

## ***Blasocut Decantation Procedure***

### ***When to Decant?***

When the coolant is contaminated with tramp oils above 2% and/or with metal fines/swarf/dirt, the fluid ought to be cleaned. To determine, fill a clear sample bottle from the machine nozzle, then let it stand undisturbed for 12-24 hours. If after settling, the sample has >2% free oil floating on top, or a significant amount of solids settled at bottom, decantation can be utilized to clean the coolant (must meet criteria stated below).

### ***Coolant Criteria***

Coolant must meet the following criteria in order to be successfully recycled

1. pH  $\geq$  8.2
2. Concentration  $\geq$  7% (4% for Kombi)
3. Smell OK

### ***Batch Process : To be successful, do not vary from these guidelines***

1. Pump coolant from the machine(s) into clean & empty decant tank (passing coolant through a 10-20 micron filter prior to the decanter is desirable).
2. Allow coolant to settle undisturbed for 3-5 days, while skimming off the free oil.
3. Drain off the dirt/sludge from bottom of the tank.
4. Adjust concentration with fresh coolant, if necessary.
5. The cleaned coolant is now ready to be “swapped” with dirty coolant from other machines. Passing coolant through a 5-10 micron filter prior to filling machines is also recommended. Do not use the coolant for topping off sumps. Only use for fill up of emptied sumps.
6. Slightly aerate or circulate the coolant continuously after the 5<sup>th</sup> day and ensure the tank is completely emptied and coolant used within 14 days.

### ***NOTES***

1. Decant tank size dependant on size of the largest sump in the plant.
2. Following the above guidelines and using acceptable water quality will ensure success.