



Formulations For Today's
Technical Manufacturing Needs

An ISO 9001:2000 Certified Company

ASTRO-SOL N

General Description

ASTRO-SOL N is a soluble oil concentrate. This product was designed to be extended with water for the machining and grinding of virtually all metals except magnesium.

Application

ASTRO-SOL N is designed for use in all metalworking applications such as CNC milling, turning, drilling, tapping and grinding.

Advantages

- Low Foaming
- Excellent Corrosion Inhibition
- Excellent Hard Water Stability
- Sulfur, Chlorine and Phosphorous Free
- Mild Pleasant Odor
- Long Lasting
- Operator Friendly
- Provides Excellent Finish

Recommended Concentrations

Application	Concentration, %	Ratio	Refractometer
Milling, Drilling or Turning	5%	1:20	5.0
Centerless, ID, OD, Surface Grinding	4%	1:25	4.0
Tapping, Reaming, Sawing	10%	1:10	10.0

Mixing Instructions

When mixing coolant, it is best to use an automatic proportioner which accurately and thoroughly mixes coolant. To maintain recommended concentration, make-up or top-off should be added at one-half of the desired concentration. Never add concentrate directly to the machine; this could cause inverted emulsions.

Concentration, %	4%	5%	6%	7%	8%	9%	10%
Ratio	1:25	1:20	1:17	1:14	1:12	1:11	1:10
Refractometer	4.0	5.0	6.0	7.0	8.0	9.0	10.0

Typical Properties

Appearance-Concentrate	Dark Amber liquid
Appearance- Dilution	Opaque White
Residual Film	Soft, fluid
pH @ 20:1	9.0 ± 0.2
Specific Gravity @ 60°F	0.90 ± 0.03
Lbs/Gallon	7.5 ± 0.1
Flash point, COC °F	355

ASTRO-SOL N is available in 5 gallon pails, 55 gallon drums and 275 gallon IBCs. Material Safety Data Sheets are available for all products. All reasonable care has been taken to ensure that the above information is accurate as of the date of printing.

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