



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 AF

### OVERVIEW

ASTRO-CUT SYN AF is a heavy-duty amine-free synthetic cutting and grinding fluid concentrate designed to offer outstanding lubricity as well as excellent corrosion control on machinery and workpieces while providing a long sump life. ASTRO-CUT SYN AF has been formulated to minimize cobalt leaching when used for grinding carbide tooling. 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

- Superior Lubrication
- Nitrite-Free
- Amine-Free
- Phenol-Free
- Resistant to Damage from Tramp Oil
- Excellent Cooling Ability
- Non-Foaming
- Resistant to Damage from Tramp Oil
- Stable pH
- Long Tank Life

### APPLICATIONS

ASTRO-CUT SYN AF has been designed to provide cooling, lubrication and corrosion protection on operations that require an amine-free product or because of waste stream restrictions on amines. Operations involving the grinding of coated parts or other areas where amines may be detrimental are particularly suited for this product. ASTRO-CUT SYN AF has been designed for machining most metals except magnesium. This product may also be used for grinding: blanchard, diamond wheel, centerless, 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	1.6 – 3.1
Centerless, ID, OD, Surface Grinding	4%	1:25	1.3

### 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	1.3	1.6	1.9	2.2	2.5	2.8	3.1

### TYPICAL PROPERTIES

Appearance-Concentrate	Clear Blue liquid
Appearance - Dilution	Transparent Blue
Residual Film	Soft, soluble
pH @ 20:1	10.0 ± 0.2
Specific Gravity @ 60 °F	1.08 ± 0.03
Lbs/Gallon	9.0 ± 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.