



Formulations For Today's  
Technical Manufacturing Needs

An ISO 9001:2000 Certified Company

## ASTRO-CUT BCL

### General Description

**ASTRO-CUT BCL** is a heavy duty BIOSTABLE semi-synthetic 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 BCL is designed for the machining and grinding of virtually all metals, except magnesium, and contains chlorine as an extreme pressure additive for greater lubricity.

### Application

**ASTRO-CUT BCL** is designed for use in metal removal operations such as all CNC milling, turning, drilling, tapping, and grinding. ASTRO-CUT BCL is also excellent on conventional machining processes and sawing applications.

### Recommended Concentrations

Application	Concentration, %	Ratio	Refractometer
Milling, Drilling, Turning	5%	1:20	2.6
Centerless, ID, OD, Surface Grinding	4%	1:25	2.1
Tapping, Sawing, Reaming	10%	1:10	5.2

### 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	2.1	2.6	3.1	3.6	4.2	4.7	5.2

### 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	8.34 ± 0.1
Total Chlorine, wt %	1.0
Flash point, PMCC	None

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

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