

AstroSol EP

General Description

AstroSol EP is a heavy-duty soluble oil concentrate containing a chlorinated additive for difficult machining operations. This product was designed to be extended with water for the machining and grinding of virtually all metals, and is particularly effective on aluminum alloys. This product uses a unique emulsification technology that provides excellent stain and corrosion protection of all metals as well as tolerance of water hardness up to 1000 ppm.

Application

AstroSol EP is designed for use in metalworking applications such as CNC milling, drilling, turning, tapping and grinding. **AstroSol EP** is also excellent on conventional machining processes 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.	0.94 ± 0.01
Lbs/ Gallon	7.87 ± 0.1
Total Sulphur, wt%	None
Total Chlorine, wt%	3.6
Flash Point - PMCC	> 350° F