



## Astro-Cut BCL HW

### OVERVIEW

ASTRO-CUT BCL-HW is a heavy duty BIOSTABLE semi-synthetic general purpose metalworking coolant containing approximately 20% mineral oil. This product, when diluted with water, forms a translucent amber emulsion which offers excellent workpiece visibility, good lubricity, and superior cooling. ASTRO-CUT BCL-HW is designed for the machining and grinding of virtually all metals, except magnesium, and contains chlorine as an extreme pressure additive for greater lubricity. ASTRO-CUT BCL HW incorporates unique additives to prevent the formation of hard water soaps in systems with extremely hard water.

### APPLICATIONS

ASTRO-CUT BCL-HW is designed for use in metal removal operations such as all CNC milling, turning, drilling, tapping, and grinding. ASTRO-CUT BCL-HW is also excellent on conventional machining processes and sawing applications.

### RECOMMENDED CONCENTRATION

Application	Concentration	Ratio	Refractometer
Milling, Drilling, Turning	5%	1:20	2.6
Centerless, ID, OD, Surface Grinding	4%	1:25	2.1
Tapping, Sawing, Reaming	10%	1:10	5.2

### 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	2.1	2.6	3.1	3.6	4.2	4.7	5.2

### TYPICAL PROPERTIES

Appearance-Concentrate	Amber Liquid
Appearance- Dilution	Translucent amber
Residual Film	Soft, fluid
pH @ 20:1	9.1 ± 0.2
Specific Gravity @ 60°F	1.0 ± 0.03
Lbs/ gal	8.34 ± 0.1
Total Chlorine, wt %	1.0
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.