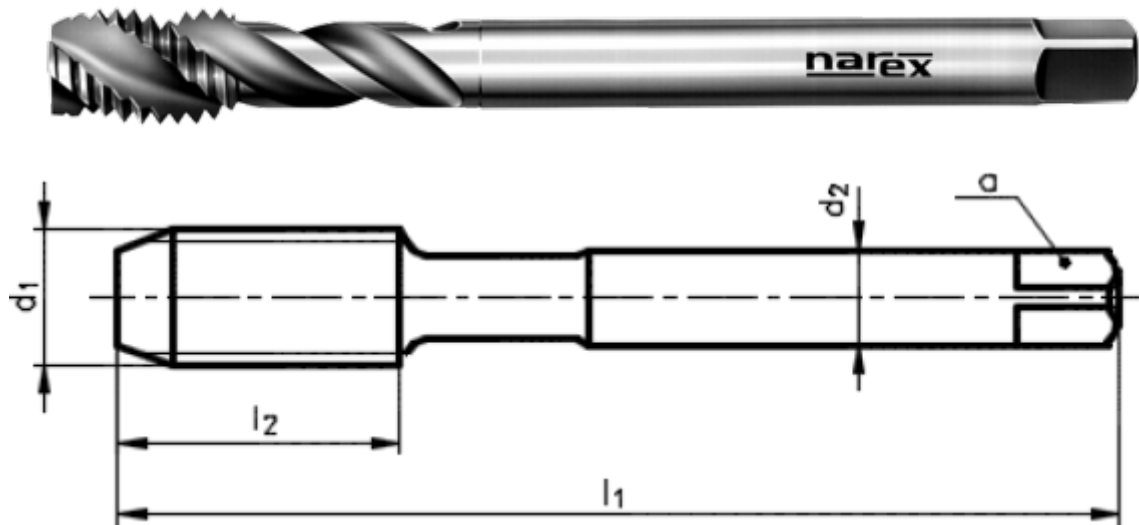


Machine tap with right-hand spiral flutes 35°

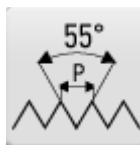


CATALOGUE NUMBER: 4052

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



THREAD G
Whitworth pipe straight thread



PROFILE SKETCH
55°



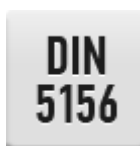
THREAD STANDARD
DIN ISO 228



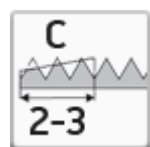
TYPE N
Tap for steels up to 800 N/mm²



TAP MATERIAL
Super high speed steel



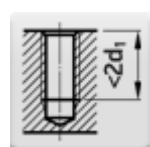
TAP STANDARD
DIN 5156



CHAMFER 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
041531632003000	G1/8"	28		90	12	7	5,5	22.70 EUR	27.47 EUR
041531632007000	G1/4"	19		100	16	11	9	31.85 EUR	38.54 EUR
041531632011000	G3/8"	19		100	16	12	9	37.85 EUR	45.80 EUR
041531632013000	G1/2"	14		125	20	16	12	48.20 EUR	58.32 EUR
041531632015000	G5/8"	14		125	20	18	14,5	61.30 EUR	74.17 EUR
041531632017000	G3/4"	14		140	22	20	16	77.60 EUR	93.90 EUR
041531632019000	G7/8"	14		150	26	22	18	103.25 EUR	124.93 EUR
041531632021000	G1"	11		160	30	25	20	119.05 EUR	144.05 EUR
041531632022000	G1 1/8"	11		170	30	28	22	155.95 EUR	188.70 EUR
041531632023000	G1 1/4"	11		170	30	32	24	188.35 EUR	227.90 EUR
041531632024000	G1 3/8"	11		180	32	36	29	Ask for price	
041531632025000	G1 1/2"	11		190	32	36	29	265.20 EUR	320.89 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 $\geq L+d1$)	14-20	Emulsion	Recommended use
Aluminium alloys si content < 10%	blind hole (thread length $L < 1,5xd1$)	14-20	Emulsion	Recommended use
Aluminium alloys si content < 10%	blind hole (thread length $L < 2xd1$)	14-20	Emulsion	Recommended use
Copper alloys (long chipping)	blind hole (thread length $L < 1,5xd1$)	6-10	Cutting Oil	Possible use
Copper alloys (long chipping)	blind hole (thread length $L < 2xd1$)	6-10	Cutting Oil	Possible use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Copper alloys (long chipping)	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	6-10	Cutting Oil	Possible use
Plain cast steels up to 800 N/mm2	blind hole (thread length L < 1,5xd1)	10-14	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 800 N/mm2	blind hole (thread length L < 2xd1)	10-14	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 800 N/mm2	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	10-14	Cutting Oil/Emulsion	Recommended use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	4-7	Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length L < 2,5xd1)	4-7	Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length L < 1,5xd1)	4-7	Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length L < 2xd1)	4-7	Emulsion	Possible use
Structural steels and heat-treated steels up to 800 N/mm2	blind hole (thread length L < 1,5xd1)	10-14	Cutting Oil/Emulsion	Recommended use
Structural steels and heat-treated steels up to 800 N/mm2	blind hole (thread length L < 2xd1)	10-14	Cutting Oil/Emulsion	Recommended use
Structural steels and heat-treated steels up to 800 N/mm2	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	10-14	Cutting Oil/Emulsion	Recommended use

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