

March 2020

Best Practice Guide

From time to time, it may be necessary to temporarily shut-down a machine tool or suspend machining operations for longer than a typical weekend i.e.; > 48 hours. At such times, it is advisable to prepare the machine tool or system for a period of dormancy. The aim of which is to preserve the condition of any in-use metal working coolant remaining in the sump or system ready for future use.

A few simple steps form the basis of this Best Practice guide:

ACTION	REASON
Ensure the sump/system is at the correct operating volume before assessing coolant condition	Later changes to coolant volume will affect coolant concentration parameters
Assess coolant condition as per current HSE Guidance COSHH Essentials Sheet MW5 https://www.hse.gov.uk/pubns/guidance/mw5.pdf	To determine any likely restorative actions necessary to obtain optimum coolant condition
Ensure product concentration is at or near maximum advised upper limit	To ensure product additive package maintains optimum coolant biostability and corrosion protection
Remove any excess surface or tramp oil including redirecting drainage pipes from LEV's to a waste container and not to sump.	To assist coolant stability and biostability
Clean down swarf from surfaces for removal by drag-conveyor or filter media	To prevent corrosion of machine tool surfaces and prevent microbial contamination
Treat with suitable biocide at correct dosage IF microbial contamination is confirmed.	Ensures biostability of coolant and assists coolant stability and corrosion protection
Turn off water hoses near to sumps and systems.	To prevent accidental leakage & possible over-dilution of coolant.
IMPORTANTLY, turn over sump/system contents at least once daily for at least 1 hour, where possible	Prevents stagnation of coolant, improves stability and reduces potential for microbial contamination.



By adopting the above Best Practices, the coolant will maintain best condition and be ready to provide optimum performance at start-up.

Please contact your Quaker Houghton Account Manager or Fluidcare Service Team for further details and advice.