



TAP & DRILL FREE™

A Cutting and Tapping Lubricant in an Aerosol container Technical Information Sheet

Description & Application:

Tap & Drill Free is the trade name for a special blend of corrosion inhibitors, extreme pressure additives and refined mineral oil that acts as a multi-use cutting and tapping lubricant. It designed to reduce friction and swarf, thus giving cleaner threads and holes and increasing tool life.

Primary features attributable to Tap & Drill Free are:

- Multi-purpose lubricant;
- Increased tool life;
- Guards against damage to taps & edges;
- Gives cleaner threads and holes;
- Prevents overheating with resultant loss of effectiveness of tooling;
- Product supplied in aerosol cans that do not contain any components or propellants that damage the ozone layer (CFC free).

Applications

Tap & Drill Free is suited for:

- Drilling;
- Tapping;
- Reaming;
- Broaching.

Tap & Drill Free is effective on all metals, particularly aluminium alloys.

Compatibility

Tap & Drill Free may be safely applied to steel, aluminium, titanium, magnesium, zinc and other metal surfaces.



Safer
Solutions
For Industry

Tap & Drill Free will not harm most plastics and elastomers at room temperature, however specific materials should be tested prior to exposure.

Health and Safety

Tap & Drill Free is based on non-hazardous low toxicity compounds. It is combustible but is neither a known or suspected carcinogen.

Users should avoid ingestion and repeated or prolonged contact will degrease skin.

Do not expose fluid containers to temperatures in excess of 50 °C or place in direct sunlight. Use only in well ventilated areas. Do not store or use near naked flames, sources of heat or ignition.

Do not eat, drink or smoke when using the product.

See Material Safety Data Sheet for details.

Typical Properties

Appearance	Clear, amber coloured liquid
Density @ 20 °C	1.005
Vapour Density	Heavier than air
Flash Point, (Closed Cup, °C)	< 0
Solubility in water	Immiscible

Storage life in original, unopened containers, at between 0 °C and 35 °C (32° to 95 °F), is not less than 5 years.

Process Application

General Application:

Tap & Drill Free is supplied in an aerosol container and is used as supplied.

Aerosol application:

Shake the can well then spray directly onto drilling/tapping area.

Repeat application as necessary to prevent overheating.

Tap & Drill Free may be applied whilst machinery is in use.

If necessary, fit an extension tube into the nozzle to enable a more concentrated jet of fluid to be applied to the surface of the part close to point of drilling/tapping operation.

Post cleaning:

Tap & Drill Free can give metal surfaces some protection from corrosion, however, the presence of fine metal particles and debris from cutting / tapping operations can be detrimental.

Consequently, residual oil film residues together with any cutting debris should be cleaned off the surface of parts after completion of all required drilling, tapping, etc., operations.

The compound must be cleaned off if the metal surface is to be chemically treated or painted.

In these cases, parts may be cleaned of all traces of the Tap & Drill Free compound by either:

- Hand application of a suitable solvent, e.g. White spirit, Toxfree or Leksol;
- By vapour degreasing;

- Ultrasonic immersion cleaning; or
- By alkaline cleaning using a suitable cleaner such as Metaclean or Orthoclean.

CONTACT DETAILS:

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Packaging Details:

Tap & Drill Free is available in:

- 500 ml aerosol cans.