

WHITE-RING – A POWERFUL TOOL

Abrasive materials such as grey cast iron tend to shorten the life of conventional thread cutting tools. This affects the efficiency of your production.

The solution: Neoboss taps especially designed to work in grey cast iron, to resist the extreme friction due to a wear-resistant TIALN-coating, and a precisely matched cutting geometry. Efficient threading – your advantage!

All Neoboss White-Ring taps are also perfect for dry machining or minimum lubrication in grey cast iron and in malleable cast iron.

RAPID TM TIALN

DIN 371 Art.-No. 7270/70
DIN 376/374 Art.-No. 7271/70

GRULO TM TIALN

DIN 371 Art.-No. 4340/70
DIN 376/374 Art.-No. 6340/70

C-GG TM

DIN 371 Art.-No. 4358/70 TIALN
DIN 371 Art.-No. 4058/06 nitrided
DIN 376/374 Art.-No. 6308/70 TIALN
DIN 376/374 Art.-No. 6008/06 nitrided

E-GG TM (Chamfer Form E)

DIN 371 Art.-No. 4359/70 TIALN
DIN 376/374 Art.-No. 6309/70 TIALN

Your advantages:

- excellent thread quality
- precise dimensional accuracy
- increased cutting speed (up to 50m/min)
- higher tool life
- suitable for dry machining and MMS

Neoboss – Range of products:

- metric ISO standard threads
- inner coolant
- base material PM and HSSE



Neoboss White-Ring – long lifetime guaranteed.

GREY CAST IRON

EN-GJL-100 up to EN-GJL-400 (GG10–GG40)

In this type of material, straight fluted taps will work in through- as well as in blind holes. The chip flutes are designed to easily carry the short chips. The highly abrasive material calls for wear-resistant taps. Neoboss solves this with a specially designed cutting geometry and a TIALN-coated surface.

NODULAR CAST IRON

EN-GJS-400-25 up to EN-GJS-800-2 (GGG40–GGG80)

Nodular Cast Iron is a long-chipping cast material, requiring various versions for through- and for blind holes. Neoboss recommends TIALN-coated **taps Rapid TM** (Art.-No. 7270/70 or 7271/70) for through holes and **Grulo TM** (Art.-No. 4340/70 or 6340/70) for blind holes. Better friction and higher hardness reduce stickiness and avoid the built-up edge. Higher cutting speeds improve the quality of the thread surface.

OTHER WORKABLE CASTING MATERIALS:

- ❖ Malleable cast iron EN-JM 1160 (GTS55-05, black malleable cast iron)
- ❖ Malleable cast iron EN-JM 1010 (GTW35-04, white malleable cast iron)
- ❖ Cast iron with vermicular graphite (GJV or CGI)

EXAMPLES INTERNAL THREAD PRODUCTION:



Workpiece:	Pump
Material:	GG 30
Neoboss Art.No.:	6308/70
Dimension:	M16x1,5 6HX
Material:	PM
Coating:	TIALN
Life:	12.000 thread
Cutting speed:	$V_c = 25\text{m/min}$
Machine:	CNC

Grey
Cast
Iron

Grey
Cast
Iron

Workpiece:	Break caliper
Material:	GG 26
Neoboss Art.No.:	6308
Dimension:	M8 6HX
Material:	PM
Coating:	TIALN
Life:	4.000 thread
Cutting speed:	$V_c = 30\text{m/min}$
Machine:	CNC
Tool holder:	synchro chuck
Cooling:	Emulsion

