

Trouble Shooting: Corrosion

Cause:

- Fluid concentration, lean mixes can cause corrosion.
- pH's lower than 8.5 can effect corrosion control.
- Hard water containing high levels of chlorides can cause corrosion.
- Other operations in the area surrounding your machine tool which create corrosive fumes can cause corrosion on surrounding equipment. 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 humidity and temperature. Hot and humid conditions can cause corrosion.
- Foul odors emanating from coolant tanks normally indicate high levels of bacteria. Some forms of bacteria can lead to corrosion.
- An improperly mixed fluid may cause corrosion.

Remedy:

- Use a refractometer to determine the coolant mixture ratio and adjust concentration if needed.
- 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, add Eliminator 105 Sump Cleaner to coolant tank for 12 to 24 hours, dump, flush system with water and add new coolant.
- Treat for bacteria by adding additional HE&M biocide product.
- Add rust inhibitor if possible. Call HE&M Saw for coolant management products at (888) 729-7787.

These maintenance tips will enhance tool performance, increase tool life, reduce costly down time and save you money



HE&M Saw has a product and accessory to fit all your metalworking fluid needs:

- | | | |
|------------------------------|--|------------------------|
| • 101 Synthetic Coolant | | • 107 Anti Spatter |
| • 102 Semi Synthetic Coolant | | • 111 Turbo Drill |
| • 103 Water Soluble Coolant | | • 132 Low Temp Coolant |
| • 104 Spray Mist Coolant | | • 701 Refractometer |
| • 105 Sump Cleaner | | • 750 Sump Devil |
| • 106 Rust Inhibitor | | • 806 Hydromaster |



www.hemsaw.com

P.O. Box 1148, Pryor, OK 74362

Toll Free: (888) 729-7787 • Phone: (918) 825-4821 • E-Mail: coolant@hemsaw.com

Hem, Inc., whose policy is one of continuous improvement, reserves the right to change the price, specifications, or design, as well as discontinue any model, at any time without notice and without incurring any obligations. Copyright 112800 Hem, Inc. All rights reserved.