

Thread-Cutting Fluid and Tapping Oil

DT Workshop Equipment Reference — D&T / STEM resource for school workshops | Consumables & Spares

Thread-cutting fluid cools, lubricates and clears chips at the cutting edge of taps, dies and single-point threads, giving cleaner threads, less tool wear and fewer broken taps. It is essential for thread cutting in steel and harder alloys.

Key Features

- Soluble and neat cutting oils
- Sulphurised and chlorinated EP types
- Aerosols and hand bottles
- Tapping pastes and sticks
- Biodegradable options

Typical Uses in the Workshop

- Lubricate tapping and reaming
- Cut threads on the lathe
- Extend tap and die life
- Cool tools in hard materials

Safe Operation

1. Apply fluid to the tool and hole
2. Reapply during the cut
3. For holes, fill or brush the flutes
4. Use the correct type for the alloy
5. Wipe tools clean after

SAFETY NOTES

- Cutting fluids can irritate skin - use gloves
- Work in a ventilated area
- Do not mix incompatible fluids
- Clean spills immediately
- Dispose of used fluid correctly

Maintenance & Consumables

- Keep bottles capped and labelled
- Filter or replace spent fluid
- Clean the applicator
- Store away from heat
- Check that stock is fresh

Specification & Buying Notes

Quality tapping fluid in a squirt bottle plus an aerosol for lathes covers school thread cutting. EP grades best for steel. Biodegradable versions suit ventilation-limited rooms.