



Product Data

Castrol Hysol MB 10 Semi-Synthetic Metalworking Fluid

Description

Castrol Hysol™ MB 10 is a semi-synthetic coolant recommended for light to medium-duty machining and grinding of all ferrous and aluminum alloys. Hysol MB 10 provides a clear performance edge over conventional soluble cutting fluids. Hysol MB 10 is chlorine and sulfur-free and provides a tight, stable emulsion that provides extended system life and product stability. Whether you are running a job shop and need trouble-free performance on a wide variety of metals and operations, or a continuous production operation that requires peak efficiency, long fluid life and low maintenance, Hysol MB 10 is the fluid to choose.

Applications

	Cast Iron	Low-medium alloyed Steel	High alloyed-stainless steel	Aluminum alloy	Magnesium alloy	Yellow metals
Grinding	✓	✓	C	C	-	-
Milling, Turning (general machining)	✓	✓	C	C	-	-
Drilling	✓	✓	C	C	-	-
Reaming, Tapping	-	-	-	-	-	-
Broaching	-	-	-	-	-	-

C – Consult with Application Engineers before recommending

Advantages

- Effective wetting properties maintains clean machines and components
- Stable fluid suitable for a wide range of water conditions
- Inhibits microbial growth to extend fluid life in central systems and individual sumps
- Low foaming in all water conditions
- Formaldehyde-free to comply with health and safety regulations

Characteristics

	Unit	Test Method	Value
Appearance of Concentrate	-	CN-TM-007	Slightly hazy yellow to amber liquid
Appearance of Dilution	-	CN-TM-007	Semi-Translucent
pH of Dilution	@ 5%	CN-TM-069	9.5
Specific Gravity	@ 60°F (16°C)	CN-TM-086	1.0
Bulk density	lbs/gal	-	8.32
Nitrites	-	-	No
Chlorine	-	-	No
Phenols	-	-	No

User advice

Castrol Hysol MB 10 is recommended for use in light to medium duty machining and grinding applications. Hysol MB 10 is compatible with ferrous and aluminum alloys. Not recommended for use in heavy duty applications

Systems using Hysol MB 10 should be maintained at a pH range of 8.8 – 9.3 by adding Balancer P3 if pH decreases. Maintenance of pH level is important to control biological activity of coolant system.

Concentration should be maintained at 5-10%. Addition of product concentrate in regular, standard additions will help maintain pH, bio-stability and additive levels.

Recommended Applications & Dilutions

Grinding: 5 - 6%

Machining: 6 - 10%

Additional Information

Concentration Control

Refractometer Reading

1.0

2.5

3.7

5.0

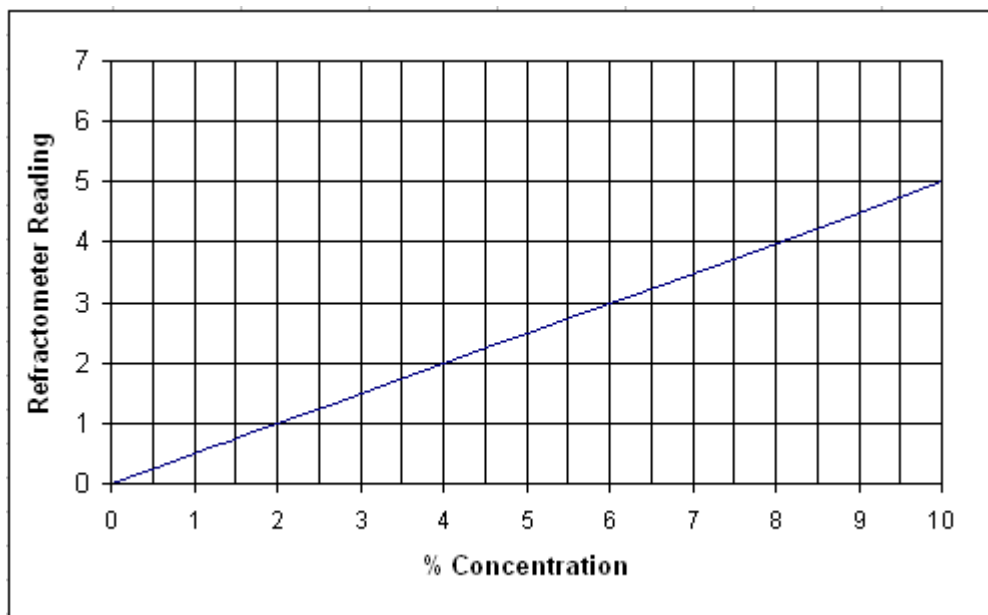
% Concentration

2.0

5.0

7.5

10.0



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Castrol Industrial North America Inc. 150 West Warrenville Road, 603 1E Naperville, IL 60563

Tel: (877) 641 1600 Fax: (877) 648 9801

www.castrol.com/industrial