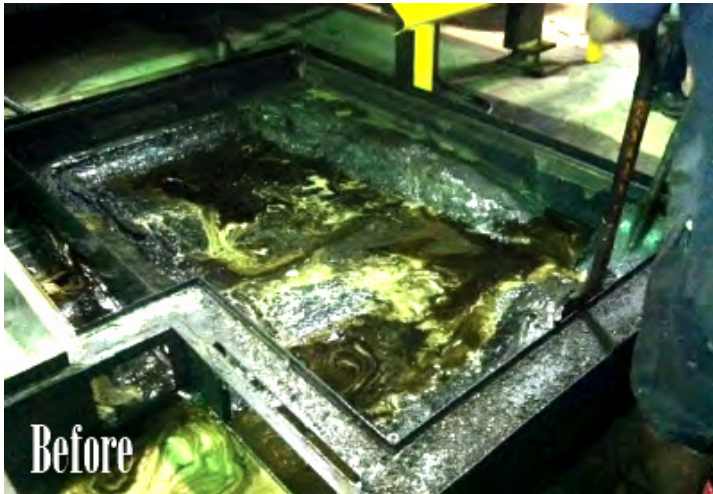




# Coolant Cleanouts

LET US TAKE CARE OF THE DIRTY WORK



ITEM	DESCRIPTION	PRICE
AHB-CLEANOUT-VMC50	Cleanout Vertical Machining Center up to 50 Gallon Tank	\$300.00
AHB-CLEANOUT-VMC100	Cleanout Vertical Machining Center up to 100 Gallon Tank	\$375.00
AHB-CLEANOUT-VMC250	Cleanout Horizontal Machining Center up to 250 Gallon Tank	\$500.00
AHB-CLEANOUT-HMC100	Cleanout Horizontal Machining Center up to 100 Gallon Tank	\$375.00
AHB-CLEANOUT-HMC250	Cleanout Horizontal Machining Center up to 250 Gallon Tank	\$500.00
AHB-CLEANOUT-PW50	Cleanout Parts Washer up to 50 Gallon Tank	\$250.00
AHB-CLEANOUT-PW250	Cleanout Parts Washer up to 250 Gallon Tank	\$400.00
AHB-CLEANOUT-TC50	Cleanout Turning Center up to 50 Gallon Tank	\$300.00
AHB-CLEANOUT-TC100	Cleanout Turning Center up to 100 Gallon Tank	\$375.00
AHB-CLEANOUT-TC250	Cleanout Turning Center up to 250 Gallon Tank	\$500.00
AHB-CLEANOUT-SAW16	Cleanout Saw up to 16" Capacity	\$250.00
AHB-CLEANOUT-SAW25	Cleanout Saw up to 25" Capacity	\$375.00

\*MINIMUM CLEANOUT CHARGE \$500.00\*



# Coolant Cleanout Procedure

LET US TAKE CARE OF THE DIRTY WORK

## Preliminary

- Determine the capacity of the tank using the following formula:
- $L \times W \times H = \text{cubic inches (231 cubic inches per gallon)}$ .
- Add appropriate amount of Blasoclean to sump (if needed).
- Run the machine normally for specified time (making sure coolant cycles during that time).

## Inside Machine Procedure

Pressure wash, steam clean and as necessary hand scrub the inside of the machine.

Five key areas to concentrate on are:

1. T-Slots
2. Chip conveyor or auger
3. Slots on table
4. Way covers
5. Around spindle and tool carousel
  - After completing the cleaning, a 3-5% solution of Blaser is sprayed on machined surfaces to prevent any flash rust while sump is being cleaned.

## Sump/Tank Cleaning

- Empty sump.
- Remove sump covers. (All other components including way covers to be removed by customer)
- Clean chip conveyor (Customer removal required - or cleaned as good as possible in place).
- Remove all chips, sludge and other debris from sump. This may require hand scrapping.
- Power wash (steam clean). The steam is the most effective and safest way to destroy any biological growth that might be existing in the tank.
- The sump and diluter vessels are then vacuumed and hand wiped out.
- A similar procedure is then followed on the conveyors.

## Exterior of Machine

- Using fresh coolant or a mild degreaser the external cabinet is wiped down.
- Loose debris is swept and removed.

## Final Fill

- Tank is filled to the proper level and concentration using the Blaser or Dosatron mixer.
- Pump lines are flushed into holding buckets where possible and fluid is discarded.
- Area around the tank is cleaned up.

**\*Customer is responsible for removal/disposal of old coolant & debris. AHB Cleanout personnel is not allowed to disassemble electrical or mechanical machine components and is not allowed to use customer equipment including cranes, forklifts, etc.**