



## I. Product Description

CRC TrueTap™ HD Cutting Fluid is an extreme duty cutting fluid. It is a thick fluid that sticks to the cutting tool throughout the operation. TrueTap™ HD is considered environmentally safe. The fluid is ideal for use on stainless steel, carbon steel, inconel, monel, hastalloy, titanium, aluminum and other alloys and exotics.

## II. Applications

Recommended for tapping, threading, drilling, sawing, shearing, turning, and reaming metal parts, pipes, conduit, screws, bolt holes, housings, aluminum sheets, strapping, gears and chains. Use in conjunction with pipe threaders, drill presses, cutting tables, shears, tap sets, hand tools and lathes.

## III. Features & Benefits

- **Use for Extreme Duty Applications.** Excellent on tough stainless and exotic metals.
- **Clings to Vertical Surfaces.** Thick fluid sticks to the tool.
- **Greatly Extends Cutting Tool Life.** Saves money by decreasing the number of tool repairs and new tool purchases.
- **Provides Excellent Finish and Accurate Threads.**
- **Does Not Contain 1,1,1 Trichloroethane** and is considered environmentally safe.

## IV. Physical Properties without propellant

|                   |                    |                  |                    |
|-------------------|--------------------|------------------|--------------------|
| Flash Point       | 415°F PMCC         | Boiling Point    | > 212°F @ 760 mmHg |
| Odor              | Light winter green | Solubility       | Neg. in water      |
| Appearance        | Amber liquid       | % Volatile       | < 1                |
| Vapor Density     | < 1 (air=1)        | Specific Gravity | 1.108              |
| VOC Content (Fed) | < 60 g/L           | Type of Film     | Lubricating Oil    |
|                   |                    | Compatibility    | All metals         |

## V. Specifications and Approvals

- Not Applicable

## VI. Performance Characteristics

|                         |                 |
|-------------------------|-----------------|
| Type of Film            | Lubricating Oil |
| ASTM D-93 (Flash Point) | 415°F PMCC      |
| Viscosity @ 104°        | 200 cSt         |
| Viscosity @ 212°        | 13-14 cSt       |

## VII. Directions

- Always read entire label before using product.
- Apply a few drops to the tool before coming in contact with the work.
- Caution. Using too much can hinder performance.
- After cutting, use a CRC Cleaner/Degreaser and a CRC corrosion inhibitor to clean and protect parts.
- Re-apply frequently on motor driven equipment.
- Re-apply with manual equipment when increased threading force is required.

## VIII. Package Description

| Part Number | Container Size  |
|-------------|-----------------|
| 03400       | 16 fl oz Bottle |
| 03401       | 1 Gallon Bottle |
| 03403       | 55 Gallon Drum  |

## IX. Disposal

Disposal requirements vary by state and local jurisdiction. All used and unused product should be disposed of in conformance with local, state and federal regulations.

## X. Special Use Warnings

### Bulk

Avoid strong oxidizing agents. Use only in well ventilated areas. Product should be kept away from all flames and other ignition sources.

### General

Use only in well ventilated area. Ventilation may be improved by opening a window or door or providing mechanical assistance. Avoid continuous breathing of vapor and spray mist. Avoid contact with skin and eyes. If ventilation is not adequate, respiratory protection should be worn. For more information regarding short term and long term exposure, review this product's Material Safety Data Sheet.

**DISCLAIMER:** This information is accurate to the best of CRC Industries' knowledge or obtained from sources believed by CRC to be accurate. Before using any product, read all warnings and directions on the label. All products should be tested for suitability on a particular application prior to actual use. CRC Industries, Inc. makes no representations or warranties of any kind concerning this data.



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