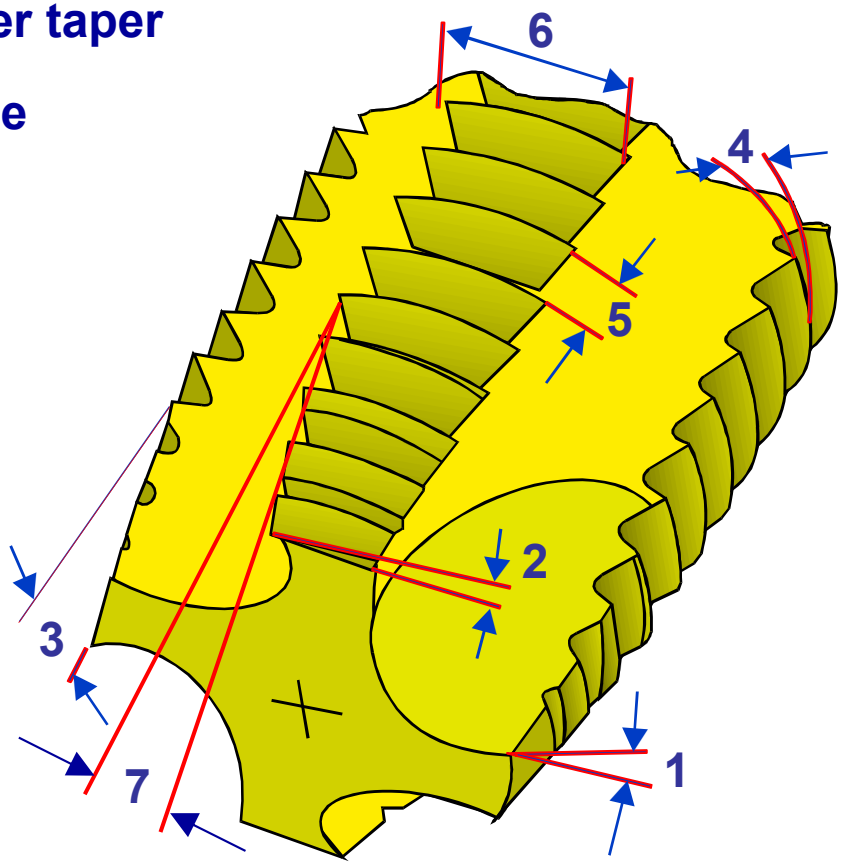
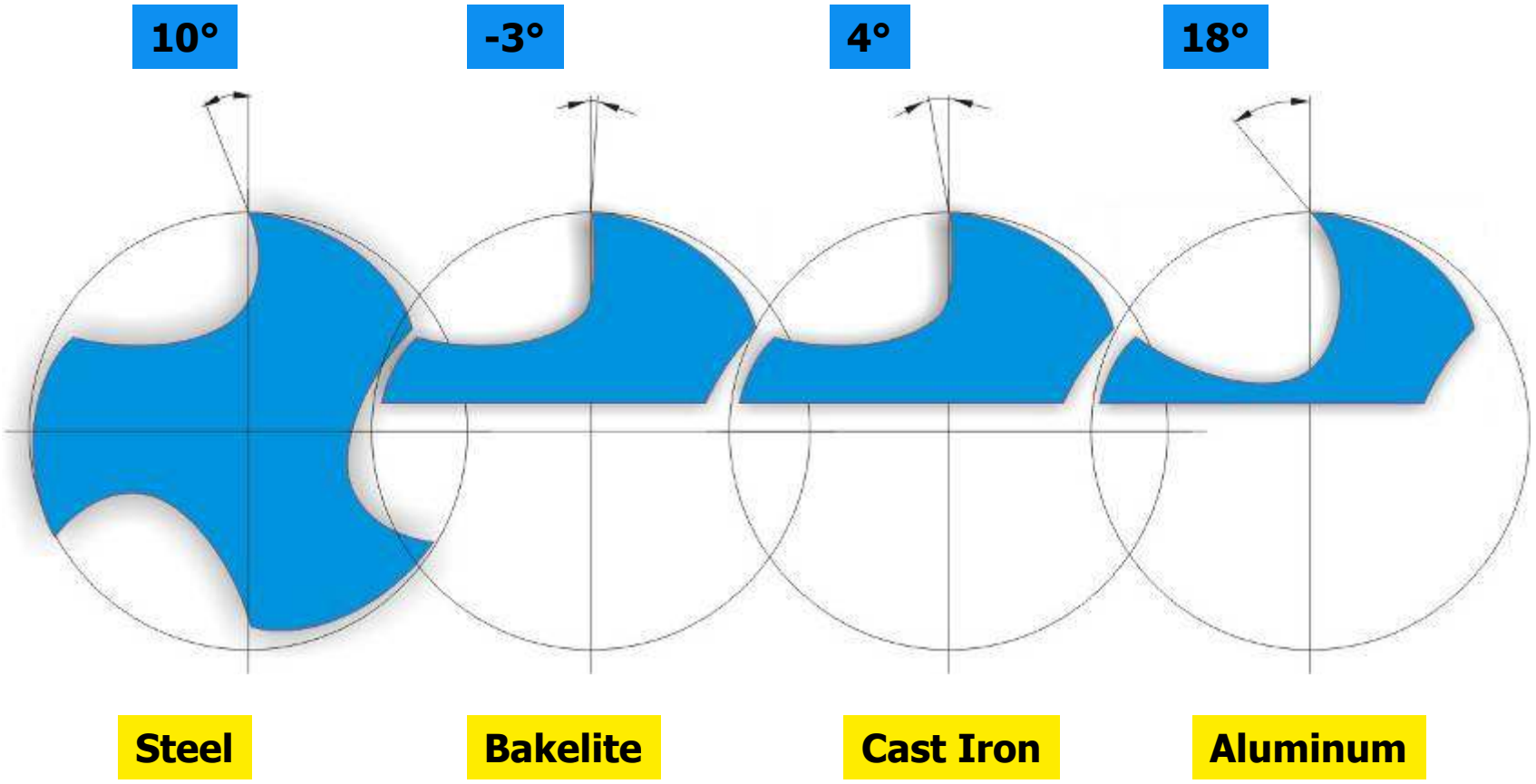
Tap Geometry

1) Rake angle cutting edge
2) Radial chamfer relief
3) Length and chamfer taper
4) Thread tooth profile
5) Pitch
6) Crest width
7) Helix angle



Rake Angle Cutting Edge



Rake Angle Cutting Edge

Materia	Rake Angle	Coolant
Steel 400-700 N/mm^2	12° ÷ 15°	Emulsion
Steel >700 N/mm^2	8° ÷ 12°	Emulsion
Stainless Steel	8° ÷ 12°	Emulsion/Oil
Nickel-Based Alloys	8° ÷ 12°	Oil
Titanium	10°	Oil
Gray Cast Iron	3° ÷ 5°	Emulsion/Dry
Cast Iron Nodular Graphite	4° ÷ 8°	Emulsion
Aluminum	25° ÷ 35°	Emulsion
Cast Aluminums	15° ÷ 25°	Emulsion
Cast Aluminums Si>12%	10° ÷ 15°	Emulsion
Brass	0° ÷ 5°	Emulsion
Bronze+Al	5° ÷ 8°	Emulsion/Oil
Bronze+Pb	2° ÷ 5°	Emulsion/Dry
Copper	15° ÷ 25°	Emulsion
Nylon,Polymer,Kevlar,Polyethylene Fibers	4° ÷ 8°	Air Jet
Bakelite	-3° ÷ 6°	Emulsion/Dry/Air
Carbon Fiber Reinforced Polymers	3°	Dry/Air