

Coolant Selector Guide

Product	Multi-Metal Machining					Product In-Use Stability					Comments
	Aluminum Machining (and Other Soft Metals)	Steel Machining (and Other Hard Metals)	Targeted Machining Severity	Meets Boeing BAC-5008	Non-Staining on Non-Ferrous Metals	Extended Sump-Life	Hard Water Compatibility	Acceptable Residues	Tamp Oil Rejection		
High Oil Semi-Synthetic Fluids (≥ 15% oil content)											
KOOLite™ 2270	**	**	Moderate - Light		Y	***	*****	*****	***	Extremely good general purpose machining fluid. Ideal for high coolant loss applications.	
KOOLite™ 2290	***	***	Heavy - Moderate	Y	Y	***	*****	*****	***	Excellent multi-metal machining fluid. Ideal for the aerospace market.	
KOOLite™ 2295 MAX	*****	*****	Heavy		Y	***	*****	*****	***	Excellent multi-metal machining fluid with additional lubrication built-in to give a boost to tool-life during more difficult operations and metals.	
KOOLite™ 2375 MAX	*****	*****	Severe		Y	***	*	*****	***	Top-tier product in machining performance. Used where maximizing productivity is the key objective.	
Low Oil Semi-Synthetic Fluids (< 15% oil content)											
Chip Rite 411	***	***	Moderate - Light		Y	***	*****	*****	***	Robust general purpose machining fluid with a good balance of cooling and lubrication.	
Full Synthetic Fluids (0% oil content)											
SynMAX™ 2505	***	***	Moderate	Y	Y	*****	*****	***	****	Best where coolant losses are high and machining operations are moderate.	
SynMAX™ 2515	*****	*****	Heavy - Moderate	Y	Y	*****	*****	***	****	Excellent multi-metal machining product that provides the same boost of performance on both aluminum and steel with zero oil content.	
SynMAX™ 2525	*****	*****	Severe	Y	Y	*****	*****	***	****	Maximum in machining performance. Ideal where severe duty machining and high productivity is the key objective and zero oil content is desired.	
Chip Rite 606	***	*	Moderate - Light		Y	**	*****	*	*****	General purpose machining fluid designed to offer robust performance on Aluminum.	
Chip Rite 605	*	***	Moderate - Light		N	**	*****	*	*****	General purpose machining fluid designed to offer robust performance on Steel.	
Emulsifiable Oil											
Chip Rite 215	***	****	Heavy - Moderate		Y	*	****	****	**	Great multipurpose emulsifiable oil providing lubrication and finishes on multi-metals and operations.	