Product Data

Hysol™ ABF 12

High performance soluble metalworking fluid

Description

Castrol Hysol™ ABF 12 (previously called Cooledge™ ABF 12) is a high performance soluble metalworking fluid which is boron, amine, chlorine and formaldehyde releasing agent free. It contains a unique additive package that works in synergy to enhance machining performance and surface finish, provide excellent product stability, improve bio-resistance properties and lower the overall operations costs.

Hysol ABF 12 is suitable for large central systems and single sump machines.

Application

Hysol ABF 12 is especially designed for cast iron and low-medium alloyed steel machining. It can also be used for machining of aluminium and magnesium alloys.

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

	Cast Iron	Low -medium alloyed steel	High alloyed - stainless steal	Aluminium alloys	Magnesium alloys	Yellow Metals
Grinding						
Milling, Turning (general Machining)	ü	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
Broaching	ü	ü		ü	ü ü	ü

Advantages

- Formaldehyde releasing free to comply with health and safety regulations
- Boron free for environmental compliance and improved residue characteristics
- Chlorine and nitrite free to fulfill your local legislation, waste treatment and environmental requirements
- Resists fungal attack to extend fluid life and reduce maintenance and machine downtime
- Low foam in recommended water conditions
- Lubrication package specifically designed to enhance tool life and improve surface finish
- Excellent wetting properties reduce coolant drag out and deliver clean machine tools and components
- Unique multi-functional product for multi-metal operations results in product consolidation

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Typical Characteristics

Name	Method	Unit	Hysol ABF 12
Concentrate			
Appearance	Visual		Amber
Mineral Oil content	Calculated	Wt%	47
Emulsion			
Appearance	Visual		Milky
pH(5%)	ASTM E70-97 DIN 51361		9.1
Refractometer Factor	-		1

Subject to usual manufacturing tolerances.

Recommended Concentrations

General machining	7-9%
Drilling	7-10%
Reaming and tapping	8-12%
Broaching	8-12%

Water Range 200-1500ppm $CaCO_3$

Additional Information

	Boron	Formaldehyde releasing agent	EP - Ester	Amines	Chlorine
Additives			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.
This product was previously called Coolegde ABF 12. The name was changed in 2015

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