



Change over procedure from mineral to glycol based hydraulic fluids

1. Drain the system as completely as possible paying attention to pipe lines, accumulators, dead legs and other places where residual oil might be trapped. Clean the inside of reservoir thoroughly by either steam cleaning or wiping with lint free cloth.
2. Remove filters, clean and replace with suitable elements. Water-glycol fluids can be used with all suitable seal materials except, polyurethane, leather or cork. As mineral oils have a tendency to swell most seal materials, whereas water glycol fluids do not, it may be good practice to change critical seals as old seals may have a tendency to shrink.
3. Fill the system with a 10% solution of Semi-Synthetic Cutting Fluid or HFA fluid until there is enough liquid to maintain pump suction and operate the system at minimum pressure for 30minutes.
4. Drain the system as completely as possible without allowing it to settle.
5. Re-check filters and strainers for contamination.
6. Fill reservoir with Water Glycol Hydraulic Fluid to full operating level.
7. The system is now ready for normal operation.
8. After 1 or 2 weeks operation send sample back to supplier for water loss and viscosity check. Periodical service checks are good practice, the time interval of which should depend on the severity of operation.

Little Row, Fenton Industrial Estate
Stoke-on-Trent, Staffordshire ST4 2SQ
Telephone. 01782 410381 / 410389
Fax. 01782 410684