



# Castrol Alusol ABF 47

High performance soluble metalworking fluid

## Description

Castrol Alusol™ ABF 47 is a high performance soluble metalworking fluid which is boron, amine, chlorine and formaldehyde releasing agent free. 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 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

- Chlorine, formaldehyde releasing agent and nitrite free which may help you to fulfill aspects of legislative requirements and waste treatment requirements that specify that these chemicals are excluded
- Boron free to meet boron free waste requirements
- Chlorine and nitrite free to fulfill your local legislation, waste treatment and environmental requirements
- 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
<b>Concentrate</b>			
Appearance	Visual		Brown
Mineral oil content	Calculated	Wt%	49
<b>Emulsion</b>			
Appearance	Visual		Milky
pH (3%)	DIN 51369 ASTM E70-97		9.0
Refractometer Factor			1.0

Subject to usual manufacturing tolerances.

## Recommended Concentrations

Grinding	4-5 %
General Machining	5-7 %
Drilling	5-7%
Reaming and Tapping	6-9%
Broaching	8-10%

Water range                    150 – 700 ppm CaCO<sub>3</sub>

## Additional Information

	Boron	Formaldehyde releasing agent	EP-Ester	Amines	Chlorine
Additives			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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