



Product Data

Alusol SL 78 XBB

High performance semi-synthetic metalworking fluid

Description

Castrol® Alusol® SL 78 XBB is a high performance semi-synthetic metalworking fluid formulated without boron, biocides and formaldehyde releasing agents. It contains an additive package that helps enhance machining performance and surface finish, provide excellent product stability and reduce overall operating costs.

Alusol SL 78 XBB is suitable for large central systems and single sump machines.

Application

Alusol SL 78 XBB is a multi-metal cutting and grinding fluid designed for machining of aluminum alloys and a wide range of steel and stainless steel 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 | Aluminum 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 | ü |
| Reaming, Tapping | ü | ü ü | ü ü | ü ü | ü |
| Broaching | ü | ü | ü | ü ü | ü |

Advantages

- Formulated without boron, biocides and formaldehyde releasing agents which may help you to fulfill legislative 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 help enhance tool life and improve surface finish
- Good wetting properties can help reduce coolant drag out and help deliver cleaner machine tools and components

Typical Characteristics

| | Test Method | Unit | Value |
|---------------------------|--------------------------|------|-------------|
| <u>Concentrate</u> | | | |
| Color | Visual | | Light Amber |
| Density @ 15 °C | ASTM D 4052 | | .937-.947 |
| <u>Emulsion</u> | | | |
| Appearance | Visual | | Milky |
| pH (5%) | DIN 51369 ASTM E70-97 | | 9.3 |
| Refractometer Factor | BRIX Multiplier | | 1.1 |

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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