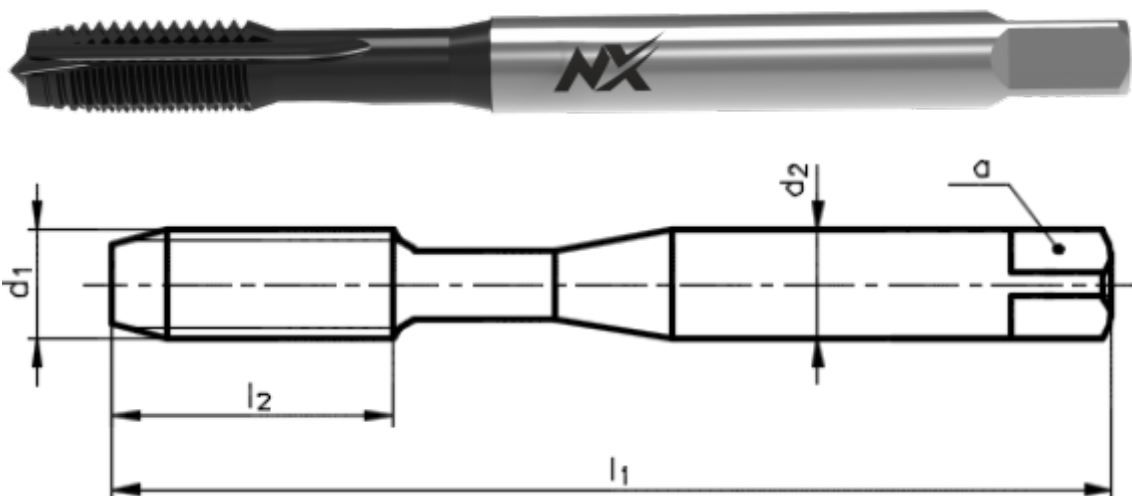


# Machine tap with straight flute and spiral point

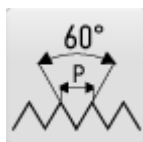


## CATALOGUE NUMBER: 1690NX

High performance machine tap with straight flutes and spiral point, metric, DIN 371, steam oxidized, suitable for structural steels, cast steels, case hardened and nitriding steels, high alloyed steels, tool steels, stainless steels with strength up to 1000 N/mm<sup>2</sup>, spheroidal and malleable cast iron, aluminium alloys, copper and zinc alloys.



**THREAD M**  
ISO Metric coarse thread



**PROFILE SKETCH**  
60°



**THREAD STANDARD**  
DIN13



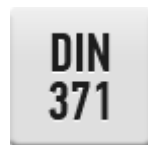
**TYPE VA**  
Tap for stainless steels



**TAP MATERIAL**  
Vanadium extra high speed steel HSSE V3



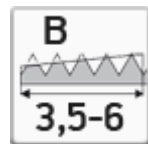
**COATING**  
Oxidation



**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	l1	l2	d2	a	Price excl. VAT	Price incl. VAT
042037062020000	M2	0,4	6H	45	8	2,8	2,1	36.60 EUR	44.29 EUR
042037062025000	M2,5	0,45	6H	50	9	2,8	2,1	32.45 EUR	39.26 EUR
042037062030000	M3	0,5	6H	56	11	3,5	2,7	22.85 EUR	27.65 EUR
042037062035000	M3,5	0,6	6H	56	12	4	3	25.50 EUR	30.86 EUR
042037062040000	M4	0,7	6H	63	13	4,5	3,4	21.90 EUR	26.50 EUR
042037062050000	M5	0,8	6H	70	16	6	4,9	22.40 EUR	27.10 EUR
042037062060000	M6	1	6H	80	19	6	4,9	23.75 EUR	28.74 EUR
042037062080000	M8	1,25	6H	90	22	8	6,2	34.20 EUR	41.38 EUR
042037062100000	M10	1,5	6H	100	24	10	8	43.60 EUR	52.76 EUR

## Use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Aluminium alloys si content < 10%	through hole (thread length L < 1,5xd1)	10-12	Cutting Oil/Emulsion	Possible use
Aluminium alloys si content < 10%	through hole (thread length L > 1,5xd1)	10-12	Cutting Oil/Emulsion	Possible use
Aluminium alloys si content > 10%	through hole (thread length L < 1,5xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Aluminium alloys si content > 10%	through hole (thread length L > 1,5xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Case hardened steels and nitriding steels up to 1100 N/mm2	through hole (thread length L < 1,5xd1)	8-10	Cutting Oil/Emulsion	Recommended use
Case hardened steels and nitriding steels up to 1100 N/mm2	through hole (thread length L > 1,5xd1)	8-10	Cutting Oil/Emulsion	Recommended use

<b>MACHINED MATERIAL</b>	<b>HOLE TYPE</b>	<b>CUTTING SPEED</b>	<b>LUBRICATION</b>	<b>USE</b>
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
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)	8-10	Cutting Oil/Emulsion	Recommended use
Heat-treated steels up to 1100 N/mm2	through hole (thread length L < 1,5xd1)	8-10	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)	10-12	Cutting Oil/Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	through hole (thread length L < 1,5xd1)	10-12	Cutting Oil/Emulsion	Possible use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm2	through hole (thread length L < 1,5xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm2	through hole (thread length L > 1,5xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm2	through hole (thread length L < 1,5xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm2	through hole (thread length L > 1,5xd1)	10-12	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)	8-10	Cutting Oil/Emulsion	Recommended use
Tool steels up to 1100 N/mm2	through hole (thread length L < 1,5xd1)	8-10	Cutting Oil/Emulsion	Recommended use

<b>MACHINED MATERIAL</b>	<b>HOLE TYPE</b>	<b>CUTTING SPEED</b>	<b>LUBRICATION</b>	<b>USE</b>
Unalloyed aluminium	through hole (thread length $L > 1,5 \times d_1$ )	20-25	Cutting Oil/Emulsion	Possible use
Unalloyed aluminium	through hole (thread length $L < 1,5 \times d_1$ )	20-25	Cutting Oil/Emulsion	Possible use
Unalloyed copper	through hole (thread length $L > 1,5 \times d_1$ )	10-12	Cutting Oil/Emulsion	Possible use
Unalloyed copper	through hole (thread length $L < 1,5 \times d_1$ )	10-12	Cutting Oil/Emulsion	Possible use
Zinc and zinc alloys	through hole (thread length $L > 1,5 \times d_1$ )	10-12	Cutting Oil/Emulsion	Possible use
Zinc and zinc alloys	through hole (thread length $L < 1,5 \times d_1$ )	10-12	Cutting Oil/Emulsion	Possible use

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