

MATERIAL	DRILLING	MILLING	TAPPING	TURNING
Aluminum	Soluble oil (70-90% water)	Soluble oil (96% water) or mineral oil	25% sulfur-based oil mixed with mineral oil	Mineral oil with 10% fat or soluble oil
Alloy Steel	Soluble oil	10% lard oil with 90% mineral oil	30% lard oil with 70% mineral oil	25% sulfur base oil with 75% mineral oil
Brass	Soluble oil	Soluble oil (96% water)	10-20% lard oil with mineral oil	Mineral oil with 10% fat or soluble oil
Bronze	Soluble oil	Soluble oil	30% lard with mineral oil	Soluble oil
Cast Iron	Dry	Dry	Dry or 25% lard oil with 80% mineral oil	Dry
Copper	Soluble oil	Soluble oil	Soluble oil	Soluble oil
Low Carbon & Tool Steels	Soluble oil	Soluble oil	25-40% lard oil with mineral oil	25% lard oil with 75% mineral oil
Malleable Iron	Soluble oil	Soluble oil	Soluble oil	Soluble oil