



Hysol 21 BF

High performance semi-synthetic metalworking fluid

Description

Castrol Hysol® 21 BF (previously called Product™ WA 0073 6510BF) is a high performance semi-synthetic metalworking fluid formulated without chlorine, formaldehyde releasing agent and boron. 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 21 BF is suitable for large central systems and single sump machines.

Application

Hysol 21 BF is especially designed for machining of cast iron and low-medium alloyed steel.

	Cast Iron	Low-medium alloyed steel	High alloyed - stainless steel	Aluminum 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 ü				
Broaching	ü ü	ü ü				

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

Advantages

- Boron free to meet waste treatment requirements
- Chlorine, formaldehyde releasing agent and nitrite free which may help you to fulfill aspects of legislative and waste treatment requirements that specify that these chemicals are excluded
- 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

Typical Characteristics

Name	Method	Units	Hysol 21 BF
Specific Gravity @ 15.6°C	CN-TM-084	g/cm ³	0.98 - 1.01
pH, Deionized water, 5%	CN-TM-069	-	9.2 - 9.8

Subject to usual manufacturing tolerances.

Recommended Concentrations

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

Preferred water hardness for optimum operation 50-600 ppm CaCO₃

Concentration Control

Refractometer Factor = 1.6

To calculate the concentration of the diluted fluid, multiply the Refractometer BRIX reading by the factor to come up with the inuse 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 the product safety data sheet.

This product was previously called Product WA 0073 6510BF. The name was changed in 2015.

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