



Product Data

## Castrol Hysol 33 FF

High performance semi-synthetic metalworking fluid

### Description

Castrol Hysol™ 33 FF is a high performance semi synthetic metalworking fluid, formulated without formaldehyde releasing agents. It contains an additive package that helps to enhance machining performance and surface finish, provide good product stability and lower the overall operations costs.

Hysol 33 FF is suitable for large central systems and single sump machines.

### Application

Hysol 33 FF is especially designed for multi metal machining from ferrous to aluminium alloys.

√√ suggested core application    √ possible application, please consult Castrol representative prior to use

	Cast Iron	Low-medium alloyed steel	High alloyed steel	Aluminum alloys	Magnesium alloy	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)
- Lubrication package designed to try to help enhance tool life and improve surface finish on aluminium and ferrous 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
- Formulated without formaldehyde releasing agents which help you to fulfil aspects of legislative requirements and waste treatment requirements that specify that these chemicals are excluded

## Typical Characteristics

Hysol 33 FF			
Density @ 15°C	ASTM D4052	g/cm3	0.99
Appearance	CN-TM-007		clear to slightly hazy liquid
Emulsion Stability, 5%, 600 ppm	CN-TM-027		Semi-translucent, stable
Refractometer Factor			1.5

## Recommended Concentrations

Grinding	4-7%
General Machining	5-8%
Drilling	6-10%
Reaming and tapping	7-10%
Broaching	8-10%
Water range	100-600 ppm CaCO <sub>3</sub>

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