HIGH PERFORMANCE MACHINE TAPS

Technical data / Technische informatie

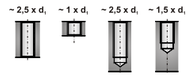
VerspaningOnline.eu

SELECTION TABLE

Symbols

Az	Interrupted threads
BL	Tap for sheet
IK	Internal cooling
SR	Oil flutes

Hole type



Chamfer

A		6 ÷ 8P	5°
B		3,5 ÷ 5,5P	8°
C		2 ÷ 3P	15°
D		3,5 ÷ 5P	8°
E		1,5 ÷ 2P	23°

Coolant

E	Emulsion
O	Oil
OS	Special oil
P	Threading paste
SP	Compressed air
S	Dry

Execution

		Straight flutes
B		Straight flutes with spiral point
L		Left spiral flutes
R		Right spiral flutes

Material

HSS	High speed molibden steel
HSSE	High speed cobalt steel
HSSE PM	High speed powder steel
HSSE PMS	High speed special powder steel

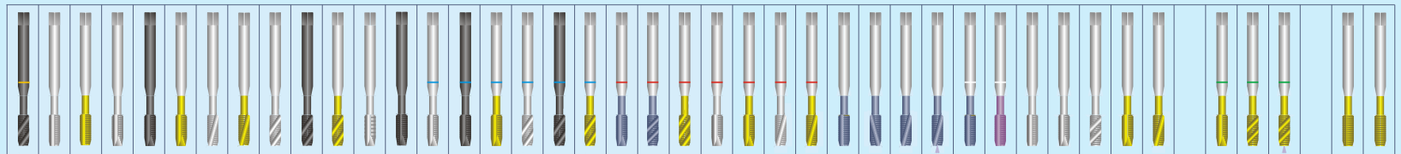
Coating

TiN	BALINIT A	œrlikon balzers coating
TiCN	BALINIT B	
TiAlN	BALINIT FUTURA NANO	
OX	Oxydation	

Notes

The values given in table are orientational.
For taps coated PVD speed can be enlarged till 150%.
For blind holes speed should be reduced for 70%.

● Well suitable tap ○ Suitable tap



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