

## REFERENCE

### Cutting Fluids



#### QUICK USES CHART – METAL

Material	HIGH PERFORMANCE			ECO-FRIENDLY		
	Tap Magic EP-Xtra	Tap Magic Xtra-Thick	Tap Magic Aluminum	Tap Magic ProTap	Tap Magic Eco-Oil	Tap Magic Aqueous
Aluminum	Better **	Good	Best	Better **	Best	Better **
Brass	Better *	Good	Best	Better *	Best	Better *
Bronze	Better *	Good	Best	Better *	Best	Good
Cast Iron	Best	Better	Good	Best	Better	Better
Copper	Better *	Good	Best	Better *	Best	Better *
Galvanize	Best	Good	Good	N/A	Best	Good
Inconel	Better	Best	Good	Better	Better	Good
Magnesium	Better *	Good	Best	Better **	Best	N/A
Mild Steel	Best	Better	Good	Best	Better	Better
Nickel	Better	Best	Good	Better	Better	Good
Stainless Steel	Better	Best	Good	Better	Better	Good
Titanium	Better	Best	Good	Better	Better	Good

#### NOTES

- \* This product works well on these metals, but may cause rapid corrosion, therefore clean the workpiece immediately after use
- \*\* This product will work on these metals, but Tap Magic Aluminum will give a better finish and tighter tolerances
- Some of the components of Tap Magic Xtra-Thick and Tap Magic EP-Xtra are chlorinated, so it is possible that they will react with moisture in the air and cause rust or corrosion on the surrounding metal surfaces overnight. Therefore, we recommend that a metal protectant such as Tap Magic Corrosion Inhibitor be used before and after each use of these products.
- Tap Magic Aqueous is designed give a boost to the cutting tool performance when working with water soluble coolants. No need to skim Tap Magic Aqueous from the coolant reservoir because it will completely emulsify with the water base coolant.
- N/A Cannot be used on magnesium due to its water content. Use light mineral based oil like Eco-Oil or Aluminum.

#### CLEANING

- All products can be cleaned with a solvent; acetone, kerosene, or a degreaser with D-Limonene with the exception of Tap Magic Aqueous which can be cleaned with water only.
- These recommendations are based on Tap Magic experience, but other similar products may work just as well.
- The product names are supplied only for the sake of clarity, not as specific requirements.

#### CAUTIONS

- OVERHEATING**
  - When product smoking has been observed, a variety of negative effects may occur, such as flash rusting or metal discoloration.
  - Since such a variety of effects have been observed, it can be expected that other effects may occur that cannot now be foreseen.
  - Overheating may be minimized by either or both of the following:
    - Slow down the machining process
    - Increase the amount or flow of the Tap Magic product
- INCOMPATIBILITIES** Not compatible with water (except Tap Magic Aqueous)

#### SHELF LIFE

- All products except Tap Magic Eco-Oil 5-8 years if stored in original container at ambient temperatures. The product is safe to use past this date but it may lose some performance.
- Tap Magic Eco-Oil 18 months if stored in original container at ambient temperatures. The product is safe to use past this date but it may lose some performance.