



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 steel	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

Typical Characteristics

Name	Method	Unit	Hysol ABF 12
<u>Concentrate</u>			
Appearance	Visual		Amber
Mineral Oil content	Calculated	Wt%	47
<u>Emulsion</u>			
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 CaCO₃

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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