



Formulations For Today's
Technical Manufacturing Needs

An ISO 9001:2000 Certified Company

ASTRO-CUT HP AERO

General Description

ASTRO-CUT HP AERO is a heavy duty mineral oil based BIOSTABLE micro-emulsion concentrate designed for the machining and grinding of virtually all metals except magnesium. This chlorine-free formulation is especially suited for aerospace and other applications which restrict the use of chlorine. **ASTRO-CUT HP AERO** has exceptional foam control for high pressure operations and was designed using raw materials that have the ability to resist extreme biological degradation, thus providing very long sump life in a properly maintained machine tool.

Application

ASTRO-CUT HP AERO is designed for use in metalworking applications such as all CNC milling, turning, drilling, tapping, grinding and sawing applications.

Advantages

• Eliminates Need for Tankside Additives	• Clean Running
• Very Low Foaming	• Chlorine, Sulfur and Phosphorous Free
• Good Workpiece Visibility	• Reduced Overall Cost
• Superior Lubricity	• Excellent Corrosion Inhibition

Recommended Concentrations

Application	Concentration, %	Ratio	Refractometer
Milling, Drilling, Turning	5%	1:20	3.4
Centerless, ID, OD, Surface Grinding	4%	1:25	2.7
Tapping, Sawing, Reaming	10%	1:10	7.1

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 should be added at one-half of the desired concentration.

Concentration, %	4%	5%	6%	7%	8%	9%	10%
Ratio	1:25	1:20	1:17	1:14	1:12	1:11	1:10
Refractometer	2.7	3.4	4.1	4.8	5.4	6.1	7.1

Typical Properties

Appearance-Concentrate	Amber liquid
Appearance- Dilution	Translucent amber
Residual Film	Soft, fluid
pH @ 20:1	8.8 ± 0.2
Specific Gravity @ 60°F	1.03 ± 0.03
Lbs/Gallon	8.7 ± 0.1
Total Phosphorous, wt %	None
Total Chlorine, wt %	None
Flash point, PMCC	None

ASTRO-CUT HP AERO 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 the above information is accurate as of the date of printing.

36 Draffin Road, Hilton, NY 14468 Phone: 800-828-6351 585-392-3434 Fax: 585-392-2691
sales@monroefluid.com Website: http://www.monroefluid.com