

# Machine tap with right-hand spiral flutes 35°

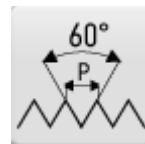


**CATALOGUE NUMBER: 2250CYC**

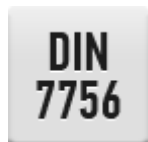
Machine tap with spiral flutes, for tyre valve threads, DIN 371, suitable for universal use.



**THREAD VG**  
Valve thread



**PROFILE SKETCH**  
60°



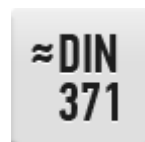
**TAP STANDARD**  
DIN 7756



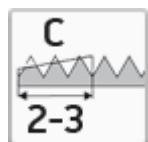
**TYPE UNI**  
Tap for universal applications



**TAP MATERIAL**  
Super high speed steel



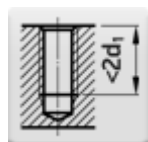
**TAP STANDARD**  
~ DIN 371



**CHAMFER C**  
Length 2-3 pitch



**SPIRAL FLUTE ANGLE**  
35°



**HOLE TYPE**  
Blind hole (thread length < 2 d1)

# Select product model

ID	D1	P	Tolerance	I1	I2	d2	a	Price excl. VAT	Price incl. VAT
041529910050000	Vg5	0,705		80	10	6	4,9	13.45 EUR	16.27 EUR
041529910080000	Vg8	0,794		90	13	8	6,2	14.70 EUR	17.79 EUR

## Use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Aluminium alloys si content < 10%	blind hole (thread length < 1,5 d1, pilot drilling depth $\geq$ L+d1)	12-20	Emulsion	Recommended use
Aluminium alloys si content < 10%	blind hole (thread length L < 1,5xd1)	12-20	Emulsion	Recommended use
Aluminium alloys si content < 10%	blind hole (thread length L < 2xd1)	12-20	Emulsion	Recommended use
Aluminium alloys si content > 10%	blind hole (thread length L < 2xd1)	12-20	Emulsion	Possible use
Aluminium alloys si content > 10%	blind hole (thread length < 1,5 d1, pilot drilling depth $\geq$ L+d1)	12-20	Emulsion	Possible use
Aluminium alloys si content > 10%	blind hole (thread length L < 1,5xd1)	12-20	Emulsion	Possible use
Case hardened steels and nitriding steels up to 1100 N/mm2	blind hole (thread length L < 2xd1)	4-6	Cutting Oil/Emulsion	Recommended use
Case hardened steels and nitriding steels up to 1100 N/mm2	blind hole (thread length < 1,5 d1, pilot drilling depth $\geq$ L+d1)	4-6	Cutting Oil/Emulsion	Recommended use
Case hardened steels and nitriding steels up to 1100 N/mm2	blind hole (thread length L < 1,5xd1)	4-6	Cutting Oil/Emulsion	Recommended use
Copper alloys (long chipping)	blind hole (thread length L < 2xd1)	12-20	Cutting Oil	Recommended use
Copper alloys (long chipping)	blind hole (thread length < 1,5 d1, pilot drilling depth $\geq$ L+d1)	12-20	Cutting Oil	Recommended use
Copper alloys (long chipping)	blind hole (thread length L < 1,5xd1)	12-20	Cutting Oil	Recommended use

<b>MACHINED MATERIAL</b>	<b>HOLE TYPE</b>	<b>CUTTING SPEED</b>	<b>LUBRICATION</b>	<b>USE</b>
Free cutting steels up to 800 N/mm <sup>2</sup>	blind hole (thread length $L < 2 \times d_1$ )	8-10	Cutting Oil/Emulsion	Possible use
Free cutting steels up to 800 N/mm <sup>2</sup>	blind hole (thread length $< 1,5 d_1$ , pilot drilling depth $\geq L + d_1$ )	8-10	Cutting Oil/Emulsion	Possible use
Free cutting steels up to 800 N/mm <sup>2</sup>	blind hole (thread length $L < 1,5 \times d_1$ )	8-10	Cutting Oil/Emulsion	Possible use
Grey cast iron	blind hole (thread length $< 1,5 d_1$ , pilot drilling depth $\geq L + d_1$ )	8-12	Emulsion	Possible use
Grey cast iron	blind hole (thread length $L < 2,5 \times d_1$ )	8-12	Emulsion	Possible use
Grey cast iron	blind hole (thread length $L < 1,5 \times d_1$ )	8-12	Emulsion	Possible use
Grey cast iron	blind hole (thread length $L < 2 \times d_1$ )	8-12	Emulsion	Possible use
Heat-treated steels up to 1100 N/mm <sup>2</sup>	blind hole (thread length $L < 1,5 \times d_1$ )	4-6	Cutting Oil/Emulsion	Recommended use
Heat-treated steels up to 1100 N/mm <sup>2</sup>	blind hole (thread length $L < 2 \times d_1$ )	4-6	Cutting Oil/Emulsion	Recommended use
Heat-treated steels up to 1100 N/mm <sup>2</sup>	blind hole (thread length $< 1,5 d_1$ , pilot drilling depth $\geq L + d_1$ )	4-6	Cutting Oil/Emulsion	Recommended use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length $L < 1,5 \times d_1$ )	7-10	Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length $L < 2 \times d_1$ )	7-10	Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length $< 1,5 d_1$ , pilot drilling depth $\geq L + d_1$ )	7-10	Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length $L < 2,5 \times d_1$ )	7-10	Emulsion	Possible use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm <sup>2</sup>	blind hole (thread length $L < 1,5 \times d_1$ )	6-10	Cutting Oil	Possible use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm <sup>2</sup>	blind hole (thread length $L < 2 \times d_1$ )	6-10	Cutting Oil	Possible use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm <sup>2</sup>	blind hole (thread length $< 1,5 d_1$ , pilot drilling depth $\geq L + d_1$ )	6-10	Cutting Oil	Possible use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm <sup>2</sup>	blind hole (thread length $< 1,5 d_1$ , pilot drilling depth $\geq L + d_1$ )	4-7	Cutting Oil	Possible use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm <sup>2</sup>	blind hole (thread length $L < 1,5 \times d_1$ )	4-7	Cutting Oil	Possible use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm <sup>2</sup>	blind hole (thread length $L < 2 \times d_1$ )	4-7	Cutting Oil	Possible use

<b>MACHINED MATERIAL</b>	<b>HOLE TYPE</b>	<b>CUTTING SPEED</b>	<b>LUBRICATION</b>	<b>USE</b>
Structural steels and heat-treated steels up to 800 N/mm <sup>2</sup>	blind hole (thread length $L < 2 \times d_1$ )	8-10	Cutting Oil/Emulsion	Recommended use
Structural steels and heat-treated steels up to 800 N/mm <sup>2</sup>	blind hole (thread length $< 1,5 d_1$ , pilot drilling depth $\geq L + d_1$ )	8-10	Cutting Oil/Emulsion	Recommended use
Structural steels and heat-treated steels up to 800 N/mm <sup>2</sup>	blind hole (thread length $L < 1,5 \times d_1$ )	8-10	Cutting Oil/Emulsion	Recommended use
Tool steels up to 1100 N/mm <sup>2</sup>	blind hole (thread length $L < 1,5 \times d_1$ )	4-6	Cutting Oil/Emulsion	Possible use
Tool steels up to 1100 N/mm <sup>2</sup>	blind hole (thread length $L < 2 \times d_1$ )	4-6	Cutting Oil/Emulsion	Possible use
Tool steels up to 1100 N/mm <sup>2</sup>	blind hole (thread length $< 1,5 d_1$ , pilot drilling depth $\geq L + d_1$ )	4-6	Cutting Oil/Emulsion	Possible use