

Cutting Fluids Recommendations

Workpiece material	Abrasive	Grinding operation		Cutting Fluid Recommendation	Water % Content	Remarks
			Reciproca Creepfeed			
Carbide Carbide + Steel Ceramics Spray-on alloys with high tungsten carbide content	Diamond	X		Emulsion	98...95	
			X	Emulsion Fully synthetic solution Semi-synthetic solution (synthetic+ oil)	95...90 98...97 98...97	
HSS Chromium Steel Spray-on alloys	CBN	X		Emulsion Fully Synthetic solution Semi-synthetic solution (synthetic+ oil)	98...95 97...95 97...96	
			X	Fully Synthetic solution Semi-synthetic solution (synthetic+ oil)	97...96 97...96	
Long-chipping steel grades, e.g. 100Cr6, 16MnCr5 specialty materials e.g. WASPALOY Inconel, Nimonic etc	CBN	X	X	Emulsion	95...80	
				Mineral Oil, if necessary with EP additives		Extraction necessary