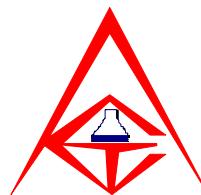


PRODUCT INFORMATION

A PRODUCT OF AMERICAN CHEMICAL TECHNOLOGIES, INC.



FR WG 200-XP

Water Glycol, Advanced Fire-Resistant Technology for Severe Hydraulic Service Environments

Manufactured with UCON ADVANTA™ Hydrolube Concentrate
from The Dow Chemical Company



FR WG 200-XP is a new water glycol hydraulic fluid (WGHF) technology used in fluid formulations that provide improved fire resistance while protecting equipment under severe service conditions.

Designed particularly for hydraulic systems utilizing vane, gear, and piston hydraulic pumps used in the steel, aluminum, and die-casting industries, FR WG 200-XP is based upon optimized polymer chemistry and a new high performance additive package. FR WG 200-XP represents the latest water glycol innovation and is based on more than 60 years of experience with polyalkylene glycol chemistry.

FR WG 200-XP enables production of formulations with outstanding shear stability compared to traditional water glycol hydraulic fluids, reducing fluid maintenance, extending pump life, and reducing reconditioning requirements. An innovative friction modifier provides excellent pump lubrication and can extend equipment service life while reducing maintenance costs. The fluids also provide superior vapor phase and solution corrosion protection compared to traditional water glycol hydraulic fluids based on morpholine technology.

PRODUCT DESCRIPTION

FR WG 200-XP uses the UCON ADVANTA™ Hydrolube Concentrate as the basis for high performance water glycol hydraulic fluids suitable for use under higher temperature service such as those found in steel and aluminum mills and die

casting operations. Compared to traditional water glycol hydraulic fluids, the favorable environmental profile of fluids formulated with UCON ADVANTA™ Hydrolube Concentrate also makes them an excellent choice in the formulation of fluids for other applications.

FIRE RESISTANCE

Fire resistance is imparted to FR WG 200-XP through its water content that is released as a snuffing blanket of steam if the fluid comes in contact with an ignition source. Because of its water content, this product has the ability to prevent flame propagation when fire occurs. Hydraulic fluids made from the ADVANTA™ Hydrolube Concentrate to the specification of FR WG 200-XP have been tested and meet the requirements of Factory Mutual (6930 standard, January 2002).

In order to insure continued fire resistance, the water content of FR WG 200-XP must be maintained and not allowed to drop below 35%. This is true of any water-glycol fluid. In order to insure against excessive water evaporation in open hydraulic systems, operating temperatures should be maintained as low as possible and should not exceed 150 °F.

A Hydraulic Fluid Monitoring Program is available for feedback on particular fluids in service.

HEAT TRANSFER

Water and water containing compositions such as FR WG 200-XP are superior heat transfer media.

Water glycol fluids have marked advantages over mineral oils or synthetic type FR fluids in this respect.

SHEAR STABILITY

The unique polymer technology of FR WG 200-XP results in higher shear stability, and reduces fluid maintenance and reconditioning requirements. FR WG 200-XP has extended viscosity retention up to five times that of conventional water glycol hydraulic fluids.

Shear Stability Documented in Six-month Field Trial by Aluminum Die Caster. The shear stability of FR WG 200-XP has been assessed in a six month field trial involving a major aluminum die caster. The trial shows that fluid viscosity loss was maintained at less than 10 percent and reserve alkalinity remained high achieving pre-trial performance target. The trial involved two parker piston pumps operating 1200 psi with a bulk reservoir temperature of 115°F to 130°F (46°C to 54°C).

VISCOSITY INDEX

The viscosity index of a fluid defines the degree to which the fluid resists thinning out at elevated temperatures. In the viscosity index rating system, the lower the VI number of an oil or fluid, the greater the spread between the fluid's viscosity measured at 100 °F, and its viscosity measured at 210 °F. Therefore, fluids with high VI numbers show a much lower spread than low VI fluids.

FR WG 200-XP has a viscosity index of 195 when tested using the ASTM D-2270 procedure. Shown below is a comparison between FR WG 200-XP and other commonly used hydraulic fluids.

Fluid Type	Viscosity Index
R & O Oil	95
A/W Hydraulic oil	95
Automatic Transmission Fluid	160
10 W 30 Motor Oil	140
Synthetic FR Fluid	70
FR WG 200-XP	195

The temperature/viscosity relationship of FR WG 200-XP assures the user of minimum fluid thin-out at operating temperatures, hence, better lubricity.

POUR POINT

The pour point of a fluid is the measured temperature at which the fluid will no longer flow under prescribed test conditions. FR WG 200-XP

has a pour point below –35 °F. In addition, this fluid can be repeatedly frozen and thawed without any loss in its homogeneity. The excellent low temperature flow properties of FR WG 200-XP, coupled with its high viscosity index, offers the user the maximum in fluid performance over a wide temperature range. Its excellent low temperature properties minimize pump problems on cold start-up and its high VI assures adequate viscosity and lubricity at running conditions.

COMPATIBILITY WITH METALS

FR WG 200-XP is formulated with special corrosion inhibitors to provide corrosion protection in both the liquid phase and the vapor phase. Vapor phase protection is especially desirable when machines do not operate around the clock or are subject to short and long-term shutdowns.

FR WG 200-D will afford corrosion protection to aluminum, copper, brass, cast iron, steel and other metals commonly used in hydraulic circuitry.

Systems utilizing solder, tin, lead, zinc, cadmium or magnesium should not use water glycol fluids, since such fluids are corrosive to these metals. Zinc and cadmium are especially bad and can result in rapid fluid deterioration, as well as corrosion of metals.

COMPATIBILITY WITH WATER GLYCOLS

FR WG 200-XP is compatible and miscible in all proportions with other established water glycol type fire resistant fluids. This assumes that the competitive fluid has been adequately maintained with the proper amount of water and rust inhibitor and is reasonably free of particulate contamination or other forms of contamination.

It is highly recommended that all systems containing competitive water glycol, be laboratory tested at ACT's research facility prior to installing FR WG 200-XP.

These fluids will be tested for the following properties:

- Water Content
- Dirt Level
- Viscosity
- Particle Size
- Rust Inhibitor Level

The A.C.T. representative will be glad to initiate this work including all necessary sample containers, labels, etc.

LUBRICITY CHARACTERISTICS

A high level of anti-wear protection is built into FR WG 200-XP. This permits usage in hydraulic systems operating up to 4,000 psi, providing the hydraulic pumps are designed to operate on water glycol fluids at that pressure. Prior to converting any system over to a water glycol fluid from a conventional or synthetic fluid, the pump manufacturer should always be consulted to make sure that the circuit hardware is suitable for water glycol.

The excellent anti-wear properties of FR WG 200-XP have been well demonstrated in actual field performance and in laboratory testing. The following chart compares FR WG 200-XP to other hydraulic fluids in this high-pressure pump test response:

<u>Fluid Type</u>	<u>Ring & Vane Wear mg. (1)</u>
Straight Oil	600-800
R & O Oil	500-700
Inverted Emulsion	150-400
FR WG 200-XP	< 10-15
Other Water Glycols	30-50
AW Hydraulic Oil	15-50
Synthetic FR Fluid	< 30

(1) ASTM D-7043, 100 hours, 65 °C, 2,000 psi, 1200 rpm, Vickers 104-C Vane Pump

A.C.T.'s FR WG 200-XP offers the consumer the maximum wear protection available in a water-glycol type hydraulic fluid.

TOXICITY AND HANDLING

FR WG 200-XP is designed to meet environmental, health and safety performance standards. In addition, the fluids do not contain secondary amines such as morpholine, which are commonly found in conventional water glycol hydraulic fluids, and can be irritating to the skin.

FR WG 200-XP contains about 40.0% diethylene glycol. The lethal dose for rats of diethylene glycol is 20,760 mg/kg. Oral toxicity is expected to be moderate in humans even though tests with animals show a low degree of toxicity. Should this product be ingested or swallowed, vomiting should be induced immediately, and a physician contacted at once. Breathing of the vapors should be avoided. This product could cause skin irritation or

sensitization in some humans. Plastic or rubber gloves are recommended when handling. After handling, washing with soap and water is recommended. FR WG 200-XP contains a basic amine-type corrosion inhibitor. Compounds of this type will cause eye irritation. In case of contact, rinse the eyes with large amounts of cool water and contact a physician at once.

FR WG 200-XP is a slippery liquid and spills constitute a definite safety hazard. Spills should be cleaned up immediately by either washing or hosing with water or by treating the affected area with commercially available spill absorbents.

SEAL AND "O" RING COMPATIBILITY

FR WG 200-XP can be operated with a wide variety of seal and gasket materials. Elastomers such as natural rubbers, Buna N, Buna S and Neoprene are unaffected by the fluid. Other materials such as Viton, Teflon, and other similar types are also satisfactory. The only seal and gasket configurations not acceptable are leather, cork, cellulose or other substances that will absorb water and either swell or deteriorate as a result.

OIL SEPARATION PROPERTIES

When converting a hydraulic system over from a mineral oil, synthetic, or oil-synthetic fluid type, there is usually some residual oil based fluid left in the system which has a tendency to slightly emulsify with water glycol fluids. This results in a pink-milky looking mixture. In time, the oil or synthetic will separate. In the case of a mineral oil, it will float on top of the reservoir and can be skimmed. Phosphate esters or other synthetics have specific gravities greater than water glycol fluids and will collect at the bottom of the sump after separation. These residuals can be bottom drained from the reservoir.

FR WG 200-XP is not prone to form stable emulsions and rapid oil separation can be expected after the conversion. However, certain used phosphate esters where oxidation has occurred may take longer to separate. A complete conversion is outlined later in this bulletin. The suggested conversion procedure is essentially that recommended in the National Fluid Power Association Standard P93-5-1973.

RESERVOIR PAINTS & COATINGS

All water glycol type fluids will tend to dissolve or deteriorate many conventional paints and coating

systems commonly used in sumps and reservoirs. When converting any system over to FR WG 200-XP, any paint or coating used in the system which is known to be incompatible with water glycol systems should be removed and replaced with a coating system which is compatible with water glycol. Several of the leading paint suppliers manufacture systems which are acceptable for water glycol usage. These suppliers should be contacted for application and paint types to be used.

PIPE JOINT COMPOUNDS & GREASES

FR WG 200-XP and all other water glycol fluids may tend to dissolve or soften certain pipe thread dopes. It is recommended that either Teflon pressure tape or pipe compounds that have water-glycol compatibility be used.

The use of soda based greases in and around hydraulic circuits should be avoided due to their proneness to emulsify with water glycol fluids. Grease selection should be restricted to those having good water tolerance such as lithium, calcium, aluminum complex and calcium sulfonate complex.

CONVERSION PROCEDURE

When converting a system to FR WG 200-XP from either a conventional mineral oil based fluid or another type of fire resistant or synthetic fluid, it is important that the following procedures be used. Compliance with these conversion procedures will permit the changeover to proceed with the minimum amount of difficulty and will benefit the service life and performance of the fluid.

Completely drain all fluid from the sump, lines, coolers, actuators, etc. Wipe clean.

Remove any interior paint that is not compatible with water glycol type fluids. Sand blast sump interior down to white metal and apply water glycol paint system.

Replace any seals or "O" rings that are not generally recommended for water glycol fluids.

Reconnect lines, accumulators, coolers, etc. using either Teflon pressure tape or a suitable pipe joint compound. Make sure any grease used is water-resistant.

Replace any filters that are not suitable for water glycol service. If there is any doubt, the filter supplier should be contacted for recommendations.

Make absolutely sure that the pump on the equipment is suitable for water glycol service. Consult the pump manufacturer.

Install a mesh strainer on the pump inlet. Usually a 60-mesh screen is adequate. DO NOT PUT A FILTER ON THE PUMP INLET. Due to the high bulk density of water glycol fluids and the resultant suction lift demands, the pump inlet must never be restricted without prior discussion with the pump manufacturer. Cavitation can result from a restricted pump inlet.

When converting from a conventional petroleum fluid or other water glycol type, fill the system with FR WG 200-XP to a minimum level to maintain pump suction and operate the system for 30 minutes at reduced pressures. When converting from a synthetic type oil-synthetic fluid first pre-flush the system with a light straight mineral oil before flushing with FR WG 200-XP.

Drain system immediately and fill to operating level with FR WG 200-XP.

Where a system already contains another water glycol fluid, it is permissible to start using FR WG 200-XP directly as make-up, providing the existing fluid is of an acceptable cleanliness level and contains the proper amount of water and rust inhibitor. Prior to adding FR WG 200-XP to a system containing another water glycol fluid it is strongly recommended that the fluid in the system be analyzed by A.C.T.'s laboratory. Your A.C.T. representative will furnish all necessary bottles, labels, etc. to facilitate this testing.

Start up the system and slowly bring it up to normal operating system pressure and conditions.

Periodically check filters and strainers for the first few weeks of operation. These components could get clogged with sludge and deposits resulting from the flushing of the system. If the system has been changed over from an oil or synthetic type fluid, FR WG 200-XP may take on a pink-milky appearance. This is normal and will occur with any water glycol type fluid. This is due to slightly emulsified oil or synthetic fluid left in the system after flushing and, in time, the emulsion should break, allowing free oil to be skimmed from the sump if it is mineral oil or drained from the bottom if it is a synthetic.

WATER CONTROL & MAKEUP

It is necessary to maintain the water level of FR WG 200-XP within acceptable limits. Excessive water reduces the fluid's viscosity and its ability to lubricate and prevent pump slippage. Insufficient water will render the fluid non fire-resistant as well as raise its viscosity and bulk density both of which will contribute to pump cavitation.

Two acceptable methods may be used to control the water level of FR WG 200-XP: 1.) Indirectly, by viscosity determination, 2.) Directly, by laboratory methods, using the Karl Fischer titration. The water level of FR WG 200-XP cannot be determined by distillation procedures. The viscosity approach is not acceptable to systems containing large amounts of oil or systems where the fluid is predominately not FR WG 200-XP. Portable viscosity gauges are available at nominal costs to determine viscosity at machine side. It is important that the gauges be standardized for FR WG 200-XP. The attached table can be used with acceptable accuracy to determine the amount of water required to adjust the fluid to acceptable limits. Only distilled, deionized, reverse osmosis, or controlled boiler feed water should be used as makeup. The use of hard tap water, well or spring water should be avoided since these waters will react with the additive system in the fluid causing fluid haziness and formation of soap-like insoluble material.

ALKALINITY CONTROL

FR WG 200-XP show outstanding solution corrosion resistance on steel, cast iron, aluminum, copper, and brass. Unlike conventional water glycol hydraulic fluids, they are also compatible with zinc. Vapor phase corrosion performance on cast iron and steel is also outstanding.

The Reserve Alkalinity in FR WG 200-XP is a measurement of the alkaline content of the fluid. It is defined technically (ASTM D-1121) as the number of milliliters of 0.1 N hydrochloric acid necessary to neutralize 100 ml of fluid to a pH of 5.5. This can only be determined by a laboratory titration. The normal alkaline reserve of new FR WG 200-XP ranges from 160 to 170 ml of 0.1 N hydrochloric acid required to neutralize 100 ml of the pH of 5.5.

Only distilled, deionized, reverse osmosis or steam condensate water should be used.

For larger or smaller systems than 100 gallons, use appropriate multiples or fractions for water addition based on the actual amount of fluid in the system.

This charge is only valid when the system is all FR WG 200-XP.

FR WG 200-XP

Properties	Method	Results
Appearance	Visual	Red, Slight Haze
Viscosity, cSt @ 40 °C	ASTM D445	46
Viscosity Index	ASTM D2270	195
Pour Point, °F	ASTM D97	-50
pH	ASTM E70	9.5
Reserve Alkalinity	ASTM D1121	16-19
Water %	ASTM E203	42.5-44.5
Foam Characteristics	ASTM D892	
Sequence I, ml/ml		10/0
Sequence II, ml/ml		10/0
Sequence III, ml/ml		10/0
Flash & Fire Point, °F	ASTM D92	None
Factory Mutual	FMST 6930	ADVANTA
Rust Prevention	ISO-7120	Pass
Copper corrosion, 6 hr	ISO-2160	1A
Copper corrosion, 24hr	ISO-2160	1B
Biodegradability	OECD 301B	Readily Biodegradable
High Pressure Pump Tests:		
Vickers Vane V-104C	ASTM D7043	10-15
2000 psi, 1200 rpm, 65 °C, 100 hr		