

TECHNICAL DATA SHEET

Calcool S1

Code 7802

General Purpose Soluble Metal Working Fluid

DESCRIPTION

Callington Calcool S1 oil is a chlorine and boron free, general purpose soluble metal working fluid.

Its high mineral oil content and unique additive package provides excellent lubrication properties, forming a milky type emulsion, it provides consistent performance in a wide range of water types.

APPLICATION

Callington Calcool S1 is suitable for use in small to medium general machine shops, where general machining operations, on a range of materials, requires a stable product, offering versatility at a reasonable cost.

Callington Calcool S1 is particularly recommended for the machining of low – medium alloy steels and aluminium alloys. It is non staining to aluminium alloys

Recommended water range is 50ppm- 400ppm hardness as CaCO₃

BENEFITS

- Versatility, multi metal compatible. 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.
- Boron free for environmental compliance and reduced residue characteristics.
- Chlorine, phenol and nitrite free, meeting local legislation, waste treatment and environmental requirements.

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RECOMMENDED DILUTIONS

Material	Low-Medium Alloy Steel	High Alloy Steel	Aluminium Alloys
Operation			
Turning	4 - 5%	5%	5%
Milling			
Boring			
Drilling			
Sawing	4%	4%	4%
Tapping	7%	8 - 10%	7%
Threading			

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

Concentrate	Test Method	Typical Result
Appearance	Visual	Amber Fluid
Density	DIN 51757/ASTM D1298	0.876
Emulsion		
Appearance	Visual	Milky, White
pH5%	DIN 51361/ASTM E70-97	9.3
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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