Designation: D 3519 – 88 (Reapproved 1997)

An American National Standard

AMERICAN SOCIETY FOR TESTING AND MATERIALS
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Standard Test Method for Foam in Aqueous Media (Blender Test)[1]

This standard is issued under the fixed designation D 3519; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ε) indicates an editorial change since the last revision or reapproval.

1. Scope

1.1 This test method covers the measurement of the increase in volume of a low-viscosity aqueous liquid (less than 3 cSt at 40°C) due to its tendency to foam under high shear conditions.

NOTE 1—Foam under low shear is covered by Test Method D 3601.

1.2 The values stated in SI units are to be regarded as the standard. The values given in parentheses are provided for information only.

1.3 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.* Fig. 1 Fig. 2 Fig. 3

2. Referenced Documents

2.1 *ASTM Standards:*

D 1126 Test Method for Hardness in Water[2]

D 3601 Test Method for Foam In Aqueous Media (Bottle Test)[3]

3. Summary of Test Method

3.1 The increase in volume is determined by the increase in total height of test fluid including foam after blending for 30 s using a commercial-type blender with glass jar (see Note 2) at 25 ± 1°C (77 ± 1.8°F) agitating between 4000 and 13 000 rpm. The preferred range would be 8000 ± 1000 rpm.

4. Significance and Use

4.1 The results obtained by the test method described are useful as guides in determining the tendency of a water-based metalworking coolant to produce foam under high shear conditions. No correlation with changes in heat transfer, pumpability, or other factors affected by foam is intended. The foam produced by any given industrial process depends on the method by which the foam is generated and may not be directly proportional to that produced by this carefully controlled laboratory test method. Further, the foam generated at the specified test temperature will not necessarily predict the foaming tendency of the liquid (that is, metalworking coolant) at some other use temperature.

5. Apparatus

5.1 *Blender*.

NOTE 2—Tests with blenders other than commercial 7-speed Waring Blendor Model 5012G or Model 91-264 (7012G), as shown in Fig. 1, may be suspect due to differences in speed or shape of the jar.[4] The blender speed should be calibrated by any reliable means. One means can be to use a hand-contact tachometer to get the order of speed and then to get several more precise determinations using a stroboscope (which does not touch the rotor). Settings then can be selected to obtain the recommended speed.

5.2 *Water Bath*, constant-temperature, suitable to hold blender jar and several bottled emulsions at 25 ± 1°C (77 ± 1.8°F) for 1 to 2 h.[5]

5.3 *Stop Watch* or *Timer,* capable of measuring 5 min ± 0.2 s.

5.4 *Glass Jars* or *Bottles*, clean or new, 250-ml (8-oz) or 500-ml (16-oz).

5.5 *Graduated Cylinder*, 250-ml, fitted with ground-glass stopper.

5.6 *Rule*, millimetre, approximately 300 mm long to be attached to the blender jar.

6. Materials

6.1 *Distilled Water*.

6.2 *Hard Water*, 20 000 ppm, made as follows: Dissolve 29.4 g of reagent grade (ACS standard) $CaCl_2 \cdot 2H_2O$ in 1 L of freshly boiled distilled water. (Used only where distilled water is used as in Note 3.)

7. Procedure

7.1 Clean and rinse the blender with distilled water using 10 s blends and fresh samples of distilled water until no appreciable foam is developed by blending.

7.2 Place the blender jar in the constant-temperature bath. (The bath water should not be allowed inside the jar.)

7.3 Using the manufacturer's recommended procedure, prepare 200 ml of emulsion at the recommended use concentration.

[1] This test method is under the jurisdiction of ASTM Committee D-2 on Petroleum Products and Lubricants and is the direct responsibility of Subcommittee D02.L0.01 Metal Removal Fluids and Lubricants.

Current edition approved Oct. 31, 1988. Published January 1989. Originally published as D 3519 – 76. Last previous edition D 3519 – 76 (1982)$^{\epsilon 2}$.

[2] *Annual Book of ASTM Standards*, Vol 11.01.

[3] *Annual Book of ASTM Standards*, Vol 05.02.

[4] Except for exterior finish of the base, Blendor Models 5012G and 7012G (91-264) are the same. Blendors may be purchased from Waring Products Div., or through supply houses (such as Cole Palmer No. 4244-80).

[5] A common household dishpan is satisfactory when the test temperature is close to room temperature.

FIG. 1 Commercial Blender (See Note 1).

1. **Preparation of Emulsion**
   - 1.1 (7.3) Sample description
   - 1.2 (7.3) Concentration, %
   - 1.3 (7.4) Source of water used
   - 1.4 (7.4) Water hardness, ppm
   - 1.5 (7.3) Method of preparing emulsion

2. **Test Data**

2.1 (7.9)	Temperature at start of test	°C
2.2 (7.10)	Initial height (*I*)	mm
2.3 (7.12)	Maximum total height at zero time (*M*)	mm
2.4 (7.14)	Residual total height after 5 min (*R*)	mm
2.5 (7.13)	Time to defoam to 10 mm (to nearest ½ min)	min
2.6 (7.15)	Temperature at end of test	°C

Caution—The round robin on this test used distilled water and a controlled synthetic hard water to make data comparative to the products under test at different places and at different times. Care must be exercised when natural waters are used that comparative samples are used in exactly the same water, taken at the same time from the same source. (For instance, well waters can change in hardness rapidly depending on the change in demand within the hour.)

NOTE 1—Numbers in parentheses indicate the section within the body of the method where the observations to be recorded are made.

FIG. 2 Suggested Test Form for Recording Data.

7.4 When tap water is used, record water hardness (using Test Method D 1126), source, and date obtained.

NOTE 3—In the absence of manufacturers' recommendations, place 190 ml of distilled water in the 250-ml capacity glass-stoppered graduated cylinder. Pour a fine stream of coolant concentrate into the cylinder to bring the liquid level to the 200-ml mark, being careful not to run concentrate down the side of the cylinder. (A syringe or serological pipet with rubber bulb may be found convenient here.[6]) Immediately, stopper and shake the cylinder to form a 5 % emulsion or solution.

7.5 Pour the test liquid into a clean glass bottle or jar and store it at 25 ± 1°C (77 ± 1.8°F) for a minimum of 1 h and a maximum of 2 h in the constant-temperature water bath deep enough so that the water level is at least 10 mm above the air-test fluid interface.

7.6 Assemble the blender.

7.7 Attach a millimetre rule to one side of the blender so that the 0 mm matches with the inside bottom of the blender jar.

NOTE 4—Permanent attachment using epoxy cement may be found to be convenient. An adhesive-backed transparent measuring tape is also suitable.[7]

7.8 Pour the test liquid into the blender jar.

[6] Serological pipets, Corning No. 7077 or Fisher No. 13-671-108E, are suitable for more viscous fluids.

[7] One suitable transparent tape is sold under the brand "Scalefix Scales" by Bel-Art Products Inc., Pequannock, NJ, Catalog No. H-2075 (1974).