



Almaredge 420

General purpose soluble metalworking fluid

Description

Castrol Almaredge™ 420 (previously known as Cooledge 420) is a general purpose soluble metalworking fluid which is chlorine and boron-free. It contains an additive package that provides good lubrication properties and performs well in a wide water range.

Almaredge 420 can be used in single sump machines as well large systems.

Application

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

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	ü	ü ü	ü ü	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

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
- Provides rust protection to machinery and parts in process and is non-staining to copper and brass.

Typical Characteristics

Name	Test Method	Unit	Almaredge 420
<i>Concentrate</i>			
Appearance	Visual		Amber
Mineral oil content	Calculated	Wt%	> 60
<i>Emulsion</i>			
Appearance	Visual		Milky
pH (5%)	ASTM E70-97 / DIN 51369		8,5
Refractometer Factor			0,9

Recommended Concentrations

Grinding	3-5%
General Machining	4-7%
Drilling	5-7%
Reaming and tapping	7-10%

Water range 100-600 ppm CaCO₃

Additional Information

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

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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