



November 2011

Monitoring pH Keeps Your Metalworking Fluids Performing Optimally!

Even though it is one of the easiest test to perform, measuring pH is one of the most often overlooked metalworking fluid test. A varying pH, a rapid increase or decrease can be good early indicators of potential problems. However, do not confuse measuring pH with measuring concentration. A sump at the proper concentration can have an out-of-specification pH and the reverse is also true. It is always best to conduct both tests.

Simple [pH indicator strips](#) often used with pools or spas are the least expensive and easiest to use. Hold the test strip in the coolant or cleaner (at the spindle if possible) and compare to the color chart that comes with the strips. The metalworking fluid's Data and Information sheet will tell you the recommended pH value.

In cutting fluids, a low pH or a gradual decrease is usually a sign of growing bacteria or poor concentration control, while sudden changes are usually associated with contamination from such things as mop water or cleaners.

For more information about pH in metalworking fluids, download these Master Chemical Technical Bulletins!



[Characteristics of Metalworking Fluids -pH+](#)



[Characteristics of Metalworking Fluids - The Importance of pH+ and Reserve Alkalinity](#)