Product Data

Hysol MB 50

High performance soluble metalworking fluid

Description

Castrol Hysol™ MB 50 is a high performance soluble 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 MB 50 is suitable for large central systems and single sump machines.

Application

Hysol MB 50 is especially designed for machining of ferrous and aluminium 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 steel	Aluminium alloys	Titanium alloys	Magnesium alloys	Yellow metals
Grinding	ü	ü ü	ü ü	ü ü			ü
Milling, Turning (general machining)	ü ü	ü ü	ü ü	ü ü	ü ü		ü
Drilling	ü ü	ü ü	ü ü	ü ü	ü		ü
Reaming, Tapping	ü ü	ü ü	ü	ü ü			ü
Broaching	ü ü	ü		ü			ü

Advantages

- 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 aluminium, titanium and ferrous machining
- Good wetting properties can help to reduce coolant drag out and help deliver cleaner machine tools and components
- Suitable for a wide range of materials and applications provides opportunity for product consolidation
- Formulated without formaldehyde releasing agents which help you to fulfil aspects of legislative requirements and waste treatment requirements that specify that these chemicals are excluded

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Experts in industrial and automotive lubrication

Typical Characteristics

	Test Method	Unit	Value
Concentrate			
Appearance	Visual		Amber
Mineral oil content	Calculated	Wt%	50
Emulsion			
Appearance	Visual		Milky
pH (5%)	DIN 51369 ASTM E70-97		9.7
Refractometer Factor			1.0

Subject to usual manufacturing tolerances.

Recommended Concentrations

Grinding	5-7%
General Machining	5-8%
Drilling	6-8%
Reaming and tapping	7-10%
Broaching	8-10%
Water range	100-1000 ppm $CaCO_3$

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 to the product safety data sheet.

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