CHESTERTON
Global Solutions, Local Service.

388

SYNTHETIC TAPPING FLUID



PRODUCT DATA SHEET

APPLICATION AREAS

- *Tapping*
- *Boring*
- *Drilling*
- *Milling*
- *Reaming*
- *Thread & Hydraulic Fitting*

KEY FEATURES AND BENEFITS

- Excellent lubricity
- Extends tool life
- Corrosion inhibited
- Superior heat dissipation
- Does not smoke, fume or mist
- Non-flammable
- Biodegradable

PACKAGING

475ml
20L
208L

DIRECTIONS

Use Chesterton 388 as received. Do not dilute. Apply directly to tool and work piece interface. Completely flood the area. Continue to apply as necessary. Residual tapping fluid on parts, equipment and tools is easily removed by rinsing with water.

DESCRIPTION

Chesterton® 388 Synthetic Tapping Fluid is a high performance, synthetic metal working fluid. It provides the industrial performance of conventional petroleum and solvent based fluids while eliminating the hazards normally associated with these traditional products. The superior lubrication of a synthetic, combined with maximum heat dissipating capability at the shear plane, results in a product which extends tool life and keeps taps cool to permit rapid cutting. Chesterton 388 is effective for all hand and automatic tapping operations and is used for a variety of demanding metal cutting operations over a broad range of metals, including aluminum. True and precise thread cutting action permits excellent thread quality. Since there is no chlorine or sulfur in the product, the working of stainless steel is facilitated without fear of embrittlement. Chesterton 388 is user and environmentally friendly. It is biodegradable, nonflammable and essentially odorless. Synthetic Tapping Fluid does not smoke, mist or fume during use. The result is a cleaner, safer work environment. A near neutral pH minimizes the potential for skin irritation and defatting commonly caused by organic solvent based cutting fluids.

Suggested Uses	
Operations	**Metals***
Drilling	Aluminum
Milling	Brass
Reaming	Bronze
Tapping	Cast Iron
Turning	Copper
Boring	Hastelloy**
Threading	High Alloy Steel
Threading	Carbon Steel
	Titanium
	Monel***

*Not recommended for use with magnesium
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TYPICAL PHYSICAL PROPERTIES

Appearance	Clear, Yellow Color Liquid
Flash Point (ASTM D 93)	None
Specific Gravity	1.01
Odor	Essentially None
Density, (Pounds/U.S. Gallon)	8.4
pH	8.2
Biodegradability (DOC Removal)	87-92% after 28 days
Lubricity (ASTM D 3233) Failure Load Maximum Final Torque	 2650lbs, 1202kg 51 in/lbs, 59 cm/kg
Tapping Torque Efficiency (vs. Petroleum Oil Cutting Fluids)	106%
Freezing Point	-1°C (30°F)

Before using this product, please refer to Safety Data Sheet (SDS).

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