



Product Data

Castrol Hysol 5 BF

Semi-synthetic metalworking fluid

Description

Castrol Hysol™ 5 BF is a semi-synthetic metalworking fluid formulated without boron for general machining and grinding for mass production. It contains an additive package that may help to enhance machining performance and surface finish. It provides excellent product stability and bio-resistance which helps to be lower the overall operational costs.

Hysol 5 BF is suitable for large central systems and single sump machines.

Application

Hysol 5 BF is suitable for grinding and general machining for ferrous and aluminum 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 boron help you to fulfil aspects of legislative requirements and waste treatment requirements
- Extended fluid life can help reduce maintenance and downtime
- Low foam in recommended water conditions
- Good wetting properties can help reduce coolant drag out and deliver cleaner machine tools and components

Typical Characteristics

Name	Method	Units	Hysol 5 BF
Appearance	Visual		Hazy light yellow
Mineral Oil Content	Calculated	% wt	< 10%
pH (5%)	DIN 51369, ASTM E70-97		9.4
Refractometer Factor			2.8

Subject to usual manufacturing tolerances

Recommended Concentrations

Grinding 4 – 7%

General Machining 5 – 8%

Drilling 5 – 9%

Reaming and Tapping 8 – 12%

Water range 50 - 800 ppm CaCO₃

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