



# 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                            |           | ..                       | ..                             | ...              |                  | ..            |

... core application .. recommended application . suggested application, please consult Castrol representative

## 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%  | 36    |
| <b>Emulsion</b>      |                          |      |       |
| Appearance           | Visual                   |      | Milky |
| pH (3%)              | DIN 51369<br>ASTM E70-97 |      | 9,2   |
| Refractometer Factor |                          |      | 1,0   |

## Recommended Concentrations

|                     |                               |
|---------------------|-------------------------------|
| Grinding            | 4-5%                          |
| General Machining   | 5-7%                          |
| Drilling            | 5-7%                          |
| Reaming and tapping | 6-9%                          |
| Broaching           | 8-10%                         |
| Water range         | 100-300 ppm CaCO <sub>3</sub> |

## Additional Information

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

## 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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