

CONTENTS

Dedication.....	i
Acknowledgement.....	ii
Contents.....	iii
List of tables.....	Vi
List of figures.....	Vii
Abstract (English).....	x
Abstract (Arabic).....	xi

Chapter one Introduction

1.1 Introduction.....	1
1.2 Composition of lubricant.....	2
1.2.1 Normal paraffins.....	2
1.2.2 Iso-paraffins (branched paraffins).....	3
1.2.3 Cycloparaffins.....	4
1.2.4 Aromatic hydrocarbons.....	4
1.2.5 Olefins.....	5
1.2.6 Elements.....	6
1.2.7 Chemical additives.....	8
1.2.7.1 Viscosity index improve.....	8
1.2.7.2 Additives to lower pour point.....	8
1.2.7.3 Anti oxidants.....	8
1.2.7.4 Detergent and dispersant additives.....	9
1.2.7.5 Anti-foaming agents.....	9
1.2.7.6 Rust and corrosion inhibitors.....	9
1.2.7.7 Anti-wear.....	9

Used Lubricating oils.....	10	1.3
Viscosity of the used Lubricant.....	11	1.3.1
Acid number of the used Lubricant.....	11	1.3.2
Base number of the used Lubricant.....	12	1.3.3
Flash point of the used Lubricant.....	12	1.3.4
Used Lubricating oil recycling processes.....	12	4.1
The acid processes.....	13	4.1.1
The phenol treating	14	4.2.1
Furfural treating	15	4.3.1
The Institut Francais du P'etrole (IFP) type processes.....	16	4.4.1
The KTI type processes.....	16	4.5.1
The MOHAWK process.....	17	4.6.1
The Phillips Re-refined Oil Process (PROP).....	17	4.7.1
The BETC process.....	18	4.8.1
The UOP DCH process.....	19	4.9.1
The Texaco Gasification Process.....	19	4.10.1

Chapter two lubricant properties

Lubricant properties.....	20	.2
Kinematic viscosity.....	20	2.1
Viscosity index.....	20	.2.2
Flash point.....	21	.3.2
Fire point.....	21	.4.2
Acidity and Basicity.....	22	.2.5
Color.....	22	.6.2
Density.....	22	.7.2
Pour point.....	23	.8.2
Infrared spectrometry.....	23	.9.2

Ultra violet spectrometry.....	26 .10 .2
Metalic ash determination.....	26 .11 .2
Oil efficiency.....	26 .12 .2
American Society for Testing and Materials (ASTM).....	27 1 .12 .2

Chapter three experimental work

Acid treatment.....	31 3.1
Viscosity test	40 .3.2
Flash point test	41 .3.3
Total Acid Number (T.A.N)test.....	42 .3.4
Total Base Number(T.B.N) test.....	43.3.5
Density test.....	44 .3.6
Determination of Zn and Ca	45 .3.7
Determination of ash, Nikel, and Chromium content.....	46 .3.8
IR test.....	47 .3.9

Chapter four results.....48

Chapter five discussion & conclusion.....68

Chapter six references.....78

LIST OF TABLES

	Page No
TABLE 1: Main contaminant elements and their probable origin.....	7
TABLE 2: Infrared spectrometry some functional groups in lubricants..	24
TABLE 3: Gasoline engines.....	28
TABLE 4: Diesel engines.....	29
TABLE 5: Viscosity at 100 °C/cSt.....	48
TABLE 6: Viscosity at 40 °C/cSt.....	49
TABLE 7: Flash point °C.....	50
TABLE 8: Total Acid Number (T.A.N) mg KOH/g.....	51
TABLE 9: Total Base Number (T.B.N) mg KOH/g.....	52
TABLE 10: Density at 15 °C.....	53
TABLE 11: Zn PPm.....	54
TABLE 12: Ca PPm.....	55
TABLE 13: Ash content (g%).....	56
TABLE 14: Ni content (µg/ml).....	57
TABLE 15: Cr content (µg/ml).....	58
TABLE 16: IR spectral data of (γ max Cm^{-1}) in sample (1) TA	73
TABLE 17: IR spectral data of (γ max Cm^{-1}) in sample (2 and 3) SH...	74
TABLE 18: IR spectral data of (γ max Cm^{-1}) in sample (4) NI.....	74
TABLE 19: IR spectral data of (γ max Cm^{-1}) in sample (5 and 6) LA	75

LIST OF FIGURES

	Page No
Figure 1: The separating funnel filled with the treated oil.....	32
Figure 2: Distilled water added to the treated oil in the separating Funnel.....	33
Figure 3: Treated oil + distilled water were shaken (emulsion formed).....	33
Figure 4: Left for 5 minutes (separation of distilled water from the treated oil was shown).....	34
Figure 5: Increasing time purifies the water at the bottom of the funnel(emulsion becomes on top).....	34
(Figure 6: Repeating of the experiment (washing with distilled water several times, the emulsion was separated in a conical flask 500 ml.....	35
Figure 7: The contents of the flask were heated for 5 minutes at 40 °C after the addition of sodium hydroxide solid (to be sufficient to neutralize the acid).....	35
Figure 8: The contents of the flask after the addition of solid sodium hydroxide, heating for 5 minutes and shaking some of the sodium hydroxide dissolved, and the oil) started to appear).....	36
Figure 9: Shows formation of oil with reddish color after heating for more 5 minutes and shaking, all sodium hydroxide dissolved and the excess separated with water at the bottom of the flask.....	36
Figure 10: Sample 1 [Ta] recycled, used and new.....	37
Figure 11: Sample 2 [SH] recycled, used and new.....	37

Figure 12: Sample 3 [SH] recycled, used and new.....	38
Figure 13: Sample 4 [NI] recycled, used and new.....	38
Figure 14: Sample 5 [LA] recycled, used and new.....	39
Figure 15: Sample 6 [LA] recycled, used and new.....	39
Figure 16: Sample 7 [TASHNILA] used and recycled.....	40
Figure 17: Ubbelohde viscometers with oil bath.....	41
Figure 18: Flash point apparatus.....	42
Figure 19: Automatic potentiometric titrator.....	44
Figure 20: Automatic density meter.....	45
Figure 21: X-ray apparatus.....	46
Figure 22: Shows viscosity at 100 °C/cSt.....	48
Figure 23: Shows viscosity at 40 °C/cSt.....	49
Figure 24: Shows flash point °C.....	50
Figure 25: Shows Total Base Number (T.A.N) mg KOH/g.....	51
Figure 26: Shows Total Acid Number (T.B.N) mg KOH/g.....	52
Figure 27: Shows density at 15 °C.....	53
Figure 28: Shows Zn ppm.....	54
Figure 29: Shows Ca ppm.....	55
Figure 30: Shows ash content g %.....	56
Figure 31: Shows Ni content (µg/ml).....	57
Figure 32: Shows Ca content (µg/ml).....	58
Figure 33: Infrared spectrum of sample 1 (TA new).....	59
Figure 34: Infrared spectrum of sample 1 (TA used).....	59
Figure 35: Infrared spectrum of sample 1 (TA recycled).....	60
Figure 36: Infrared spectrum of sample 2 &3 (new SH).....	60
Figure 37: Infrared spectrum of sample 2 (used SH).....	61
Figure 38: Infrared spectrum of sample 2 (recycled SH).....	61
Figure 39: Infrared spectrum of sample3 (used SH).....	62

Figure 40: Infrared spectrum of sample 3 (SH recycled).....	62
Figure 41: Infrared spectrum of sample4 (NI new).....	63
Figure 42: Infrared spectrum of sample4 (NI used).....	63
Figure 43: Infrared spectrum of sample 4 (NI recycled).....	64
Figure 44: Infrared spectrum of sample 5 &6 (LA new).....	64
Figure 45: Infrared spectrum of sample5 (LA. used).....	65
Figure 46: Infrared spectrum of sample 5 (LA recycled).....	65
Figure 47: Infrared spectrum of sample 6 (LA used).....	66
Figure 48: Infrared spectrum of sample 6 (LA recycled).....	66
Figure 49: Infrared spectrum of sample 7 (TASHNILA used).....	67
Figure 50: Infrared spectrum of sample 7(TASHNILA recycled)...	67