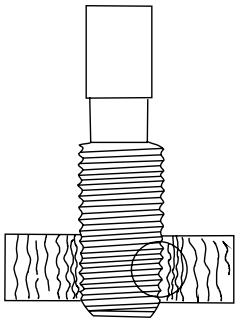
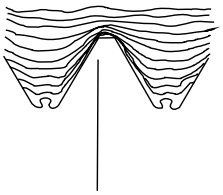
Technical Information
Fluteless Machine Taps

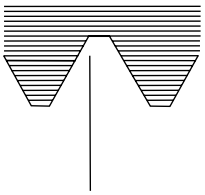
VÖLKEL THREADING SOLUTIONS

Fluteless Taps (Forming Taps) are threading tools to form internal threads without cutting.
The thread is produced by deformation of the material without damaging the fibre structure.





Fibre structure of thread forming



Fibre structure of thread cutting

Benefit:

✓ longer endurance as cutting taps
✓ higher possible cutting speed
✓ steady exactness of dimension and profile
✓ high stability of the forming threads
✓ high security against fracture
✓ no removal of swarf, no jaming of swarf

Application:

- Unalloyed and low alloyed Steel
- Constructional Steel
- Heat resistant Steel
- Stainless Steel
- Long-chipping nonferrous Metal
- Zinc Alloys
- For through and blind holes

Material	**bright** for nonferrous metal of good ductility	**VAP** for steel up to approx. 700 N/mm²	**TIN** for steel up to approx. 900 N/mm² and to increase endurance and cutting speed
unalloyed and low alloyed Steel			x
heat resistant Steel			x
Stainless Steel		x	x
Constructional Steel		x	x
Brass, long-chipping	x		
Bronzes, long-chipping	x		
Copper	x		
Al-alloys, long-chipping	x		
Zinc Alloyes	x		

Recommended Core Hole Diameter

M 1	M 1,1	M 1,2	M 1,4	M 1,6	M 1,7	M 1,8	M 2	M 2,5	M 3	M 4	M 5	M 6	M 8	M 10	M 12	M 14	M 16
0,90	1,00	1,10	1,25	1,45	1,55	1,65	1,80	2,30	2,80	3,70	4,65	5,55	7,45	9,30	11,20	13,00	15,10