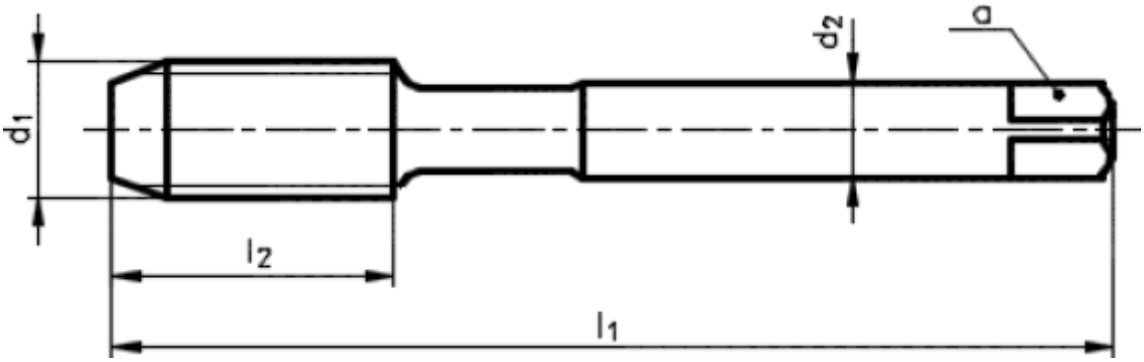
Machine tap with right-hand spiral flutes 50°



CATALOGUE NUMBER: 4222NX

High performance machine tap with 50° spiral flutes, british standard pipe, DIN 5156, Balinit Hardlube coated, suitable for universal use.

THREAD G
Whitworth pipe straight thread

PROFILE SKETCH
55°

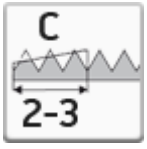
THREAD STANDARD
DIN ISO 228

TYPE UNI
Tap for universal applications

TAP MATERIAL
Powder high speed steel

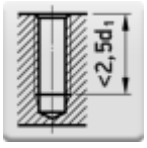
COATING
Balinit® Hardlube coating (titanium aluminiumnitride + tungsten carbide)

TAP STANDARD
DIN 5156



CHAMFER C
Length 2-3 pitch

SPIRAL FLUTE ANGLE
50°



HOLE TYPE
Blind hole (thread length < 2,5 d1)

Select product model

ID	D1	P	Tolerance	l1	l2	d2	a	Price excl. VAT	Price incl. VAT
042036638003000	G1/8"	28		90	12	7	5,5	**80.17** EUR	**97.01** EUR
042036638007000	G1/4"	19		100	15	11	9	**121.62** EUR	**147.16** EUR
042036638011000	G3/8"	19		100	15	12	9	**152.54** EUR	**184.57** EUR
042036638013000	G1/2"	14		125	18	16	12	**203.99** EUR	**246.83** EUR
042036638015000	G5/8"	14		125	18	18	14,5	**250.47** EUR	**303.07** EUR
042036638017000	G3/4"	14		140	20	20	16	**304.81** EUR	**368.82** EUR
042036638021000	G1"	11		160	22	25	20	**418.62** EUR	**506.53** EUR

Use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Aluminium alloys si content < 10%	blind hole (thread length L < 1,5xd1)	15-20	Cutting Oil/Emulsion	Recommended use
Aluminium alloys si content < 10%	blind hole (thread length L < 2xd1)	15-20	Cutting Oil/Emulsion	Recommended use
Aluminium alloys si content < 10%	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	15-20	Cutting Oil/Emulsion	Recommended use
Aluminium alloys si content < 10%	blind hole (thread length L < 2,5xd1)	15-20	Cutting Oil/Emulsion	Recommended use
Aluminium alloys si content > 10%	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	12-15	Cutting Oil/Emulsion	Recommended use
Aluminium alloys si content > 10%	blind hole (thread length L < 2,5xd1)	12-15	Cutting Oil/Emulsion	Recommended use
Aluminium alloys si content > 10%	blind hole (thread length L < 1,5xd1)	12-15	Cutting Oil/Emulsion	Recommended use
Aluminium alloys si content > 10%	blind hole (thread length L < 2xd1)	12-15	Cutting Oil/Emulsion	Recommended use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Case hardened steels and nitriding steels up to 1100 N/mm2	blind hole (thread length L < 1,5xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Case hardened steels and nitriding steels up to 1100 N/mm2	blind hole (thread length L < 2xd1)	10-12	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 ≥ L+d1)	10-12	Cutting Oil/Emulsion	Recommended use
Case hardened steels and nitriding steels up to 1100 N/mm2	blind hole (thread length L < 2,5xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Copper alloys (long chipping)	blind hole (thread length L < 1,5xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Copper alloys (long chipping)	blind hole (thread length L < 2xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Copper alloys (long chipping)	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	10-12	Cutting Oil/Emulsion	Recommended use
Copper alloys (long chipping)	blind hole (thread length L < 2,5xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Copper alloys (short chipping)	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	10-12	Cutting Oil/Emulsion	Recommended use
Copper alloys (short chipping)	blind hole (thread length L < 2,5xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Copper alloys (short chipping)	blind hole (thread length L < 1,5xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Copper alloys (short chipping)	blind hole (thread length L < 2xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Free cutting steels up to 800 N/mm2	blind hole (thread length L < 2,5xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Free cutting steels up to 800 N/mm2	blind hole (thread length L < 1,5xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Free cutting steels up to 800 N/mm2	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	10-12	Cutting Oil/Emulsion	Recommended use
Free cutting steels up to 800 N/mm2	blind hole (thread length L < 2xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Grey cast iron	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	15-20	Cutting Oil/Emulsion	Recommended use
Grey cast iron	blind hole (thread length L < 2,5xd1)	15-20	Cutting Oil/Emulsion	Recommended use
Grey cast iron	blind hole (thread length L < 1,5xd1)	15-20	Cutting Oil/Emulsion	Recommended use
Grey cast iron	blind hole (thread length L < 2xd1)	15-20	Cutting Oil/Emulsion	Recommended use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Heat-treated steels up to 1100 N/mm2	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	10-12	Cutting Oil/Emulsion	Recommended use
Heat-treated steels up to 1100 N/mm2	blind hole (thread length L < 2,5xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Heat-treated steels up to 1100 N/mm2	blind hole (thread length L < 1,5xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Heat-treated steels up to 1100 N/mm2	blind hole (thread length L < 2xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Heat-treated steels up to 1400 N/mm2	blind hole (thread length L < 1,5xd1)	10-12	Cutting oil for high resistance steels	Recommended use
Heat-treated steels up to 1400 N/mm2	blind hole (thread length L < 2xd1)	10-12	Cutting oil for high resistance steels	Recommended use
Heat-treated steels up to 1400 N/mm2	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	10-12	Cutting oil for high resistance steels	Recommended use
Heat-treated steels up to 1400 N/mm2	blind hole (thread length L < 2,5xd1)	10-12	Cutting oil for high resistance steels	Recommended use
High-alloyed steels up to 1400 N/mm2	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	10-12	Cutting oil for high resistance steels	Recommended use
High-alloyed steels up to 1400 N/mm2	blind hole (thread length L < 2,5xd1)	10-12	Cutting oil for high resistance steels	Recommended use
High-alloyed steels up to 1400 N/mm2	blind hole (thread length L < 1,5xd1)	10-12	Cutting oil for high resistance steels	Recommended use
High-alloyed steels up to 1400 N/mm2	blind hole (thread length L < 2xd1)	10-12	Cutting oil for high resistance steels	Recommended use
Plain cast steels up to 500 N/mm2	blind hole (thread length L < 1,5xd1)	15-25	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 500 N/mm2	blind hole (thread length L < 2xd1)	15-25	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 500 N/mm2	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	15-25	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 500 N/mm2	blind hole (thread length L < 2,5xd1)	15-25	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)	10-12	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 800 N/mm2	blind hole (thread length L < 2,5xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 800 N/mm2	blind hole (thread length L < 1,5xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 800 N/mm2	blind hole (thread length L < 2xd1)	10-12	Cutting Oil/Emulsion	Recommended use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length L < 1,5xd1)	12-15	Cutting Oil/Emulsion	Recommended use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length L < 2xd1)	12-15	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)	12-15	Cutting Oil/Emulsion	Recommended use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length L < 2,5xd1)	12-15	Cutting Oil/Emulsion	Recommended use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm2	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	10-12	Cutting Oil/Emulsion	Recommended use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm2	blind hole (thread length L < 2,5xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm2	blind hole (thread length L < 1,5xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm2	blind hole (thread length L < 2xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm2	blind hole (thread length L < 1,5xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm2	blind hole (thread length L < 2xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm2	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	10-12	Cutting Oil/Emulsion	Recommended use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm2	blind hole (thread length L < 2,5xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Structural steels and heat-treated steels up to 800 N/mm2	blind hole (thread length L < 2,5xd1)	10-12	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)	10-12	Cutting Oil/Emulsion	Recommended use
Structural steels and heat-treated steels up to 800 N/mm2	blind hole (thread length L < 1,5xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Structural steels and heat-treated steels up to 800 N/mm2	blind hole (thread length L < 2xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Structural steels up to 500 N/mm2	blind hole (thread length L < 2,5xd1)	15-25	Cutting Oil/Emulsion	Recommended use
Structural steels up to 500 N/mm2	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	15-25	Cutting Oil/Emulsion	Recommended use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Structural steels up to 500 N/mm2	blind hole (thread length L < 1,5xd1)	15-25	Cutting Oil/Emulsion	Recommended use
Structural steels up to 500 N/mm2	blind hole (thread length L < 2xd1)	15-25	Cutting Oil/Emulsion	Recommended use
Tool steels up to 1100 N/mm2	blind hole (thread length L < 1,5xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Tool steels up to 1100 N/mm2	blind hole (thread length L < 2xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Tool steels up to 1100 N/mm2	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	10-12	Cutting Oil/Emulsion	Recommended use
Tool steels up to 1100 N/mm2	blind hole (thread length L < 2,5xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Unalloyed aluminium	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	15-35	Cutting Oil/Emulsion	Recommended use
Unalloyed aluminium	blind hole (thread length L < 2,5xd1)	15-35	Cutting Oil/Emulsion	Recommended use
Unalloyed aluminium	blind hole (thread length L < 1,5xd1)	15-35	Cutting Oil/Emulsion	Recommended use
Unalloyed aluminium	blind hole (thread length L < 2xd1)	15-35	Cutting Oil/Emulsion	Recommended use
Unalloyed copper	blind hole (thread length L < 1,5xd1)	15-20	Cutting Oil/Emulsion	Recommended use
Unalloyed copper	blind hole (thread length L < 2xd1)	15-20	Cutting Oil/Emulsion	Recommended use
Unalloyed copper	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	15-20	Cutting Oil/Emulsion	Recommended use
Unalloyed copper	blind hole (thread length L < 2,5xd1)	15-20	Cutting Oil/Emulsion	Recommended use
Zinc and zinc alloys	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	10-12	Cutting Oil/Emulsion	Recommended use
Zinc and zinc alloys	blind hole (thread length L < 2,5xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Zinc and zinc alloys	blind hole (thread length L < 1,5xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Zinc and zinc alloys	blind hole (thread length L < 2xd1)	10-12	Cutting Oil/Emulsion	Recommended use

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