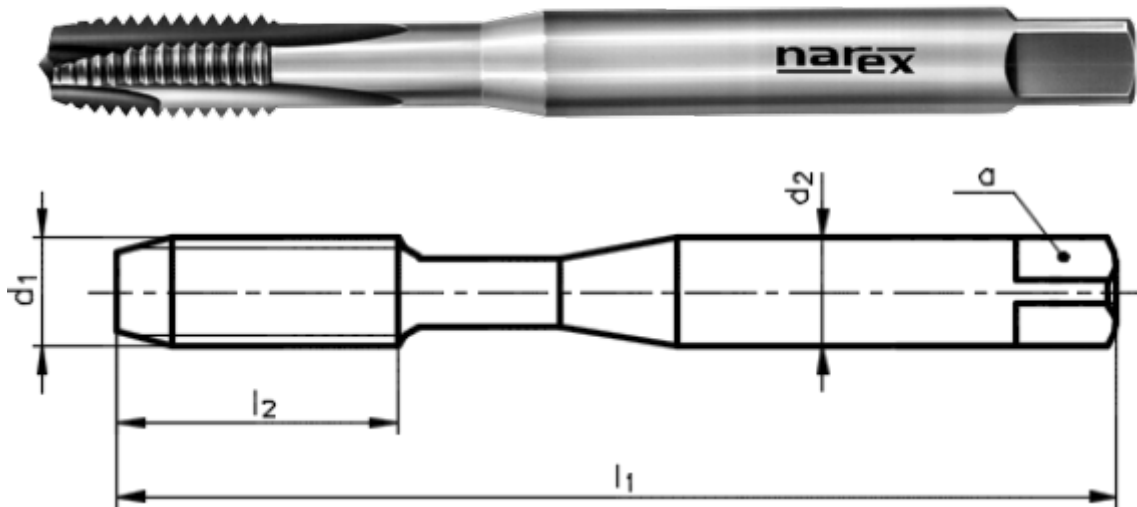


# Machine tap with straight flutes and spiral point

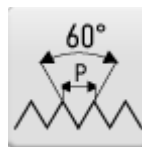


## CATALOGUE NUMBER: 1500

Machine tap with straight flutes and spiral point, metric, DIN 371, suitable for structural steels, plain cast steels, free cutting steels, short chipping copper alloys, spheroidal and malleable cast iron, aluminium alloys with Si<10%.



**THREAD M**  
ISO Metric coarse thread



**PROFILE SKETCH**  
60°



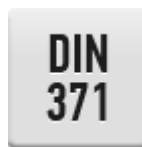
**THREAD STANDARD**  
DIN13



**TYPE N**  
Tap for steels up to 800 N/mm<sup>2</sup>



**TAP MATERIAL**  
Super high speed steel



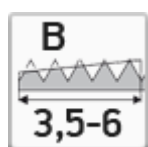
**TAP STANDARD**  
DIN 371



**THREAD TOLERANCE**  
ISO 2 - 6H



**THREAD TOLERANCE**  
ISO 3 - 6G



**CHAMFER B**  
Length 3,5-6 pitch



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

# Select product model

ID	D1	P	Tolerance	l1	l2	d2	a	Price excl. VAT	Price incl. VAT
041531052020000	M2	0,4	6H	45	8	2,8	2,1	9.22 EUR	11.16 EUR
041531052025000	M2,5	0,45	6H	50	9	2,8	2,1	8.86 EUR	10.72 EUR
041531052030000	M3	0,5	6H	56	9	3,5	2,7	7.34 EUR	8.88 EUR
041531052035000	M3,5	0,6	6H	56	11	4	3	7.96 EUR	9.63 EUR
041531052040000	M4	0,7	6H	63	12	4,5	3,4	7.55 EUR	9.14 EUR
041531052050000	M5	0,8	6H	70	13	6	4,9	7.96 EUR	9.63 EUR
041531052060000	M6	1	6H	80	15	6	4,9	7.96 EUR	9.63 EUR
041531052070000	M7	1	6H	80	15	7	5,5	9.90 EUR	11.98 EUR
041531052080000	M8	1,25	6H	90	18	8	6,2	9.17 EUR	11.10 EUR
041531052100000	M10	1,5	6H	100	20	10	8	11.06 EUR	13.38 EUR
041531054030000	M3	0,5	6G	56	9	3,5	2,7	7.34 EUR	8.88 EUR
041531054035000	M3,5	0,6	6G	56	11	4	3	7.96 EUR	9.63 EUR
041531054040000	M4	0,7	6G	63	12	4,5	4,9	7.55 EUR	9.14 EUR
041531054050000	M5	0,8	6G	70	13	6	4,9	7.96 EUR	9.63 EUR
041531054060000	M6	1	6G	80	15	6	4,9	7.96 EUR	9.63 EUR
041531054080000	M8	1,25	6G	90	18	8	6,2	9.17 EUR	11.10 EUR
041531054100000	M10	1,5	6G	100	20	10	8	11.06 EUR	13.38 EUR

## Use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Aluminium alloys si content < 10%	through hole (thread length L < 1,5xd1)	14-20	Emulsion	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 $L > 1,5d_1$ )	14-20	Emulsion	Recommended use
Aluminium alloys si content > 10%	through hole (thread length $L > 1,5d_1$ )	12-15	Emulsion	Possible use
Aluminium alloys si content > 10%	through hole (thread length $L < 1,5d_1$ )	12-15	Emulsion	Possible use
Copper alloys (short chipping)	through hole (thread length $L > 1,5d_1$ )	12-20	Cutting Oil/Emulsion	Possible use
Copper alloys (short chipping)	through hole (thread length $L < 1,5d_1$ )	12-20	Cutting Oil/Emulsion	Possible use
Free cutting steels up to 800 N/mm <sup>2</sup>	through hole (thread length $L > 1,5d_1$ )	10-14	Cutting Oil/Emulsion	Possible use
Free cutting steels up to 800 N/mm <sup>2</sup>	through hole (thread length $L < 1,5d_1$ )	10-14	Cutting Oil/Emulsion	Possible use
Plain cast steels up to 500 N/mm <sup>2</sup>	through hole (thread length $L < 1,5d_1$ )	6-10	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 500 N/mm <sup>2</sup>	through hole (thread length $L > 1,5d_1$ )	6-10	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 800 N/mm <sup>2</sup>	through hole (thread length $L < 1,5d_1$ )	10-14	Cutting Oil/Emulsion	Possible use
Plain cast steels up to 800 N/mm <sup>2</sup>	through hole (thread length $L > 1,5d_1$ )	10-14	Cutting Oil/Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	through hole (thread length $L < 1,5d_1$ )	4-7	Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length $< 1,5 d_1$ , pilot drilling depth $\geq L+d_1$ )	4-7	Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	through hole (thread length $L > 1,5d_1$ )	4-7	Emulsion	Possible use
Structural steels and heat-treated steels up to 800 N/mm <sup>2</sup>	through hole (thread length $L > 1,5d_1$ )	10-14	Cutting Oil/Emulsion	Recommended use
Structural steels and heat-treated steels up to 800 N/mm <sup>2</sup>	through hole (thread length $L < 1,5d_1$ )	10-14	Cutting Oil/Emulsion	Recommended use
Structural steels up to 500 N/mm <sup>2</sup>	through hole (thread length $L < 1,5d_1$ )	5-8	Cutting Oil/Emulsion	Possible use
Structural steels up to 500 N/mm <sup>2</sup>	through hole (thread length $L > 1,5d_1$ )	5-8	Cutting Oil/Emulsion	Possible use

**NAREX Ždánice, spol. s r.o.**

Městečko 250  
696 32 Ždánice, Česká republika

Tel.: +420 518 607 111  
Fax: +420 518 607 153  
E-mail: [sales@narexzd.cz](mailto:sales@narexzd.cz)  
Web: [www.narexzd.cz](http://www.narexzd.cz)