

## PURPLERING FOR STAINLESS STEELS

Stainless steel is difficult to work on. The tendency to jam and the resulting high torque, poor thermal conductivity and hardened edges result in high strain on the tool.

The Neoboss purplering machine tap is a tool with a **special geometry** and a **powerful coating** indispensable for steels with high amount of chrome-nickel.

### Grulo-V4A

DIN371 Art. no. 4365 vap.  
DIN371 Art. no. 4365/81 TiCN  
DIN376/374 Art. no. 6365 vap.  
DIN376/374 Art. no. 6365/81 TiCN

### Rapid-V4A

DIN371 Art. no. 7225 vap.  
DIN371 Art. no. 7225/81 TiCN  
DIN376/374 Art. no. 7235 vap.  
DIN376/374 Art. no. 7235/81 TiCN

### Your advantages:

- > extended tool-life
- > high reliability
- > excellent quality of thread surface

### Neoboss – Range of Products:

- > metric ISO standard threads
- > metric ISO fine threads
- > other standards and special taps on request



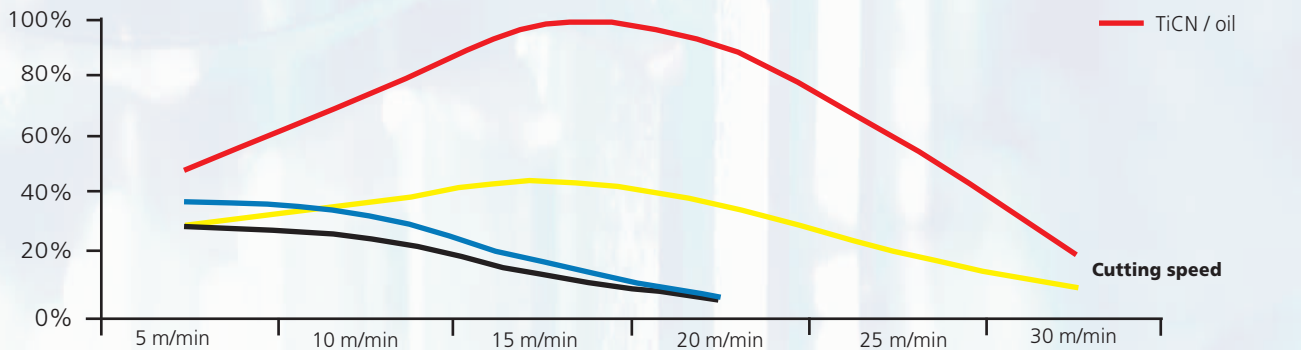
## Range of materials

<b>X39Cr 13</b>	1.4031
<b>X20CrNi 17 2</b>	1.4057
<b>X6CrMo 17</b>	1.4113
<b>X12CrNi 17 7</b>	1.4310
<b>X2CrNiN 18 10</b>	1.4311
<b>X2CrNiMo 17 13 2</b>	1.4404
<b>X5CrNiMo 17 13 3</b>	1.4436
<b>X2CrNiMo 18 16</b>	1.4438
<b>X5NiCrMoCuNb 20 18</b>	1.4505
<b>X6CrTi 12</b>	1.4512
<b>X2CrMoTi 18 2</b>	1.4521



### Interdependence of tool-life, surface treatment and cooling in material 1.4438

max. tool-life in 100 %



## Cutting speed / Cooling

**TiCN-coated  
steam-tempered**

**10 - 20 m/min  
6 - 10 m/min**

**oil / emulsion  
oil/ emulsion**

Cutting of materials with a tensile strength of 1.000 N/mm<sup>2</sup> and more, the usage of oil is strictly recommended.



**Workpiece: setscrew**

Material: X12CrNi 17 7  
v<sub>c</sub>: 20 m/min  
Article-No.: 4365/81 M8 6H



**Workpiece: connecting strap**

Material: X5CrNiMo 17 13 3  
v<sub>c</sub>: 8 m/min  
Article-No.: 4365 M14 6HX