



Hysol™ 6519

High performance semi-synthetic metalworking fluid

Description

√√Castrol Hysol™ 6519 (previously called Clearedge™ 6519) is a high performance semi-synthetic metalworking fluid which is chlorine and formaldehyde releasing agent free. It is ideally suited for job shops that want a single fluid to machine a variety of metals.

Hysol 6519 is a clean product that provides dependable rancidity control when used in machine tools with individual sumps. However, the durable, longlasting qualities of this versatile cutting fluid also make it an excellent choice for extended use in central systems.

Hysol 6519 is suitable for large central systems and single sump machines.

Application

•Hysol 6519 is especially designed for grinding and machining of aluminium alloys and low-medium alloyed steel.

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

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

Conditions of Use

√

Advantages

- 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
- Unique multi-functional product for multi-metal operations results in product consolidation
- Versatile fluid suitable for a wide range of applications on multiple metals
- Extreme pressure lubrication extends tool life and improves finishes
- Low maintenance fluid minimizes hassles such as frequent additive additions

Typical Characteristics

Name	Method	Units	Hysol 6519
Appearance	CN-TM-007	-	Yellow to amber liquid
Specific Gravity @ 15°C (60°F)	CN-TM-084	-	0.991 - 1.011
pH, Deionized water, 5%	CN-TM-069	-	9.1 - 9.7

Subject to usual manufacturing tolerances.

Recommended Concentrations

Grinding	4-5%
General Machining	4-8%
Water Range	100-400 pm CaCO ₃

Concentration Control

Refractometer Factor = 1.4

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

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 6519. The name changed in 2015

Hysol™ 6519
29 Apr 2016
Castrol, the Castrol logo and related marks are trademarks of Castrol Limited, used under licence.

This data sheet and the information it contains is believed to be accurate as of the date of printing. However, no warranty or representation, express or implied, is made as to its accuracy or completeness. Data provided is based on standard tests under laboratory conditions and is given as a guide only. Users are advised to ensure that they refer to the latest version of this data sheet. It is the responsibility of the user to evaluate and use products safely, to assess suitability for the intended application and to comply with all applicable laws and regulations. Material Safety Data Sheets are available for all our products and should be consulted for appropriate information regarding storage, safe handling, and disposal of the product. No responsibility is taken by either BP plc or its subsidiaries for any damage or injury resulting from abnormal use of the material, from any failure to adhere to recommendations, or from hazards inherent in the nature of the material. All products, services and information supplied are provided under our standard conditions of sale. You should consult our local representative if you require any further information.

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