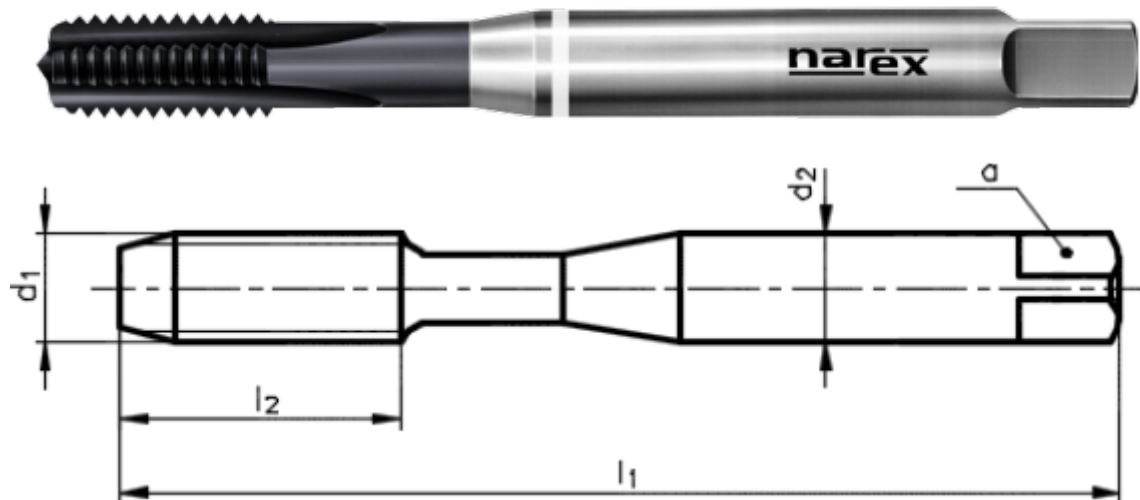


Machine tap with straight flutes

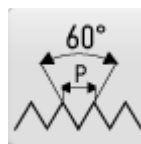


CATALOGUE NUMBER: 1080

Machine tap with straight flutes, metric, DIN 371, TiCN coated, suitable for grey cast iron, aluminium alloys with Si > 10 %.



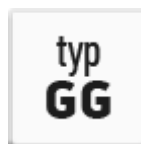
THREAD M
ISO Metric coarse thread



PROFILE SKETCH
60°



THREAD STANDARD
DIN 13



TYPE GG
Tap for cast iron



TAP MATERIAL
Super high speed steel



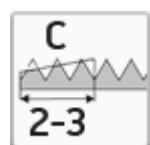
COATING
Titanium carbonitridenitride coating



TAP STANDARD
DIN 371



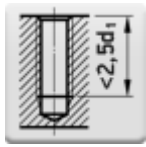
THREAD TOLERANCE
ISO 2 - 6HX



CHAMFER C
Length 2-3 pitch



HOLE TYPE
Through hole (thread length $L > 1,5d_1$)



HOLE TYPE

Blind hole (thread length $< 2,5 d_1$)

Select product model

ID	D1	P	Tolerance	l1	l2	d2	a	Price excl. VAT	Price incl. VAT
041538029030000	M3	0,5	6HX	56	9	3,5	2,7	12.75 EUR	15.43 EUR
041538029040000	M4	0,7	6HX	63	12	4,5	3,4	13.00 EUR	15.73 EUR
041538029050000	M5	0,8	6HX	70	13	6	4,9	13.45 EUR	16.27 EUR
041538029060000	M6	1	6HX	80	15	6	4,9	13.90 EUR	16.82 EUR
041538029080000	M8	1,25	6HX	90	18	8	6,2	15.35 EUR	18.57 EUR
041538029100000	M10	1,5	6HX	100	20	10	8	18.55 EUR	22.45 EUR

Use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Aluminium alloys si content $> 10\%$	through hole (thread length $L < 1,5d_1$)	12-20	Emulsion	Possible use
Aluminium alloys si content $> 10\%$	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$)	12-20	Emulsion	Possible use
Grey cast iron	blind hole (thread length $L < 1,5d_1$)	15-20	Emulsion	Recommended use
Grey cast iron	through hole (thread length $L < 1,5d_1$)	15-20	Emulsion	Recommended use
Grey cast iron	blind hole (thread length $L < 2xd_1$)	15-20	Emulsion	Recommended use
Grey cast iron	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$)	15-20	Emulsion	Recommended use
Grey cast iron	blind hole (thread length $L < 2,5xd_1$)	15-20	Emulsion	Recommended use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Grey cast iron	through hole (thread length L > 1,5xd1)	15-20	Emulsion	Recommended use

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