



Product Data

Hysol 11 FF

High performance semi-synthetic metalworking fluid

Description

Castrol Hysol™ 11 FF is a high performance semi synthetic metalworking fluid, formulated without formaldehyde releasing agents. It contains an additive package that helps to enhance machining performance and surface finish, provide good product stability and lower the overall operations costs.

Hysol 11 FF is suitable for large central systems and single sump machines

Application

Hysol 11 FF is especially designed for grinding of low to medium alloyed steel and machining cast iron.

**suggested core application * possible application, please consult Castrol representative prior to use

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

Advantages

- Formulated without formaldehyde releasing agent help you to fulfil aspects of legislative requirements and waste treatment requirements that specify that these chemicals are excluded
- Extended fluid life can help reduce maintenance and machine downtime
- Low foam in recommended water conditions (see details in below)
- Good wetting properties can help reduce coolant drag out and help deliver cleaner machine tools and components

Typical Characteristics

Name	Method	Units	Value
Concentrate			-
Colour	Visual		Pale Amber
Mineral Oil Content	Calculated	Wt%	10
Emulsion			-
Appearance	Visual		Translucent
pH (5%)	DIN 51369, ASTM E70-97		9.2-9.9
Refractometer Factor			2.7

Subject to usual manufacturing tolerances.

Recommended Concentrations

- Grinding

5 - 7%
- General Machining

6 - 10%
- Water hardness range

100 - 600 ppm CaCO₃

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