



ASTRO-CUT SYN XL

OVERVIEW

ASTRO-CUT SYN XL is a heavy-duty oil-free synthetic cutting and grinding fluid concentrate designed for use on aluminum, aluminum casings and extruded aluminum. This product combines outstanding machining performance with excellent corrosion control on machinery and workpieces while providing a long sump life. This product may be used on a variety of operations ranging from grinding to turning to milling.

APPLICATIONS

ASTRO-CUT SYN XL has been designed specifically for machining aluminum alloys, but will perform well on most metals except magnesium. Excellent on cast iron. This product may also be used for grinding: Blanchard, diamond wheel, belt, disk, etc. NOTE: Since this product is completely oil-free, it may be used in most coolant mist units for machining and grinding operations.

FEATURES & BENEFITS

- Excellent Corrosion Inhibition
- Very Low Foaming
- Excellent Cooling and Lubricity
- Hard Water Tolerant
- Rejects Tramp Oil
- Extended Tank Life
- Free of Chlorine, Nitrites, and Phenol
- Superior Machining Lubrication
- No DCHA

MIXING INSTRUCTIONS

When Mixing coolant, it is best to use an automatic proportioner which accurately and thoroughly mixes coolant. To maintain proper concentration, make-up should be added at one-half of the desired concentration.							
Concentration	4%	5%	6%	7%	8%	9%	10%
Dilution Ratio	1:25	1:20	1:17	1:14	1:12	1:11	1:10
Refractometer Reading	1.3	1.7	2.0	2.4	2.7	3.0	3.3
ASTRO-CUT SYN XL is available in 5 gallon pails, 55 gallon drums and 275 gallon IBC's.							

RECOMMENDED CONCENTRATION

Application	Concentration	Ratio	Refractometer
Milling, Drilling, Turning	5% - 10%	1:20 – 1:10	2.6 - 5.1
Centerless, ID, OD, Surface Grinding	4%	1:25	2.0
Tapping, Sawing, Reaming	10%	1:10	5.1

TYPICAL PROPERTIES

Appearance – Concentrate	Amber Liquid
Appearance – Dilution	Transparent Amber
Residual Film	Soft, Fluid
pH @ 20:1	9.2 +/- 0.2
Specific Gravity	1.04 +/- 0.03
Lbs. / Gallon	8.7 +/- 0.1
Flash Point, PMCC	None