



# Hysol™ 6754

High performance soluble metalworking fluid.

## Description

Castrol Hysol™ 6754 (previously named Superedge™ 6754) is a high performance soluble metalworking fluid which is formaldehyde releasing agent, boron and chlorine free. It contains an additive package that works in synergy to enhance machining performance and surface finish, provide excellent product stability, improve bio-resistance properties and lower the overall operations costs.

Hysol 6754 is suitable for large central systems and single sump machines.

## Application

Hysol 6754 is especially designed for machining of aluminium alloys. The product can also be used for machining of ferrous and other non-ferrous metals.

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

- Formaldehyde releasing agent free to comply with health and safety regulations
- Chlorine, boron and nitrite free to fulfill your local legislation, waste treatment and environmental requirements.
- Robust product with extend fluid life and reduce maintenance and machine downtime
- Low foam in recommended water conditions
- Lubrication package specifically designed to enhance tool life and improve surface finish in aluminium machining
- Excellent wetting properties reduce coolant drag out and deliver clean machine tools and components
- Multi-functional product for multi-metal operations results in product consolidation

## Typical Characteristics

Name	Method	Units	Hysol 6754
Appearance	CN-TM-007	-	Slight Amber Hazy fluid
Specific Gravity @ 15°C	CN-TM-084	-	0.92 - 0.945
pH, Deionized water, 5%	CN-TM-069	-	9.4 - 10.4

Subject to usual manufacturing tolerances.

## Recommended Concentrations

Grinding	4-6%
General Machining	5-7%
Drilling	6-8%
Reaming and tapping	7-9%
Broaching	8-10%
Water range	100-600 ppm CaCO <sub>3</sub>

## Concentration Control

Refractometer factor = 1.0

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	EP-Ester	Amines	Chlorine
<b>Additives</b>	-	-	ü	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 named Superedge 6754. The name was changed in 2015.**

Hysol™ 6754  
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