

# 395

## TAPPING LUBRICANT

### Description

Chesterton® 395 Tapping Lubricant is a high quality petroleum based machining lubricant specifically designed for aluminum and other soft metals. It is a high performance cutting fluid that will not stain and darken such metals during machining processes.

Chesterton 395 Tapping Lubricant reduces friction at point of contact by depositing a protective oily film which clings to machine tools. Excellent dimensional control and smooth thread finish are achieved as tools and parts are kept cool and well lubricated. The active agents in 395 Tapping Lubricant bind the compound to working edges promoting its effectiveness deep into the cut. Chips are prevented from welding back to the parent metal behind the cutting point. As chips move freely, tool breakage from galling is eliminated.

Many tapping compounds are formulated with chlorinated hydrocarbons because they provide excellent cooling. However, these solvents can stain and darken metal especially aluminum. The high performance additive package used in 395 Tapping Lubricant will reduce friction and prevent heat build up to provide excellent dimensional control without use of chlorinated compounds. The combination of lubricants in 395 Tapping Lubricant will cling to the tool and produce a finer chip that is freer moving and easier to eliminate. The product will treat the metal surface of parts to provide a superior, uniform finish.

### Typical Physical Properties

Appearance	Clear, Colorless
Odor	Pleasant, Mild
Density	0,8 kg/l
Solubility in Water	Negligible

### Composition

Chesterton 395 Tapping Lubricant begins with a pure paraffinic petroleum base. A proprietary, high performance additive package is utilized to achieve superior machining results in the absence of traditional metalworking additives that could stain or darken aluminum and other soft metals. These include:

- A high molecular weight, saturated lipid compound that clings to tool parts and aids in producing extremely fine parts finish. This high viscosity compound treats metal surfaces and promotes a uniform network of the microscopic fissures that are characteristic of a superior surface finish.

- A cooling solvent that wicks away heat from point of contact and helps to maintain dimensional control. In combination with the excellent friction reduction of the tapping lubricant, tool and parts are kept cool and lifetime of cutting tools extended.

### Applications

Specially formulated for tapping, threading, reaming, milling, boring, broaching etc., a wide variety of metals including aluminum alloys.

### Features

- Contains No Damaging Chlorinated Hydrocarbons
- Use On All Metals
- Excellent Lubricity
- High Viscosity, Clings to Tools
- Pleasant Mild Odor
- Improves Cutting Accuracy
- Clear, Colorless, Nonstaining
- Stops Galling
- NSF H2 - Registration number 133935

### Benefits

- Nonstaining to Aluminum
- Lowers Rejection Rate
- Prolongs Life of Cutting Tools
- Promotes a Uniform Cut
- Increases Production Rate
- Produces Quality, Smooth Parts Finish

**Directions**

Apply Chesterton® 395 Tapping Lubricant directly to tap or die and workpiece before starting cutting operation. Reapply as needed during the cutting process.

**Safety**

Before using this product, review the Material Safety Data Sheet (MSDS) or the appropriate safety sheet in your area.

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