

Technical Data Sheet

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Safety Data Sheets, product photos, and other information can be obtained by visiting www.chemtools.com.au



Tap-N-Cool Soluble Cutting Fluid - EP

PART NUMBER	AVAILABLE SIZE*
CT-SCFO-1L	1 Litre
CT-SCFO-5L	5 Litres
CT-SCFO-20L	20 Litres

*Available colours and/or sizes may change without notice.

DESCRIPTION

Chemtools® Tap-N-Cool Soluble Cutting Fluid - EP is a heavy duty, bio-stable metalworking and grinding fluid mixed with water for highly efficient cooling. Its non-staining, extreme pressure formula consists of solvent refined mineral oils and specialised additives, including a long lasting, highly effective biocide package. This unique blend ensures the in-use emulsion resists forming bacteria and fungus, thereby reducing spoilage and odours.

SCFO replaces straight oils and offers excellent lubrication and corrosion inhibition to maintain a rust-free environment for machine tools and finished parts. It has been developed to provide an excellent finish on hard-to-work metals such as stainless steel, tool steels, and high nickel alloys, and is suited to high pressure cutting and grinding, along with other metalworking operations.

RECOMMENDED OPERATIONS

Tapping	Broaching/Gear Hobbing	Threading	Deep Hole/Gun Drilling	Sawing	Milling
Reaming	Turning/Boring	Drilling	Screw Machining	Stamping	Grinding

DIRECTIONS

Mix concentrate with tap water before use and avoid very cold water. Refer to Dilution Ratios chart below for different metal types and operations. Continue mixing until a stable, milky emulsion is formed.

Note: Always add the concentrate to water with agitation, to avoid gelling or splitting of the emulsion. Use a dosing unit or mixer to ensure constant concentration for optimum fluid performance.

DILUTION RATIOS

OPERATION	FERROUS & NON-FERROUS METALS	ALLOYS
Tapping	5 – 7% Water	5 – 10% Water
Broaching/Gear Hobbing		
Threading		
Deep Hole/Gun Drilling		
Sawing	5 – 7% Water	Not Recommended
Milling		
Reaming		
Turning/Boring		
Drilling		
Screw Machining		
Stamping		
Grinding	3 – 5% Water	

TECHNICAL DATA

Appearance	Brown liquid
Appearance (5% Emulsion)	Milky white
Density	0.91 (@ 20°C)
R1 Factor	1.42
Flash Point	> 200°C

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FIRST AID & SAFETY PRECAUTIONS

Always refer to Safety Data Sheet/s before use. Use proper Personal Protection Equipment. Do not get in eyes, on skin, or on clothing. Use with adequate ventilation. Avoid breathing fumes. This product may produce adverse health conditions, ranging from minor skin irritation to serious systemic effects. It should not be used, stored, or transported until the handling precautions and recommendations as stated in the Safety Data Sheet/s for this product have been fully understood by all persons who will work with the material.

STORAGE & TRANSPORT

Refer to Safety Data Sheet/s for recommendations. As a general precaution, keep containers tightly closed, protect from sunlight, and do not expose to temperatures exceeding 50°C. Store in a cool, dry place at room temperature (5 – 40°C). Do not return any unused material to its original container. Containers should be secured and stored upright during transit.

DISCLAIMER

Every effort has been made to ensure the information provided in this document is accurate at the date of publication. Chemtools® Pty Ltd expressly recommends that the user make his/her own assessment to determine the suitability of the product for its intended purpose prior to application. Chemtools® Pty Ltd shall not be responsible for loss, damage, or injury, resulting from the reliance upon, or failure to adhere to, any recommendations or information contained herein; nor from abnormal use of the material; nor from any hazard inherent in the nature of the material.