

# Technical data

## TAP Plus

The logo for MOLYSLIP, featuring the brand name in a bold, italicized, sans-serif font with a registered trademark symbol, set against a red rectangular background.

## High performance lubricants for drilling, reaming and tapping

### Description

MOLYSLIP TAP Plus is a range of high performance lubricants designed for severe metal working operations such as drilling, reaming and tapping. They are highly concentrated mixtures of lubricity and reactive extreme pressure and anti-wear additives. MOLYSLIP TAP Plus are formulated to meet the latest health, safety and environmental standards - all of the products in the range are free from mineral oil, short and medium chain chlorinated paraffins and other hazardous components.

MOLYSLIP TAP Plus products provide excellent surface finish to components and protect tooling from wear and damage. They are suitable for drilling, reaming and tapping (spiral point, spiral flute and fluteless) operations on most commonly encountered workpiece materials. However it is advised that compatibility with non-ferrous metals is checked prior to use as the sulphurised extreme pressure additives may interact and result in surface discolouration.

For situations where chlorine must be avoided use TAP Chlorine free, where both chlorine and sulphur must be avoided it is advised that TAP AQUA is used.

MOLYSLIP TAP Plus liquid can also be used to fortify flood applied neat cutting oils, typical addition rates are 5-10% (check compatibility with prior to addition).

### Features and benefits

- Excellent extreme pressure and anti-wear performance
- Maximises tool life in arduous operations
- Improves surface finish
- Facilitates increased metal removal rates
- Available in liquid, paste and aerosol form

### Packaging

Compound: 450g tin and 4.5kg pail  
Liquid: 350ml bottle and 5ltr poly  
Spray: 400 ml aerosol

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Molyslip is a division of Metalube Ltd. Company registration number: 2263118; Company registered in England VAT registration number GB108244927000

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### Instructions for use

To obtain optimum performance MOLYSLIP TAP Plus products should be used as supplied. Apply directly to either the tool (while stationary) or workpiece.

MOLYSLIP TAP Plus liquid can be used as a supplement to boost the performance of neat cutting oils used in lathes and milling machines etc. The recommended addition rate is 5 - 10% concentration - check compatibility with the oil to be treated before use.

### Technical data (typical values)

Property	Test method	TAP liquid	TAP compound
Appearance	-	Amber liquid	Soft amber paste
Kinematic viscosity at 40°C	MSTM27	105 cSt	-
Melt point	IP371	-	65°C
Unworked penetration	IP50	-	195 mm <sup>-10</sup>
Copper corrosion (3 hours at 100°C)	IP112		3c
4-ball weld load	IP239		>800kg
Silicone content	-		Nil

**Note:** Results for TAP Plus spray are the same as TAP Plus liquid

### Storage

Store MOLYSLIP TAP Plus out of direct sunlight.

Storage temperature should be controlled to between 5°C and 35°C.

The product information in this publication is based on knowledge and experience at the time of printing. There are many factors outside our control or knowledge which affect the use and performance of our products, for which reason it is given without responsibility.  
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