

TECHNICAL DATA SHEET

CALCOOL S4

Code 7801

High Performance Soluble Metal Working Fluid

DESCRIPTION

Callington Calcool S4 is a high performance, chlorinated soluble metal working fluid. It is formulated to provide excellent machining performance and surface finish, through the use of a unique blend of extreme pressure additives and corrosion inhibitors.

The product provides excellent product stability and bio resistance, to provide consistent process operation, at a reasonable cost.

APPLICATION

Callington Calcool S4 is a general purpose EP soluble coolant formulated to meet the requirements of a wide range of machining applications, including general machining, drilling, reaming and tapping.

Callington Calcool S4 is suitable for machining cast iron, ferrous alloys and non ferrous alloys including aluminium alloys.

BENEFITS

- Versatility, multi metal compatible and suitable for use in a range of machining operations. Ideal for small to medium workshops, offers potential for product rationalisation.
- Stable, low scumming performance in hard water environments, providing cleaner working conditions.
- Low foam performance in soft water conditions, eliminating use of antifoams and reducing maintenance costs.
- Effective biocide system, to prevent bacterial degradation, and extend coolant life.

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RECOMMENDED DILUTIONS

Material	Cast Iron	Low-Medium Alloy Steel	Stainless Steel	Aluminium Alloys	Yellow Metals
Operation	4%	4%	4%	4%	4%
Grinding					
Milling					
Turning	4%	4%	4%	6%	6%
Boring					
Drilling	4%	4 - 6%	5 - 6%	4 - 8%	4 - 8%
Deep Hole Drilling					
Reaming	7%	7%	7%	8%	8%
Tapping					

TYPICAL DATA (note: data is typical and does not constitute a specification).

Concentrate	Test Method	Typical Result
Appearance	Visual	Amber Fluid
Density @ 30°C	DIN 51757/ASTM D1298	0.89
Emulsion		
Appearance	Visual	Milky, White
pH5%	DIN 51361/ASTM E70-97	9.35
Refractometer Factor		1

STORAGE

Keep container closed, prevent exposure to frost, and prevent water ingress. Store in cool, dry conditions, and avoid direct sunlight. Indoor storage is preferable.

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