



CALLINGTON METAL WORKING FLUIDS SELECTION CHART

Product Name	Fluid Type	Applications									Materials						
		sawing	milling	drilling	deep hole drilling, gun drilling	tapping, threading	turning	broaching, reaming	cylindrical & surface grinding	centreless grinding	stainless steel	low carbon steel	high carbon steel, tool steel, mould steel	cast iron	wrought aluminum alloy, milling light duty	cast aluminum alloy	yellow metals: copper, brass
water miscible cutting & grinding fluids																	
U/S971LF	F Synthetic	>5%	>5%	>5%	>10%	>10%	7-10%	>10%	3-5%	3-5%							
GC100	F Synthetic	>5%	>5%	>5%	8-10%	8-10%	7-10%	>10%	3-5%	3-5%							
AC985	Semi Syn	>5%	>5%	>5%	8-10%	10%	8-10%	>10%	3-5%	3-5%							
AL400	Hi Oil Semi Syn	>5%	>5%	>5%	6-10%	6-10%	6-10%	6-10%									
EP M2	Hi Oil Semi Syn	>5%	>5%	>5%	6-10%	6-10%	6-10%	6-10%	3-4%	3-4%							
CU500	Soluble Oil	>5%	>5%	>5%	6-8%	6-8%	6-8%	8-9%	3-4%	3-4%							
MS500	Semi Syn	>5% mist	>5% mist	>5% mist													
water miscible grinding fluid																	
PGF256	F Synthetic								2-3%	4-6%							
non water miscible grinding fluid																	
PG580	Synthetic Oil																

excellent
 suitable
 might be suitable
 not suitable

Note: U/S971LF and MS500 is only suitable for Australia and other areas that have very soft water