

AstroSol CF

General Description

AstroSol CF is a heavy-duty soluble oil concentrate free of chlorine, but containing vegetable based lubricity additives for difficult machining operations. This product was designed to be extended with water for the machining and grinding of virtually all metals. **AstroSol CF** uses a unique emulsifier technology that gives excellent corrosion and stain protection of all metals and is resistant to water hardness up to 1000 ppm.

Application

AstroSol CF is designed for use in metalworking applications such as CNC milling, turning, drilling, tapping and grinding. It is also excellent on conventional machining and sawing applications.

Recommended Concentrations

Application	Concentration %	Ratio	Refractometer
General Machining	7%	1:14	8.4
Grinding	4%	1:25	4.8
Tapping, Drilling, Reaming	8%	1:12	9.6

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. Premixed coolant should always be used to maintain coolant levels in machines for best concentration control.

Concentration %	4%	5%	6%	7%	8%	9%	10%
Ratio	1:25	1:20	1:17	1:14	1:12	1:11	1:10
Refractometer	4.8	6.0	7.2	8.4	9.6	10.8	12.0

Product Characteristics

Appearance - Concentrate	Amber Liquid
Appearance - Dilution	Opaque Amber - White
Residual Film	Soft, Fluid
pH @ 20:1 (5%)	9.5 ± 0.3
Specific Gravity @ 60 F.	0.93 ± 0.01
Lbs/ Gallon	7.76 ± 0.1
Total Sulphur, wt%	None
Total Chlorine, wt%	None
Flash Point - PMCC	>350° F