



## High Performance Coolants and Cutting Oils

- Provides outstanding performance
- Low odor
- Long lasting
- High quality standards results in consistent reliable performance
- No disproportionate depletion of additives so none are required
- Safe for people who use it and for the environment
- Reach compliant
- Available in 5 gallon pails, 55 gallon drums or totes. When ordering, specify quantity in gallons, 5 gallon minimum



### Coolants

Part #	Item #	Material Compatibility					
		Aluminum Alloys	Carbon Steel	Magnesium Alloys*	Nickel Alloys	Stainless Steel	Titanium
RC1000	1	●●	●	●	●●	●●	●
RC1500	2	●●	●	●	●●	●●	●
RC2000	3	●	●●	●	●	●	●
RC2500	4	●●	●	●	●	●	●
RC2500 Heavy	5	●	●	●	●●	●●	●●

● = Recommended ●● = Highly Recommended

\* As with all magnesium, extreme caution must be maintained when using water based fluids

### Cutting/Machining Oils

Part #	Item #	Stock Diameter			Material Compatibility					
		<0.25"	0.25-0.75"	>0.75"	Brass	Carbon Steel	Copper	Nickel Alloys	Stainless Steel	Titanium
RO22	6	●●	●●	●●	●●	●●	●●	●	●●	●
RO20BC	7	●●	●●	●●	●●	●	●●	●	●	●
RO412	8	●●	●	●	●●	●●	●●	●●	●●	●●
RO428	9	●	●●	●	●	●●	●	●●	●●	●●
RO840	10	—	●	●●	●●	●	●	●●	●●	●●

● = Recommended ●● = Highly Recommended

### Grinding Oils

Part #	Item #	Stock Diameter			Material Compatibility					
		Flute	Edge	Surface Profile	Carbide	Ceramic	Cement	CBN	PCD	HSS
RG7	11	●●	●●	●●	●●	●●	●●	●●	●●	●●

● = Recommended ●● = Highly Recommended



**Coolant Concentration/Mixing Ratios**

Part #	Actual %*	General Purpose Machining		Heavy Machining	
		Start up	Top Off	Start up	Top Off
RC1000	RR x 1.0	10% mixing ratio = 10% RR	6% mixing ratio = 6% RR	14% mixing ratio = 14% RR	8% mixing ratio = 8% RR
RC1500	RR x 1.0	10% mixing ratio = 10% RR	6% mixing ratio = 6% RR	14% mixing ratio = 14% RR	8% mixing ratio = 8% RR
RC2000	RR x 1.82	6% mixing ratio = 3.5% RR	2% mixing ratio = 1% RR	10% mixing ratio = 5.5% RR	3% mixing ratio = 2% RR
RC2500	RR x 1.89	6% mixing ratio = 3.5% RR	2% mixing ratio = 1% RR	10% mixing ratio = 5.5% RR	3% mixing ratio = 2% RR
RC2500 Heavy	RR x 2.10	8% mixing ratio = 4% RR	2% mixing ratio = 1% RR	12% mixing ratio = 5.5% RR	3% mixing ratio = 1.5% RR

\*RR = Refractometer Reading

