



Formulations For Today's
Technical Manufacturing Needs

An ISO 9001:2000 Certified Company

ASTRO-CUT HIGH PRESSURE

General Description

ASTRO-CUT HIGH PRESSURE is a BIOSTABLE semi-synthetic high pressure metalworking coolant containing approximately 15% mineral oil. **ASTRO-CUT HIGH PRESSURE** has exceptional foam control, hard water stability and tramp oil rejection while providing outstanding lubricity for machining and grinding. It is compatible with virtually all metals except Magnesium and is formulated without the use of Chlorine.

Application

ASTRO-CUT HIGH PRESSURE is designed for use in high and low pressure metal removal operations such as all CNC milling, turning, drilling, tapping, grinding and sawing.

Recommended Concentrations

Application	Concentration, %	Ratio	Refractometer
Milling, Drilling, Turning	5%	1:20	2.5
Centerless, ID, OD, Surface Grinding	4%	1:25	2.0
Tapping, Sawing, 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	9.2 ± 0.2
Specific Gravity @ 60°F	1.02 ± 0.03
Lbs/Gallon	8.51 ± 0.1
Total Sulphur, wt %	None
Total Chlorine, wt %	None
Flash point, PMCC	None

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

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