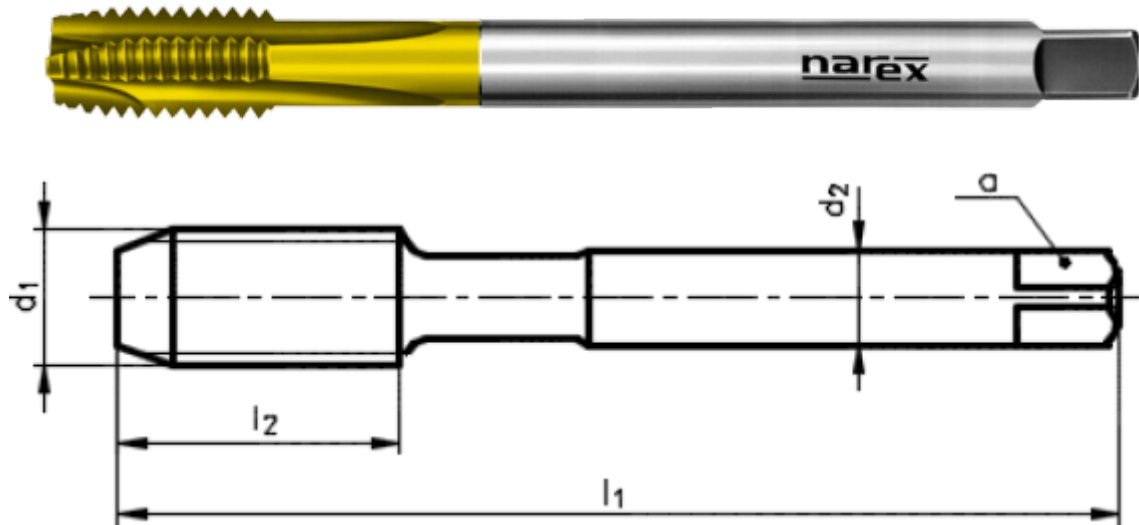


Machine tap with straight flutes and spiral point

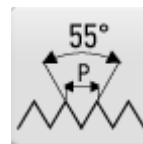


CATALOGUE NUMBER: 3512

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



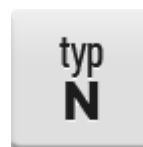
THREAD G
Whitworth pipe straight thread



PROFILE SKETCH
55°



THREAD STANDARD
DIN ISO 228



TYPE N
Tap for steels up to 800 N/mm²



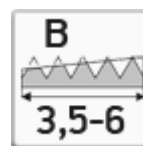
TAP MATERIAL
Super high speed steel



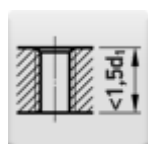
COATING
Titanium nitride coating



TAP STANDARD
DIN 5156



CHAMFER B
Length 3,5-6 pitch



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

Select product model

ID	D1	P	Tolerance	l1	l2	d2	a	Price excl. VAT	Price incl. VAT
041535620003000	G1/8"	28		90	20	7	5,5	23.00 EUR	27.83 EUR
041535620007000	G1/4"	19		100	21	11	9	31.25 EUR	37.81 EUR
041535620011000	G3/8"	19		100	21	12	9	38.40 EUR	46.46 EUR
041535620013000	G1/2"	14		125	24	16	12	51.75 EUR	62.62 EUR
041535620015000	G5/8"	14		125	24	18	14,5	64.40 EUR	77.92 EUR
041535620017000	G3/4"	14		140	26	20	16	81.80 EUR	98.98 EUR
041535620019000	G7/8"	14		150	28	22	18	104.65 EUR	126.63 EUR
041535620021000	G1"	11		160	30	25	20	114.70 EUR	138.79 EUR
041535620022000	G1 1/8"	11		170	30	28	22	157.85 EUR	191.00 EUR
041535620023000	G1 1/4"	11		170	30	32	24	190.00 EUR	229.90 EUR
041535620024000	G1 1/8"	11		180	32	36	29	Ask for price	
041535620025000	G1 1/2"	11		190	32	36	29	263.10 EUR	318.35 EUR
041535620027000	G1 3/4"	11		190	32	40	32	Ask for price	
041535620029000	G2"	11		220	40	45	35	408.45 EUR	494.22 EUR

Use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Aluminium alloys si content < 10%	through hole (thread length L < 1,5xd1)	15-30	Emulsion	Recommended use
Aluminium alloys si content < 10%	through hole (thread length L > 1,5xd1)	15-30	Emulsion	Recommended use
Aluminium alloys si content > 10%	through hole (thread length L < 1,5xd1)	14-20	Emulsion	Possible use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Aluminium alloys si content > 10%	through hole (thread length $L > 1,5d_1$)	14-20	Emulsion	Possible use
Copper alloys (short chipping)	through hole (thread length $L > 1,5d_1$)	15-25	Cutting Oil/Emulsion	Possible use
Copper alloys (short chipping)	through hole (thread length $L < 1,5d_1$)	15-25	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	Recommended use
Free cutting steels up to 800 N/mm ²	through hole (thread length $L < 1,5d_1$)	10-14	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 500 N/mm ²	through hole (thread length $L > 1,5d_1$)	8-12	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 500 N/mm ²	through hole (thread length $L < 1,5d_1$)	8-12	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 800 N/mm ²	through hole (thread length $L < 1,5d_1$)	12-15	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 800 N/mm ²	through hole (thread length $L > 1,5d_1$)	12-15	Cutting Oil/Emulsion	Recommended use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$)	6-8	Emulsion	Recommended use
Spheroidal graphite cast iron and malleable cast iron	through hole (thread length $L > 1,5d_1$)	6-8	Emulsion	Recommended use
Spheroidal graphite cast iron and malleable cast iron	through hole (thread length $L < 1,5d_1$)	6-8	Emulsion	Recommended use
Structural steels and heat-treated steels up to 800 N/mm ²	through hole (thread length $L < 1,5d_1$)	12-15	Cutting Oil/Emulsion	Recommended use
Structural steels and heat-treated steels up to 800 N/mm ²	through hole (thread length $L > 1,5d_1$)	12-15	Cutting Oil/Emulsion	Recommended use
Structural steels up to 500 N/mm ²	through hole (thread length $L > 1,5d_1$)	6-10	Cutting Oil/Emulsion	Recommended use
Structural steels up to 500 N/mm ²	through hole (thread length $L < 1,5d_1$)	6-10	Cutting Oil/Emulsion	Recommended 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