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## ASTRO-DRAW SYN FP

### Overview

ASTRO-DRAW SYN FP is a heavy-duty synthetic, oil-free drawing, forming and stamping fluid, incorporating a blend of boundary and EP lubrication additives, in a water extendable package. ASTRO-DRAW SYN FP is a versatile drawing and stamping fluid that can be used neat or diluted with water. The film remaining after forming operations is easily removed with water or an alkaline cleaner. The product may be used on ferrous or non-ferrous metals.

### Applications

ASTRO-DRAW SYN FP may be used for drawing and stamping operations where clean, oil-free parts are required for subsequent operations. ASTRO-DRAW SYN FP may be applied by brushing, dipping, spraying, rolling or other convenient method.

### Features Benefits

- Easily Removed With Water
- Mild Pleasant Odor
- Excellent Corrosion Inhibition
- Long Lasting
- Stable in Hard or Soft Water
- Operator Friendly
- For Ferrous and Non-Ferrous Metals
- Superior Lubricity

### Recommended Concentration

Application	Concentration, %	Ratio	Refractometer
Severe Drawing and Forming	10% - 20%	1:10 to 1:5	6.0 – 12.0
Normal Applications	5% - 10%	1:20 to 1:10	3.0 – 6.0
Light Applications, Roll Forming Copper and Brass	4% - 5%	1:25 to 1:20	2.4 – 3.0

### Mixing

Concentration, %	4%	5%	7%	10%	20%
Ratio	1:25	1:20	1:14	1:10	1:5
Refractometer	2.4	3.0	4.2	6.0	12.0

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

### Typical Properties

Appearance-Concentrate	Amber clear liquid
Appearance- Dilution	Translucent/Opaque
pH @ 10:1	8.7 ± 0.2
Specific Gravity @ 60°F	1.03± 0.03
Lbs/Gallon	8.59 ± 0.1
Viscosity@40°	130 cSt

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.