



Hysol MB 50

High performance soluble metalworking fluid

Description

Castrol Hysol™ MB 50 is a high performance soluble metalworking fluid which is formaldehyde releasing agent and chlorine-free. It contains an additive package that may help to enhance machining performance and surface finish. It also provides excellent product stability which helps to lower the overall operational 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.

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	Titanium alloys	Magnesium alloys	Yellow metals
Grinding	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		ü
Reaming, Tapping	ü ü	ü ü	ü	ü ü			ü
Broaching	ü ü	ü		ü			ü

Advantages

- Extended fluid life can help to reduce maintenance and downtime
- Low foam in recommended water conditions (see details below)
- Lubrication package designed to try to help enhance tool life and improve surface finish on aluminium, titanium and ferrous machining
- Good wetting properties can help to reduce coolant drag out and help deliver cleaner machine tools and components
- Suitable for a wide range of materials and applications provides opportunity for product consolidation
- Chlorine, formaldehyde releasing agent and nitrite free which help you to fulfil aspects of legislative requirements and waste treatment requirements where applicable

Typical Characteristics

Name	Method	Units	Value
Concentrate			
Appearance	Visual		Amber
Mineral oil content	Calculated	Wt%	50
Emulsion			
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 100-1000 ppm CaCO₃

Additional Information

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

Storage

All packages should be stored under cover. Where outside storage is unavoidable drums should be laid horizontally to avoid the possible ingress of water and damage to drum markings. Products should not be stored above 60°C, exposed to hot sun or freezing condition

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