



## Alusol 41 BF

High performance semi-synthetic metalworking fluid

### Description

Castrol Alusol™ 41 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 41 BF is suitable for large central systems and single sump machines.

### Application

Alusol 41 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	◊	◊ ◊	◊ ◊	◊ ◊ ◊		◊
Milling, Turning (general machining)	◊	◊ ◊	◊ ◊	◊ ◊ ◊		◊
Drilling	◊	◊ ◊	◊	◊ ◊ ◊		◊
Reaming, Tapping	◊	◊ ◊		◊ ◊ ◊		◊
Broaching	◊	◊		◊ ◊ ◊		◊

### 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%	35
Emulsion			
Appearance	Visual		Milky
pH (5%)	DIN 51369 ASTM E70-97		9.1
Refractometer Factor			1.0

## Recommended Concentrations

General Machining	6-8%
Drilling	7-9%
Reaming and tapping	8-10%
Broaching	8-10%
Water range	50-400 ppm CaCO <sub>3</sub>

## Additional Information

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

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Castrol Industrial, Technology Centre , Whitchurch Hill , Pangbourne , Reading , RG8 7QR , United Kingdom

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