



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 SYN G-XBP

### Overview

ASTRO-CUT SYN G-XBP is a heavy-duty oil-free synthetic cutting and grinding fluid concentrate designed to offer good lubricity as well as excellent corrosion control on machinery and workpieces while providing a long sump life. The incorporation of a unique package of synergistic components and enhanced additive technology enables ASTRO-CUT SYN G-XBP to provide extended biological stability and corrosion resistance in the working fluid. This product may be used on a variety of metals, including steels, cast iron and aluminum; in operations ranging from grinding to turning to milling.

### Applications

ASTRO-CUT SYN G-XBP has been designed for machining most metals except magnesium. Excellent on cast iron. This product may also be used for grinding: Blanchard, diamond wheel, belt, disk, etc. NOTE: Since this product is completely oil-free, it may be used in most coolant mist units for machining and grinding operations.

### Features Benefits

- Excellent Corrosion Inhibition
- Nitrite-Free
- Chlorine-Free
- Phenol-Free
- Very Low Foam – Excellent on High Pressure or High Speed Machining
- Excellent Cooling for Ability to Maintain Close Tolerances
- Tolerant of Hard Water
- Resistant to Damage from Tramp Oil
- Water Extendable- Economical
- Long Tank Life

### Recommended Concentration

Application	Concentration, %	Ratio	Refractometer
Milling, Drilling, Turning	5% - 10%	1:10 - 1:20	1.6 – 3.2
Centerless, ID, OD, Surface Grinding	4%	1:25	1.3
Tapping, Sawing, Reaming	10%	1:10	3.2

### 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	1.3	1.6	1.9	2.2	2.6	2.9	3.2

When mixing coolant, it is best to use an automatic proportioner which accurately and thoroughly mixes coolant. To maintain proper concentration, make-up should be added at one-half of the desired concentration.

### Typical Properties

Appearance-Concentrate	Amber liquid
Appearance- Dilution	Transparent Amber
Residual Film	Soft, soluble
pH @ 20:1	9.7 ± 0.2
Specific Gravity @ 60°F	1.03 ± 0.03
Lbs/Gallon	8.6 ± 0.1
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.