



Hysol SL 45 XBB

High performance soluble metalworking fluid

Description

Castrol® Hysol® SL 45 XBB is a high performance soluble metalworking fluid which is formulated without boron, biocides, formaldehyde releasing agents and chlorine. It contains an additive package that may help to enhance machining performance and surface finish. It also provides good product stability which helps to lower the overall operational costs.

Hysol SL 45 XBB is suitable for large central systems and single sump machines.

Application

Hysol SL 45 XBB is especially designed for machining of aluminum and titanium alloys in aerospace industry. The product can also be used for machining of ferrous alloys.

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

	Cast Iron	Low-medium alloyed steel	High alloyed - stainless steel	Aluminum alloys	Magnesium alloys	Yellow metals
Grinding	ü	ü ü	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		ü
Reaming, Tapping	ü	ü ü	ü	ü ü		ü
Broaching	ü	ü	ü	ü ü		ü

Advantages

- Formulated without chlorine, formaldehyde releasing agents and nitrite which may help you to fulfill aspects of legislative requirements and waste treatment requirements that specify that these chemicals are excluded
- Extended fluid life can help reduce maintenance and machine downtime
- Low foam in recommended water conditions (see details below)
- Lubrication package designed to try to help to enhance tool life and improve surface finish on aluminium machining
- Good wetting properties can help reduce coolant drag out and help deliver cleaner machine tools and components
- Suitable for a wide range of materials and applications provides opportunity for product consolidation

Typical Characteristics

	Test Method	Value
Concentrate		
Appearance	Visual	Amber
Specific Gravity at 15.6 °C	ASTM D 4052	0.94 - 0.96
Emulsion		
Appearance	Visual	milky
pH (5% DI water)	CN-TM-069	9.1 - 9.5
Refractometer Factor	multiplier	1.1

Subject to usual manufacturing tolerances.

Recommended Concentrations

Grinding	5-7%
General Machining	6-8%
Drilling	7-9%
Reaming and tapping	8-10%
Broaching	8-10%

Water range 100-800 ppm CaCO₃

Additional Information

	Boron	Formaldehyde releasing agent	EP-Ester	Amines	Chlorine
Additives			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.

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