

Castrol Hysol 3505

High performance semi-synthetic metalworking fluid

Description

Castrol Hysol™ 3505 is a high performance chlorine free semi-synthetic metalworking fluid. It contains a unique 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 3505 is suitable for large central systems and single sump machines.

Application

Hysol 3505 is especially designed for machining of cast iron and low-medium alloyed steel.

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

Advantages

- Chlorine and nitrite free to fulfill your local legislation, waste treatment and environmental requirements
- Resists fungal and bacterial attack to extend fluid life and reduce maintenance and machine downtime
- Low foam in recommended water conditions
- Excellent anti-corrosion properties to protect machine tools and parts
- Advanced lubricity compounds ensure improved tool life and part quality
- Excellent wetting properties reduce coolant drag out and deliver clean machine tools and components

Typical Characteristics

	Test Method	Unit	Value
Concentrate			
Appearance	Visual		Amber
Mineral oil content	Calculated	Wt%	28
Emulsion			
Appearance	Visual		Transparent
pH (5%)	DIN 51361 ASTM E70-97		9.4
Refractometer Factor			1.3

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

Recommended Concentrations

Grinding	4-6%
General Machining	5-7%
Drilling	6-8%
Reaming and tapping	6-8%
Broaching	6-8%
Water range	20-200 ppm CaCO ₃

Storage

To avoid product deterioration, keep the container/drum tightly sealed always. Prevent any frost and water ingress.

Store it in a cool and dry place away from direct sunlight. It is preferable to store the product indoors always. For more details, please refer the product safety data sheet.

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