



## Hysol™ 6510

High performance semi-synthetic metalworking fluid

### Description

Castrol Hysol™ 6510 (previously called Clearedge™ 6510) is a high performance semi-synthetic chlorine free metalworking fluid. It contains an additive package that helps to enhance machining performance and surface finish, provide excellent product stability, improve system life and lower the overall operations costs.

Hysol 6510 is suitable for large central systems and single sump machines.

### Application

Hysol 6510 is especially designed for grinding of steel and machining of low-medium alloyed steel and cast iron.

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			
Miling, Turning (general machining)	ü ü	ü ü	ü			
Drilling	ü	ü	ü			
Reaming, Tapping	ü	ü				
Broaching						

### Advantages

- Formaldehyde releasing free to comply with health and safety regulations
- Chlorine and nitrite free to fulfill your local legislation, waste treatment and environmental requirements
- Long system life can help to reduce maintenance and machine downtime
- Low foam in recommended water conditions
- Excellent wetting properties helps to reduce coolant drag out and deliver clean machine tools and components

## Typical Characteristics

Name	Method	Units	Hysol 6510
<b><i>Concentrate</i></b>			
Appearance	Visual		Amber
Mineral Oil Content	calculated	Wt%	22
<b><i>Emulsion</i></b>			
Appearance	Visual		Transparent
pH (5%)	ASTM E70-97 / DIN 51369		9.5
Refractometer Factor			1.5

Subject to usual manufacturing tolerances.

## Recommended Concentrations

Grinding	4-5%
General Machining	5-8%

Water Range      50-600 ppm CaCO<sub>3</sub>

## 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 Clearedge 6510. The name was changed in 2015.**

Hysol™ 6510  
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