

Hysol HDM

High performance soluble metalworking fluid

Description

Castrol Hysol™ HDM is a high performance soluble metalworking fluid which is chlorine free. It contains an additive packet 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 HDM is suitable for large central systems and single sump machines.

Application

Hysol HDM is especially designed for machining of steel, stainless steel 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	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
Drilling	ü	ü ü	ü ü	ü ü		ü
Reaming, Tapping	ü	ü ü	ü ü	ü		ü
Broaching	ü	ü ü	ü ü	ü		ü

Advantages

- Chlorine and nitrite free which may help you to fulfil aspects of legislative requirements and waste treatment requirements that specify that these chemicals are excluded. Resists fungal and bacterial attack to extend fluid life and reduce maintenance and machine downtime
- Low foam in recommended water conditions (see details below)
- Good anti-corrosion properties to protect machine tools and parts
- Lubrication package designed to try to help enhance tool life and improve surface finish on steel 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

Typical Characteristics

Name	Method	Units	Value
Concentrate			
Appearance	Visual		Brown
Mineral oil content		Wt%	41
Emulsion			
Appearance	Visual		Translucent
pH (5%)	DIN 51369 ASTM E70-97		9.1
Refractometer Factor			1.1

Recommended Concentrations

Grinding	4-6%
General Machining	4-7%
Drilling	6-10%
Reaming and Tapping	6-10%
Broaching	7-10%
Water range	20-300 ppm CaCO ₃

Additional Information

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

Storage

To avoid product deterioration always keep the container/drum tightly sealed. For optimum product stability, store between 5°C/41°F and 45°C/113°F in a cool, dry place away from direct sunlight. Prevent exposure to frost and avoid water ingress. It is preferable to store the product indoors.

For more details, please refer the product safety data sheet.

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30 Jun 2014
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