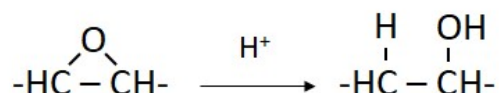


## HYDROXYL VALUE

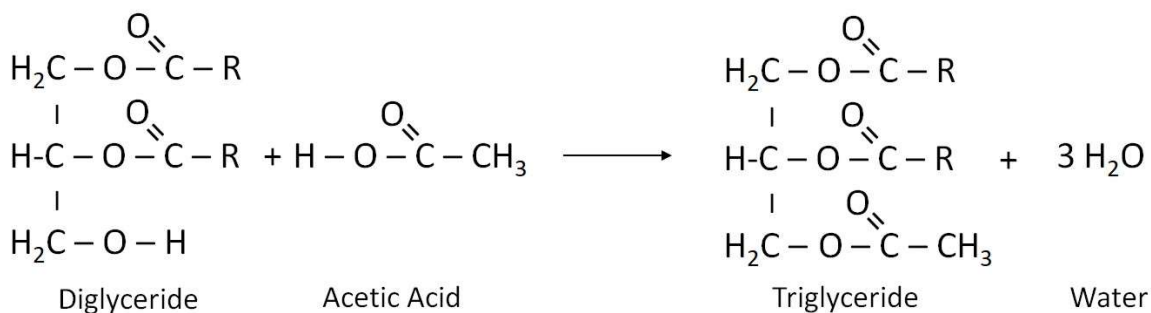
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The hydroxyl value measures the average concentration of hydroxyl functions in the molecule of the final product. The presence of hydroxyl functions needs to be maintained at low levels to ensure higher compatibility of the plasticizer with PVC.

In the epoxidation process, a secondary undesired reaction generates hydroxyl functions due to the opening of the oxirane ring, as described by the equation below.



Also, for third generation plasticizers, such as Innoleic™ MB line, the hydroxyl value measures the conversion of the acylation reaction, where a hydroxyl group is substituted by an acetic ester group, as described by the equation below:



The table below shows the hydroxyl value specifications of Innoleic™ MB products.

	Hydroxyl Value
Innoleic™ MB50	35 max
Innoleic™ MB25	35 max