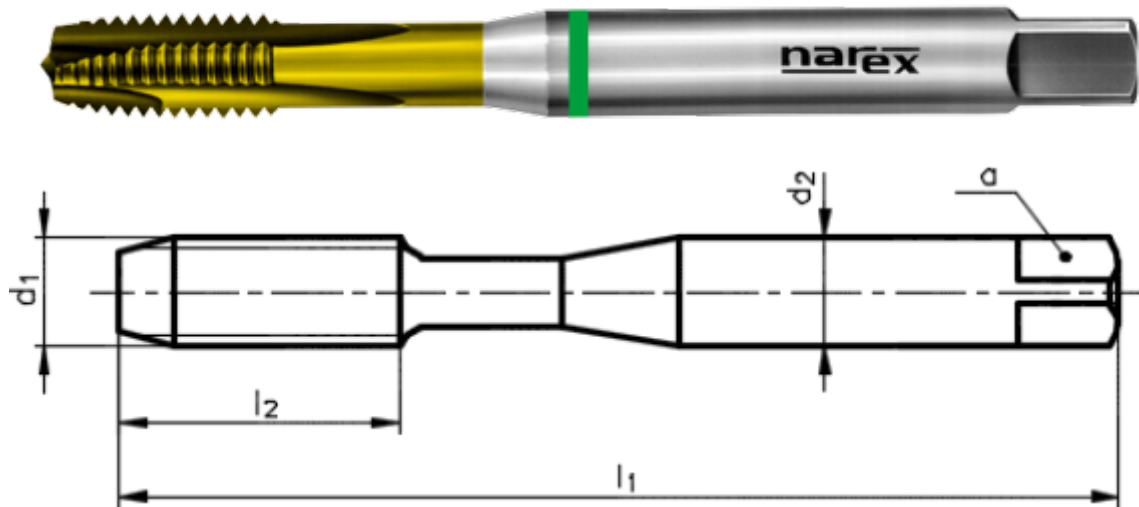


# Machine tap with straight flutes and spiral point

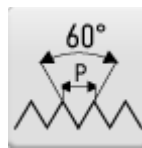


## CATALOGUE NUMBER: 1710

Machine tap with straight flutes and spiral point, metric, DIN 371, TiN coated, suitable for universal use.



**THREAD M**  
ISO Metric coarse thread



**PROFILE SKETCH**  
60°



**THREAD STANDARD**  
DIN13



**TYPE UNI**  
Tap for universal applications



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



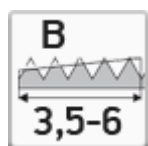
**COATING**  
Titanium nitride coating



**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
041535046030000	M3	0,5	6H	56	9	3,5	2,7	13.95 EUR	16.88 EUR
041535046040000	M4	0,7	6H	63	12	4,5	3,4	14.10 EUR	17.06 EUR
041535046050000	M5	0,8	6H	70	13	6	4,9	14.55 EUR	17.61 EUR
041535046060000	M6	1	6H	80	15	6	4,9	14.65 EUR	17.73 EUR
041535046080000	M8	1,25	6H	90	18	8	6,2	16.95 EUR	20.51 EUR
041535046100000	M10	1,5	6H	100	20	10	8	19.90 EUR	24.08 EUR

## Use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Aluminium alloys si content < 10%	through hole (thread length L > 1,5xd1)	12-20	Emulsion	Recommended use
Aluminium alloys si content < 10%	through hole (thread length L < 1,5xd1)	12-20	Emulsion	Recommended use
Aluminium alloys si content > 10%	through hole (thread length L < 1,5xd1)	12-20	Emulsion	Possible use
Aluminium alloys si content > 10%	through hole (thread length L > 1,5xd1)	12-20	Emulsion	Possible use
Case hardened steels and nitriding steels up to 1100 N/mm2	through hole (thread length L < 1,5xd1)	4-6	Cutting Oil/Emulsion	Recommended use
Case hardened steels and nitriding steels up to 1100 N/mm2	through hole (thread length L > 1,5xd1)	4-6	Cutting Oil/Emulsion	Recommended use
Copper alloys (long chipping)	through hole (thread length L < 1,5xd1)	12-20	Cutting Oil	Recommended use
Copper alloys (long chipping)	through hole (thread length L > 1,5xd1)	12-20	Cutting Oil	Recommended use

<b>MACHINED MATERIAL</b>	<b>HOLE TYPE</b>	<b>CUTTING SPEED</b>	<b>LUBRICATION</b>	<b>USE</b>
Free cutting steels up to 800 N/mm <sup>2</sup>	through hole (thread length $L > 1,5d_1$ )	10-12	Cutting Oil/Emulsion	Possible use
Free cutting steels up to 800 N/mm <sup>2</sup>	through hole (thread length $L < 1,5d_1$ )	10-12	Cutting Oil/Emulsion	Possible use
Grey cast iron	through hole (thread length $L < 1,5d_1$ )	8-12	Emulsion	Possible use
Grey cast iron	blind hole (thread length $< 1,5 d_1$ , pilot drilling depth $\geq L+d_1$ )	8-12	Emulsion	Possible use
Grey cast iron	through hole (thread length $L > 1,5d_1$ )	8-12	Emulsion	Possible use
Heat-treated steels up to 1100 N/mm <sup>2</sup>	through hole (thread length $L > 1,5d_1$ )	4-6	Cutting Oil/Emulsion	Recommended use
Heat-treated steels up to 1100 N/mm <sup>2</sup>	through hole (thread length $L < 1,5d_1$ )	4-6	Cutting Oil/Emulsion	Recommended use
Spheroidal graphite cast iron and malleable cast iron	through hole (thread length $L > 1,5d_1$ )	7-10	Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	through hole (thread length $L < 1,5d_1$ )	7-10	Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length $< 1,5 d_1$ , pilot drilling depth $\geq L+d_1$ )	7-10	Emulsion	Possible use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm <sup>2</sup>	through hole (thread length $L > 1,5d_1$ )	6-10	Cutting Oil	Possible use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm <sup>2</sup>	through hole (thread length $L < 1,5d_1$ )	6-10	Cutting Oil	Possible use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm <sup>2</sup>	through hole (thread length $L > 1,5d_1$ )	4-7	Cutting Oil	Possible use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm <sup>2</sup>	through hole (thread length $L < 1,5d_1$ )	4-7	Cutting Oil	Possible use
Structural steels and heat-treated steels up to 800 N/mm <sup>2</sup>	through hole (thread length $L < 1,5d_1$ )	10-12	Cutting Oil/Emulsion	Recommended use
Structural steels and heat-treated steels up to 800 N/mm <sup>2</sup>	through hole (thread length $L > 1,5d_1$ )	10-12	Cutting Oil/Emulsion	Recommended use
Tool steels up to 1100 N/mm <sup>2</sup>	through hole (thread length $L > 1,5d_1$ )	4-6	Cutting Oil/Emulsion	Possible use
Tool steels up to 1100 N/mm <sup>2</sup>	through hole (thread length $L < 1,5d_1$ )	4-6	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)