



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 A-XBP

OVERVIEW

ASTRO-SOL A-XBP is a medium-to-heavy duty biostatic soluble oil. This product was designed to be extended with water for the machining and grinding of virtually all metals except magnesium. This chlorine-free formulation is especially suited for aerospace and other applications which restrict the use of chlorine. ASTRO-SOL A-XBP has exceptional foam control for high pressure operations and was designed using raw materials that have the ability to resist extreme biological degradation, thus providing very long sump life in a properly maintained machine tool.

FEATURES & BENEFITS

- Eliminates Need for Tankside Additives
- Mild Pleasant Odor
- Excellent Corrosion Inhibition
- Very Long Lasting
- Excellent Hard Water Stability
- Operator Friendly

APPLICATIONS

ASTRO-SOL A-XBP is designed for use in metalworking applications such as all CNC milling, turning, drilling, tapping, grinding and sawing applications.

RECOMMENDED CONCENTRATION

| Application | Concentration, % | Ratio | Refractometer |
|----------------------------|------------------|-------|---------------|
| General Machining | 7% | 1:14 | 8.0 |
| Grinding | 4% | 1:25 | 4.6 |
| Tapping, Drilling, Reaming | 10% | 1:10 | 11.4 |

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 | 4.6 | 5.8 | 6.8 | 8.0 | 9.1 | 10.3 | 11.4 |

TYPICAL PROPERTIES

| | |
|--------------------------|--------------|
| Appearance-Concentrate | Amber liquid |
| Appearance- Dilution | Opaque Amber |
| Residual Film | Soft, fluid |
| pH @ 20:1 | 9.3 ± 0.2 |
| Specific Gravity @ 60 °F | 0.94 ± 0.03 |
| Lbs/Gallon | 7.85 ± 0.1 |
| Total Chlorine, wt % | None |
| Flash point, COC °F | 355 |

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.