



Product Data Sheet

Almaredge BI

General purpose soluble metalworking fluid

Description

Castrol Almaredge™ BI is a general purpose soluble metalworking fluid formulated without boron. It contains an additive package that helps to provide good lubrication properties and performs well in a wide water range.

Almaredge BI can be used in single sump machines as well large systems.

Application

Almaredge BI is a versatile product recommended for general machining on low-medium alloy steel and aluminium alloys.

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

Advantages

- Formulated without boron which helps you to fulfil aspects of legislative requirements and waste treatment requirements that specify that this chemical is excluded
- Versatile product suitable for wide range of materials and operations
- Low foam in recommended water conditions

Typical Characteristics

| Name | Method | Units | Almaredge BI |
|----------------------|--------------------------|-------|--------------|
| Concentrate | - | - | - |
| Appearance | Visual | - | Amber |
| Mineral oil content | Calculated | Wt% | > 60 |
| Emulsion | - | - | - |
| Appearance | Visual | - | Milky |
| pH (5%) | DIN 51 361 / ASTM E70-97 | - | 9.5 |
| Refractometer Factor | - | - | 1.0 |

Subject to usual manufacturing tolerances.

Recommended Concentrations

General Machining 4 - 7%
Drilling 5 - 7%
Reaming and tapping 7 - 10%

Water range 50 - 400 ppm CaCO

Storage

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

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

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