



Astro-Cut B

OVERVIEW

ASTRO-CUT B is a semi-synthetic BIOSTABLE 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 B is designed for the machining and grinding of virtually all metals, except magnesium and is formulated without the use of chlorine, phenols, nitrites or DCHA.

APPLICATIONS

ASTRO-CUT B is designed for use in all metalworking applications such as CNC milling, turning, drilling, tapping and grinding. ASTRO-CUT B is also excellent on cast iron and sawing applications.

RECOMMENDED CONCENTRATION

Application	Concentration	Ratio	Refractometer
Tapping, Sawing, Reaming	10%	1:10	5.0
General Machining	7%	1:14	3.5
Grinding	4%	1:25	2.0

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

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	8.33 ± 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.