



Formulations For Today's
Technical Manufacturing Needs

An ISO 9001:2000 Certified Company

ASTRO-CUT SYN

General Description

ASTRO-CUT SYN is a heavy-duty oil-free synthetic cutting and grinding fluid concentrate designed to offer outstanding machining performance as well as excellent corrosion control on machinery and workpieces while providing a long sump life. 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 has been designed for machining most metals except magnesium. Excellent on cast iron. This product may also be used for grinding: blanchard, diamond wheel, 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 Machining Lubrication	• Nitrite-Free
• Chlorine-Free	• Phenol-Free
• Very Low Foam – Excellent on High Pressure or High Speed Machining	• Excellent Cooling for Ability to Maintain Close Tolerances
• Tolerant of Hard Water	• Resistant to Damage from Tramp Oil
• Water Extendable- Economical	• Long Tank Life

Recommended Concentrations

Application	Concentration, %	Ratio	Refractometer
Milling, Drilling, Turning	5% - 10%	1:10 - 1:20	1.6 – 3.2
Centerless, ID, OD, Surface Grinding	4%	1:25	1.3
Tapping, Sawing, Reaming	10%	1:10	3.2

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	1.3	1.6	1.9	2.2	2.6	2.9	3.2

Typical Properties

Appearance-Concentrate	Blue liquid
Appearance- Dilution	Transparent Blue
Residual Film	Soft, fluid
pH @ 20:1	9.5 ± 0.2
Specific Gravity @ 60°F	1.04 ± 0.03
Lbs/Gallon	8.7 ± 0.1
Flash point, PMCC	None

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

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