

ASTRO-CUT SOL N

WATER SOLUBLE CUTTING AND GRINDING FLUID

ASTRO-CUT 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.

ADVANTAGES

- Operator Friendly
- Low Foaming
- Mild, Pleasant Odor
- Excellent Corrosion Inhibition
- Sulfur and Phosphorus Free
- Excellent Hard Water Stability
- Clean Running
- Provides Excellent Finish

APPLICATIONS

Designed for use in metalworking applications such as all CNC milling, turning, drilling, tapping, and grinding. **ASTRO-CUT SOL N** is also suitable for light-duty stamping operations. Suggested mixture: 1:3 to 1:10 based upon results obtained from the mixture.

RECOMMENDED STARTING DILUTIONS

Centerless, ID, OD, Surface Grinding	25:1 (4%)
Milling, Drilling, Turning	20:1 (5%)
Tapping, Reaming, Sawing	10:1 (10%)

ASTRO-CUT SOL N

TYPICAL PROPERTIES

Appearance - concentrate	Brown Clear Liquid
Appearance - dilution	Opaque White
Odor	Bland
Residual Film	Soft, Fluid
pH @ 20:1 (5 %)	8.9 ± 0.3
Specific Gravity @ 60° F.	0.915 ± 0.01
API Gravity	23.1
Lbs./Gallon	7.63 ± 0.1
Flash Point, COC	355° F./ 179°C.

CONCENTRATION

ASTRO-CUT SOL N

CONCENTRATION	4% (1:25)	5% (1:20)	6% (1:17)	7% (1:14)	8% (1:12)	9% (1:11)	10% (1:10)
REFRACTOMETER READING	4.8	6.0	7.2	8.4	9.6	10.8	12.0

An optical refractometer may be used for determining concentration.

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.

04/06



36 Draffin Road, Hilton, NY 14468 Phone: 800-828-6351 585-392-3434 Fax: 585-392-2691

EMERGENCY NUMBERS: CHEMTREC (800) 424-9300 Monroe Fluid Technology (800) 828-6351