Product Data

Hysol SL 45 XBB

High performance soluble metalworking fluid

Description

Castrol Hysol™ SL 45 XBB is a high performance soluble metalworking fluid formulated without boron and formaldehyde releasing agents. It contains an additive package that may help to enhance machining performance and surface finish. It also provides good product stability which helps to lower the overall operational costs.

Hysol SL 45 XBB is suitable for large central systems and single sump machines.

Application

Hysol SL 45 XBB is especially designed for machining of aluminum and titanium alloys in aerospace industry. The product can also be used for machining of ferrous alloys.

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

Advantages

- 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
- Extended fluid life can help reduce maintenance and machine downtime
- Low foam in recommended water conditions (see details below)
- Lubrication package designed to try to help to enhance tool life and improve surface finish on aluminium machining
- Good wetting properties can help 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

Berreteaga N°6, A, 48150, Sondika (Bizkaia) · mendoza@comercialmendoza.es

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Typical Characteristics

	Unit	Test Method	Value
Concentrate			
Appearance		Visual	Amber
Mineral oil content	Wt%	Calculated	45
Emulsion			
Appearance		Visual	milky
pH (6%)		DIN 51369 ASTM E70-97	9.4
Refractometer Factor			1.0

Subject to usual manufacturing tolerances.

Recommended Concentrations

Grinding	5-7%
General Machining	6-8%
Drilling	7-9%
Reaming and tapping	8-10%
Broaching	8-10%

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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Castrol Industrial, Technology Centre , Whitchurch Hill , Pangbourne , Reading , RG8 7QR , United Kingdom

http://msdspds.castrol.com

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