



Product Data

## Hysol MB 10 BF

Semi-synthetic metalworking fluid

### Description

Castrol Hysol™ MB 10 BF is a semi synthetic metalworking fluid which is chlorine, formaldehyde releasing agent and boron free. It contains an additive package that works in synergy to capture machining performance and surface finish, provide excellent product stability and lower the overall operations costs.

Hysol MB 10 BF is suitable for large central systems and single sump machines.

### Application

Hysol MB 10 BF is especially designed for machining of cast iron and grinding of 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 alloys	Yellow metals
Grinding	ü ü	ü ü	ü	ü		
Milling, Turning (general machining)	ü ü	ü ü	ü	ü		
Drilling	ü ü		ü	ü		
Reaming, Tapping						
Broaching						

### Advantages

- Formaldehyde releasing agent free to comply with health and safety regulations
- Boron, chlorine and nitrite free to fulfill your local legislation, waste treatment and environmental requirements
- Extend fluid life and reduce maintenance and machine downtime
- Low foam in recommended water conditions
- Excellent anti-corrosion properties to protect machine tools and parts
- Excellent wetting properties reduce coolant drag out and deliver clean machine tools and components
- Stable fluid suitable for a wide range of water conditions

## Typical Characteristics

	Test Method	Unit	Value
<b><u>Concentrate</u></b>			
Appearance	Visual		Yellow-Amber
Mineral oil content	Calculated	Wt%	13
<b><u>Emulsion</u></b>			
Appearance	Visual		Translucent
pH (3%)	DIN 51369 ASTM E70-97		9.8
Refractometer Factor			2.0

Subject to usual manufacturing tolerances.

## Recommended Concentrations

Grinding 5-6%  
General Machining 6-10%

Water range 100-800 ppm CaCO<sub>3</sub>

## Additional Information

	Boron	Formaldehyde releasing agent	EP-Ester	Amines	Chlorine
Additives				ii	

## 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.

Hysol MB 10 BF

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