



Formulations For Today's
Technical Manufacturing Needs

An ISO 9001:2000 Certified Company

ASTRO-CUT B

General Description

ASTRO-CUT B is a semi-synthetic BIOSTABLE general purpose metalworking coolant containing approximately 20% mineral oil. This product, when diluted with water, forms a translucent amber emulsion which offers excellent workpiece visibility, good lubricity, and superior cooling. **ASTRO-CUT B** is designed for the machining and grinding of virtually all metals, except magnesium and is formulated without the use of chlorine.

Application

ASTRO-CUT B is designed for use in all metalworking applications such as CNC milling, turning, drilling, tapping and grinding. **ASTRO-CUT B** is also excellent on cast iron and sawing applications.

Recommended Concentrations

Application	Concentration, %	Ratio	Refractometer
General Machining	7%	1:14	3.5
Grinding	4%	1:25	2.0
Tapping, Drilling, Reaming	10%	1:10	5.0

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	2.0	2.5	3.0	3.5	4.0	4.5	5.0

Typical Properties

Appearance-Concentrate	Amber liquid
Appearance- Dilution	Translucent amber
Residual Film	Soft, fluid
pH @ 20:1	9.1 ± 0.2
Specific Gravity @ 60°F	1.0 ± 0.03
Lbs/Gallon	8.33 ± 0.1
Total Sulphur, wt %	None
Total Chlorine, wt %	None
Flash point, PMCC	None

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

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