



Product Data

## Alusol RAL BF

High performance semi-synthetic metalworking fluid

### Description

Castrol Alusol™ RAL BF is a high performance semi synthetic metalworking fluid which is boron and chlorine 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 RAL BF is suitable for large central systems and single sump machines.

### Application

Alusol RAL BF is especially designed for machining of aluminium alloys. The product 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		ü	ü	ü		
Milling, Turning (general machining)	ü	ü ü	ü	ü ü ü		ü
Drilling	ü	ü ü		ü ü ü		ü
Reaming, Tapping	ü	ü ü		ü ü ü		ü

### Advantages

- 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 and bacterial 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

## Typical Characteristics

Name	Method	Units	Value
Concentrate			
Appearance	Visual		Amber
Mineral oil content	Calculated	Wt%	44
Emulsion			
Appearance	Visual		Milky
pH (6%)	DIN 61369 ASTM E70-97		9.0
Refractometer Factor			1.0

## Recommended Concentrations

Grinding	6-7%
General Machining	6-8%
Drilling	7-9%
Reaming and tapping	8-10%
Broaching	8-10%

Water range                    100-800 ppm CaCO<sub>3</sub>

## Additional Information

	Boron	Formaldehyde releasing agent	EP-Ester	Amines	Chlorine
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## 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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