



# Alusol RBF

High performance semi-synthetic metalworking fluid

## Description

Castrol Alusol™ RBF is a high performance semi-synthetic metalworking fluid which is boron, formaldehyde releasing agent and chlorine-free. It contains an additive package that may help to enhance machining performance and surface finish. It also provides excellent product stability which helps to lower the overall operational costs.

Alusol RBF is suitable for large central systems and single sump machines.

## Application

Alusol RBF is especially designed for the machining of aluminium alloys. The product can also be used for the machining of ferrous 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		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

- Extended fluid life can help to reduce maintenance and downtime
- Low foam in recommended water conditions (see details below)
- Lubrication package designed to try to help enhance tool life and improve surface finish on aluminium machining
- Good wetting properties can help to reduce coolant drag out and help deliver cleaner machine tools and components
- Boron free to meet boron free waste requirements where applicable
- Chlorine, formaldehyde releasing agent and nitrite free which help you to fulfil aspects of legislative requirements and waste treatment requirements where applicable

## Typical Characteristics

	Test Method	Unit	Value
<b>Concentrate</b>			
Appearance	Visual		Amber
Mineral oil content	Calculated	Wt%	35
<b>Emulsion</b>			
Appearance	Visual		milky
pH (5%)	DIN 51369 ASTM E70-97		9,3
Refractometer Factor			1,0

## Recommended Concentrations

Grinding	6-7 %
General Machining	6-8 %
Drilling	6-10%
Reaming and Tapping	6-10%
Broaching	6-10%
Water range	100 – 600 ppm CaCO <sub>3</sub>

## Additional Information

	Boron	Formaldehyde releasing agent	EP-Ester	Amines	Chlorine
Additives			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 to the product safety data sheet.