

Coolant Troubleshooting Guide

This chart will assist you in troubleshooting coolant failures and was designed to provide a visual reference to indicate these failures and how they are traced to one or more sources for correction. Also reference other failures that may arise if a preventative maintenance protocol, such as Hardness (ppm), is mismanaged or entirely neglected.

Hardness (ppm)	Concentration (%)	pH (pH)	Tramp Oil (T/O)	Chips (Ch)
Premature Tool Wear	Premature Tool Wear	Premature Tool Wear	Premature Tool Wear	Premature Tool Wear
Poor Finishes	Poor Finishes	Poor Finishes	Poor Finishes	Poor Finishes
Rust	Rust	Rust	Rust	
Split Emulsions	Raw Material Waste	Split Emulsions	Split Emulsions	Split Emulsions
Grease Formation	Skin Sensitivity	Skin Sensitivity	Skin Sensitivity	Skin Sensitivity
Foam	Emulsified Oils		Emulsified Oils	Emulsified Oils
Gummy Residues	Gummy Residues	Foul Odor	Foul Odor	

H = High Value L = Low Value

Shop Mist & Smoke



For instance, coolant odor is traced to poor management of Tramp Oil and pH. Skim tramp oil more frequently, aerate the fluid when not in use, and monitor pH levels to prevent recurrence. You may also be experiencing other problems that are caused by the same neglect, such as prematurely worn tooling, poor finishes, split emulsions, rust, and skin sensitivity.

Refer to the Zebra Coolant Quality Log for maintenance frequency recommendations and to log their performance. Go to ZebraSkimmers.com for products to manage all protocols.