



Formulations For Today's
Technical Manufacturing Needs

An ISO 9001:2000 Certified Company

ASTROSOL C HD

General Description

ASTROSOL C HD is an extreme duty soluble oil concentrate designed for the most demanding machining operations where controlled foam and cleanliness are required. The unique combination of chlorinated extreme pressure additive, modern boundary lubricants and a controlled-foam emulsifier package brings outstanding performance to the most severe applications. **ASTROSOL C HD** is formulated with a high level of stabilized chlorinated EP additive using a synthetic emulsification platform that is very stable and exceptionally low foaming.

Application

ASTROSOL C HD is designed for use in heavy duty metal removal, deep hole drilling, tapping and threading, as well as all conventional machining processes and sawing.

Advantages

- Controlled Foam
- Excellent Corrosion Inhibition
- Excellent Hard Water Stability
- Mild Pleasant Odor
- Long Lasting
- Operator Friendly

Recommended Concentrations

Application	Concentration, %	Ratio	Refractometer
General Machining	5% - 10%	1:20 – 1:10	5.8 – 11.6
Grinding	4%	1:25	4.6
Tapping, Drilling, Sawing	10%	1:10	11.6

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. 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	4.6	5.8	7.0	8.1	9.3	10.4	11.6

Typical Properties

Appearance-Concentrate	Amber, slight hazy liquid
Appearance- Dilution	Opaque white
Residual Film	Soft, fluid
pH @ 20:1	10.0 ± 0.2
Specific Gravity @ 60°F	1.0 ± 0.03
Lbs/Gallon	8.34 ± 0.1
Total Chlorine, wt %	14 - 16
Flash point, PMCC °F	355

ASTROSOL C HD 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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