

CIMCOOL®

METALWORKING FLUIDS

CIMTAP® PASTE TAPPING COMPOUND

APPLICATIONS	<p>CIMTAP® tapping compound is a water-soluble paste that contains chemical and extreme pressure (EP) type lubricants. Recommended for a wide range of tapping operations, from hand tapping to high production automatic jobs on ferrous and nonferrous metals.</p> <p>Can be used in three ways:</p> <ol style="list-style-type: none">1. Applied to tap directly by brushing or dipping.2. Diluted from 1:2 (50%) to 1:4 (25%) with water and applied with a squirt can.3. For high production on machines with multiple operations, it can be combined with CIMCOOL® mixes in dilutions from 1:20 (5%) to 1:30 (3.3%). <p>An excellent application for CIMTAP® is on parts where the compound needs to be restricted to the tapped hole to minimize or eliminate subsequent cleaning and washing operations.</p> <p>Metals: Steels, cast irons, stainless and nickel alloys, aluminum, brass, copper</p> <p>Duty Range: For moderate to heavy -duty operations</p>
FEATURES & BENEFITS	<p>MAXIMUM TAP LIFE Good lubricity eliminates chip welding, tap burning and resultant tap breakage</p> <p>MAXIMUM PRODUCTION - Works best at high tapping speeds</p> <p>CLEAN - Readily soluble in water - Does not leave deposits on the machine - Blind threaded holes can be cleaned with water or an air hose</p> <p>RESIDUE - Does not harden to a dry solid residue - Eliminates subsequent operations to remove residue</p> <p>PLEASANT TO USE - No smoke - No Smell - Nontoxic</p>

RECOMMENDED STARTING DILUTIONS	<p>FOR INDUSTRIAL USE ONLY</p> <ul style="list-style-type: none"> - For brush on application, use without diluting. - For squirt can application, dilute one part CIMTAP® to four parts water. - For multiple operations, add CIMTAP® to a CIMCOOL® mix to make a 1:20 (5%) to 1:30 (3.3%) dilution. <p>Not recommended for use with magnesium or alloyed magnesium.</p>
TYPICAL PHYSICAL AND CHEMICAL PROPERTIES	<p>Physical state: Paste Appearance and odor: Opaque / Chemical Colors available: Pink Solubility in water: 100% Miscible Weight, lb/gal, 60°F (15.6°C): 8.88 Specific gravity, (H₂O = 1): 1.064 Boiling point, °F (°C): NA Flash point, COC, °F (°C): None, Self Extinguishing Fire point, COC, °F (°C): Not Applicable Freezing point (or pour point), °F, (°C): 34 (1.1) Protect from freezing. pH, concentrate: Not Applicable pH, 10.0% mix, typical operating conditions: 9.8 Total chlorine/chloride, wt%, calculated: 14.40/< 50 ppm Total sulfur, wt%, calculated: 0.52 Silicones: None</p>
PACKAGING	<p>Available in 40-lb. pails, 250-lb. drums, 450-lb drums and cases of 24 one-pint cans.</p>
<p>For additional information concerning CIMTAP®, refer to its OSHA MSDS or contact CIMCOOL® Technical Services at 1-513-458-8199. Reprints/Updates of this Product Information Flyer (PIF) can be found on our web site, WWW.CIMCOOL.COM or from your Milacron representative.</p> <p>Minor formulation changes or normal variations in the manufacture of this product may cause slight variances in the data presented on this sheet. Consumable Products Division/ Milacron Marketing Company Cincinnati, Ohio 45209</p> <p>PC-815 4/11/05</p>	

