

Coolant changeover guidelines












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Introduction

A clean sump will maximize coolant life. During the Metal Working Fluids (MWF) changeover process to a new coolant, any bacteria, fungus, dirt and/or sludge left from the previous coolant can decrease the new fluid's life.

Hence, a good machine cleaner is highly recommended to thoroughly clean the sump, prior to charging the new coolant.

9-Step Cleaning Process

 <p>Step 1: Thoroughly clean the system and sump tank to remove all residue, contaminants, grease, rust prevention products etc.</p>	 <p>Step 2: Add system cleaner a day before the MWF changeover. Ensure that the fluids are circulated for over 8 hours during normal operation of machine tools.</p>	 <p>Step 3: Add 1.5 to 2% of MWF-solution/ MWF-emulsion along with fungicide. Ensure that plain water is not present as it poses a risk of rust.</p>
 <p>Step 4: Circulate for 1 hour, then drain and dispose of used fluid from the MWF solution mix.</p>	 <p>Step 5: Before proceeding with a 2nd system rinse, clean the machine for at least 1-2 hours using a 2% MWF-solution/MWF-emulsion.</p>	 <p>Step 6: Drain and dispose the rinsing fluid.</p>
 <p>Step 7: Carefully clean the system again to ensure all metal chips and residuals are removed completely.</p>	 <p>Step 8: Prepare fresh water and the MWF mix with a concentration of 5 to 10%.</p>	 <p>Step 9: Test the concentration level after 30 minutes of circulation and adjust accordingly.</p>

Precautions

- ⦿ Ensure proper Personal Protection Equipment (PPE) is used during cleaning process.
- ⦿ Ensure all electrical connections on the machine are switched off.
- ⦿ Ensure that while making emulsion, oil is charged in water.
- ⦿ Ensure that waste water generated is disposed in accordance to local regulations.