Product Data

Hysol SL 20 XBB

High performance semi-synthetic metalworking fluid

Description

Castrol Hysol™ SL 20 XBB is a high performance semi synthetic metalworking fluid which is formulated without formaldehyde releasing agent and boron. It contains an additive package that works in synergy to help enhancing machining performance and surface finish, provide excellent product stability and lower the overall operations costs.

Hysol SL 20 XBB is suitable for large central systems and single sump machines.

Application

Hysol SL 20 XBB is especially designed for machining of cast iron and low-medium alloyed steel.

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	Magnesium alloys	Yellow metals
Grinding	√√	√√	√√			
Milling, Turning (general machining)	√√	√√	√			
Drilling	√√	√				
Reaming, Tapping	√√	√				
Broaching	√√	√				

Advantages

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

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Typical Characteristics

	Test Method	Unit	Value
Concentrate			
Appearance	Visual	-	Amber
Mineral oil content	Calculated	Wt%	20
Emulsion			
Appearance	Visual	-	Translucent-Milky
pH (5%)	DIN 51369 ASTM E70-97		9.8
Refractometer Factor			1.6

Subject to usual manufacturing tolerances.

Recommended Concentrations

Grinding	4-6%
General Machining	6-10%
Drilling	6-8%
Reaming	6-10%
Broaching	6-10%
Water range	100-800 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 the product safety data sheet.

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