



## Product Data

# Castrol Hysol X™

Premium Semi Synthetic Cutting Oil

### Description

*Castrol Hysol X is a milky-type biostable EP soluble oil, based on solvent refined mineral oil. Castrol Hysol X contains a synthetic lubricity agent, chlorine free EP additives and special additives to protect against corrosion. It is based on materials, which are naturally resistant to bacterial attack.*

### Application

*Castrol Hysol X is designed for use in most production engineering applications. It is equally suitable (or large central systems) and (or small Individual coolant sumps). Castrol Hysol X is suitable for a very wide range of demanding machining operations, from milling, drilling, tapping and broaching to creep feed grinding, where it has outstanding performance at low concentration without foam or misting. Castrol Hysol X is ideal for machining centres and FMS systems where a range of operations is performed on a variety of different metals. Steels, cast irons and even difficult alloys such as stainless and high silicon aluminum can all be machined successfully. Castrol Hysol X can often replace neat oils without impairing performance, particularly where oil mist is a problem.*

### Advantages

- ◆ Gives excellent performance with low foaming properties particularly in naturally soft and pre-softened waters.
- ◆ Suitable for virtually all metals and most machining operations.
- ◆ Excellent machining 'performance with extended tool life'.
- ◆ Exceptional emulsion stability and long coolant life - Ideal for large central systems.
- ◆ Good extreme pressure properties and therefore suitable for severe applications such as broaching, creep lead grinding, tapping and reaming of difficult alloys such as stainless steel.
- ◆ Operator and environment friendly - free from chlorine, nitrites and phenols and based on solvent refined mineral oil.
- ◆ Non-aggressive to paints.
- ◆ Good corrosion prevention and non-staining.
- ◆ Compatible with seal materials commonly used in machine tools.

*All the above have been confirmed by extensive field trials over at least a two year period.*

Castrol Hysol X  
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All reasonable care has been taken to ensure that the information included in this publication is accurate as of the date of printing. However, such information may nevertheless be affected by changes in the blend formulation occurring subsequent to the date of printing. Material Safety Data Sheets are available for all Castrol India Limited products. MSDS must be consulted for appropriate information regarding storage, safe handling and disposal of a product

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## Product Data

Material	Cast Iron	Low Tensile Steel	High Tensile Steel	Stainless Steel	Heat Resistant Steel	Non Ferrous	Low Alloy Content Aluminium	High Alloy Content Aluminium
Operation								
Boring	3-5%	4-6%	4-6%	4-6%	4-6%	4-6%	5-10%	6-12%
Drilling	3-5%	4-8%	4.6%	4-6%	4-6%	4-6%	8-10%	6-12%
Grinding	3-5%	3-5%	3-5%	3-5%	3-5%	3-5%	5-10%	6-12%
Milling	3-5%	4-6%	4-6%	4-6%	4-6%	4-6%	5-10%	6-10%
Sawing	3-5%	5-10%	5-10%	5-10%	5-10%	6-12%	6-12%	6-12%
Screw Cutting	3.5%	5-10%	5-10%	5-10%	5-10%	6-12%	6-12%	6-12%
Tapping	3-5%	5.10%	5-10%	5-10%	5-10%	6-12%	6-12%	6-12%
Turning	3-5%	5-10%	5-10%	5-10%	5-10%	6-12%	6-12%	6-12%

## Characteristics

Characteristics	Typical Value
Appearance	Clear Brown Liq
pH, value 3% v/v in D.W.	9.2
Emulsion Type	Milky
Cast Iron Corrosion	Grade 0
Total Alkalinity % NaOH	4.5
Therm stability 48 hrs @50° c	Stable, No separation
Emulsion stability	Stable for 24 hrs
Foam test 3%	Foam Collapses with in 30 sec
Boron Content	1.1
Odour	Amined

*The above are typical figures and do not constitute a specification.*

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