

Astro-Cut B-CF

General Description

Astro-Cut B-CF is a biostable semi-synthetic coolant concentrate containing approximately 15% mineral oil utilizing a unique emulsification technology that provides excellent stain and corrosion protection of all metals, as well as superior hard water tolerance. This product is formulated without the use of chlorine.

Application

Astro-Cut B-CF is designed for use in metalworking applications such as all CNC milling, turning, drilling, tapping and grinding. **Astro-Cut B-CF** is also excellent on conventional machining processes and sawing applications.

Recommended Concentrations

| Application | Concentration % | Ratio | Refractometer |
|----------------------------|-----------------|-------|---------------|
| General Machining | 7% | 1:14 | 3.8 |
| Grinding | 4% | 1:25 | 2.2 |
| Tapping, Drilling, Reaming | 8% | 1:12 | 4.3 |

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 | 2.2 | 2.7 | 3.2 | 3.8 | 4.3 | 4.8 | 5.4 |

Product Characteristics

| | |
|--------------------------|-------------------|
| Appearance - Concentrate | Amber Liquid |
| Appearance - Dilution | Translucent Amber |
| Residual Film | Soft, Fluid |
| pH @ 20:1 (5%) | 8.9 ± 0.2 |
| Specific Gravity @ 60 F. | 1.02 ± 0.03 |
| Lbs/ Gallon | 8.55 ± 0.1 |
| Total Sulphur, wt% | None |
| Total Chlorine, wt% | None |
| Flash Point - PMCC | None |