

### GREENCUT LONGEVITY is based on Good Maintenance practices

Based on twelve years of operational experience with many Plasma Arc CNC's, LubeCorp recommends:

GreenCut should be maintained at a 20 : 1 ratio of Water to GreenCut, to a maximum 50 : 1 ratio, at which point rust will start to occur.



1. **Check the pH regularly of the bath/table** in order to maintain a 20:1 Water/GreenCut ratio by using pH test strips to do a color match; **pH should be between 9 and 10** for optimum performance.
2. Water Inspection Report (Spectrograph Analysis) of the bath should be done annually to check for abnormalities.
3. GreenCut Cutting Fluid should be changed out completely every two to three years if proper maintenance procedures are not adhered to.
4. GreenCut has been shown to last up to eight years\*, and counting, without change-out provided that the coolant reservoir and equipment are properly maintained.
5. Circulation of the bath/tank must be maintained while it is in operation. Use a circulation pump which covers the whole tank, to promote cooling from the plasma torches and to stimulate biodegradation of the tramp oils which come into the tank via the steel plates that are being cut/machined, etc. (GreenCut instantly does this interfacing at the molecular level in contacting any oils in the bath, breaking the oils down into water and carbon dioxide.)

\* \_\_\_\_\_ Iron Works, USA is now in year 8 without change-out of the GreenCut Cutting Fluid. They are excellent in their maintenance and we fully expect their Plasma Arc Cutting table to go to ten years without GreenCut coolant change-out, utilising their existing maintenance plus these recommendations, adding GreenCut Cutting Fluid to the bath as indicated by the pH strip readings.

Please contact me with any questions or concerns you may have.

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