



Product Data

Hysol LXE

High performance soluble metalworking fluid

Description

Castrol Hysol™ LXE is a high performance chlorinated soluble metalworking fluid formulated without formaldehyde releasing agent. It contains a unique blend of extreme pressure additives and corrosion inhibitors, which work in synergy to help enhance machining performance and surface finish, provide excellent product stability, improve bio-resistance properties and lower the overall operations costs.

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

Application

Hysol LXE is recommended for use on most general purpose machining applications including milling, drilling, tapping, and reaming. It is a versatile product that can be used for machining of cast iron, low-medium alloyed steel, high alloy-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		ü
Milling, Turning (general machining)	ü 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

- Formulated without formaldehyde releasing agents to fulfill aspects of legislative requirements that specify that these chemicals are excluded
- Helps to extend fluid life and reduce maintenance and machine downtime
- Excellent anti-corrosion properties to protect machine tools and parts
- Advanced extreme pressure additives to ensure improved tool life and part quality
- Excellent wetting properties reduce coolant drag out and deliver clean machine tools and components
- Can be used on a wide range of metals and operations – an ideal candidate for product rationalization on the shop floor

Typical Characteristics

	Test Method	Unit	Value
<u>Concentrate</u>			
Appearance	Visual		Yellow
Mineral oil content	Calculated	Wt%	Around 47
<u>Solution</u>			
Appearance	Visual		Milky
pH (3%)	DIN 51369 ASTM E70-97		9.1
Refractometer Factor			1.0

Subject to usual manufacturing tolerances.

Recommended Concentrations

Grinding	4-6%
General Machining	4-6%
Drilling	5-7%
Reaming and tapping	6-15%
Broaching	6-15%

Water range 100-400 ppm CaCO₃

Additional Information

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

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Castrol Industrial, Technology Centre , Whitchurch Hill , Pangbourne , Reading , RG8 7QR , United Kingdom

<http://msdspds.castrol.com>