



Hysol MB 50

High performance soluble metalworking fluid

Description

Castrol Hysol™ MB 50 is a high performance soluble metal working fluid recommended for machining all grades of aluminum as well as ferrous alloys. Hysol MB 50 provides the performance of heavy duty soluble oils without the unpleasant shop environments and high usage rates of traditional fluids. Hysol MB 50 is chlorine, sulfur and formaldehyde releasing agent free. Its performance can exceed products which contain extreme pressure additives. The tight, stable emulsion of Hysol MB 50 provides extended system life and product stability.

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 varying hardness water conditions
- Formaldehyde releasing agent free to comply with health and safety regulations
- Specifically designed to provide superior performance on aerospace and automotive aluminum

Typical Physical Characteristics

	Unit	Test Method	Value
Appearance of Concentrate	-	Visual	Slightly hazy to amber
Appearance of Emulsion	-	Visual	Tight emulsion, stable
pH of Emulsion	-	CN-TM-069	9.3 – 9.8
Specific Gravity	@60°F (16°C)	Cn-TM-086	0.94 – 0.96
Bulk Density	Lbs/gal	-	7.91
Nitrites	-	-	None
Chlorine	-	-	None
Phenols	-	-	None

Recommended Concentrations

Grinding: 3 - 5%*

Machining: 5 - 10%

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

*Systems using Hysol MB 50 should be maintained at a pH range of 8.8 – 9.3. Maintenance of pH level is important to control biological activity of coolant system.

Concentration Control

Refractometer Reading	% Concentration
3.1	3.0
5.1	5.0
7.1	7.0
10.1	10.0

Additional Information

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

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