



Alusol MF

High performance soluble metalworking fluid

Description

Castrol Alusol™ MF is a high performance soluble chlorine free metalworking fluid. It contains an additive package that works in synergy to help to enhance machining performance and surface finish, provide excellent product stability and lower the overall operations costs.

Alusol MF is suitable for large central systems and single sump machines.

Application

Alusol MF is especially designed for machining of aluminium alloys. The product can also be used for machining of low-medium alloyed steel.

ü ü suggested core application ü possible application, please consult Castrol representative prior to use

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

Advantages

- Organic chlorine and nitrite free to fulfill your local legislation, waste treatment and environmental requirements
- Helps to extend fluid life and reduce maintenance and machine downtime
- Low foam in recommended water conditions (see details below)
- Lubrication package specifically designed to enhance tool life and improve surface finish in aluminium machining
- Excellent wetting properties can help to reduce coolant drag out and deliver clean machine tools and components

Typical Characteristics

| | Test Method | Unit | Value |
|---------------------------|--------------------------|------|-------------------|
| <u>Concentrate</u> | | | |
| Appearance | Visual | | Amber |
| Mineral oil content | Calculated | Wt% | 37 |
| <u>Emulsion</u> | | | |
| Appearance | Visual | | Translucent-Milky |
| pH (5%) | DIN 51369 ASTM E70-97 | | 9.0 |
| Refractometer Factor | | | 1,0 |

Subject to usual manufacturing tolerances.

Recommended Concentrations

| | |
|---------------------|-------|
| Grinding | 5-7% |
| General Machining | 5-7% |
| Drilling | 7-9% |
| Reaming and tapping | 7-12% |
| Broaching | 8-12% |

Water range 100-600 ppm CaCO₃

Additional Information

| | Boron | Formaldehyde releasing agent | EP-Ester | Amines | Organic chlorine |
|-----------|-------|------------------------------|----------|--------|------------------|
| Additives | ü | ü | ü | ü | - |

Storage

To avoid product deterioration always keep the container/drum tightly sealed. Store the product in a cool, dry place away from direct sunlight. Prevent exposure to frost and avoid water ingress. For optimum product stability, it is preferable to store the product indoors between 5°C and 45 °C / 41°F and 113°F.

For more details, please refer the product safety data sheet.

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