



(51) International Patent Classification:

C10M 177/00 (2006.01) C10M 105/32 (2006.01)
C07C 2/50 (2006.01) C10N 40/20 (2006.01)
C10M 101/04 (2006.01)

(21) International Application Number:

PCT/US2016/057079

(22) International Filing Date:

14 October 2016 (14.10.2016)

(25) Filing Language:

English

(26) Publication Language:

English

(30) Priority Data:

62/242,100 15 October 2015 (15.10.2015) US

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(81) Designated States (unless otherwise indicated, for every
kind of national protection available): AE, AG, AL, AM,
AO, AT, AU, AZ, BA, BB, BG, BH, BN, BR, BW, BY,
BZ, CA, CH, CL, CN, CO, CR, CU, CZ, DE, DJ, DK, DM,
DO, DZ, EC, EE, EG, ES, FI, GB, GD, GE, GH, GM, GT,
HN, HR, HU, ID, IL, IN, IR, IS, JP, KE, KG, KN, KP, KR,
KW, KZ, LA, LC, LK, LR, LS, LU, LY, MA, MD, ME,
MG, MK, MN, MW, MX, MY, MZ, NA, NG, NI, NO, NZ,
OM, PA, PE, PG, PH, PL, PT, QA, RO, RS, RU, RW, SA,
SC, SD, SE, SG, SK, SL, SM, ST, SV, SY, TH, TJ, TM,
TN, TR, TT, TZ, UA, UG, US, UZ, VC, VN, ZA, ZM,
ZW.

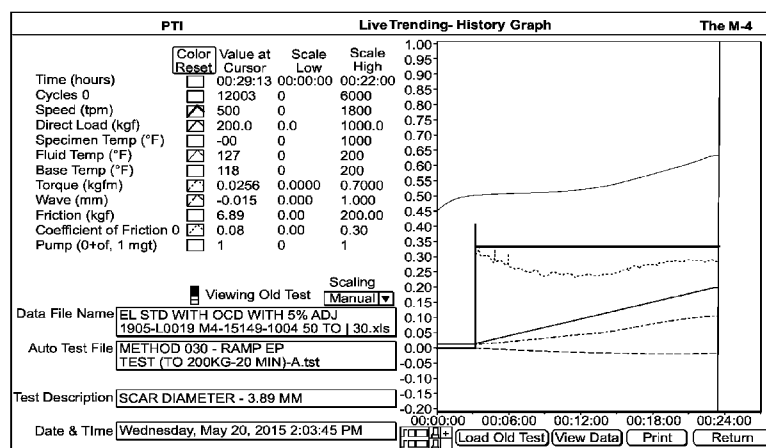
(84) Designated States (unless otherwise indicated, for every
kind of regional protection available): ARIPO (BW, GH,
GM, KE, LR, LS, MW, MZ, NA, RW, SD, SL, ST, SZ,
TZ, UG, ZM, ZW), Eurasian (AM, AZ, BY, KG, KZ, RU,
TJ, TM), European (AL, AT, BE, BG, CH, CY, CZ, DE,
DK, EE, ES, FI, FR, GB, GR, HR, HU, IE, IS, IT, LT, LU,
LV, MC, MK, MT, NL, NO, PL, PT, RO, RS, SE, SI, SK,
SM, TR), OAPI (BF, BJ, CF, CG, CI, CM, GA, GN, GQ,
GW, KM, ML, MR, NE, SN, TD, TG).

Published:

— without international search report and to be republished
upon receipt of that report (Rule 48.2(g))

(54) Title: LUBRICATING COMPOSITIONS AND METHODS FOR THE USE THEREOF

FIG. 1



(57) Abstract: Disclosed herein are lubricating compositions and methods of use of the same, including for, e.g., use in metal work-
ing operations.

LUBRICATING COMPOSITIONS AND METHODS FOR THE USE THEREOF

FIELD OF THE INVENTION

[0001] This invention relates to compositions and methods of use thereof for lubrication.

BACKGROUND

[0002] Lubricating fluids facilitate the reduction of friction (i.e. lubricate), remove heat (i.e. cool), flush away impurities, preserve or improve surface quality, and protect, e.g., tools and machine parts from damage, wear and corrosion as far as possible. In addition to the functions described above, ideal lubricating fluids have the following desirable functions and properties: inhibit corrosion, low foam formation, low toxicity, microbial resistant, waste treatment friendly, biodegradable, and non-objectionable odor.

[0003] For example, lubricating fluids are frequently used in metal working processes, e.g., cutting, grinding, forming, lapping, drawing, forming, pressing, punching, rolling, stamping, etc. Metalworking fluids are often straight oil (vegetable or animal oil or fat, a mineral oil, synthetic oil or a mixture thereof) or water-based fluids. Water-based metalworking fluids include soluble oils, which contain less than 2% by weight of water; semi-synthetic fluids, which contain 10-60% by weight of water; synthetic fluids, which are petroleum oil-free and can contain any water-soluble lubricity additive; and neo-synthetic fluids, which use vegetable oil and/or animal oil instead of petroleum and may contain an emulsifier, corrosion inhibitors, alkanolamine, and water. Metalworking fluids may also include agents, for example, an oiliness improver, an extreme pressure agent, a corrosion inhibitor (e.g. a rust preventative), a surfactant, a preservative, an antioxidant, etc.

[0004] Petroleum oil rich metalworking fluids are utilized in nearly 80% of metalworking operations. Petroleum based metalworking fluids, however, have several drawbacks, for example: (1) poor heat conductivity and therefore, limited ability to cool; (2) misting results in petroleum residues that are difficult to remove; (3) the emulsion stability is often effected by water hardness; and (4) not environmentally friendly and therefore, result in disposal difficulties.

[0005] Amine-containing metalworking fluids are being employed because the amines (e.g. alkanolamines) increase bio-resistance, corrosion protection, and emulsion stability. Effective water-based metalworking fluids are difficult to formulate without employing

amines. However, amines can be very toxic. Furthermore, synthetic petroleum oil-free (i.e. water-based) metalworking fluids currently on the market have limited lubricity and stability. As such, there is a need for metalworking fluids that are effective lubricants, which are stable for an extended period of time, and contain less hazardous compounds (e.g. reduced amine content).

[0006] DIACID 1550 is often employed in lubricating fluids because it is a co-emulsifier that inhibits corrosion (extends machinery life), has lower bioactivity (prolongs fluid life), and has increased hard water tolerance compared to mixed and fatty acids. As such, employing DIACID 1550 results fewer additives in the lubricating fluid because it functions to lubricate, prevent corrosion, co-emulsifies, etc. However, DIACID 1550 is limited in its hard water tolerance (i.e. stability in hard water), and produces foam when utilized in metalworking fluids.

[0007] Therefore, there exists a need to for lubricating fluids that have increased stability (i.e., longer shelf-life), performance in hard water, suitable lubricity, and reduced foam formation during use, e.g., metalworking.

SUMMARY

[0008] The present description relates to the surprising and unexpected discovery of agents that provide superior lubrication and hard water tolerance (i.e. stable in hard water), in a non-foaming or low foaming composition. In particular, the present description discloses lubricating compounds and compositions comprising the same. The compounds described herein include partial esters of a compound derived from the Diels-Alder reaction of a diene, e.g., a conjugated fatty acid, and an acid precursor dienophile. The resulting half-esters as described herein demonstrate at least one of increased stability (i.e., longer shelf life), better performance in hard water, lubricity, and reduced foam formation during use. As such, the lubricating compositions as described herein are suitable for numerous applications, including mechanical processes such as metalworking.

[0009] In certain embodiments, the diene is a conjugated fatty acid (substituted or unsubstituted).

[0010] In certain embodiments the dienophile can be an acrylic acid or an acrylic acid ester. In certain other embodiments the dienophile can be maleic anhydride or fumaric acid or a fumaric acid mono or diester. In certain embodiments, the compound derived from the

Diels-Alder reaction of a diene, e.g., a conjugated fatty acid, and an acid precursor dienophile is DIACID 1550, which is derived from the reaction of a fatty acid and acrylic acid.

[0011] In certain embodiments, the lubricating compound comprises or consists essentially of a DIACID 1550 partial or half ester. The DIACID 1550 partial ester can be derived from a reaction product of DIACID 1550 and an alcohol. In an embodiment, the lubricating compound is a partial ester of DIACID 1550 and at least one of n-Pentanol, 1-Dodecanol, or 2-ethyl-1-hexanol.

[0012] In another aspect, the description provides lubricating compositions comprising a compound as described herein. The lubricating compositions described herein are useful for a variety of applications including, e.g., as a lubricant in mechanical processes or machines such as metalworking.

[0013] In a certain embodiment described herein, the composition is a semi-synthetic lubricating fluid. In an exemplary embodiment, the lubricating fluid is a metalworking fluid. The semi-synthetic lubricating fluid can be optimized with a coupling solvent, e.g. tripropylene glycol methyl ether or diethylene glycol monobutyl ether. In another embodiment of the present description, the composition is a synthetic lubricating fluid. The synthetic lubricating fluid can be optimized with a non-ionic surfactant, for example, alkylphenol ethoxylate, a linear alcohol ethoxylate, or a DIACID 1550 ethoxylate.

[0014] In an embodiment, the lubricating composition is a semi-synthetic lubricating fluid and further includes a coupling solvent, for example tripropylene glycol methyl ether or diethylene glycol monobutyl ether.

[0015] In another embodiment, the lubricating composition is a synthetic lubricating fluid and further includes a nonionic surfactant, for example a alkylphenol ethoxylate, a linear alcohol ethoxylate, or a DIACID 1550 ethoxylate.

[0016] In certain embodiments, the lubricating composition includes at least one of a biocide and a fungicide.

[0017] In certain aspects, the present disclosure relates to a method of lubricating a metal workpiece by applying the aqueous lubricating composition described herein.

[0018] In certain other aspects, the present disclosure relates to a machining process comprising performing a machining operation, e.g., metalworking, by flushing, spraying, high pressure spraying, brushing, flowing, fluting, roll coating, immersion, or any combination thereof with the aqueous lubricating composition described herein.

[0019] The preceding general areas of utility are given by way of example only and are not intended to be limiting on the scope of the present disclosure and appended claims. Additional objects and advantages of the present invention will be appreciated by one of ordinary skill in the art in light of the instant claims, description, and examples. For example, the various aspects and embodiments of the invention may be utilized in numerous combinations, all of which are expressly contemplated by the present description. These additional objects and advantages are expressly included within the scope of the present invention.

BRIEF DESCRIPTION OF THE DRAWINGS

[0020] The accompanying drawings, which are incorporated into and form a part of the specification, illustrate several embodiments of the present invention and, together with the description, serve to explain the principles of the invention. The drawings are only for the purpose of illustrating an embodiment of the invention and are not to be construed as limiting the invention.

[0021] **Figure 1.** Graph of DIACID 1550 2-Ethyl-1-hexanol 4Ball Test data.

[0022] **Figure 2.** Graph of Polartech LA-8330 (industry standard lubricant) 4Ball Test data.

[0023] **Figure 3.** Graph of a Standard Ester 4Ball Test data.

[0024] **Figure 4.** Graph comparing average torque values from a Microtap in aluminum 6061 of DIACID 1550 2-Ethyl-1-hexanol (78-60B) and an Industry Standard Lubricant (78-60C).

[0025] **Figure 5.** Graph comparing efficiency of DIACID 1550 2-Ethyl-1-hexanol (78-60B) and an Industry Standard Lubricant (78-60C) in a Microtap test of on aluminum 6061.

[0026] **Figure 6.** Graph comparing average torque values from a Microtap in steel 6061 of DIACID 1550 2-Ethyl-1-hexanol (78-60B) and an Industry Standard Lubricant (78-60C).

[0027] **Figure 7.** Graph comparing efficiency of DIACID 1550 2-Ethyl-1-hexanol (78-60B) and an Industry Standard Lubricant (78-60C) in a Microtap test of on steel 1018.

[0028] **Figure 8.** Graph comparing Falex Pin and Vee results of DIACID 1550 2-Ethyl-1-hexanol (78-60B) and an Industry Standard Lubricant (78-60C).

[0029] **Figure 9.** Corrosion inhibition data for DIACID 1550 2-Ethyl-1-hexanol (78-60B) and an Industry Standard Lubricant (78-60C) in 100 ppm hard water.

[0030] **Figure 10.** Corrosion inhibition data for DIACID 1550 2-Ethyl-1-hexanol (78-60B) and an Industry Standard Lubricant (78-60C) in 500 ppm hard water.

[0031] **Figure 11.** Hard water tolerance data for DIACID 1550 2-Ethyl-1-hexanol (78-60B ; left two cylinders) and an Industry Standard Lubricant (78-60C ; right two cylinders) with the left of each diluted in 500 ppm hardness water and the right of each diluted in 1,000 ppm hardness water.

[0032] **Figure 12.** Comparison of the torque during a Falex Pin Vee Block test of DIACID 1550 2-Ethyl-1-hexanol partial ester and Priolube™ 3952 containing semi-synthetic metal working fluids.

[0033] **Figure 13.** Comparison of the torque during a Falex Pin Vee Block test of DIACID 1550 2-Ethyl-1-hexanol partial ester and Priolube™ 3952 containing semi-synthetic metal working fluids.

[0034] **Figure 14.** Comparison of the torque during a Falex Pin Vee Block test of DIACID 1550 2-Ethyl-1-hexanol partial ester and Priolube™ 3952 containing semi-synthetic metal working fluids.

[0035] **Figure 15.** Comparison of the torque during a Falex Pin Vee Block test of DIACID 1550 2-Ethyl-1-hexanol partial ester and Priolube™ 3952 containing semi-synthetic metal working fluids.

DETAILED DESCRIPTION

[0036] The following is a detailed description of the disclosure provided to aid those skilled in the art in practicing the present disclosure. Those of ordinary skill in the art may make modifications and variations in the embodiments described herein without departing from the spirit or scope of the present disclosure. Unless otherwise defined, all technical and scientific terms used herein have the same meaning as commonly understood by one of ordinary skill in the art to which this disclosure belongs. The terminology used in the description of the disclosure herein is for describing particular embodiments only and is not intended to be limiting of the disclosure. All publications, patent applications, patents, figures and other references mentioned herein are expressly incorporated by reference in their entirety.

[0037] As described herein, the present description relates to the surprising and unexpected discovery of an agent that provides superior lubrication and hard water tolerance (i.e. stable in hard water), in a non-foaming or low foaming composition. In particular, the present description discloses lubricating compounds and compositions comprising the same. The compounds described herein include partial esters of a compound derived from the Diels-Alder reaction of a diene, e.g., a conjugated fatty acid, and an acid precursor dienophile. The resulting half-esters as described herein demonstrate at least one of increased stability (i.e., longer shelf life), better performance in hard water, lubricity, and reduced foam formation during use. As such the lubricating compositions as described herein are suitable for numerous applications, including mechanical processes such as metalworking.

[0038] In certain embodiments, the diene is a conjugated fatty acid (substituted or unsubstituted).

[0039] In certain embodiments the dienophile can be an acrylic acid or an acrylic acid ester. In certain other embodiments the acid precursor dienophile is at least one of methacrylic acid, maleic anhydride, fumaric acid, a fumaric acid mono or diester or a combination thereof. In certain embodiments, the compound derived from the Diels-Alder reaction of a diene, e.g., a conjugated fatty acid, and an acid precursor dienophile is DIACID 1550 (Ingevity Corporation), which is derived from the reaction of a fatty acid and acrylic acid.

[0040] In certain embodiments, the lubricating compound is a DIACID 1550 partial or half ester. The DIACID 1550 partial ester can be derived from a reaction product of DIACID 1550 and an alcohol. In an embodiment, the lubricating compound is a partial ester of DIACID 1550 and at least one of n-Pentanol, 1-Dodecanol, or 2-ethyl-1-hexanol.

[0041] In another aspect, the description provides lubricating compositions comprising a compound as described herein. The lubricating compositions described herein are useful for a variety of applications including, e.g., metalworking.

[0042] In a certain embodiment described herein, the lubricating composition is a semi-synthetic lubricating fluid. The semi-synthetic lubricating fluid can be optimized with a coupling solvent, e.g. tripropylene glycol methyl ether or diethylene glycol monobutyl ether. In another embodiment of the present description, the composition is a synthetic lubricating fluid. The synthetic lubricating fluid can be optimized with a non-ionic surfactant, for example, alkylphenol ethoxylate, a linear alcohol ethoxylate, or a DIACID 1550 ethoxylate.

[0043] In another aspect, the description discloses an aqueous lubricating composition comprising a partial ester of a compound derived from the Diels-Alder reaction of a diene, e.g., a conjugated fatty acid, and an acid precursor dienophile, e.g., a DIACID 1550 partial ester. The DIACID 1550 partial ester can be derived from a reaction of an alcohol and DIACID 1550. In a particular embodiment, the alcohol is selected from the group consisting of n-pentanol, 1-docecanol, 2-ethyl-1-hexanol, and combinations thereof.

[0044] DIACID 1550 partial esters, for example a half ester (that is, a monoester), are an effective additive for lubricating fluids, e.g., metalworking fluids. In particular, mixtures comprising DIACID 1550 partial esters, including in combination with at least one of DIACID1550 bis-esters or diesters or DIACID 1550, are effective additives for lubricating compositions, including, e.g., metalworking fluids. DIACID 1550 half esters have properties that can be used in semi-synthetic and synthetic lubricating fluid formulations. In properly balanced systems, DIACID 1550 half esters provide very good results with regard to emulsion stability in hard water. This hard water stability is a significant improvement over DIACID 1550 alone. The DIACID 1550 half esters also have enhanced lubrication and comparable corrosion inhibition properties compared to DIACID 1550.

[0045] In addition, the DIACID 1550 half esters give very good results in synthetic systems when nonionic surfactants are used to adjust the hydrophobic/lipophilic balance (HLB) of the formulation. In semi-synthetic systems, a coupling solvent can be used to optimize formulation stability. The DIACID 1550 half esters appear to be significantly more flexible when compared to DIACID 1550 in these type of formulations.

[0046] Where a range of values is provided, it is understood that each intervening value, to the tenth of the unit of the lower limit unless the context clearly dictates otherwise (such as in the case of a group containing a number of carbon atoms in which case each carbon atom number falling within the range is provided), between the upper and lower limit of that range and any other stated or intervening value in that stated range is encompassed within the disclosure. The upper and lower limits of these smaller ranges may independently be included in the smaller ranges is also encompassed within the invention, subject to any specifically excluded limit in the stated range. Where the stated range includes one or both of the limits, ranges excluding either both of those included limits are also included in the invention.

[0047] The following terms are used to describe the present invention. In instances where a term is not specifically defined herein, that term is given an art-recognized meaning by those of ordinary skill applying that term in context to its use in describing the present invention.

[0048] The articles "a" and "an" as used herein and in the appended claims are used herein to refer to one or to more than one (i.e., to at least one) of the grammatical object of the article unless the context clearly indicates otherwise. By way of example, "an element" means one element or more than one element.

[0049] The phrase "and/or," as used herein in the specification and in the claims, should be understood to mean "either or both" of the elements so conjoined, i.e., elements that are conjunctively present in some cases and disjunctively present in other cases. Multiple elements listed with "and/or" should be construed in the same fashion, i.e., "one or more" of the elements so conjoined. Other elements may optionally be present other than the elements specifically identified by the "and/or" clause, whether related or unrelated to those elements specifically identified. Thus, as a non-limiting example, a reference to "A and/or B", when used in conjunction with open-ended language such as "comprising" can refer, in one embodiment, to A only (optionally including elements other than B); in another embodiment, to B only (optionally including elements other than A); in yet another embodiment, to both A and B (optionally including other elements); etc.

[0050] As used herein in the specification and in the claims, "or" should be understood to have the same meaning as "and/or" as defined above. For example, when separating items in a list, "or" or "and/or" shall be interpreted as being inclusive, i.e., the inclusion of at least one, but also including more than one, of a number or list of elements, and, optionally, additional unlisted items. Only terms clearly indicated to the contrary, such as "only one of" or "exactly one of," or, when used in the claims, "consisting of," will refer to the inclusion of exactly one element of a number or list of elements. In general, the term "or" as used herein shall only be interpreted as indicating exclusive alternatives (i.e., "one or the other but not both") when preceded by terms of exclusivity, such as "either," "one of," "only one of," or "exactly one of."

[0051] In the claims, as well as in the specification above, all transitional phrases such as "comprising," "including," "carrying," "having," "containing," "involving," "holding," "composed of," and the like are to be understood to be open-ended, i.e., to mean including but

not limited to. Only the transitional phrases "consisting of" and "consisting essentially of" shall be closed or semi-closed transitional phrases, respectively, as set forth in the 10 United States Patent Office Manual of Patent Examining Procedures, Section 2111.03.

[0052] As used herein in the specification and in the claims, the phrase "at least one," in reference to a list of one or more elements, should be understood to mean at least one element selected from anyone or more of the elements in the list of elements, but not necessarily including at least one of each and every element specifically listed within the list of elements and not excluding any combinations of elements in the list of elements. This definition also allows that elements may optionally be present other than the elements specifically identified within the list of elements to which the phrase "at least one" refers, whether related or unrelated to those elements specifically identified. Thus, as a nonlimiting example, "at least one of A and B" (or, equivalently, "at least one of A or B," or, equivalently "at least one of A and/or B") can refer, in one embodiment, to at least one, optionally including more than one, A, with no B present (and optionally including elements other than B); in another embodiment, to at least one, optionally including more than one, B, with no A present (and optionally including elements other than A); in yet another embodiment, to at least one, optionally including more than one, A, and at least one, optionally including more than one, B (and optionally including other elements); etc.

[0053] It should also be understood that, unless clearly indicated to the contrary, in any methods claimed herein that include more than one step or act, the order of the steps or acts of the method is not necessarily limited to the order in which the steps or acts of the method are recited.

[0054] The term "compound", as used herein, unless otherwise indicated, refers to any specific chemical compound disclosed herein and includes tautomers, regioisomers, geometric isomers, and where applicable, stereoisomers, including optical isomers (enantiomers) and other stereoisomers (diastereomers) thereof. It is noted that in describing the present compounds, numerous substituents and variables associated with same, among others, are described. It is understood by those of ordinary skill that molecules which are described herein are stable compounds as generally described hereunder. When the bond is shown, both a double bond and single bond are represented within the context of the compound shown.

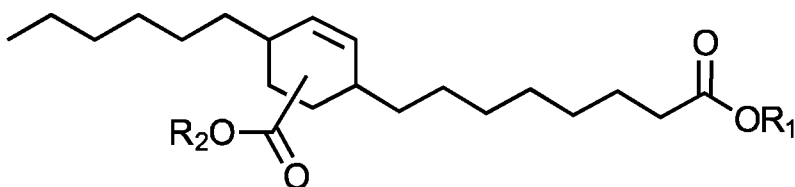
[0055] As described above, the present description discloses a lubricating fluid composition comprising a partial ester of a Diels-Alder product resulting from the reaction of

a diene, e.g., a conjugated fatty acid, with an acid precursor dienophile. In certain embodiments the dienophile can be an acrylic acid or an acrylic acid ester. In certain other embodiments the dienophile can be maleic anhydride or fumaric acid or a fumaric acid mono or diester. In certain embodiments, the compound derived from the Diels-Alder reaction of a diene, e.g., a conjugated fatty acid, and an acid precursor dienophile is DIACID 1550 (Ingevity Corporation), which is derived from the reaction of a fatty acid and acrylic acid.

[0056] In certain embodiments, the partial ester is a DIACID 1550 half ester. DIACID 1550 (Ingevity, South Carolina) is a Diels-Alder product resulting from the reaction of acrylic acid with a tall oil fatty acid (TOFA). The DIACID 1550 half ester can be derived from a reaction comprising an alcohol and DIACID 1550. In a preferred embodiment, the reaction is performed with a molar excess of carboxyl moieties, such that the majority of esters produced are partial esters. In certain embodiments, the alcohol in the reaction is present at an alcohol to carboxyl moiety molar ratio of less than or equal to 0.5:1. In an embodiment, the half ester is derived from at least one of n-Pentanol, 1-Dodecanol, or 2-ethyl-1-hexanol.

[0057] In addition to the DIACID 2-Ethyl-1-hexanol, 1-dodecanol, and n-pentanol half esters, DIACID 1550 half esters of other alcohols can be utilized as a lubricating additive in any of the lubricating compositions described herein, including for metalworking. For example, in an embodiment, the DIACID 1550 half ester alcohol is selected from methanol, ethanol, 1-propanol, 2-propanol, 2-chloro-1-propanol, 1-chloro-2-propanol, 1-butanol, 2-butanol, isobutanol, tert-butanol, 1-pentanol, 2-methyl-1-butanol, 3-methyl-1-butanol, 2,2-dimethyl-1-propanol, cyclopentanol, 1-hexanol, 2-methyl-1-pentanol, 3-methyl-1-pentanol, 4-methyl-1-pentanol, 2,2-dimethyl-1-butanol, 2,3-dimethyl-1-butanol, 3,3-dimethyl-1-butanol, 2-ethyl-1-butanol, 3-ethyl-1-butanol, cyclohexanol, 1-octanol, 2-octanol, 2-ethyl-1-hexanol, 1-decanol, 2-decanol, 1-dodecanol, 2-dodecanol, 1-tetradecanol, 2-tetradecanol, 1-hexadecanol, 2-hexadecanol, 1-octadecanol, 2-octadecanol, benzyl alcohol, nonanol, decanol, polyoxyethylene, polyoxypropylene, diol or polyol.

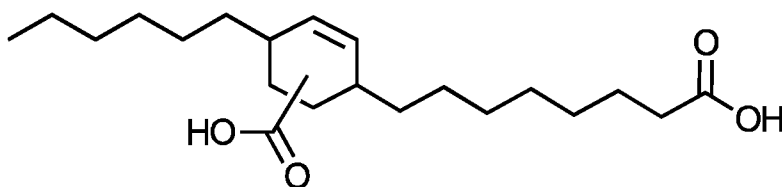
[0058] In a particular embodiment, the DIACID 1550 partial ester has Formula (I):



Formula (I),

wherein R_1 and R_2 are independently selected from the group comprising H, alkyl, alkenyl, cycloalkyl, chloroalkyl, chlorocycloalkyl, polyoxyethylene, polyoxypropylene, or a mixture thereof, and wherein at least one of R_1 and R_2 is H and the other is not.

[0059] In an embodiment, DIACID 1550 has Formula (II):



Formula (II).

[0060] In certain embodiments, at least one of R_1 or R_2 but not both is at least one of alkyl, alkenyl, cycloalkyl, chloroalkyl, chlorocycloalkyl, polyoxyethylene and polyoxypropylene.

[0061] In a certain embodiment, at least 10 mol-% of R_1 and R_2 are H. In another embodiment, up to 90 mol-% of R_1 or R_2 are at least one of alkyl, alkenyl, cycloalkyl, chloroalkyl, chlorocycloalkyl, polyoxyethylene and polyoxypropylene.

[0062] The DIACID 1550 partial ester alcohol of the description may have the Formula (III): $HO-R^3-R^4$, wherein R^3 comprises an aliphatic group having 1 to 50 carbon atoms, and R^2 or R^4 comprises either H or an aromatic ring bound to any carbon atom of R^3 . Alternatively, the DIACID 1550 partial ester alcohol of the description may have the formula

[0063] As used herein, the term “alcohol” refers to a compound in which a hydroxyl group (-OH) is attached to a carbon atom.

[0064] As used here, the term “aliphatic” refers to a carbon and hydrogen group that can be saturated or unsaturated without an aromatic arrangement.

[0065] As used herein, “diol” refers to a compound that contains two hydroxyl groups.

[0066] As used herein, “polyol” refers to a compound that contains multiple hydroxyl groups.

[0067] As used herein, the term “alkyl,” by itself or as part of another substituent means, unless otherwise stated, a straight or branched chain hydrocarbon having the number of carbon atoms designated (i.e., C_1 - C_{10} means one to ten carbon atoms) and includes straight, branched chain, or cyclic substituent groups. Examples include methyl, ethyl, propyl, isopropyl, butyl, isobutyl, tert-butyl, pentyl, neopentyl, hexyl, and cyclopropylmethyl. Most

preferred is (C₁-C₆) alkyl, such as, but not limited to, ethyl, methyl, isopropyl, isobutyl, n-pentyl, n-hexyl and cyclopropylmethyl.

[0068] As used herein, the term “cycloalkyl,” by itself or as part of another substituent means, unless otherwise stated, a cyclic chain hydrocarbon having the number of carbon atoms designated (i.e., C₃-C₆ means a cyclic group comprising a ring group consisting of three to six carbon atoms) and includes straight, branched chain or cyclic substituent groups. Examples include cyclopropyl, cyclobutyl, cyclopentyl, cyclohexyl, cycloheptyl, and cyclooctyl. Most preferred is (C₃-C₆)cycloalkyl, such as, but not limited to, cyclopropyl, cyclobutyl, cyclopentyl and cyclohexyl.

[0069] As used herein, the term “chloroalkyl,” by itself or as part of another substituent means, unless otherwise states, any alkyl radical having one or more hydrogen atoms replaced by chlorine.

[0070] As used herein, the term “chlorocycloalkyl,” by itself or as part of another substituent means, unless otherwise states, any cycloalkyl radical having one or more hydrogen atoms replace by chlorine.

[0071] As used herein, the term “alkenyl,” employed alone or in combination with other terms, means, unless otherwise stated, a stable mono-unsaturated or di-unsaturated straight chain or branched chain hydrocarbon group having the stated number of carbon atoms. Examples include vinyl, propenyl (or allyl), crotyl, isopentenyl, butadienyl, 1,3-pentadienyl, 1,4-pentadienyl, and the higher homologs and isomers. A functional group representing an alkene is exemplified by -CH₂-CH=CH₂.

[0072] In an embodiment, the esterification of the Diels-Alder reaction product, e.g., DIACID 1550, is not complete (i.e., DIACID 1550 retains at least one unsubstituted carboxyl). For example, by reacting the alcohol or alkoxy with DIACID 1550, wherein the molar ratio of the alcohol to carboxyl moieties is less than 1:1, partial esterification of DIACID 1550 is achieved.

[0073] In certain embodiments, the description provides a lubricating composition, e.g., a lubricating fluid composition, comprising a partial (i.e., half) ester of a Diels-Alder reaction product of a diene, e.g., conjugated fatty acid, and a dienophile, e.g., an acid precursor dienophile. In certain additional embodiments, the diene is a conjugated fatty acid (substituted or unsubstituted).

[0074] In certain embodiments the dienophile can be an acrylic acid or an acrylic acid ester. In additional embodiments, the acid precursor dienophile is methacrylic acid. In certain other embodiments the dienophile can be maleic anhydride or fumaric acid or a fumaric acid mono or diester. In certain embodiments, the compound derived from the Diels-Alder reaction of a diene, e.g., a conjugated fatty acid, and an acid precursor dienophile is DIACID 1550 (Ingevity Corporation), which is derived from the reaction of a fatty acid and acrylic acid.

[0075] In certain embodiments, the conjugated fatty acid is derived from tall oil fatty acid. In additional embodiments, the conjugated fatty acid is linoleic acid.

[0076] In certain embodiments, the compound derived from the Diels-Alder reaction of a conjugated fatty acid and acrylic acid is DIACID 1550, and the partial ester is a DIACID 1550 partial ester.

[0077] In another aspect, the description provides a lubricating composition, e.g., a lubricating fluid, comprising a partial ester compound as described herein. In certain embodiments, the composition comprises a mixture of DIACID 1550 partial (i.e., half) esters.

[0078] In certain embodiments, the description provides a lubricating composition, e.g., a lubricating fluid, comprising a mixture of DIACID 1550 partial (i.e., half) ester, DIACID 1550 bis-ester, and DIACID 1550. In certain embodiments, the composition comprises an excess of DIACID 1550 partial ester relative to at least one of the bis-ester, DIACID 1550 or a combination thereof. In additional embodiments, the amount of DIACID 1550 partial ester is at least 2x, 3x, or 4x, the amount of either the bis-ester or DIACID 1550.

[0079] In certain embodiments, the description provides a lubricating composition, e.g., a lubricating fluid or metalworking fluid comprising from about 40% to about 80% (based on Area % as determined by GPC) DIACID 1550 partial ester. In certain additional embodiments, the DIACID 1550 partial ester may be present in a range of about 40% to about 75%, about 40% to about 70%, about 40% to about 65%, about 40% to about 60%, about 40% to about 55%, about 40% to about 50%, about 40% to about 45%, 45% to about 80%, about 45% to about 75%, about 45% to about 70%, about 45% to about 65%, about 45% to about 60%, about 45% to about 55%, about 45% to about 50%, 50% to about 80%, about 50% to about 75%, about 50% to about 70%, about 50% to about 65%, about 50% to about 60%, about 50% to about 55%, 55% to about 80%, about 55% to about 75%, about 55% to about 70%, about 55% to about 65%, about 55% to about 60%, 60% to about 80%, about

60% to about 75%, about 60% to about 70%, about 60% to about 65%, 65% to about 80%, about 65% to about 75%, about 65% to about 70%, 70% to about 80%, about 70% to about 75%, or about 75% to about 80%. In certain embodiments, DIACID 1550 partial ester is present in about 40%, about 42.5%, about 45%, about 47.5%, about 50%, about 52.5%, about 55%, about 57.5%, about 60%, about 62.5%, about 65%, about 67.5%, about 70%, about 72.5%, about 75%, about 77.5%, or about 80% (all of the above percentages are based on Area % as determined by GPC).

[0080] In certain embodiments, the lubricating composition, e.g., a lubricating fluid or metalworking fluid further comprises DIACID 1550 in a range of about 5% to about 35%, about 5% to about 32.5%, about 5% to about 30%, about 5% to about 27.5%, about 5% to about 25%, about 5% to about 22.5%, about 5% to about 20%, about 5% to about 17.5%, about 5% to about 15%, about 5% to about 12.5%, about 5% to about 10%, about 5% to about 7.5%, about 7.5% to about 35%, about 7.5% to about 32.5%, about 7.5% to about 30%, about 7.5% to about 27.5%, about 7.5% to about 25%, about 7.5% to about 22.5%, about 7.5% to about 20%, about 7.5% to about 17.5%, about 7.5% to about 15%, about 7.5% to about 12.5%, about 7.5% to about 10%, about 10% to about 35%, about 10% to about 32.5%, about 10% to about 30%, about 10% to about 27.5%, about 10% to about 25%, about 10% to about 22.5%, about 10% to about 20%, about 10% to about 17.5%, about 10% to about 15%, about 10% to about 12.5%, about 12.5% to about 35%, about 12.5% to about 32.5%, about 12.5% to about 30%, about 12.5% to about 27.5%, about 12.5% to about 25%, about 12.5% to about 22.5%, about 12.5% to about 20%, about 12.5% to about 17.5%, about 12.5% to about 15%, about 15% to about 35%, about 15% to about 32.5%, about 15% to about 30%, about 15% to about 27.5%, about 15% to about 25%, about 15% to about 22.5%, about 15% to about 20%, about 15% to about 17.5%, about 17.5% to about 35%, about 17.5% to about 32.5%, about 17.5% to about 30%, about 17.5% to about 27.5%, about 17.5% to about 25%, about 17.5% to about 22.5%, about 17.5% to about 20%, about 20% to about 35%, about 20% to about 32.5%, about 20% to about 30%, about 20% to about 27.5%, about 20% to about 25%, about 20% to about 22.5%, about 22.5% to about 35%, about 22.5% to about 32.5%, about 22.5% to about 30%, about 22.5% to about 27.5%, about 22.5% to about 25%, about 25% to about 35%, about 25% to about 32.5%, about 25% to about 30%, about 25% to about 27.5%, about 27.5% to about 35%, about 27.5% to about 32.5%, about 27.5% to about

30%, about 30% to about 35%, about 30% to about 32.5%, or about 32.5% to about 35%. (All of the above percentages are based on Area % as determined by GPC).

[0081] In certain embodiments, the lubricating composition, e.g., a lubricating fluid or metalworking fluid comprises DIACID 1550 in about 5%, about 6%, about 7%, about 8%, about 9%, about 10%, about 11%, about 12%, about 13%, about 14%, about 15%, about 16%, about 17%, about 18%, about 19%, about 20%, about 21%, about 22%, about 23%, about 24%, about 25%, about 26%, about 27%, about 28%, about 29%, about 30%, about 31%, about 32%, about 33%, about 34%, or about 35%. (All of the above percentages are based on Area % as determined by GPC).

[0082] In certain embodiments, the lubricating composition, e.g., a lubricating fluid or metalworking fluid further comprises DIACID 1550 bis-ester in a range of about 5% to about 35%, about 5% to about 32.5%, about 5% to about 30%, about 5% to about 27.5%, about 5% to about 25%, about 5% to about 22.5%, about 5% to about 20%, about 5% to about 17.5%, about 5% to about 15%, about 5% to about 12.5%, about 5% to about 10%, about 5% to about 7.5%, about 7.5% to about 35%, about 7.5% to about 32.5%, about 7.5% to about 30%, about 7.5% to about 27.5%, about 7.5% to about 25%, about 7.5% to about 22.5%, about 7.5% to about 20%, about 7.5% to about 17.5%, about 7.5% to about 15%, about 7.5% to about 12.5%, about 7.5% to about 10%, about 10% to about 35%, about 10% to about 32.5%, about 10% to about 30%, about 10% to about 27.5%, about 10% to about 25%, about 10% to about 22.5%, about 10% to about 20%, about 10% to about 17.5%, about 10% to about 15%, about 10% to about 12.5%, about 12.5% to about 35%, about 12.5% to about 32.5%, about 12.5% to about 30%, about 12.5% to about 27.5%, about 12.5% to about 25%, about 12.5% to about 22.5%, about 12.5% to about 20%, about 12.5% to about 17.5%, about 12.5% to about 15%, about 15% to about 35%, about 15% to about 32.5%, about 15% to about 30%, about 15% to about 27.5%, about 15% to about 25%, about 15% to about 22.5%, about 15% to about 20%, about 15% to about 17.5%, about 17.5% to about 35%, about 17.5% to about 32.5%, about 17.5% to about 30%, about 17.5% to about 27.5%, about 17.5% to about 25%, about 17.5% to about 22.5%, about 17.5% to about 20%, about 20% to about 35%, about 20% to about 32.5%, about 20% to about 30%, about 20% to about 27.5%, about 20% to about 25%, about 20% to about 22.5%, about 22.5% to about 35%, about 22.5% to about 32.5%, about 22.5% to about 30%, about 22.5% to about 27.5%, about 22.5% to about 25%, about 25% to about 35%, about 25% to about 32.5%, about 25% to about 30%, about 25% to

about 27.5%, about 27.5% to about 35%, about 27.5% to about 32.5%, about 27.5% to about 30%, about 30% to about 35%, about 30% to about 32.5%, or about 32.5% to about 35%. (All of the above percentages are based on Area % as determined by GPC).

[0083] In certain embodiments, the DIACID 1550 bis-ester is present in about 5%, about 6%, about 7%, about 8%, about 9%, about 10%, about 11%, about 12%, about 13%, about 14%, about 15%, about 16%, about 17%, about 18%, about 19%, about 20%, about 21%, about 22%, about 23%, about 24%, about 25%, about 26%, about 27%, about 28%, about 29%, about 30%, about 31%, about 32%, about 33%, about 34%, or about 35%. (All of the above percentages are based on Area % as determined by GPC).

[0084] In an embodiment, the DIACID 1550 partial ester composition may include a ratio of DIACID 1550 half ester to DIACID 1550 bis ester in a range of about 16:1 to about 1:1, about 15:1 to about 1:1, about 14:1 to about 1:1, about 13:1 to about 1:1, about 12:1 to about 1:1, about 11:1 to about 1:1, about 10:1 to about 1:1, about 9:1 to about 1:1, about 8:1 to about 1:1, about 7:1 to about 1:1, about 6:1 to about 1:1, about 5:1 to about 1:1, about 4:1 to about 1:1, about 3:1 to about 1:1, about 2:1 to about 1:1, about 16:1 to about 2:1, about 15:1 to about 2:1, about 14:1 to about 2:1, about 13:1 to about 2:1, about 12:1 to about 2:1, about 11:1 to about 2:1, about 10:1 to about 2:1, about 9:1 to about 2:1, about 8:1 to about 2:1, about 7:1 to about 2:1, about 6:1 to about 2:1, about 5:1 to about 2:1, about 4:1 to about 2:1, about 3:1 to about 2:1, about 16:1 to about 3:1, about 15:1 to about 3:1, about 14:1 to about 3:1, about 13:1 to about 3:1, about 12:1 to about 3:1, about 11:1 to about 3:1, about 10:1 to about 3:1, about 9:1 to about 3:1, about 8:1 to about 3:1, about 7:1 to about 3:1, about 6:1 to about 3:1, about 5:1 to about 3:1, about 4:1 to about 3:1, about 16:1 to about 4:1, about 15:1 to about 4:1, about 14:1 to about 4:1, about 13:1 to about 4:1, about 12:1 to about 4:1, about 11:1 to about 4:1, about 10:1 to about 4:1, about 9:1 to about 4:1, about 8:1 to about 4:1, about 7:1 to about 4:1, about 6:1 to about 4:1, about 5:1 to about 4:1, about 16:1 to about 5:1, about 15:1 to about 5:1, about 14:1 to about 5:1, about 13:1 to about 5:1, about 12:1 to about 5:1, about 11:1 to about 5:1, about 10:1 to about 5:1, about 9:1 to about 5:1, about 8:1 to about 5:1, about 7:1 to about 5:1, about 6:1 to about 5:1, about 16:1 to about 6:1, about 15:1 to about 6:1, about 14:1 to about 6:1, about 13:1 to about 6:1, about 12:1 to about 6:1, about 11:1 to about 6:1, about 10:1 to about 6:1, about 9:1 to about 6:1, about 8:1 to about 6:1, about 7:1 to about 6:1, about 16:1 to about 7:1, about 15:1 to about 7:1, about 14:1 to about 7:1, about 13:1 to about 7:1, about 12:1 to about 7:1, about 11:1 to about 7:1, about

10:1 to about 7:1, about 9:1 to about 7:1, about 8:1 to about 7:1, about 16:1 to about 8:1, about 15:1 to about 8:1, about 14:1 to about 8:1, about 13:1 to about 8:1, about 12:1 to about 8:1, about 11:1 to about 8:1, about 10:1 to about 8:1, about 9:1 to about 8:1, about 16:1 to about 9:1, about 15:1 to about 9:1, about 14:1 to about 9:1, about 13:1 to about 9:1, about 12:1 to about 9:1, about 11:1 to about 9:1, about 10:1 to about 9:1, about 16:1 to about 10:1, about 15:1 to about 10:1, about 14:1 to about 10:1, about 13:1 to about 10:1, about 12:1 to about 10:1, about 11:1 to about 10:1, about 16:1 to about 11:1, about 15:1 to about 11:1, about 14:1 to about 11:1, about 13:1 to about 11:1, about 12:1 to about 11:1, about 16:1 to about 12:1, about 15:1 to about 12:1, about 14:1 to about 12:1, about 13:1 to about 12:1, about 16:1 to about 13:1, about 15:1 to about 13:1, about 14:1 to about 13:1, about 16:1 to about 14:1, about 15:1 to about 14:1, or about 16:1 to about 15:1. In a certain embodiment, a ratio of DIACID 1550 half ester to DIACID 1550 bis ester is about 16:1, about 15:1, about 14:1 about 13:1, about 12:1, about 11:1, about 10:1, about 9:1, about 8:1, about 7:1, about 6:1, about 5:1, about 4:1, about 3:1, about 2:1, about 8:7, or about 1:1.

[0085] In an embodiment, the DIACID 1550 partial ester composition may include a ratio of DIACID 1550 half ester to DIACID 1550 in a range of about 16:1 to about 1:1, about 15:1 to about 1:1, about 14:1 to about 1:1, about 13:1 to about 1:1, about 12:1 to about 1:1, about 11:1 to about 1:1, about 10:1 to about 1:1, about 9:1 to about 1:1, about 8:1 to about 1:1, about 7:1 to about 1:1, about 6:1 to about 1:1, about 5:1 to about 1:1, about 4:1 to about 1:1, about 3:1 to about 1:1, about 2:1 to about 1:1, about 16:1 to about 2:1, about 15:1 to about 2:1, about 14:1 to about 2:1, about 13:1 to about 2:1, about 12:1 to about 2:1, about 11:1 to about 2:1, about 10:1 to about 2:1, about 9:1 to about 2:1, about 8:1 to about 2:1, about 7:1 to about 2:1, about 6:1 to about 2:1, about 5:1 to about 2:1, about 4:1 to about 2:1, about 3:1 to about 2:1, about 16:1 to about 3:1, about 15:1 to about 3:1, about 14:1 to about 3:1, about 13:1 to about 3:1, about 12:1 to about 3:1, about 11:1 to about 3:1, about 10:1 to about 3:1, about 9:1 to about 3:1, about 8:1 to about 3:1, about 7:1 to about 3:1, about 6:1 to about 3:1, about 5:1 to about 3:1, about 4:1 to about 3:1, about 16:1 to about 4:1, about 15:1 to about 4:1, about 14:1 to about 4:1, about 13:1 to about 4:1, about 12:1 to about 4:1, about 11:1 to about 4:1, about 10:1 to about 4:1, about 9:1 to about 4:1, about 8:1 to about 4:1, about 7:1 to about 4:1, about 6:1 to about 4:1, about 5:1 to about 4:1, about 16:1 to about 5:1, about 15:1 to about 5:1, about 14:1 to about 5:1, about 13:1 to about 5:1, about 12:1 to about 5:1, about 11:1 to about 5:1, about 10:1 to about 5:1, about 9:1 to about 5:1, about 8:1 to

about 5:1, about 7:1 to about 5:1, about 6:1 to about 5:1, about 16:1 to about 6:1, about 15:1 to about 6:1, about 14:1 to about 6:1, about 13:1 to about 6:1, about 12:1 to about 6:1, about 11:1 to about 6:1, about 10:1 to about 6:1, about 9:1 to about 6:1, about 8:1 to about 6:1, about 7:1 to about 6:1, about 16:1 to about 7:1, about 15:1 to about 7:1, about 14:1 to about 7:1, about 13:1 to about 7:1, about 12:1 to about 7:1, about 11:1 to about 7:1, about 10:1 to about 7:1, about 9:1 to about 7:1, about 8:1 to about 7:1, about 16:1 to about 8:1, about 15:1 to about 8:1, about 14:1 to about 8:1, about 13:1 to about 8:1, about 12:1 to about 8:1, about 11:1 to about 8:1, about 10:1 to about 8:1, about 9:1 to about 8:1, about 16:1 to about 9:1, about 15:1 to about 9:1, about 14:1 to about 9:1, about 13:1 to about 9:1, about 12:1 to about 9:1, about 11:1 to about 9:1, about 10:1 to about 9:1, about 16:1 to about 10:1, about 15:1 to about 10:1, about 14:1 to about 10:1, about 13:1 to about 10:1, about 12:1 to about 10:1, about 11:1 to about 10:1, about 16:1 to about 11:1, about 15:1 to about 11:1, about 14:1 to about 11:1, about 13:1 to about 11:1, about 12:1 to about 11:1, about 16:1 to about 12:1, about 15:1 to about 12:1, about 14:1 to about 12:1, about 13:1 to about 12:1, about 16:1 to about 13:1, about 15:1 to about 13:1, about 14:1 to about 13:1, about 16:1 to about 14:1, about 15:1 to about 14:1, or about 16:1 to about 15:1. In a certain embodiment, a ratio of DIACID 1550 half ester to DIACID 1550 is about 16:1, about 15:1, about 14:1 about 13:1, about 12:1, about 11:1, about 10:1, about 9:1, about 8:1, about 7:1, about 6:1, about 5:1, about 4:1, about 3:1, about 2:1, about 8:7, or about 1:1.

[0086] In certain aspects, the partial esterification of DIACID 1550 can take place in the presence of one or more (i.e., a mixture) of alcohols, for example, at least two alcohols, at least three alcohols, or at least four alcohols. For example, the at least two alcohols can be selected from 2-ethyl-1-hexanol, 1-dodecanol, and n-pentanol. In an embodiment, the DIACID 1550 ester is a partially esterified DIACID 1550.

[0087] In certain embodiments, the lubricating composition, e.g., a lubricating fluid or metalworking fluid described herein comprises a counterion. In certain embodiments, the counterion is selected from the group consisting of sodium, potassium, ammonium, or triethanolamine (TEA).

[0088] In an embodiment, the description provides a semi-synthetic lubricating composition, e.g., a lubricating fluid or metalworking fluid. The semi-synthetic lubricating composition, e.g., a lubricating fluid or metalworking fluid can be optimized with a coupling solvent, e.g. tripropylene glycol methyl ether or diethylene glycol monobutyl ether. In

another embodiment of the present description, the composition is a synthetic lubricating composition, e.g., a lubricating fluid or metalworking fluid. The synthetic lubricating composition, e.g., a lubricating fluid or metalworking fluid can be optimized with a non-ionic surfactant, for example, an alkylphenol ethoxylate, a linear alcohol ethoxylate, or a DIACID 1550 ethoxylate.

[0089] In another aspect, the description discloses an aqueous lubricating composition, e.g., a lubricating fluid or metalworking fluid composition comprising a DIACID 1550 partial ester (e.g. a half ester). The DIACID 1550 partial ester can be derived from a reaction of an alcohol and DIACID 1550. In a particular embodiment, the alcohol is selected from the group consisting of n-pentanol, 1-doecanol, 2-ethyl-1-hexanol, and combinations thereof.

[0090] In an embodiment, the lubricating composition, e.g., a lubricating fluid or metalworking fluid is a semi-synthetic lubricating composition, e.g., a lubricating fluid or metalworking fluid and further includes a coupling solvent, for example tripropylene glycol methyl ether or diethylene glycol monobutyl ether.

[0091] In another embodiment, the lubricating composition, e.g., a lubricating fluid or metalworking fluid is a synthetic lubricating composition, e.g., a lubricating fluid or metalworking fluid and further includes a nonionic surfactant, for example, an alkylphenol ethoxylate, a linear alcohol ethoxylate, or a DIACID 1550 ethoxylate. Other exemplary non-ionic surfactants include, for example, include ethylene oxide adducts of alcohols, polyols, phenols, carboxylic acids and carboxylic acid esters such as ethylene oxide adducts of oleyl alcohol, nonyl phenol, glycerol, sorbitol, mannitol, pentaerythritol, sorbitan monolaurate, glycerol monooleate, pentaerythritol monostearate, oleic acid, stearic acid, and the like.

[0092] In certain embodiment, the lubricating composition, e.g., a lubricating fluid or metalworking fluid includes at least one of a biocide and a fungicide. In an embodiment, the biocide is at least one of CONTRAM™ 121, CONTRAM™ CB Metalworking Fluid System Cleaners, CONTRAM™ MBO, CONTRAM™ OF-G, CONTRAM™ ST-1, BIOBAN™ 1487, ROCIMA™ BT 2S, BIOBAN™ DB-20, SUMP BUDDY™ MWF, BIOBAN™ BP-30, KORDEK™ LX5000, UCARCIDE™ 50, UCARCIDE™ 25, DOWICIL™ 75, BIOBAN™ P-1487, DOWACIDE™ A, DOWICIDE™ 25L, KATHON™ 886 MW, DOWICIDE™ 1E. In an embodiment, the fungicide is at least one of Polyphase FX-40, BIOBAN™ IPBC-40, BIOBAN™ IPBC-40 L E, DOWICIDE™ 25L, DOWICIDE™ A, KATHON™ 893 MW,

KATHON™ 886 MW, DOWICIDE™ A, DOWICIDE™ 1E, BIOBAN™ P-1487, and Omicide™ fungicides (iodopropynyl butyl carbamate).

[0093] In certain aspects, the present disclosure relates to a method of lubricating a metal workpiece by applying the aqueous metalworking composition described herein.

[0094] In certain other aspects, the present disclosure relates to a metalworking process comprising performing a metalworking operation by flushing, spraying, high pressure spraying, brushing, flowing, fluting, roll coating, immersion, or any combination thereof with the aqueous metalworking composition described herein.

[0095] In an embodiment, the description provides a full synthetic formulation comprising a DIACID partial ester, including from about 1 to about 10% by weight of TEA, from about 5 to about 25% by weight of DIACID 1550 partial ester (e.g., 2-ethylhexanol, 1-dodecanol, or n-pentanol), from about 1 to about 10% by weight emulsifier (e.g. TOFA Alkanolamide), and optionally, from about 0.1 to about 5% by weight coupler (e.g. propylene glycol butyl ether). The DIACID half ester full synthetic formulation may further comprise from about 0.1 to about 10% by weight of a biocide (e.g. BIOBAN™ 1487) and/or from about 0.1 to about 10% by weight of a fungicide. In another embodiment, DIACID partial ester full synthetic formulation comprises from about 5 to about 8% by weight of TEA, from about 16 to about 20% by weight of DIACID 1550 partial ester (e.g., 2-ethylhexanol, 1-dodecanol, or n-pentanol), from about 4 to about 8% by weight emulsifier (e.g. TOFA Alkanolamide), and optionally, from about 0.1 to about 5% by weight coupler (e.g. propylene glycol butyl ether). The DIACID partial ester full synthetic formulation may further comprise from about 1 to about 7% by weight of a biocide (e.g. BIOBAN™ 1487) and/or from about 1 to about 7% by weight of a fungicide. In a particular embodiment, the DIACID half ester full synthetic formulation comprises about 6.6% by weight of TEA, about 18% by weight of DIACID 1550 partial ester (e.g., 2-ethylhexanol, 1-dodecanol, or n-pentanol), about 6.5% by weight emulsifier (e.g. TOFA Alkanolamide), and optionally, about 1.5% by weight coupler (e.g. DOWANOL™ PnB).

[0096] In another embodiment, the description provides semi-synthetic formulation comprising a DIACID partial ester, including from about 5 to about 50% by weight of oil (e.g. 100 SU naphthenic oil), from about 1 to about 10% by weight of DIACID 1550 partial ester (e.g., 2-ethylhexanol, 1-dodecanol, or n-pentanol), from about 0.1 to about 5% by weight of TEA, from about 5 to about 25% by weight of an emulsifier (e.g. TOFA

Alkanolamide), and optionally, from about 1 to about 10% by weight coupler (e.g. propylene glycol butyl ether). The DIACID partial ester semi-synthetic formulation may further comprise from about 1 to about 10% by weight of a second emulsifier (e.g. petroleum sulfonate). In an embodiment, the DIACID partial ester semi-synthetic formulation comprises from about 8 to about 20% by weight of oil (e.g. 100 SU naphthenic oil), from about 3 to about 8% by weight of DIACID 1550 partial ester (e.g., 2-ethylhexanol, 1-dodecanol, or n-pentanol), from about 0.75 to about 3.5% by weight of TEA, from about 10 to about 20% by weight of an emulsifier (e.g. TOFA Alkanolamide), and optionally, from about 2 to about 8% by weight coupler (e.g. propylene glycol butyl ether). The DIACID partial ester semi-synthetic formulation can further comprise from about 2 to about 8% by weight of a second emulsifier (e.g. petroleum sulfonate). The DIACID 1550 partial ester semi-synthetic formulation may comprise from about 0.1 to about 10% by weight of a biocide (e.g. BIOBAN™ 1487) and/or from about 0.1 to about 10% by weight of a fungicide. In a particular embodiment, the DIACID partial ester semi-synthetic formulation comprises about 10% by weight of oil (e.g. 100 SU naphthenic oil), about 5% by weight of DIACID 1550 partial ester (e.g., 2-ethylhexanol, 1-dodecanol, or n-pentanol), about 1.75% by weight of TEA, about 15% by weight of a first emulsifier (e.g. TOFA Alkanolamide), about 5% by weight of a second emulsifier (e.g. petroleum sulfonate), about 3% by weight of a biocide (e.g. BIOBAN™ 1487), and optionally, about 5% by weight coupler (e.g. DOWANOL™ PnB),.

[0097] In certain embodiments, the DIACID 1550 partial ester is present in a range of about 1% to about 25% by weight, about 1% to about 24% by weight, about 1% to about 23% by weight, about 1% to about 22% by weight, about 1% to about 21% by weight, about 1% to about 20% by weight, about 1% to about 19% by weight, about 1% to about 18% by weight, about 1% to about 17% by weight, about 1% to about 16% by weight, about 1% to about 15% by weight, about 1% to about 14% by weight, about 1% to about 13% by weight, about 1% to about 12% by weight, about 1% to about 11% by weight, about 1% to about 10% by weight, about 1% to about 9% by weight, about 1% to about 8% by weight, about 1% to about 7% by weight, about 1% to about 6% by weight, about 1% to about 5% by weight, about 1% to about 4% by weight, about 1% to about 3% by weight, about 1% to about 2% by weight, including all ranges in between. about 2% to about 25% by weight, about 2% to about 24% by weight, about 2% to about 23% by weight, about 2% to about 22% by weight, about 2% to

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by weight, about 6% to about 21% by weight, about 6% to about 20% by weight, about 6% to about 19% by weight, about 6% to about 18% by weight, about 6% to about 17% by weight, about 6% to about 16% by weight, about 6% to about 15% by weight, about 6% to about 14% by weight, about 6% to about 13% by weight, about 6% to about 12% by weight, about 6% to about 11% by weight, about 6% to about 10% by weight, about 6% to about 9% by weight, about 6% to about 8% by weight, about 6% to about 7% by weight, about 7% to about 25% by weight, about 7% to about 24% by weight, about 7% to about 23% by weight, about 7% to about 22% by weight, about 7% to about 21% by weight, about 7% to about 20% by weight, about 7% to about 19% by weight, about 7% to about 18% by weight, about 7% to about 17% by weight, about 7% to about 16% by weight, about 7% to about 15% by weight, about 7% to about 14% by weight, about 7% to about 13% by weight, about 7% to about 12% by weight, about 7% to about 11% by weight, about 7% to about 10% by weight, about 7% to about 9% by weight, about 7% to about 8% by weight, about 8% to about 25% by weight, about 8% to about 24% by weight, about 8% to about 23% by weight, about 8% to about 22% by weight, about 8% to about 21% by weight, about 8% to about 20% by weight, about 8% to about 19% by weight, about 8% to about 18% by weight, about 8% to about 17% by weight, about 8% to about 16% by weight, about 8% to about 15% by weight, about 8% to about 14% by weight, about 8% to about 13% by weight, about 8% to about 12% by weight, about 8% to about 11% by weight, about 8% to about 10% by weight, about 8% to about 9% by weight, about 9% to about 25% by weight, about 9% to about 24% by weight, about 9% to about 23% by weight, about 9% to about 22% by weight, about 9% to about 21% by weight, about 9% to about 20% by weight, about 9% to about 19% by weight, about 9% to about 18% by weight, about 9% to about 17% by weight, about 9% to about 16% by weight, about 9% to about 15% by weight, about 9% to about 14% by weight, about 9% to about 13% by weight, about 9% to about 12% by weight, about 9% to about 11% by weight, about 9% to about 10% by weight, about 10% to about 25% by weight, about 10% to about 24% by weight, about 10% to about 23% by weight, about 10% to about 22% by weight, about 10% to about 21% by weight, about 10% to about 20% by weight, about 10% to about 19% by weight, about 10% to about 18% by weight, about 10% to about 17% by weight, about 10% to about 16% by weight, about 10% to about 15% by weight, about 10% to about 14% by weight, about 10% to about 13% by weight, about 10% to about 12% by weight, about 10% to about 11% by weight, about 11% to about 25% by weight, about 11% to about 24% by weight, about 11% to about 23% by

[illegible]

weight, about 18% to about 19% by weight, about 19% to about 25% by weight, about 19% to about 24% by weight, about 19% to about 23% by weight, about 19% to about 22% by weight, about 19% to about 21% by weight, about 19% to about 20% by weight, about 20% to about 25% by weight, about 20% to about 24% by weight, about 20% to about 23% by weight, about 20% to about 22% by weight, about 20% to about 21% by weight, about 21% to about 25% by weight, about 21% to about 24% by weight, about 21% to about 23% by weight, about 21% to about 22% by weight, about 22% to about 25% by weight, about 22% to about 24% by weight, about 22% to about 23% by weight, about 23% to about 25% by weight, about 23% to about 24% by weight, or about 24% to about 25% by weight. In certain embodiments, DIACID 1550 partial ester is present in about 1% by weight, about 1.5% by weight, about 2% by weight, about 2.5% by weight, about 3% by weight, about 3.5% by weight, about 4% by weight, about 4.5% by weight, about 5% by weight, about 5.5% by weight, about 6% by weight, about 6.5% by weight, about 7% by weight, about 7.5% by weight, about 8% by weight, about 8.5% by weight, about 9% by weight, about 9.5% by weight, about 10% by weight, about 10.5% by weight, about 11% by weight, about 11.5% by weight, about 12% by weight, about 12.5% by weight, about 13% by weight, about 13.5% by weight, about 14% by weight, about 14.5% by weight, about 15% by weight, about 15.5% by weight, about 16% by weight, about 16.5% by weight, about 17% by weight, about 17.5% by weight, about 18% by weight, about 18.5% by weight, about 19% by weight, about 19.5% by weight, about 20% by weight, about 20.5% by weight, about 21% by weight, about 21.5% by weight, about 22% by weight, about 22.5% by weight, about 23% by weight, about 23.5% by weight, about 24% by weight, about 24.5% by weight, or about 25% by weight.

[0098] In additional embodiments, the base (e.g., TEA or potassium hydroxide) is present in a range of about 0.1% to about 10% by weight, about 0.1% to about 9.5% by weight, about 0.1% to about 9% by weight, about 0.1% to about 8.5% by weight, about 0.1% to about 8% by weight, about 0.1% to about 7.5% by weight, about 0.1% to about 7% by weight, about 0.1% to about 6.5% by weight, about 0.1% to about 6% by weight, about 0.1% to about 5.5% by weight, about 0.1% to about 5% by weight, about 0.1% to about 4.5% by weight, about 0.1% to about 4% by weight, about 0.1% to about 3.5% by weight, about 0.1% to about 3% by weight, about 0.1% to about 2.5% by weight, about 0.1% to about 2% by weight, about 0.1% to about 1.5% by weight, about 0.1% to about 1% by weight, about 0.1% to about 0.75% by weight, about 0.1% to about 0.5% by weight, about 0.1% to about 0.25%

by weight, about 0.5% to about 7% by weight, about 0.5% to about 6.5% by weight, about 0.5% to about 6% by weight, about 0.5% to about 5.5% by weight, about 0.5% to about 5% by weight, about 0.5% to about 4.5% by weight, about 0.5% to about 4% by weight, about 0.5% to about 3.5% by weight, about 0.5% to about 3% by weight, about 0.5% to about 2.5% by weight, about 0.5% to about 2% by weight, about 0.5% to about 1.5% by weight, about 0.5% to about 1% by weight, about 0.25% to about 10% by weight, about 0.25% to about 9.5% by weight, about 0.25% to about 9% by weight, about 0.25% to about 8.5% by weight, about 0.25% to about 8% by weight, about 0.25% to about 7.5% by weight, about 0.25% to about 7% by weight, about 0.25% to about 6.5% by weight, about 0.25% to about 6% by weight, about 0.25% to about 5.5% by weight, about 0.25% to about 5% by weight, about 0.25% to about 4.5% by weight, about 0.25% to about 4% by weight, about 0.25% to about 3.5% by weight, about 0.25% to about 3% by weight, about 0.25% to about 2.5% by weight, about 0.25% to about 2% by weight, about 0.25% to about 1.5% by weight, about 0.25% to about 1% by weight, about 0.25% to about 0.75% by weight, about 0.25% to about 0.5% by weight, about 0.5% to about 10% by weight, about 0.5% to about 9.5% by weight, about 0.5% to about 9% by weight, about 0.5% to about 8.5% by weight, about 0.5% to about 8% by weight, about 0.5% to about 7.5% by weight, about 0.5% to about 7% by weight, about 0.5% to about 6.5% by weight, about 0.5% to about 6% by weight, about 0.5% to about 5.5% by weight, about 0.5% to about 5% by weight, about 0.5% to about 4.5% by weight, about 0.5% to about 4% by weight, about 0.5% to about 3.5% by weight, about 0.5% to about 3% by weight, about 0.5% to about 2.5% by weight, about 0.5% to about 2% by weight, about 0.5% to about 1.5% by weight, about 0.5% to about 1% by weight, about 0.75% by weight, about 0.75% to about 10% by weight, about 0.75% to about 9.5% by weight, about 0.75% to about 9% by weight, about 0.75% to about 8.5% by weight, about 0.75% to about 8% by weight, about 0.75% to about 7.5% by weight, about 0.75% to about 7% by weight, about 0.75% to about 6.5% by weight, about 0.75% to about 6% by weight, about 0.75% to about 5.5% by weight, about 0.75% to about 5% by weight, about 0.75% to about 4.5% by weight, about 0.75% to about 4% by weight, about 0.75% to about 3.5% by weight, about 0.75% to about 3% by weight, about 0.75% to about 2.5% by weight, about 0.75% to about 2% by weight, about 0.75% to about 1.5% by weight, about 0.75% to about 1% by weight, about 1% to about 10% by weight, about 1% to about 9.5% by weight, about 1% to about 9% by weight, about 1% to about 8.5% by weight, about 1% to about 8% by

weight, about 1% to about 7.5% by weight, about 1% to about 7% by weight, about 1% to about 6.5% by weight, about 1% to about 6% by weight, about 1% to about 5.5% by weight, about 1% to about 5% by weight, about 1% to about 4.5% by weight, about 1% to about 4% by weight, about 1% to about 3.5% by weight, about 1% to about 3% by weight, about 1% to about 2.5% by weight, about 1% to about 2% by weight, about 1% to about 1.5% by weight, about 1.5% to about 10% by weight, about 1.5% to about 9.5% by weight, about 1.5% to about 9% by weight, about 1.5% to about 8.5% by weight, about 1.5% to about 8% by weight, about 1.5% to about 7.5% by weight, about 1.5% to about 7% by weight, about 1.5% to about 6.5% by weight, about 1.5% to about 6% by weight, about 1.5% to about 5.5% by weight, about 1.5% to about 5% by weight, about 1.5% to about 4.5% by weight, about 1.5% to about 4% by weight, about 1.5% to about 3.5% by weight, about 1.5% to about 3% by weight, about 1.5% to about 2.5% by weight, about 1.5% to about 2% by weight, about 2% to about 10% by weight, about 2% to about 9.5% by weight, about 2% to about 9% by weight, about 2% to about 8.5% by weight, about 2% to about 8% by weight, about 2% to about 7.5% by weight, about 2% to about 7% by weight, about 2% to about 6.5% by weight, about 2% to about 6% by weight, about 2% to about 5.5% by weight, about 2% to about 5% by weight, about 2% to about 4.5% by weight, about 2% to about 4% by weight, about 2% to about 3.5% by weight, about 2% to about 3% by weight, about 2% to about 2.5% by weight, about 2.5% to about 10% by weight, about 2.5% to about 9.5% by weight, about 2.5% to about 9% by weight, about 2.5% to about 8.5% by weight, about 2.5% to about 8% by weight, about 2.5% to about 7.5% by weight, about 2.5% to about 7% by weight, about 2.5% to about 6.5% by weight, about 2.5% to about 6% by weight, about 2.5% to about 5.5% by weight, about 2.5% to about 5% by weight, about 2.5% to about 4.5% by weight, about 2.5% to about 4% by weight, about 2.5% to about 3.5% by weight, about 2.5% to about 3% by weight, about 3% to about 10% by weight, about 3% to about 9.5% by weight, about 3% to about 9% by weight, about 3% to about 8.5% by weight, about 3% to about 8% by weight, about 3% to about 7.5% by weight, about 3% to about 7% by weight, about 3% to about 6.5% by weight, about 3% to about 6% by weight, about 3% to about 5.5% by weight, about 3% to about 5% by weight, about 3% to about 4.5% by weight, about 3% to about 4% by weight, about 3% to about 3.5% by weight, about 3.5% to about 7% by weight, about 3.5% to about 10% by weight, about 3.5% to about 9.5% by weight, about 3.5% to about 9% by weight, about 3.5% to about 8.5% by weight, about 3.5% to about 8% by weight, about 3.5% to about 7.5% by weight, about 3.5% to about

6.5% by weight, about 3.5% to about 6% by weight, about 3.5% to about 5.5% by weight, about 3.5% to about 5% by weight, about 3.5% to about 4.5% by weight, about 3.5% to about 4% by weight, about 4% to about 10% by weight, about 4% to about 9.5% by weight, about 4% to about 9% by weight, about 4% to about 8.5% by weight, about 4% to about 8% by weight, about 4% to about 7.5% by weight, about 4% to about 7% by weight, about 4% to about 6.5% by weight, about 4% to about 6% by weight, about 4% to about 5.5% by weight, about 4% to about 5% by weight, about 4% to about 4.5% by weight, about 4.5% to about 10% by weight, about 4.5% to about 9.5% by weight, about 4.5% to about 9% by weight, about 4.5% to about 8.5% by weight, about 4.5% to about 8% by weight, about 4.5% to about 7.5% by weight, about 4.5% to about 7% by weight, about 4.5% to about 6.5% by weight, about 4.5% to about 6% by weight, about 4.5% to about 5.5% by weight, about 4.5% to about 5% by weight, about 5% to about 10% by weight, about 5% to about 9.5% by weight, about 5% to about 9% by weight, about 5% to about 8.5% by weight, about 5% to about 8% by weight, about 5% to about 7.5% by weight, about 5% to about 7% by weight, about 5% to about 6.5% by weight, about 5% to about 6% by weight, about 5% to about 5.5% by weight, about 5.5% to about 10% by weight, about 5.5% to about 9.5% by weight, about 5.5% to about 9% by weight, about 5.5% to about 8.5% by weight, about 5.5% to about 8% by weight, about 5.5% to about 7.5% by weight, about 5.5% to about 7% by weight, about 5.5% to about 6.5% by weight, about 5.5% to about 6% by weight, about 6% to about 10% by weight, about 6% to about 9.5% by weight, about 6% to about 9% by weight, about 6% to about 8.5% by weight, about 6% to about 8% by weight, about 6% to about 7.5% by weight, about 6% to about 7% by weight, about 6% to about 6.5% by weight, about 6.5% to about 10% by weight, about 6.5% to about 9.5% by weight, about 6.5% to about 9% by weight, about 6.5% to about 8.5% by weight, about 6.5% to about 8% by weight, about 6.5% to about 7.5% by weight, about 6.5% to about 7% by weight, about 7% to about 10% by weight, about 7% to about 9.5% by weight, about 7% to about 9% by weight, about 7% to about 8.5% by weight, about 7% to about 8% by weight, about 7% to about 7.5% by weight, about 7.5% to about 10% by weight, about 7.5% to about 9.5% by weight, about 7.5% to about 9% by weight, about 7.5% to about 8.5% by weight, about 7.5% to about 8% by weight, about 8% to about 10% by weight, about 8% to about 9.5% by weight, about 8% to about 9% by weight, about 8% to about 8.5% by weight, about 9% to about 10% by weight, about 9% to about 9.5% by weight, or about 9.5% to about 10% by weight. In certain embodiments, TEA is present in about

0.1% by weight, about 0.25% by weight, about 0.5% by weight, about 0.75% by weight, about 1% by weight, about 1.5% by weight, about 2% by weight, about 2.5% by weight, about 3% by weight, about 3.5% by weight, about 4% by weight, about 4.5% by weight, about 5% by weight, about 5.5% by weight, about 6% by weight, about 7% by weight about 7.5% by weight, about 8% by weight, about 8.5% by weight, about 9% by weight, about 9.5% by weight, or about 10% by weight.

[0099] In certain embodiments, the emulsifier is present in a range of about 1% to about 25% by weight, about 1% to about 24% by weight, about 1% to about 23% by weight, about 1% to about 22% by weight, about 1% to about 21% by weight, about 1% to about 20% by weight, about 1% to about 19% by weight, about 1% to about 18% by weight, about 1% to about 17% by weight, about 1% to about 16% by weight, about 1% to about 15% by weight, about 1% to about 14% by weight, about 1% to about 13% by weight, about 1% to about 12% by weight, about 1% to about 11% by weight, about 1% to about 10% by weight, about 1% to about 9% by weight, about 1% to about 8% by weight, about 1% to about 7% by weight, about 1% to about 6% by weight, about 1% to about 5% by weight, about 1% to about 4% by weight, about 1% to about 3% by weight, about 1% to about 2% by weight, about 2% to about 25% by weight, about 2% to about 24% by weight, about 2% to about 23% by weight, about 2% to about 22% by weight, about 2% to about 21% by weight, about 2% to about 20% by weight, about 2% to about 19% by weight, about 2% to about 18% by weight, about 2% to about 17% by weight, about 2% to about 16% by weight, about 2% to about 15% by weight, about 2% to about 14% by weight, about 2% to about 13% by weight, about 2% to about 12% by weight, about 2% to about 11% by weight, about 2% to about 10% by weight, about 2% to about 9% by weight, about 2% to about 8% by weight, about 2% to about 7% by weight, about 2% to about 6% by weight, about 2% to about 5% by weight, about 2% to about 4% by weight, about 2% to about 3% by weight, about 3% to about 25% by weight, about 3% to about 24% by weight, about 3% to about 23% by weight, about 3% to about 22% by weight, about 3% to about 21% by weight, about 3% to about 20% by weight, about 3% to about 19% by weight, about 3% to about 18% by weight, about 3% to about 17% by weight, about 3% to about 16% by weight, about 3% to about 15% by weight, about 3% to about 14% by weight, about 3% to about 13% by weight, about 3% to about 12% by weight, about 3% to about 11% by weight, about 3% to about 10% by weight, about 3% to about 9% by weight, about 3% to about 8% by weight, about 3% to about 7% by weight, about 3% to about 6% by weight,

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about 14% to about 25% by weight, about 14% to about 24% by weight, about 14% to about 23% by weight, about 14% to about 22% by weight, about 14% to about 21% by weight, about 14% to about 20% by weight, about 14% to about 19% by weight, about 14% to about 18% by weight, about 14% to about 17% by weight, about 14% to about 16% by weight, about 14% to about 15% by weight, about 15% to about 25% by weight, about 15% to about 24% by weight, about 15% to about 23% by weight, about 15% to about 22% by weight, about 15% to about 21% by weight, about 15% to about 20% by weight, about 15% to about 19% by weight, about 15% to about 18% by weight, about 15% to about 17% by weight, about 15% to about 16% by weight, about 16% to about 25% by weight, about 16% to about 24% by weight, about 16% to about 23% by weight, about 16% to about 22% by weight, about 16% to about 21% by weight, about 16% to about 20% by weight, about 16% to about 19% by weight, about 16% to about 18% by weight, about 16% to about 17% by weight, about 17% to about 25% by weight, about 17% to about 24% by weight, about 17% to about 23% by weight, about 17% to about 22% by weight, about 17% to about 21% by weight, about 17% to about 20% by weight, about 17% to about 19% by weight, about 17% to about 18% by weight, about 18% to about 25% by weight, about 18% to about 24% by weight, about 18% to about 23% by weight, about 18% to about 22% by weight, about 18% to about 21% by weight, about 18% to about 20% by weight, about 18% to about 19% by weight, about 19% to about 25% by weight, about 19% to about 24% by weight, about 19% to about 23% by weight, about 19% to about 22% by weight, about 19% to about 21% by weight, about 19% to about 20% by weight, about 20% to about 25% by weight, about 20% to about 24% by weight, about 20% to about 23% by weight, about 20% to about 22% by weight, about 20% to about 21% by weight, about 21% to about 25% by weight, about 21% to about 24% by weight, about 21% to about 23% by weight, about 21% to about 22% by weight, about 22% to about 25% by weight, about 22% to about 24% by weight, about 22% to about 23% by weight, about 23% to about 25% by weight, about 23% to about 24% by weight, or about 24% to about 25% by weight. In certain embodiments, the emulsifier is present in about 1% by weight, about 1.5% by weight, about 2% by weight, about 2.5% by weight, about 3% by weight, about 3.5% by weight, about 4% by weight, about 4.5% by weight, about 5% by weight, about 5.5% by weight, about 6% by weight, about 6.5% by weight, about 7% by weight, about 7.5% by weight, about 8% by weight, about 8.5% by weight, about 9% by weight, about 9.5% by weight, about 10% by weight, about 10.5% by weight,

about 11% by weight, about 11.5% by weight, about 12% by weight, about 12.5% by weight, about 13% by weight, about 13.5% by weight, about 14% by weight, about 14.5% by weight, about 15% by weight, about 15.5% by weight, about 16% by weight, about 16.5% by weight, about 17% by weight, about 17.5% by weight, about 18% by weight, about 18.5% by weight, about 19% by weight, about 19.5% by weight, about 20% by weight, about 20.5% by weight, about 21% by weight, about 21.5% by weight, about 22% by weight, about 22.5% by weight, about 23% by weight, about 23.5% by weight, about 24% by weight, about 24.5% by weight, or about 25% by weight.

[00100] In additional embodiments, the oil is present in a range of about 1% to about 50% by weight, about 1% to about 49% by weight, about 1% to about 48% by weight, about 1% to about 47% by weight, about 1% to about 46% by weight, about 1% to about 45% by weight, about 1% to about 44% by weight, about 1% to about 43% by weight, about 1% to about 42% by weight, about 1% to about 41% by weight, about 1% to about 40% by weight, about 1% to about 39% by weight, about 1% to about 38% by weight, about 1% to about 37% by weight, about 1% to about 36% by weight, about 1% to about 35% by weight, about 1% to about 34% by weight, about 1% to about 33% by weight, about 1% to about 32% by weight, about 1% to about 31% by weight, about 1% to about 30% by weight, about 1% to about 29% by weight, about 1% to about 28% by weight, about 1% to about 27% by weight, about 1% to about 26% by weight, about 1% to about 25% by weight, about 1% to about 24% by weight, about 1% to about 23% by weight, about 1% to about 22% by weight, about 1% to about 21% by weight, about 1% to about 20% by weight, about 1% to about 19% by weight, about 1% to about 18% by weight, about 1% to about 17% by weight, about 1% to about 16% by weight, about 1% to about 15% by weight, about 1% to about 14% by weight, about 1% to about 13% by weight, about 1% to about 12% by weight, about 1% to about 11% by weight, about 1% to about 10% by weight, about 1% to about 9% by weight, about 1% to about 8% by weight, about 1% to about 7% by weight, about 1% to about 6% by weight, about 1% to about 5% by weight, about 1% to about 4% by weight, about 1% to about 3% by weight, about 1% to about 2% by weight, about 2% to about 50% by weight, about 2% to about 49% by weight, about 2% to about 48% by weight, about 2% to about 47% by weight, about 2% to about 46% by weight, about 2% to about 45% by weight, about 2% to about 44% by weight, about 2% to about 43% by weight, about 2% to about 42% by weight, about 2% to about 41% by weight, about 2% to about 40% by weight, about 2% to about 39% by weight, about 2% to about 38%

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weight, about 43% to about 44% by weight, about 44% to about 50% by weight, about 44% to about 49% by weight, about 44% to about 48% by weight, about 44% to about 47% by weight, about 44% to about 46% by weight, about 44% to about 45% by weight, about 45% to about 50% by weight, about 45% to about 49% by weight, about 45% to about 48% by weight, about 45% to about 47% by weight, about 45% to about 46% by weight, about 46% to about 50% by weight, about 46% to about 49% by weight, about 46% to about 48% by weight, about 46% to about 47% by weight, about 47% to about 50% by weight, about 47% to about 49% by weight, about 47% to about 48% by weight, about 48% to about 50% by weight, about 48% to about 49% by weight, or about 49% to about 50% by weight,. In certain embodiments, the oil is present in about 5% by weight, about 5.5% by weight, about 6% by weight, about 6.5% by weight, about 7% by weight, about 7.5% by weight, about 8% by weight, about 8.5% by weight, about 9% by weight, about 9.5% by weight, about 10% by weight, about 10.5% by weight, about 11% by weight, about 11.5% by weight, about 12% by weight, about 12.5% by weight, about 13% by weight, about 13.5% by weight, about 14% by weight, about 14.5% by weight, about 15% by weight, about 15.5% by weight, about 16% by weight, about 16.5% by weight, about 17% by weight, about 17.5% by weight, about 18% by weight, about 18.5% by weight, about 19% by weight, about 19.5% by weight, about 20% by weight, about 20.5% by weight, about 21% by weight, about 21.5% by weight, about 22% by weight, about 22.5% by weight, about 23% by weight, about 23.5% by weight, about 24% by weight, about 24.5% by weight, about 25% by weight, about 25.5% by weight, about 26% by weight, about 26.5% by weight, about 27% by weight, about 27.5% by weight, about 28% by weight, about 28.5% by weight, about 29% by weight, about 29.5% by weight, about 30% by weight, about 30.5% by weight, about 31% by weight, about 31.5% by weight, about 32% by weight, about 32.5% by weight, about 33% by weight, about 33.5% by weight, about 34% by weight, about 34.5% by weight, about 35% by weight, about 35.5% by weight, about 36% by weight, about 36.5% by weight, about 37% by weight, about 37.5% by weight, about 38% by weight, about 38.5% by weight, about 39% by weight, about 39.5% by weight, about 40% by weight, about 40.5% by weight, about 41% by weight, about 41.5% by weight, about 42% by weight, about 42.5% by weight, about 43% by weight, about 43.5% by weight, about 44% by weight, about 44.5% by weight, about 45% by weight, about 45.5% by weight, about 46% by weight, about 46.5% by weight, about 47% by weight, about 47.5% by weight, about 48% by

weight, about 48.5% by weight, about 49% by weight, about 49.5% by weight, or about 50% by weight.

[00101] In certain embodiments, the coupling solvent is present in a range of about 0.1% to about 10% by weight, about 0.1% to about 9.5% by weight, about 0.1% to about 9% by weight, about 0.1% to about 8.5% by weight, about 0.1% to about 8% by weight, about 0.1% to about 7.5% by weight, about 0.1% to about 7% by weight, about 0.1% to about 6.5% by weight, about 0.1% to about 6% by weight, about 0.1% to about 5.5% by weight, about 0.1% to about 5% by weight, about 0.1% to about 4.5% by weight, about 0.1% to about 4% by weight, about 0.1% to about 3.5% by weight, about 0.1% to about 3% by weight, about 0.1% to about 2.5% by weight, about 0.1% to about 2% by weight, about 0.1% to about 1.5% by weight, about 0.1% to about 1% by weight, about 0.1% to about 0.75% by weight, about 0.1% to about 0.5% by weight, about 0.1% to about 0.25% by weight, about 0.25% to about 10% by weight, about 0.25% to about 9.5% by weight, about 0.25% to about 9% by weight, about 0.25% to about 8.5% by weight, about 0.25% to about 8% by weight, about 0.25% to about 7.5% by weight, about 0.25% to about 7% by weight, about 0.25% to about 6.5% by weight, about 0.25% to about 6% by weight, about 0.25% to about 5.5% by weight, about 0.25% to about 5% by weight, about 0.25% to about 4.5% by weight, about 0.25% to about 4% by weight, about 0.25% to about 3.5% by weight, about 0.25% to about 3% by weight, about 0.25% to about 2.5% by weight, about 0.25% to about 2% by weight, about 0.25% to about 1.5% by weight, about 0.25% to about 1% by weight, about 0.25% to about 0.75% by weight, about 0.25% to about 0.5% by weight, about 0.5% to about 10% by weight, about 0.5% to about 9.5% by weight, about 0.5% to about 9% by weight, about 0.5% to about 8.5% by weight, about 0.5% to about 8% by weight, about 0.5 to about 7.5% by weight, about 0.5% to about 7% by weight, about 0.5% to about 6.5% by weight, about 0.5% to about 6% by weight, about 0.5% to about 5.5% by weight, about 0.5% to about 5% by weight, about 0.5% to about 4.5% by weight, about 0.5% to about 4% by weight, about 0.5% to about 3.5% by weight, about 0.5% to about 3% by weight, about 0.5% to about 2.5% by weight, about 0.5% to about 2% by weight, about 0.5% to about 1.5% by weight, about 0.5% to about 1% by weight, about 0.75% to about 10% by weight, about 0.75% to about 9.5% by weight, about 0.75% to about 9% by weight, about 0.75% to about 8.5% by weight, about 0.75% to about 8% by weight, about 0.75 to about 7.5% by weight, about 0.75% to about 7% by weight, about 0.75% to about 6.5% by weight, about 0.75% to about 6% by weight, about 0.75% to

about 5.5% by weight, about 0.75% to about 5% by weight, about 0.75% to about 4.5% by weight, about 0.75% to about 4% by weight, about 0.75% to about 3.75% by weight, about 0.75% to about 3% by weight, about 0.75% to about 2.5% by weight, about 0.75% to about 2% by weight, about 0.75% to about 1.5% by weight, about 0.75% to about 1% by weight, about 1% to about 10% by weight, about 1% to about 9.5% by weight, about 1% to about 9% by weight, about 1% to about 8.5% by weight, about 1% to about 8% by weight, about 1% to about 7.5% by weight, about 1% to about 7% by weight, about 1% to about 6.5% by weight, about 1% to about 6% by weight, about 1% to about 5.5% by weight, about 1% to about 5% by weight, about 1% to about 4.5% by weight, about 1% to about 4% by weight, about 1% to about 3.5% by weight, about 1% to about 3% by weight, about 1% to about 2.5% by weight, about 1% to about 2% by weight, about 1% to about 1.5% by weight, about 1.5% to about 10% by weight, about 1.5% to about 9.5% by weight, about 1.5% to about 9% by weight, about 1.5% to about 8.5% by weight, about 1.5% to about 8% by weight, about 1.5% to about 7.5% by weight, about 1.5% to about 7% by weight, about 1.5% to about 6.5% by weight, about 1.5% to about 6% by weight, about 1.5% to about 5.5% by weight, about 1.5% to about 5% by weight, about 1.5% to about 4.5% by weight, about 1.5% to about 4% by weight, about 1.5% to about 3.5% by weight, about 1.5% to about 3% by weight, about 1.5% to about 2.5% by weight, about 1.5% to about 2% by weight, about 2% to about 10% by weight, about 2% to about 9.5% by weight, about 2% to about 9% by weight, about 2% to about 8.5% by weight, about 2% to about 8% by weight, about 2% to about 7.5% by weight, about 2% to about 7% by weight, about 2% to about 6.5% by weight, about 2% to about 6% by weight, about 2% to about 5.5% by weight, about 2% to about 5% by weight, about 2% to about 4.5% by weight, about 2% to about 4% by weight, about 2% to about 3.5% by weight, about 2% to about 3% by weight, about 2% to about 2.5% by weight, about 2.5% to about 10% by weight, about 2.5% to about 9.5% by weight, about 2.5% to about 9% by weight, about 2.5% to about 8.5% by weight, about 2.5% to about 8% by weight, about 2.5% to about 7.5% by weight, about 2.5% to about 7% by weight, about 2.5% to about 6.5% by weight, about 2.5% to about 6% by weight, about 2.5% to about 5.5% by weight, about 2.5% to about 5% by weight, about 2.5% to about 4.5% by weight, about 2.5% to about 4% by weight, about 2.5% to about 3.5% by weight, about 2.5% to about 3% by weight, about 3% to about 10% by weight, about 3% to about 9.5% by weight, about 3% to about 9% by weight, about 3% to about 8.5% by weight, about 3% to about 8% by weight, about 3% to about 7.5% by weight, about 3% to

about 8% by weight, about 3% to about 7% by weight, about 3% to about 6.5% by weight, about 3% to about 6% by weight, about 3% to about 5.5% by weight, about 3% to about 5% by weight, about 3% to about 4.5% by weight, about 3% to about 4% by weight, about 3% to about 3.5% by weight, about 3.5% to about 10% by weight, about 3.5% to about 9.5% by weight, about 3.5% to about 9% by weight, about 3.5% to about 8.5% by weight, about 3.5% to about 8% by weight, about 3.5% to about 7.5% by weight, about 3.5% to about 7% by weight, about 3.5% to about 6.5% by weight, about 3.5% to about 6% by weight, about 3.5% to about 5.5% by weight, about 3.5% to about 5% by weight, about 3.5% to about 4.5% by weight, about 3.5% to about 4% by weight, about 4% to about 10% by weight, about 4% to about 9.5% by weight, about 4% to about 9% by weight, about 4% to about 8.5% by weight, about 4% to about 8% by weight, about 4% to about 7.5% by weight, about 4% to about 7% by weight, about 4% to about 6.5% by weight, about 4% to about 6% by weight, about 4% to about 5.5% by weight, about 4% to about 5% by weight, about 4% to about 4.5% by weight, about 4.5% to about 10% by weight, about 4.5% to about 9.5% by weight, about 4.5% to about 9% by weight, about 4.5% to about 8.5% by weight, about 4.5% to about 8% by weight, about 4.5% to about 7.5% by weight, about 4.5% to about 7% by weight, about 4.5% to about 6.5% by weight, about 4.5% to about 6% by weight, about 4.5% to about 5.5% by weight, about 4.5% to about 5% by weight, about 5% to about 10% by weight, about 5% to about 9.5% by weight, about 5% to about 9% by weight, about 5% to about 8.5% by weight, about 5% to about 8% by weight, about 5% to about 7.5% by weight, about 5% to about 7% by weight, about 5% to about 6.5% by weight, about 5% to about 6% by weight, about 5% to about 5.5% by weight, about 5.5% to about 10% by weight, about 5.5% to about 9.5% by weight, about 5.5% to about 9% by weight, about 5.5% to about 8.5% by weight, about 5.5% to about 8% by weight, about 5.5% to about 7.5% by weight, about 5.5% to about 7% by weight, about 5.5% to about 6.5% by weight, about 5.5% to about 6% by weight, about 6% to about 10% by weight, about 6% to about 9.5% by weight, about 6% to about 9% by weight, about 6% to about 8.5% by weight, about 6% to about 8% by weight, about 6% to about 7.5% by weight, about 6% to about 7% by weight, about 6% to about 6.5% by weight, about 6.5% to about 10% by weight, about 6.5% to about 9.5% by weight, about 6.5% to about 9% by weight, about 6.5% to about 8.5% by weight, about 6.5% to about 8% by weight, about 6.5% to about 7.5% by weight, about 6.5% to about 7% by weight, about 7% to about 10% by weight, about 7% to about 9.5% by weight, about 7% to about 9% by weight, about 7% to

about 8.5% by weight, about 7% to about 8% by weight, about 7% to about 7.5% by weight, about 7.5% to about 10% by weight, about 7.5% to about 9.5% by weight, about 7.5% to about 9% by weight, about 7.5% to about 8.5% by weight, about 7.5% to about 8% by weight, about 8% to about 10% by weight, about 8% to about 9.5% by weight, about 8% to about 9% by weight, about 8% to about 8.5% by weight, about 8.5% to about 10% by weight, about 8.5% to about 9.5% by weight, about 8.5% to about 9% by weight, about 9% to about 10% by weight, about 9% to about 9.5% by weight, or about 9.5% to about 10% by weight. In certain embodiments, the coupling solvent is present in about 0.1% by weight, about 0.25% by weight, about 0.5% by weight, about 0.75% by weight, about 1% by weight, about 1.5% by weight, about 2% by weight, about 2.5% by weight, about 3% by weight, about 3.5% by weight, about 4% by weight, about 4.5% by weight, about 5% by weight, about 5.5% by weight, about 6% by weight, about 7% by weight, about 7.5% by weight, about 8% by weight, about 8.5% by weight, about 9% by weight, about 9.5% by weight, or about 10% by weight.

[00102] In certain embodiments, a second emulsifier is present in a range of about 1% to about 10% by weight, about 1% to about 9.5% by weight, about 1% to about 9% by weight, about 1% to about 8.5% by weight, about 1% to about 8% by weight, about 1% to about 7.5% by weight, about 1% to about 7% by weight, about 1% to about 6.5% by weight, about 1% to about 6% by weight, about 1% to about 5.5% by weight, about 1% to about 5% by weight, about 1% to about 4.5% by weight, about 1% to about 4% by weight, about 1% to about 3.5% by weight, about 1% to about 3% by weight, about 1% to about 2.5% by weight, about 1% to about 2% by weight, about 1% to about 1.5% by weight, about 1.5% to about 10% by weight, about 1.5% to about 9.5% by weight, about 1.5% to about 9% by weight, about 1.5% to about 8.5% by weight, about 1.5% to about 8% by weight, about 1.5% to about 7.5% by weight, about 1.5% to about 7% by weight, about 1.5% to about 6.5% by weight, about 1.5% to about 6% by weight, about 1.5% to about 5.5% by weight, about 1.5% to about 5% by weight, about 1.5% to about 4.5% by weight, about 1.5% to about 4% by weight, about 1.5% to about 3.5% by weight, about 1.5% to about 3% by weight, about 1.5% to about 2.5% by weight, about 1.5% to about 2% by weight, about 2% to about 10% by weight, about 2% to about 9.5% by weight, about 2% to about 9% by weight, about 2% to about 8.5% by weight, about 2% to about 8% by weight, about 2% to about 7.5% by weight, about 2% to about 7% by weight, about 2% to about 6.5% by weight, about 2% to about 6% by weight,

about 2% to about 5.5% by weight, about 2% to about 5% by weight, about 2% to about 4.5% by weight, about 2% to about 4% by weight, about 2% to about 3.5% by weight, about 2% to about 3% by weight, about 2% to about 2.5% by weight, about 2.5% to about 10% by weight, about 2.5% to about 9.5% by weight, about 2.5% to about 9% by weight, about 2.5% to about 8.5% by weight, about 2.5% to about 8% by weight, about 2.5 to about 7.5% by weight, about 2.5% to about 7% by weight, about 2.5% to about 6.5% by weight, about 2.5% to about 6% by weight, about 2.5% to about 5.5% by weight, about 2.5% to about 5% by weight, about 2.5% to about 4.5% by weight, about 2.5% to about 4% by weight, about 2.5% to about 3.5% by weight, about 2.5% to about 3% by weight, about 3% to about 10% by weight, about 3% to about 9.5% by weight, about 3% to about 9% by weight, about 3% to about 8.5% by weight, about 3% to about 8% by weight, about 3% to about 7.5% by weight, about 3% to about 8% by weight, about 3% to about 7% by weight, about 3% to about 6.5% by weight, about 3% to about 6% by weight, about 3% to about 5.5% by weight, about 3% to about 5% by weight, about 3% to about 4.5% by weight, about 3% to about 4% by weight, about 3% to about 3.5% by weight, about 3.5% to about 10% by weight, about 3.5% to about 9.5% by weight, about 3.5% to about 9% by weight, about 3.5% to about 8.5% by weight, about 3.5% to about 8% by weight, about 3.5% to about 7.5% by weight, about 3.5% to about 7% by weight, about 3.5% to about 6.5% by weight, about 3.5% to about 6% by weight, about 3.5% to about 5.5% by weight, about 3.5% to about 5% by weight, about 3.5% to about 4.5% by weight, about 3.5% to about 4% by weight, about 4% to about 10% by weight, about 4% to about 9.5% by weight, about 4% to about 9% by weight, about 4% to about 8.5% by weight, about 4% to about 8% by weight, about 4% to about 7.5% by weight, about 4% to about 7% by weight, about 4% to about 6.5% by weight, about 4% to about 6% by weight, about 4% to about 5.5% by weight, about 4% to about 5% by weight, about 4% to about 4.5% by weight, about 4.5% to about 10% by weight, about 4.5% to about 9.5% by weight, about 4.5% to about 9% by weight, about 4.5% to about 8.5% by weight, about 4.5% to about 8% by weight, about 4.5% to about 7.5% by weight, about 4.5% to about 7% by weight, about 4.5% to about 6.5% by weight, about 4.5% to about 6% by weight, about 4.5% to about 5.5% by weight, about 4.5% to about 5% by weight, about 5% to about 10% by weight, about 5% to about 9.5% by weight, about 5% to about 9% by weight, about 5% to about 8.5% by weight, about 5% to about 8% by weight, about 5% to about 7.5% by weight, about 5% to about 7% by weight, about 5% to about 6.5% by weight, about 5% to about 6% by weight, about 5% to

about 5.5% by weight, about 5.5% to about 10% by weight, about 5.5% to about 9.5% by weight, about 5.5% to about 9% by weight, about 5.5% to about 8.5% by weight, about 5.5% to about 8% by weight, about 5.5% to about 7.5% by weight, about 5.5% to about 7% by weight, about 5.5% to about 6.5% by weight, about 5.5% to about 6% by weight, about 6% to about 10% by weight, about 6% to about 9.5% by weight, about 6% to about 9% by weight, about 6% to about 8.5% by weight, about 6% to about 8% by weight, about 6% to about 7.5% by weight, about 6% to about 7% by weight, about 6% to about 6.5% by weight, about 6.5% to about 10% by weight, about 6.5% to about 9.5% by weight, about 6.5% to about 9% by weight, about 6.5% to about 8.5% by weight, about 6.5% to about 8% by weight, about 6.5% to about 7.5% by weight, about 6.5% to about 7% by weight, about 7% to about 10% by weight, about 7% to about 9.5% by weight, about 7% to about 9% by weight, about 7% to about 8.5% by weight, about 7% to about 8% by weight, about 7% to about 7.5% by weight, about 7.5% to about 10% by weight, about 7.5% to about 9.5% by weight, about 7.5% to about 9% by weight, about 7.5% to about 8.5% by weight, about 7.5% to about 8% by weight, about 8% to about 10% by weight, about 8% to about 9.5% by weight, about 8% to about 9% by weight, about 8% to about 8.5% by weight, about 8.5% to about 10% by weight, about 8.5% to about 9.5% by weight, about 8.5% to about 9% by weight, about 9% to about 10% by weight, about 9% to about 9.5% by weight, or about 9.5% to about 10% by weight. In certain embodiments, the second emulsifier is present in about 1% by weight, about 1.5% by weight, about 2% by weight, about 2.5% by weight, about 3% by weight, about 3.5% by weight, about 4% by weight, about 4.5% by weight, about 5% by weight, about 5.5% by weight, about 6% by weight, about 7% by weight, about 7.5% by weight, about 8% by weight, about 8.5% by weight, about 9% by weight, about 9.5% by weight, or about 10% by weight.

[00103] In certain embodiments, the biocide is present in a range of about 0.1% to about 10% by weight, about 0.1% to about 9.5% by weight, about 0.1% to about 9% by weight, about 0.1% to about 8.5% by weight, about 0.1% to about 8% by weight, about 0.1% to about 7.5% by weight, about 0.1% to about 7% by weight, about 0.1% to about 6.5% by weight, about 0.1% to about 6% by weight, about 0.1% to about 5.5% by weight, about 0.1% to about 5% by weight, about 0.1% to about 4.5% by weight, about 0.1% to about 4% by weight, about 0.1% to about 3.5% by weight, about 0.1% to about 3% by weight, about 0.1% to about 2.5% by weight, about 0.1% to about 2% by weight, about 0.1% to about 1.5% by weight, about 0.1% to about 1% by weight, about 0.1% to about 0.75% by weight, about

0.1% to about 0.5% by weight, about 0.1% to about 0.25% by weight, about 0.25% to about 10% by weight, about 0.25% to about 9.5% by weight, about 0.25% to about 9% by weight, about 0.25% to about 8.5% by weight, about 0.25% to about 8% by weight, about 0.25% to about 7.5% by weight, about 0.25% to about 7% by weight, about 0.25% to about 6.5% by weight, about 0.25% to about 6% by weight, about 0.25% to about 5.5% by weight, about 0.25% to about 5% by weight, about 0.25% to about 4.5% by weight, about 0.25% to about 4% by weight, about 0.25% to about 3.5% by weight, about 0.25% to about 3% by weight, about 0.25% to about 2.5% by weight, about 0.25% to about 2% by weight, about 0.25% to about 1.5% by weight, about 0.25% to about 1% by weight, about 0.25% to about 0.75% by weight, about 0.25% to about 0.5% by weight, about 0.5% to about 10% by weight, about 0.5% to about 9.5% by weight, about 0.5% to about 9% by weight, about 0.5% to about 8.5% by weight, about 0.5% to about 8% by weight, about 0.5% to about 7.5% by weight, about 0.5% to about 7% by weight, about 0.5% to about 6.5% by weight, about 0.5% to about 6% by weight, about 0.5% to about 5.5% by weight, about 0.5% to about 5% by weight, about 0.5% to about 4.5% by weight, about 0.5% to about 4% by weight, about 0.5% to about 3.5% by weight, about 0.5% to about 3% by weight, about 0.5% to about 2.5% by weight, about 0.5% to about 2% by weight, about 0.5% to about 1.5% by weight, about 0.5% to about 1% by weight, about 0.75% to about 10% by weight, about 0.75% to about 9.5% by weight, about 0.75% to about 9% by weight, about 0.75% to about 8.5% by weight, about 0.75% to about 8% by weight, about 0.75% to about 7.5% by weight, about 0.75% to about 7% by weight, about 0.75% to about 6.5% by weight, about 0.75% to about 6% by weight, about 0.75% to about 5.5% by weight, about 0.75% to about 5% by weight, about 0.75% to about 4.5% by weight, about 0.75% to about 4% by weight, about 0.75% to about 3.75% by weight, about 0.75% to about 3% by weight, about 0.75% to about 2.5% by weight, about 0.75% to about 2% by weight, about 0.75% to about 1.5% by weight, about 0.75% to about 1% by weight, about 1% to about 10% by weight, about 1% to about 9.5% by weight, about 1% to about 9% by weight, about 1% to about 8.5% by weight, about 1% to about 8% by weight, about 1% to about 7.5% by weight, about 1% to about 7% by weight, about 1% to about 6.5% by weight, about 1% to about 6% by weight, about 1% to about 5.5% by weight, about 1% to about 5% by weight, about 1% to about 4.5% by weight, about 1% to about 4% by weight, about 1% to about 3.5% by weight, about 1% to about 3% by weight, about 1% to about 2.5% by weight, about 1% to about 2% by weight, about 1% to about 1.5% by weight, about 1.5% to about

10% by weight, about 1.5% to about 9.5% by weight, about 1.5% to about 9% by weight, about 1.5% to about 8.5% by weight, about 1.5% to about 8% by weight, about 1.5 to about 7.5% by weight, about 1.5% to about 7% by weight, about 1.5% to about 6.5% by weight, about 1.5% to about 6% by weight, about 1.5% to about 5.5% by weight, about 1.5% to about 5% by weight, about 1.5% to about 4.5% by weight, about 1.5% to about 4% by weight, about 1.5% to about 3.5% by weight, about 1.5% to about 3% by weight, about 1.5% to about 2.5% by weight, about 1.5% to about 2% by weight, about 2% to about 10% by weight, about 2% to about 9.5% by weight, about 2% to about 9% by weight, about 2% to about 8.5% by weight, about 2% to about 8% by weight, about 2% to about 7.5% by weight, about 2% to about 7% by weight, about 2% to about 6.5% by weight, about 2% to about 6% by weight, about 2% to about 5.5% by weight, about 2% to about 5% by weight, about 2% to about 4.5% by weight, about 2% to about 4% by weight, about 2% to about 3.5% by weight, about 2% to about 3% by weight, about 2% to about 2.5% by weight, about 2.5% to about 10% by weight, about 2.5% to about 9.5% by weight, about 2.5% to about 9% by weight, about 2.5% to about 8.5% by weight, about 2.5% to about 8% by weight, about 2.5 to about 7.5% by weight, about 2.5% to about 7% by weight, about 2.5% to about 6.5% by weight, about 2.5% to about 6% by weight, about 2.5% to about 5.5% by weight, about 2.5% to about 5% by weight, about 2.5% to about 4.5% by weight, about 2.5% to about 4% by weight, about 2.5% to about 3.5% by weight, about 2.5% to about 3% by weight, about 3% to about 10% by weight, about 3% to about 9.5% by weight, about 3% to about 9% by weight, about 3% to about 8.5% by weight, about 3% to about 8% by weight, about 3% to about 7.5% by weight, about 3% to about 7% by weight, about 3% to about 6.5% by weight, about 3% to about 6% by weight, about 3% to about 5.5% by weight, about 3% to about 5% by weight, about 3% to about 4.5% by weight, about 3% to about 4% by weight, about 3% to about 3.5% by weight, about 3.5% to about 10% by weight, about 3.5% to about 9.5% by weight, about 3.5% to about 9% by weight, about 3.5% to about 8.5% by weight, about 3.5% to about 8% by weight, about 3.5% to about 7.5% by weight, about 3.5% to about 7% by weight, about 3.5% to about 6.5% by weight, about 3.5% to about 6% by weight, about 3.5% to about 5.5% by weight, about 3.5% to about 5% by weight, about 3.5% to about 4.5% by weight, about 3.5% to about 4% by weight, about 4% to about 10% by weight, about 4% to about 9.5% by weight, about 4% to about 9% by weight, about 4% to about 8.5% by weight, about 4% to about 8% by weight, about 4% to about 7.5% by weight, about 4% to about 7%

by weight, about 4% to about 6.5% by weight, about 4% to about 6% by weight, about 4% to about 5.5% by weight, about 4% to about 5% by weight, about 4% to about 4.5% by weight, about 4.5% to about 10% by weight, about 4.5% to about 9.5% by weight, about 4.5% to about 9% by weight, about 4.5% to about 8.5% by weight, about 4.5% to about 8% by weight, about 4.5% to about 7.5% by weight, about 4.5% to about 7% by weight, about 4.5% to about 6.5% by weight, about 4.5% to about 6% by weight, about 4.5% to about 5.5% by weight, about 4.5% to about 5% by weight, about 5% to about 10% by weight, about 5% to about 9.5% by weight, about 5% to about 9% by weight, about 5% to about 8.5% by weight, about 5% to about 8% by weight, about 5% to about 7.5% by weight, about 5% to about 7% by weight, about 5% to about 6.5% by weight, about 5% to about 6% by weight, about 5% to about 5.5% by weight, about 5.5% to about 10% by weight, about 5.5% to about 9.5% by weight, about 5.5% to about 9% by weight, about 5.5% to about 8.5% by weight, about 5.5% to about 8% by weight, about 5.5% to about 7.5% by weight, about 5.5% to about 7% by weight, about 5.5% to about 6.5% by weight, about 5.5% to about 6% by weight, about 6% to about 10% by weight, about 6% to about 9.5% by weight, about 6% to about 9% by weight, about 6% to about 8.5% by weight, about 6% to about 8% by weight, about 6% to about 7.5% by weight, about 6% to about 7% by weight, about 6% to about 6.5% by weight, about 6.5% to about 10% by weight, about 6.5% to about 9.5% by weight, about 6.5% to about 9% by weight, about 6.5% to about 8.5% by weight, about 6.5% to about 8% by weight, about 6.5% to about 7.5% by weight, about 6.5% to about 7% by weight, about 7% to about 10% by weight, about 7% to about 9.5% by weight, about 7% to about 9% by weight, about 7% to about 8.5% by weight, about 7% to about 8% by weight, about 7% to about 7.5% by weight, about 7.5% to about 10% by weight, about 7.5% to about 9.5% by weight, about 7.5% to about 9% by weight, about 7.5% to about 8.5% by weight, about 7.5% to about 8% by weight, about 8% to about 10% by weight, about 8% to about 9.5% by weight, about 8% to about 9% by weight, about 8% to about 8.5% by weight, about 8.5% to about 10% by weight, about 8.5% to about 9.5% by weight, about 8.5% to about 9% by weight, about 9% to about 10% by weight, about 9% to about 9.5% by weight, or about 9.5% to about 10% by weight. In certain embodiments, the biocide is present in about 0.1% by weight, about 0.25% by weight, about 0.5% by weight, about 0.75% by weight, about 1% by weight, about 1.5% by weight, about 2% by weight, about 2.5% by weight, about 3% by weight, about 3.5% by weight, about 4% by weight, about 4.5% by weight, about 5% by weight, about 5.5% by weight, about 6% by

weight, about 7% by weight, about 7.5% by weight, about 8% by weight, about 8.5% by weight, about 9% by weight, about 9.5% by weight, or about 10% by weight.

[00104] In certain embodiments, the fungicide is present in a range of about 0.1% to about 10% by weight, about 0.1% to about 9.5% by weight, about 0.1% to about 9% by weight, about 0.1% to about 8.5% by weight, about 0.1% to about 8% by weight, about 0.1% to about 7.5% by weight, about 0.1% to about 7% by weight, about 0.1% to about 6.5% by weight, about 0.1% to about 6% by weight, about 0.1% to about 5.5% by weight, about 0.1% to about 5% by weight, about 0.1% to about 4.5% by weight, about 0.1% to about 4% by weight, about 0.1% to about 3.5% by weight, about 0.1% to about 3% by weight, about 0.1% to about 2.5% by weight, about 0.1% to about 2% by weight, about 0.1% to about 1.5% by weight, about 0.1% to about 1% by weight, about 0.1% to about 0.75% by weight, about 0.1% to about 0.5% by weight, about 0.1% to about 0.25% by weight, about 0.25% to about 10% by weight, about 0.25% to about 9.5% by weight, about 0.25% to about 9% by weight, about 0.25% to about 8.5% by weight, about 0.25% to about 8% by weight, about 0.25% to about 7.5% by weight, about 0.25% to about 7% by weight, about 0.25% to about 6.5% by weight, about 0.25% to about 6% by weight, about 0.25% to about 5.5% by weight, about 0.25% to about 5% by weight, about 0.25% to about 4.5% by weight, about 0.25% to about 4% by weight, about 0.25% to about 3.5% by weight, about 0.25% to about 3% by weight, about 0.25% to about 2.5% by weight, about 0.25% to about 2% by weight, about 0.25% to about 1.5% by weight, about 0.25% to about 1% by weight, about 0.25% to about 0.75% by weight, about 0.25% to about 0.5% by weight, about 0.5% to about 10% by weight, about 0.5% to about 9.5% by weight, about 0.5% to about 9% by weight, about 0.5% to about 8.5% by weight, about 0.5% to about 8% by weight, about 0.5 to about 7.5% by weight, about 0.5% to about 7% by weight, about 0.5% to about 6.5% by weight, about 0.5% to about 6% by weight, about 0.5% to about 5.5% by weight, about 0.5% to about 5% by weight, about 0.5% to about 4.5% by weight, about 0.5% to about 4% by weight, about 0.5% to about 3.5% by weight, about 0.5% to about 3% by weight, about 0.5% to about 2.5% by weight, about 0.5% to about 2% by weight, about 0.5% to about 1.5% by weight, about 0.5% to about 1% by weight, about 0.75% to about 10% by weight, about 0.75% to about 9.5% by weight, about 0.75% to about 9% by weight, about 0.75% to about 8.5% by weight, about 0.75% to about 8% by weight, about 0.75 to about 7.5% by weight, about 0.75% to about 7% by weight, about 0.75% to about 6.5% by weight, about 0.75% to about 6% by weight, about 0.75% to

about 5.5% by weight, about 0.75% to about 5% by weight, about 0.75% to about 4.5% by weight, about 0.75% to about 4% by weight, about 0.75% to about 3.75% by weight, about 0.75% to about 3% by weight, about 0.75% to about 2.5% by weight, about 0.75% to about 2% by weight, about 0.75% to about 1.5% by weight, about 0.75% to about 1% by weight, about 1% to about 10% by weight, about 1% to about 9.5% by weight, about 1% to about 9% by weight, about 1% to about 8.5% by weight, about 1% to about 8% by weight, about 1% to about 7.5% by weight, about 1% to about 7% by weight, about 1% to about 6.5% by weight, about 1% to about 6% by weight, about 1% to about 5.5% by weight, about 1% to about 5% by weight, about 1% to about 4.5% by weight, about 1% to about 4% by weight, about 1% to about 3.5% by weight, about 1% to about 3% by weight, about 1% to about 2.5% by weight, about 1% to about 2% by weight, about 1% to about 1.5% by weight, about 1.5% to about 10% by weight, about 1.5% to about 9.5% by weight, about 1.5% to about 9% by weight, about 1.5% to about 8.5% by weight, about 1.5% to about 8% by weight, about 1.5% to about 7.5% by weight, about 1.5% to about 7% by weight, about 1.5% to about 6.5% by weight, about 1.5% to about 6% by weight, about 1.5% to about 5.5% by weight, about 1.5% to about 5% by weight, about 1.5% to about 4.5% by weight, about 1.5% to about 4% by weight, about 1.5% to about 3.5% by weight, about 1.5% to about 3% by weight, about 1.5% to about 2.5% by weight, about 1.5% to about 2% by weight, about 2% to about 10% by weight, about 2% to about 9.5% by weight, about 2% to about 9% by weight, about 2% to about 8.5% by weight, about 2% to about 8% by weight, about 2% to about 7.5% by weight, about 2% to about 7% by weight, about 2% to about 6.5% by weight, about 2% to about 6% by weight, about 2% to about 5.5% by weight, about 2% to about 5% by weight, about 2% to about 4.5% by weight, about 2% to about 4% by weight, about 2% to about 3.5% by weight, about 2% to about 3% by weight, about 2% to about 2.5% by weight, about 2.5% to about 10% by weight, about 2.5% to about 9.5% by weight, about 2.5% to about 9% by weight, about 2.5% to about 8.5% by weight, about 2.5% to about 8% by weight, about 2.5% to about 7.5% by weight, about 2.5% to about 7% by weight, about 2.5% to about 6.5% by weight, about 2.5% to about 6% by weight, about 2.5% to about 5.5% by weight, about 2.5% to about 5% by weight, about 2.5% to about 4.5% by weight, about 2.5% to about 4% by weight, about 2.5% to about 3.5% by weight, about 2.5% to about 3% by weight, about 3% to about 10% by weight, about 3% to about 9.5% by weight, about 3% to about 9% by weight, about 3% to about 8.5% by weight, about 3% to about 8% by weight, about 3% to about 7.5% by weight, about 3% to

about 8% by weight, about 3% to about 7% by weight, about 3% to about 6.5% by weight, about 3% to about 6% by weight, about 3% to about 5.5% by weight, about 3% to about 5% by weight, about 3% to about 4.5% by weight, about 3% to about 4% by weight, about 3% to about 3.5% by weight, about 3.5% to about 10% by weight, about 3.5% to about 9.5% by weight, about 3.5% to about 9% by weight, about 3.5% to about 8.5% by weight, about 3.5% to about 8% by weight, about 3.5% to about 7.5% by weight, about 3.5% to about 7% by weight, about 3.5% to about 6.5% by weight, about 3.5% to about 6% by weight, about 3.5% to about 5.5% by weight, about 3.5% to about 5% by weight, about 3.5% to about 4.5% by weight, about 3.5% to about 4% by weight, about 4% to about 10% by weight, about 4% to about 9.5% by weight, about 4% to about 9% by weight, about 4% to about 8.5% by weight, about 4% to about 8% by weight, about 4% to about 7.5% by weight, about 4% to about 7% by weight, about 4% to about 6.5% by weight, about 4% to about 6% by weight, about 4% to about 5.5% by weight, about 4% to about 5% by weight, about 4% to about 4.5% by weight, about 4.5% to about 10% by weight, about 4.5% to about 9.5% by weight, about 4.5% to about 9% by weight, about 4.5% to about 8.5% by weight, about 4.5% to about 8% by weight, about 4.5% to about 7.5% by weight, about 4.5% to about 7% by weight, about 4.5% to about 6.5% by weight, about 4.5% to about 6% by weight, about 4.5% to about 5.5% by weight, about 4.5% to about 5% by weight, about 5% to about 10% by weight, about 5% to about 9.5% by weight, about 5% to about 9% by weight, about 5% to about 8.5% by weight, about 5% to about 8% by weight, about 5% to about 7.5% by weight, about 5% to about 7% by weight, about 5% to about 6.5% by weight, about 5% to about 6% by weight, about 5% to about 5.5% by weight, about 5.5% to about 10% by weight, about 5.5% to about 9.5% by weight, about 5.5% to about 9% by weight, about 5.5% to about 8.5% by weight, about 5.5% to about 8% by weight, about 5.5% to about 7.5% by weight, about 5.5% to about 7% by weight, about 5.5% to about 6.5% by weight, about 5.5% to about 6% by weight, about 6% to about 10% by weight, about 6% to about 9.5% by weight, about 6% to about 9% by weight, about 6% to about 8.5% by weight, about 6% to about 8% by weight, about 6% to about 7.5% by weight, about 6% to about 7% by weight, about 6% to about 6.5% by weight, about 6.5% to about 10% by weight, about 6.5% to about 9.5% by weight, about 6.5% to about 9% by weight, about 6.5% to about 8.5% by weight, about 6.5% to about 8% by weight, about 6.5% to about 7.5% by weight, about 6.5% to about 7% by weight, about 7% to about 10% by weight, about 7% to about 9.5% by weight, about 7% to about 9% by weight, about 7% to

about 8.5% by weight, about 7% to about 8% by weight, about 7% to about 7.5% by weight, about 7.5% to about 10% by weight, about 7.5% to about 9.5% by weight, about 7.5% to about 9% by weight, about 7.5% to about 8.5% by weight, about 7.5% to about 8% by weight, about 8% to about 10% by weight, about 8% to about 9.5% by weight, about 8% to about 9% by weight, about 8% to about 8.5% by weight, about 8.5% to about 10% by weight, about 8.5% to about 9.5% by weight, about 8.5% to about 9% by weight, about 9% to about 10% by weight, about 9% to about 9.5% by weight, or about 9.5% to about 10% by weight. In certain embodiments, the fungicide is present in about 0.1% by weight, about 0.25% by weight, about 0.5% by weight, about 0.75% by weight, about 1% by weight, about 1.5% by weight, about 2% by weight, about 2.5% by weight, about 3% by weight, about 3.5% by weight, about 4% by weight, about 4.5% by weight, about 5% by weight, about 5.5% by weight, about 6% by weight, about 7% by weight, about 7.5% by weight, about 8% by weight, about 8.5% by weight, about 9% by weight, about 9.5% by weight, or about 10% by weight.

[00105] Additional objects and advantages of the present invention will be appreciated by one of ordinary skill in the art in light of the current description and examples of the preferred embodiments, and are expressly included within the scope of the present invention.

[00106] EXAMPLES

[00107] Examining Partial Esters of DIACID 1550 with 2-Ethylhexanol or Dodecanol as Lubricating Corrosion Inhibitors. Evaluations were conducted for surface rust prevention, lubricity, hard water tolerance, and foaming properties for partial esters of DIACID 1550 neutralized with either TEA or potassium hydroxide. The following observations were made: (1) potassium and TEA salts of the partial esters are significantly more stable in hard water than the corresponding DIACID 1550 salts; (2) potassium and TEA salts of the partial esters have notably reduced foaming compared to the corresponding DIACID 1550 salts; (3) potassium salts of both the partial esters are better corrosion inhibitors than the potassium salt of DIACID 1550 and the DIACID M-T67; (4) potassium salts of both the partial esters are equivalent boundary lubricants to DIACID M-T67; and (5) TEA salts of the two partial esters are better boundary lubricants than DIACID M-T67.

[00108] Partial esters of DIACID 1550, DIACID 1525, and DIACID 1550 XLM with 2-ethylhexanol or dodecanol were synthesized with hypophosphorous acid as a catalyst. Aliquots of the partial esters were neutralized with (1:1) potassium hydroxide as the 41% active aqueous solution or neat (1:1) with TEA 99. The neat TEA salts were clear and

flowable. The aqueous 41% active potassium solution of the 2-ethylhexanol partial ester of DIACID 1550 was clear, but the other partial esters were opaque and unstable.

[00109] The DIACID 1550 partial ester potassium and TEA salts were diluted to various levels between 0.5% to 10% with 300 ppm hard water. The hard water solutions were examined for short and long term stability; 1% solutions were examined using the Falex Pin and V-Block Lubricity Testing Apparatus (ASTM D2670), 1-5% solutions were examined by the Cast Iron Chip Corrosion Test (ASTM D4627-86), and 0.5%, 2%, and 5% solutions were examined for hard water tolerance, relative foaming tendencies, and clarity. The data is shown in Table 1 and Table 2.

[00110] Table 1.

	DIACID 1525 1/2 Ester 2-Ethylhexyl	DIACID 1550 1/2 Ester 2-Ethylhexyl	DIACID 1550 1/2 Ester Dodecyl	DIACID 1550 XLM 1/2 Ester 2-Ethylhexyl	DIACID 1550 K ⁺ Salt	DIACID M-T67
TEA Salt (neat)	1, W	1, W	1, W	1, W	1, W	1, W
K ⁺ Salt (41%/H ₂ O)	2, Z	1, W	2, Z	2, Z	1, W	1, W
TEA Salt						
0.5% (300ppm HW)		1, Y	1, Y, VLS			2, Z, LS
1% (300ppm HW)		1, Y	1, Y			
2% (300ppm HW)		1, X	1, Y			
5% (300ppm HW)		1, X	1, Y			
10% (300ppm HW)		1, X	1, Y			1, W
K ⁺ Salt						
0.5% (300ppm HW)		1, X	1, Y		2, Z, LS	
1% (300ppm HW)		1, X	1, Y			
2% (300ppm HW)		1, X	1, Y			
5% (300ppm HW)		1, X	1, Z			
10% (300ppm HW)	2, Z	1, X	1, Z	2, Z	1, W	
Iron Chip CI Test						
TEA Salt						
0.5% (300ppm HW)		D	D			D
1% (300ppm HW)		C	D			B
2% (300ppm HW)		C	D			B
5% (300ppm HW)		B	C			B+
10% (300ppm HW)		B+	B			A

K ⁺ Salt						
0.5% (300ppm HW)		D	D		D	
1% (300ppm HW)		D	D		C	
2% (300ppm HW)		C	C		C	
5% (300ppm HW)		A	A		B	
10% (300ppm HW)		A	A		A	

Key:

1	Stable	W	clear
2	Unstable after 1 hour	X	blue-white haze
3	Unstable after 1 day	Y	White haze
4	Precipitate	Z	Opaque

VLS	Very light scum	A	No rust
LS	Light scum	B	Up to 20% rust spots
MS	Medium scum	C	Up to 50% rust spots
HS	Heavy scum	D	Greater than 50% rust spots

[00111] Table 2.

	DIACID 1525 1/2 Ester 2-Ethylhexyl	DIACID 1550 1/2 Ester 2-Ethylhexyl	DIACID 1550 1/2 Ester Dodecyl	DIACID 1550 XLM 1/2 Ester 2-Ethylhexyl	DIACID 1550 K ⁺ Salt	DIACID M-T67
Lubricity Falex P&V Boundary (700 psi)	Number of Teeth (lower is better)					
TEA Salt 1% (300ppm HW)		19	17			* 38
K ⁺ Salt 1% (300ppm HW)		36	38		* 163	
Ramp (psi vs. torque)	Torque (pounds-inches)					
TEA Salt 1% (300ppm HW)						
500 psi		16	18			
750 psi		23	24			
1000 psi		26	26			
1250 psi		27	30			
1500 psi		29	32			
1750 psi		32	36			
2000 psi		36	43			

2250 psi		47	46			
2500 psi		51	52			
2750 psi		53	55			
3000 psi		55	56			
3250 psi		61	59			
K ⁺ Salt 1% (300ppm HW)						
500 psi		16	13			
750 psi		24	21			
1000 psi		28	25			
1250 psi		31	29			
1500 psi		35	32			
1750 psi		38	36			
2000 psi		41	39			
2250 psi		43	41			
2500 psi		45	44			
2750 psi		48	47			
3000 psi		49	49			
3250 psi		52	52			
3500 psi		54	58			
3750 psi		57				

[00112] The potassium and TEA salts of the partial esters of 2-ethylhexanol and dodecanol are significantly more stable in hard water than the corresponding DIACID 1550 salts. The 2-ethylhexanol partial ester salts are more stable than the dodecanol partial ester salts. The dodecanol partial ester potassium salt is not as stable as a 41% active solution in deionized water; lower concentration solutions, however, are stable in 300 ppm hard water.

[00113] The potassium salts of both the 2-ethylhexanol and dodecanol partial esters of DIACID 1550 are better corrosion inhibitors and boundary lubricants than the potassium salt of DIACID 1550. Furthermore, both the 2-ethylhexanol and dodecanol partial esters of DIACID 1550 perform better than DIACID M-T67 (67% DIACID 1550 1:2 TEA salt, 8% TEA, and 25% water). The TEA salts of the DIACID 1550 partial esters are better boundary lubricants than DIACID M-T67, but slightly worse corrosion inhibitors. This is likely due to the excess TEA in the DIACID M-T67.

[00114] The potassium salt solutions at 2% and 5% demonstrated stability for over 2 months and have a blue-white haze that keeps them from being completely clear. The

potassium salts of the DIACID 1550 partial esters completely prevent rust at a lower concentration than the DIACID M-T67 which has 8% excess TEA, but is only 75% active. The salts of the DIACID 1550 partial esters foam significantly less than the corresponding DIACID 1550 salts at the same concentrations, particularly in hard water.

[00115] Examining DIACID 1550 Partial Esters of 2-Ethylhexanol or Dodecanol in Generic Semi-Synthetic Metalworking Fluid Formulation. An investigation was conducted to observe the performance of the partial esters in a generic semi-synthetic metalworking fluid formulation. DIACID 1550, DIACID 1550 2-Ethyl-1-hexanol partial ester, and the DIACID 1550 1-Dodecanol partial ester were examined in the formulation. After roughly optimizing the formulation for each product, stabilities of both the concentrates and their 1% active concentration dilutions (in 300 ppm hard water) were observed over a period of at least 10 days. The general formulation of the semi-synthetic metalworking fluid was:

Component	Weight %
Golden Bear 100 SUS Oil	15.0
ACTRAMIDE 202	15.0
ACTRABASE 264	5.0
DIACID 1550 or partial ester	6.1
Butyl CARBITOL™	3.9
KOH, 45%	Q.S. to 100%
	q.s. to pH=8.6-10.5

[00116] The following general observations were made: (1) in properly balanced formulations, the DIACID 1550 partial ester salts performed noticeably better than the corresponding DIACID 1550; (2) generally, the partial ester salts performed significantly better in hard water; (3) optimization of the level of neutralizing agent and the coupling agent is important; and (4) the HLB of the system can be adjusted to enhance the lubricating and corrosion inhibiting effects of the DIACID 1550 partial esters.

[00117] Modifications were made to the formulation in order to examine two couplers (DOWANOL™ TPM (tripropylene glycol methyl ether) and Butyl CARBITOL™ (diethylene glycol monobutyl ether)), examine different amounts of neutralizing (“buffering”) agents, the effect of pH, and adjust the HLB. The concentrates were formulated with deionized water

and subsequent 1% active concentration dilutions were made with 300 ppm hard water. The concentrates and 1% dilutions were observed for at least 10 days. The inherent foam properties of the DIACID partial esters were determined with the Ross-Miles Foam Test procedure. American Society of Testing and Materials Annual Book of ASTM Standards, Volume 15.04 (1992), Standard D1173 “Standard Test Method for Foaming Properties for Surface-Active Agents”, pp 108-109. The clarity, stability, layering, scumming, and relative foam were documented. The results can be found in Table 3 and Table 4.

[00118] Table 3. Semi-Synthetic Metalworking Fluid

Component	7833-53B	7833-53E	7833-54A	7833-54C	7833-54E
Golden Bear 100	15.08	15.05	15.16	14.73	14.72
ACTRAMIDE 202	15.09	15.01	15.15	14.72	14.68
ACTRABASE 264	5.11	4.98	5.22	5.07	4.87
DIACID 1550					
1550 2-ethyl-1-hexanol 1/2 Ester	6.10	6.06	6.10	8.93	5.93
1550 dodecanol 1/2 Ester					
DOWANOL™ TPM	1.61	1.68	1.60	4.38	3.82
DI Water	53.28	55.26	53.61	52.10	54.06
KOH, 45%	3.73	1.96	1.85	1.80	1.92
Ethox TMO14A			1.31	1.27	
Appearance					
Concentrate					
PH (approx.)*					
Initial	2,6	2,6	2,4	1,2	1,2
6 Day	7	2,6	2,5	2,3	2,3
15 Day		2,6	2,5	2,3	2,3
1% in 300 ppm HW					
PH (approx.)*					
Initial	6, B/C	5, C	5, C	1,2,B/C	2,3,B/C
1 Hour				2,3	
6 Day	6,7,9	2,6	2,6	2,3	2,3
15 Day	7,0	6,9	6,8	2,3	2,3

Appearance Key:

- | | |
|---------------------|-----------------|
| 1 = clear | A = light foam |
| 2 = stable | B = low foam |
| 3 = very light haze | C = medium foam |
| 4 = light haze | D = high foam |
| 5 = haze | |

6 = opaque, milky

X = oil droplets at the top

7 = layers

8 = very light scum

9 = light scum

0 = scum, creamy

Table 4. Semi-Synthetic Metalworking Fluid

Component	7833-55E	7833-55G	7833-56B	7833-56D	7833-57A	7833-57C	7833-57E
Golden Bear 100	15.06	14.43	15.34	14.91	14.81	15.10	14.89
ACTRAMIDE 202	15.02	14.39	15.75	14.97	14.87	15.06	14.96
ACTRABASE 264	5.09	4.88	5.32	5.09	5.20	5.12	5.02
DIACID 1550	6.04	5.79					6.08
1550 2-ethyl-1-hexanol 1/2 Ester						6.09	
1550 dodecanol 1/2 Ester			6.43	6.08	6.17		
DOWANOL™ TPM	1.61	5.73	6.18				
DI Water	54.67	50.47	48.38	51.36	52.82	52.51	50.58
KOH, 45%	4.50	4.31	2.60	2.21	2.27	2.20	4.61
Butyl CARBITOL™				5.38	3.85	3.93	
Appearance							
Concentrate							
PH (approx.)*							
Initial	6,D	6,D	1,2	1,2	1,2	1,2	6
1 Hour	7	7					7
1 Day			1,2	1,2			
5 Day					1,2	1,2	
6 Day			1,2	1,2			
15 Day			1,2	1,2	1,2	1,2	
1% in 300 ppm HW							
PH (approx.)*							
Initial	6,C	6,C	5,C	2,3,B/C	2,3,B/C	2,3,B/C	6,B/C
1 Hour							2,6,8
1 Day			5,8	2,3			
3 Day	6,7,0	6,7					
5 Day					2,4,9	2,4,8	6,0
6 Day	6,7,0	6,7,0	5,9	2,4,8			

15 Day				4,0			
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Appearance Key:

1 = clear	A = light foam
2 = stable	B = low foam
3 = very light haze	C = medium foam
4 = light haze	D = high foam
5 = haze	
6 = opaque, milky	X = oil droplets at the top
7 = layers	
8 = very light scum	
9 = light scum	
0 = scum, creamy	

[00119] The five formulations in Table 3 were used as range finders for the DIACID 1550 2-Ethyl-1-hexanol partial ester potassium salt. A 1.5 fold excess of neutralizing agent was tried with a lower level of DOWANOL™ TPM coupling solvent in 53B. This was similar practice to excess TEA formulations. The initial appearance of the concentrate was white opaque, but stable. This was marginal so other options were tried. The potassium hydroxide excess was reduced to one third in 53E. The appearance of the concentrate was still white opaque and stable. A non-ionic tall oil fatty acid ethoxylate (Ethox TM014A) was added as a co-emulsifier and hydrophobic/lipophilic balance (HLB) modifier in 54A. A significant improvement to a stable, near clear solution with a light white haze was obtained. In 54C, additional DOWANOL™ TPM coupling solvent was added to the levels used in 54A. The result was a clear, stable concentrate. In 54E, the Ethox TM014A was left out and a lower level of DOWANOL™ TPM was used. The same clear, stable concentrate was obtained. Dilutions with 300 ppm hard water were performed. Initial results for the hard water dilutions gave better results as they progressed from 53B to 54C and 54E. Initially, 54C was clear, but within the first hour developed a very light white haze. Initially, 54E had a very light white haze. Upon aging 6 days, 54C and 54E remained stable with a very light haze for both the concentrate and hard water dilution. As for the other concentrates, 53B layered, 53E was white opaque, but 54A was stable with a white haze. Their hard water dilutions were poorer in performance. The hard water dilution of 53B was white opaque, layered, and had a light scum. The hard water dilutions of 53E and 54A were stable and white opaque.

[00120] In Table 4, DIACID 1550 and the two DIACID 1550 partial esters were compared as potassium salts. DIACID 1550 was examined at a low and a high DOWANOL™ TPM level in 55E and 55G. DIACID 1550 performed poorly in the concentrate, layering in the first hour. In 56B, the DIACID1550 1-Dodecanol partial ester was examined at a high DOWANOL™ TPM level and it produced a clear, stable concentrate. The coupling solvent was changed to Butyl CARBITOL™ (diethylene glycol monobutyl ether) because it was specified in the original generic formulation. In 56D and 57A, the DIACID 1550 1-Dodecanol partial ester salts with high and medium levels of Butyl CARBITOL™ were examined with very good results in the concentrates observed (clear and stable). Based on these results in the concentrates, the medium level of Butyl CARBITOL™ was used with DIACID 1550 and the DIACID 1550 2-Ethyl-1-hexanol partial ester (57E and 57C respectively). The DIACID 1550 2-Ethyl-1-hexanol partial ester concentrate (57C) was clear and stable. But the DIACID 1550 concentrate (57E) was white opaque and layered within the first hour. When the 300 ppm hard water dilutions were performed, the DIACID 1550 based concentrates performed poorly.

[00121] The DIACID 1550 1-Dodecanol partial ester performed better with Butyl CARBITOL™ coupling solvent when placed in 300ppm hard water, but as concentrates the Butyl CARBITOL™ and DOWANOL™ TPM based formulations were comparable. The DIACID 1550 2-Ethyl-1-hexanol and 1-Dodecanol partial esters performed very well as concentrates and hard water dilutions with Butyl CARBITOL™ as the coupling solvent in the formulation. It appears that the DIACID 1550 2-Ethyl-1-hexanol partial ester performs slightly better with DOWANOL™ TPM as the coupling solvent. DIACID 1550 1-Dodecanol partial ester, DIACID 1550 2-ethyl-1-hexanol partial ester, and DIACID 1550 were compared under similar formulations in 57 A-E and the partial esters were far better.

[00122] **Examining DIACID 1550 2-Ethylhexanol Partial Esters Performance in Generic Synthetic Metalworking Fluid Formulations.** DIACID 1550, DIACID M-T67, and the DIACID 1550 2-Ethylhexanol partial ester were examined a generic synthetic metalworking fluid formulations. After roughly optimizing the formulation, stabilities of both the concentrates and their 1% active concentration dilutions (in 300 ppm hard water) were observed over a period of at least 10 days. The inherent foam properties were determined with the Ross-Miles Foam Test procedure, as cited above. The following observations were made: (1) in an optimized system, the DIACID 1550 2-Ethylhexanol partial ester significantly

outperforms DIACID 1550 in a hard water dilution; (2) pH is important, particularly in a KOH neutralized system; and (3) adjustment of the system HLB is critical for the DIACID 1550 2-Ethylhexanol partial ester.

[00123] The partial ester of DIACID 1550 with 2-Ethyl-1-hexanol was formulated into a generic synthetic metalworking fluid. DIACID 1550 was formulated for comparison. The general formulation of the generic synthetic metal working fluid is:

Component	Weight %
EMPHOS TS-230 (EP Lubricant)	4.1
EM-550	10.1
Boundary Lubricant/Corrosion Inhibitor (DIACID 1550 or DIACID 1550 partial ester)	8.1
Nonionic Surfactant (HLB adjustment)	up to 5%
Water, DI	Q.S. to 100%
KOH, 45% or TEA	q.s. to pH = 8-10

[00124] Modifications were made to the formulation in order to examine a coupler (Butyl CARBITOL™), examine different amounts of neutralizing ("buffering") agents, the effect of pH, and adjust the HLB. The concentrates were formulated with deionized water and subsequent 1 % active concentration dilutions were made with 300 ppm hard water. The concentrates and 1% dilutions were observed for at least 10 days. The clarity, stability, layering, scumming, and relative foam were documented. The results for the synthetic formulation are in Tables 5, 6, and 7.

[00125] Table 5. DIACID 1550 2-Ethyl-1-hexanol partial ester potassium salt

Component	7833-43B	7833-43D	7833-44A	7833-44B	7833-44D	7833-44E	7833-45A	7833-45C
DI Water	82.94	82.38	82.08	81.34	80.94	81.87	80.29	88.58
KOH, 45%	2.71	2.51	3.95	3.56	4.02	4.02	4.11	2.15
DIACID M-T67								
DIACID 2-Ethylhexanol Partial ester	10.13	10.04	9.95	10.05	9.87	10.07	10.02	9.27
Emphos TS-230	4.21	4.06	4.01	4.01	3.99	4.04	4.02	
Ethox TMO14A		1.02		1.04	1.00		1.56	
Appearance								

Concentrate								
PH (approx.)*	pH = 7	pH = 6.5	pH = 12	pH = 8.5	pH = 13	pH = 12	pH = 12	pH = 10
Initial	5,2,C	5,2,C	3,2	1,2	1,2	1,2	1,2	1,2,A
1 Hour						5,2		
1 Day	6,2		3,X	1,2	1,X	5,X	1,X	1,2
15 Day				1,2				3,2
1% in 300 ppm HW								
PH (approx.)*	pH = 5	pH = 5		pH = 7.5	pH = 8.5	pH = 7.5	pH = 7.5	pH = 6.5
Initial	3,2,A	3,2,A		1,2,B	1,2,B	4,2	1,2,B	3,2,A
1 Hour							3,2	
1 Day	4,X			5,2	5,2,8	6,2,8	5,2,8	4,2
2 Day		4,0						
15 Day				5,2,8			5,2	4,X

Appearance Key:

- | | |
|---------------------|-----------------------------|
| 1 = clear | A = light foam |
| 2 = stable | B = low foam |
| 3 = very light haze | C = medium foam |
| 4 = light haze | D = high foam |
| 5 = haze | |
| 6 = opaque, milky | X = oil droplets at the top |
| 7 = layers | |
| 8 = very light scum | |
| 9 = light scum | |
| 0 = scum, creamy | |

[00126] The formulations in Table 5 were used as range finders for the DIACID 1550 2-Ethyl-1-hexanol partial ester potassium salt. The EM-550 emulsifier package was left out in order to examine the effect of pH changes on the partial ester salt in the presence of the Emphos TS-230 phosphate ester. Concentrate pH ranges were from 6.5 to 13. A tall oil fatty acid ethoxylate (Ethox TMO14A) was added to selected samples for HLB adjustment. The best initial stability for the concentrates occurred above pH 8. Extended stability for pH13 was poor and pH 12 appeared to be a borderline. Addition of the Ethox TMO14A to the formulation appeared to improve the stability of the hard water dilutions. Formulation 45C does not contain the emulsifier or phosphate ester, and the resulting foam rating demonstrates that the formulation foam is not from the 2-Ethyl-1-hexanol partial ester alone.

[00127] Table 6. Comparison of DIACID 1550 2-ethyl-1-hexanol partial ester and DAICID 1550 in a potassium neutralized system

Component	7833-59A	7833-59C	7833-59E	7833-60A	7833-60B	7833-60C
DI Water	71.04	68.35	65.70	65.97	70.65	63.19
KOH, 45%	6.63	8.94	6.14	5.13	3.73	4.71
DIACID 1550		8.07				
DIACID 2-Ethylhexanol Partial ester	8.01		7.41	9.83	8.21	11.57
EM-550	10.18	10.36	9.41	9.89	10.05	9.48
Emphos TS-230	4.14	4.28	3.83	4.10	4.18	3.86
Ethox TMO14A					3.18	3.28
Butyl CARBITOL™			3.20			
Tergitol NP-7			4.31			
Tergitol NP-9				5.08		
Concentrate						
PH (approx.)*	pH = >13	pH = 12	pH = 11	pH = 9.5	pH = 8	pH = 13
Initial	1,2,C	1,2,D	1,2,C	1,2,D	1,2,C	1,2,D
1 Hour	5,2	1,2	1,2	1,2	1,2	1,2
1 Day	7,X	1,2	1,2			
3 Day				1,2	1,2	1,2
4 Day	7,X	1,2	7,X	1,2	1,2	1,2
15 Day	7,X	1,2	7,X	1,2	1,2	1,2
1% in 300 ppm HW						
PH (approx.)*	pH = 5	pH = 5		pH = 7.5	pH = 8.5	pH = 7.5
Initial	1,2,B	3,2,D	1,2,C	1,2,D	1,2,C	
1 Hour	1,2	4,2	1,2	1,2	1,2	
1 Day	1,2	4,8	1,2			
3 Day				1,2	1,2	
4 Day	3,2	4,8	1,2	1,2	1,2	
5 Day	3,2	4,8	1,2			
15 Day	3,2	4,8	1,2	1,2	1,2	

Appearance Key:

1 = clear

A = light foam

2 = stable

B = low foam

3 = very light haze	C = medium foam
4 = light haze	D = high foam
5 = haze	
6 = opaque, milky	X = oil droplets at the top
7 = layers	
8 = very light scum	
9 = light scum	
0 = scum, creamy	

[00128] The formulations in Table 6 were used to compare DIACID 1550 2-Ethyl-1-hexanol partial ester and DIACID 1550 in a potassium neutralized system. All formulation ingredients were present and in some cases a coupling solvent and/or nonionic surfactant was added in an attempt to optimize the 2-Ethyl-1-hexanol partial ester concentrate formulation stability. The high pH 2-Ethyl-1-hexanol partial ester formulation concentrate (59A) performed very poorly, but the hardwater dilution performed moderately well. The DIACID 1550 formulation concentrate (59C) performed very well, but the hardwater dilution performed poorly. Reduction in pH and addition of the above mentioned stabilizing additives provided significantly enhanced performance in the 2-Ethyl-1-hexanol partial ester based concentrates (59E, 60A, and 60B). All three formulations performed very well as hardwater dilutions.

[00129] Table 7.

Component	7833-58A	7833-58C	7833-58E	7833-58G
DI Water	70.49	70.31	70.34	61.40
TEA, 99%	5.11	8.66	9.37	7.56
DIACID M-T67	10.16			
DIACID 1550			6.06	
DIACID 2-Ethylhexanol Partial ester		6.76		5.90
EM-550	10.20	10.14	10.14	8.86
Emphos TS-230	4.04	4.13	4.10	3.61
Butyl CARBITOL™				2.99
Tergitol NP-7				5.48
Tergitol NP-9				4.20
Concentrate				
PH (approx.)*	pH = >13	pH = 12	pH = 11	pH = 9.5

Initial	1,2,D	5,C	1,2,D	1,2,D
1 Hour				1,2
2 Day	1,2	7,X	1,2	
3 Day				1,2
4 Day				1,2
5 Day	1,2	7,X	1,2	
15 Day	1,2	7,X	1,2	1,2
1% in 300 ppm HW				
PH (approx.)*	pH = 5	pH = 5		pH = 7.5
Initial	1,2,D	6,C	1,2,D	1,2,D
1 Hour			4,2	1,2
2 Day	5,2	5,0	5,8	
3 Day				1,2
5 Day	5,2	5,0	5,9	
15 Day	5,2	5,0	5,9	1,2

Appearance Key:

1 = clear	A = light foam
2 = stable	B = low foam
3 = very light haze	C = medium foam
4 = light haze	D = high foam
5 = haze	
6 = opaque, milky	X = oil droplets at the top
7 = layers	
8 = very light scum	
9 = light scum	
0 = scum, creamy	

[00130] The formulations in Table 7 examine the system with triethanolamine (TEA) as the neutralizing agent. Each formulation contains approximately 6% TEA in excess of the amount needed to neutralize the DIACID 1550 or DIACID 1550 2-Ethyl-1-hexanol partial ester. Formulation 58A has pre-made DIACID M-T67, while 58E contains DIACID 1550 neutralized in situ. It should be noted that 58A (DIACID M-T67) and 58E (DIACID 1550) performed differently. Modification of the HLB and/or addition of a coupling solvent were previously demonstrated to dramatically improve the performance of the partial ester formulations. This was illustrated again in when comparing 58C (2-Ethyl-1-hexanol) with 58G.

[00131] Examining DIACID 1550 Partial Ester of 2-Ethyl-1-hexanol or 1-Dodecanol in Generic Metalworking Fluid Formulations.

An investigation was conducted to observe the performance of the 2-Ethyl-1-hexanol and 1-Dodecanol DIACID 1550 partial esters in generic synthetic and semi-synthetic metalworking fluid formulations. DIACID 1550, DIACID 1550 2-Ethyl-1-hexanol partial esters, and DIACID 1550 1-Dodecanol partial esters were examined in the formulations. Several additives were used to adjust the HLB, or the solvency, of the formulations to determine the best overall stability. After adjusting the formulations, stabilities of both the concentrates and their 1% active concentration dilutions (in 300 ppm hard water) were observed over a period of at least 10 days. The inherent foam properties of the neutralized partial esters were determined with the Ross-Miles Foam Test procedure, as cited above.

[00132] The following observations were made: (1) in the optimized TEA based semi-synthetic system, the DIACID 1550 2-Ethyl-1-hexanol partial esters and DIACID 1-Dodecanol partial esters significantly outperformed DIACID 1550 in the concentrate and the hard water dilutions; (2) in the TEA based synthetic system, the unmodified formulation gave poor results; (3) TEA based synthetic system was difficult to stabilize, but IGEPAL CO-530 an octylphenol ethoxylate (HLB=10.8) worked well, yielding significant improvement with the partial esters; (4) a blend of IGEPAL CO-530 with OCD-480 (a PEG-400 diester of L-5) with HLB=10.2, worked well, yielding significant improvement with the partial esters; (5) in the potassium hydroxide (KOH) based synthetic system in which the HLB was balanced, the partial esters were far superior to DIACID 1550; (6) the alcohol ethoxylates (linear or alkylphenol) with HLB values of 10.5-12.5 did well with regard to stabilizing the partial ester based potassium hydroxide formulations; (7) the blends of OCD-480 (a PEG-400 diester of L-5) and alcohol ethoxylates (linear or alkylphenol) with resulting HLB values of 10.5 to 11.5 did well with regard to stabilizing the partial ester potassium hydroxide based formulations; (8) the Tall Oil Fatty Acid ethoxylate with a HLB value of 13.7 did well with regard to stabilizing the partial ester potassium hydroxide based formulations; (9) the DIACID 1550 12 mole ethoxylate with a HLB value of 12.0 did the best overall with regard to stabilizing the partial ester potassium hydroxide based formulations; (10) system adjustments did not improve the DIACID 1550 performance anywhere near as well as the improvement obtained in the performance of the DIACID 1550 partial esters; and (11) adjustment of the system HLB enhanced the stability of the concentrates and the hard water dilution.

[00133] Semi-Synthetic Formulations. The partial esters of DIACID 1550 with 2-Ethyl-1-hexanol or 1-Dodecanol were formulated into a TEA based generic semi-synthetic metalworking fluid. DIACID1550 was formulated for comparison. The general formulation is shown in Table 8. The concentrates were formulated with deionized water, and subsequently 1% active concentration dilutions were made with 300 ppm hard water. The concentrates and dilutions were observed for at least 10 days. Results for the TEA based semi-synthetic metalworking fluid formulation, including clarity, stability, layering, scumming and relative foam can be found in Tables 9.

[00134] Table 8. TEA Based Semi-Synthetic Metalworking Fluid Concentrate Formulation.

Component	Weight %
Golden Bear 100 SUS Oil	15.0
ACTRAMIDE 202	15.0
ACTRABASE 264	5.0
DIACID 1550 or partial ester	6.2
Butyl CARBITOL™	3.9
TEA 99% 1:1 Equivalents* and 5% excess	
Water, DI	Q.S. to 100%

*based on Acid number of DIACID 1550 or partial ester

[00135] Table 9. TEA Based Semi-Synthetic Metalworking Formulation

Component	7833-62A	7833-62B	7833-62C
Golden Bear 100	15.13	15.07	14.93
ACTRAMIDE 202	15.03	15.12	15.11
ACTRABASE 264	5.18	5.06	5.02
DIACID 1550	6.44		
DIACID1550 2-ethyl-1-hexanol 1/2 Ester		6.17	
DIACID1550 dodecanol 1/2 Ester			6.04
TEA, 99%	9.76	6.96	6.85
DI Water	44.40	47.61	47.67
Butyl CARBITOL™	4.05	4.00	4.02
Appearance			

Concentrate			
Initial	6	1,2	1,2
1 Hour	7		
1 Day	7	1,2	1,2
2 Day		1,2	1,2
6 Day		1,2	1,2
15 Day		1,2	1,2
1 % in 300 ppm HW			
Initial	6,B	3,2,C	3,2,C/D
1 Hour	6,0		
1 Day	6,0	4,2	4,2
2 Day	6,0	4,2	4,2
6 Day	6,0	4,2	4,2
15 Day	6,0	5,9/0	5,0

Appearance Key:

1 = clear	A = light foam
2 = stable	B = low foam
3 = very light haze	C = medium foam
4 = light haze	D = high foam
5 = haze	
6 = opaque, milky	X = oil droplets at the top
7 = layers	
8 = very light scum	
9 = light scum	
0 = scum, creamy	

[00136] Items 62A, 62B, and 62C are the results for DIACID 1550, the 1550 2-Ethyl-1-hexanol partial ester, and the DIACID 1550 1-Dodecanol partial ester, respectively. DIACID 1550 performs poorly in the concentrate and the hard water dilution. The DIACID 1550 2-Ethyl-1-hexanol and 1-Dodecanol partial esters performed very well in the concentrate and good in the hard water dilutions.

[00137] TEA Based Synthetic Formulation. The partial esters of DIACID 1550 with either 2-Ethyl-1-hexanol or 1-Dodecanol were formulated into a generic synthetic metalworking fluid. DIACID 1550 was formulated for comparison. The general formulation is shown in Table 10. Modifications were made to the formulation in order to examine a coupler (Butyl CARBITOL™), and adjust the HLB. The concentrates were formulated with

deionized water, and subsequently 1% active concentration dilutions were made with 300 ppm hard water. The concentrates and dilutions were observed for at least 10 days. The clarity, stability, layering, scumming, and relative foam were documented. The results for the TEA based synthetic metalworking fluid formulation can be found in Tables 11-14.

[00138] Table 10. TEA Based Synthetic Metalworking Fluid Concentrate Formulation

Component	Weight %
EMPHOS TS-230 (EP Lubricant)	4.1
EM-550	10.1
Boundary Lubricant/Corrosion Inhibitor (DIACID 1550 or partial ester)	8.1
Nonionic Surfactant (HLB adjustment)	up to 5.0
TEA 99% 1:1 equivalent ration (based on Acid number of DIACID 1550 or partial ester)	
TEA 99% 1:1 Equivalents* and 5% excess	5.0
Water, DI	Q.S. to 100%

[00139] Table 11. Unmodified Synthetic Metalworking Formulation with TEA

Component	7833-63A	7833-63B	7833-63C
DI Water	66.61	70.27	70.46
TEA, 99%	10.84	7.33	7.08
DIACID 1550	8.11		
1550 2-ethyl-1-hexanol 1/2 Ester		8.14	
1550 dodecanol 1/2 Ester			8.13
EM-550	10.26	10.10	10.15
EMPHOS TS-230	4.17	4.15	4.18
Appearance			
Concentrate			
Initial	1,2,D+	6,B	6,B
1 Hour	1,2	7	7
1 Day	1,2	7	7
15 Day	1,2	7	7
1 % in 300 ppm HW			
Initial	3,C/D	5,B	5,C

1 Hour	3,8	5,9	5,9
1 Day	3,9	6,0	6,0
15 Day	5,9	6,0	6,0

Appearance Key:

1 = clear	A = light foam
2 = stable	B = low foam
3 = very light haze	C = medium foam
4 = light haze	D = high foam
5 = haze	
6 = opaque, milky	X = oil droplets at the top
7 = layers	
8 = very light scum	
9 = light scum	
0 = scum, creamy	

[00140] The results for the unmodified base formulation are found in Table 11. Items 63A, 63B, and 63C are the results for DIACID 1550, the 1550 2-Ethyl-1-hexanol half ester, and the 1550 1-Dodecanol partial ester, respectively. DIACID 1550 performed well in the concentrate, but poorly in the hard water dilution. The DIACID 1550 2-Ethyl-1-hexanol partial ester, and 1-Dodecanol partial ester performed very poorly in the concentrate and the hard water dilutions.

[00141] Table 12. Synthetic Metalworking Formulation with TEA and Butyl CARBITOL™ Modifications

Component	7833-64A1	7833-64B	7833-64C
DI Water	56.43	60.53	60.75
TEA, 99%	9.55	6.42	6.12
DIACID 1550	7.43		
1550 2-ethyl-1-hexanol 1/2 Ester		7.07	
1550 dodecanol 1/2 Ester			7.06
EM-550	8.95	8.74	8.74
EMPHOS TS-230	3.65	3.59	3.63
Butyl CARBITOL™	14.00	13.65	13.69
Appearance			
Concentrate			
Initial	1,2,D+	6,B	6,B/C

1 Hour		7	7
1 Day	1,2	7	7
4 Day	1,2	7	7
6 Day	1,2		
15 Day	1,2		
1% in 300 ppm HW			
Initial	3,D		
1 Hour	4,9		
1 Day	3,9		
4 Day	4,9		
6 Day	5,9/0		
15 Day	5,9/0		

Appearance Key:

1 = clear	A = light foam
2 = stable	B = low foam
3 = very light haze	C = medium foam
4 = light haze	D = high foam
5 = haze	
6 = opaque, milky	X = oil droplets at the top
7 = layers	
8 = very light scum	
9 = light scum	
0 = scum, creamy	

[00142] Table 12 contains the results for modifications with Butyl CARBITOL™, which had performed well in stabilizing the semi-synthetic formulation. Excessive amounts of Butyl CARBITOL™ were unable to improve the performance of the TEA based synthetic formulation.

[00143] Table 13. Synthetic Metalworking Formulation with TEA and ETHOX TMO14A or TERGITOL™ NP-9 Modification

Component	7833-65A	7833-66A
DI Water	63.61	63.67
TEA, 99%	10.85	10.85
DIACID 1550	8.15	8.13
EM-550	10.13	10.16
EMPHOS TS-230	4.18	4.13
Ethox TMO14A	3.07	

Tergitol NP-9		3.06
Concentrate		
Initial	1,2,D	1,2,D
1 Day	1,2	1,2
4 Day	1,2	1,2
6 Day	1,2	1,2
15 Day	1,2	1,2
1% in 300 ppm HW		
Initial	1,2,D+	1,2,D
1 Hour	3,9	
1 Day	3,9	1,2
4 Day	4,9/0	4,8
6 Day	5,9/0	5,8
15 Day	5,9/0	5,8

Appearance Key:

1 = clear	A = light foam
2 = stable	B = low foam
3 = very light haze	C = medium foam
4 = light haze	D = high foam
5 = haze	
6 = opaque, milky	X = oil droplets at the top
7 = layers	
8 = very light scum	
9 = light scum	
0 = scum, creamy	

[00144] Table 13 contains the results for the modifications of the DIACID 1550 TEA based synthetic formulation with Ethox TM014A (14 mole ethoxylate of tall oil fatty acid, TOFA) or TERGITOL NP-9 (a 9 mole ethoxylate of nonylphenol). The unmodified DIACID 1550 TEA based synthetic formulation had a stable concentrate. Therefore, improvement was not detected in the concentrate. However, the TERGITOL NP-9 improved the hard water dilution stability from less than 1 hour up to greater than 1 day, but less than 4 days. The Ethox TMO14A did not improve the performance of the DIACID 1550 TEA based synthetic formulation with regard to hard water dilution stability.

[00145] Table 14. HLB Optimization of Synthetic Metalworking Formulation with TEA

Component	7833-67A	7833-67B	7833-67C	7833-67D	7833-67E	7833-67F	7833-68C
DI Water	65.03	65.06	64.84	65.01	64.77	64.94	64.45
TEA, 99%	7.28	7.30	7.22	7.28	7.56	7.36	7.22
1550 2-ethyl-1-hexanol 1/2 Ester	8.11	8.18	8.16	8.18	8.04	8.10	8.18
EM-550	10.21	10.17	10.10	10.15	10.32	10.32	10.03
EMPHOS TS-230	4.32	4.14	4.27	4.17	4.19	4.28	4.22
Tergitol NP-4	5.04					3.04	
Tergitol NP-7					5.11	1.52	
IGEPAL CO-430							2.96
IGEPAL CO-530		5.15		3.86			2.95
OCD-480			5.41	1.36		0.54	
Appearance							
Concentrate							
Initial	4,2	1,2	4,2	4,2	3,2	1,2	1,2,C/D
1 Hour			6,2				
1 Day	4,2	1,2	6,2	4,2	3,2	1,2	1,2
3 Day	4,2	1,2	6,2	4,2	3,2	1,2	1,2
6 Day		1,2		4,2		1,2	1,2
15 Day		1,2		7*		1,2	1,2
1% in 300 ppm HW							
Initial		1,2,C/D		1,2,D		1,2,C/D	1,2,C
1 Day		4,2		4,2		4/5,2	4/5,2
4 Day		4,2		4,2		4/5,2	4/5,2
6 Day		4,2		4,2		4/5,2	4/5,2
15 Day		4,2		4,9		4/5,2	4/5,2

Appearance Key:

1 = clear

2 = stable

3 = very light haze

4 = light haze

5 = haze

6 = opaque, milky

7 = layers

8 = very light scum

9 = light scum

A = light foam

B = low foam

C = medium foam

D = high foam

X = oil droplets at the top

0 = scum, creamy

[00146] In Table 14, alkylphenol ethoxylates and OCD-480, which is a TOFA polyethylene glycol diester (TOFA-PEG), are used to optimize the HLB of the DIACID 1550 2-ethyl-1-hexanol partial ester TEA based synthetic formulation. Additive combinations with HLB of 9.5 to 11 perform well in the concentrate and the hard water dilutions.

[00147] Potassium Hydroxide Based Synthetic Formulation. The partial esters of DIACID 1550 with either 2-Ethyl-1-hexanol or 1-Dodecanol were formulated into a generic synthetic metalworking fluid. DIACID 1550 was formulated for comparison. The general formulation is shown in Table 15. Modifications were made to the formulation in order to examine a coupler (e.g. Butyl CARBITOL™), and adjust the HLB. The concentrates were formulated with deionized water, and subsequently 1% active concentration dilutions were made with 300 ppm hard water. The concentrates and dilutions were observed for at least 10 days. The clarity, stability, layering, scumming, and relative foam were documented. Results for the potassium hydroxide based synthetic formulation can be found in Tables 16-20.

[00148] Table 15. Potassium Hydroxide Based Synthetic Metalworking Fluid Concentrate Formulation.

Component	Weight %
EMPHOS TS-230 (EP Lubricant)	4.1
EM-550	10.1
Boundary Lubricant/Corrosion Inhibitor (DIACID 1550 or partial ester)	8.1
Nonionic Surfactant (HLB adjustment)	up to 5.0
Potassium Hydroxide, 45%	q.s. to pH = 8-10
Water, DI	Q.S. to 100%

[00149] Table 16. Synthetic Metalworking Formulation with Potassium Hydroxide

Component	7833-72C	7833-72B	7833-72A	7833-71C	7833-71B	7833-71A
DI Water	70.57	69.54	64.29	73.38	73.41	67.52
KOH, 45%	3.47	3.83	9.74	3.62	3.96	9.76
DIACID 1550			8.19			8.06
1550 2-ethyl-1-		8.52			8.14	

hexanol 1/2 Ester						
1550 dodecanol 1/2 Ester	8.39			8.11		
EM-550	10.06	10.42	10.13	10.54	10.26	10.46
EMPHOS TS-230	4.07	4.18	4.18	4.35	4.23	4.20
Ethox TMO14A	3.43	3.52	3.47			
Appearance						
Concentrate						
Initial	1,2,C	1,2,C	1,2,D	4,2,C	4,2,C	1,2,D
1 Hour				5,2	5,2	
1 Day	1,2	1,2	1,2	7	7	1,2
2 Day	1,2	1,2	1,2			
3 Day	4,2	1,2	1,2			1,2
6 Day	7,X	1,2	1,2			1,2
15 Day		1,2	1,2			1,2
1% in 300 ppm HW						
Initial	1,2,B/C	1,2,B/C	4,D,8	4,2,A	4,2,A	3,D,8
1 Hour				4,2	4,2	3,9
1 Day	1,2	1,2	3,0	4,0	5,0	3,0
2 Day	1,2	1,2	4,0	4,0	5,0	4,0
3 Day	1,2	1,2	4,0	4,0	5,0	4,0
6 Day	1,2	1,2	4,0	4,0	5,0	4,0
15 Day	1,2	1,2	4,0	4,0	5,0	4,0

Appearance Key:

- | | |
|---------------------|-----------------------------|
| 1 = clear | A = light foam |
| 2 = stable | B = low foam |
| 3 = very light haze | C = medium foam |
| 4 = light haze | D = high foam |
| 5 = haze | |
| 6 = opaque, milky | X = oil droplets at the top |
| 7 = layers | |
| 8 = very light scum | |
| 9 = light scum | |
| 0 = scum, creamy | |

[00150] The results for the unmodified potassium hydroxide based synthetic formulation are found in Table 16, along with the results for the formulation modified with

ETHOX TMO14A. Items 71A, 71B, and 71C are the results for DIACID 1550, the DIACID 1550 2-Ethyl-1-hexanol partial ester, and the DIACID 1550 1-Dodecanol partial ester, respectively. DIACID 1550 performed well in the concentrate, but poorly in the hard water dilution. Items 72A, 72B, and 72C are the results for the Ethox TM014A modified formulation with DIACID 1550, the DIACID 1550 2-Ethyl-1-hexanol partial ester, and the DIACID 1550 1-Dodecanol partial ester, respectively. DIACID 1550 performed well in the concentrate. However, the DIACID 1550 2-Ethyl-1-hexanol partial ester performed very well in the concentrate and the hard water dilution. The DIACID 1550 1-Dodecanol partial ester performed significantly better in the concentrate and very well in the hard water dilution.

[00151] Table 17. Synthetic Metalworking Formulation with Potassium Hydroxide

Component	7833-73C	7833-73B	7833-73A
DI Water	70.19	69.70	63.68
KOH, 45%	3.56	3.83	9.81
DIACID 1550			8.58
1550 2-ethyl-1-hexanol 1/2 Ester		8.35	
1550 dodecanol 1/2 Ester	8.39		
EM-550	10.15	10.15	10.11
EMPHOS TS-230	4.18	4.19	4.29
Butyl CARBITOL™	3.54	3.77	3.53
Appearance			
Concentrate			
Initial	6,C	6,C	1,2,D+
1 Day	7.00	7.00	1,2
2 Day			1,2
3 Day			1,2
6 Day			1,2
15 Day			1,2
1% in 300 ppm HW			
Initial	4,A	4,A	3,D+,9
1 Day	4,0	4,0	4,0
2 Day	4,0	4,0	4,0
3 Day	4,0	4,0	4,0
6 Day	4,0	4,0	4,0

15 Day	4,0	4,0	4,0
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Appearance Key:

1 = clear	A = light foam
2 = stable	B = low foam
3 = very light haze	C = medium foam
4 = light haze	D = high foam
5 = haze	
6 = opaque, milky	X = oil droplets at the top
7 = layers	
8 = very light scum	
9 = light scum	
0 = scum, creamy	

[00152] Table 17 contains the results for the potassium hydroxide based synthetic formulation modified with Butyl CARBITOL™. There was no improvement of performance with Butyl CARBITOL™. As noted previously with the TEA based synthetic formulation, Butyl CARBITOL™ does not improve the performance of the synthetic formulation but readily improves the performance of the semi-synthetic formulation where it acts as an emulsifying solvent.

[00153] Table 18. Synthetic Metalworking Formulation with Potassium Hydroxide.

Component	7833-74E	7833-74D	7833-74C	7833-74B	7833-74A
DI Water	69.81	69.95	69.94	70.02	69.98
KOH, 45%	3.83	3.86	3.83	3.86	3.85
1550 2-ethyl-1-hexanol 1/2 Ester	8.17	8.25	8.28	8.18	8.22
EM-550	10.14	10.16	10.11	10.19	10.26
EMPHOS TS-230	4.23	4.25	4.36	4.21	4.22
IGEPAL CO-630			3.48		
NEODOL 91-6				3.54	
NEODOL 91-8					3.48
OCD-383	1.85				
OCD-384	1.97	3.53			
Appearance					
Concentrate					
Initial	1,2,C	3,2,C	1,2,C	1,2,D+	1,2,D+
1 Hour	3,2	5,2			3,2
2 Hours					4,2

1 Day	5,7	5,7	1,2	1,2	5,7
2 Day			1,2	1,2	
6 Day			1,2	1,2	
15 Day			1,2	1,2	
1% in 300 ppm HW					
Initial	3,2,B/C	3,2,B	1,2,C	1,2,D	1,2,D
1 Day	3,9/0	3,9/0	1,2	1,2	1,9
6 Day	3,9/0	3,9/0	1,2	1,2	1,9/0
15 Day	3,9/0	3,9/0	1,2	1,2	1,9/0

Appearance Key:

1 = clear	A = light foam
2 = stable	B = low foam
3 = very light haze	C = medium foam
4 = light haze	D = high foam
5 = haze	
6 = opaque, milky	X = oil droplets at the top
7 = layers	
8 = very light scum	
9 = light scum	
0 = scum, creamy	

[00154] Table 19. Synthetic Metalworking Formulation with Potassium Hydroxide

Component	7833-75E	7833-75D	7833-75C	7833-75B	7833-75A
DI Water	70.29	70.15	70.26	70.19	70.13
KOH, 45%	3.85	3.85	3.85	3.83	3.86
1550 2-ethyl-1-hexanol 1/2 Ester	8.12	8.15	8.11	8.15	8.19
EM-550	10.11	10.18	10.09	10.16	10.07
EMPHOS TS-230	4.13	4.17	4.14	4.16	4.21
Tergitol NP-7		3.49			
IGEPAL CO-530				3.51	
TRITON X-114			3.55		
NEODOL 23-5					3.54
OCD-383	3.51				
Appearance					
Concentrate					
Initial	1,2,C	1,2,D	1,2,D	1,2,C	1,2,D

1 Day	1,2	1,2	1,2	1,2	1,2
5 Day	1,2	1,2	1,2	1,2	1,2
6 Day	1,2	1,2	1,2	1,2	1,2
15 Day	1,2	1,2	1,2	1,2	1,2
1% in 300 ppm HW					
Initial	1,2,B+	1,2,C	1,2,D	1,2,C/D	1,2,D
1 Day	1,2	1,2	1,2	1,2	1,2
6 Day	1,2	1,2	1,2	1,2	1,2
15 Day	1,2	1,2	1,2	1,2	1,2

Appearance Key:

1 = clear	A = light foam
2 = stable	B = low foam
3 = very light haze	C = medium foam
4 = light haze	D = high foam
5 = haze	
6 = opaque, milky	X = oil droplets at the top
7 = layers	
8 = very light scum	
9 = light scum	
0 = scum, creamy	

[00155] The results reported in Table 18 and Table 19 represent the examination of the 2-Ethyl-1-hexanol partial ester in the potassium hydroxide based synthetic formulation modified with HLB adjusting additives of various chemistries. The additives consist of alkylphenol ethoxylates, linear alcohol ethoxylates, and Ingevity DIACID 1550 ethoxylates. The additives with HLB values between 10.5 and 12.5 worked best. But IGEPAL CO-630 (alkylphenol ethoxylate with HLB of 13.0; and in particular, nonyl phenol ethoxylate) performed very well. Another additive consisting of a blend of DIACID1550 ethoxylates (OCD-383 and OCD-384) performed poorly. It had a 12.6 calculated HLB. It should be noted here that the Ingevity DIACID 1550 ethoxylate with 12 moles EO (OCD-383) was one of the best performers and its formulation had the lowest foam.

[00156] Table 20. Synthetic Metalworking Formulation with KOH.

Component	7833-76D	7833-76C	7833-76B	7833-76A
DI Water	70.03	70.15	69.16	69.90
KOH, 45%	3.87	3.86	3.85	3.88

1550 2-ethyl-1-hexanol 1/2 Ester	8.18	8.19	8.12	8.32
EM-550	10.14	10.19	9.98	10.12
EMPHOS TS-230	4.29	4.13	4.09	4.29
IGEPAL CO-630				1.74
NEODOL 91-8		1.75	2.40	
OCD-384	1.74			
OCD-480	1.73	1.74	2.40	1.75
Appearance				
Concentrate				
Initial	1,2,B/C	1,2,D	1,2,D	1,2,C
1 Day	1,2	1,2	1,2	1,2
5 Day	1,2	1,2	1,2	1,2
6 Day	1,2	1,2	1,2	1,2
15 Day	1,2	1,2	1,2	1,2
1% in 300 ppm HW				
Initial	1,2,C-	1,2,C	1,2,C	1,2,C
1 Day	1,2	1,2	1,2	1,2
6 Day	1,2	1,2	1,2	1,2
15 Day	1,2	1,2	1,2	1,2

Appearance Key:

1 = clear	A = light foam
2 = stable	B = low foam
3 = very light haze	C = medium foam
4 = light haze	D = high foam
5 = haze	
6 = opaque, milky	X = oil droplets at the top
7 = layers	
8 = very light scum	
9 = light scum	
0 = scum, creamy	

[00157] Table 20 contains results of the investigation of the 2-Ethyl-1-hexanol partial ester in the potassium hydroxide based synthetic formulation modified with HLB adjusting additives consisting of OCD-480(TOFA-PEG diester) blended with either an alkylphenol ethoxylate, a linear alcohol ethoxylate, or a Ingevity DIACID 1550 ethoxylate. The additive

blends had HLB values ranging from 10.7 to 11.2, and they each performed very well. The TOFA-PEG diester and the DIACID 1550 ethoxylates also demonstrate the potential to be non-petroleum, renewable resource based metalworking fluid additives.

[00158] Comparing DIACID Partial Ester of n-Pentanol with 2-Ethyl-1-hexanol and 1-Dodecanol Analogues in Semi-synthetic and Synthetic Metalworking

Fluid Formulations. An investigation was conducted to observe the performance of the DIACID 1550 n-Pentanol partial ester, and compare it to 2-Ethyl-1-hexanol and 1-Dodecanol partial esters, in generic synthetic and semi-synthetic working fluid formulations. DIACID 1550 n-Pentanol partial esters were examined in the semi-synthetic and synthetic metalworking fluid formulations and compares to data for DIACID 1550, DIACID 1550 2-Ethyl-1-hexanol partial esters, and DIACID 1550 1-Dodecanol partial ester. Selected additives were used to adjust the HLB, or the solvency, of the formulations based on the overall stability determined in previous experiments. After adjusting the formulations, stabilities of both the concentrates and their 1% active concentration dilutions (in 300 ppm hard water) were observed over a period of at least 10 days.

[00159] The following observations were made: (1) in the optimized TEA based semi-synthetic system, the DIACID 1550 n-Pentanol partial esters, like the DIACID 1550 2-Ethyl-1-hexanol and 1-Dodecanol partial esters, significantly outperformed DIACID 1550 in the concentrate and the hard water dilution; (2) in the optimized potassium hydroxide based semi-synthetic system, the DIACID 1550 n-Pentanol partial esters, like the 1550 2-Ethyl-1-hexanol and 1-Dodecanol partial esters, significantly outperformed DIACID 1550 in the concentrate and the hard water dilution; (3) in the TEA based synthetic system, the unmodified formulation gave poor results in the hard water dilutions with all the partial esters and DIACID 1550; (4) DIACID 1550 gave very good stability in the TEA based and potassium hydroxide based synthetic formulation concentrate without hard water ; (5) the TEA based synthetic system modified with a nonionic surfactant like IGEPAL CO-530, an octylphenol ethoxylate (HLB=10.8), gave very good stability and significant improvement with the partial esters and to a lesser degree with DIACID1550 ; (6) in the potassium hydroxide based unmodified synthetic formulation, all the partial esters and DIACID 1550 gave poor results in the hard water dilutions ; (7) in the potassium hydroxide based synthetic system with the HLB adjusted, the DIACID 1550 partial esters were far superior to DIACID 1550; (8) system adjustments did not improve the DIACID 1550 performance anywhere near

as well as the improvement obtained in the performance of the DIACID 1550 partial esters; and (9) adjustment of the system HLB enhanced the stability of the concentrates and the hard water dilutions.

[00160] The investigation of the neutralized DIACID 1550 n-Pentanol partial esters as potential lubricating corrosion inhibitors consisted of observation of the salts in 300 ppm hard water, examination of the performance in the Iron Chip Corrosion Test (ASTM D4627-86), and the examination of lubricity properties using the Falex Pin and V-Block Lubricity Testing Apparatus (ASTM D2670). The results were compared to results for the neutralized 2-Ethylhexyl and dodecanol partial esters. The inherent foam properties of the neutralized partial esters were determined with the Ross-Miles Foam Test procedure, as cited above, and compared to the results for the neutralized 2-Ethyl-1-hexanol and 1-Dodecanol DIACID partial esters.

[00161] Semi-Synthetic Formulation. The DIACID 1550 n-Pentanol partial esters were formulated into a TEA based, and a KOH based, generic semi-synthetic metalworking fluid, and compared with results for DIACID 1550, DIACID 1550 2-Ethyl-1-hexanol partial ester, and DIACID 1550 1-Dodecanol partial ester. The general formulation is included in Table 8 above and Table 21 below. The concentrates were formulated with deionized and subsequently 1% active concentration dilutions were made with 300 ppm hard water. The concentrates and dilutions were observed for at least 10 days. The clarity, stability, layering, scumming, and relative foam were documented.

[00162] Table 21. Potassium Hydroxide Based Semi-synthetic Metalworking Fluid Concentrate Formulation

Component	Weight %
Golden Bear 100 SUS Oil	15.0
ACTRAMIDE 202	15.0
ACTRABASE 264	5.0
DIACID 1550 or partial ester	6.2
Butyl CARBITOL™	3.9
KOH, 45%	q.s. to pH = 8-10
Water, DI	Q.S. to 100%

[00163] Table 22.

Observations	DIACID 1550 2-Ethylhexyl Partial Ester	DIACID 1550 Dodecyl Partial Ester	DIACID 1550 n-Pentyl Partial Ester	DIACID K ⁺ Salt	DIACID M-T67
TEA Salt (neat)	1,W	1,W	1,W	1,W	1,W
K ⁺ Salt (41% H ₂ O)	1,W	2,Z	1,W	1,W	1,W
TEA Salt					
0.5% (300ppm HW)	1,Y	1,Y,VLS			1,Z,LS
1% (300ppm HW)	1,Y	1,Y	1,Z		
2% (300ppm HW)	1,X	1,Y	1,Z		
5% (300ppm HW)	1,X	1,Y	1,Z		
10% (300 ppm HW)	1,X	1,Y			1,W
K⁺ Salt					
0.5% (300ppm HW)	1,X	1,Y		2,Z,LS	
1% (300ppm HW)	1,X	1,Y	1,Y		
2% (300ppm HW)	1,X	1,Y	1,X		
5% (300ppm HW)	1,X	1,Z	1,W		
10% (300 ppm HW)	1,X	1,Z		1,W	
Cast Iron Chip Test					
TEA Salt					
0.5% (300ppm HW)	D	D	C		D
1% (300ppm HW)	C	D	C		B
2% (300ppm HW)	D	D	C		B
5% (300ppm HW)	B	C	B		B+
10% (300 ppm HW)	B+	B	B+		A
K⁺ Salt					
0.5% (300ppm HW)	D	D	D	D	
1% (300ppm HW)	D	D	C	C	
2% (300ppm HW)	C	C	C	C	
5% (300ppm HW)	A	A	B+	B	
10% (300 ppm HW)	A	A	A	A	

Key:

- | | | | |
|---|-----------------------|---|-----------------|
| 1 | Stable | W | clear |
| 2 | Unstable after 1 hour | X | blue-white haze |
| 3 | Unstable after 1 day | Y | White haze |
| 4 | Precipitate | Z | Opaque |

VLS Very light scum

A No rust

LS Light scum

B Up to 20% rust spots

MS Medium scum

C Up to 50% rust spots

HS Heavy scum

D Greater than 50% rust spots

[00164] The observations of dilute solutions of the DIACID 1550 partial ester salts made with 300 ppm hard water, and the results of the Iron Chip Test are reported in Table 22. The DIACID 1550 n-Pentanol partial ester performs comparably to the DIACID 1550 2-Ethyl-1-hexanol or 1-Dodecanol partial esters and DIACID 1550 with regard to hard water stability and Iron Chip Corrosion Inhibition.

[00165] Table 23. Falex Pin and V-Block Analysis

Observations	DIACID 1550 2-Ethylhexyl Partial Ester	DIACID 1550 Dodecyl Partial Ester	DIACID 1550 n-Pentyl Partial Ester	DIACID K ⁺ Salt	DIACID M-T67
Lubricity Falex P&V Boundary (700 psi)	Number of Teeth (lower is better)				
TEA Salt 1% (300 ppm HW)	19	17	16		38*
K ⁺ Salt 1% (300 ppm HW)	36	38	39	163*	

* Data from the DIACID Metalworking Manual Section on Lubricity.

[00166] The Falex Pin and V-Block results are reported in Table 23. The DIACID 1550 n-Pentanol partial ester performs comparably to the DIACID 1550 2-Ethyl-1-hexanol or 1-Dodecanol partial esters. All three of the DIACID 1550 partial esters perform better than DIACID 1550 with regard to Boundary Lubrication as tested by the Falex Pin and V-Block procedure.

[00167] Table 24. Ross-Miles Foam Test (at 49°C)

Sample	Conc., %	Time = 1 min	Time = 5 min
		Foam Height, cm	Foam Height, cm
DIACID 1550 K ⁺ Salt (full)	0.1	10.0	9.5
DIACID 1550 Partial Ester of 2-Ethyl-1-hexanol, K ⁺ Salt	0.1	4.5	1.5
DIACID 1550 Partial Ester of 1-Dodecanol, K ⁺ Salt	0.1	6.5	2.5
DIACID 1550 Partial Ester of n-Pentanol, K ⁺ Salt	0.1	10.5	1.0
DIACID 1550 TEA Salt (full)	0.1	2.5	1.5
DIACID 1550 Partial Ester of	0.1	1.5	0.5

2-Ethyl-1-hexanol, K+ Salt			
DIACID 1550 Partial Ester of 1-Dodecanol, K+ Salt	0.1	1.5	0.5
DIACID 1550 Partial Ester of n-Pentanol, K+ Salt	0.1	1.0	0.5
DIACID 1550 K+ Salt (full)	1.0	20.5	19.5
DIACID 1550 Partial Ester of 2-Ethyl-1-hexanol, K+ Salt	1.0	10.5	0.5
DIACID 1550 Partial Ester of 1-Dodecanol, K+ Salt	1.0	12.5	1.0
DIACID 1550 Partial Ester of n-Pentanol, K+ Salt	1.0	13.5	1.5
DIACID 1550 TEA Salt (full)	1.0	18.5	5.0
DIACID 1550 Partial Ester of 2-Ethyl-1-hexanol, K+ Salt	1.0	4.0	0.5
DIACID 1550 Partial Ester of 1-Dodecanol, K+ Salt	1.0	2.5	0.5
DIACID 1550 Partial Ester of n-Pentanol, K+ Salt	1.0	5.0	0.5

[00168] The Ross-Miles Foam results are reported in Table 24. The DIACID 1550 n-Pentanol partial ester performs comparably to the DIACID 1550 2-Ethyl-1-hexanol or 1-Dodecanol partial esters, except that the 0.1% solution of potassium neutralized n-Pentanol partial ester appears to have initial foam heights like DIACID 1550 potassium neutralized material. However, the potassium neutralized n-Pentanol partial ester solution has a 5 minute foam stability like the other partial esters. In general, the partial esters have are improved with regard to their foaming properties (i.e., they have reduced foam production).

[00169] Table 25. Semi-Synthetic Metalworking Formulation with TEA

Component	81A	81B	7833-62A	7833-62B	7833-62C
Golden Bear 100	15.04	15.02	15.13	15.07	14.93
ACTRAMIDE 202	15.15	15.06	15.03	15.12	15.11
ACTRABASE 264	5.08	5.05	5.18	5.06	5.02
DIACID 1550			6.44		
DIACID1550 2-Ethyl- 1-hexanol Partial Ester				6.17	
DIACID1550					6.40

dodecanol Partial Ester					
DIACID1550 n-Pentanol Partial ester	6.02	6.13			
TEA, 99%	6.88	6.91	9.76	6.96	6.85
DI Water	51.82	47.82	44.40	47.61	47.67
Butyl CARBITOL™		4.02	4.05	4.00	4.02
Appearance					
Concentrate					
Initial	2,4	1,2	6	1,2	1,2
1 Hour			7		
1 Day	5,5	1,2	7	1,2	1,2
2 Day	5,2	1,2		1,2	1,2
5 Day	5,2	1,2			
6 Day	6	1,2		1,2	1,2
15 Day	6	1,2		1,2	1,2
1% in 300 ppm HW					
Initial	2,6,C	2,3,C	6,B	3,2,C	3,2,C/D
1 Hour			6,0		
1 Day	2,6	2,4	6,0	4,2	4,2
2 Day	2,6	2,5	6,0	4,2	4,2
5 Day	2,6	2,5			
6 Day	6,8	2,5	6,0	4,2	4,2
15 Day	6,0	2,5	6,0	5,9/0	5,0

Appearance Key:

- | | |
|---------------------|-----------------------------|
| 1 = clear | A = light foam |
| 2 = stable | B = low foam |
| 3 = very light haze | C = medium foam |
| 4 = light haze | D = high foam |
| 5 = haze | |
| 6 = opaque, milky | X = oil droplets at the top |
| 7 = layers | |
| 8 = very light scum | |
| 9 = light scum | |
| 0 = scum, creamy | |

[00170] Results for the TEA based semi-synthetic metalworking fluid formulation are shown in Table 25. As shown previously above, DIACID 1550 performs poorly in the concentrate and the hard water dilution. The DIACID 1550 2-Ethyl-1-hexanol and 1-

Dodecanol partial esters performed very well in the concentrate and good in the hard water dilutions when the system was stabilized with a coupling solvent.

[00171] Table 26. Semi-Synthetic Metalworking Formulation with Potassium Hydroxide

Component	81C	81D	7833-54E	7833-55E	7833-55G	7833-57A	7833-57C	7833-57E
Golden Bear 100	15.04	15.04	14.72	15.06	14.43	14.81	15.10	14.89
ACTRAMIDE 202	15.10	15.22	14.68	15.02	14.39	14.87	15.06	14.96
ACTRABASE 264	5.10	5.17	4.87	5.09	4.88	5.20	5.12	5.02
DIACID 1550				6.04	5.79			6.08
DIACID1550 2-Ethyl-1-hexanol Partial Ester			5.93				6.09	
DIACID1550 dodecanol Partial Ester						6.17		
DIACID1550 n-Pentanol Partial Ester	6.20	6.04						
DOWANOL™ TPM		4.01	3.82	1.61	5.73			
DI Water	56.50	52.47	54.06	52.67	50.47	52.82	52.51	50.48
KOH, 45%	2.07	2.05	1.92	4.50	4.31	2.27	2.20	4.61
Butyl CARBITOL™						3.85	3.93	3.87
Appearance								
Concentrate								
Initial	5,2	1,2	1,2	6,D	6,D	1,2	1,2	6
1 Day	5,2	1,2						
2 Day	5,2	1,2						
5 Day	5,2	1,2				1,2	1,2	
6 Day	6	1,2	2,3					
15 Day	6	1,2	2,3			1,2	1,2	
1% in 300 ppm HW								
Initial	2,6,B/C	2,3,C	2,3	6,C	6,C	2,3,B/C	2,3,B/C	6,B/C
1 Hour								2,6,8
1 Day	2,6	2,4						
4 Day	6,8	2,4						
5 Day	6,8	4,X				2,4,9	2,4,8	6,0
6 Day	6,8	4,X	2,3	6,7,0	6,7,0			
15 Day	6,8	4,X	2,3					

Appearance Key:

1 = clear	A = light foam
2 = stable	B = low foam
3 = very light haze	C = medium foam
4 = light haze	D = high foam
5 = haze	
6 = opaque, milky	X = oil droplets at the top
7 = layers	
8 = very light scum	
9 = light scum	
0 = scum, creamy	

[00172] Results for the potassium hydroxide based semi-synthetic metalworking fluid formulation can be found in Table 26. Once again as reported previously above, DIACID 1550 performs poorly in the concentrate and the hard water dilution, whether or not the system has been stabilized with a coupling solvent. The DIACID 1550 2-Ethyl-1-hexanol, 1-Dodecanol, and n-Pentanol partial esters performed very well in the concentrate and good in the hard water dilutions when the system was stabilized with a coupling solvent.

[00173] In both the TEA and the potassium hydroxide based systems, the DIACID 1550 partial ester performed better than DIACID 1550 even when the system does not contain a coupling solvent.

[00174] Synthetic Formulation. The DIACID 1550 n-Pentanol partial esters were formulated into a TEA based, and a KOH based, generic synthetic metalworking fluid, and compared to DIACID 1550, DIACID 1550 2-Ethyl-1-hexanol partial ester, and DIACID 1550 1-Dodecanol partial ester. The general formulation is included in Tables 10 and 15 above. The concentrates were formulated with deionized water, and subsequently 1% active concentration dilutions were made with 300 ppm hard water. The concentrates and dilutions were observed for at least 10 days. The clarity, stability, layering, scumming, and relative foam were documented.

[00175] Table 27. Synthetic Metalworking Formulation with TEA.

Component	80D	63C	63B	63A	80E	67B
DI Water	70.09	70.46	70.27	66.61	64.89	65.06
TEA, 99%	7.32	7.08	7.33	10.84	7.39	7.30
DIACID 1550				8.11		
DIACID1550 2-Ethyl-1-			8.14			8.18

hexanol Partial Ester						
DIACID1550 1-Dodecanol Partial Ester		8.13				
DIACID 1550 n-Pentanol Partial Ester	8.20				8.16	
EM-550	10.21	10.15	10.10	10.26	10.35	10.17
EMPHOS TS-230	4.18	4.18	4.15	4.17	4.19	4.14
IGEPAL CO-530					5.02	5.15
Appearance						
Concentrate						
Initial	2,6,C	6,B	6,B	1,2,D+	1,2,C	1,2
1 Hour		7	7	1,2		
1 Day	7	7	7	1,2	1,2	1,2
2 Day					1,2	
3 Day					1,2	1,2
5 Day					1,2	
6 Day					1,2	1,2
15 Day		7	7	1,2	1,2	1,2
1% in 300 ppm HW						
Initial	2,5,C/D	5,C	5,B	3,C/D	1,2,D	1,2,C/D
1 Hour		5,9	5,9	3,8		
2 Hours	7,0				3,2	
1 Day		6,0	6,0	3,9	3,2	4,2
2 Day					3,2	
4 Day						4,2
5 Day					4,2	
6 Day					4,2	4,2
15 Day		6,0	6,0	5,9	4,2	4,2

Appearance Key:

- | | |
|---------------------|-----------------------------|
| 1 = clear | A = light foam |
| 2 = stable | B = low foam |
| 3 = very light haze | C = medium foam |
| 4 = light haze | D = high foam |
| 5 = haze | |
| 6 = opaque, milky | X = oil droplets at the top |
| 7 = layers | |
| 8 = very light scum | |
| 9 = light scum | |

0 = scum, creamy

[00176] Table 28. Synthetic Metalworking Formulation with TEA

Component	65A	66A
DI Water	63.61	63.67
TEA, 99%	10.85	10.85
DIACID 1550	8.15	8.13
EM-550	10.13	10.16
EMPHOS TS-230	4.18	4.13
Ethox TMO14A	3.07	
Tergitol NP-9		3.06
Appearance		
Concentrate		
Initial	1,2,D	1,2,D
1 Day	1,2	1,2
4 Day	1,2	1,2
6 Day	1,2	1,2
15 Day	1,2	1,2
1% in 300 ppm HW		
Initial	1,2,D+	1,2,D
1 Hour	3,9	
1 Day	3,9	1,2
4 Day	4,9/0	4,8
6 Day	5,9/0	5,8
15 Day	5,9/0	5,8

Appearance Key:

1 = clear

2 = stable

3 = very light haze

4 = light haze

5 = haze

6 = opaque, milky

7 = layers

8 = very light scum

9 = light scum

0 = scum, creamy

A = light foam

B = low foam

C = medium foam

D = high foam

X = oil droplets at the top

[00177] Results for the TEA based synthetic metalworking fluid formulations can be found in Tables 27 and 28. Items 63A, 63B, 63C, and 80D are the results for DIACID 1550, the DIACID 1550 2-Ethyl-1-hexanol partial ester, the DIACID 1550 1-Dodecanol partial ester, and the DIACID 1550 n-Pentanol partial ester, respectively. In the unmodified formulation, DIACID 1550 performed well in the concentrate, but poorly in the hard water dilution. In the unmodified formulation, the DIACID 1550 2-Ethyl-1-hexanol, 1-Dodecanol, and n-Pentanol partial esters performed very poorly in the concentrate and the hard water dilutions. When the formulation is modified with nonionic surfactants to balance the HLB, the DIACID 1550 performs better in the hard water dilution. The DIACID 1550 partial esters perform significantly better in both the concentrate and the hard water dilutions when the formulation is modified with nonionic surfactants to balance the HLB.

[00178] Table 29. Synthetic Metalworking Formulation with Potassium Hydroxide.

Component	80A	71C	71B	71A	80B	80C	75E	75D
DI Water	73.49	73.38	73.41	67.52	70.25	69.93	70.29	70.15
KOH, 45%	3.86	3.62	3.96	9.76	3.88	3.92	3.85	3.85
DIACID M-T67								
DIACID 1550				8.06				
DIACID1550 2-Ethyl-1-hexanol Partial Ester			8.14				8.12	8.15
DIACID1550 1-Dodecanol Partial Ester		8.11						
DIACID 1550 n-Pentanol Partial Ester	8.24				8.15	5.23		
EM-550	10.27	10.54	10.26	10.46	10.15	10.18	10.11	10.18
EMPHOS TS-230	4.14	4.35	4.23	4.20	4.13	4.31	4.13	4.17
Tergitol NP-7						3.44		3.49
OCD-383					3.44		3.51	
Appearance								
Concentrate								
Initial	2,5,C	4,2,C	4,2,C	1,2,D	1,2,C	1,2,C/D	1,2,C	1,2,D
1 Hour		5,2	5,2					
1 Day	7	7	7	1,2	1,2	1,2	1,2	1,2
2 Day					1,2	1,2		
3 Day				1,2	1,2	1,2		
5 Day					1,2	1,2	1,2	1,2
6 Day				1,2	1,2	1,2	1,2	1,2

15 Day				1,2	1,2	1,2	1,2	1,2
1% in 300 ppm HW								
Initial	2,4,C	4,2,A	4,2,A	3,D,8	1,2,B/C	1,2,C/D	1,2,B+	1,2,C
1 Hour		4,2	4,2	3,9				
2 Hours	4,X				1,2	1,2		
1 Day	4,X	4,0	5,0	3,0	1,2	1,2	1,2	1,2
2 Day	4,9	4,0	5,0	4,0	1,2	1,2		
3 Day		4,0	5,0	4,0				
5 Day	4,0				1,2	1,2		
6 Day		4,0	5,0	4,0	1,2	1,2	1,2	1,2
15 Day		4,0	5,0	4,0	1,2	1,2	1,2	1,2

Appearance Key:

1 = clear	A = light foam
2 = stable	B = low foam
3 = very light haze	C = medium foam
4 = light haze	D = high foam
5 = haze	
6 = opaque, milky	X = oil droplets at the top
7 = layers	
8 = very light scum	
9 = light scum	
0 = scum, creamy	

[00179] Table 30. Synthetic Metalworking Formulation with Potassium Hydroxide

Component	72C	72B	72A	71C	71B	71A
DI Water	70.57	69.54	64.29	73.38	73.41	67.52
KOH, 45%	3.47	3.83	9.74	3.62	3.96	9.76
DIACID 1550			8.19			8.06
DIACID1550 2-Ethyl-1-hexanol Partial Ester		8.52			8.14	
DIACID1550 1-Dodecanol Partial Ester	8.39			8.11		
EM-550	10.06	10.42	10.13	10.54	10.26	10.46
EMPHOS TS-230	4.07	4.18	4.18	4.35	4.23	4.20
Ethox TMO14A	3.43	3.52	3.47			
Appearance						
Concentrate						
Initial	1,2,C	1,2,C	1,2,D	4,2,C	4,2,C	1,2,D

1 Hour				5,2	5,2	
1 Day	1,2	1,2	1,2	7.00	7.00	1,2
2 Day	1,2	1,2	1,2			
3 Day	4,2	1,2	1,2			1,2
6 Day	7,X	1,2	1,2			1,2
15 Day		1,2	1,2			1,2
1% in 300 ppm HW						
Initial	1,2,B/C	1,2,B/C	4,D,8	4,2,A	4,2,A	3,D,8
1 Hour				4,2	4,2	3,9
1 Day	1,2	1,2	3,0	4,0	5,0	3,0
2 Day	1,2	1,2	4,0	4,0	5,0	4,0
3 Day	1,2	1,2	4,0	4,0	5,0	4,0
6 Day	1,2	1,2	4,0	4,0	5,0	4,0
15 Day	1,2	1,2	4,0	4,0	5,0	4,0

Appearance Key:

1 = clear	A = light foam
2 = stable	B = low foam
3 = very light haze	C = medium foam
4 = light haze	D = high foam
5 = haze	
6 = opaque, milky	X = oil droplets at the top
7 = layers	
8 = very light scum	
9 = light scum	
0 = scum, creamy	

[00180] Results for the potassium hydroxide based synthetic formulation can be found in Tables 29 and 30. They represent the examination of the partial esters in the potassium hydroxide based synthetic formulation unmodified and modified with HLB adjusting additives of three chemistries. The nonionic HLB adjusting additives were a nonylphenol 7 mole ethoxylate (TERGITOL NP-7), a Ingevity DIACID 1550 12 mole ethoxylate (OCD-383), and a tall oil fatty acid 14 mole ethoxylate (Ethox TMO14A). It should be noted here that the Ingevity DIACID 1550 ethoxylate with 12 moles EO (OCD-383) was one of the best performers in studies above and its formulation had the lowest foam.

[00181] DIACID 1550 partial esters of n-Pentanol, 2-Ethyl-1-hexanol, and 1-Dodecanol have properties that can be used in semi-semisynthetic and synthetic

metalworking fluid formulations. In properly balanced systems, they provide very good results with regard to emulsion stability in hard water. This hard water stability is a significant improvement over DIACID 1550. The DIACID 1550 partial esters have enhanced lubrication and comparable corrosion inhibition properties to DIACID 1550. The partial esters give very good results in synthetic systems when nonionic surfactants are used to adjust the HLB of the formulation. In semi-synthetic systems, a coupling solvent can be used to optimize formulation stability. The partial esters appear to have significantly better flexibility when compared to DIACID 1550 in semi-synthetic formulations. These experiments demonstrate that DIACID 1550 partial esters of alcohols can be used as products for metalworking.

[00182] Comparison of the Lubricity and Hydrolytic Stability of DIACID 1550

2-Ethyl-1-hexanol Partial Ester and TOFA Ester Lubricant. DIACID 1550 2-Ethyl-1-hexanol partial ester was analyzed for lubricity, and compared to an identical formula containing an industry standard TOFA Ester Lubricant (Polartech LA 8330). The DIACID 1550 2-Ethyl-1-hexanol partial ester was further tested for hydrolytic stability, and that data was measured against a standard ester used for comparison testing. The DIACID 1550 2-Ethylhexanol formulation utilized is shown in Table 31.

[00183] Table 31. DIACID 1550 2-Ethylhexanol Formulation Utilized in the 4Ball Test

Ingredient	% by Vol
Water	57.6 (note: STL Tap ~120 ppm)
Amine Borate	8
Carboxylic Acid	12
Amino Alcohol	5
Test Ester	5
Neodecanoic Acid	5
Propylene Glycol	3
Passivators, Inhibitors, dye	4.4
Total	100

[00184] Wear scar diameter was measure using a 4Ball instrument. The instrument was set to ramp from 0 Kg to 200 Kg of pressure over the course of 20 minutes with the apparatus revolving at a constant 600 rpms. While the pressure ramped, fluid temperature, torque, wear, and coefficient of friction were tracked. The data are graphed, and can be compared between tests. The data point that is of the most importance is the measured scar diameter at the end of the test, measured in millimeters. Other data points that bear attention are in the column “Value at Cursor,” which indicate the maximum value of each parameter at 200 Kg of pressure after 20 minutes. These data points have been collated into the Table 32.

[00185] Table 32. 4Ball Test Data for Ester Lubricants

4Ball Test Data for Ester Lubricants (20 minute ramp to 200Kg @ 600rpm)			
	DIACID 1550 2-Ethylhexanol Partial Ester	LA-8330	EL Ester
Scar diameter (mm)	0.89	0.95	1.05
Torque (kgf*m)	0.0756	0.0976	0.0921
Coefficient of Friction	0.08	0.11	0.1
Fluid Temp (F)	127	157	150

[00186] The data of Table 32 indicate that DIACID 1550 2-Ethyl-1-hexanol partial ester is an excellent lubricant compared to the Standard TOFA Ester Lubricant (Polartech LA 8330) and the Standard Ester (EL Ester). Figures 1-3 are graphs of the 4Ball Test Data for DIACID 1550 2-Ethyl-1-hexanol partial ester, the Standard TOFA Ester Lubricant (Polartech LA 8330), and the Standard Ester (EL Ester), respectively.

[00187] Large esters often have low hydrolytic stability, so this parameter was tested on the DIACID 1550 2-Ethyl-1-hexanol partial ester in comparison with a standard methyl ester used for an ester benchmark. The test method was as follows:

1. Add 2000 ppm of deionized water to test ester.
2. An aliquot of the water/ester mix was sealed in 5 different sealed vials.
3. One vial was retained to test acid value before heating.
4. The vials were placed in a 180°C oven.

5. Periodically, a vial was removed, allowed to cool, and then the Acid Value was run and the number of days in the over was recorded.
6. Over the course of two weeks all vials were tested. The 5th vial was tested on day 14.

[00188] An increase in the acid value indicates hydrolysis is occurring. Less increase in acid value indicates better hydrolytic stability. The data for the hydrolytic stability is shown in Table 33.

[00189] Table 33. Hydrolytic Stability Test for Ester Lubricants

Hydrolytic Stability Test for Ester Lubricants (14 days in water in sealed vial at 180°C)		
Sample	DIACID 1550 2-Ethylhexanol Partial Ester	Methyl Ester Standard
Starting Acid Number	99.12	0.27
Final Acid Number	110.32	5.44

[00190] The data indicates that DIACID 1550 2-ethylhexyl partial ester is relatively hydrolytically stable. Paired with the lubrication data, this information indicates that DIACID 1550 2-ethylhexyl partial ester is a very effective ester boundary lubricant for metalworking fluids.

[00191] **Comparison of Lubricity Between Semi-Synthetic Metalworking Fluid with DIACID 1550 2-Ethylhexyl Partial Ester and a Lubricant Used in the Industry.**

DIACID 1550 2-Ethylhexyl Half Ester containing Semi-synthetic Metalworking Fluid (78-60B) and an Industry Standard Lubricant containing Semi-synthetic Metalworking Fluid (78-60C) were examined via a microtap testing and Falex pin and vee block, shake foam test, cast iron chip test, hard water stability, and emulsion stability.

[00192] Microtap testing involved a test bar of the desired alloy with pre-drilled holes through it. These holes were filled with metalworking fluid diluted to 10% in deionized water, then a tapping bit was driven into each hole. The instrument rotated the tapping bit at 500 rpm, and had a torque gauge attached. Four holes were tapped with each fluid, and the

mean value of the torque was reported as the work performed by the tapping tool. Lubrication of the formulas was evaluated with 1018 Steel and 6061 Aluminum. The results are shown in Tables 34 and 35 and Figures 4-7. With the fluid being the only variable, the lowest mean value determines the best fluid. The mean value is the average torque over the depth of cut.

[00193] Table 34. Microtap Results on Aluminum

Fluid Comparison at Plateau .2 to 14mm of 14.5mm depth of cut						
Comment	Fluid Results			Calculated Efficiency vs.		
	Fluid	Mean Average	Std Dev	Reference Fluid	Best Fluid	All Fluids
10%	78-60B	2.794	0.822	100.0%	98.8%	99.4%
10%	78-60C	2.761	0.872	101.2%	100.0%	100.6%

** The Reference Fluid is >>> 78-60B

[00194] Table 35. Microtap Results on Steel 1018

Fluid Comparison at Plateau .2 to 13.7mm of 14.0mm depth of cut						
Comment	Fluid Results			Calculated Efficiency vs.		
	Fluid	Mean Average	Std Dev	Reference Fluid	Best Fluid	All Fluids
10%	78-60B	4.334	1.329	100.0%	97.0%	98.5%
10%	78-60C	4.263	1.307	103.1%	100.0%	101.6%

** The Reference Fluid is >>> 78-60B

[00195] Falex testing evaluates the lubrication of a metalworking formula. The test was run using steel or aluminum pin and vees. The test was run with steel pin and vee blocks at 5% dilution of the formulas in 100 ppm hardness water. A return to zero torque signifies a failure. As can be seen in Figure 8, the Industry Standard Lubricant Semi-synthetic Metalworking Fluid (78-60C) failed the test, while DIACID 1550 2-Ethylhexyl Partial Ester Semi-synthetic Metalworking Fluid (78-60B) did not.

[00196] The shake foam test evaluates the foaminess of a metalworking fluid by placing 50mL of a 5% solution in deionized water into a 100mL stoppered graduated cylinder. The cylinder is then shaken vigorously for 10 seconds. The foam height at t = 0 is measured, as is the time for the foam to dissipate to 0 mL. The data from the shake foam test is shown in Table 36.

[00197] Table 36. Shake Foam Test Data

Shake Foam Test Deionized Water		
Sample	78-60B	78-60C
Foam height	80 mL	80 mL
Time to dissipate	10s	14s

[00198] Next, the samples were tested using the cast iron chip corrosion test. Any appearance of rust indicates a failure of the fluid to prevent corrosion. Images of the test

paper are shown in Figures 9 and 10. The test was run at 100 ppm hardness and 500 ppm hardness water at varying dilutions of the formulas. In both tests, the DIACID 1550 2-Ethylhexyl Partial Ester Semi-synthetic Metalworking Fluid (78-60B) and the Industry Standard Lubricant Semi-synthetic Metalworking Fluid (78-60C) have comparable performance for cast iron corrosion inhibition.

[00199] Hard water tolerance was examined with by diluting the formulas to 5% in water of varying hardness. The two samples on the left in Figure 11 are the DIACID 1550 2-Ethylhydroxyl Semi-synthetic Metalworking Fluid formulation (78-60B) and the two on the right are the Industry Standard Lubricant Metalworking Fluid formulation (78-60C). The translucent dilutions are 500 ppm hardness water, the opaque solutions are 1000 ppm hardness water. These formulas show no variation in their degree of hard water tolerance, both are still stable emulsions at 1000 ppm hardness.

[00200] Emulsion stability was examined by heating the formulation concentrates to 120°C for 4 hours, cooled to 0°C for 4 hours, and then allowed to return to room temperature. At each stage these formulations were observed to be equally stable, indicating that the balance of emulsifier to oil and water is stable in both formulations. Neither formula exhibited better emulsion stability than the other.

[00201] These tests demonstrate that Industry Standard Lubricant Semi-synthetic Metalworking Fluid (78-60C) and the DIACID 1550 2-Ethylhydroxyl Semi Synthetic Metalworking Fluid (78-60B) have similar lubricating abilities. These tests indicate that the two formulas have similar characteristics with regard to corrosion protection properties, and emulsion and hard water stability. Formula Industry Standard Lubricant Semi-synthetic Metalworking Fluid (78-60C) has 3% better lubrication in the microtap torque test using steel than DIACID 1550 2-Ethylhydroxyl Semi Synthetic Metalworking Fluid (78-60B), though this difference is minor. Furthermore, there is not a statistically significant difference between these lubricants in the microtap test tapping aluminum alloy. It was observed that DIACID 1550 2-Ethylhydroxyl Semi -synthetic Metalworking Fluid (78-60B) had faster foam dissipation in the shake test than the Industry Standard Lubricant Semi-synthetic Metalworking Fluid (78-60C).

[00202] **Comparison of Semi-synthetic Metalworking Fluids Containing Either DIACID 1550 2-Ethyl-1-hexanol Half Ester or Priolube™ 3952.** The Semi-synthetic metalworking fluid formulations are shown in Table 37.

[00203] Table 37. Semi-synthetic Metalworking Fluid Formulations

	DIACID 1550 2-Ethylhexyl Partial Ester Semi-Synthetic Metalworking Fluid Formulation	Priolube 3952™ Semi- Synthetic Metalworking Fluid Formulation
Hydrocal 100 (100 SUS Naphthenic Oil)	20.0	20.0
Polartech® EA™ 646	7.5	7.5
M28 (tall oil fatty acid)	3.0	3.0
Test Lubricant	5.0 (DIACID 1550 2- Ethylhexyl Partial Ester)	5.0 (Croda Priolube™ 3952 – Self-emulsifying ester)
Emulsogen M-A (fatty alcohol ethoxylate)	3.5	
ANTAROX® RA-40 (fatty alcohol ethoxylate/propoxylate)	2.0	2.0
DIACID 1550	1.0	1.0
Polyphase FX-40 (fungicide)	1.0	1.0
DIGLYCOLAMINE®	5.0	5.0
Triethanolamine, 85%	5.0	5.0
AQUALOX™ 232 (corrosion inhibitor)	6.0	6.0
CORRGUARD® EXT (bioresistant amine/coupler)	0.75	0.75
Deionized Water	38.15	38.15
CONTRAM™ ST-1 (bactericide)	2.0	2.0
FOAM BAN® HP-753 (defoamer)	0.1	0.1

[00204] The 100 SUS naphthenic oil Hydrocal 100 was acquired from Calumet Refining (Calumet Specialty Products Partners, L.P., 2780 Waterfront Pkwy. E. Dr. Suite

200, Indianapolis, IN 46214, USA). The 460 molecular weight, medium molecular weight, natural sodium petroleum sulfonate Polartech[®] EA[™] 646 was acquired from Afton[®] Chemical (Afton[®] Chemical, 500 Spring Street, Richmond, VA, 23219, USA). Tall oil fatty acid M-28 was acquired from Ingevity (Ingevity, South Carolina). Fatty alcohol ethoyleate emulsifier Emulsogen M-A was acquired from Clariant (Clariant SE, Rothausstrasse 61, 4132 Muttensz 1, Switzerland). Fatty alcohol/propoxylate ANTAROX[®] RA-40 was acquired from Solvay (Solvay, 3333 Richmond Avenue, Houston, TX 77098, USA) or Rhodia (Immeuble Coeur Défense, Tour A, 37eme etage, 110 esplanade Charles de Gaulle, Courbevoie, Île-de-France, France). DIACID 1550 was acquired from Ingevity (Ingevity, South Carolina). Fungicide Polyphase FX-40 (IPBC-iodopropynylbutyl-carbamate) was acquired from Troy (Troy Corporation, 8 Vreeland Road, PO Box 955, Florham Park, New Jersey, 07932 USA). DIGLYCOLAMINE[®] was acquired from Huntsman (Huntsman Corporation, 10003 Woodlock Forest Dr. The Woodlands, TX 77380, USA). Triethanolamine (85%) was acquired from Dow[™] Chemical (Dow[™] Chemical, 2030 Dow Center, Midland, MI 48674, USA), 15% present in water. Corrosion inhibitor AQUALOX[™] 232 was acquired from Lubrizol (The Lubrizol Corporation, 24900 Lakeland Boulevard, Wickliffe, Ohio 44092, USA), which is based on INVISTA CORFREE[®] M1 and MEA/TEA. Bioresistant amine/coupler CORRGUARD[®] EXT was acquired from ANGUS[®] Chemical (ANGUS[®] Chemical, 1500 E Lake Cook Rd, Buffalo Grove, IL 60089, USA). Bactericide CONTRAM[™] ST-1 (methylenebismorpholine) was acquired from Lubrizol (The Lubrizol Corporation, 24900 Lakeland Boulevard, Wickliffe, Ohio 44092, USA). Defoamer FOAM BAN[®] HP-753 was acquired from Münzing (MÜNZING CHEMIE GmbH, Münzingstrasse 2, 74232 Abstatt, Germany).

[00205] The components found in Table 37 were added in the order in which they are found in the table. The 100 SUS naphthenic oil was added to a beaker with a magnetic stirrer. The agitator was turned on and the oil heated to a temperature slightly above room temperature (40-45°C). In larger batches, for example in a 5 gallon drum, the 100 SUS naphthenic oil was preheated. Sodium sulfonate was warmed to about 50°C in an oven. The hot sodium sulfonate was then added to the naphthenic oil while the agitation continued. The sodium sulfonate is quite viscous, so the heat was used to enable the sodium sulfonate to more quickly dissolve in the naphthenic oil.

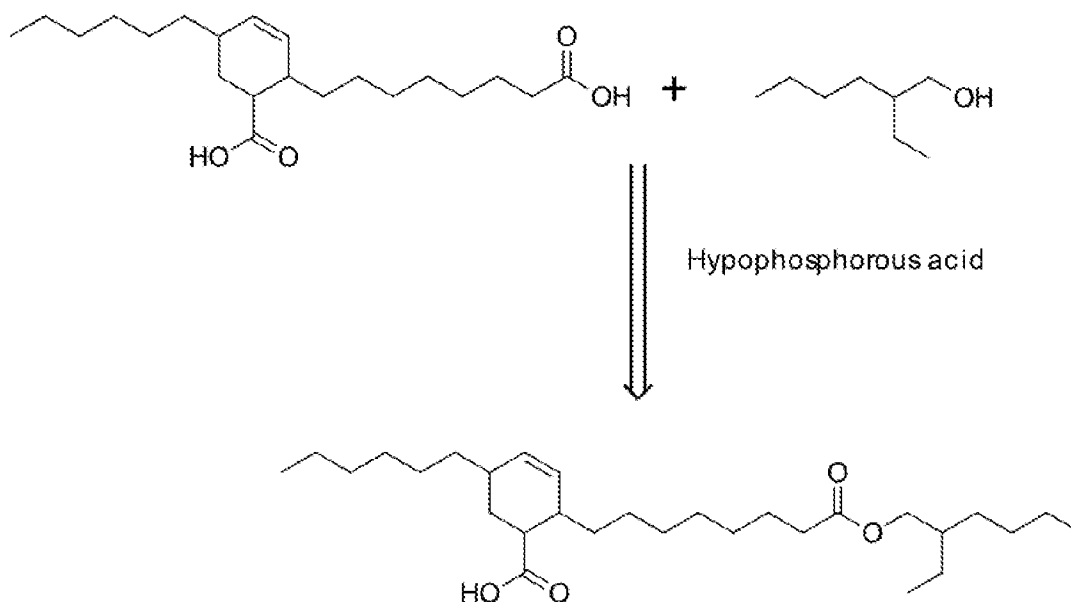
[00206] The remaining ingredients were added in the order provided in Table 37 without the use of any heat and assuring uniform dispersal prior to the addition of the next ingredient. In some embodiments, the defoamer was not utilized. Examination of the formulations is shown in Table 38.

[00207] Table 38.

Parameter	Result
Appearance	Clear Amber Liquid
Odor	Characteristic Amine
pH, 5% (deionized water)	9.35
Specific Gravity , 60/60 F	0.997
Density – lbs/gallon	8.32
5 Day Low Temperature Stability Testing (0°C to -2°C)	Remained Homogeneous
5 Day High Temperature Stability Testing (40°C)	Remained Homogeneous

[00208] Comparison of the DIACID 1550 2-Ethyl-1-hexanol partial ester and the Priolube™ 3952 containing semi-synthetic metal working fluids are shown in Figures 12-15.

[00209] **Exemplary Method of Producing DIACID 1550 2-Ethylhexanol Partial Ester.** DIACID 1550 and 2-Ethylhexanol were reacted at a 2:1 mole ratio. Hypophosphorous acid was used as catalyst (0.25 wt% of Diacid). The reaction and the resultant products are shown below.



[00210] Four batches of DIACID 1550 were analyzed by non-polar GC to determine the differences of C18 monounsaturated acid percentage then used to prepare DIACID 1550 2-Ethylhexanol Partial Ester to examine the variability of the final product specifications. These results are shown in Table 39.

[00211] Table 39. Batch Rest Results for DIACID 1550 2-Ethylhexanol Partial Ester

Diacid 1550	Acid Number	C18 monounsatur. %	Partial Ester AN	Partial Ester Color
Old	270.27	8.1	112.25	6.6
03/31/2015	270.20	7.4	108.40	6.9
04/20/2015	278.24	8.4	112.77	6.7
05/19/2015	263.41	4.4	111.4	6.5

[00212] The results demonstrate that various starting DIACID 1550 have little effects on the final partial ester products. Each of the partial esters derived from different batches of DIACID 1550 have similar acid number and color on the Gardner Color Scale (Standard Test Method for Color of Transparent Liquids (Gardner Color Scale) (ASTM D1544-04 (2010))).

[00213] As described herein, the description provides a lubricating fluid composition comprising a partial (i.e., half) ester of a compound derived from the Diels-Alder reaction of a conjugated fatty acid and an acid precursor dienophile. In any of the aspects or embodiments, the acid precursor dienophile is an acrylic acid or acrylic acid ester. In any of the aspects or embodiments, acid precursor dienophile is at least one of methacrylic acid,

maleic anhydride, fumaric acid, a fumaric acid mono or diester or a combination thereof. In any of the aspects or embodiments, the conjugated fatty acid is derived from tall oil fatty acid. In any of the aspects or embodiments, the conjugated fatty acid is linoleic acid. In any of the aspects or embodiments, the compound derived from the Diels-Alder reaction of a conjugated fatty acid and acrylic acid is DIACID 1550, and the partial ester is a DIACID 1550 partial ester. In any of the aspects or embodiments, the DIACID 1550 partial ester is derived from an esterification reaction comprising an alcohol and DIACID 1550, and wherein the reaction comprises a molar excess of carboxyl moieties. In any of the described aspects or embodiments, the alcohol is selected from the group consisting of n-pentanol, 1-dodecanol, 2-ethyl-1-hexanol, and combinations thereof. In any of the described aspects or embodiments, the reaction further comprises a catalyst. In any of the described aspects or embodiments, the catalyst is hypophosphorous acid.

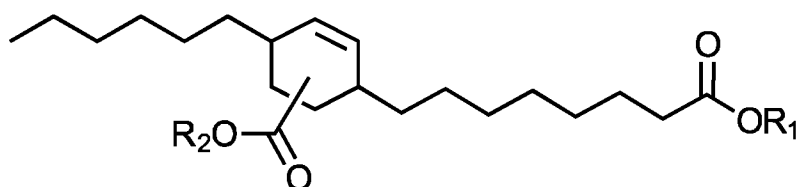
[00214] Additionally, the description provides an aqueous metalworking composition comprising an effective amount of a lubricating compound as described herein. In any of the described aspects or embodiments, the composition comprises an effective amount of the DIACID 1550 partial ester to reduce or inhibit foaming as compared to DIACID 1550 or DIACID 1550 bis-ester alone. In any of the described aspects or embodiments, the composition comprises a semi-synthetic metalworking fluid or a full-synthetic metalworking fluid. In any of the described aspects or embodiments, the metalworking composition is a semi-synthetic metalworking fluid and further includes a coupling solvent. In any of the described aspects or embodiments, the coupling solvent is a glycol ether. In any of the described aspects or embodiments, the glycol ether is tripropylene glycol methyl ether or diethylene glycol monobutyl ether. In any of the described aspects or embodiments, the metalworking composition is a synthetic metalworking fluid and further includes a nonionic surfactant. In any of the described aspects or embodiments, the nonionic surfactant is at least one of a alkylphenol ethoxylate, a linear alcohol ethoxylate, or a DIACID 1550 ethoxylate. In any of the described aspects or embodiments, the alkylphenol ethoxylate is at least one of nonyl phenol ethoxylate and octylphenol ethoxylate. In any of the described aspects or embodiments, the linear alcohol ethoxylate is at least one of: tall oil fatty acid ethoxylate, TERGITOL™ NP-4, TERGITOL™ NP-7, and TERGITOL™ NP-9. In any of the described aspects or embodiments, the DIACID 1550 ethoxylate is at least one of: OCD-383 and OCD-

384. In any of the described aspects or embodiments, the metalworking fluid comprises at least one of a biocide and a fungicide.

[00215] The description also provides a method of lubricating a metal workpiece by applying the aqueous metalworking composition as described in any of the aspects or embodiments described herein to the metal workpiece.

[00216] The description also provides a metalworking process comprising performing a metalworking operation by flushing, spraying, high pressure spraying, brushing, flowing, fluting, roll coating, immersion, or any combination thereof with the aqueous metalworking composition as described in any of the aspects or embodiments.

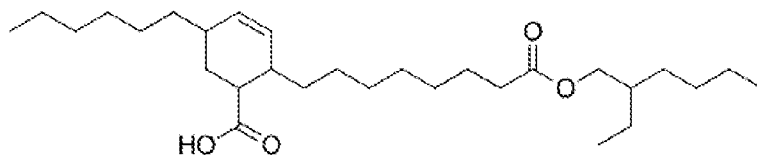
[00217] In certain aspects, the description provides compound having the structure:



[00218]

[00219] wherein R_1 and R_2 are independently selected from the group comprising H, alkyl, alkenyl, cycloalkyl, chloroalkyl, chlorocycloalkyl, polyoxyethylene, polyoxypropylene, or a mixture thereof, and wherein at least one of R_1 or R_2 but not both is H and the other is not. In any of the aspects or embodiments described herein, at least one of R_1 or R_2 but not both is at least one of alkyl, alkenyl, cycloalkyl, chloroalkyl, chlorocycloalkyl, polyoxyethylene and polyoxypropylene. In any of the aspects or embodiments described herein, the composition comprises the compound wherein at least 10 mol% of R_1 and R_2 is H. In any of the aspects or embodiments described herein, the composition comprises the compound wherein up to 90 mol% of R_1 and R_2 are at least one of alkyl, alkenyl, cycloalkyl, chloroalkyl, chlorocycloalkyl, polyoxyethylene and polyoxypropylene.

[00220] In certain embodiments, the compound has the structure :



[00221] As would be understood by those of skill in the art, certain quantities, amounts, and measurements are subject to theoretical and/or practical limitations in precision, which are inherent to some of the instruments and/or methods. Therefore, unless otherwise

indicated, it is contemplated that claimed amounts encompass a reasonable amount of variation.

[00222] It is understood that the detailed examples and embodiments described herein are given by way of example for illustrative purposes only, and are in no way considered to be limiting to the invention. Various modifications or changes in light thereof will be suggested to persons skilled in the art and are included within the spirit and purview of this application and are considered within the scope of the appended claims. For example, the relative quantities of the ingredients may be varied to optimize the desired effects, additional ingredients may be added, and/or similar ingredients may be substituted for one or more of the ingredients described. Additional advantageous features and functionalities associated with the systems, methods, and processes of the present invention will be apparent from the appended claims.

In The Claims:

1. A lubricating composition comprising a partial or half-ester of a compound derived from the Diels-Alder reaction of a conjugated fatty acid and an acid precursor dienophile.
2. The lubricating composition of claim 1, wherein the acid precursor dienophile is an acrylic acid or acrylic acid ester.
3. The lubricating composition of claim 1 or 2, wherein the acid precursor dienophile is at least one of methacrylic acid, maleic anhydride, fumaric acid, a fumaric acid mono or diester or a combination thereof.
4. The lubricating composition of any of claims 1-3, wherein the conjugated fatty acid is derived from tall oil fatty acid.
5. The lubricating composition of any of claims 1-4, wherein the conjugated fatty acid is linoleic acid.
6. The lubricating composition of any of claims 1-5, wherein the compound derived from the Diels-Alder reaction of a conjugated fatty acid and acrylic acid is DIACID 1550, and the partial ester is a DIACID 1550 partial ester.
7. The lubricating composition of any of claims 1-6, wherein the DIACID 1550 partial ester is derived from an esterification reaction comprising an alcohol and DIACID 1550, and wherein the reaction comprises a molar excess of carboxyl moieties.
8. The lubricating composition of any of claims 1-7, wherein the alcohol is selected from the group consisting of n-pentanol, 1-doecanol, 2-ethyl-1-hexanol, and combinations thereof.
9. The lubricating composition of any of claims 1-8, wherein the composition comprises an effective amount of the DIACID 1550 partial ester to reduce or inhibit foaming as compared to DIACID 1550 or DIACID 1550 bis-ester alone.
10. The lubricating composition of any of claims 1-9, wherein the composition comprises a semi-synthetic metalworking fluid or a full-synthetic metalworking fluid.
11. An aqueous metalworking lubricating composition comprising an effective amount of a DIACID 1550 partial ester.
12. The aqueous metalworking lubricating composition of claim 11, wherein the DIACID 1550 partial ester is derived from a reaction comprising an alcohol and DIACID 1550, and wherein the reaction comprises a molar excess of carboxyl moieties.

13. The aqueous metalworking lubricating composition of claim 12, wherein the alcohol is selected from the group consisting of n-pentanol, 1-docecanol, or 2-ethyl-1-hexanol.

14. The aqueous metalworking lubricating composition of any of claims 11-13, wherein the metalworking lubricating composition comprises a semi-synthetic metal working fluid or a synthetic metal working fluid.

15. The aqueous metalworking lubricating composition of any of claims 11-14, wherein the metalworking lubricating composition comprises a semi-synthetic metalworking fluid and a coupling solvent.

16. The aqueous metalworking lubricating composition of claim 15, wherein the coupling solvent is a glycol ether.

17. The aqueous metalworking lubricating composition of claim 16, wherein the glycol ether is tripropylene glycol methyl ether or diethylene glycol monobutyl ether.

18. The aqueous metalworking lubricating composition of any one of claims 1-13, wherein the metalworking composition comprises a synthetic metalworking fluid and a nonionic surfactant.

19. The aqueous metalworking lubricating composition of claim 18, wherein the nonionic surfactant is at least one of a alkylphenol ethoxylate, a linear alcohol ethoxylate, or a DIACID 1550 ethoxylate.

20. The aqueous metalworking lubricating composition of claim 19, wherein the alkylphenol ethoxylate is at least one of nonyl phenol ethoxylate and octylphenol ethoxylate.

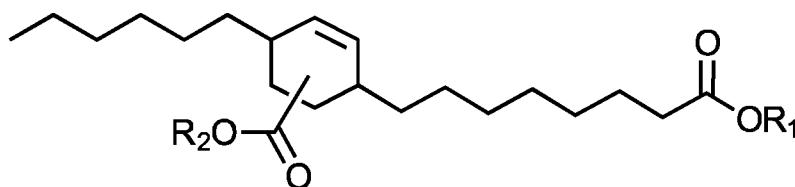
21. The aqueous metalworking lubricating composition of claim 19, wherein the linear alcohol ethoxylate is at least one of a tall oil fatty acid ethoxylate, TERGITOL™ NP-4, TERGITOL™ NP-7, and TERGITOL™ NP-9.

22. The aqueous metalworking lubricating composition of claim 19, wherein the DIACID 1550 ethoxylate is at least one of: OCD-383 and OCD-384.

23. The aqueous metalworking lubricating composition of any of claims 13-22, further comprising at least one of a biocide and a fungicide.

24. A method of lubricating a metal workpiece by applying the aqueous metalworking composition of claim 13 to the metal workpiece.

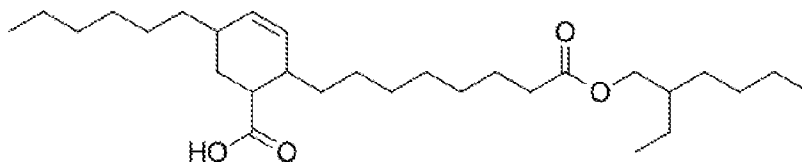
25. A compound having the structure:



wherein R_1 and R_2 are independently selected from the group comprising H, alkyl, alkenyl, cycloalkyl, chloroalkyl, chlorocycloalkyl, polyoxyethylene, polyoxypropylene, or a mixture thereof, and wherein at least one of R_1 or R_2 but not both is H and the other is not.

26. The compound of claim 25, wherein at least one of R_1 or R_2 but not both is at least one of alkyl, alkenyl, cycloalkyl, chloroalkyl, chlorocycloalkyl, polyoxyethylene and polyoxypropylene.

27. The compound of claim 25, wherein the compound has the structure :



28. A composition comprising the compound of claim 25, wherein at least 10 mol% of R_1 and R_2 is H.

29. The composition of claim 28, wherein up to 90 mol% of R_1 and R_2 are at least one of alkyl, alkenyl, cycloalkyl, chloroalkyl, chlorocycloalkyl, polyoxyethylene and polyoxypropylene.

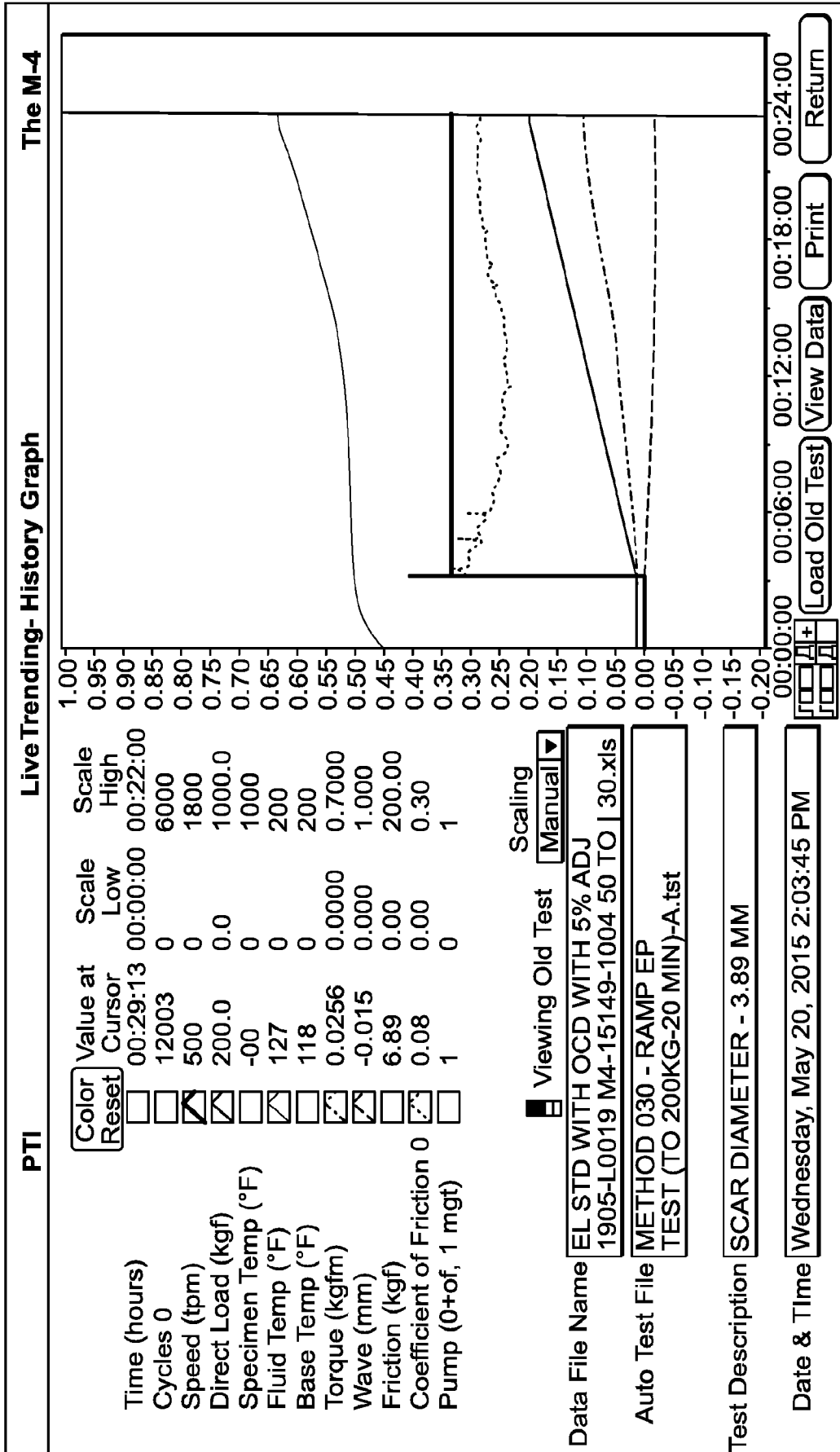


FIG. 1

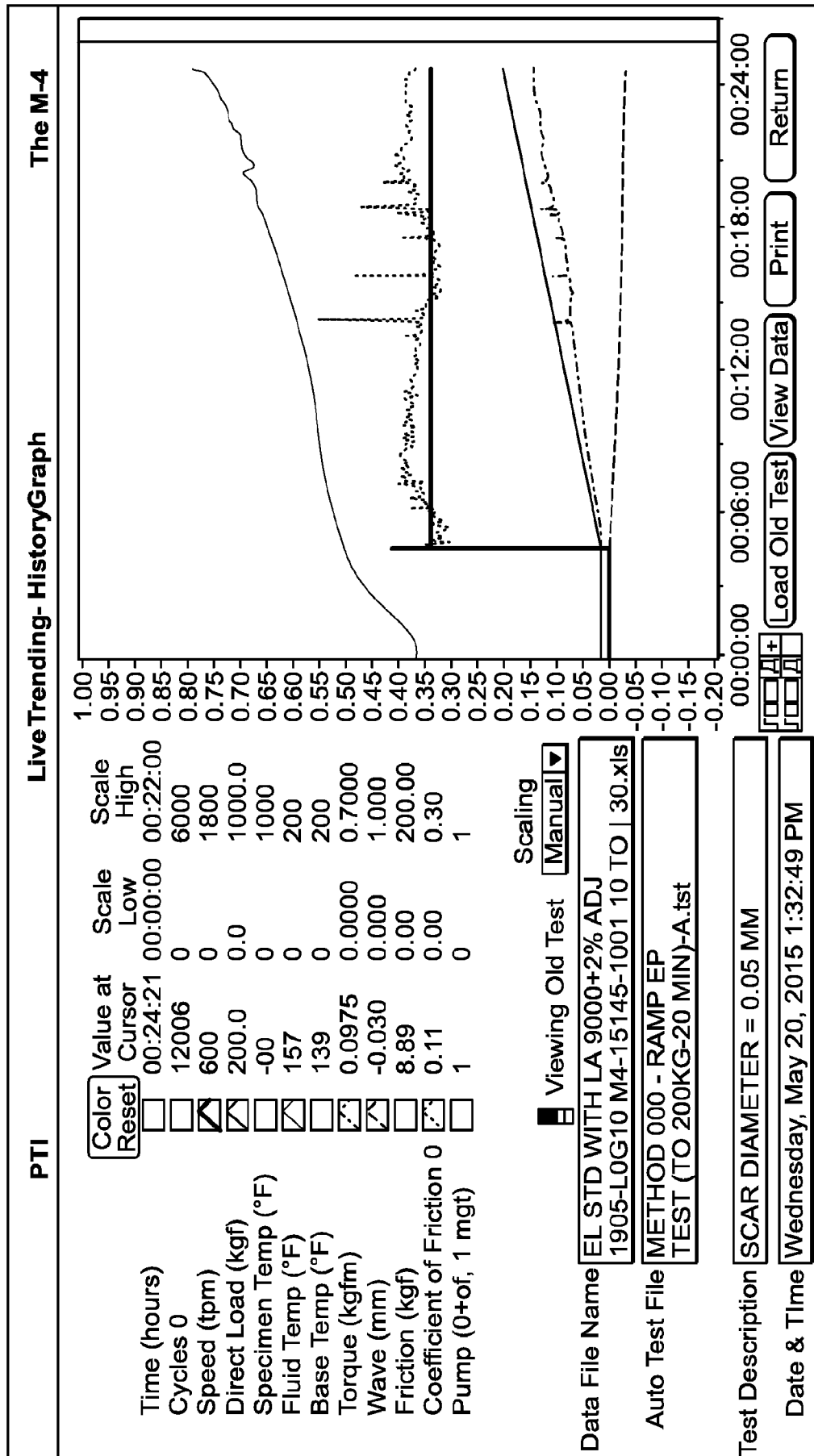


FIG. 2

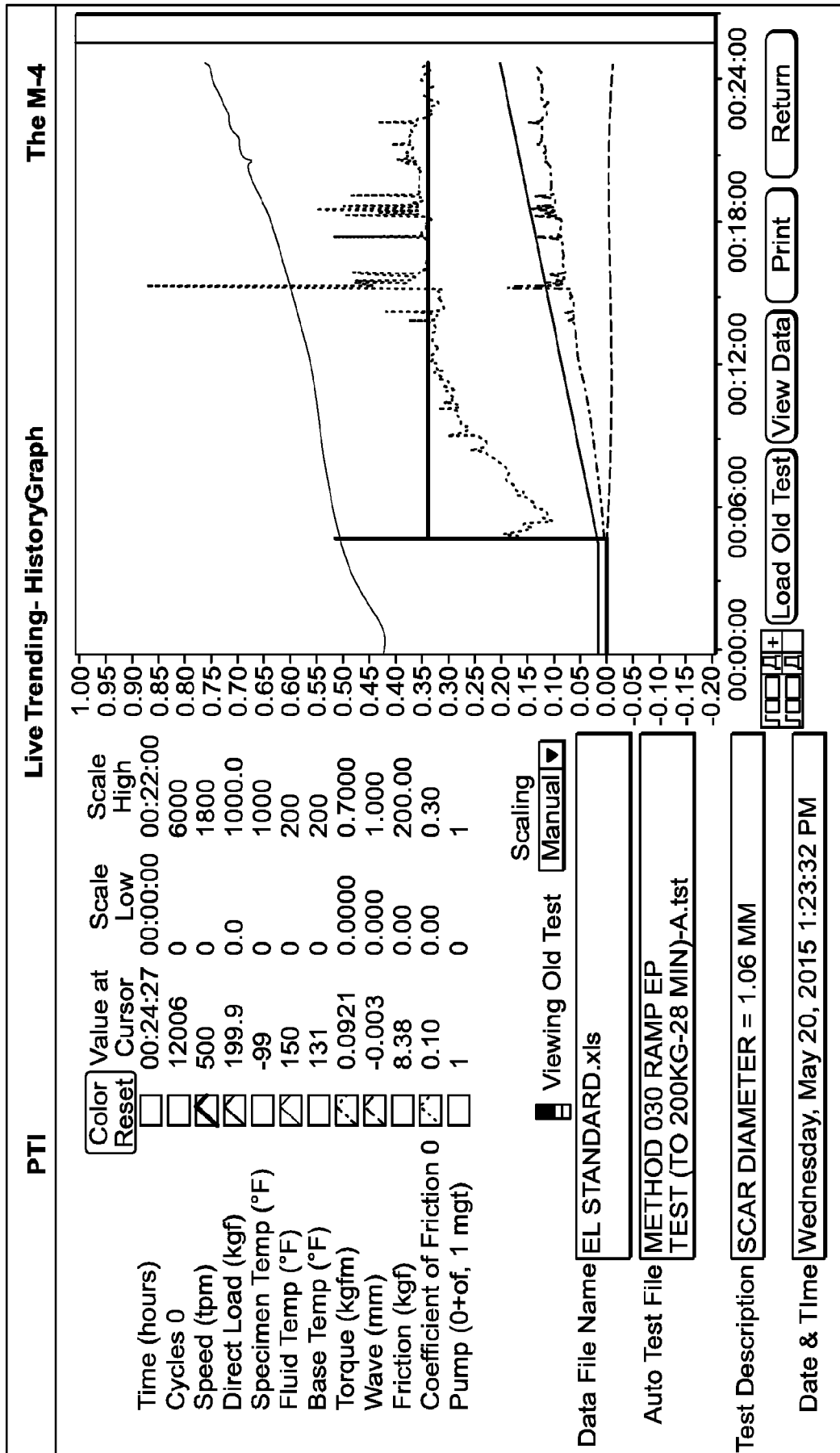


FIG. 3

FIG. 4

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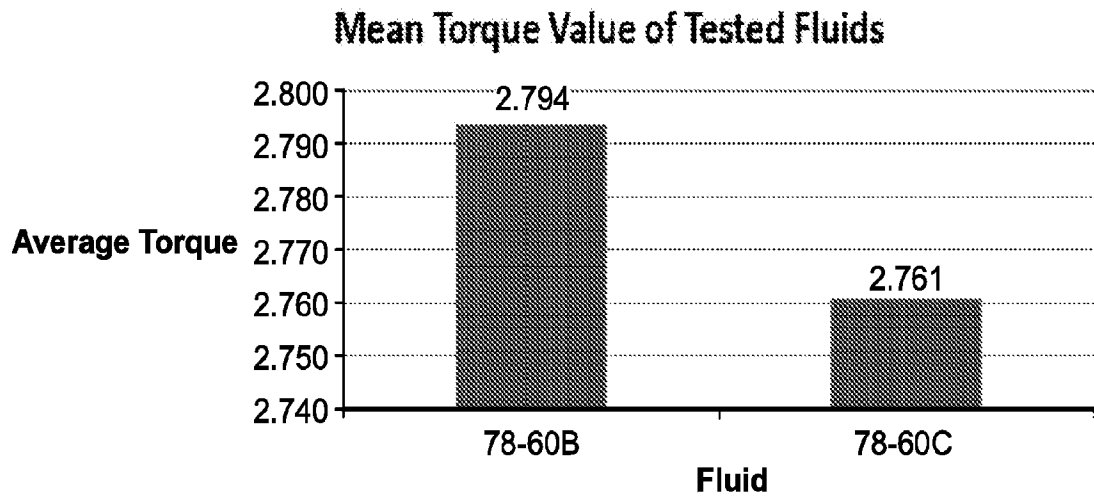


FIG. 5

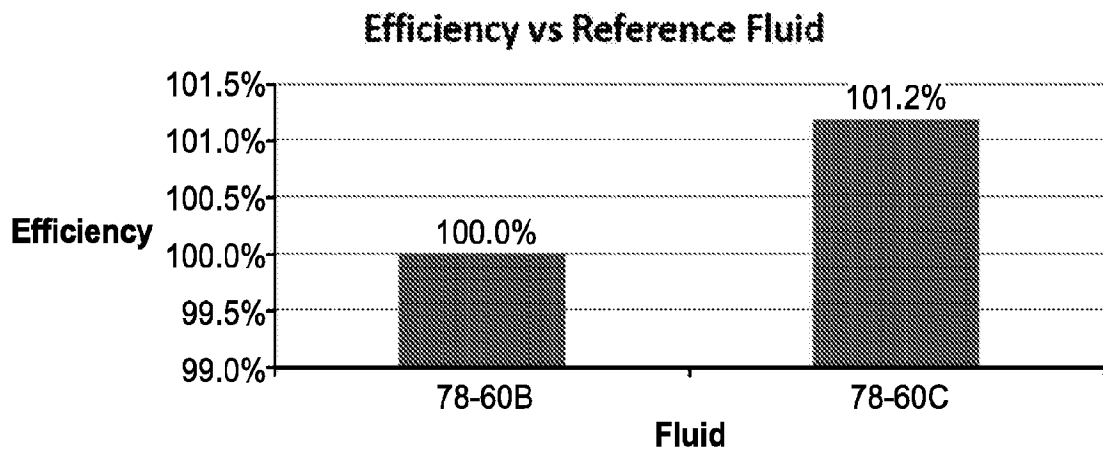
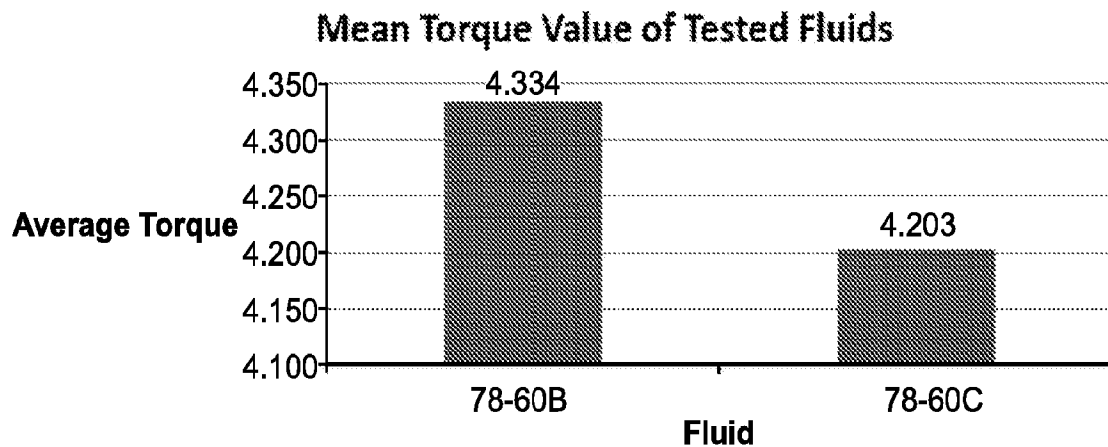


FIG. 6



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FIG. 7

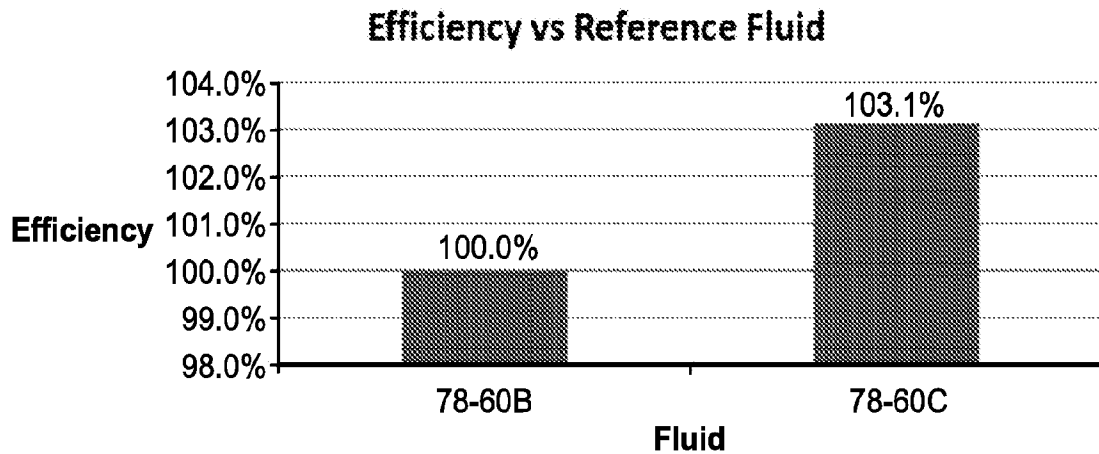
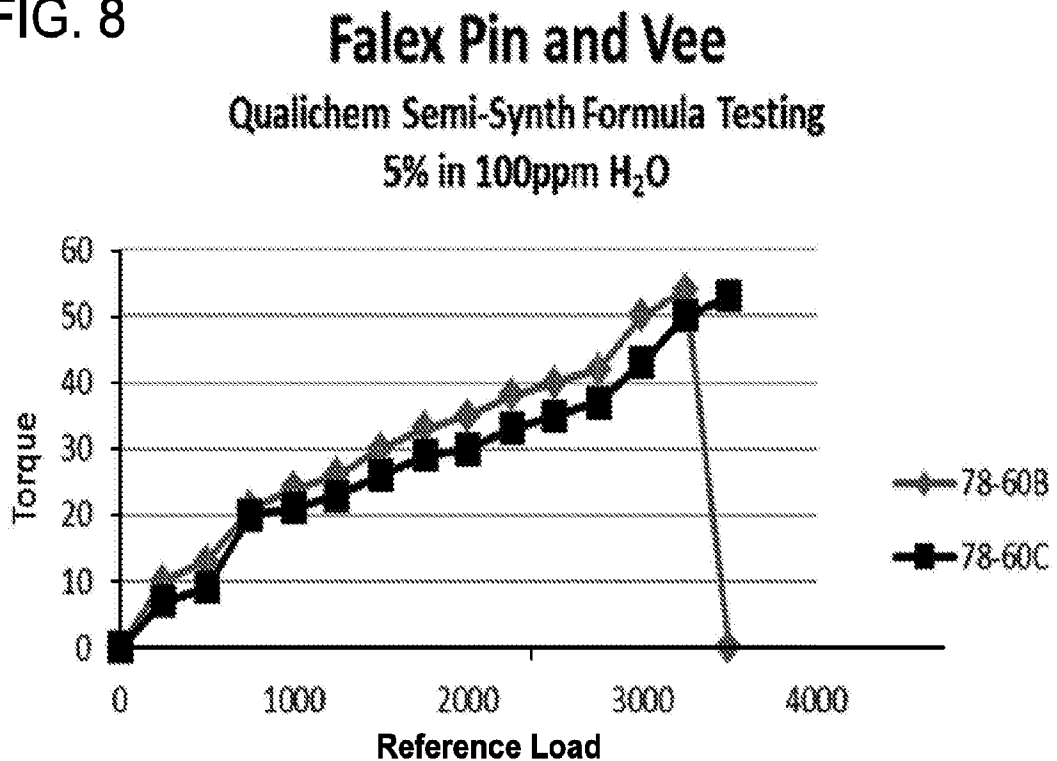


FIG. 8



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FIG. 9

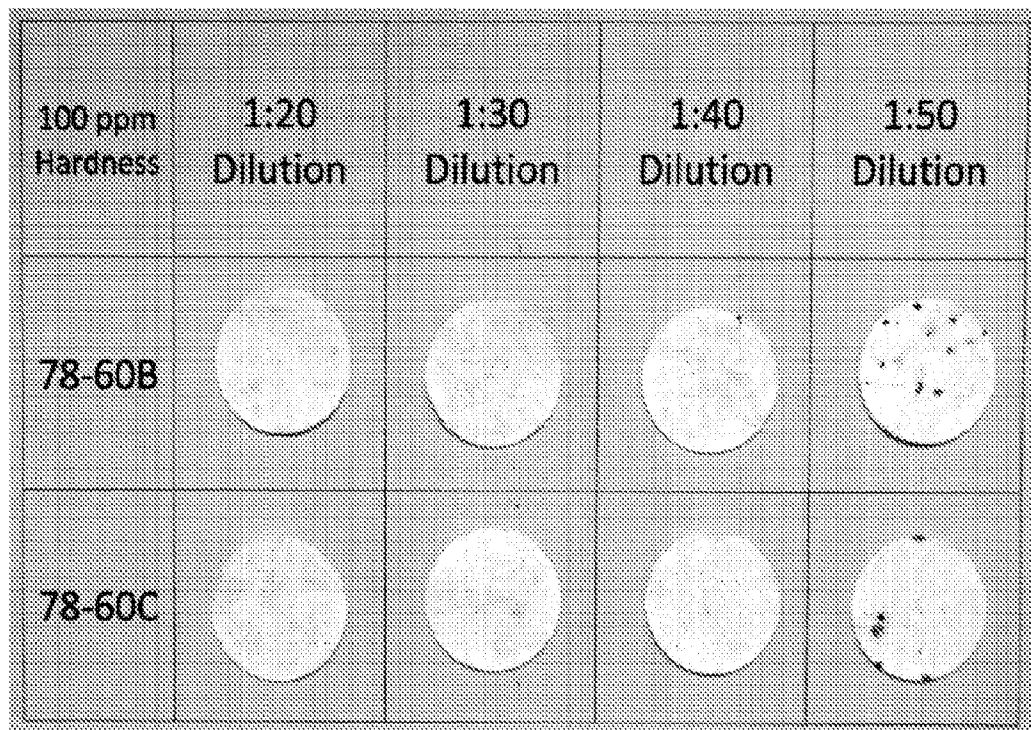
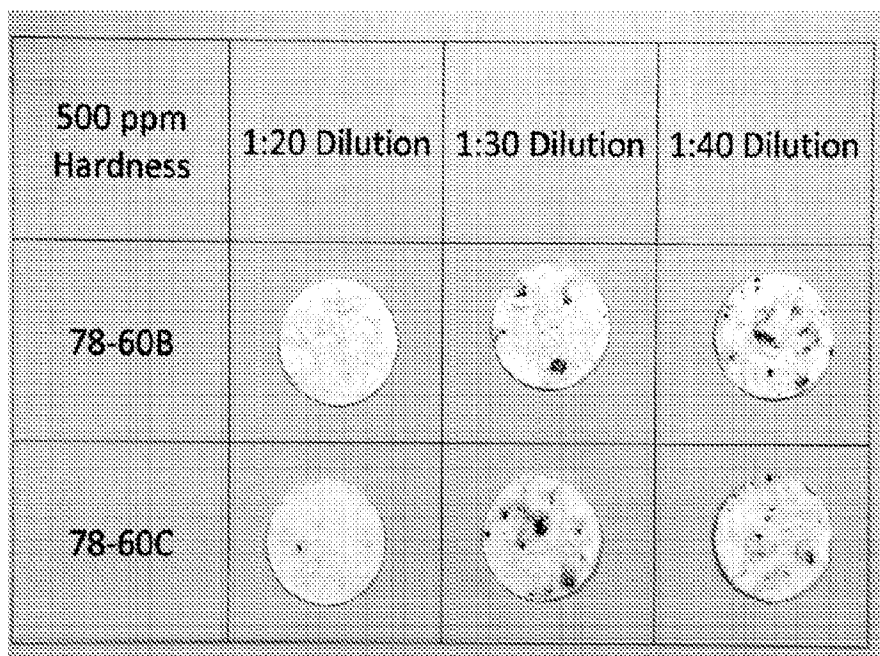


FIG. 10



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FIG. 11

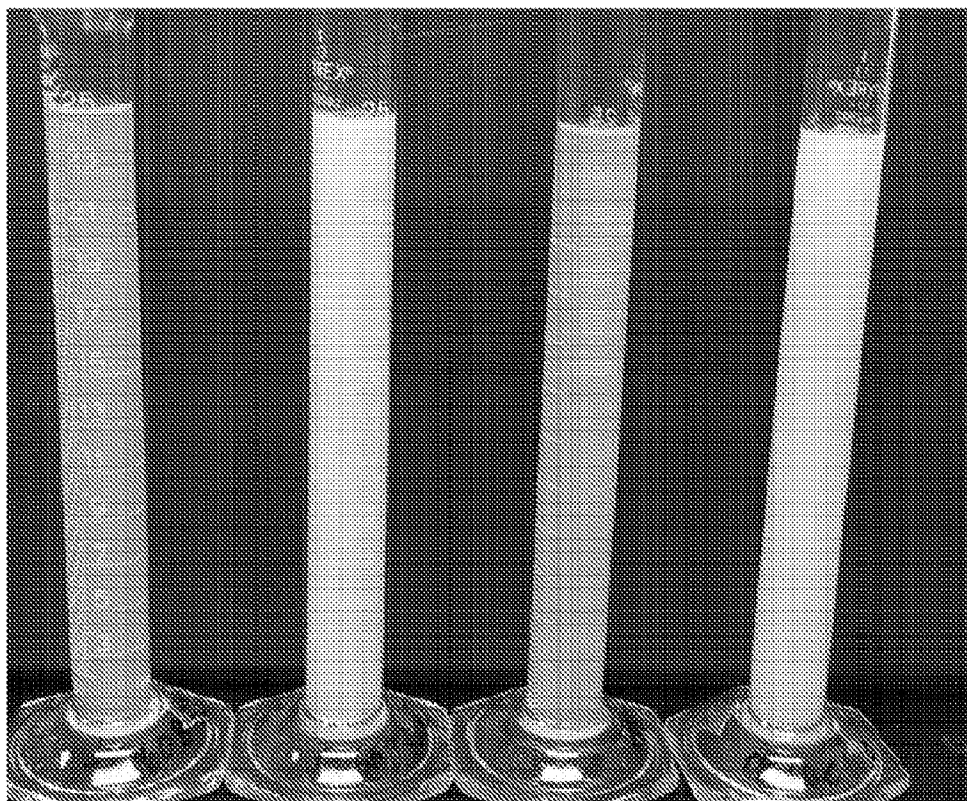


FIG. 12

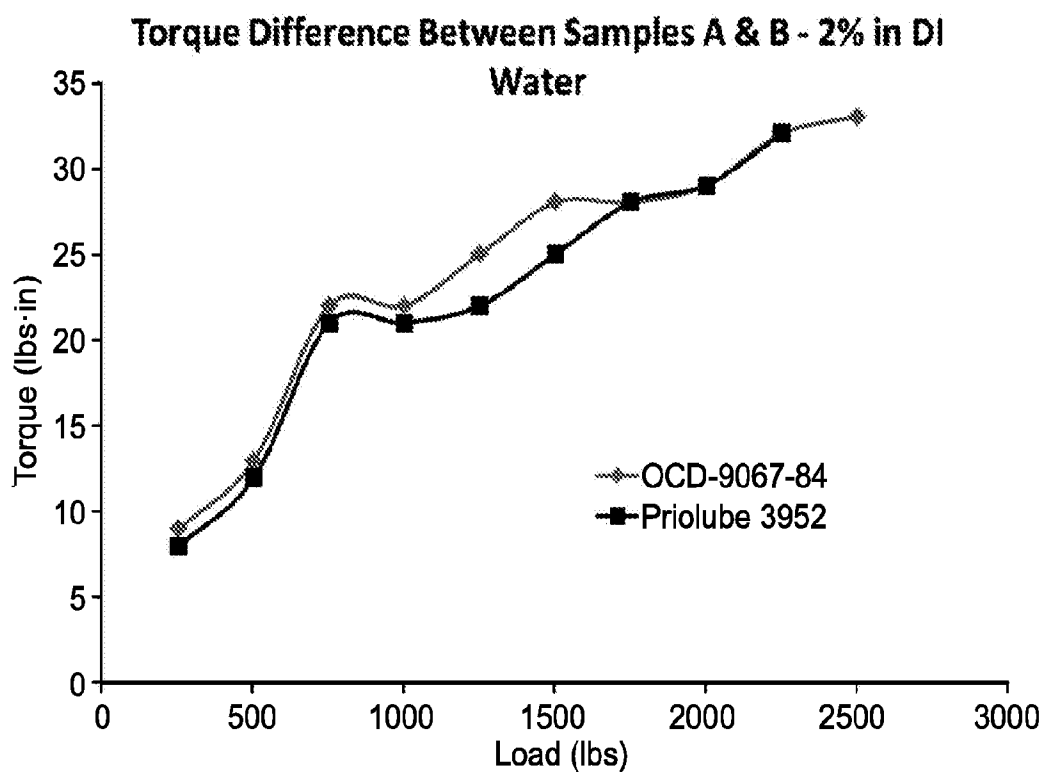


FIG. 13
Torque Difference Between Samples A & B - 5% in DI
Water

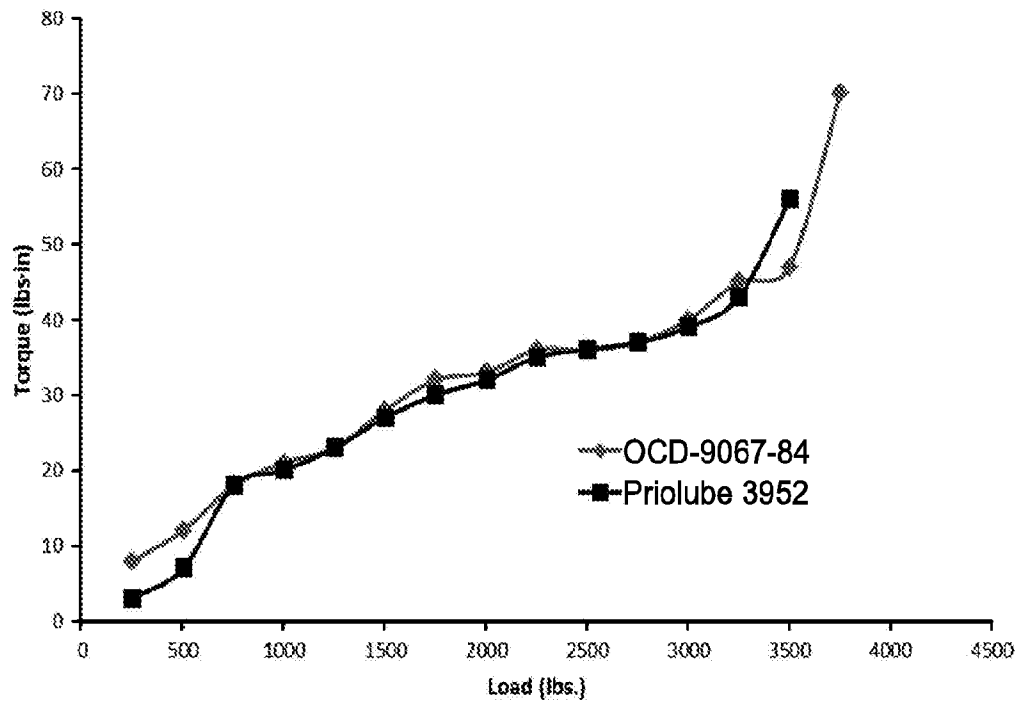
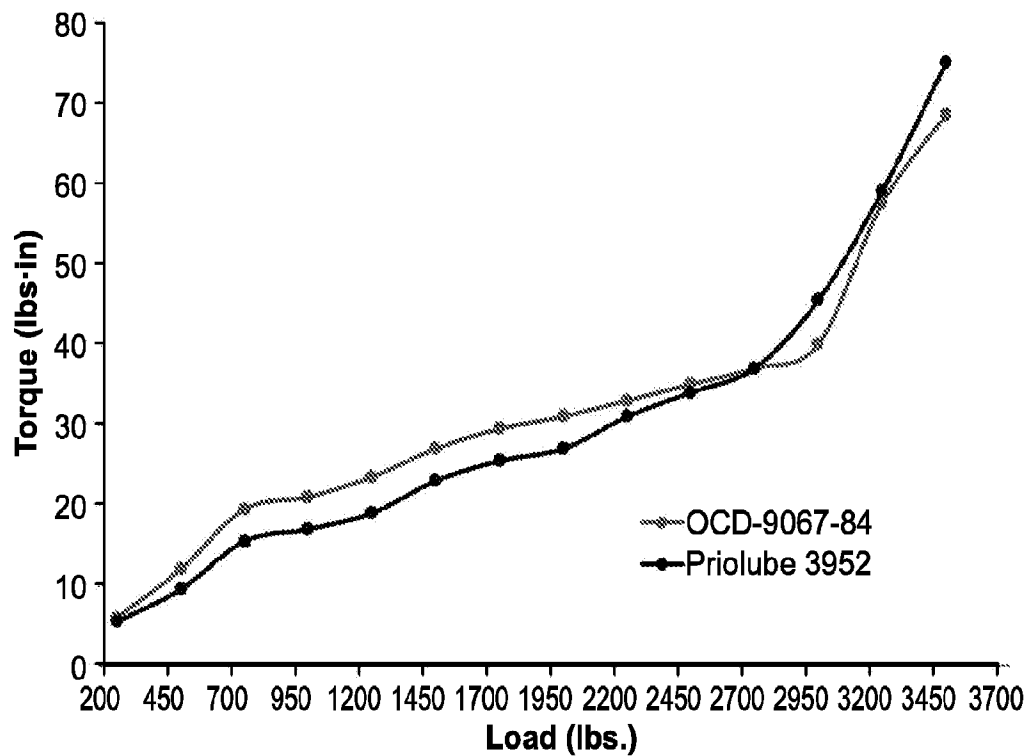


FIG. 14
Torque Difference Between Samples A & B in 300
ppm Hard Water



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FIG. 15

**Torque Difference Between Samples A & B - 5% in
500 ppm Hard Water**

