



Hysol MB 50

High performance soluble metalworking fluid

Description

Castrol Hysol™ MB 50 is a high performance soluble metal working fluid, which is chlorine and formaldehyde releasing agent free. 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
Grinding	ü ü	ü ü	ü ü	ü ü	
Milling, Turning (general machining)	ü ü	ü ü ü	ü ü	ü ü ü	
Drilling	ü ü	ü ü	ü ü	ü ü	
Reaming, Tapping	ü ü	ü ü	ü	ü ü	
Broaching	ü ü	ü ü		ü ü	

ü ü ü : core application

ü ü : recommended application

ü : suggested application; please consult Castrol representative

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NB: Hysol MB 50 is not recommended for use with yellow metals.

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 CaCO₃

Additional Information

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

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