



Product Data

Hysol R

High performance semi-synthetic metalworking fluid

Description

Castrol Hysol™ R is a high performance chlorine free semi-synthetic metalworking fluid. It contains an additive package that works to enhance machining performance and surface finish. It also provides excellent product stability and helps lower the overall operations costs.

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

Application

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

Advantages

- Chlorine and nitrite free which may help you to fulfill aspects of legislative requirements and waste treatment requirements that specify that these chemicals are excluded
- Extended fluid life can reduce maintenance and machine downtime
- Low foam in recommended water conditions (see details below)
- Excellent anti-corrosion properties to protect machine tools and parts
- Good wetting properties can help reduce coolant drag out and deliver clean machine tools and components

Typical Characteristics

	Test Method	Unit	Value
Concentrate			
Appearance	Visual		Amber
Mineral oil content	Calculated	Wt%	36
Emulsion			
Appearance	Visual		Transparent- Transluzent
pH (3%)	DIN 51369 ASTM E70-97		9.1
Refractometer Factor			1.1

Recommended Concentrations

Grinding	3-4 %
General Machining	4-6 %
Drilling	4-8%
Reaming and Tapping	5-10%

Water range 100 – 700 ppm CaCO₃

Additional Information

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

Storage

To avoid product deterioration, keep the container/drum tightly sealed always. Prevent any frost and water ingress. Store it in a cool and dry place away from direct sunlight. It is preferable to store the product indoors always. For more details, please refer the product safety data sheet.

Hysol R
16 May 2014
Castrol, the Castrol logo and related marks are trademarks of Castrol Limited, used under licence.

This data sheet and the information it contains is believed to be accurate as of the date of printing. However, no warranty or representation, express or implied, is made as to its accuracy or completeness. Data provided is based on standard tests under laboratory conditions and is given as a guide only. Users are advised to ensure that they refer to the latest version of this data sheet. It is the responsibility of the user to evaluate and use products safely, to assess suitability for the intended application and to comply with all applicable laws and regulations. Safety Data Sheets are available for all our products and should be consulted for appropriate information regarding storage, safe handling, and disposal of the product. No responsibility is taken by either BP plc or its subsidiaries for any damage or injury resulting from abnormal use of the material, from any failure to adhere to recommendations, or from hazards inherent in the nature of the material. All products, services and information supplied are provided under our standard conditions of sale. You should consult our local representative if you require any further information.

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

<http://msdspds.castrol.com>