

LUBRICATION

Selection and application of the proper lubricant has a very important bearing on the successful thread cutting operation. Longer tap and die life plus smoother, cleaner, and more accurately formed threads will be the benefits. Once the proper lubricant has been selected, it should be directed, with an old can, brush, or other convenient method, to the cutting edges (during the threading operation). Recommended lubricants, most readily available for the home work shop use, are listed with the materials to be threaded.

Steel	Lard oil, cutting oil or Crisco
Cast Iron.....	Dry or air blast
Aluminum	Kerosene or Kerosene lightly mixed with lard oil
Brass	Kerosene
Magnesium	Kerosene
Zinc	Kerosene
Bakelite	Dry
Hard Rubber	Dry
Bronze	Kerosene or Kerosene mixed with lard oil

Stainless Steel

Kerosene mixed with lard oil

Additional lubricants for production or industrial uses may be obtained by consulting commercial distributors of oils and greases.

WARNING

Always wear eye protection that complies with current ANSI Standard Z87.1. Always maintain firm footing and control of the tool. Discard immediately if any chipping or cracking of this tool has occurred. **FAILURE TO READ ALL WARNINGS AND INSTRUCTIONS COULD RESULT IN SERIOUS BODILY INJURY.**

CRAFTSMAN

HANDBOOK OF TAPS, DIES AND THREADING ACCESSORIES

