

## Castrol Cooledge BI

General purpose soluble metalworking fluid

### Description

Castrol Cooledge™ BI is a general purpose soluble metalworking fluid which is chlorine and boron-free. It contains a unique additive package that provides good lubrication properties and performs well in a wide water range.

Cooledge BI can be used in single sump machines as well large systems.

### Application

Cooledge BI is a versatile product recommended for general machining on low-medium alloy steel and aluminium alloys.

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

### 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

## Typical Characteristics

	Test Method	Unit	Value
<b>Concentrate</b>			
Appearance	Visual		Amber
Mineral oil content	Calculated	Wt%	> 60
<b>Emulsion</b>			
Appearance	Visual		Milky
pH (5%)	DIN 51361 ASTM E70-97		9.5
Refractometer Factor			1.0

	Boron	Formaldehyde releasing agent	EP-Ester	Amines	Chlorine
Additives	-	✓	-	✓	-

## Recommended Concentrations

General Machining	4-7%
Drilling	5-7%
Reaming and tapping	7-10%
Water range	50-400 ppm CaCO <sub>3</sub>

## Storage

To avoid product deterioration, keep the container/drum tightly sealed always. Prevent any frost and water ingress.

Store it in a cool and dry place away from direct sunlight. It is preferable to store the product indoors always. For more details, please refer the product safety data sheet.

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Address: Castrol (UK) Limited, Pipers Way, Swindon, Wiltshire SN3 1RE  
Telephone No. Orders/Enquiries 0845 9645111, Technical Enquiries 0845 9000209, Fax 01793 486083  
[www.castrol.com/industrial](http://www.castrol.com/industrial)