



Product Data

Alusol AU 68

High performance soluble metalworking fluid

Description

Alusol™ AU 68 is a multi-purpose, multi-metal compatible semi-synthetic product designed for heavy duty manufacturing applications. Alusol AU 68 is designed to meet stringent HSSE requirements for metalworking fluids. Alusol AU 68 is chlorine-, boron-, phosphorous- and sulfur-free, yet its performance exceeds soluble oils containing these extreme pressure additives. The tight, stable emulsion of Alusol AU 68 provides excellent tramp oil rejection and product stability in all water conditions.

Advantages

- Effective wetting properties maintains clean machines and components
- Boron-free, Chlorine-free, Phosphorus-Free and Sulfur-free for environmental regulations.
- Inhibits microbial growth to extend fluid life in central systems and individual sumps
- Formaldehyde-free to comply with health and safety regulations
- Specifically designed to provide superior performance on aerospace alloys and automotive aluminum.

Characteristics

	Unit	Test Method	Value
Appearance	-	Visual	Hazy, Yellow to Amber
Specific Gravity	@ 60°F (16°C)	CN-TM-086	0.947
Bulk Density	Lbs/gal	-	7.90

Recommended Concentrations

Grinding	5-6%
General Machining	5-7%

Systems using Alusol AU 68 should be maintained at a pH range of 8.8 – 9.3 by adding Balancer P3 if pH decreases. Maintenance of pH level is important to control biological activity of coolant system.

Concentration should be maintained at 5-10% depending on machining application. Addition of product concentrate in regular, standard additions will help maintain pH, bio-stability and additive levels.

Concentration Control

Refractometer Reading	% Concentration
3.0	3.3
5.0	5.5
7.0	7.7
10.0	11.0

User Advice

Alusol AU 68 is recommended for use with aerospace and automotive aluminum, and is also suitable for ferrous alloys. Consult your Castrol Account Manager for questions regarding compatibility

Additional Information

	Boron	Formaldehyde releasing agent	EP-Ester	Amines	Chlorine
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