Designation: E2657 – 16

An American National Standard

Standard Practice for Determination of Endotoxin Concentrations in Water-Miscible Metalworking Fluids[1]

This standard is issued under the fixed designation E2657; 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 practice covers quantitative methods for the sampling and determination of bacterial endotoxin concentrations in water miscible metalworking fluids (MWF).

1.2 Users of this practice need to be familiar with the handling of MWF.

1.3 This practice gives an estimate of the endotoxin concentration in the sampled MWF.

1.4 This practice replaces Method E2250.

1.5 This practice seeks to minimize inter-laboratory variation of endotoxin data but does not ensure uniformity of results.

1.6 *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.*

2. Referenced Documents

2.1 *ASTM Standards:*[2]

D4840 Guide for Sample Chain-of-Custody Procedures

E1488 Guide for Statistical Procedures to Use in Developing and Applying Test Methods

E1497 Practice for Selection and Safe Use of Water-Miscible and Straight Oil Metal Removal Fluids

E1542 Terminology Relating to Occupational Health and Safety

E2250 Method for Determination of Endotoxin Concentration in Water Miscible Metal Working Fluids (Withdrawn 2008)[3]

2.2 *Government Standard:*[4]

29 CFR 1910.1450 Occupational Exposure to Hazardous Chemicals in Laboratories

2.3 *Other Documents:*[5]

Criteria Document for a Recommended Standard: Occupational Exposure to Metalworking Fluids, 1998 NIOSH

Manual of Analytical Methods (NMAM), 4th ed., Eller and Cassinelli, Eds., 1994

3. Terminology

3.1 For definitions of terms relating to this practice, refer to Terminology E1542.

3.2 *Definitions of Terms Specific to This Standard:*

3.2.1 *control standard endotoxin (CSE), n*—a purified preparation of endotoxin based on the USP Reference Standard Endotoxin (RSE); used in laboratories to prepare standard solutions.

3.2.2 *endotoxin, n*—pyrogenic high molar mass lipopolysaccharide (LPS) complex associated with the cell wall of gram-negative bacteria.

3.2.2.1 *Discussion*—Though endotoxins are pyrogens, not all pyrogens are endotoxins. Endotoxins are specifically detected through a Limulus Amoebocyte Lysate (LAL) test.

3.2.3 *endotoxin unit (EU), n*—a biological potency unit equivalent to the FDA Reference Standard Endotoxin (RSE).

3.2.3.1 *Discussion*—The current RSE (EC-6) is equivalent to 1ng = 10 EU.

3.2.4 *geometric mean (GM), n*—the central tendency of a set of numbers expressed as the nth root of their product.

3.2.5 *geometric standard deviation (GSD), n*—the spread of data in a set of numbers expressed as a geometric mean.

3.2.6 *Gram-negative bacteria, n*—prokaryotic cells that have a complex cell wall structure that stains characteristically when subjected to the differential Gram staining procedure.

[1] This practice is under the jurisdiction of ASTM Committee E34 on Occupational Health and Safety and is the direct responsibility of Subcommittee E34.50 on Health and Safety Standards for Metal Working Fluids.

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[2] For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

[3] The last approved version of this historical standard is referenced on www.astm.org.

[4] Available from U.S. Government Printing Office Superintendent of Documents, 732 N. Capitol St., NW, Mail Stop: SDE, Washington, DC 20401, http://www.access.gpo.gov.

[5] Available from CDC/NIOSH, 4676 Columbia Pkwy, Cincinnati, OH 45226-1998.

3.2.7 *inhibition/enhancement phenomenon, n*—conditions or artifacts in sample solutions that cause endotoxin concentration data from LAL assays to be less than or more than the concentration of endotoxin actually present in a given aqueous sample.

3.2.8 *Limulus amebocyte lysate (LAL) assay, n*—a biological assay dependent on a series of cascading enzyme reactions that occur when Limulus blood cell (amebocyte) lysate combines with endotoxin.

3.2.9 *metalworking fluid (MWF), n*—any fluid used for the purpose of cooling or treating metal surfaces during metal removal, metal forming or surface protection or preservation.

3.2.10 *metal removal fluid (MRF), n*—any fluid in the subclass of metalworking fluids used to cut, or otherwise take away material or piece of stock.

3.2.10.1 *Discussion*—Metal removal fluids include straight or neat oils (D2881), not intended for further dilution with water, and water miscible soluble oils, semisynthetics and synthetics, which are intended to be diluted with water before use. Metal removal fluids become contaminated during use in the workplace with a variety of workplace substances including, but not limited to, abrasive particles, tramp oils, cleaners, dirt, metal fines and shavings, dissolved metal and hard water salts, bacteria, fungi, microbiological decay products, and waste. These contaminants can cause changes in the lubricity and cooling ability of the metal removal fluid as well as have the potential to adversely affect the health and welfare of employees in contact with the contaminated metal removal fluid.

3.2.11 *Operator-dependent assay, n*—an assay performed by a technician in such a manner to cause significant influence(s) on the resultant data.

3.2.12 *pyrogen-free (PF), adj*—material(s) devoid of measurable endotoxin activity.

3.2.13 *pyrogen-free water (PFW), n*—processed water that is devoid of measurable endotoxin activity.

3.2.14 *sensitivity range, n*—a span of endotoxin measurements expressed as EU/mL or λ.

4. Summary of Practice

4.1 Serial dilutions of CSE in PFW in borosilicate glass test tubes are prepared to construct a calibration curve.

4.2 The metalworking fluid sample is sonicated, centrifuged, and the supernatant retained.

4.3 Triplicates of the sample supernate, standard serial dilutions, blanks, and positive control solutions are subjected to the kinetic chromogenic LAL assay.

4.4 If data indicate interferences are present, MWF supernate is diluted and assay is performed with diluted supernate.

4.5 The reaction of Limulus amebocyte lysate with sample endotoxin imparts a proportional yellow color to the analyte solution that is measured photometrically at 405 nm.

4.6 The measured endotoxin concentration is reported as EU/mL.

5. Significance and Use

5.1 The determination of endotoxin concentrations in MWF is a parameter that can be used in decision-making for prudent fluid management practices (fluid draining, cleaning, recharging or biocide dosages).

5.2 This standard provides a practice for analysts who perform quantitative endotoxin analyses of water-miscible MWF.

6. Interferences

6.1 Data from samples analyzed by LAL methodologies are prone to variations due to batch differences in lysate composition/processing, non-optimal pH and temperatures of assay solutions.

6.2 In the event that the phenomenon of inhibition/enhancement influences this practice, endotoxin concentration data will be less than or more than actual concentrations present in a given MWF sample.

6.3 LAL assays are highly influenced by the skill/experience level of the analyst.

7. Apparatus

7.1 *Sampling:*

7.1.1 *Sample Collection Container,* pyrogen-free, wide-mouth, stainless steel sealable container, at least 100 mL capacity.

7.1.2 *Glass Pipet,* pyrogen-free, 50 mL.

7.1.3 *Battery-Powered Aspirator Unit (or suction bulb),* compatible with 100 mL glass pipet.

7.2 *Extraction:*

7.2.1 *Centrifuge,* minimum rotational speed of 5000 rpm.

7.2.2 *Ultrasonic Water Bath,* ultrasonic/water bath apparatus with a minimum peak frequency of 40 kHz with cavitation adjustment and thermostat control; use pyrogen-free glass containers only.

7.3 *Analysis:*

7.3.1 *Incubating/Shaking Microplate Reader,* spectrophotometric at 405 nm.

7.3.2 *Statistical Analysis Software Package for Microplate Reader.*

7.3.3 *Vortexer,* variable speed.

7.3.4 *Microtiter Plates,* flat-bottomed, pyrogen-free, 96-well.

7.3.5 *Dilution Tubes,* pyrogen-free, 13 by 100 mm.

7.3.6 *Borosilicate Glass Test Tubes,* pyrogen-free, screw caps, 10 by 75 mm.

7.3.7 *Single-Channel Micropipetor(s),* 0.5-10 µL.

7.3.8 *Eight-Channel Micropipetor,* 100 µL.

7.3.9 *Pipet Tips,* pyrogen-free, 300 µL.

7.3.10 *Glass Rod,* pyrogen-free.

7.3.11 *Reagent Reservoir,* pyrogen-free, 8-channel multipipettor compatible.

7.3.12 *Parafilm M.*