



# Almaredge™ 4K

High performance soluble metalworking fluid

## Description

Castrol Almaredge™ 4K (previously called Superedge™ 4K) is a high performance chlorinated soluble metalworking fluid. It contains a blend of extreme pressure additives and corrosion inhibitors, which helps to enhance machining performance and surface finish, provide good product stability, improve system life and helps to lower the overall operations costs.

Almaredge 4K is suitable for large central systems and single sump machines.

## Application

Almaredge 4K is a general purpose soluble coolant recommended to cover the widest range of machining applications including turning, milling, drilling and light duty tapping and reaming. It is suitable for both ferrous and non ferrous materials including aluminium alloys and stainless 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 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
Broaching	ü	ü	ü	ü		ü

## Advantages

- Phenol and nitrite free to fulfill your local legislation, waste treatment and environmental requirements
- Helps to extend fluid life and reduce maintenance and machine downtime
- Low foam in recommended water conditions (see details below)
- Suitable for a wide range of materials and applications provides opportunity for product consolidation

## Typical Characteristics

	Test Method	Unit	Almaredge 4K
<b><u>Concentrate</u></b>			
Appearance	Visual		Light Amber
Mineral oil content	Calculated	Wt%	>50
<b><u>Emulsion</u></b>			
Appearance	Visual		Milky
pH (5%)	DIN 51369 ASTM E70-97		9.0
Refractometer Factor			1.1

Subject to usual manufacturing tolerances.

## Recommended Concentrations

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

Water range                    50 – 400 ppm CaCO<sub>3</sub>

## Additional Information

	Boron	Formaldehyde releasing agent	EP-Ester	Amines	Chlorine
Additives	ü	ü		ü	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.

**This product was previously called Superedge 4K. The name was changed in 2015**

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