



## Hysol AMG

High performance soluble metalworking fluid

### Description

Castrol Hysol™ AMG is a chlorine-free, heavy duty, emulsifiable fluid for machining and grinding steel, cast iron, stainless steels, aluminum, titanium and copper alloys. This low foaming fluid is specifically formulated for use with naturally soft or softened waters while still maintaining emulsion stability in hard waters. The oily concentrate of Hysol AMG is easy to mix with water, forming a stable, milky white, non-foaming emulsion that helps protect machines and manufactured parts from rust and stain while resisting the development of rancid odors and fungus.

Hysol AMG provides heavy duty extreme pressure lubricity without the use of chlorinated ingredients, making it an excellent choice for a wide variety of machining and grinding applications. These include broaching, tapping, reaming, deep hole drilling, multi-tool operations on CNC machines, centerless grinding and creep-feed grinding.

### Advantages

- Exceptional resistance to foaming
- Acceptable for use in most machining and grinding operations on a wide variety of metals.
- Good extreme pressure and boundary lubricity extends tool life and promotes better surface finishes
- Compatible with most machine tool paints and seals, helps keep machines and parts clean and in good operating condition
- Excellent emulsion stability in hard waters up to 115 gpg (2000 ppm)
- User friendly with a pleasant, mild odor

### Typical Physical Characteristics

	Unit	Test Method	Value
Appearance of Concentrate	-	Visual	Yellow fluid, slightly hazy
Appearance of Emulsion	-	Visual	Milky, opaque
pH of Concentrate	-	CN-TM-069	8.9 – 9.3
pH of Emulsion	@ 5%	CN-TM-069	9.1 – 9.7
Specific Gravity	@60°F (16°C)	Cn-TM-086	0.95 – 0.97
Bulk Density	Lbs/gal	-	8.1

## Recommended Concentrations

Grinding	3%
General Machining	4-8%
Drilling	5-10%
Reaming and Tapping	5-12%
Broaching	5-12%

## Concentration Control

Refractometer Reading	% Concentration
3.0	3.0
5.0	5.0
7.0	7.0
10.0	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](http://www.castrol.com/industrial)