



## Mixing Guide

Product: Stoughcool Jet 9PXD  
 Multiplier/Factor 1.0

Below is a general guide for coolant mixtures and refractometer readings. Please note the Pre-mix/daily make up is to be added to sump to maintain coolant mixture. Never use **pre-mix only** to charge up empty machine as the pre-mix is “thin” and is to be added to machines to maintain mixture and allowing for evaporation and carry off.

### **Charging up Empty Machine Sump**

When charging up an empty machine sump with 8% coolant, we need to provide sump with an 8% mix. For example, if sump is 100 gallons, add approximately 8 gallons of coolant to sump. This is the charge up procedure. Once machine is charged up at desired mix, then pre-mix/ daily make-up can be added daily to keep mixture within range.

### **Pre-Mix/ Daily Make Up**

The Pre-Mix/Daily Make Up is to be added to the coolant sump daily. This is used to maintain mixture in the machine. It is typically less than half of the desired concentration needed.

<b>Pre-Mix Guide/Daily adds to tanks</b>		
<b>Target Coolant Mix Range</b>	<b>Coolant Pre-Mix</b>	<b>Pre-Mix Refractometer Reading</b>
6%-to-10%	4.0%	4.0

<b>Refractometer Reading</b>	<b>Coolant Mix</b>
1.0	1.0%
2.0	2.0%
3.0	3.0%
4.0	4.0%
5.0	5.0%
6.0	6.0%
7.0	7.0%
8.0	8.0%
9.0	9.0%
10.0	10.0%
11.0	11.0%
12.0	12.0%

Desired Coolant mix in machine sump highlighted