

Blend Tech Blending Procedure

Date: August 1, 2013

Document Description: Blending Procedure for NMOAT EG 50/50 Premix

Formulation: @60°F

	Lbs/gal	% by Volume	10,000 Gallon Blend Gal
1. Ethylene Glycol	9.3081	46.64	4617.36
2. Demineralized Water	8.3462	49.61	4911.39
3. NMOAT	9.1983	3.75	371.25
Coolant Total:	8.9205	100.00	9900*

Blend Procedure:

1. Temperature of Water, EG and Inhibitor should be at least 60° F. Assure that the Inhibitor has been mixed until homogenous. Fluids should be combined gradually while the batch is being agitated.
2. To the specified amount of EG, slowly add in specified amount of demineralized water. Mix thoroughly. Assure that the pH of the water and the EG is 6.5-9.0.
3. Always mix the inhibitor before decanting to assure that the chemicals have been combined in the container (barrel, tote or bulk). Slowly pump in proper amount of NMOAT blending syrup into the tank.

Note: Drummed NMOAT must be stored @ 60°F or above. Should NMOAT crystallize in the drum due to low temperature storage, heat the drum to 80°F - 90°F, and mix thoroughly until crystals completely redissolve.

4. Mix further for at least one hour. Check for proper pH.

* Total gallons do not add to 10,000 because volume shrinks when different liquids are mixed together.

Quality Control Limits

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Product: NMOAT EG 50/50 Premix

Tests:	ASTM	Spec Limit
Specific Gravity, 60°F	D-1122	1.065 - 1.080
pH	D-1287	7.8 - 8.5
Freeze Point	D-3321	-34°F max.
Nitrite	D-5827	375 - 425 ppm
Molybdate	D-5827	405 - 475 ppm