic acids, oxyacids,
 - 20 hydroxy acids, keto acids, borated amine, paraffin wax, imadazoline derivative, alkenyl succinic acid half ester, organic polycarboxylic acid, paraffin wax, nonyl phenoxy acetic acid, n-oleyl sarcosine, phosphorus, carboxylic acid derivatives, zincnaphthenates, Ca sulphonate(s), Ba sulphonate(s), Ca dialkylbenzene sulphonate(s), Mg sulfonate(s), calcium
 - 25 dialkabezene sulphonate, sodium oxidate, calcium oxidate, barium oxidate, fatty acid amines, amine nitrite salts, calcium nitrite, calcium acetate, calcium dichromate, calcium hypophosphite, disodium sebacate, sodium sulfonate(s), sodium mercaptobenzothiazole, sodium nitrite, sodium hydroxides, sodium salts of succinic acid/sulfonic acid, barium nitrite,
 - 30 barium bromate, monoethanolamine borate, phosphate amines, potassium salts, potassium hydroxides, phosphate esters, amine salts of carboxylic acids, monocarboxylic acids, dicarboxylic acids, tall oil imidazoline, oleyl

imidazoline, vegetable waxes, etc.

2-Metal Deactivators (optional): tolutriazole, tolytriazole, triazole, benzotriazole

5

Optionally, the lubricant may further include an additive from the group comprising:

10 D- Viscosity modifiers-including, but not limited to, ethylene vinyl acetate, polyisobutylenes, polymethacrylates, olefin copolymers, esters of styrene maleic anhydride copolymers, hydrogenated styrene-diene copolymers, hydrogenated radial polyisoprene, alkylated polystyrene, fumed silicas, food grade tackifiers like natural rubber, etc.

15 E- Anti-wear inhibitor(s), friction modifier(s), extreme pressure additive(s) are, but not limited to, as follows: synthetic ester, sulfurized synthetic esters, synthetic ester polymers, phosphorous sulfurs, fatty phosphites, phosphites, phosphate esters, calcium sulfonates, sodium sulfonates, polysulfides, sulfurized fats, sulfurized olefins.

20 F- Triglyceride vegetable oils (including, but not limited to, soybean oil, rapeseed oil, sunflower oil, coconut oil, lesquerella oil, canola oil, peanut oil, corn oil, cottonseed oil, palm oil, safflower oil, meadowfoam oil, or castor oil), synthetic esters, petroleum mineral oils, petroleum mineral solvents, polyalphaolefins, rerefined mineral oils. The most bio-degradable
25 and non-toxic of these base oils are most preferred natural and synthetic esters, and any of the petroleum base oils would be limited in the formulation depending upon meeting bio-degradability tests and toxicity tests. Food grade solvents/white oils, polyalphaolefin, and severely hydrotreated mineral oils are examples of those that would be preferred
30 over solvent refined mineral oils.

G- Emulsifiers anionic and non-ionic can also be added to the invention to

improve water emulsification or water solubility of the formulas.

Example 1

5 Bio-Base Corrosion Inhibitor, Medium Preservative Lubricant Mil-PRF-3150D

	Component	Weight Percent
	Triglyceride (HO Canola)	59
	Soy Methyl Ester	10
10	Alox® 2290A (sodium sulfonate) Corrosion Inhibitor	20
	LZ 7352 (styrene butadiene copolymer) Viscosity Modifier	8.6
	RhMx 10-310 (polyalkyl methacrylate) Pour Point Depressant	2
	Akrochm pana Anti-Oxidant	.20
	Akrochm BHT Anti-Oxidant	.20

15

Table IV

TYPICAL PROPERTIES	VALUES
Viscosity at 40°C, Kinematic, centistokes	95 to 125
Pour Point, °C	-8 to -4
Evaporation loss at 100°C, present	6.0 to 4.0
Copper strip corrosion at 100°C for 3 hr ASTM D 130 classification, max	2e

20

Table V

Humidity Cabinet ¹ Sandblasted Panels	Days/Fail Polished Panels	5% Salt Spray ² Sandblasted Panels	Hours/Fail Polished Panels
60+	60+	40	80

¹ASTM D-1748²Federal Standard 791b Method 4001.2

In addition, other military and government specifications can be met by this invention including: Penetrating oil (general purpose) to meet Federal

Specification VV-P216; Mil-C-81309 Types II and III Water Displacing Corrosion Inhibitors (Ultra-Thin); Mil-C-16173E Water Displacing Corrosion Inhibitors (Ultra-Thin);

- Mil-PRF372D cleaning compound/corrosion inhibitor for bore of small arms and
 5 automatic aircraft weapons; Mil-C-15074E corrosion preventive, fingerprint remover; and, Mil-PRF-32033 lubricating oil, general purpose, preservative (water-displacing).

Example 2

10

Water Emulsifiable Corrosion Inhibitor

	Component	Weight Percent
	Triglyceride (HO Canola)	69.6
15	Alox 2290A (sodium sulfonate) Corrosion Inhibitor	25
	Akrochm pana Anti-Oxidant	.20
	Akrochm BHT Anti-Oxidant	.20
	Diethylene Glycol n-Butyl Ether	5

- 20 A - Blend 125.28g (69.6 % weight) of holly canola oil, with a viscosity of 37.62 with 45.00g (25% weight) of Alox 2290A, with a viscosity of 500, at approximately 139° F. Then blend 9.00g (5% weight) of diethylene glycol n-butyl ether for approximately 2 minutes, at approximately 124° F. Blend together 0.36g (0.2% weight) PANA and 0.36g (0.2% weight) Akrochem BHT for
 25 approximately one minute at approximately 150° F, then blend with previous mixture for approximately two minutes at approximately 138° F. Alox 2290A is a sodium sulfonate corrosion inhibitor additive, manufactured by The Lubrizol Corporation of Wickliffe, Ohio. Akrochem BHT is a butylated hydroxy toluene, manufactured by Akrochem of Akron, Ohio. The final viscosity for the inhibitor is
 30 60 centistokes.

	Component	Weight Percent
	Triglyceride (HO Canola)	64.6
	Soy Methyl Ester	5.0
35	Alox 2290A (sodium sulfonate) Corrosion Inhibitor	25
	Akrochm pana Anti-Oxidant	.20
	Akrochm BHT Anti-Oxidant	.20

Diethylene Glycol n-Butyl Ether

5

B - Blend 116.28g (64.6 % weight) of holly canola oil, with a viscosity of 37.62 with 45.00g (25% weight) of Alox 2290A, with a viscosity of 500, and 9.0g
 5 soy methyl ester (5.0% weight) at approximately 139° F. Then blend 9.00g (5% weight) of diethylene glycol n-butyl ether for approximately 2 minutes, at approximately 124° F. Blend together 0.36g (0.2% weight) PANA and 0.36g (0.2% weight) Akrochem BHT for approximately one minute at approximately 150° F, then blend with previous mixture for approximately two minutes at
 10 approximately 138° F. The final viscosity for the inhibitor is 53 centistokes.

Table VI

Days/Fail Humidity Cabinet ¹ Sandblasted Panels	Days/Fail Polished Panels	Hours/Fail 5% Salt Spray ² Sandblasted Panels	Hours/Fail Polished Panels
40	55	24	48

¹ASTM D-1748²Federal Standard 791b Method 4001.2

In this embodiment of the invention, once the water emulsifiable corrosion inhibitor is prepared, it can be diluted with water in accordance with the
 15 specifications of the user. Any ratio of water to inhibitor can be used by the consumer, but the lower the ratio, the better the corrosion inhibition. However, in this example the ratio of water to inhibitor is 10:1.

Example 3

20

Bio Volatile Corrosion Inhibitor

A - Blend 36g (20% weight) soy methyl ester with 139.86g (77.7% weight) ethyl lactate for approximately three minutes at approximately 110° F, then blend in 3.6g (2% weight) Alox 904 for approximately three minutes at
 25 approximately 120° F, then blend in 0.54g (0.3% weight) PANA (heat PANA to 145° F before blending) for approximately three minutes at approximately 130° F.

Alox 904 is a sodium sulfonate corrosion inhibitor manufactured by The Lubrizol Corporation in Wickliffe, Ohio. The final viscosity of the inhibitor is 1.7 centistokes.

- 5 **B** - Blend 87.93g (48.85% weight) soy methyl ester with 87.93g (48.85% weight) ethyl lactate for approximately three minutes at approximately 110° F, then blend in 3.6g (2% weight) Alox 904 for approximately three minutes at approximately 120° F, then blend in 0.54g (0.3% weight) PANA (heat PANA to 145° F before blending) for approximately three minutes at approximately 130° F.
- 10 The final viscosity of the inhibitor is 2.5 centistokes.

- C** - Blend 96.48g (53.6% weight) soy methyl ester with 75.6g (42% weight) corn ethyl lactate for approximately five minutes at approximately 100° F, then blend in 7.2g (4% weight) Alox 165 for approximately three minutes at approximately 116° F, then blend together 0.36g (0.2% weight) PANA and 0.36g (0.2% weight) Akrochem BHT for approximately one minute at approximately 160° F, then blend with previous mixture for approximately three minutes at approximately 160° F. Alox 165 is a calcium sulfonate manufactured by The Lubrizol Corporation in Wickliffe, Ohio. The final viscosity of the inhibitor is 2.9 centistokes.

Results For Part C

	Film Thickness	Humidity Cabinet ASTM D-1748	Stain Test Mil-C-
	(Mils)	22235	
25	0.02 ¹	Days/Fail	Pass
		30	
1 Film thickness is determined by weighing an ASTM plate, adding the material, then weighing the plate again.			

- 30 **D** - Blend 114.48g (63.6% weight) soy methyl ester with 46.8g (26% weight) corn ethyl lactate for approximately five minutes at approximately 100° F, then blend in 18.0g (10% weight) Alox 165 for approximately three minutes at approximately 116° F, then blend together 0.36g (0.2% weight) PANA and 0.36g
-

(0.2% weight) Akrochem BHT for approximately one minute at approximately 160° F, then blend with previous mixture for approximately three minutes at approximately 160° F. Alox 165 is a calcium sulfonate manufactured by The Lubrizol Corporation in Wickliffe, Ohio. The final viscosity of the inhibitor is 7.1 centistokes.

Results For Part D

	Film Thickness	Humidity Cabinet ASTM D-1748 22235	Stain Test Mil-C-
	(Mils)	Days/Fail	
10	0.06	60	Pass

E - Blend 84.24g (46.8% weight) soy methyl ester with 42.075g (23.375% weight) PD-23 for approximately four minutes at approximately 80° F, then blend in 42.075g (23.375% weight) ethyl lactate for approximately four minutes at approximately 100° F, then add 7.20g (4.00% weight) Alox 165 for approximately five minutes at approximately 120° F, then blend together 0.27g (0.15% weight) PANA, 0.27g (0.15% weight) RC 7120, and 0.27g (0.15% weight) Wingstay 29 for approximately two minutes at approximately 145° F, then blend with previous mixture for approximately two minutes at approximately 136° F, then add 3.60g (2.00% weight) RhMx 10-310 for approximately four minutes at approximately 134° F. The final viscosity of the inhibitor is 4.43 centistokes.

Example 4

Firearm Cleaner

	Component Percent	Weight
	Soy Methyl Ester	78
	Corn Ethyl Lactate	17.6
30	Alox 904 (sodium sulfonate and hexylene glycol) Corrosion Inhibitor	2
	Akrochm BHT Anti-Oxidant	.20
	Akrochm pana Anti-Oxidant	.20
	RhMx 10-310 (polyalkyl methacrylate) Pour Point Depressant	2

A - Blend together 140.40g (78.00% weight) soy methyl ester, 31.68g (17.6% weight) corn ethyl lactate for approximately ten minutes at approximately 105° F. Then blend in 3.60g (2.00% weight) Alox 904 for approximately three

minutes at approximately 101° F. Blend 0.36g (0.2% weight) PANA with 0.36g (0.2% weight) Akro BHT for approximately one minute at approximately 155° F. Then blend the two mixtures together for approximately two minutes at approximately 127° F. Then blend in 3.60g (2.00% weight) RhMx 10-310 (2.00% weight) for approximately three minutes at approximately 126°F. The final viscosity of the cleaner is 4.5 centistokes.

B - Blend together 125.1g (69.5% weight) soy methyl ester, 18g (10% weight) Alox 904, and 36g (20% weight) holly canola oil for approximately five minutes at approximately 103° F. Blend 0.54g (0.3% weight) PANA with 0.36g (0.2% weight) Akro BHT for approximately five minutes at approximately 140° F. Then blend the two mixtures together for approximately ten minutes at approximately 124° F. The final viscosity of the cleaner is 13 centistokes.

The invention has been described with reference to several embodiments. Obviously, modifications and alterations will occur to others upon a reading and understanding of this specification. It is intended to include all such modifications and alternations in so far as they come within the scope of the appended claims or the equivalence thereof.

20

Having thus described the invention, it is now claimed:

- 26 -

CLAIMS:

1. A biopenetrating lubricant, comprising:

at least one triglyceride oil or solvent derived from triglyceride of the

5 formula



15 wherein R¹, R², and R³ are aliphatic hydrocarbyl groups containing from 7 to 23 carbon atoms;

an organic solvent comprising:

(1) ethyl lactate, or

(2) combinations consisting of ethyl lactate and a methyl ester;

an antioxidant; and,

20 a corrosion inhibitor.

2. The lubricant of claim 1 wherein, the corrosion inhibitor comprises triazole, substituted triazole, surface-active organic acids, oxyacids, hydroxy acids, keto acids, borated amine, paraffin wax, imadazoline derivative, alkenyl succinic acid half ester, organic polycarboxylic acid, nonyl phenoxy acetic acid, n-oleyl sarcosine, phosphorus, carboxylic acid derivatives, zinc naphthenates, Ca sulphonate(s), Ba sulphonate(s), Ca dialkylbenzene sulphonate(s), Mg sulfonate(s), sodium oxidate, calcium oxidate, barium oxidate, fatty acid amines, amine nitrite salts, calcium nitrite, calcium acetate, calcium dichromate, calcium hypophosphite, 25 disodium sebacate, sodium sulfonate(s), sodium mercaptobenzothiazole, sodium nitrite, sodium hydroxides, sodium salts of succinic acid/sulfonic acid, barium nitrite,
- 30

- 27 -

barium bromate, monoethanolamine borate, phosphate amines, potassium salts, potassium hydroxides, phosphate esters, amine salts of carboxylic acids, monocarboxylic acids, dicarboxylic acids, tall oil imidazoline, oleyl imidazoline, or vegetable waxes.

5

3. The lubricant of claim 2 wherein, R^1 , R^2 and R^3 have at least a 60 percent by weight monounsaturations content derived from an oleic acid residue.

4. The lubricant of claim 1 wherein, the triglyceride oil is about 10 to 90 weight percent based upon the weight of the lubricant.

5. The lubricant of claim 1 wherein, the antioxidant is about 0.1 to about 4 weight percent based upon the weight of the lubricant.

6. The lubricant of claim 1 wherein, the organic solvent is about 10 to about 90 weight percent based upon the weight of the lubricant.

7. The lubricant of claim 1 further comprising a metal deactivator, the deactivator comprising: tolutriazole, tolytriazole, triazole, or benzotriazole.

20

8. The lubricant of claim 1, wherein the lubricant further comprises a viscosity modifier.

9. The lubricant of claim 8, wherein the viscosity modifier comprises: ethylene vinyl acetate, polyisobutylenes, polymethacrylates, olefin copolymers, esters of styrene maleic anhydride copolymers, hydrogenated styrene-diene copolymers, hydrogenated radial polyisoprene, alkylated polystyrene, fumed silicas, or food grade tackifiers.

10. The lubricant of claim 8, wherein the lubricant further comprises: an anti-wear inhibitor; and,

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an emulsifier.

11. The lubricant of claim 10 wherein, the anti-wear inhibitor is about 0.1 to about 30 weight percent based upon the weight of the lubricant.

5

12. The lubricant of claim 1 wherein, the corrosion inhibitor is about 0.01 to about 30 weight percent based upon the weight of the lubricant.

13. A lubricant, comprising:

10 at least one triglyceride oil or solvent derived from triglyceride of the formula



wherein R¹, R², and R³ are aliphatic hydrocarbyl groups containing from 7 to 23 carbon atoms;

an organic solvent comprising:

(1) ethyl lactate, or

(2) combinations consisting of ethyl lactate and a methyl ester;

an anti-oxidant; and,

25 at least one additive selected from the group consisting of: a corrosion inhibitor, a viscosity modifier, an anti-wear inhibitor, and an emulsifier.

14. The lubricant of claim 13 wherein, the triglyceride oil is about 10 to about 90 weight percent based upon the weight of the composition.

30

15. The lubricant of claim 14 wherein, the antioxidant is about 0.1 to

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about 4 weight percent based upon the weight of the composition.

16. The lubricant of claim 15 wherein, the organic solvent is about 10 to about 90 weight percent based upon the weight of the composition.

5

17. The lubricant of claim 16 wherein, the anti-wear inhibitor is about 0.1 to about 30 weight percent based upon the weight of the composition.

18. The lubricant of claim 17, wherein the corrosion inhibitor is about
10 0.01 to about 30 weight percent based upon the weight of the composition.

19. The lubricant of claim 13, wherein the lubricant further comprises at least one mineral spirit.

