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 GL

Overview

ASTRO-CUT SYN GL 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. 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 GL 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

Recommended Concentration

Application	Concentration, %	Ratio	Refractometer
Milling, Drilling, Turning	5% - 10%	1:10 - 1:20	1.7 – 3.4
Centerless, ID, OD, Surface Grinding	4%	1:25	1.4
Tapping, Sawing, Reaming	10%	1:10	3.4

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	1.4	1.7	2.0	2.4	2.7	3.1	3.4

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	Colorless liquid
Appearance- Dilution	Transparent Colorless
Residual Film	Soft, soluble
pH @ 20:1	9.5 ± 0.2
Specific Gravity @ 60°F	1.04± 0.03
Lbs/Gallon	8.68 ± 0.1
Flash point, PMCC	None