Lincoln Electric® PlateGuard™:
Installation & Maintenance

This document details the procedure for adding Lincoln Electric PlateGuard to your water table. It is recommended that the table be clean and clear of any remaining debris or leftover water that may contain other additive solutions prior to adding PlateGuard.

PlateGuard helps prevent rusting of the water table itself, and any material that is loaded onto the machine to be cut. It is recommended that the content of the water table is 10% PlateGuard to 90% water for maximum effectiveness. Concentration will fall over time as product splashes out or is removed with cut parts. When concentration levels reach 5%, more PlateGuard must be added to maintain effectiveness.

Please Note:

Verify that the table is clean & dry, check that all water drain valves are closed prior to beginning these steps

Step 1:

With a clean & dry table, add the PlateGuard product to the water table first. The table below shows the appropriate amounts of PlateGuard based on table model and size to achieve the recommended concentration of PlateGuard to Water.

- Torchmate 4400 - 5 Gallons
- Torchmate 4800 - 10 Gallons
- Torchmate X 5'x10' - 30 Gallons
- Torchmate 5100 - 35 Gallons
- Torchmate X 6'x14' - 45 Gallons
- Torchmate X 8'x22' - 100 Gallons

Step 2:

With the PlateGuard product added to the water table, add water to the appropriate full amount. Reference your specific model table's user guide for specific filling instructions.

Step 3:

To measure the concentration level of PlateGuard additive in your water table a 0-10% Brix Refractometer can be used to measure the difference in clear "house" water (the water used to fill the machine) and water from the table after the PlateGuard has been added.

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Step 4:

The recommended concentration percentage should be 5-10% of PlateGuard to water. When utilizing a refractometer, the percentage Brix is equal to 1/5th of actual concentration percentage. For example, a 1% Brix reading equals a 5% concentration level. A 2% Brix reading equals a 10% concentration.

The chart below can be utilized to quickly reference the % Brix reading to PlateGuard concentration percentage.

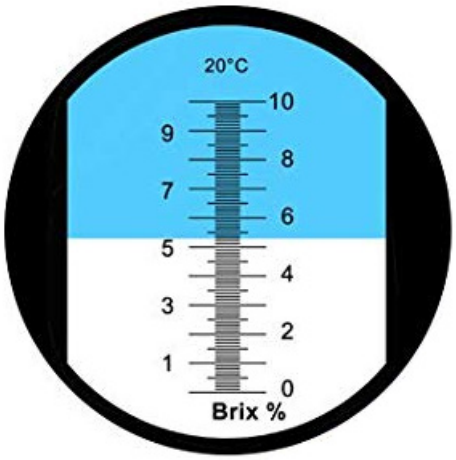
Reading % Brix	PlateGuard Concentration %
0.0	0.0%
0.5	2.5%
1.0	5.0%
1.5	7.5%
2.0	10.0%
2.5	12.5%
3.0	15.0%
3.5	17.5%
4.0	20.0%
4.5	22.5%
5.0	25.0%

Step 5:

Place a sample on the refractometer's prism, and close the daylight plate. Ensure the sample covers the entire prism.

Step 6:

Point the prism and daylight plate towards a bright light source, and look through the lens. Adjust the focus ring of the refractometer until the numbers on the scale, and line across the scale are clearly visible.



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