

TECHNICAL DATA SHEET

AL 1500

Code 7460

Premium Semi Synthetic Metal Working Coolant

DESCRIPTION

Callington AL1500 is a high-performance, semi synthetic metal working coolant, designed for the machining of **aluminium and aluminium alloys**, commonly used in the automotive, electronics and aerospace industries, as well as **ferrous alloys**. It has been formulated for use in soft water as well as hard waters, and exhibits low foam and excellent stability under a wide range of conditions.

APPLICATION

Callington AL1500 is designed for use in most metal working applications including grinding, and its performance is particularly outstanding in the more difficult aluminium machining operations such as reaming, tapping and broaching of the harder high silicon aluminium alloys. It is non- staining to aluminium and its alloys, making it suitable for use in automotive, electronics and aerospace aluminium applications.

Callington AL1500 is suitable for use with the latest technology high speed machining centres and can be **used also on ferrous materials**, making it ideal for use where both aluminium alloys and ferrous materials are being machined. It is low foaming and ideal for high pressure, high volume coolant flow applications. It is equally suitable for use in large centralised coolant systems and for small individual coolant sumps.

BENEFITS

- Excellent surface finish and extended tool life, even in difficult operations
- Can be used on both aluminium and ferrous materials, offering manufacturing flexibility
- Excellent wetting properties, reducing “drag out” and product usage
- Exceptional product stability and long coolant life means lower process costs
- Excellent corrosion protection, non-staining to ferrous materials and to aluminium and its alloys.
- Low foaming characteristics even in modern high pressure machines.

RECOMMENDED DILUTIONS

| Material | Low Si Aluminium | High Si Aluminium | Low Alloy Steels | High Alloy Steels |
|--------------------|------------------|-------------------|------------------|-------------------|
| Operation | | | | |
| Grinding | 4% | 4% | - | - |
| Turning | | | | |
| Drilling | 5% | 6% | 5% | 6% |
| Heavy Duty Milling | | | | |
| Tapping | 7% | 8 - 10% | 6% | 6% |
| Reaming | | | | |
| Broaching | 7% | 8 - 10% | - | - |

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TYPICAL DATA (note: data is typical and does not constitute a specification).

| Concentrate | Test Method | Typical Result |
|----------------------|-----------------------|------------------|
| Appearance | Visual | Pale Amber Fluid |
| Density | DIN 51757/ASTM D1298 | 0.96 g/ml |
| Emulsion | | |
| Appearance | Visual | Semi Translucent |
| pH5% | DIN 51361/ASTM E70-97 | 9.0 |
| Refractometer Factor | | 1.12 |

STORAGE

Keep container closed, prevent exposure to frost, and prevent water ingress. Store in cool, dry conditions, avoid direct sunlight. Indoor storage is preferable.

SHELF LIFE

The shelf-life of the product when stored under appropriate storage conditions is 12 months from the date of manufacture

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