

Astro -Cut PF Bio

General Description

Astro-Cut PF Bio is a medium-to-heavy duty soluble oil concentrate containing no mineral oil. This renewable-resource based product may be extended with water for the machining and grinding of virtually all metals except magnesium. **Astro-Cut PF Bio** is formulated without the use of chlorine.

Application

Astro-Cut PF Bio is designed for CNC machining, as well as conventional metal removal operations involving turning, milling, drilling, tapping and grinding.

Recommended Concentrations

Application	Concentration %	Ratio	Refractometer
General Machining	7%	1:14	3.5
Grinding	4%	1:25	2.0
Tapping, Drilling, Reaming	8%	1:12	4.0

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. 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	2.0	2.5	3.0	3.5	4.0	4.5	5.0

Product Characteristics

Appearance -Concentrate	Amber Liquid
Appearance - Dilution	Translucent Amber
Residual Film	Soft, Fluid
pH @ 20:1 (5%)	9.1 ± 0.3
Specific Gravity @ 60 F.	1.03 ± 0.01
Lbs/ Gallon	8.59 ± 0.1
Total Sulphur, wt%	None
Total Chlorine, wt%	None
Flash Point - COC	355°C