



Hysol™ 6510

High performance semi-synthetic metalworking fluid

Description

Castrol Hysol™ 6510 (previously called Clearedge™ 6510) is a semi-synthetic cutting and grinding fluid for ferrous metals. This fluid offers exceptional hard water stability and is designed for central system applications where long fluid life and cleanliness are key product attributes. Hysol 6510 eliminates many of the problems commonly associated with traditional semi-synthetic fluids.

It is formulated with innovative technology to provide long fluid life and stability. This technology results in significant inuse savings by reducing system recharges, make-up rates and additive purchases.

Application

Hysol 6510 is designed for grinding of steel and machining of low-medium alloyed steel and cast iron.

	Cast Iron	Low-Medium alloyed steel	High alloyed - Stainless steel	Aluminium Alloys	Magnesium Alloys	Yellow Metals
Grinding	ü ü	ü ü	ü			
Miling, Turning (general machining)	ü ü	ü ü	ü			
Drilling	ü	ü	ü			
Reaming, Tapping	ü	ü				
Broaching						

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

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
- Long system life can help to reduce maintenance and machine downtime
- Low foam in recommended water conditions
- Excellent wetting properties helps to reduce coolant drag out and deliver clean machine tools and components

Typical Characteristics

Name	Method	Units	Hysol 6510
Appearance	CN-TM-007	-	Clear Amber
Specific Gravity @ 15°C	CN-TM-084	g/ml	0.99 - 1.02
pH (5%) DI	CN-TM-069	-	9.3 - 9.8

Subject to usual manufacturing tolerances.

Recommended Concentrations

Grinding 4-5%
General Machining 5-8%

Water Range 50-600 ppm CaCO₃

Concentration Control

Refractometer Factor: 1.7

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	Chlorine	Nitrites
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 the product safety data sheet.

This product was previously called Clearedge 6510. The name was changed in 2015.

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