

The invention relates to mechanical cutting of metals, especially to cooling mixtures, and may be used for drilling operations of carbon and other steels.

According to the invention the cooling mixture has following composition, in weight percent:

Calcium sulfonate	5 - 14.5
Elemental sulfur or polysulfide	0.5 - 3.0
Vegetable oil or oleic acid	0.5 - 2.0
Petroleum oil	Up to 100

Cooling mixture has high tribological properties extending service life of drills.