



## Astro-Cut HD HW

### OVERVIEW

ASTRO-CUT HD-HW is a heavy duty BIOSTABLE semi-synthetic high pressure metalworking coolant. ASTROCUT HD-HW combines the superior chemical flexibility of synthetics with mineral oil and a chlorinated extreme pressure additive. ASTRO-CUT HD-HW has exceptional foam control, hard water stability and tramp oil rejection. It provides outstanding extreme-pressure lubricity for machining and grinding virtually all metals, particularly Aluminum, Stainless Steels and other hard to machine alloys. ASTRO-CUT HD-HW is not recommended for use on Magnesium.

### APPLICATIONS

ASTRO-CUT HD-HW is designed for use in high and low pressure metal removal operations such as all CNC milling, turning, drilling, tapping, grinding and sawing.

### RECOMMENDED CONCENTRATION

Application	Concentration	Ratio	Refractometer
Milling, Drilling, Turning	5%	1:20	4.0
Centerless, ID, OD, Surface Grinding	4%	1:25	3.2
Tapping, Sawing, Reaming	10%	1:10	8.0

### 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	3.2	4.0	4.8	5.6	6.4	7.2	8.0

### TYPICAL PROPERTIES

Appearance-Concentrate	Amber liquid
Appearance- Dilution	Translucent amber
Residual Film	Soft, fluid
pH @ 20:1	8.9 ± 0.2
Specific Gravity @ 60°F	1.03 ± 0.03
Lbs/ gal	8.6 ± 0.1
Total Chlorine, wt %	3 – 5% max
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.