



MACHINING FLUIDS

All listed products do not contain any nitrite compounds.

EMULSIFIABLE/SOLUBLE OILS

PRODUCT	USAGE CONCENTRATION (% By Volume)		Drawing	FEATURES/APPLICATIONS
	GRINDING	MILLING, BORING & TURNING		
DART 141	3 – 4	10 – 20	-	Premium quality for light-to-moderate duty machining.
DRAW-GARD 1010	-	-	3 - 100	High quality drawing compound for heavy-duty operations. Has excellent lubricity. Can be used on ferrous metals, and provides sufficient lubricity for off set expansion of stainless steel.
SOLUBE 1204	3 – 5	5 – 10	-	Superior quality with excellent lubricity for use on a wide variety of metals (ferrous, aluminum, cuprous alloys).

SEMI-SYNTHETIC

PRODUCT	USAGE CONCENTRATION (% By Volume)		FEATURES/APPLICATIONS
	GRINDING	MILLING, BORING & TURNING	
SEMILUBE 1295	2 – 5	5 – 8	High degree of lubricity with excellent wetting and cooling properties. Good corrosion protection. For use on ferrous, aluminum and stainless steel.

SYNTHETIC/WATER-BASED

These products have rust preventive properties. Consult Product Data Sheet for use conditions.

PRODUCT	USAGE CONCENTRATION (% BY VOLUME)	FEATURES/APPLICATIONS
BIOLUBE HV	5 - 50	Excellent, synthetic drawing compound. Provides excellent lubricity for moderate drawing operations. Is fatty acid soap based.
SYNLUBE 21	3 – 10	General purpose synthetic lube for grinding, milling, turning, and rolling. For use on ferrous and aluminum alloys.
SYNLUBE EP-GM	2-8	Synthetic lube for use in extreme pressure applications, and with a variety of metals including ferrous, aluminum, and cuprous alloys, including leaded brass.
SYNLUBE EP-201	3 - 10	Specially designed synthetic for granite and stone cutting operations.
STARCOOL	0.5 - 5	Versatile grinding fluid in the optical industry for glass and plastic.

VANISHING OILS

These products have rust preventive properties. Consult Product Data Sheet for use conditions.

PRODUCT	(°F. TCC)	EVAPORATION RATE (n-Bu acetate = 1)	FEATURES/APPLICATIONS
VANISHING OIL K	103	0.20	More capable version of VANISHING OIL N with additional lubricity.
VANISHING OIL N	103	0.20	Aliphatic hydrocarbon that leaves virtually no residue. Typically used in forming or machining of aluminum.
VANISHING OIL H	120	<0.1	Aliphatic hydrocarbon optimized for low odor in work area.

Written data is for typical applications. Please consult your Madison Chemical Company representative for your specific application.