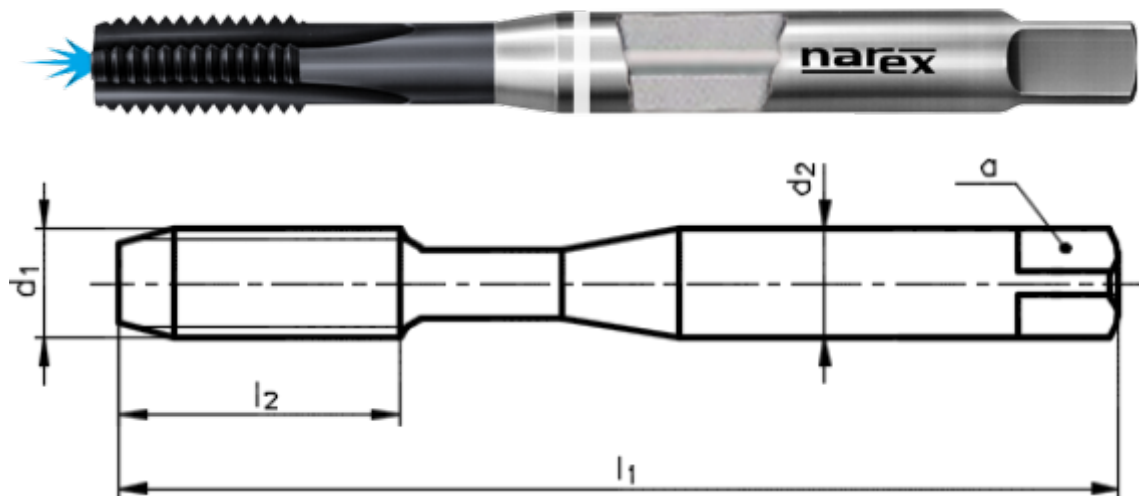


# Machine tap with straight flutes

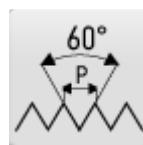


## CATALOGUE NUMBER: 1080IKZ

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



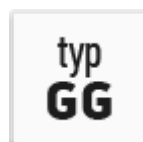
**THREAD M**  
ISO Metric coarse thread



**PROFILE SKETCH**  
60°



**THREAD STANDARD**  
DIN13



**TYPE GG**  
Tap for čast iron



**TAP MATERIAL**  
Super high speed steel



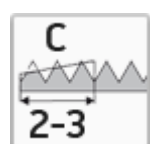
**COATING**  
Titanium carbonitridenitride coating



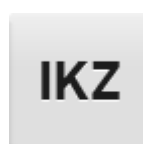
**TAP STANDARD**  
DIN 371



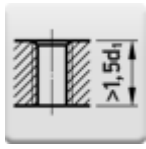
**THREAD TOLERANCE**  
ISO 2 - 6HX



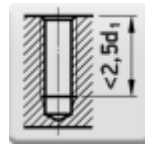
**CHAMFER C**  
Length 2-3 pitch



**COOLING METHOD**  
Internal axial coolant supply



**HOLE TYPE**  
Through hole (thread length  $L > 1,5 \times d1$ )



**HOLE TYPE**  
Blind hole (thread length  $< 2,5 d1$ )

## Select product model

ID	D1	P	Tolerance	I1	I2	d2	a	Price excl. VAT	Price incl. VAT
041638029050000	M5	0,8	6HX	70	13	6	4,9	28.15 EUR	34.06 EUR
041638029060000	M6	1	6HX	80	15	6	4,9	30.25 EUR	36.60 EUR
041638029080000	M8	1,25	6HX	90	18	8	6,2	31.70 EUR	38.36 EUR
041638029100000	M10	1,5	6HX	100	20	10	8	36.55 EUR	44.23 EUR

## Use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Aluminium alloys si content > 10%	through hole (thread length $L < 1,5 \times d1$ )	12-20	Emulsion	Possible use
Aluminium alloys si content > 10%	blind hole (thread length $< 1,5 d1$ , pilot drilling depth $\geq L+d1$ )	12-20	Emulsion	Possible use
Grey cast iron	blind hole (thread length $L < 2,5 \times d1$ )	15-20	Emulsion	Recommended use
Grey cast iron	through hole (thread length $L > 1,5 \times d1$ )	15-20	Emulsion	Recommended use
Grey cast iron	blind hole (thread length $L < 1,5 \times d1$ )	15-20	Emulsion	Recommended use
Grey cast iron	through hole (thread length $L < 1,5 \times d1$ )	15-20	Emulsion	Recommended use
Grey cast iron	blind hole (thread length $L < 2 \times d1$ )	15-20	Emulsion	Recommended use
Grey cast iron	blind hole (thread length $< 1,5 d1$ , pilot drilling depth $\geq L+d1$ )	15-20	Emulsion	Recommended use

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