



## Cooling and cutting oils for reaming

<b>Material to machine</b>	<b>Reaming</b>
Tool steels	Diluted soluble oil
Alloyed steels	Diluted soluble oil, cutting oil
Stainless and heat resistant steels	Bore oil, cutting oil
Cast iron steels	Diluted soluble oil
Grey cast iron	Dry
Chilled cast iron	Diluted soluble oil
Malleable cast iron	Dry, diluted soluble oil
Brass	Dry, diluted soluble oil
Bronze	Dry, diluted soluble oil
Copper	Diluted soluble oil
Red cast iron	Dry, Diluted soluble oil
Aluminium	Diluted soluble oil, petroleum
Plastic	Dry