



Formulations For Today's  
Technical Manufacturing Needs

An ISO 9001:2000 Certified Company

## ASTRO-CUT SS-250

### General Description

**ASTRO-CUT SS-250** is a semi-synthetic general purpose metalworking coolant containing approximately 10% mineral oil. This product, when diluted with water, forms a translucent Amber emulsion which offers excellent workpiece visibility, good lubricity, and superior cooling. **ASTRO-CUT SS-250** is designed for the machining and grinding of virtually all metals, except magnesium and is formulated without the use of Chlorine.

### Application

Designed for use in metalworking applications such as all CNC milling, turning, drilling, tapping, and grinding, **ASTRO-CUT SS-250** is also excellent on conventional machining processes and sawing applications.

### Advantages

- Good Workpiece Visibility
- Excellent Corrosion Inhibition
- Excellent Hard Water Stability
- Mild Pleasant Odor
- Long Lasting
- Operator Friendly

### Recommended Concentrations

Application	Concentration, %	Ratio	Refractometer
General Machining	7%	1:14	2.1
Grinding	4%	1:25	1.2
Tapping, Drilling, Reaming	10%	1:10	3.0

### 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. 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	1.2	1.5	1.8	2.1	2.4	2.7	3.0

### Typical Properties

Appearance-Concentrate	Amber liquid
Appearance- Dilution	Translucent Amber
Residual Film	Soft, fluid
pH @ 20:1	9.0 ± 0.2
Lbs/Gallon	8.34 ± 0.1
Total Chlorine, wt %	None
Flash point, PMCC	None

**ASTRO-CUT SS-250** is available in 5 gallon pails, 55 gallon drums and 275 gallon IBCs.

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