



Product Data

## Hysol MB 50

High performance soluble metalworking fluid

### Description

Castrol Hysol™ MB 50 is a high performance soluble metal working fluid, which is formulated without chlorine or formaldehyde releasing agents . 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 MB 50 is suitable for large central systems and single sump machines.

### Application

Hysol MB 50 is especially designed for machining of ferrous and aluminium alloys.

	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 ü		ü
Drilling	ü ü	ü ü	ü ü	ü ü		ü
Reaming, Tapping	ü ü	ü ü	ü	ü ü		ü
Broaching	ü ü	ü ü		ü ü		ü

ü ü ü : *core application*

ü ü : *recommended application*

ü : *suggested application; please consult Castrol representative*

### 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
- Resists fungal and bacterial attack to extend fluid life and reduce maintenance and machine downtime
- Low foam in recommended water conditions
- Good anti-corrosion properties to protect machine tools and parts
- Advanced lubricity compounds ensure improved tool life and part quality
- 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	Value
Concentrate			
Appearance	Visual		Amber
Mineral oil content	Calculated	Wt%	50
Emulsion			
Appearance	Visual		Milky
pH (5%)	DIN 51369 ASTM E70-97		9.7
Refractometer Factor			1.0

## Recommended Concentrations

Grinding	5-7%
General Machining	5-8%
Drilling	6-8%
Reaming and tapping	7-10%
Broaching	8-10%

Water range            100-600 ppm CaCO<sub>3</sub>

## Additional Information

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

Hysol MB 50  
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