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ASTRO-CUT SC 1000

Overview

ASTRO-CUT SC-1000 is a heavy duty soluble oil concentrate containing a chlorinated additive for difficult machining operations. This product was designed to be extended with water for the machining and grinding of virtually all metals except magnesium. ASTRO-CUT SC-1000 is excellent on high silicon aluminum alloys.

Applications

Designed for use in metalworking applications such as all CNC milling, turning, drilling, tapping, and grinding. ASTRO-CUT SC-1000 is also excellent on conventional machining processes and sawing applications.

Features Benefits

- Low Foaming
- Mild Pleasant Odor
- Excellent Corrosion Inhibition
- Long Lasting
- Excellent Hard Water Stability
- Operator Friendly

Recommended Concentration

Application	Concentration, %	Ratio	Refractometer
General Machining	5% - 10%	1:20 – 1:10	5.0 – 10.0
Grinding	4%	1:25	4.0
Tapping, Drilling, Sawing	10%	1:10	10.0

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	4.0	5.0	6.0	7.0	8.0	9.0	10.0

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	Green liquid
Appearance- Dilution	Opaque Green
Residual Film	Soft, fluid
pH @ 20:1	9.0 ± 0.2
Specific Gravity @ 60°F	0.925± 0.03
Lbs/Gallon	7.7 ± 0.1
Total Chlorine, wt %	5.0
Flash point, COC °F	350

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.