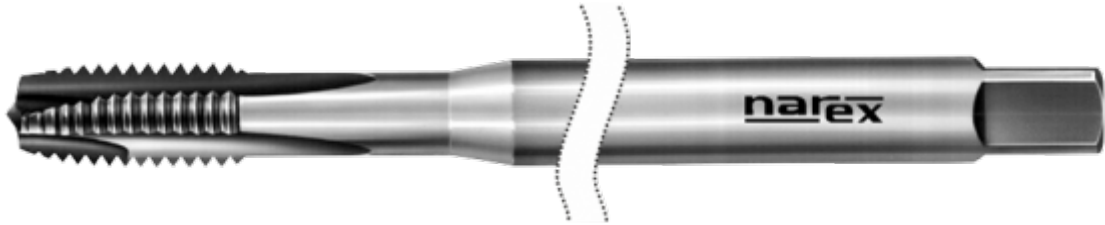


Extra long shank machine tap with straight flutes and spiral point L=100 mm

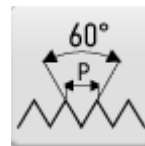


CATALOGUE NUMBER: 1500XL

Machine tap with straight flutes and spiral point, metric, extended to L=100 mm, the rest the same as 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/mm2



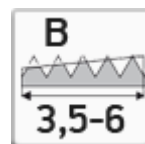
TAP MATERIAL
Super high speed steel



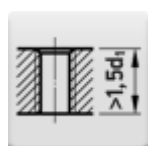
TAP STANDARD
~ DIN 371



THREAD TOLERANCE
ISO 2 - 6H



CHAMFER B
Length 3,5-6 pitch



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

Select product model

ID	D1	P	Tolerance	I1	I2	d2	a	Price excl. VAT	Price incl. VAT
042131052030000	M3	0,5	6H	100	11	3,5	2,7	16.85 EUR	20.39 EUR
042131052040000	M4	0,7	6H	100	13	4,5	3,4	17.25 EUR	20.87 EUR
042131052050000	M5	0,8	6H	100	16	6	4,9	18.15 EUR	21.96 EUR
042131052060000	M6	1	6H	100	19	6	4,9	18.15 EUR	21.96 EUR
042131052080000	M8	1,25	6H	100	22	8	6,2	21.00 EUR	25.41 EUR
042131052100000	M10	1,5	6H	100	24	10	8	25.25 EUR	30.55 EUR
042131052120000	M12	1,75	6H	100	29	12	9	29.80 EUR	36.06 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
Aluminium alloys si content < 10%	through hole (thread length L > 1,5xd1)	14-20	Emulsion	Recommended use
Aluminium alloys si content > 10%	through hole (thread length L > 1,5xd1)	12-15	Emulsion	Possible use
Aluminium alloys si content > 10%	through hole (thread length L < 1,5xd1)	12-15	Emulsion	Possible use
Copper alloys (short chipping)	through hole (thread length L > 1,5xd1)	12-20	Cutting Oil/Emulsion	Possible use
Copper alloys (short chipping)	through hole (thread length L < 1,5xd1)	12-20	Cutting Oil/Emulsion	Possible use
Free cutting steels up to 800 N/mm2	through hole (thread length L > 1,5xd1)	10-14	Cutting Oil/Emulsion	Possible use
Free cutting steels up to 800 N/mm2	through hole (thread length L < 1,5xd1)	10-14	Cutting Oil/Emulsion	Possible use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Plain cast steels up to 500 N/mm ²	through hole (thread length $L < 1,5d_1$)	6-10	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 500 N/mm ²	through hole (thread length $L > 1,5d_1$)	6-10	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 800 N/mm ²	through hole (thread length $L < 1,5d_1$)	10-14	Cutting Oil/Emulsion	Possible use
Plain cast steels up to 800 N/mm ²	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 ²	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 ²	through hole (thread length $L < 1,5d_1$)	10-14	Cutting Oil/Emulsion	Recommended use
Structural steels up to 500 N/mm ²	through hole (thread length $L < 1,5d_1$)	5-8	Cutting Oil/Emulsion	Possible use
Structural steels up to 500 N/mm ²	through hole (thread length $L > 1,5d_1$)	5-8	Cutting Oil/Emulsion	Possible use

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