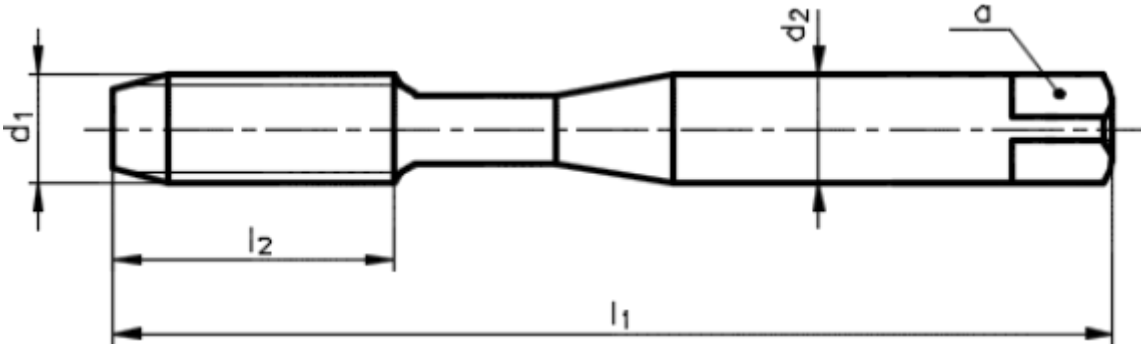
Forming tap



CATALOGUE NUMBER: 2910

Forming tap, metric, DIN 2174, TiN coated, suitable for zinc alloys, structural steels, plain cast steels, free cutting steels, unalloyed aluminium and aluminium alloys with Si<10 %

M

THREAD M
ISO Metric coarse thread

PROFILE SKETCH
60°

DIN 13

THREAD STANDARD
DIN13

typ N

TYPE N
Tap for steels up to 800 N/mm2

HSSE

TAP MATERIAL
Super high speed steel

TiN

COATING
Titanium nitride coating

DIN 2174

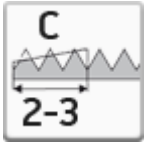
TAP STANDARD
DIN 2174

ISO 2 6HX

THREAD TOLERANCE
ISO 2 - 6HX

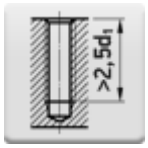
ISO 3 6GX

THREAD TOLERANCE
ISO 3 - 6GX



CHAMFER C
Length 2-3 pitch

HOLE TYPE
Through hole (thread length L > 1,5xd1)



HOLE TYPE
Blind hole (thread length > 2,5 d1)

Select product model

ID	D1	P	Tolerance	l1	l2	d2	a	Price excl. VAT	Price incl. VAT
041535191030000	M3	0,5	6HX	56	11	3,5	2,7	**21.00** EUR	**25.41** EUR
041535191035000	M3,5	0,6	6HX	56	12	4	3	**22.95** EUR	**27.77** EUR
041535191040000	M4	0,7	6HX	63	13	4,5	3,4	**21.45** EUR	**25.95** EUR
041535191050000	M5	0,8	6HX	70	16	6	4,9	**22.45** EUR	**27.16** EUR
041535191060000	M6	1	6HX	80	19	6	4,9	**23.90** EUR	**28.92** EUR
041535191080000	M8	1,25	6HX	90	22	8	6,2	**25.65** EUR	**31.04** EUR
041535191100000	M10	1,5	6HX	100	24	10	8	**32.50** EUR	**39.33** EUR
041535191120000	M12	1,75	6HX	110	28	9	7	**39.30** EUR	**47.55** EUR
041535193030000	M3	0,5	6GX	56	11	3,5	2,7	**21.00** EUR	**25.41** EUR
041535193035000	M3,5	0,6	6GX	56	12	4	3	**22.95** EUR	**27.77** EUR
041535193040000	M4	0,7	6GX	63	13	4,5	3,4	**21.45** EUR	**25.95** EUR
041535193050000	M5	0,8	6GX	70	16	6	4,9	**22.45** EUR	**27.16** EUR
041535193060000	M6	1	6GX	80	19	6	4,9	**23.90** EUR	**28.92** EUR
041535193080000	M8	1,25	6GX	90	22	8	6,2	**25.65** EUR	**31.04** EUR
041535193100000	M10	1,5	6GX	100	24	10	8	**32.50** EUR	**39.33** EUR
041535193120000	M12	1,75	6GX	110	28	9	7	Ask for price	

Use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Aluminium alloys si content < 10%	blind hole (thread length L < 2,5xd1)	15-30	Cutting Oil/Emulsion	Possible use
Aluminium alloys si content < 10%	through hole (thread length L > 1,5xd1)	15-30	Cutting Oil/Emulsion	Possible use
Aluminium alloys si content < 10%	blind hole (thread length L < 1,5xd1)	15-30	Cutting Oil/Emulsion	Possible use
Aluminium alloys si content < 10%	blind hole (thread length L > 2,5xd1)	15-30	Cutting Oil/Emulsion	Possible use
Aluminium alloys si content < 10%	through hole (thread length L < 1,5xd1)	15-30	Cutting Oil/Emulsion	Possible use
Aluminium alloys si content < 10%	blind hole (thread length L < 2xd1)	15-30	Cutting Oil/Emulsion	Possible use
Aluminium alloys si content < 10%	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	15-30	Cutting Oil/Emulsion	Possible use
Free cutting steels up to 800 N/mm2	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	15-20	Cutting Oil/Emulsion	Possible use
Free cutting steels up to 800 N/mm2	blind hole (thread length L < 2,5xd1)	15-20	Cutting Oil/Emulsion	Possible use
Free cutting steels up to 800 N/mm2	through hole (thread length L > 1,5xd1)	15-20	Cutting Oil/Emulsion	Possible use
Free cutting steels up to 800 N/mm2	blind hole (thread length L < 1,5xd1)	15-20	Cutting Oil/Emulsion	Possible use
Free cutting steels up to 800 N/mm2	blind hole (thread length L > 2,5xd1)	15-20	Cutting Oil/Emulsion	Possible use
Free cutting steels up to 800 N/mm2	through hole (thread length L < 1,5xd1)	15-20	Cutting Oil/Emulsion	Possible use
Free cutting steels up to 800 N/mm2	blind hole (thread length L < 2xd1)	15-20	Cutting Oil/Emulsion	Possible use
Structural steels and heat-treated steels up to 800 N/mm2	blind hole (thread length L < 1,5xd1)	15-20	Cutting Oil/Emulsion	Possible use
Structural steels and heat-treated steels up to 800 N/mm2	blind hole (thread length L > 2,5xd1)	15-20	Cutting Oil/Emulsion	Possible use
Structural steels and heat-treated steels up to 800 N/mm2	through hole (thread length L < 1,5xd1)	15-20	Cutting Oil/Emulsion	Possible use
Structural steels and heat-treated steels up to 800 N/mm2	blind hole (thread length L < 2xd1)	15-20	Cutting Oil/Emulsion	Possible use
Structural steels and heat-treated steels up to 800 N/mm2	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	15-20	Cutting Oil/Emulsion	Possible use
Structural steels and heat-treated steels up to 800 N/mm2	blind hole (thread length L < 2,5xd1)	15-20	Cutting Oil/Emulsion	Possible use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Structural steels and heat-treated steels up to 800 N/mm2	through hole (thread length L > 1,5xd1)	15-20	Cutting Oil/Emulsion	Possible use
Structural steels up to 500 N/mm2	through hole (thread length L < 1,5xd1)	12-20	Cutting Oil/Emulsion	Possible use
Structural steels up to 500 N/mm2	blind hole (thread length L < 2xd1)	12-20	Cutting Oil/Emulsion	Possible use
Structural steels up to 500 N/mm2	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	12-20	Cutting Oil/Emulsion	Possible use
Structural steels up to 500 N/mm2	blind hole (thread length L < 2,5xd1)	12-20	Cutting Oil/Emulsion	Possible use
Structural steels up to 500 N/mm2	through hole (thread length L > 1,5xd1)	12-20	Cutting Oil/Emulsion	Possible use
Structural steels up to 500 N/mm2	blind hole (thread length L < 1,5xd1)	12-20	Cutting Oil/Emulsion	Possible use
Structural steels up to 500 N/mm2	blind hole (thread length L > 2,5xd1)	12-20	Cutting Oil/Emulsion	Possible use
Unalloyed aluminium	blind hole (thread length L < 2xd1)	15-35	Cutting Oil	Possible use
Unalloyed aluminium	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	15-35	Cutting Oil	Possible use
Unalloyed aluminium	blind hole (thread length L < 2,5xd1)	15-35	Cutting Oil	Possible use
Unalloyed aluminium	through hole (thread length L > 1,5xd1)	15-35	Cutting Oil	Possible use
Unalloyed aluminium	blind hole (thread length L < 1,5xd1)	15-35	Cutting Oil	Possible use
Unalloyed aluminium	blind hole (thread length L > 2,5xd1)	15-35	Cutting Oil	Possible use
Unalloyed aluminium	through hole (thread length L < 1,5xd1)	15-35	Cutting Oil	Possible use
Zinc and zinc alloys	blind hole (thread length L > 2,5xd1)	15-20	Emulsion	Recommended use
Zinc and zinc alloys	through hole (thread length L < 1,5xd1)	15-20	Emulsion	Recommended use
Zinc and zinc alloys	blind hole (thread length L < 2xd1)	15-20	Emulsion	Recommended use
Zinc and zinc alloys	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	15-20	Emulsion	Recommended use
Zinc and zinc alloys	blind hole (thread length L < 2,5xd1)	15-20	Emulsion	Recommended use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Zinc and zinc alloys	through hole (thread length L > 1,5xd1)	15-20	Emulsion	Recommended use
Zinc and zinc alloys	blind hole (thread length L < 1,5xd1)	15-20	Emulsion	Recommended use

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