



Formulations For Today's
Technical Manufacturing Needs

An ISO 9001:2000 Certified Company

ASTRO-CUT HIGH PRESSURE HD

General Description

ASTRO-CUT HIGH PRESSURE HD is a heavy duty BIOSTABLE semi-synthetic high pressure metalworking coolant. **ASTRO-CUT HIGH PRESSURE HD** combines the superior chemical flexibility of synthetics with mineral oil and a chlorinated extreme-pressure additive. **ASTRO-CUT HIGH PRESSURE HD** has exceptional foam control, hard water stability and tramp oil rejection. It provides outstanding extreme-pressure lubricity for machining and grinding virtually all metals, particularly Aluminum, Stainless Steels and other hard to machine alloys. **ASTRO-CUT HIGH PRESSURE HD** is not recommended for use on Magnesium.

Application

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

Recommended Concentrations

Application	Concentration, %	Ratio	Refractometer
Milling, Drilling, Turning	5%	1:20	4.0
Centerless, ID, OD, Surface Grinding	4%	1:25	3.2
Tapping, Sawing, Reaming	10%	1:10	8.0

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	3.2	4.0	4.8	5.6	6.4	7.2	8.0

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	1.03 ± 0.03
Lbs/Gallon	8.55 ± 0.1
Total Chlorine, wt %	3 – 5% max
Flash point, PMCC	None

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

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