

| MATERIAL | DRILLING & BORING | REAMING | TAPPING & THREADING | MILLING | TURNING | GRINDING |
|---|--|----------------------------------|---------------------------------|--|--|---------------------------|
| Steel, mild, free cutting | Soluble oil Mineral oil | Soluble oil min + lard oil | Soluble oil lard oil | Soluble oil min + lard oil | Soluble oil Mineral oil | Soluble oil water soda |
| Steel, tool High carbon High speed | Soluble oil Mineral oil Min + lard oil | Soluble oil Min + lard oil | Lard oil Sulph min oil | Soluble oil Min + lard oil Sulph min oil | Soluble oil Mineral oil Min + lard oil | Soluble oil water soda |
| Steel, alloy Forgings | Soluble oil Min + lard oil | Soluble oil Min + lard oil | Min + Lard oil Sulph min oil | Min + lard oil | Soluble oil Min + lard oil | Soluble oil water soda |
| Brass | Soluble oil Min + lard oil | Min + lard oil Kero + min oil | Mineral oil Min + Lard oil | Soluble oil or Dry | Soluble oil Mineral oil or Dry | Soluble oil water soda |
| Bronze | Soluble oil or Dry | Soluble oil or Dry | Soluble oil Min + lard oil | Soluble oil or Dry | Soluble oil Min + lard oil | Soluble oil water soda |
| Copper | Soluble oil | Soluble oil | Soluble oil Lard oil | Soluble oil or Dry | Soluble oil Min + lard oil | Soluble oil water soda |
| Aluminium | Sulph min oil Kero + min oil | Sulph min oil or Dry | Lard oil Kero + min oil | Soluble oil or Dry | Soluble oil Sulph min oil | Soluble oil Kerosene |
| Magnesium * | Mineral oil ONLY | Mineral oil ONLY | Mineral oil ONLY | Mineral oil ONLY | Mineral oil ONLY | Mineral oil ONLY |
| Iron castings malleable | Soluble oil Sulph min oil | Soluble oil | Soluble oil Lard oil | Soluble oil | Soluble oil Min + lard oil | Soluble oil water soda |
| Cast iron | Dry | Dry | Dry Lard oil | Dry | Dry | Soluble oil |

*** Magnesium:** DO NOT USE any coolant containing water as this will result in FIRE.
MINERAL OIL is the **ONLY** safe coolant