BlendTech Blending Procedure

Date: August 1, 2013

Document Description: *Blending Procedure for NMOAT EG Concentrate*

Formulation: *@60°F*

	Relative Density		% by Volume	10,000 Gallon Blend
	mg/L	Lbs/gal		Gal
1. Ethylene Glycol	1.1155	9.3081	92.50	9,250.0
2. NMOAT	1.1022	9.1983	7.50	750.0
Coolant Total:	1.1146	9.3003	100.00	9900*

Blend Procedure:

1. Temperature of EG and Inhibitor should be at least 60º F. Assure that the Inhibitor has been mixed until homogenous. Fluids should be combined gradually while the batch is being agitated. If EG is measured by volume, take into account the changes of density at different temperatures. Maintain good mixing.

2. 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.

3. Mix further for at least one hour. Check for proper pH. Adjust as required.

*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 Concentrate*

Tests:	ASTM	Spec Limit
Specific Gravity, 60°F	D-1122	1.110 – 1.130
pH	D-1287	8.1 – 8.7
Freeze Point	D-3321	-34°F max.
Nitrite	D-5827	750 – 850 ppm
Molybdate	D-5827	810 – 950 ppm