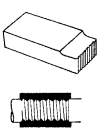

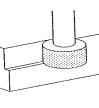
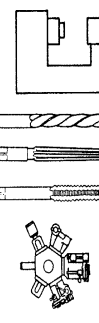
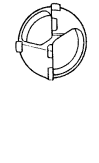
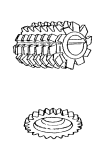


Yuma Recommendation Standard

Material Groups		Type of Cut	Low - Medium Carbon Free Machining Steels	Low Alloy Structural Steels	Stainless Steels	Cast Iron	Aluminum & Alloys	Copper & Alloys
	Tapping	Chasing	HEC-30	HEC-30	HEC-30	EX-90	EX-90	NO.2
		Single Point Thread Cutting	HEC-30	HEC-30	HEC-30	EX-90	EX-90	
	Tapping	Threading	NO.3	DS-50	UB-100	NO.3	NO.2	
		Threading	NO.7	UX-10	UX-10			
	Honing		SC-870C	SC-870C		SC-870C		
			SF-45H	SF-45H	SF-45H	SF-45H		
	Gear Shaving	G-55	G-55					
	Super Finish	SF-36	SF-36	SF-36		SF-36		
	Cylindrical Grinding		SC-56T	SC-56T	EX-90	SC-56T	MIC-16K	
			SC-56T	SC-56T	EX-90	SC-56T	MIC-16K	
	Internal Grinding		S-83F	S-83F	HSG300	SC-870C	MIC-16K	
			SC-870C					
Center less Grinding		SC-56T	SC-870C	S-83F	SC-56T	MIC-16K		
		SC-870C	SC-830C	SC-870C				
Paper Lapping		SC-870C	SC-870C	SC-870C	SC-870C			
		CL-5	CL-5	CL-5	CL-5			
	CNC Lathe Machining Center Drilling Reaming Tapping		EC-63	EC-63	HEC-30	EC-63	EC-63	NO.2
			EX-90	EX-90		SC-830C	MIC-16K	
			SC-830C	HEC-30		SC-870C	EX-90	
			SC-870C	SC-830C			MIC-3	
	Transfer Machine		NO.3	NO.3	DS-50	NO.3	NO.2	NO.3
			EC-63	HEC-30		MIC-3	EC-63	
	Multi-Spindle Lathe Machine		NO.3	DS-50	DS-50	NO.3	NO.2	
			EX-90	HEC-30	HEC-30	MIC-3	EX-90	
Swiss Type Lathe Machine		NO.3	G-30	UB100		NO.2	NO.2	
		UX-10	UX-10	UX-10				
	Drilling		MIC-3	MIC-3	HEC-30	MIC-3	EC-63	NO.2
			SC-830C	SC-830C		SC-830C		
	Reaming		NO.2	NO.3	DS-50	NO.2	NO.2	NO.2
			HEC-30	HEC-30		MIC-3	EX-90	
	Tapping							NO.3
			HEC-30	HEC-30		MIC-3	EX-90	
	Milling		DS-50	TS-50	UB-100	UB-100	UB-100	NO.3
			EX-90	EX-90	HEC-30	EX-90	EX-90	NO.3
Milling		NO.3	UL-65	UB-75B	NO.3	NO.3	NO.2	
	High-Speed Hobbing			HEC-30				
	Gear Cutting Lapping					HEC-30		
			GLDO-320Z	GLDO-320Z	GLDO-320Z	GLDO-320Z		
	Gear Shaping			UB-75B				
			NO.7	NO.8				
Gear Shaving	DS-50	UB-75B						
Broaching					EX-90	EX-90		
		UB-100	BX-45	BX-1545H				
Chain Broaching	UB-100	UB-100						

General Purpose Recommendations

- EC-63** **Emulsion**
- KC-770T** **Soluble Synthetic**
- MIC-3** **Micro-emulsion**
- SC-895** **Synthetic**

Oil Base
Water Base