



Castrol Alusol ABF 47

High performance soluble metalworking fluid

Description

Castrol Alusol™ ABF 47 is a high performance soluble metalworking fluid formulated without boron, alkanolamines and formaldehyde releasing agents. It contains an additive package that helps to enhance machining performance and surface finish, provide good product stability, helps to improve system life and can lower the overall operations costs.

Alusol ABF 47 is suitable for large central systems and single sump machines.

Application

Alusol ABF 47 is especially designed for machining of aluminium alloys. It can also be used for machining of lowmedium alloyed steel.

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		ü
Milling, Turning (general machining)		ü ü	ü	ü ü		ü
Drilling		ü ü	ü	ü ü		ü
Reaming, Tapping		ü	ü	ü ü		ü
Broaching		ü	ü	ü ü		ü

Advantages

- Formulated without formaldehyde releasing agent and boron which help you to fulfil aspects of legislative requirements and waste treatment requirements that specify that these chemicals are excluded
- Extended fluid life can help reduce maintenance and machine downtime
- Low foam in recommended water conditions (see details below)
- Lubrication package designed to try to help to enhance tool life and improve surface finish on aluminium machining
- Multi-functional product for multi-metal operations can results in product consolidation

Typical Characteristics

	Test Method	Unit	Value
Concentrate			
Appearance	Visual		Brown
Mineral oil content	Calculated	Wt%	45
Emulsion			
Appearance	Visual		Milky
pH (5%)	DIN 51369 ASTM E70-97		9.2
Refractometer Factor			1.0

Subject to usual manufacturing tolerances.

Recommended Concentrations

Grinding	6 - 7%
General Machining	7 - 8%
Drilling	7 - 8%
Reaming and Tapping	8 - 10%
Broaching	10 - 12%

Water range 200 – 700 ppm CaCO₃

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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