

HEM**Performance
Source****Your Source for Straight Cuts!****Sawing Fluid Trouble
Shooting Guides**

TROUBLE SHOOTING GUIDE - CORROSION

Action:

- Check fluid concentration. Lean mixes cause corrosion.
- Check mix pH, typically pH's lower than 8.5 can effect corrosion control.
- Check for contamination. High levels of chlorides can cause corrosion.
- Check environment of machine tool. Corrosive fumes from local washer and pickling baths can cause corrosion. Concrete dust can also cause corrosion.
- Check how parts are handled or stacked. Hands have acids and stacking parts on top of each other can cause corrosion.
- Corrosion can sometimes be linked to the time of year. Hot and humid conditions can cause corrosion.
- Check bacteria levels.
- Check emulsion stability. An improperly mixed fluid may cause corrosion.

Remedy:

- Adjust concentration to correct ratio for your application.
- Adjust pH. Check pH of coolant. It should read according to pH level on product sheets, typically between 7 - 10. If excessively acidic or alkaline, put sump shocker in tank for 6-8 hours and recharge the next day.
- Treat for bacterial.
- Add rust inhibitor if possible. Call HE&M Saw for product at (888) 729-7787.

**These maintenance tips will save money, decrease
downtime, and get better tool and blade life.**

HE&M Saw - Your Sawing Specialists!

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