

Hysol EM 400

High performance Oil Phase-Multipack Soluble Metalworking Fluid

Description

Castrol Hysol™ EM 400 is the oil phase of the innovative Castrol Multipack metalworking fluid system. Castrol Multipack combines the effectiveness of advanced metalworking fluid performance with the efficiency to manage fluid systems for maximum sump life. Hysol EM 400 is the vegetable oil phase containing advanced lubricity components to ensure improved tool life and part quality. It is used in conjunction with Boost WP Series which are the available water phases containing fluid management components to ensure bacteria control, pH stability and corrosion protection. Castrol Multipack technology allows for variable concentrations of each phase depending on severity of operation. In addition, lower fluid make-up costs are achieved as only depleted components are added back to the metalworking fluid system.

Application

Multi-pack vegetable oil base for machining of steel and aluminium alloys. It should be used only in combination with Boost WP water phase.

	Cast Iron	Low-medium alloyed steel	High alloyed - stainless steel	Alu alloys	Magn alloys	Ye
Grinding	ü	ü ü	ü ü	ü ü		
Milling, Turning (general machining)	ü	ü ü ü	ü ü ü	ü ü ü		
Drilling	ü	ü ü ü	ü ü ü	ü ü ü		
Reaming, Tapping	ü	ü ü ü	ü ü ü	ü ü ü		
Broaching				ü ü ü		

Advantages

- Chlorine and nitrite free to fulfill your local legislation, waste treatment and environmental requirements
- Improved environmental compliance with the use of renewable, vegetable oil technology
- Advanced lubrication to extend tool life and improve part finish
- Versatile fluid suitable for a wide range of applications on multiple metals
- Excellent stability in recommended water conditions
- Excellent foam control
- Developed specifically for Castrol Carelube lubrication technology

Typical Characteristics

Name	Method	Units	Value
Concentrate			
Appearance	Visual		Amber
Mineral oil content	Calculated	Wt%	0
Emulsion (4% Hysol EM 400 + 2% Boost WP Series)			
Appearance	Visual		Milky
pH	DIN 51369 ASTM E70-79		9.3

Recommended Concentrations

Grinding	1-3% Hysol EM 400	+ 1.5-2.0% Boost WP Series
Machining	4-8% Hysol EM 400	+ 1.5-2.0% Boost WP Series
Water range	100-300 ppm CaCO ₃	

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