



Formulations For Today's
Technical Manufacturing Needs

An ISO 9001:2000 Certified Company

ASTRO-CUT SYN AF

General Description

ASTRO-CUT SYN AF is a heavy-duty amine-free synthetic cutting and grinding fluid concentrate designed to offer outstanding lubricity as well as excellent corrosion control on machinery and workpieces while providing a long sump life. **ASTRO-CUT SYN AF** has been formulated to minimize cobalt leaching when used for grinding carbide tooling. This product may be used on a variety of metals, including steels, cast iron and aluminum; in operations ranging from grinding to turning to milling.

Application

ASTRO-CUT SYN AF has been designed to provide cooling, lubrication and corrosion protection on operations that require an amine-free product or because of waste stream restrictions on amines. Operations involving the grinding of coated parts or other areas where amines may be detrimental are particularly suited for this product. **ASTRO-CUT SYN AF** has been designed for machining most metals except magnesium. This product may also be used for grinding: blanchard, diamond wheel, centerless, belt, disk, etc. NOTE: Since this product is completely oil-free, it may be used in most coolant mist units for machining and grinding operations.

Advantages

• Superior Lubrication	• Nitrite-Free
• Amine-Free	• Phenol-Free
• Resistant to Damage from Tramp Oil	• Excellent Cooling Ability
• Non-Foaming	• Resistant to Damage from Tramp Oil
• Stable pH	• Long Tank Life

Recommended Concentrations

Application	Concentration, %	Ratio	Refractometer
Milling, Drilling, Turning	5% - 10%	1:10 - 1:20	1.4 – 2.8
Centerless, ID, OD, Surface Grinding	4%	1:25	1.1

Mixing Instructions

When mixing coolant, it is best to use an automatic proportioner which accurately and thoroughly mixes coolant. To maintain proper concentration, make-up should be added at one-half of the desired concentration.

Concentration, %	4%	5%	6%	7%	8%	9%	10%
Ratio	1:25	1:20	1:17	1:14	1:12	1:11	1:10
Refractometer	1.1	1.4	1.7	2.0	2.2	2.5	2.8

Typical Properties

Appearance-Concentrate	Clear Blue liquid
Appearance- Dilution	Transparent Blue
Residual Film	Soft, soluble
pH @ 20:1	10.0 ± 0.2
Specific Gravity @ 60°F	1.08 ± 0.03
Lbs/Gallon	9.0 ± 0.1
Flash point, PMCC	None

ASTRO-CUT SYN AF is available in 5 gallon pails, 55 gallon drums and 275 gallon IBCs.

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