



Alusol A

High performance soluble metal working fluid

Description

Castrol Alusol™ A is a high performance semi-synthetic chlorine free metalworking fluid. It contains a unique additive package especially designed to machine various aluminium alloys that works in synergy to enhance machining performance and surface finish, provide excellent product stability, improve bio-resistance properties and lower the overall operations costs. Castrol Alusol A is suitable for large central systems and single sump machines.

Application

Castrol Alusol A is especially designed for machining of aluminium alloys. It can be used for severe machining applications including mapal reaming, deep hole drilling and tapping. The product can also be used for machining of low-medium alloyed steel.

	Cast Iron	Low-medium alloyed steel	High alloyed - stainless steel	Aluminium alloys	Magnesium alloys	Yellow metals
Grinding						
Milling, Turning (general machining)	•	• •	•	• • •		•
Drilling	•	• •		• • •		•
Reaming, Tapping	•	• •		• • •		•
Broaching				• •		•

Advantages

- Chlorine and nitrite free to fulfill your local legislation, waste treatment and environmental requirements
- Resists fungal and bacterial attack to extend fluid life and reduce maintenance and machine downtime
- Low foam in recommended water conditions • Lubrication package specifically designed to enhance tool life and improve surface finish in aluminium machining
- Excellent wetting properties reduce coolant drag out and deliver clean machine tools and components

Typical Characteristics

Name	Method	Units	Value
Concentrate			
Appearance	Visual		Amber
Mineral oil content	Calculated	Wt%	40
Emulsion			
Appearance	Visual		Translucent
pH (5%)	DIN 51369 ASTM E70-97		8.9
Refractometer Faktor			1.1

Recommended Concentrations

General Machining	4-6%
Drilling	5-8%
Reamling and tapping	7-10%
Broaching	8-10%
Water range	50-200 ppm CaCO ₃

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08 Dec 2010
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