

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 HD XBP**

## OVERVIEW

ASTRO-CUT HD XBP is a heavy duty BIOSTABLE semi-synthetic high pressure metalworking coolant. ASTRO-CUT HD XBP combines the superior chemical flexibility of synthetics with mineral oil and a chlorinated extreme-pressure additive. ASTRO-CUT HD XBP 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 XBP is not recommended for use on Magnesium. ASTRO-CUT HD XBP is does not contain DCHA.

## **APPLICATIONS**

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

| RECOMMENDED CON                      | CENTRATION |                |                  |      |       |      |     |               |      |
|--------------------------------------|------------|----------------|------------------|------|-------|------|-----|---------------|------|
| Application                          |            | Concentration, | Concentration, % |      | Ratio |      |     | Refractometer |      |
| Milling, Drilling, Turning           |            | 5%             | 5%               |      | 1:20  |      | 4.2 |               |      |
| Centerless, ID, OD, Surface Grinding |            | 4%             |                  | 1:25 |       |      | 3.4 |               |      |
| Tapping, Sawing, Reami               | ing        | 10%            |                  |      | 1:10  |      |     | 8.4           |      |
| 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                        | 3.4        | 4.2            | 5.0              | 5.9  |       | 6.7  | 7   | .6            | 8.4  |

## TYPICAL PROPERTIES

| Appearance-Concentrate  |  | Amber liquid      |
|-------------------------|--|-------------------|
| Appearance- Dilution    |  | Translucent Amber |
| Residual Film           |  | Soft, fluid       |
| pH @ 20:1               |  | 9.3 ± 0.2         |
| Specific Gravity @ 60°F |  | 1.01± 0.03        |
| Lbs/Gallon              |  | 8.43 ± 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.