Monroe Fluid Technology

Astro-Cut SYN D

OVERVIEW

ASTRO-CUT SYN D is a heavy-duty oil-free synthetic cutting and grinding fluid concentrate designed to offer outstanding machining performance as well as excellent corrosion control on machinery and workpieces while providing a long sump life. This product may be used on a variety of metals, including steels, cast iron and aluminum; in operations ranging from grinding to turning to milling.

FEATURES & BENEFITS

· Excellent Corrosion Inhibition
· Chlorine-Free
· Very Low Foam – Excellent on High Pressure or High Speed Machining
· Excellent Cooling for Ability to Maintain Close Tolerances
· Tolerant of Hard Water
· Resistant to Damage from Tramp Oil
· Water Extendable- Economical
· Long Tank Life
· Phenol-Free
· Nitrite-Free

APPLICATIONS

ASTRO-CUT SYN D has been designed for machining 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.

RECOMMENDED CONCENTRATION

Application	Concentration	Ratio	Refractometer
Miling, Driling, Turning	5% - 10%	1:10 - 1:20	2.5 – 4.9
Centerless, ID, OD, Surface Grinding	4%	1:25	2.0
Tapping, Sawing, Reaming	10%	1:10	4.9

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	2.9	3.4	3.9	4.4	4.9

TYPICAL PROPERTIES

Appearance-Concentrate	Blue liquid
Appearance - Dilution	Transparent Blue
Residual Film	Soft, soluble
pH @ 20:1	9.1 ± 0.2
Specific Gravity @ 60°F	1.07 ± 0.03
Lbs/Gallon	8.9 ± 0.1
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.