



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-CUT SYN EAF

### OVERVIEW

ASTRO-CUT SYN EAF is a heavy-duty oil-free synthetic cutting and grinding fluid concentrate manufactured without the use of ethanolamines and designed to offer good lubricity and excellent corrosion control on operations that require an amine-free product or because of waste stream restrictions on amines. 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
- Nitrite-Free
- Ethanolamine-Free
- Phenol-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

### APPLICATIONS

ASTRO-CUT SYN EAF has been designed for machining most metals except magnesium. Operations involving the grinding of coated parts or other areas where amines may be detrimental are particularly suited for this product. NOTE: Since this product is completely oil-free, it may be used in most coolant mist units.

### RECOMMENDED CONCENTRATION

Application	Concentration, %	Ratio	Refractometer
Milling, Drilling, Turning	5% - 10%	1:10 - 1:20	1.9 – 3.8
Centerless, ID, OD, Surface Grinding	4%	1:25	1.5
Tapping, Sawing, Reaming	10%	1:10	3.8

### 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	1.5	1.9	2.3	2.7	3.1	3.5	3.8

### 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	1.06 ± 0.03
Lbs/Gallon	8.8 ± 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.