



## WORKING WITH ANVILOY® 1150 TIP SHEET

### TAPPING ANVILOY® 1150

- 1) We recommend tapping threads at 50% to 60% thread depth. Use slightly larger pilot hole so that only the bottom 50% to 60% of the thread depth is cut. Even though the threads are at half depth, due to the very high density of Anviloy® 1150, full strength will be achieved.
- 2) In bottom holes instead of using a plug or bottoming tap we recommend using a spiral point tap to start the thread, and then grind off the tip to thread the bottom of the hole. Even after grinding off the tip, the flutes of the spiral tap are more suitable than those of a plug or bottoming tap.
- 3) For best results plan on using a fresh tap for each hole.

### RELEASE AGENTS

- 1) DO NOT spray Anviloy® 1150 with a release agent. Anviloy® 1150 cools 5 times faster than H13 Tool Steel so it will not burn off the release agent (fluid) which results in a gummy residue that will interfere with clean production.
- 2) Anviloy® 1150's faster cooling prevents soldering, so a release agent is not required.

### COOLANTS

- 1) Coolants are not required while machining ANVILOY® 1150
- 2) If coolant is used, properly degrease part prior to use.

### SEALANTS

- 1) Teflon tape can be used if required.
- 2) Pipe dope may also be used if necessary.

### UNIQUE PROPERTIES REQUIRES UNIQUE HANDLING

It is common to knock off solder buildup by hitting or tapping the die &/or core rods to loosen solder deposits with H13 Tool Steel, BUT THERE IS NO NEED TO DO THIS WITH ANVILOY® 1150!!!!