



Product Data

Hysol™ 6519

High performance semi-synthetic metalworking fluid

Description

Castrol Hysol™ 6519 (previously called Clearedge™ 6519) is high performance semi-synthetic metalworking fluid which is 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 6519 is suitable for large central systems and single sump machines.

Application

Hysol 6519 is especially designed for grinding and machining of aluminium alloys and low-medium alloyed steel.

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

Advantages

- Chlorine and nitrite free to fulfill your local legislation, waste treatment and environmental requirements
- Resists fungal and bacterial attack to extend fluid life and reduce maintenance and machine downtime
- Low foam in recommended water conditions
- 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	Units	Hysol 6519
<i>Concentrate</i>			
Appearance	Visual	-	Yellow
Mineral Oil content	Calculated	Wt%	29
<i>Emulsion</i>			
Appearance	Visual		Translucent
pH (5%)	ASTM E70-97 DIN 51361		9.3
Refractometer Factor			1.4

Subject to usual manufacturing tolerances.

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Recommended Concentrations

Grinding	4-5%
General Machining	4-8%
Water Range	100-400 ppm CaCO ₃

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 Clearegde 6519. The name changed in 2015

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