

Haas Coolant Concentration Check

Problem

HAAS Coolant needs to be checked regularly both for Fill Level and Concentration.

Concentration should be checked with the refractometer at 10 brix +/- 1.

Solution

The refractometer is in a brown plastic case in one of the bottom drawers in the HAAS tool chest.

It is cylindrical and about the diameter of an old "d" size battery flashlight and about 6-8 inches long.

Watch some YouTube videos on using a refractometer....my sparse instructions will make sense in conjunction with most videos.

1. remove the refractometer from its case then remove the black stirring stick from the bottom of the refractometer
2. dip the stirring stick into the coolant in the chip trough of the HAAS
3. lift the opaque flap of the refractometer on the side opposite to the eyepiece.
4. touch the stirring rod to the exposed glass; placing coolant on the glass
5. close the opaque flap sandwiching the coolant between the glass and opaque flap
6. with the flap oriented upward towards a brightish light look through the eyepiece and note where the horizontal line falls related to the graduations
7. open the opaque flap
8. wipe off the coolant from the underside of the flap and the glass surface with a soft cloth
9. close the transparent flap
10. wipe off the stirring stick with a paper towel
11. return the black stirring stick to its clips on the refractometer
12. put the refractometer back in its case
13. put the refractometer in the drawer, where you found it
14. let the HAAS distribution know what the reading was on talk