



Product Data

Hysol™ 6519

High performance semi-synthetic metalworking fluid

Description

✓✓ Castrol Hysol™ 6519 (previously called Clearedge™ 6519) is a high performance semi-synthetic metalworking fluid which is chlorine and formaldehyde releasing agent free. It is ideally suited for job shops that want a single fluid to machine a variety of metals.

Hysol 6519 is a clean product that provides dependable rancidity control when used in machine tools with individual sumps. However, the durable, longlasting qualities of this versatile cutting fluid also make it an excellent choice for extended use in central systems.

Hysol 6519 is suitable for large central systems and single sump machines.

Application

• Hysol 6519 is especially designed for grinding and machining of aluminium alloys and low-medium alloyed steel.

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

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

Conditions of Use

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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
- Unique multi-functional product for multi-metal operations results in product consolidation
- Versatile fluid suitable for a wide range of applications on multiple metals
- Extreme pressure lubrication extends tool life and improves finishes
- Low maintenance fluid minimizes hassles such as frequent additive additions

Typical Characteristics

Name	Method	Units	Hysol 6519
Appearance	CN-TM-007	-	Yellow to amber liquid
Specific Gravity @ 15°C (60°F)	CN-TM-084	-	0.991 - 1.011
pH, Deionized water, 5%	CN-TM-069	-	9.1 - 9.7

Subject to usual manufacturing tolerances.

Recommended Concentrations

Grinding 4-5%
General Machining 4-8%
Water Range 100-400 ppm CaCO₃

Concentration Control

Refractometer Factor = 1.4

To calculate the concentration of the diluted fluid, multiply the Refractometer reading by the factor to come up with the in-use concentration.

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 Clearedge 6519. The name changed in 2015

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