

## Castrol Alusol ABF 10

High performance semi synthetic metalworking fluid

### Description

Castrol Alusol™ ABF 10 is a high performance semi synthetic metalworking fluid which is boron, amine, chlorine and formaldehyde releasing agent free. It contains a unique additive package 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.

Alusol ABF 10 is suitable for large central systems and single sump machines.

### Application

Alusol ABF 10 is especially designed for machining of aluminium alloys. It 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

- Formaldehyde releasing free to comply with health and safety regulations
- Boron free for environmental compliance and improved residue characteristics
- Chlorine and nitrite free to fulfill your local legislation, waste treatment and environmental requirements
- Resists fungal 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
- Unique multi-functional product for multi-metal operations results in product consolidation

## Typical Characteristics

	Test Method	Unit	Value
<b>Concentrate</b>			
Appearance	Visual		Amber
Mineral oil content	Calculated	Wt%	40
<b>Emulsion</b>			
Appearance	Visual		Milky
pH (5%)	DIN 51389 ASTM E70-97		8.9
Refractometer Factor			1.0

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

## Recommended Concentrations

Grinding	4-5%
General Machining	5-7%
Drilling	5-7%
Reaming and tapping	6-9%
Broaching	8-10%
Water range	100-400 ppm CaCO <sub>3</sub>

## 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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Castrol Limited, Pipers Way, Swindon, Wiltshire SN3 1RE, UK  
[www.castrol.com/industrial](http://www.castrol.com/industrial)  
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