



Alusol SL 68 XBB

High performance semi-synthetic metalworking fluid

Description

Castrol Alusol™ SL 68 XBB is a high performance semi-synthetic metalworking fluid formulated without boron and formaldehyde releasing agent. It contains an additive package that helps to enhance machining performance and surface finish, provide excellent product stability and lower the overall operations costs.

Alusol SL 68 XBB is suitable for large central systems and single sump machines.

Application

Alusol SL 68 XBB is especially designed for machining of aluminium alloys. The product can also be used for 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	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	ü

Advantages

- Formulated without boron to meet boron free waste requirements
- Formulated without formaldehyde releasing agent which may help you to fulfill aspects of legislative requirements and waste treatment requirements that specify that these chemicals are excluded
- Extended fluid life can help reduce maintenance and machine downtime
- Low foam in recommended water conditions (see details below)
- Lubrication package designed to try to help to enhance tool life and improve surface finish on aluminium machining
- Good wetting properties can help reduce coolant drag out and help deliver cleaner machine tools and components

Typical Characteristics

	Test Method	Unit	Value
Concentrate			
Colour	Visual		Light Amber
Mineral oil content	Calculated	Wt%	28
Emulsion			
Appearance	Visual		Milky
pH (5%)	DIN 51369 ASTM E70-97		9.3
Refractometer Factor			1.0

Subject to usual manufacturing tolerances.

Recommended Concentrations

Grinding	5-6%
General Machining	5-7%
Drilling	6-8%
Reaming and tapping	8-10%
Broaching	8-10%
Water range	100-600 ppm CaCO ₃

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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