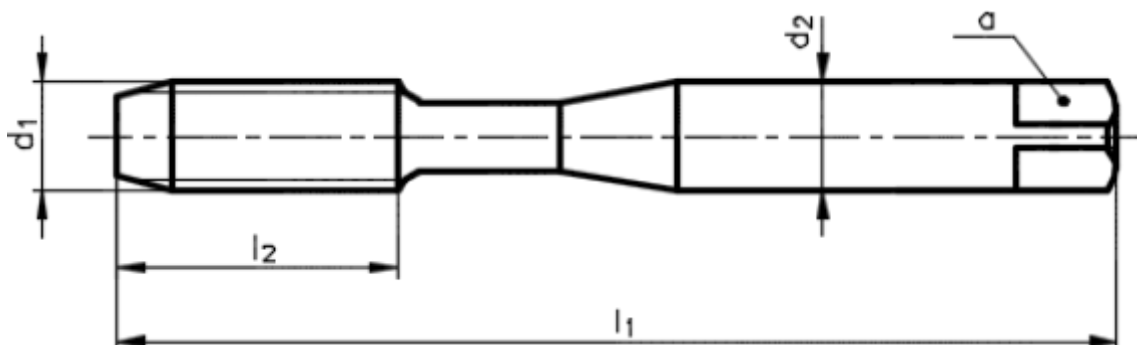


# Forming tap with oil grooves

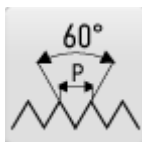


**CATALOGUE NUMBER: 4960NX**

High precision forming tap with oil grooves, metric, DIN 2174, TiN coated, for stainless steels, possible to use in structural steels, plain cast steels, free cutting steels, unalloyed aluminium and aluminium alloys with Si<10 %, unalloyed copper.



**THREAD M**  
ISO Metric coarse thread



**PROFILE SKETCH**  
60°



**TAP STANDARD**  
DIN 2174



**TYPE VA**  
Tap for stainless steels



**TAP MATERIAL**  
Super high speed steel



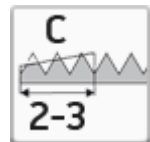
**COATING**  
Titanium nitride coating



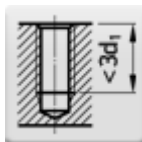
**THREAD TOLERANCE**  
ISO 2 - 6HX



**THREAD TOLERANCE**  
ISO 3 - 6GX



**CHAMFER C**  
Length 2-3 pitch



**HOLE TYPE**  
Blind hole (thread length < 3 d1)

# Select product model

ID	D1	P	Tolerance	I1	I2	d2	a	Price excl. VAT	Price incl. VAT
042035392020000	M2	0,4	6HX	45	8	2,8	2,1	55.90 EUR	67.64 EUR
042035392025000	M2,5	0,45	6HX	50	9	2,8	2,1	53.10 EUR	64.25 EUR
042035392030000	M3	0,5	6HX	56	11	3,5	2,7	49.20 EUR	59.53 EUR
042035392032000	M3	0,35	6HX	56	8	3,5	2,7	91.45 EUR	110.65 EUR
042035392035000	M3,5	0,6	6HX	56	11	4	3	53.10 EUR	64.25 EUR
042035392040000	M4	0,7	6HX	63	13	4,5	3,4	49.20 EUR	59.53 EUR
042035392041000	M4	0,5	6HX	63	10	4,5	3,4	84.85 EUR	102.67 EUR
042035392050000	M5	0,8	6HX	70	16	6	4,9	53.10 EUR	64.25 EUR
042035392051000	M5	0,5	6HX	70	12	6	4,9	86.10 EUR	104.18 EUR
042035392060000	M6	1	6HX	80	19	6	4,9	53.10 EUR	64.25 EUR
042035392068000	M6	0,75	6HX	80	14	6	4,9	87.30 EUR	105.63 EUR
042035392080000	M8	1,25	6HX	90	22	8	6,2	63.55 EUR	76.90 EUR
042035392087000	M8	1	6HX	90	22	8	6,2	93.80 EUR	113.50 EUR
042035392100000	M10	1,5	6HX	100	24	10	8	77.60 EUR	93.90 EUR
042035392107000	M10	1	6HX	90	20	10	8	123.60 EUR	149.56 EUR
042035392120000	M12	1,75	6HX	110	28	9	7	101.05 EUR	122.27 EUR
042035392125000	M12	1,5	6HX	100	22	9	7	107.90 EUR	130.56 EUR
042035392140000	M14	2	6HX	110	30	11	9	145.35 EUR	175.87 EUR
042035392160000	M16	2	6HX	110	32	12	9	147.85 EUR	178.90 EUR
042035392165000	M16	1,5	6HX	100	22	12	9	149.75 EUR	181.20 EUR
042035394020000	M2	0,4	6GX	45	8	2,8	2,1	55.90 EUR	67.64 EUR
042035394025000	M2,5	0,45	6GX	50	9	2,8	2,1	53.10 EUR	64.25 EUR
042035394030000	M3	0,5	6GX	56	11	3,5	2,7	49.20 EUR	59.53 EUR
042035394035000	M3,5	0,6	6GX	56	11	4	3	53.10 EUR	64.25 EUR
042035394040000	M4	0,7	6GX	63	13	4,5	3,4	49.20 EUR	59.53 EUR
042035394050000	M5	0,8	6GX	70	16	6	4,9	53.10 EUR	64.25 EUR
042035394060000	M6	1	6GX	80	19	6	4,9	53.10 EUR	64.25 EUR

ID	D1	P	Tolerance	l1	l2	d2	a	Price excl. VAT	Price incl. VAT
042035394080000	M8	1,25	6GX	90	22	8	6,2	63.55 EUR	76.90 EUR
042035394100000	M10	1,5	6GX	100	24	10	8	77.60 EUR	93.90 EUR
042035394120000	M12	1,75	6GX	110	28	9	7	101.05 EUR	122.27 EUR
042035394140000	M14	2	6GX	110	30	11	9	145.35 EUR	175.87 EUR
042035394160000	M16	2	6GX	110	32	12	9	147.85 EUR	178.90 EUR

## Use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Aluminium alloys si content < 10%	through hole (thread length $L < 1,5 \times d1$ )	20-50	Cutting Oil	Recommended use
Aluminium alloys si content < 10%	blind hole (thread length $L < 2 \times d1$ )	20-50	Cutting Oil	Recommended use
Aluminium alloys si content < 10%	through hole (thread length $L < 0,8 \times d1$ )	20-50	Cutting Oil	Recommended use
Aluminium alloys si content < 10%	blind hole (thread length $< 1,5 \times d1$ , pilot drilling depth $\geq L + d1$ )	20-50	Cutting Oil	Recommended use
Aluminium alloys si content < 10%	blind hole (thread length $L < 2,5 \times d1$ )	20-50	Cutting Oil	Recommended use
Aluminium alloys si content < 10%	through hole (thread length $L > 1,5 \times d1$ )	20-50	Cutting Oil	Recommended use
Aluminium alloys si content < 10%	blind hole (thread length $L < 1,5 \times d1$ )	20-50	Cutting Oil	Recommended use
Aluminium alloys si content < 10%	blind hole (thread length $L > 2,5 \times d1$ )	20-50	Cutting Oil	Recommended use
Aluminium alloys si content > 10%	through hole (thread length $L < 1,5 \times d1$ )	20-50	Cutting Oil	Recommended use
Aluminium alloys si content > 10%	blind hole (thread length $L < 2 \times d1$ )	20-50	Cutting Oil	Recommended use
Aluminium alloys si content > 10%	through hole (thread length $L < 0,8 \times d1$ )	20-50	Cutting Oil	Recommended use
Aluminium alloys si content > 10%	blind hole (thread length $< 1,5 \times d1$ , pilot drilling depth $\geq L + d1$ )	20-50	Cutting Oil	Recommended use
Aluminium alloys si content > 10%	blind hole (thread length $L < 2,5 \times d1$ )	20-50	Cutting Oil	Recommended use

<b>MACHINED MATERIAL</b>	<b>HOLE TYPE</b>	<b>CUTTING SPEED</b>	<b>LUBRICATION</b>	<b>USE</b>
Aluminium alloys si content > 10%	through hole (thread length $L > 1,5d_1$ )	20-50	Cutting Oil	Recommended use
Aluminium alloys si content > 10%	blind hole (thread length $L < 1,5d_1$ )	20-50	Cutting Oil	Recommended use
Aluminium alloys si content > 10%	blind hole (thread length $L > 2,5d_1$ )	20-50	Cutting Oil	Recommended use
Copper alloys (long chipping)	through hole (thread length $L < 1,5d_1$ )	20-40	Cutting Oil	Recommended use
Copper alloys (long chipping)	blind hole (thread length $L < 2xd_1$ )	20-40	Cutting Oil	Recommended use
Copper alloys (long chipping)	through hole (thread length $L < 0,8xd_1$ )	20-40	Cutting Oil	Recommended use
Copper alloys (long chipping)	blind hole (thread length $< 1,5 d_1$ , pilot drilling depth $\geq L+d_1$ )	20-40	Cutting Oil	Recommended use
Copper alloys (long chipping)	blind hole (thread length $L < 2,5xd_1$ )	20-40	Cutting Oil	Recommended use
Copper alloys (long chipping)	through hole (thread length $L > 1,5xd_1$ )	20-40	Cutting Oil	Recommended use
Copper alloys (long chipping)	blind hole (thread length $L < 1,5xd_1$ )	20-40	Cutting Oil	Recommended use
Copper alloys (long chipping)	blind hole (thread length $L > 2,5xd_1$ )	20-40	Cutting Oil	Recommended use
Copper alloys (short chipping)	through hole (thread length $L < 1,5xd_1$ )	20-40	Cutting Oil	Recommended use
Copper alloys (short chipping)	blind hole (thread length $L < 2xd_1$ )	20-40	Cutting Oil	Recommended use
Copper alloys (short chipping)	through hole (thread length $L < 0,8xd_1$ )	20-40	Cutting Oil	Recommended use
Copper alloys (short chipping)	blind hole (thread length $< 1,5 d_1$ , pilot drilling depth $\geq L+d_1$ )	20-40	Cutting Oil	Recommended use
Copper alloys (short chipping)	blind hole (thread length $L < 2,5xd_1$ )	20-40	Cutting Oil	Recommended use
Copper alloys (short chipping)	through hole (thread length $L > 1,5xd_1$ )	20-40	Cutting Oil	Recommended use
Copper alloys (short chipping)	blind hole (thread length $L < 1,5xd_1$ )	20-40	Cutting Oil	Recommended use
Copper alloys (short chipping)	blind hole (thread length $L > 2,5xd_1$ )	20-40	Cutting Oil	Recommended use
Free cutting steels up to 800 N/mm <sup>2</sup>	through hole (thread length $L > 1,5xd_1$ )	18-28	Cutting Oil	Recommended use
Free cutting steels up to 800 N/mm <sup>2</sup>	blind hole (thread length $L < 2,5xd_1$ )	18-28	Cutting Oil	Recommended use
Free cutting steels up to 800 N/mm <sup>2</sup>	blind hole (thread length $< 1,5 d_1$ , pilot drilling depth $\geq L+d_1$ )	18-28	Cutting Oil	Recommended use

<b>MACHINED MATERIAL</b>	<b>HOLE TYPE</b>	<b>CUTTING SPEED</b>	<b>LUBRICATION</b>	<b>USE</b>
Free cutting steels up to 800 N/mm <sup>2</sup>	through hole (thread length $L < 0,8 \times d_1$ )	18-28	Cutting Oil	Recommended use
Free cutting steels up to 800 N/mm <sup>2</sup>	blind hole (thread length $L < 2 \times d_1$ )	18-28	Cutting Oil	Recommended use
Free cutting steels up to 800 N/mm <sup>2</sup>	through hole (thread length $L < 1,5 \times d_1$ )	18-28	Cutting Oil	Recommended use
Free cutting steels up to 800 N/mm <sup>2</sup>	blind hole (thread length $L > 2,5 \times d_1$ )	18-28	Cutting Oil	Recommended use
Free cutting steels up to 800 N/mm <sup>2</sup>	blind hole (thread length $L < 1,5 \times d_1$ )	18-28	Cutting Oil	Recommended use
Plain cast steels up to 500 N/mm <sup>2</sup>	through hole (thread length $L > 1,5 \times d_1$ )	18-28	Cutting Oil	Recommended use
Plain cast steels up to 500 N/mm <sup>2</sup>	blind hole (thread length $L < 2,5 \times d_1$ )	18-28	Cutting Oil	Recommended use
Plain cast steels up to 500 N/mm <sup>2</sup>	blind hole (thread length $< 1,5 \times d_1$ , pilot drilling depth $\geq L + d_1$ )	18-28	Cutting Oil	Recommended use
Plain cast steels up to 500 N/mm <sup>2</sup>	through hole (thread length $L < 0,8 \times d_1$ )	18-28	Cutting Oil	Recommended use
Plain cast steels up to 500 N/mm <sup>2</sup>	blind hole (thread length $L < 2 \times d_1$ )	18-28	Cutting Oil	Recommended use
Plain cast steels up to 500 N/mm <sup>2</sup>	through hole (thread length $L < 1,5 \times d_1$ )	18-28	Cutting Oil	Recommended use
Plain cast steels up to 500 N/mm <sup>2</sup>	blind hole (thread length $L > 2,5 \times d_1$ )	18-28	Cutting Oil	Recommended use
Plain cast steels up to 500 N/mm <sup>2</sup>	blind hole (thread length $L < 1,5 \times d_1$ )	18-28	Cutting Oil	Recommended use
Plain cast steels up to 800 N/mm <sup>2</sup>	through hole (thread length $L > 1,5 \times d_1$ )	18-28	Cutting Oil	Recommended use
Plain cast steels up to 800 N/mm <sup>2</sup>	blind hole (thread length $L < 2,5 \times d_1$ )	18-28	Cutting Oil	Recommended use
Plain cast steels up to 800 N/mm <sup>2</sup>	blind hole (thread length $< 1,5 \times d_1$ , pilot drilling depth $\geq L + d_1$ )	18-28	Cutting Oil	Recommended use
Plain cast steels up to 800 N/mm <sup>2</sup>	through hole (thread length $L < 0,8 \times d_1$ )	18-28	Cutting Oil	Recommended use
Plain cast steels up to 800 N/mm <sup>2</sup>	blind hole (thread length $L < 2 \times d_1$ )	18-28	Cutting Oil	Recommended use
Plain cast steels up to 800 N/mm <sup>2</sup>	through hole (thread length $L < 1,5 \times d_1$ )	18-28	Cutting Oil	Recommended use
Plain cast steels up to 800 N/mm <sup>2</sup>	blind hole (thread length $L > 2,5 \times d_1$ )	18-28	Cutting Oil	Recommended use
Plain cast steels up to 800 N/mm <sup>2</sup>	blind hole (thread length $L < 1,5 \times d_1$ )	18-28	Cutting Oil	Recommended use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm <sup>2</sup>	through hole (thread length $L > 1,5 \times d_1$ )	12-20	Cutting Oil	Recommended use

<b>MACHINED MATERIAL</b>	<b>HOLE TYPE</b>	<b>CUTTING SPEED</b>	<b>LUBRICATION</b>	<b>USE</b>
Stainless steels and heat resisting steels with strength 450 - 800 N/mm <sup>2</sup>	blind hole (thread length $L < 2,5d_1$ )	12-20	Cutting Oil	Recommended use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm <sup>2</sup>	blind hole (thread length $< 1,5 d_1$ , pilot drilling depth $\geq L+d_1$ )	12-20	Cutting Oil	Recommended use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm <sup>2</sup>	through hole (thread length $L < 0,8xd_1$ )	12-20	Cutting Oil	Recommended use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm <sup>2</sup>	blind hole (thread length $L < 2xd_1$ )	12-20	Cutting Oil	Recommended use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm <sup>2</sup>	through hole (thread length $L < 1,5xd_1$ )	12-20	Cutting Oil	Recommended use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm <sup>2</sup>	blind hole (thread length $L > 2,5xd_1$ )	12-20	Cutting Oil	Recommended use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm <sup>2</sup>	blind hole (thread length $L < 1,5xd_1$ )	12-20	Cutting Oil	Recommended use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm <sup>2</sup>	through hole (thread length $L < 1,5xd_1$ )	12-20	Cutting Oil	Recommended use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm <sup>2</sup>	blind hole (thread length $L < 2xd_1$ )	12-20	Cutting Oil	Recommended use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm <sup>2</sup>	through hole (thread length $L < 0,8xd_1$ )	12-20	Cutting Oil	Recommended use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm <sup>2</sup>	blind hole (thread length $< 1,5 d_1$ , pilot drilling depth $\geq L+d_1$ )	12-20	Cutting Oil	Recommended use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm <sup>2</sup>	blind hole (thread length $L < 2,5xd_1$ )	12-20	Cutting Oil	Recommended use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm <sup>2</sup>	through hole (thread length $L > 1,5xd_1$ )	12-20	Cutting Oil	Recommended use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm <sup>2</sup>	blind hole (thread length $L < 1,5xd_1$ )	12-20	Cutting Oil	Recommended use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm <sup>2</sup>	blind hole (thread length $L > 2,5xd_1$ )	12-20	Cutting Oil	Recommended use
Structural steels and heat-treated steels up to 800 N/mm <sup>2</sup>	through hole (thread length $L > 1,5xd_1$ )	18-28	Cutting Oil	Recommended use
Structural steels and heat-treated steels up to 800 N/mm <sup>2</sup>	blind hole (thread length $L < 2,5xd_1$ )	18-28	Cutting Oil	Recommended use
Structural steels and heat-treated steels up to 800 N/mm <sup>2</sup>	blind hole (thread length $< 1,5 d_1$ , pilot drilling depth $\geq L+d_1$ )	18-28	Cutting Oil	Recommended use
Structural steels and heat-treated steels up to 800 N/mm <sup>2</sup>	through hole (thread length $L < 0,8xd_1$ )	18-28	Cutting Oil	Recommended use
Structural steels and heat-treated steels up to 800 N/mm <sup>2</sup>	blind hole (thread length $L < 2xd_1$ )	18-28	Cutting Oil	Recommended use

<b>MACHINED MATERIAL</b>	<b>HOLE TYPE</b>	<b>CUTTING SPEED</b>	<b>LUBRICATION</b>	<b>USE</b>
Structural steels and heat-treated steels up to 800 N/mm <sup>2</sup>	through hole (thread length $L < 1,5d_1$ )	18-28	Cutting Oil	Recommended use
Structural steels and heat-treated steels up to 800 N/mm <sup>2</sup>	blind hole (thread length $L > 2,5d_1$ )	18-28	Cutting Oil	Recommended use
Structural steels and heat-treated steels up to 800 N/mm <sup>2</sup>	blind hole (thread length $L < 1,5d_1$ )	18-28	Cutting Oil	Recommended use
Structural steels up to 500 N/mm <sup>2</sup>	through hole (thread length $L > 1,5d_1$ )	18-28	Cutting Oil	Recommended use
Structural steels up to 500 N/mm <sup>2</sup>	blind hole (thread length $L < 2,5d_1$ )	18-28	Cutting Oil	Recommended use
Structural steels up to 500 N/mm <sup>2</sup>	blind hole (thread length $< 1,5 d_1$ , pilot drilling depth $\geq L+d_1$ )	18-28	Cutting Oil	Recommended use
Structural steels up to 500 N/mm <sup>2</sup>	through hole (thread length $L < 0,8d_1$ )	18-28	Cutting Oil	Recommended use
Structural steels up to 500 N/mm <sup>2</sup>	blind hole (thread length $L < 2xd_1$ )	18-28	Cutting Oil	Recommended use
Structural steels up to 500 N/mm <sup>2</sup>	through hole (thread length $L < 1,5d_1$ )	18-28	Cutting Oil	Recommended use
Structural steels up to 500 N/mm <sup>2</sup>	blind hole (thread length $L > 2,5d_1$ )	18-28	Cutting Oil	Recommended use
Structural steels up to 500 N/mm <sup>2</sup>	blind hole (thread length $L < 1,5d_1$ )	18-28	Cutting Oil	Recommended use
Unalloyed aluminium	through hole (thread length $L < 1,5d_1$ )	20-50	Cutting Oil	Recommended use
Unalloyed aluminium	blind hole (thread length $L < 2xd_1$ )	20-50	Cutting Oil	Recommended use
Unalloyed aluminium	through hole (thread length $L < 0,8d_1$ )	20-50	Cutting Oil	Recommended use
Unalloyed aluminium	blind hole (thread length $< 1,5 d_1$ , pilot drilling depth $\geq L+d_1$ )	20-50	Cutting Oil	Recommended use
Unalloyed aluminium	blind hole (thread length $L < 2,5d_1$ )	20-50	Cutting Oil	Recommended use
Unalloyed aluminium	through hole (thread length $L > 1,5d_1$ )	20-50	Cutting Oil	Recommended use
Unalloyed aluminium	blind hole (thread length $L < 1,5d_1$ )	20-50	Cutting Oil	Recommended use
Unalloyed aluminium	blind hole (thread length $L > 2,5d_1$ )	20-50	Cutting Oil	Recommended use
Unalloyed copper	through hole (thread length $L < 1,5d_1$ )	20-40	Cutting Oil	Recommended use
Unalloyed copper	blind hole (thread length $L < 2xd_1$ )	20-40	Cutting Oil	Recommended use
Unalloyed copper	through hole (thread length $L < 0,8d_1$ )	20-40	Cutting Oil	Recommended use

<b>MACHINED MATERIAL</b>	<b>HOLE TYPE</b>	<b>CUTTING SPEED</b>	<b>LUBRICATION</b>	<b>USE</b>
Unalloyed copper	blind hole (thread length $< 1,5 d_1$ , pilot drilling depth $\geq L+d_1$ )	20-40	Cutting Oil	Recommended use
Unalloyed copper	blind hole (thread length $L < 2,5xd_1$ )	20-40	Cutting Oil	Recommended use
Unalloyed copper	through hole (thread length $L > 1,5xd_1$ )	20-40	Cutting Oil	Recommended use
Unalloyed copper	blind hole (thread length $L < 1,5xd_1$ )	20-40	Cutting Oil	Recommended use
Unalloyed copper	blind hole (thread length $L > 2,5xd_1$ )	20-40	Cutting Oil	Recommended use

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