

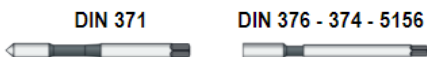


Threading Taps from FERG Spain

Spiral Point



Heat treated and heat-resistant steels
 $R_m < 1.000 \text{ N/mm}^2$



184A

184

COATING



T184A

T184

TiN



A184A

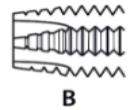
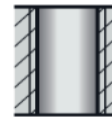
A184

TiAlN

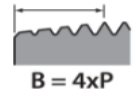


HSSE-V

$\leq 3 \times d_1$



B



$B = 4 \times P$

Machine tap with spiral point, driving the chips ahead.

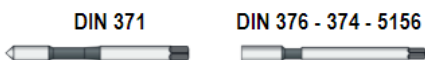
Chamfer lead 4-5 threads (DIN-Form B).

Rake angle $8^\circ \pm 10^\circ$ measured in the 3rd thread.

Spiral Flute



Heat treated and heat-resistant steels
 $R_m < 1.000 \text{ N/mm}^2$



182A

182

COATING



T182A

T182

TiN



A182A

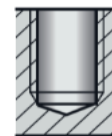
A182

TiAlN

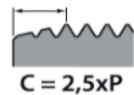


HSSE-V

$\leq 3 \times d_1$



R38



$C = 2,5 \times P$

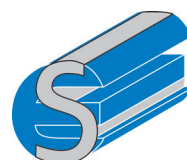
Machine tap with 38° right-hand spiral flutes, driving the chips to the back, increased flute length.

Threaded length: 10 threads.

Starting from the 5th thread, back tapered thread portion to reduce friction and improve swarf clearance.

Chamfer lead 2.5 threads (DIN-Form C).

Rake angle $8^\circ \pm 10^\circ$.



Elliott & Small

..... PRECISELY