



Formulations For Today's
Technical Manufacturing Needs

An ISO 9001:2000 Certified Company

ASTRO-CUT SUPER SYN

General Description

ASTRO-CUT SUPER SYN is a heavy-duty oil-free synthetic cutting and grinding fluid concentrate designed to offer outstanding machining performance in even the most demanding applications, including **aluminum** and **tough aerospace materials**. This clean-running, low-foam product is stable in both soft and extremely hard water and contains additives which provide excellent rejection of tramp oils. In addition, **ASTRO-CUT SUPER SYN** provides rapid fine settling capabilities. This product contains no secondary amines.

Application

ASTRO-CUT SUPER SYN has been designed for machining and grinding most metals, including stainless steels, tool steels and alloys. **ASTRO-CUT SUPER SYN** is formulated to prevent staining or corrosion on copper, brass, bronze or aluminum. Excellent on cast iron. **ASTRO-CUT SUPER SYN should not** be used for machining Magnesium. This product may be used in most coolant mist units.

Advantages

- Superior Machining Lubrication
- Chlorine-Free
- Very Low Foam – Excellent on High Pressure or High Speed Machining
- Tolerant of Hard Water
- Water Extendable- Economical
- Nitrite-Free
- Phenol-Free
- Excellent Cooling for Ability to Maintain Close Tolerances
- Resistant to Damage from Tramp Oil
- Long Tank Life

Recommended Concentrations

Application	Concentration, %	Ratio	Refractometer
Milling, Drilling, Turning	5% - 10%	1:10 - 1:20	2.0 – 4.0
Centerless, ID, OD, Surface Grinding	4%	1:25	1.6
Misting Applications	2.5% - 4%	1:25 – 1:40	1.0 – 1.6

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	1.6	2.0	2.4	2.8	3.2	3.6	4.0

Typical Properties

Appearance-Concentrate	Blue liquid
Appearance- Dilution	Transparent Blue
Residual Film	Soft, soluble
pH @ 20:1	9.3 ± 0.2
Specific Gravity @ 60°F	1.03 ± 0.03
Flash point, PMCC	None

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

36 Draffin Road, Hilton, NY 14468 Phone: 800-828-6351 585-392-3434 Fax: 585-392-2691
sales@monroefluid.com Website: <http://www.monroefluid.com>