

LABORATORY ANALYSIS



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Department **CNC**
Equipment No. **O-04 VMC Okuma (X0017)**
System **Machining Fluid**
Oil Type **ENGINEERED LUBRICANTS ENCOOL SS-7478EP-AS (50 GAL)**

DIAGNOSIS

Add ENGINEERED LUBRICANTS ENCOOL SS-7478EP-AS concentrate until reaching a dilution of 15:1. The desired refractometer reading for this reservoir is 3.59. Resubmit sample for testing. Add 0.1 gallons of ENCOOL BASE PH-1-2 to the reservoir in an area of high agitation. Circulate the reservoir for a minimum 15 minutes. Check pH for a minimum reading of 8.9. If the reading has not stabilized at or above an 8.9, repeat the same addition and circulation process until a pH minimum of 8.9 has been achieved. (not applicable) There is no indication of any contamination in the machining fluid. Ratio is too lean. Maintaining the desired ratio is the top priority for optimum coolant performance and longevity. The pH is marginally low. PH is a metric for overall coolant health and stability. Maintaining the desired pH assists with corrosion protection and is a microorganism deterrent.

SAMPLE INFORMATION

Lab Number	New	2307-00262	2305-00428	2303-00064
Date of Sample	(Typical)	07 Jul 2023	08 May 2023	06 Mar 2023
Oil Added		UNK	UNK	UNK
Last Drain Date		--	--	--
Last Filter Service		--	--	--
Sample Point		---	---	---
Sample Status		SEVERE	NORMAL	ABNORMAL

RATIO PER REFRACTOMETER

Refract. Reading		2.3	3.4	2.7
Refract. Model		DIGITAL	DIGITAL	DIGITAL
Refract. Ratio	oil:water	24:1	16:1	20:1

PH (ASTM E-70)

pH	Scale 0-14	8.3	9.1	9.0
Ratio Rec'd	oil:water	AS REC'D	AS REC'D	AS REC'D

BACTERIA COUNT (CLASS RANGE 0 TO 6)

Bacteria Class	Scale 0-6	0	0	0
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FUNGUS COUNT (CLASS RANGES: YEAST 0 TO 4/MOLD 0 TO 3)

Yeast Class	Scale 0-4	0	0	0
Mold Class	Scale 0-3	0	1	0

Customer Id: ENC0303701
Sample No.: EN23070262
Lab Number: 23070262
Test Package: TEST



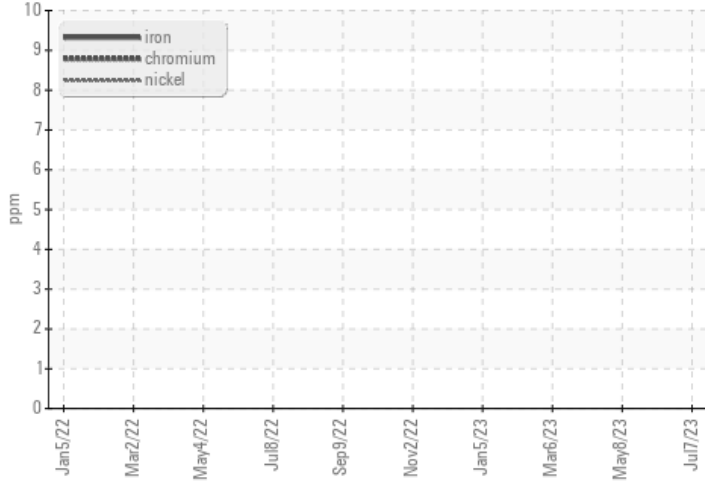
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To discuss the diagnosis or test data:
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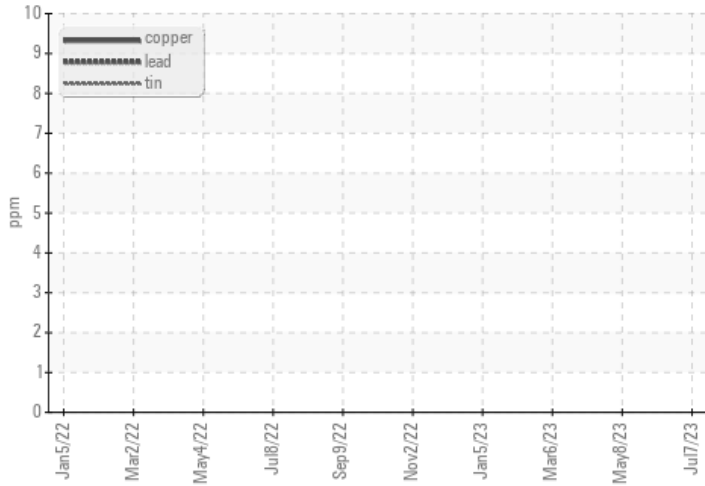
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FUEL REPORT

Ferrous Alloys



Non-ferrous Metals



Viscosity @ 40°C

