36 Draffin Road Hilton, New York 14468
Phone: 585-392-3434
Toll Free: 1-800-828-6351
Sales: sales@monroefluid.com
Technical: technical@monroefluid.com

ASTRO-CUT 2084 CLF PLUS

Overview

ASTRO-CUT 2084 CLF PLUS is a heavy duty BIOSTABLE semi-synthetic high pressure metalworking coolant. ASTRO-CUT 2084 CLF PLUS combines the superior chemical flexibility of synthetics with mineral oil plus phosphorus and active sulfur extreme-pressure additives. ASTRO-CUT 2084 CLF PLUS has exceptional foam control, hard water stability and tramp oil rejection. It provides outstanding extreme-pressure lubricity for machining and grinding virtually all ferrous metals, particularly Stainless Steels and other hard to machine alloys. ASTRO-CUT 2084 CLF PLUS is not recommended for use on Magnesium or copper alloys which might stain.

Applications

ASTRO-CUT 2084 CLF PLUS is designed for use in high and low pressure metal removal operations such as all CNC milling, turning, drilling, tapping, grinding and sawing.

Recommended Concentration

Application	Concentration, %	Ratio	Refractometer
Milling, Drilling, Turning	5%	1:20	4.2
Centerless, ID, OD, Surface Grinding	4%	1:25	3.4
Tapping, Sawing, Reaming	10%	1:10	8.4

Mixing

Concentration, %	4%	5%	6%	7%	8%	9%	10%
Ratio	1:25	1:20	1:17	1:14	1:12	1:11	1:10
Refractometer	3.4	4.2	5.0	5.9	6.7	7.6	8.4

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.

Typical Properties

Appearance-Concentrate	Amber liquid
Appearance- Dilution	Translucent amber
Residual Film	Soft, fluid
pH @ 20:1	8.9 ± 0.2
Specific Gravity @ 60°F	1.02 ± 0.03
Lbs/Gallon	8.48 ± 0.1
Total Sulfur, wt %	3 – 5% max
Flash point, PMCC	None