



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-SOL CF

Overview

ASTROSOL CF is a heavy duty soluble oil concentrate free of chlorine but containing vegetable-based lubricity additives for difficult machining operations. ASTROSOL CF is designed to be extended with water for the machining and grinding of virtually all metals. ASTROSOL CF is particularly effective on aluminum alloys. This product uses a unique emulsifier technology which gives excellent corrosion and stain protection and is resistant to water hardness up to 1000 ppm.

Applications

ASTROSOL CF is designed for use in heavy duty metal removal, deep hole drilling, tapping and threading, as well as all conventional machining processes and sawing. Advantages

Features Benefits

- Controlled Foam
- 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	6.0 – 12.0
Grinding	4%	1:25	4.8
Tapping, Drilling, Sawing	10%	1:10	12.0

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	4.8	6.0	7.0	8.4	9.6	10.8	12

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, slight hazy liquid
Appearance- Dilution	Opaque white
Residual Film	Soft, fluid
pH @ 20:1	9.5 ± 0.2
Specific Gravity @ 60°F	0.93 ± 0.03
Lbs/Gallon	7.76 ± 0.1
Total Chlorine, wt %	None
Flash point, PMCC °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.