



Hysol™ SL 35 XBB

High performance semi-synthetic metalworking fluid

Description

Castrol Hysol™ SL 35 XBB is a high performance semi-synthetic metalworking fluid which is boron, formaldehyde releasing agent and chlorine-free. It contains an additive package that provides excellent corrosion protection to machine tools and parts. It also provides excellent product stability which helps to lower the overall operational costs.

Hysol SL 35 XBB is suitable for large central systems and single sump machines.

Application

Hysol SL 35 XBB is especially designed for machining of cast iron and low-medium alloyed steel.

	Cast Iron	Low-medium alloyed steel	High alloyed - stainless steel	Aluminium alloys	Magnesium alloys	Yellow metals
Grinding	ü ü	ü ü	ü ü			
Milling, Turning (general machining)	ü ü	ü ü	ü			
Drilling	ü ü	ü ü				
Reaming, Tapping	ü ü	ü				
Broaching	ü ü	ü				

ü ü suggested core application ü possible application, please consult Castrol representative prior to use

Advantages

- Extended fluid life can help to reduce maintenance and downtime
- Low foam in recommended water conditions (see details below)
- Excellent anti-corrosion properties to protect machine tools and parts
- Good wetting properties can help to reduce coolant drag out and help deliver cleaner machine tools and components
- Boron free to meet boron free waste requirements where applicable
- 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	Hysol SL 35 XBB
Density @ 20C	CIP 501	g/ml	0.965 - 0.985
Appearance	Visual	-	Translucent to milky
pH @ 4%	ASTM E70-97	-	9.4 - 9.8
Viscosity @ 40C	ASTM D445	cSt	45 - 55

Recommended Concentrations

Grinding	4-6%
General Machining	6-10%
Drilling	6-8%
Reaming	6-10%
Broaching	6-10%

Water range 100-800 ppm CaCO₃

Concentration Control

Refractometer Factor = 1.1

To calculate the concentration of the diluted fluid, multiply the Refractometer reading by the factor to come up with the in use concentration.

Additional Information

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

Storage

To avoid product deterioration always keep the container/drum tightly sealed. Store the product in a cool, dry place away from direct sunlight. Prevent exposure to frost and avoid water ingress. For optimum product stability, it is preferable to store the product indoors between 5°C and 45 °C / 41°F and 113°F.

For more details, please refer to the product safety data sheet.

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06 Mar 2015
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