

WATER-MISCIBLE COOLANT CARE

7 TIPS FOR SUCCESS

1. Start with quality water

- ✓ Use drinking-quality water (remember with a 10% concentration you still run 90% water!).
- ✓ Use DI or RO water if necessary (tap water may be too hard or too high in overall salt load).
- ✓ Hardness and other water salts do not evaporate and accumulate in the coolant.

2. Mix properly

- ✓ Use a Jetmix, Minimix or other recommended mixing device such as a Dosatron.
- ✓ Hand mixing: Oil In Last = O.I.L. Stir water vigorously while slowly adding concentrate.
- ✓ Do not mix with air or otherwise introduce air into freshly mixed product.

3. Maintain proper concentration

- ✓ Refer to the PIDS for the ideal %, typically 3-5% above minimum for best results in most cases.

4. Keep tramp oil to a minimum

- ✓ Fix oil leaks.
- ✓ Remove using a (skimmer, vacuum, coalescer, centrifuge or other device etc.).

5. Never add straight water or straight concentrate to system

- ✓ Always top off with fresh coolant, typically at 1/5 to 1/3 of the target concentration.

6. Top off machines regularly

- ✓ Letting the sump run low increases usage, temperature, and dirt levels, as well as the foam tendency of the coolant. Always keep sump level between 85-100% full.

7. Maintain your sump – Don't dump!

- ✓ For your own health and safety, do not throw garbage, spit, throw cigarette butts or any other foreign matter into the coolant.
- ✓ Periodically remove sludge/fines/swarf from the sump.
- ✓ Filter the coolant to minimize sludge and to optimize cutting/grinding performance.

For further education or information, consult with your local Blaser Distributor, Area Manager or Customer Service representative.

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