

## Castrol Hysol 40 FF

High performance semi-synthetic metalworking fluid

### Description

Castrol Hysol™ 40 FF is a high performance chlorine free semi-synthetic metalworking fluid. 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 40 FF is suitable for large central systems and single sump machines.

### Application

Hysol 40 FF is especially designed for machining of cast iron and low-medium alloyed steel.

	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

- Chlorine and nitrite free to fulfill your local legislation, waste treatment and environmental requirements
- Resists fungal and bacterial attack to extend fluid life and reduce maintenance and machine downtime
- Low foam in recommended water conditions
- Good anti-corrosion properties to protect machine tools and parts
- Advanced lubricity compounds ensure improved tool life and part quality
- Excellent wetting properties reduce coolant drag out and deliver clean machine tools and components

## Typical Characteristics

	Test Method	Unit	Value
<b>Concentrate</b>			
Appearance	Visual		Yellow
Mineral oil content	Calculated	Wt%	40
<b>Emulsion</b>			
Appearance	Visual		Translucent
pH (5%)	DIN 51361 ASTM E70-97		9.2
Refractometer Factor			1

	Boron	Formaldehyde releasing agent	EP-Ester	Amines	Chlorine
Additives	✓	-	✓	✓	-

## Recommended Concentrations

Grinding	3-6%
General Machining	4-8%
Drilling	6-8%
Reaming and tapping	6-8%
Broaching	6-8%
Water range	100-400 ppm CaCO <sub>3</sub>

## Storage

To avoid product deterioration, keep the container/drum tightly sealed always. Prevent any frost and water ingress.

Store it in a cool and dry place away from direct sunlight. It is preferable to store the product indoors always. For more details, please refer the product safety data sheet.

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