



Product Data

Almaredge™ 420

General Purpose Soluble Oil

Description

Castrol Almaredge™ 420 (previously called Cooledge™ 420) is general purpose soluble oil recommended for the machining and grinding of cast iron, steel, aluminum, and copper.

Almaredge 420 forms a stable, low-foaming emulsion in soft and hard water. This product is multi-metal compatible and therefore offers effective corrosion control for a variety of materials.

Application

Almaredge 420 is a versatile product recommended for general machining on cast iron, low-medium alloy steel, aluminium alloys and yellow metals.

	Cast Iron	Low-medium alloyed steel	High alloyed - stainless steel	Aluminium alloys	Magnesium alloys
Grinding	ü	ü ü	ü ü	ü ü	
Milling, Turning (general machining)	ü	ü ü	ü	ü ü	
Drilling	ü	ü ü	ü	ü ü	
Reaming, Tapping	ü	ü ü	ü	ü ü	
Broaching	ü			ü ü	

ü ü ü *core application* ü ü *suggested core application* ü *suggested application; please consult Castrol representative*

Advantages

- Efficiently settles swarf to maintain clean systems.
- Provides rust protection to machinery and parts in-process and is non-staining to copper and brass.
- Forms a stable emulsion in hard or soft water.

Typical Characteristics

Name	Method	Unit	Almaredge 420
Appearance of Emulsion	CN-TM-074	-	Light Milky-white
pH of Dilution @ 5%	CN-TM-069	-	8.2 - 8.8
Specific Gravity @15°C (60°F)	CN-TM-084	-	0.92 - 0.95

Recommended Concentrations

Grinding 3-4%
General Machining 4-5%

Concentration Control

Refractometer Factor = 0.90

To calculate the concentration of the diluted fluid, multiply the Refractometer reading by the factor to come up with the in-use concentration

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.

This product was previously called Cooledge 420. The name was changed in 2015.

Almaredge™ 420

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