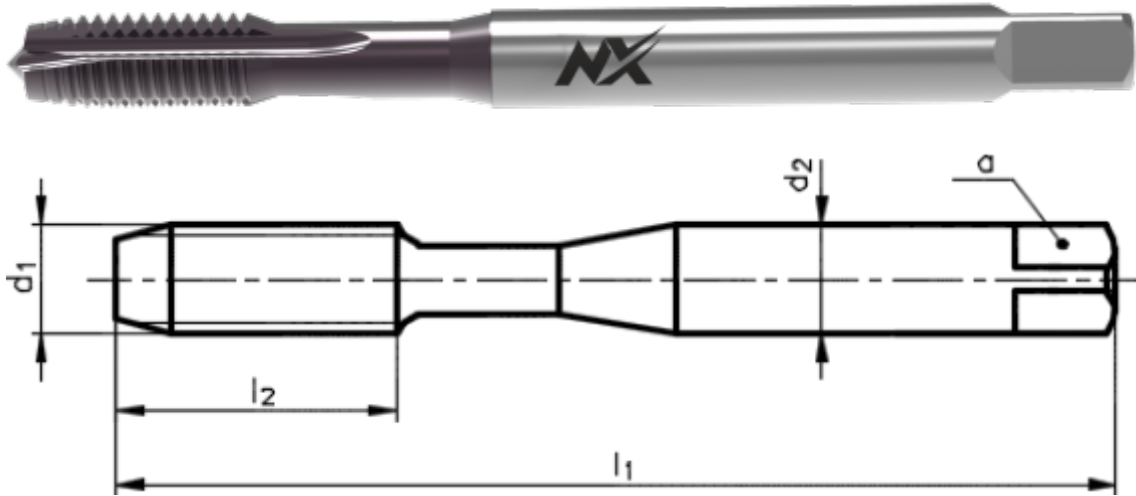


Machine tap with straight flute and spiral point

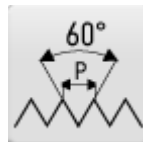


CATALOGUE NUMBER: 1680NX

High performance machine tap with straight flutes and spiral point, metric, DIN 371, TiCN coated, suitable for structural steels, cast steels, case hardened and nitriding steels, high alloyed steels, tool steels, stainless steels with strength up to 1000 N/mm², spheroidal and malleable cast iron, aluminium alloys, copper and zinc alloys.



THREAD M
ISO Metric coarse thread



PROFILE SKETCH
60°



THREAD STANDARD
DIN13



TYPE VA
Tap for stainless steels



TAP MATERIAL
Vanadium extra high speed steel HSSE V3



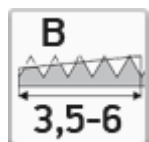
COATING
Titanium carbonitridenitride coating



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
042038062030000	M3	0,5	6H	56	11	3,5	2,7	28.90 EUR	34.97 EUR
042038062040000	M4	0,7	6H	63	13	4,5	3,4	28.90 EUR	34.97 EUR
042038062050000	M5	0,8	6H	70	16	6	4,9	29.85 EUR	36.12 EUR
042038062060000	M6	1	6H	80	19	6	4,9	30.70 EUR	37.15 EUR
042038062080000	M8	1,25	6H	90	22	8	6,2	42.85 EUR	51.85 EUR
042038062100000	M10	1,5	6H	100	24	10	8	55.55 EUR	67.22 EUR

Use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Aluminium alloys si content < 10%	through hole (thread length L > 1,5xd1)	15-20	Cutting Oil/Emulsion	Possible use
Aluminium alloys si content < 10%	through hole (thread length L < 1,5xd1)	15-20	Cutting Oil/Emulsion	Possible use
Aluminium alloys si content > 10%	through hole (thread length L > 1,5xd1)	15-20	Cutting Oil/Emulsion	Recommended use
Aluminium alloys si content > 10%	through hole (thread length L < 1,5xd1)	15-20	Cutting Oil/Emulsion	Recommended use
Case hardened steels and nitriding steels up to 1100 N/mm2	through hole (thread length L > 1,5xd1)	15-20	Cutting Oil/Emulsion	Recommended use
Case hardened steels and nitriding steels up to 1100 N/mm2	through hole (thread length L < 1,5xd1)	15-20	Cutting Oil/Emulsion	Recommended use
Copper alloys (long chipping)	through hole (thread length L > 1,5xd1)	10-12	Cutting Oil/Emulsion	Possible use
Copper alloys (long chipping)	through hole (thread length L < 1,5xd1)	10-12	Cutting Oil/Emulsion	Possible use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Copper alloys (short chipping)	through hole (thread length L < 1,5xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Copper alloys (short chipping)	through hole (thread length L > 1,5xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Free cutting steels up to 800 N/mm2	through hole (thread length L < 1,5xd1)	15-20	Cutting Oil/Emulsion	Possible use
Free cutting steels up to 800 N/mm2	through hole (thread length L > 1,5xd1)	15-20	Cutting Oil/Emulsion	Possible use
Heat-treated steels up to 1100 N/mm2	through hole (thread length L > 1,5xd1)	15-20	Cutting Oil/Emulsion	Recommended use
Heat-treated steels up to 1100 N/mm2	through hole (thread length L < 1,5xd1)	15-20	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 800 N/mm2	through hole (thread length L > 1,5xd1)	15-20	Cutting Oil/Emulsion	Possible use
Plain cast steels up to 800 N/mm2	through hole (thread length L < 1,5xd1)	15-20	Cutting Oil/Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	through hole (thread length L > 1,5xd1)	15-20	Cutting Oil/Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	through hole (thread length L < 1,5xd1)	15-20	Cutting Oil/Emulsion	Possible use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm2	through hole (thread length L > 1,5xd1)	15-20	Cutting Oil/Emulsion	Recommended use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm2	through hole (thread length L < 1,5xd1)	15-20	Cutting Oil/Emulsion	Recommended use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm2	through hole (thread length L > 1,5xd1)	15-20	Cutting Oil/Emulsion	Recommended use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm2	through hole (thread length L < 1,5xd1)	15-20	Cutting Oil/Emulsion	Recommended use
Structural steels and heat-treated steels up to 800 N/mm2	through hole (thread length L > 1,5xd1)	15-20	Cutting Oil/Emulsion	Possible use
Structural steels and heat-treated steels up to 800 N/mm2	through hole (thread length L < 1,5xd1)	15-20	Cutting Oil/Emulsion	Possible use
Tool steels up to 1100 N/mm2	through hole (thread length L < 1,5xd1)	15-20	Cutting Oil/Emulsion	Recommended use
Tool steels up to 1100 N/mm2	through hole (thread length L > 1,5xd1)	15-20	Cutting Oil/Emulsion	Recommended use
Unalloyed aluminium	through hole (thread length L < 1,5xd1)	15-35	Cutting Oil/Emulsion	Possible use
Unalloyed aluminium	through hole (thread length L > 1,5xd1)	15-35	Cutting Oil/Emulsion	Possible use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Unalloyed copper	through hole (thread length L > 1,5xd1)	20-25	Cutting Oil/Emulsion	Possible use
Unalloyed copper	through hole (thread length L < 1,5xd1)	20-25	Cutting Oil/Emulsion	Possible use
Zinc and zinc alloys	through hole (thread length L > 1,5xd1)	10-12	Cutting Oil/Emulsion	Possible use
Zinc and zinc alloys	through hole (thread length L < 1,5xd1)	10-12	Cutting Oil/Emulsion	Possible use

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