

Almaredge BI

General purpose soluble metalworking fluid

Description

Castrol Almaredge™ BI is a general purpose soluble metalworking fluid which is chlorine and boron-free. It contains a unique additive package that provides good lubrication properties and performs well in a wide water range.

Almaredge BI can be used in single sump machines as well large systems.

Application

Almaredge BI is a versatile product recommended for general machining on low-medium alloy steel and aluminium 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 | | | | | | |
| Milling, Turning (general ,machining) | 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 |

Advantages

- Boron free for environmental compliance and improved residue characteristics
- Chlorine and nitrite free to fulfill your local legislation, waste treatment and environmental requirements
- Versatile product suitable for wide range of materials and operations
- Low foam in recommended water conditions

Typical Characteristics

| Name | Method | Units | Almaredge BI |
|----------------------|--------------------------|-------|--------------|
| Concentrate | - | - | - |
| Appearance | Visual | - | Amber |
| Mineral oil content | Calculated | Wt% | > 60 |
| Emulsion | - | - | - |
| Appearance | Visual | - | Milky |
| pH (5%) | DIN 51 361 / ASTM E70-97 | - | 9.5 |
| Refractometer Factor | - | - | 1.0 |

Typical Physical Characteristics

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

Recommended Concentrations

General Machining 4 - 7%

Drilling 5 - 7%

Reaming and tapping 7 - 10%

Water range 50 - 400 ppm CaCO

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.

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08 Dec 2014

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