



# Hysol XF

High performance semi-synthetic soluble metalworking fluid

## Description

Castrol Hysol™ XF is a high performance semi synthetic metalworking fluid formulated without formaldehyde releasing agents. It contains an additive package that may help to enhance machining performance and surface finish. It also provides excellent product stability which helps to lower the overall operational costs.

Hysol XF is suitable for large central systems and single sump machines.

## Application

Hysol XF is especially designed for steel and aluminum alloys machining.

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 alloy	Magnesium alloy	Yellow metals
Grinding	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
Broaching	ü	ü ü	ü ü	ü		ü

## Advantages

- Formulated without formaldehyde releasing agents which may help you to fulfil aspects of legislative requirements that specify that these chemicals are excluded
- Extended fluid life can help to reduce maintenance and downtime
- Low foam in recommended water conditions (see details below)
- Lubrication package designed to try to help enhance tool life and improve surface finish on steel machining
- Good wetting properties can help to reduce coolant drag out and help deliver cleaner machine tools and components
- Multi-functional product for multi-metal operations can help in product consolidation

## Typical Characteristics

	Unit	Test Method	Value
<b><u>Concentrate</u></b>			
Appearance		Visual	Amber
Mineral oil content	Wt%	Calculated	around 34
<b><u>Emulsion</u></b>			
Appearance		Visual	milky
pH (5%)		DIN 51361 ASTM E70-97	9,4
Refractometer Factor			1,1

Subject to usual manufacturing tolerances.

## Recommended Concentrations

Grinding	5- 6%
General Machining	5- 7%
Drilling	5-8%
Reaming and Tapping	6-10%
Broaching	8-10%

Water range: 50-300 ppm CaCO<sub>3</sub>

## Additional Information

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

## 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.

Hysol XF  
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