

Alusol MF

High performance soluble metalworking fluid

Description

Castrol Alusol™ MF is a high performance soluble chlorine free metalworking fluid. 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 MF is suitable for large central systems and single sump machines.

Application

Alusol MF is especially designed for machining of aluminium alloys. The product can also be used for machining of low-medium alloyed steel.

- √√√: Core application
- √√: Recommended application
- √: Suggested application, please contact Castrol representative

	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

- 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	Alusol MF
Appearance (Concentrate)	Visual		Amber
Appearance (Emulsion)	Visual		Translucent
Mineral oil content	Calculated	Wt%	40
pH (5%)	DIN 51369 ASTM E70-97		9.0
Refractometer Factor			1.1

Recommended Concentrations

General Machining	5 - 7 %
Drilling	7 - 9 %
Reaming and tapping	7 - 10 %
Broaching	8 - 10 %
Water range	50 - 400 ppm CaCO ₃

Storage

All packages should be stored under cover. Where outside storage is unavoidable drums should be laid horizontally to avoid the possible ingress of water and damage to drum markings. Products should not be stored above 60°C, exposed to hot sun or freezing condition.

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