



Preparing Machines & Metalworking Fluids for Start Up



Machine Start Up

When coming out of an extended shutdown, coolant systems should be reviewed on an individual basis to ensure degradation of the fluid has not occurred and optimum performance of the metalworking fluid can be achieved.

Visit www.chemarrow.com to learn more about our full line of metalworking fluids, industrial lubricants & cleaners.



Here are some steps you can take to best review each system prior to use.

- Step 1** Skim and remove surface contaminants, tramp oil and residues.
- Step 2** Remove any swarf/chips from filtration or catchment trays.
- Step 3** Circulate coolant for several hours to ensure aeration and any stagnant fluid is purged.
- Step 4** Calibrate your refractometer with water to read zero.
- Step 5** Measure the health of the coolant (concentration and pH) and adjust accordingly to ensure it is within the recommended parameters.
- Step 6** Fill sump to capacity with fresh fluid.

In most cases, these actions will bring the coolant parameters back into control with no unpleasant odours. In cases where it does not, the following products may be added for adjustment (see next page).



CHEM ARROW EUROPE
Bentley, Surrey UK
Tel +44 (0) 1420-383035
sales@chemarroweurope.com

CHEM ARROW KOREA
Seoul, South Korea
Tel: +822-368-2020
sales@chemarrowkorea.com

CHEM ARROW CORP
Irwindale, CA USA
Tel: +1-626-358-2255
sales@chemarrow.com

CHEM ARROW CN
Beijing, PRC
Tel: +86-18612216558
saleschina@chemarrow.com

CHEM ARROW CANADA
Hamilton, ON Canada
Tel: +1-905-332-0216
salescanada@chemarrow.com



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In most cases, the steps on the previous page will bring the coolant parameters back into control with no unpleasant odours. In cases where they do not, the following products may be added for adjustment:

Systems in good condition

- Emulsion Conditioner
- ArrowClean 25020 (Systems Cleaner)

Single sump systems in degenerated condition

Depending on the duration of the machine's inactivity and previous health condition it may be more economical to drain, clean and refill.

If the machine is heavily contaminated with foreign oil, swarf, chips or microbiology in combination with a low pH value (< pH 8.5), we recommend the machine should be sanitised and the fluid is changed in the following way:

- Step 1** Add ArrowClean 25020 at 3% and circulate for a minimum of 24 hours.
- Step 2** Remove dirty fluid and clean machine thoroughly including all swarf trays and filtration.
- Step 3** Thoroughly rinse after circulation to remove all residues.
- Step 4** Dispose of spent fluid in an approved manner.
- Step 5** Recharge the machine sump with fresh Chem Arrow coolant at recommended concentration.

Remember to always wear the correct Personal Protective Equipment (PPE).

Contact your Chem Arrow sales representative or distributor with any questions.



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