

# WATER-MISCIBLE COOLANT CHECKLIST FOR RE-STARTING AFTER SHUTDOWN

If the machines were not emptied of the water-miscible Metalworking Fluid before an extended shutdown, then the following steps can be taken to ensure the coolant is in good, stable condition before re-use. Consideration should be given in regard to the sump tank size, coolant age, condition, and disposal costs of the metalworking fluid. If unsure of any of these steps, consult with your local Blaser representative, or Blaser Customer Service.

1. Visually inspect the coolant tank/sump. Remove floating tramp oils, swarf, etc., before circulating the coolant. Do NOT add fresh coolant at this point unless the coolant level is too low to start the pumps. If so, add just enough coolant, at or above the target concentration, in order to start the pumps. If there are significant solids in the coolant sump, then ideally, the tank and machine should be cleaned out before proceeding.
2. Turn on ALL of the coolant pumps, and circulate for 40-60 minutes.
3. Check concentration with a refractometer (test the coolant from the nozzle).
4. Top off the sump with fresh coolant to achieve the target concentration + 2%, filling the sump to 90-95% of capacity. Refer to the top off calculator if needed to determine the top off %.
5. Check pH (also from the nozzle) and odor of the coolant. This step is for Emulsions ONLY! If pH is < 8.8, or if the fluid has an unacceptable odor, add 3% (of tank volume) Blasoclean AF or Blasorun 5. Circulate the coolant for an additional 30 minutes and re-check pH. Repeat using 1% doses until pH reaches >=9.0. Note: Additive C41 (@ 0.05% increments) can be used, in lieu of additional doses of Blasoclean AF or Blasorun 5 to raise pH after the 3% initial dose.
  - a. For full synthetics or for central systems, contact our customer support team or your local Blaser representative.
  - b. Consult with us prior to treating fluids machining delicate aluminum highly prone to staining such as 2000, 5000 and 7000 series aluminum.
6. Add fresh coolant, adjusting concentration as needed to bring tank volume to 100% capacity
7. Going forward - Check concentration daily and pH weekly. Keep records on the Daily Coolant Log. Act quickly to correct if pH or concentration are out of target range.

While the above steps have been highly effective, it may be more cost effective in some cases to perform a Dose, Dispose, Clean, Rinse and Refill (DDCRR) if the fluid is very old and/or in very poor condition.

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