



Product Data

Castrol Hysol GS BF

Semi-synthetic metalworking fluid

Description

Castrol Hysol™ GS BF is a semi-synthetic metalworking fluid formulated without boron for general machining and grinding for mass production. It contains an additive package that may help to enhance machining performance and surface finish. It provides excellent product stability and bio-resistance which helps to be lower the overall operational costs.

Hysol GS BF is suitable for large central systems and single sump machines

Application

Hysol GS BF is suitable for grinding and general machining for ferrous and aluminum alloys.

√√: suggested core application √: 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	√√	√√	√√			
Milling, Turning (general machining)	√√	√√	√			
Drilling	√√	√√				
Reaming, Tapping	√√	√				
Broaching	√√	√				

Advantages

- Formulated without boron help you to fulfil aspects of legislative requirements and waste treatment requirements
- Extended fluid life can help reduce maintenance and downtime
- Low foam in recommended water conditions
- Good wetting properties can help reduce coolant drag out and deliver cleaner machine tools and components

Typical Characteristics

Name	Method	Units	Hysol GS BF
Density @ 15C, Relative	ASTM D4052	g/ml	0.9557
Appearance, Concentrate before QS	Visual		Yellow Slight Hazy
pH, Distilled Water (5%)	ASTM D1293		10.02
Emulsion appearance, 5% in Water	Visual		Translucent milky
Refractometer Factor			1.21

Subject to usual manufacturing tolerances.

Recommended Concentrations

Grinding: 3-5%
General Cutting: 5-10%

Water range : 50 - 400 ppm CaCO₃

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