ValCOOL®

TROUBLESHOOTING

SOLUTIONS THROUGH INNOVATIVE TECHNOLOGIES

PROBLEM	CAUSES	SOLUTIONS	SEE DETAILS
Foaming	• Concentration too high	• Adjust concentration	1
	• Excessive Pressure / Agitation	• Convert current product to coolant with high pressure capabilities	–
	• Machine cleaner in sump	• Check pH level	3
		• Allow machine to run, cleaner should dissipate	–
	• Mechanical (crack in hose, sump level too low, crack in pump, pump pressure too high) Restricted Intake	• Check machinery and repair as required	–
	• Soft water	• Sample water, treat if necessary	–
	• High tramp oil content	• Skim off oil • Check hydraulic lines for leaks, and repair as required	4
	• Equipment design	• Check system for point of agitation	–

PROBLEM	CAUSES	SOLUTIONS	SEE DETAILS
Rusting	• Concentration too low • pH too low	• Adjust concentration	2
		• Adjust pH level	3
	• Poor mixing (soluble oil)	• Add concentrate to water	1
	• High tramp oil content • High bacteria count	• Skim off oil	4
		• Check hydraulic lines for leaks, and repair as required	4
		• Dump, clean and recharge system	–

PROBLEM	CAUSES	SOLUTIONS	SEE DETAILS
Poor Tool Life	• Concentration too low	• Adjust concentration	1
	• Wrong product being used	• Contact ValCOOL, LLC at 800-244-9004 for information	–
	• Large amounts of biocide added to sump or system	• Contact ValCOOL, LLC at 800-244-9004 for information	–
	• High tramp oil content	• Skim off oil	4
		• Check hydraulic lines for leaks, and repair as required	4
	• Air In coolant	• Check for mechanical problems	–
	• Incorrect application	• Make sure coolant is directed at tool	–

PROBLEM	CAUSES	SOLUTIONS	SEE DETAILS
Odor	• Low concentration	• Adjust concentration	1
	• Low pH	• Check pH then contact a ValCOOL, LLC representative for further instructions	3
	• High tramp oil content	• Skim off oil	4
		• Check hydraulic lines for leaks, and repair as required	4
	• Contamination	• Submit cutting fluid sample to a ValCOOL, LLC representative	–
	• Chips and swarf build-up	• Thoroughly clean sump and machine, and fill with fresh fluid	–

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PROBLEM	CAUSES	SOLUTIONS	SEE DETAILS
Skin Irritation	• High concentration	• Adjust concentration	1 5
	• High pH	• Check pH then contact a ValCOOL, LLC representative for further instructions	3 5
	• High tramp oil content	• Skim off oil	4 5
		• Check hydraulic lines for leaks, and repair as required	4 5
	• Dirty shop cloths	• Use only clean cloths	–
	• Allergies	• Have workers checked for allergies and contact physician if necessary	–
	• Out-of-shop influences	• Check pH then contact a ValCOOL, LLC representative for further instructions	3
	• Material contaminate	• Skim off floating debris and clear chips	–

PROBLEM	CAUSES	SOLUTIONS	SEE DETAILS
Residue in Machine	• High concentration	• Adjust concentration	1
	• High tramp oil content	• Skim off oil	4
		• Check hydraulic lines for leaks, and repair as required	4
	• Incorrect mixing	• Submit cutting fluid sample to a ValCOOL, LLC representative	1
	• High misting operations	• Check ventilation system	–
		• Adjust coolant nozzle(s)	–

	SOLUTION DETAILS	PRODUCTS TO USE
1	**Efficiently mix coolant concentrates with water** • Always add concentrate to water, never the other way. Mix by hand, or with a slow speed mechanical agitator.	• Use a proportioner for "charging" and "make-up" dilutions • Check pH level • Coolant Mixer
2	**Check fluid concentration** • Checking concentration is one of the most important maintenance functions.	• Refractometer, a hand-held instrument to measure actual mix concentration.
3	**Check fluid mix pH** • pH control is critical to maximizing fluid life and performance. Optimum pH range - 8.8 to 9.2.	• Electronic pH Meter. • pH Test Strips to measure fluids in the 8.0 to 9.7 range.
4	**Control tramp oil** • Check and maintain your machines on a regular schedule • Use extreme care in lubricating or filling hydraulic systems	• Sidewinder Skimmer for access to impaired sumps. • Smart Skimmer with integral gravity separator. • Belt Skimmers • Belt Skimmers Diverter only. • Standard Skimmer
5	**Control bacteria growth** • Add oxygen to the sump to kill anaerobic bacteria • Keep sumps clean. Maintain proper cutting fluid concentration and pH • Remove tramp oil	• Oxygenator • Refractometer

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