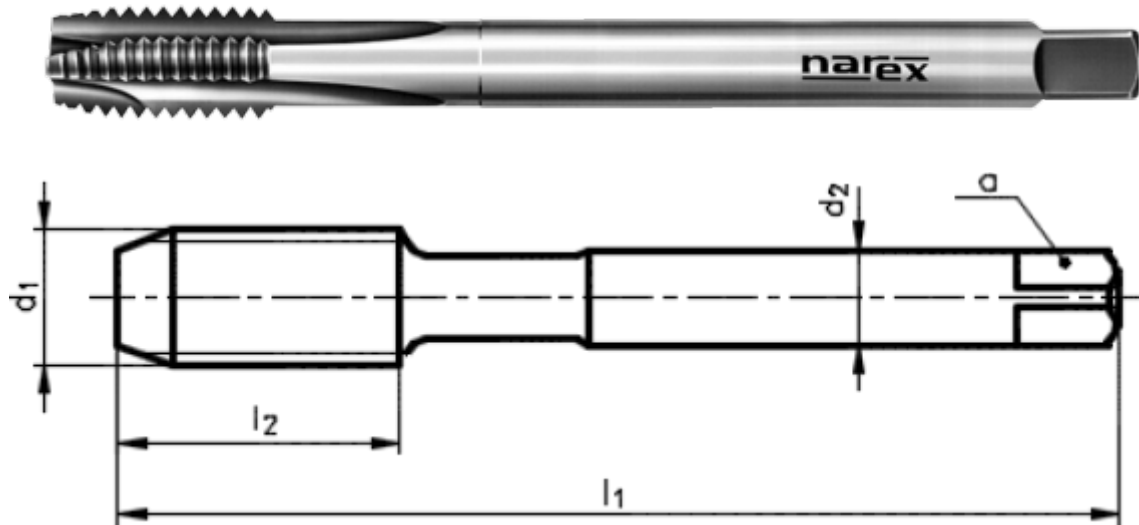


Machine tap with straight flutes and spiral point

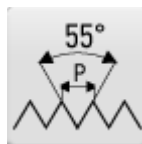


CATALOGUE NUMBER: 3502

Machine tap with straight flutes and spiral point, british standard pipe thread, DIN 5156, suitable for structural steels, plain cast steels, free cutting steels, short chipping copper alloys, spheroidal and malleable cast iron, aluminium alloys with Si<10%.



THREAD G
Whitworth pipe straight thread



PROFILE SKETCH
55°



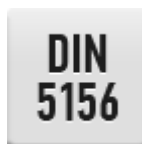
THREAD STANDARD
DIN ISO 228



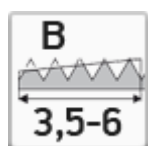
TYPE N
Tap for steels up to 800 N/mm²



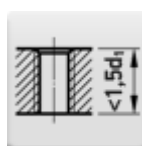
TAP MATERIAL
Super high speed steel



TAP STANDARD
DIN 5156



CHAMFER B
Length 3,5-6 pitch



HOLE TYPE
Through hole (thread length $L < 1,5 \times d_1$)

Select product model

ID	D1	P	Tolerance	l1	l2	d2	a	Price excl. VAT	Price incl. VAT
041531620003000	G1/8"	28		90	20	7	5,5	17.70 EUR	21.42 EUR
041531620007000	G1/4"	19		100	21	11	9	24.10 EUR	29.16 EUR
041531620011000	G3/8"	19		100	21	12	9	29.45 EUR	35.63 EUR
041531620013000	G1/2"	14		125	24	16	12	39.80 EUR	48.16 EUR
041531620015000	G5/8"	14		125	24	18	14,5	49.40 EUR	59.77 EUR
041531620017000	G3/4"	14		140	26	20	16	62.90 EUR	76.11 EUR
041531620019000	G7/8"	14		150	28	22	18	80.50 EUR	97.41 EUR
041531620021000	G1"	11		160	30	25	20	88.20 EUR	106.72 EUR
041531620022000	G1 1/8"	11		170	30	28	22	121.50 EUR	147.02 EUR
041531620023000	G1 1/4"	11		170	30	32	24	146.10 EUR	176.78 EUR
041531620024000	G1 3/8"	11		180	32	36	29	179.70 EUR	217.44 EUR
041531620025000	G1 1/2"	11		190	32	36	29	202.35 EUR	244.84 EUR
041531620027000	G1 3/4"	11		190	32	40	32	273.75 EUR	331.24 EUR
041531620029000	G2"	11		220	40	45	35	314.25 EUR	380.24 EUR

Use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Aluminium alloys si content < 10%	through hole (thread length L < 1,5xd1)	14-20	Emulsion	Recommended use
Aluminium alloys si content < 10%	through hole (thread length L > 1,5xd1)	14-20	Emulsion	Recommended use
Aluminium alloys si content > 10%	through hole (thread length L > 1,5xd1)	12-15	Emulsion	Possible use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Aluminium alloys si content > 10%	through hole (thread length $L < 1,5d_1$)	12-15	Emulsion	Possible use
Copper alloys (short chipping)	through hole (thread length $L > 1,5d_1$)	12-20	Cutting Oil/Emulsion	Possible use
Copper alloys (short chipping)	through hole (thread length $L < 1,5d_1$)	12-20	Cutting Oil/Emulsion	Possible use
Free cutting steels up to 800 N/mm ²	through hole (thread length $L < 1,5d_1$)	10-14	Cutting Oil/Emulsion	Possible use
Free cutting steels up to 800 N/mm ²	through hole (thread length $L > 1,5d_1$)	10-14	Cutting Oil/Emulsion	Possible use
Plain cast steels up to 500 N/mm ²	through hole (thread length $L > 1,5d_1$)	6-10	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 500 N/mm ²	through hole (thread length $L < 1,5d_1$)	6-10	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 800 N/mm ²	through hole (thread length $L < 1,5d_1$)	10-14	Cutting Oil/Emulsion	Possible use
Plain cast steels up to 800 N/mm ²	through hole (thread length $L > 1,5d_1$)	10-14	Cutting Oil/Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$)	4-7	Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	through hole (thread length $L > 1,5d_1$)	4-7	Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	through hole (thread length $L < 1,5d_1$)	4-7	Emulsion	Possible use
Structural steels and heat-treated steels up to 800 N/mm ²	through hole (thread length $L < 1,5d_1$)	10-14	Cutting Oil/Emulsion	Recommended use
Structural steels and heat-treated steels up to 800 N/mm ²	through hole (thread length $L > 1,5d_1$)	10-14	Cutting Oil/Emulsion	Recommended use
Structural steels up to 500 N/mm ²	through hole (thread length $L > 1,5d_1$)	5-8	Cutting Oil/Emulsion	Possible use
Structural steels up to 500 N/mm ²	through hole (thread length $L < 1,5d_1$)	5-8	Cutting Oil/Emulsion	Possible use

NAREX Ždánice, spol. s r.o.

Městečko 250
696 32 Ždánice, Česká republika

Tel.: +420 518 607 111
Fax: +420 518 607 153
E-mail: sales@narexzd.cz
Web: www.narexzd.cz