

TECHNICAL DATA SHEET

CALCOOL S1

General Purpose Soluble Metal Working Fluid

Code 7802

DESCRIPTION

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

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

FEATURES & 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.



APPLICATION

Callington Calcool S1 is suitable for use in small to medium general machine shops, where general machining operations, on a range of materials, require 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.

The recommended water range is 50ppm- 400ppm hardness as CaCO₃.

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RECOMMENDED DILUTIONS

Material	Low Medium Alloy Steel	High Alloy Steel	Aluminium Alloys
Operation	5%	4-5%	5%
Turning			
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

ORDERING INFORMATION

Product Code	Packaging
7802/51	20 litres
7802/64	200 litres

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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