



# Castrol Moly Dee CF Tapping Fluid

High Performance Tapping Fluid

## Description

Castrol Moly Dee™ CF Tapping Fluid is a high performance tapping fluid that improves threading accuracy, extends tool life, improves surface finishes and increases production. Moly Dee CF Tapping Fluid is suggested for use on most metals, including aluminum, titanium and steel. It is especially effective on difficult-to-machine metals such as stainless steel and aerospace alloys.

## Application

Used straight, Moly Dee CF Tapping Fluid should be applied directly to the tool/workpiece interface from a spout-top can or other applicator. Used as an additive with straight cutting oils, it should be poured into a high agitation area in the machine sump. Add approximately one gallon of Moly Dee CF Tapping Fluid to every ten gallons of conventional cutting oils. Moly Dee CF Tapping Fluid is recommended for use on most metals including aluminum, titanium and steel. It can stain copper or copper alloys if not removed following use.

This product is not water soluble and should not be mixed with water soluble oils or synthetic coolants. Consult your Castrol Sales Engineer for questions regarding compatibility.

## Advantages

- Outstanding thermal and chemical stability means improved threading performance. This resistance to breakdown allows adherence to closer tolerances and provides smoother, more accurate threads.
- The molybdenum disulfide withstands pressures up to 400,000 psi, which is beyond the yield point of any known metal. This reduces metal-to-metal contact and results in longer tool life.
- Contains selected extreme pressure additives, including sulfur and MoS<sub>2</sub> that promote optimum metal cutting performance and improved surface finishes.
- The synergistic combination of friction reducing lubricants and chemical activity permits faster speeds and increases production.

## Typical Characteristics

Name	Method	Units	Moly Dee CF
Appearance	Visual	-	Grey
Specific Gravity at 60° F (16° C)	CN-TM-084	-	0.948
Viscosity at 40°C	CN-TM-101	cSt	192
Flash Point, COC	CN-TM-039	°C	200
Bulk Density	-	lbs/gal	7.91
Copper Corrosion	ASTM 130	-	4c
Chlorine	CN-TM-012	-	No
Fat	MW-TM-321	-	Yes

Name	Method	Units	Moly Dee CF
Sulfur	CN-TM-096	-	Yes
Active Sulfur	CN-TM-151	-	Yes

## Storage

To avoid product deterioration, keep the container/drum tightly sealed always. Prevent any frost and water ingress. Store it in a cool and dry place away from direct sunlight. It is preferable to store the product indoors always. For more details, please refer the product safety data sheet

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