

STARCHEM

Foam Reducer

Metalworking Fluid Additive

GENERAL DESCRIPTION

Foam Reducer is water-soluble calcium salt solution that increases total hardness when added to water or to a metalworking fluid mix. This additive is an effective defoamer designed to control or eliminate excessive foaming due to soft water. Unlike silicone or other insoluble antifoams, **Foam Reducer** is a much longer lasting and often permanent solution to foam problems.

APPLICATION

Foam Reducer is recommended for use in semisynthetic and soluble oil metalworking fluids. Emulsion products provide maximum performance in the 100 ppm to 200 ppm hardness range. Water hardnesses below 100 ppm can cause foam whereas water hardnesses above 200 ppm can cause residues, dirty machines and parts, and split mixes.

Add **Foam Reducer** to the clean side of central systems or return troughs or directly to the sump of individual machines. On a fresh recharge, adding **Foam Reducer** to the water before adding the metalworking fluid concentrate will provide maximum effectiveness.

The attached table provides the levels of **Foam Reducer** required to increase the total hardness to 200 ppm. The addition levels are based on the current water hardness of the system and the sump size. In most cases, increasing hardness above 200 ppm will not improve foam control.

PHYSICAL PROPERTIES

Form	Clear Liquid	Specific Gravity (H₂O=1)	1.06
Solubility in Water	Complete	Density, lbs./gals.	8.8

AVAILABILITY

Foam Reducer is available in 1-gallon jugs, 5-gallon pails and 55-gallon drums.

HEALTH & SAFETY

The most recent MSDS is available from either **STARCHEM** or your authorized **STARCHEM** Distributor.

NOTES

- For Industrial Use only. Consult **STARCHEM** before using this product on any metals or applications not specifically recommended.
- The general description, recommended uses, application data and statements in the product literature are guidelines. Because this product may be used for a variety of applications over which the manufacturer has no control, the manufacturer assumes no liability for incidental, consequential, or direct damages of any kind, regardless of causes, including negligence.

Foam Reducer Additions to Increase Total Water Hardness to 200 ppm

Sump Size, Gals.	Current Water Hardness							
	0 ppm		50 ppm		100 ppm		150 ppm	
	Amount of Foam Reducer Required							
	oz.	gals.	oz.	gals.	oz.	gals.	oz.	gals.
50	6.4		4.8		3.2		1.6	
100	12.8		9.6		6.4		3.2	
150	19.2		14.4		9.6		4.8	
200	25.6		19.2		12.8		6.4	
300	38.4		28.8		19.2		9.6	
400	51.2		38.4		25.6		12.8	
500	64.0		48.0		32.0		16.0	
1,000		1.0	96.0		64.0		32.0	
1,500		1.5		1.1	96.0		48.0	
2,000		2.0		1.5		1.0	64.0	
2,500		2.5		1.9		1.3	80.0	
3,000		3.0		2.3		1.5	96.0	
4,000		4.0		3.0		2.0		1.0
5,000		5.0		3.8		2.5		1.3
7,500		7.5		5.6		3.8		1.9
10,000		10.0		7.5		5.0		2.5
15,000		15.0		11.3		7.5		3.8
20,000		20.0		15.0		10.0		5.0
25,000		25.0		18.8		12.5		6.3
30,000		30.0		22.5		15.0		7.5
40,000		40.0		30.0		20.0		10.0
50,000		50.0		37.5		25.0		12.5
100,000		100.0		75.0		50.0		25.0

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