FUNCTIONAL PRODUCTS INC.
Innovative Chemistry for Lubricants

Industrial Packages

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Functional Products Inc. was founded in 1985. The Quality Management System is certified to ISO 9001:2015 (with design). Functional Products is committed to compliance with current REACH and CLP regulations, including the Globally Harmonized System (GHS) for classification and labeling standard.

Functional Products is an active member or participant in the following professional technical associations: NLGI, ELGI, NLGI India, STLE, KSTLE, AOCS, NSF, UEIL and ILMA.

Functional Products formulates and blends over 200 active products and also provides custom formulary capability for short- and long-run needs.

Headquarters, general offices and manufacturing plant are located in Macedonia, Ohio. Sales offices and stocking points are located throughout the United States and Canada, as well as Latin America, Europe, Australia, India and Asia.

Mission Statement:
Functional Products Inc. is committed to providing our customers with quality products and services that meet or exceed their expectations through the use of continuous improvement.

Health and Safety:
The product descriptions here, in Technical Data Sheets (TDSs) and on product labels are not intended to take the place of a Safety Data Sheet (SDS).

An SDS is provided with each order or sample shipment and can be downloaded from our website: www.functionalproducts.com

Phone: 1-330-963-3060

FUNCTIONAL PRODUCTS INC.
Industrial Packages are fully formulated concentrates that are added to a base oil at performance-specific amounts to create a finished fluid, hydraulic, gear or way oil, that meets all industry standards for the type of fluid.

FUNCTIONAL PRODUCTS INC. offers industrial packages for mineral and vegetable oil to make finished hydraulic fluids, gear oils and way oils. This catalog presents physical data on these packages and the standards met by the finished fluids. Detailed performance data is available upon request.

Noteworthy
FUNCTIONAL PRODUCTS was given the “Best Paper Award” at the ELGI Annual Meeting in Paris for their paper on polymer compatibility in mineral and vegetable oils.

FUNCTIONAL PRODUCTS received an award for its paper at the National Lubricating Grease Symposium in Wuyishan, China.

FUNCTIONAL PRODUCTS contributed to TLT’s article on Viscosity Modifiers and Additives for Grease.

FUNCTIONAL PRODUCTS has authored technical papers and written book chapters (Leslie Rudnick’s Lubricant Additives chapter on tackifiers)

Definitions
Extreme Pressure Property — (EP) The ability of a lubricant to reduce scuffing, scoring and the seizure of contacting surfaces when applied loads are high

Lubricity — The reduction of friction or wear between two load-bearing surfaces, in relative motion, by the addition of a lubricant

Demulsibility — The tendency of an oil to resist emulsification in the sump.

R&O Package — Provides protection against rust and oxidation within the hydraulic system pump. Primarily for piston pumps.

AW Package — Provides protection against wear, rust and oxidation within the hydraulic system pump. Also, contains anti-foam agents. Primarily for vane pumps.

PSSI — The Shear Stability Index value as determined by a mechanical shear test. The PSSI is used to evaluate the shear stress performance of polymers in real applications. Unless otherwise noted, the PSSI herein is based on ASTM D6278.
**Viscosity Modifiers**

Viscosity modifiers are high molecular weight polymers used to increase the viscosity of lubricants. Typically these additives improve the viscosity index as viscosity index improvers and greatly reduce the thinning of oil with heat. Blending with viscosity modifiers rather than high viscosity oil allows for better low temperature fluidity, greater VI, and better adherence in applications like engine oil, chain oil, light duty hydraulics, semi-fluid grease and coatings, heavy duty open gear lubes, and more.

Options are available in solid form as pellet or bale and as liquids with various viscosities and diluent oils. For NSF HX1/HX2 and biobased viscosity modifiers, refer to the *Food Grade* and *Biobased* guides. Olefin copolymers (OCP) of ethylene-propylene chemistry offer the best economics and thickening efficiencies.

### Typical Properties

<table>
<thead>
<tr>
<th>V-290</th>
<th>V-100</th>
<th>V-255</th>
<th>V-135</th>
<th>V-101</th>
<th>V-113</th>
<th>V-201</th>
</tr>
</thead>
<tbody>
<tr>
<td>Form</td>
<td>Pellet</td>
<td>Bale</td>
<td>Pellet</td>
<td>Bale</td>
<td>Bale</td>
<td>Bale</td>
</tr>
</tbody>
</table>
| Shear Stability Index, PSSI  
(ASTM D6278) | 0 SSI | 22 SSI | 25 SSI | 33 SSI | 45 SSI | 50 SSI | 60 SSI |
| Chemistry | Proprietary OCP | OCP | OCP | OCP | OCP | OCP |
| Specific Gravity | 0.98 - 1.02 | 0.86 - 0.88 | 0.86 - 0.88 | 0.86 - 0.88 | 0.86 - 0.88 | 0.86 - 0.88 | 0.86 - 0.88 |
| % Ethylene | Proprietary | 45 - 55% | 12 - 18% | 45 - 55% | 45 - 55% | 50 - 60% | 60 - 70% |
| Thickening Efficiency  
(1wt% in ISO32 Gr. I 100ºC) | 7.6 cSt (10%wt) | 11.0 cSt | 10.5 cSt | 11.9 cSt | 13.0 cSt | 14.6 cSt | 21.0 cSt |
| Treat for 1000 cST @ 100ºC  
(100N Gr. II) | N/A | 9.8 wt% | 13 wt% | 8.3 wt% | 9.0 wt% | 6.6 wt% | 5.4 wt% |
| Solution Viscosity  
(1wt% in 100N Gr. II, @ 100ºC) | 6.2 cSt (10%wt) | 9.0 cSt | 9.0 cSt | 9.7 cSt | 10.1 cSt | 12.2 cSt | 15.0 cSt |

High PSSI (permanent shear stability index) polymers are more effective in modifying oil but more sensitive to mechanical shearing. Low PSSI polymers operate longer under more intense applications but require higher treat levels.

Recommended PSSI for various applications is shown below. For industrial gear and hydraulic fluids requiring low PSSI, consider Functional polymethacrylates in the *Polymethacrylate* guide.
Mineral oils from Group I/II/III stocks contain wax species which gel at low temperature to prevent oil from flowing. Pour point depressants (PPDs) inhibit wax formation and allow paraffinic mineral oils to pour at temperatures down to -50°C / -58°F rather than -12°C / 10°F. Other low temperature properties like Brookfield viscosity, MRV, and cold crank are also improved.

**FUNCTIONAL PD-610** is ideal for most Group I/II and bright stock formulations. **FUNCTIONAL PD-620** is an economical PPD for Group I and naphthenic oils containing waxy additives. **FUNCTIONAL PD-630** is optimized for Group III base stocks. Typical treat levels range from 0.1-0.5wt%.

For vegetable oil PPDs, use 0.3-1.0wt% **FUNCTIONAL PD-585** or consult the Biobased brochure.

Functional Products offers lab testing to screen for the best PPD and optimal treat level for your formulation.
Water Based Products

FUNCTIONAL V-802P is a water-based tackifier and thickener (60,000 cSt at 40°C) for water and water-based fluids. It may also act as a binder for powders and an anti-sag agent in paints. Typical treat rates are 0.3-5wt% depending on desired effect and application.

FUNCTIONAL MW-612 is a concentrated but low viscosity anti-misting emulsion that greatly reduces the formation of coolant mist in metal working applications.

FUNCTIONAL CI-498 is an NSF HX1 corrosion inhibitor based on phosphate salt for lubricants that may have incidental food contact. Use at 0.3-0.5wt%.

FUNCTIONAL AW-487 is an anti-wear and lubricity additive for use in water-based lubricants. AW-487 contains no phosphorus, chlorine, or heavy metals. Use at 0.5-2.0wt%.

Hydraulic Fluid Packages

FUNCTIONAL HF-580 is a non-hazardous light color, low odor hydraulic fluid package which is compatible in a wide range of petroleum oils, biobased esters, PAO, and PAG. HF-580 at ISO 46 in canola passes the ASTM D7043 Vickers Vane Pump Test (V104C) and exhibits excellent demulsibility, rust and copper inhibition, 4-ball wear performance and hydrolytic and thermal stability.

FUNCTIONAL HF-595 is an Ecolabel/LuSC listed hydraulic fluid package meeting European Ecolabel requirements for biodegradability, renewability, toxicity, and bioaccumulation. HF-595 is designed to meet ISO 15380 performance in HETG, HEES, HEPR, and HEPG hydraulic fluids.

<table>
<thead>
<tr>
<th>Typical Properties</th>
<th>HF-580</th>
<th>HF-595</th>
</tr>
</thead>
<tbody>
<tr>
<td>Appearance</td>
<td>Clear, Amber Liquid</td>
<td>Clear, Amber Liquid</td>
</tr>
<tr>
<td>Odor</td>
<td>Mild</td>
<td>Mild</td>
</tr>
<tr>
<td>Specific Gravity</td>
<td>0.98</td>
<td>0.99</td>
</tr>
<tr>
<td>Lbs. per Gallon</td>
<td>8.2</td>
<td>8.26</td>
</tr>
<tr>
<td>Flash Point, D92</td>
<td>&gt;230ºC (450ºF)</td>
<td>&gt;150ºC (300ºF)</td>
</tr>
<tr>
<td>Kinematic Viscosity @ 40ºC</td>
<td>50 cSt</td>
<td>145 cSt</td>
</tr>
<tr>
<td>wt% Sulfur/Phosphorus/Calcium</td>
<td>3.5%/1.1%/0%</td>
<td>11.9%/0%/0.2%</td>
</tr>
<tr>
<td>Ecolabel/LuSC</td>
<td>No</td>
<td>Yes</td>
</tr>
<tr>
<td>Treat Level, wt%</td>
<td>2.5%</td>
<td>2.2%</td>
</tr>
</tbody>
</table>

Industrial Gear Oil Additive Packages

FUNCTIONAL GA-614 is a high-performance industrial gear oil package compatible in petroleum oils, esters, and synthetic base oils. GA-614 is metal-free and uses sulfur-phosphorus chemistry to achieve FZG load stages of 12+, >60 lb Timken load, and up to 620 kg EP weld loads in mineral oil. 2.8wt% meets US Steel 224, DIN 51517-3, and ISO 6743-6. Treat level may be adjusted from 1.5-5.0wt% to achieve different EP weld loads as needed.

<table>
<thead>
<tr>
<th>Test Results - 2.8wt% GA-614 in ISO 220 Gr. II</th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>Demulsibility (D-1401, 30min)</td>
<td>39/41/0</td>
</tr>
<tr>
<td>Turbine Oil Rust Test (D665A &amp; B)</td>
<td>Pass</td>
</tr>
<tr>
<td>4-Ball Wear Scar (D4172, 20 kg)</td>
<td>0.33 mm</td>
</tr>
<tr>
<td>4-Ball Weld Load (D2783)</td>
<td>315 kg</td>
</tr>
<tr>
<td>Load Wear Index (LWI)</td>
<td>66</td>
</tr>
<tr>
<td>Timken OK Load (D2782)</td>
<td>&gt;60 lbs</td>
</tr>
<tr>
<td>Foam (D892), Sequence I, II, III</td>
<td>00/00</td>
</tr>
<tr>
<td>Oxidation Test (D2893), Viscosity Change</td>
<td>0.28%</td>
</tr>
<tr>
<td>Precipitation Number</td>
<td>0.02 mL</td>
</tr>
<tr>
<td>FZG A/8.3/90 (D1582), Load Stage</td>
<td>&gt;12</td>
</tr>
</tbody>
</table>
Additives for Mist Inhibition and Worker Safety

Misting of metalworking fluids is an environmental and health concern in many metal-removal applications such as milling and grinding. Anti-mist additives FUNCTIONAL MW-612 and V-162 greatly reduce the formation of mist and are especially in equipment that lacks mist-collecting systems.

FUNCTIONAL MW-612 is an oil/water emulsion. It is added tank side at a 0.05% treat rate in the finished fluid or at a 0.5% in concentrates.

FUNCTIONAL V-162 is a clear oil-based solution. Depending on machinery speed and cutting oil viscosity, treatment levels vary from 0.02% to 0.10% (200-1000 ppm).

Way Oil Additive Packages

Way oil or slide way lubricants are used to lubricate the ways of planers, grinders, horizontal boring machines, shapers, jig borers and milling machines. Functional WA products provide high extreme pressure properties, a substantial friction reduction, excellent wear protection, and corrosion inhibition. WA products are carefully screened for resistance to alkali and removal by coolant. Use with 0.5wt% FUNCTIONAL V-176 or V-178 tackifier for excellent adherence to working surfaces.

FUNCTIONAL WA-24 is a way oil package designed for use in Group I paraffinic oils. Fully formulated fluids will pass Fives Cincinnati P-47 specifications.

FUNCTIONAL WA-64 is a light color, low odor way oil package compatible in a wide array of base fluids including vegetable oils and synthetics. Compatibility in rerefined base oils should be checked. Fully formulated fluids will pass Fives Cincinnati P-47 and GM LS-2 specifications.

FUNCTIONAL WA-60SF is a sulfur-free, ashless way oil package designed for use in light duty and biobased applications. WA-60SF adds no color to finished lubricants and makes water-white way oils. It is soluble in mineral oils, white oils, synthetics, and oil-soluble PAGs. Passes Fives Cincinnati stick-slip requirements.

<table>
<thead>
<tr>
<th>Typical Properties</th>
<th>WA-24</th>
<th>WA-64</th>
<th>WA-60SF</th>
</tr>
</thead>
<tbody>
<tr>
<td>Extreme Pressure</td>
<td>High</td>
<td>High</td>
<td>Low</td>
</tr>
<tr>
<td>Corrosion Inhibition</td>
<td>Excellent</td>
<td>Excellent</td>
<td>Excellent</td>
</tr>
<tr>
<td>Demulsibility</td>
<td>Excellent</td>
<td>Excellent</td>
<td>Excellent</td>
</tr>
<tr>
<td>Color</td>
<td>Black</td>
<td>Amber</td>
<td>Amber</td>
</tr>
<tr>
<td>Base Oil Solubility</td>
<td>Group I</td>
<td>Group I/II/III/IV</td>
<td>Biobased</td>
</tr>
<tr>
<td>Treat Level wt%</td>
<td>1.75</td>
<td>1.75</td>
<td>1.4</td>
</tr>
</tbody>
</table>

*Copies of the anti-mist test protocol are available upon request.
**Blending of Way Lubricants**

Paraffinic oil is the recommended base fluid for blending way lubricants for the greatly coolant compatibility. Naphthenic base oil typically emulsifies with soluble oil coolants.

Add base oil to the kettle first followed by way oil package and then tackifier. Allow package to disperse completely (10-30 minutes) before adding tackifier. Do not add package and tackifier concentrate at the same time. Do not include tackifier in masterbatches of additives. Concentrated additive packages and tackifier are incompatible and may form separation in the finished lubricant if improperly mixed.

**Do you need a better way lubricant?**
The “bottle test” quickly and easily compares lubricants in any setting. Fill a small bottles half way with coolant. Add ¼” (5-6 mm) of way lubricant, seal the bottle, and invert a ten times. A proper way oil should quickly form a clear coolant layer; an incompatible way oil will emulsify and cause the coolant to turn hazy.

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**Evaluating the Coolant Compatibility of Way Lubricants**

It is critically important to evaluate a way oil with the actual coolant. A way oil must be compatible with the metalworking coolant in order to resist emulsification. If the way oil is not resistant, the fluid will wash off the slide way and contaminate the coolant. If the way oil includes a tackifier, incompatibility can cause the tackifier to come out of solution and accumulate at the top of the sump as a sticky, gummy material.

If the coolant is not available or multiple coolants are used then use a generic aqueous solution matching the coolants pH. Most way oils are resistant to emulsification but some friction modifiers can form detergent upon standing with alkaline coolants. This byproduct can causes emulsions even if the way oil did not emulsify with neutral water. Way oils should separate readily from coolant to allow skimming of the way oil and reuse of the coolant. If emulsion begins to form then the coolant will remove the way lube from the way. An elaborate treatment (such as acidification) is necessary to separate the oil-coolant and the coolant should be disposed of.

**Quantitative Evaluation:**
Coolant compatibility can be quantitatively evaluated using ASTM D6553. 40 mLs of coolant and 40 mLs of lubricant are agitated for 5 minutes. The test is observed every 5 minutes and amount of oil, aqueous phase and emulsion are recorded. Way oil should separate within 30 minutes. The Schmidt Koburg test evaluates coolant separation over longer periods.

**Qualitative Evaluation:**
Sometimes a qualitative evaluation is sufficient. ASTM D6553 testing can be simulated by placing 40 mL of way oil and 40 mL of coolant in a 100 mL graduated cylinder and inverting ten to twenty times. A persistent emulsion or cloudy coolant layer demonstrates poor compatibility. A good, coolant-compatible way oil will quickly float to the top of the cylinder and leave the coolant clear.
Purchasing Information

Headquarters

FUNCTIONAL PRODUCTS INC.
8282 Bavaria Road
Macedonia, OH 44056
Phone: 330-963-3060
Fax: 330-963-3322
sales@functionalproducts.com
sds@functionalproducts.com
www.functionalproducts.com

North America

United States

Midwest
Hall Technologies
St. Louis, MO
Phone: 314-725-2600
www.halltechninc.com

East Coast
Ivanhoe Industries, INC.
Tullytown, PA
Phone: 215-547-1200
j.snyder@ivanhoeindustries.com
www.ivanhoeindustries.com

West Coast
Tri-iso Tryline, LLC
Cardiff By The Sea, CA
Phone: 909626-4855
www.tri-iso.com

Canada
IMCD Canada Limited
Brampton, Ontario
Phone: 800-575-3382
www.imcdca.com

Mexico
Proaïnsda
Mexico City DF, Mexico
Phone: 011-52-556-696-5551
jgarduno@proaindsa.com

Australia

IMCD Australia Limited
Mulgrave, Australia
Phone: 61-3-8544-3100
cs@imcd.com.au
www.imcdgroup.com

Europe

France
Lumar France
Carrières sur Seine, France
Phone: +33 (0)1 80 83 50 40
contact@lumarfrance.com
www.lumarfrance.com

Germany
Lumar Deutschland
Stuttgart, Germany
Phone: +49 (0)711-18-56-27-13
info@lumardeutschland.com
www.lumardeutschland.com

Italy
Lumar Italia Srl
Assago, Italy
informazioni@lumaritalia.com
www.lumaritalia.com

Spain, Turkey
Lumar Quimica, S.L.U.
Barcelona, Spain
lumar@lumarquimica.com
www.lumarquimica.com

Sweden, Finland, Norway, Denmark, Estonia,
Latvia, Lithuania
PEMCO Additives
Hisings Backa, Sweden
Phone: +46 31 775 67 80
lars-erik.liljered@pemco.org
www.pemco.org

United Kingdom
Lumar UK
London, England
Phone: +0203 318 5698
axel.fahri@lumar-uk.com
www.lumar-uk.com

Middle East

United Arab Emirates
Environ Speciality Chemicals Gulf FZE
Ras Al Khaimah, UAE
Phone: +971 52548 5751
ravi@environchemfze.com
www.environchemfze.com

Asia

India, Bangladesh
Environ Speciality Chemicals Pvt. Ltd.
Mumbai, India
Phone: +91-22-42489200/230
sales@environchem.com
www.environchem.com

China
Smart Oil & Chemical Limited
Hong Kong
brianay@smart-oil.com
www.smart-oil.com

Greenbase Industries, Inc.
Shanghai
Phone: 86-186-2158-0862
xz.fan@greebase.com

Japan
Nippon Chemicals Sales Co., Ltd.
Tokyo, Japan
Phone: 03-3719-0366
info@ncstokyo.co.jp

Thailand
Connell Brothers Company Ltd.
Bangkok
Phone: 66-0-2259-8500
Cell: 66-8-1755-1021
Wut.C@wecocbc.com
www.connellbrothers.com

Korea
Inwoo Corp.
Seoul
Phone: 82-2-2202-7028
inwoo@inwoocorp.co.kr
www.inwoocorp.co.kr

Singapore
Eweka International Pte. Ltd.
Singapore
Phone: 65-6348-7279
rianto@ewekainternational.com.sg

Taiwan, ROC
Shiony Chemical Co. Ltd.
Taipei
Phone: 886-2-2356-0258
shiony@ms31.hinet.net
shiony.taipei@msa.hinet.net
www.shiony.com