

# Drain, Clean, Recharge

## INSTRUCTIONS

Proper coolant management starts with draining, cleaning and recharging the machine. This is the most important step in breaking the cycle of rancidity and metalworking fluid failure.

Before starting a change-out, a heavy-duty microbiostat, like Triadine 10 or Triadine 20, should be added to the sump 24 hours before it is drained. This will eliminate any bacteria or fungi in the sump, pumps, filters and coolant lines. During this time the coolant should be circulated and the machine can remain in operation. Do not use bleach as a biocide, bleach will only shorten the life of the metalworking fluid.

### **DRAIN**

After circulating the microbiostat for 24 hours, drain the sump completely and properly dispose of the old coolant. Remove all chips, swarf and other debris from the sump.

### **CLEAN**

Fill the system with just enough fresh water and alkaline cleaner so the pumps can circulate the solution to clean grease and dirt from the sump and coolant circulation system. After running the system for 15 to 20 minutes, pump out the cleaning solution and circulate clean water through the system. Make sure to dispose of the cleaning solution in the same manner as the old coolant, since it is contaminated with oil, grease and metal.

After cleaning, the machine is vulnerable to rust. To protect against corrosion, use a 1:1 mixture of coolant concentrate and water in a spray bottle and apply to all machine surfaces, making sure to spray under all the machine fixtures. Clean or change all machine filters at this time.

### **RECHARGE**

Refill the system with fresh coolant mixture and circulate. Remember to always use the OIL (oil in first) method when mixing water-soluble oils or semi-synthetic coolants. This will produce stronger emulsions and increase the life of the fluid.

In cases where the sump is extremely contaminated before the change-out it is a good practice to treat the sump two or three days after the change-out to make sure the bacteria/fungus problem is completely cleared.

