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ASTRO-CUT MICRO A HP

Overview

ASTRO-CUT MICRO A HP is a heavy duty mineral oil based BIOSTABLE micro-emulsion concentrate designed for the machining and grinding of virtually all metals except magnesium. ASTRO-CUT MICRO A HP has exceptional foam control for high pressure operations and is formulated without the use of chlorine. This product offers a long sump life and a high degree of emulsion stability, even in hard water. ASTRO-CUT MICRO A HP is not recommended for use on Magnesium.

Applications

ASTRO-CUT MICRO A HP 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 | 4.1 |
| Centerless, ID, OD, Surface Grinding | 4% | 1:25 | 3.3 |
| Tapping, Sawing, Reaming | 10% | 1:10 | 8.2 |

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 | 3.3 | 4.1 | 4.9 | 5.7 | 6.6 | 7.4 | 8.2 |

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 | 9.1 ± 0.2 |
| Specific Gravity @ 60°F | 1.00 ± 0.03 |
| Lbs/Gallon | 8.34 ± 0.1 |
| Total Chlorine, wt % | None |
| Flash point, PMCC | None |

Material Safety Data Sheets are available for all products.
All reasonable care has been taken to ensure
that the above information is accurate as of the date of printing.