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Astro-Cut HP XBP

Overview

Astro-Cut HP XBP is a BIOSTABLE semi-synthetic high pressure metalworking coolant containing approximately 15% mineral oil. Astro-Cut HP XBP has exceptional foam control, hard water stability and tramp oil rejection while providing outstanding lubricity for machining and grinding. It is compatible with virtually all metals except Magnesium and is formulated without the use of Chlorine.

Applications

Astro-Cut HP XBP is designed for use in high and low pressure metal removal operations such as all CNC milling, turning, drilling, tapping, grinding and sawing.

Recommended Concentration

Application	Concentration	Ratio	Refractometer
Miling, Driling, Turning	5%	1:20	2.5
Centerless, ID, OD, Surface Grinding	4%	1:25	2.0
Tapping, Sawing, Reaming	10%	1:10	5.0

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	2.0	2.5	3.0	3.5	4.0	4.5	5.0

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 - Conentrate	Amber liquid
Appearance - Dilution	Translucent Amber
Residual Film	Soft, fluid
pH @ 20:1	9.8 ± 0.2
Specific Gravity @ 60°F	1.01± 0.03
Lbs/Gallon	8.43 ± 0.1
Total Sulphur, wt %	None
Total Chlorine, wt %	None
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.