



Formulations For Today's  
Technical Manufacturing Needs

An ISO 9001:2000 Certified Company

## ASTRO-GRIND A

### General Description

**ASTRO-GRIND A** is an oil free, nitrite free, water extendable grinding fluid concentrate containing wetting agents for superior cooling and corrosion inhibitors for in-process rust protection of machine tools and metal parts. This product offers excellent performance in most grinding operations on cast iron, steels, and most non-ferrous metals except magnesium.

### Application

**ASTRO-GRIND A** can be used for most grinding applications, including centerless, ID, OD, and Blanchard grinding. It can also be used for light machining operations and makes an excellent misting fluid for various machining and grinding processes.

### Advantages

- Excellent Cooling Function
- Excellent Corrosion Inhibition
- Allows Swarf to Settle Out
- Oil Free - Minimal Disposal Costs
- Mild Pleasant Odor
- Long Sump Life
- Economical
- Non-Foaming

### Recommended Concentrations

| Application                          | Concentration, % | Ratio       | Refractometer |
|--------------------------------------|------------------|-------------|---------------|
| Centerless, ID, OD, Surface Grinding | 4%               | 1:25        | 0.7           |
| Light Machining                      | 5%               | 1:20        | 0.9           |
| Misting                              | 3% - 4%          | 1:20 – 1:33 | 0.5 – 0.7     |

### 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.

|                  |      |      |      |      |      |      |      |
|------------------|------|------|------|------|------|------|------|
| Concentration, % | 4%   | 5%   | 6%   | 7%   | 8%   | 9%   | 10%  |
| Ratio            | 1:25 | 1:20 | 1:17 | 1:14 | 1:12 | 1:11 | 1:10 |
| Refractometer    | 0.7  | 0.9  | 1.1  | 1.3  | 1.4  | 1.6  | 1.8  |

### Typical Properties

|                         |                          |
|-------------------------|--------------------------|
| Appearance-Concentrate  | Clear light amber liquid |
| Appearance- Dilution    | Transparent light amber  |
| Residual Film           | Soft, soluble            |
| pH @ 20:1               | 9.6 ± 0.2                |
| Specific Gravity @ 60°F | 1.02 ± 0.03              |
| Lbs/Gallon              | 8.5 ± 0.1                |
| Flash point, PMCC °F    | None                     |

ASTRO-GRIND A 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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