AL 4 EP

Description

AL4 EP is a metal working, water extendible fluid, formulated to provide enhanced machining performance in applications that are arduous and demand more lubricity.
AL4 EP contains chlorine and formulated with yellow metal deactivators, biocides to maintain biostability in the working emulsion.

Directions for use:

AL4 EP is suitable for use on ferrous and non- ferrous metals as well as aluminium alloys
To produce an emulsion, always add the product to potable tap water, while mixing at the required dilution rate.

Applications Guide:

Recommended dilution rates:
- Automatic machines 4.0%
- Turning and Milling 4.0%
- Drilling 5-8%
- Sawing 8.0%
- Broaching 8.0%

Physical Data

Appearance Pale Amber fluid
Density @ 20C g/ml 0.982
pH Value @ 5% 9.2
Mineral Oil Content 45.0%
Min. Corrosion limit (IP 287) 3.0%

Overview

AL4 EP is recommended for aluminium and its alloys that may be difficult to machine in certain aspects. In metal cutting operations, a conventional general purpose soluble oil is not always suitable as surface finish and coolant life may be affected. **AL4 EP** overcomes these problems and is now widely accepted due to its improved performance in the above areas and its cooling and lubricating properties.

This product has an opaque emulsion. Always add the product to water while agitating at the recommended concentration level to produce a clear, stable, working emulsion. Maintaining the recommended concentration range for your metalworking fluid will improve the overall performance of the operation, improve productivity, extend fluid life, reduce disposal costs, and improve overall operator satisfaction.

Routine concentration checks along with proper makeup are essential to good fluid management. It is recommended the concentration levels are evaluated with a refractometer. DSAL4EP Pg. 2 of 2
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Refractometer chart—concentrations, brix%

Dilution refractometer reading Brix. 100:1 1	1,4
100:2 2	2.6
100:3 3	3.8
100:4 4	4.6
100:5 5	5,2
100:6 6	6.4
100:7 7	7,2
100:8 8	8.0
100:9 9	8,8
100:10 10	9,8

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