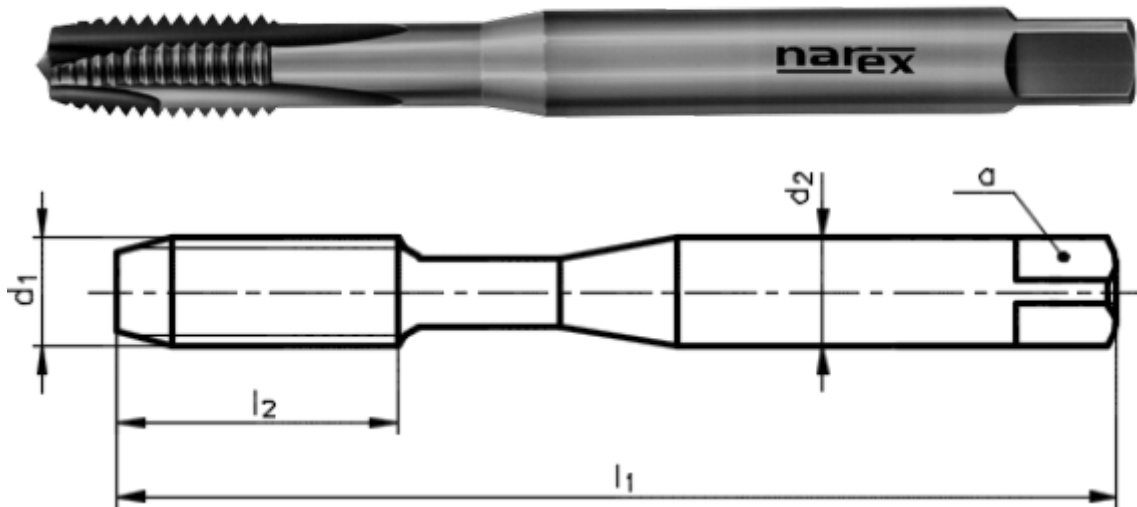


# Machine tap with straight flutes and spiral point

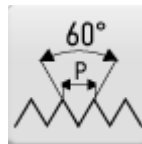


## CATALOGUE NUMBER: 1690

Machine tap with straight flutes and spiral point, metric, DIN 371, steam oxidized, suitable for case hardened and nitriding steels, stainless steels with strength up to 1000 N/mm<sup>2</sup>.



**THREAD M**  
ISO Metric coarse thread



**PROFILE SKETCH**  
60°



**THREAD STANDARD**  
DIN13



**TYPE VA**  
Tap for stainless steels



**TAP MATERIAL**  
Super high speed steel



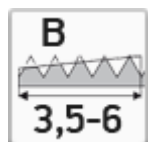
**COATING**  
Oxidation



**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
041537062030000	M3	0,5	6H	56	9	3,5	2,7	10.95 EUR	13.25 EUR
041537062040000	M4	0,7	6H	63	12	4,5	3,4	11.10 EUR	13.43 EUR
041537062050000	M5	0,8	6H	70	13	6	4,9	11.50 EUR	13.92 EUR
041537062060000	M6	1	6H	80	15	6	4,9	11.55 EUR	13.98 EUR
041537062080000	M8	1,25	6H	90	18	8	6,2	13.45 EUR	16.27 EUR
041537062100000	M10	1,5	6H	100	20	10	8	15.65 EUR	18.94 EUR

## Use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Case hardened steels and nitriding steels up to 1100 N/mm2	through hole (thread length L > 1,5xd1)	3-5	Cutting Oil	Possible use
Case hardened steels and nitriding steels up to 1100 N/mm2	through hole (thread length L < 1,5xd1)	3-5	Cutting Oil	Possible use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm2	through hole (thread length L < 1,5xd1)	4-7	Cutting Oil	Possible use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm2	through hole (thread length L > 1,5xd1)	4-7	Cutting Oil	Possible use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm2	through hole (thread length L > 1,5xd1)	3-5	Cutting Oil	Possible use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm2	through hole (thread length L < 1,5xd1)	3-5	Cutting Oil	Possible use

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