

**Product Data**

## Castrol Alusol A

### 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

	Test Method	Unit	Value
<b>Concentrate</b>			
Appearance	Visual		Amber
Mineral oil content	Calculated	Wt%	37
<b>Emulsion</b>			
Appearance	Visual		Milky
pH (5%)	DIN 51369 ASTM E70-97		8.9
Refractometer Factor			0.9

	Boron	Formaldehyde releasing agent	EP-Ester	Amines	Chlorine
Additives	✓	✓	✓	✓	-

## Recommended Concentrations

General Machining	4-6%
Drilling	5-8%
Reaming and tapping	7-10%
Broaching	8-10%
Water range	5-10 ° dH

## Storage

To avoid product deterioration, keep the container/drum tightly sealed always. Prevent any frost and water ingress.

Store it in a cool and dry place away from direct sunlight. It is preferable to store the product indoors always. For more details, please refer the product safety data sheet.

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