

Machine tap with right-hand spiral flutes 35°

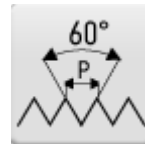


CATALOGUE NUMBER: 2250CYC

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



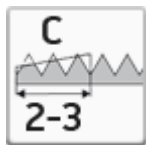
TYPE UNI
Tap for universal applications



TAP MATERIAL
Super high speed steel



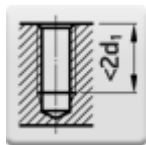
TAP STANDARD
~ DIN 371



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	l1	l2	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 $L < 2 \times d1$)	12-20	Emulsion	Recommended use
Aluminium alloys si content < 10%	blind hole (thread length $< 1,5 \times d1$, pilot drilling depth $\geq L+d1$)	12-20	Emulsion	Recommended use
Aluminium alloys si content < 10%	blind hole (thread length $L < 1,5 \times d1$)	12-20	Emulsion	Recommended use
Aluminium alloys si content > 10%	blind hole (thread length $L < 1,5 \times d1$)	12-20	Emulsion	Possible use
Aluminium alloys si content > 10%	blind hole (thread length $L < 2 \times d1$)	12-20	Emulsion	Possible use
Aluminium alloys si content > 10%	blind hole (thread length $< 1,5 \times d1$, pilot drilling depth $\geq L+d1$)	12-20	Emulsion	Possible use
Case hardened steels and nitriding steels up to 1100 N/mm2	blind hole (thread length $L < 1,5 \times d1$)	4-6	Cutting Oil/Emulsion	Recommended use
Case hardened steels and nitriding steels up to 1100 N/mm2	blind hole (thread length $L < 2 \times d1$)	4-6	Cutting Oil/Emulsion	Recommended use
Case hardened steels and nitriding steels up to 1100 N/mm2	blind hole (thread length $< 1,5 \times d1$, pilot drilling depth $\geq L+d1$)	4-6	Cutting Oil/Emulsion	Recommended use
Copper alloys (long chipping)	blind hole (thread length $L < 1,5 \times d1$)	12-20	Cutting Oil	Recommended use
Copper alloys (long chipping)	blind hole (thread length $L < 2 \times d1$)	12-20	Cutting Oil	Recommended use
Copper alloys (long chipping)	blind hole (thread length $< 1,5 \times d1$, pilot drilling depth $\geq L+d1$)	12-20	Cutting Oil	Recommended use

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

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

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