

Premium Quality Chlorine Free Soluble Cutting Fluid

DESCRIPTION

Castrol Hysol X has been formulated using chlorine-free high performance additives to ensure exceptional cutting characteristics where the cutting process is particularly arduous eg. broaching and where the metal is difficult to machine eg. Stainless Steel, nimonics etc.

APPLICATION

Hysol X has such exceptional cutting properties that in some instances it is possible to replace some neat oil applications with it. The high performance additives also allow the product to be used for general purpose applications such as cutting of steel.

Castrol Hysol X incorporates advanced additive technology to control fungal and bacterial growth ensuring exceptional bath life and means the product can be used equally well in central systems or single sump machines and reduces the need for fluid maintenance.

FEATURES

- ◆ High performance synthetic lubricity additives
- ◆ Optimised surfactant package
- ◆ Advanced additive technology
- ◆ Chlorine free

BENEFITS

- ◆ Exceptional tool-life and surface finish
- ◆ Can replace neat oils in some applications
- ◆ Inherently low foam
- ◆ Long bath life
- ◆ Reduced need for maintenance
- ◆ Environmentally acceptable



TYPICAL PHYSICAL CHARACTERISTICS**Concentrate**

Appearance	-	Dark Amber
Density at 20°C kg/m ³	-	0.990

Emulsion

Appearance	-	Milky emulsion
pH at 3% Concentration	-	9.0 - 9.5
Refractometer Correction Factor	-	1.1

RECOMMENDED CONCENTRATIONS

Material	Mild and Low Carbon Content Steels	Stainless Steels	Nimonic Alloys	Heat Resistant
Operation				
Multi-Tool Lathes	4%	5%	5%	5%
Gear Cutting	4%	5%	6%	6%
Deep Hole Drilling	5%	7%	7%	7%
Broaching	5%	6-7%	8%	8%
General Machining	4%	5%	5%	5%

ADDITIONAL INFORMATION

For maximum service life, coolant systems should be cleaned and sterilised by treatment with Castrol System Cleaner before changing to Hysol X. Treatment entails the addition of approximately 1% System Cleaner to the previous charge of coolant the day before it is due to be discarded.

Note that if the concentration of Hysol X should become too high, above a maximum of 10% not only will the emulsion become unstable but there is also the possibility of skin complaints among operators.

Health and Safety information sheets are available for all Castrol products from the address below.
Castrol International, Pipers Way, Swindon, Wiltshire SN3 1RE, England., Telephone: Enquiries
+44 (0)1793 512712, Technical Enquiries +44 (0)118 984 3311, Fax +44 (0)1793 453218

All reasonable care has been taken to ensure that the information contained in this publication is accurate as at the date of printing. It should be noted however that the information above may be affected by changes occurring subsequent to the date of printing in the blend formulation or methods of application of any of the products referred to or in the requirements of any specification approval relating to any such products.

