

**HE&M****Performance  
Source****Your Source for Straight Cuts!****Sawing Fluid Trouble  
Shooting Guide**

## TROUBLE SHOOTING GUIDE - RANCIDITY

### Action:

- Check fluid concentration.
- Check sump levels.
- Ask if fluid make-up was added.
- Check pH.
- Determine extraneous oil levels.
- Check for solid contamination.
- Look for "dead" areas for fluid stagnation.
- Check for fluid discoloration.
- Check for staining of parts.
- Check for emulsion stability.
- Check ion levels - high sulfate levels can promote bacterial growth.

### Remedy:

- Dump and recharge.
- Biocide addition - Call HE&M Saw (888) 729-7727 for product and installation.
- Aeration
- Keep fluid circulating.
- 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 and recharge the next day.

**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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