

Veralite[®] - Tapping

Veralite[®] can be tapped easily, following advice :

Conventional 4-flute taps can be used to tap internal threads in Veralite[®] sheets.

However, we advise to use 2-flute taps, as 4-flute taps tend to generate a considerable heat production whilst tapping.

2-flute taps do not only have a longer lifetime and higher tapping-speed, but they also provide better clearance for chip discharge.

The flute has to be fixed in a way that both edges cut simultaneously, to obtain uniform thread on the part.

Cutting edges have to be 85° from the center-line, giving a negative rake of 5° on the front face of the lands so that the top will not bind in the hole when it is backed out.

All above information is based on current knowledge and experience. The data does not imply any warranty from the manufacturer towards third parties. Users should consider the above data as a guideline and gather additional information, to make independant decisions regarding the proper use, disposal, safety towards other parties and the protection of the environment.

For more specific information, please feel free to contact our technical department :

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