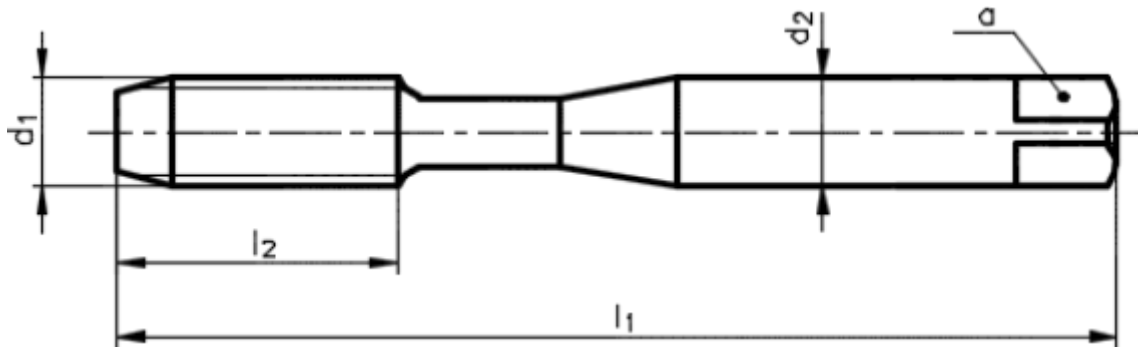


Machine tap with straight flutes and spiral point

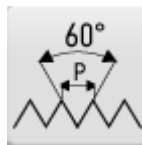


CATALOGUE NUMBER: 1720NXIKZN

High performance machine tap with straight flute with spiral point with radial cooling, metric, DIN 371, Balinit Hardlube coated, suitable for universal use.



THREAD M
ISO Metric coarse thread



PROFILE SKETCH
60°



THREAD STANDARD
DIN13



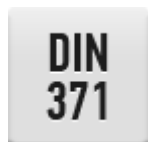
TYPE UNI
Tap for universal applications



TAP MATERIAL
Powder high speed steel



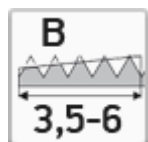
COATING
Balinit® Hardlube coating (titanium aluminiumnitride + tungsten carbide)



TAP STANDARD
DIN 371



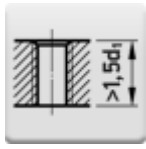
THREAD TOLERANCE
ISO 2 - 6HX



CHAMFER B
Length 3,5-6 pitch



COOLING METHOD
Internal axial coolant supply with hole outlets in the flutes



HOLE TYPE

Through hole (thread length $L > 1,5 \times d1$)

Select product model

ID	D1	P	Tolerance	l1	l2	d2	a	Price excl. VAT	Price incl. VAT
043036046060090	M6	1	6HX	80	19	6	4,9	110.45 EUR	133.64 EUR
043036046080090	M8	1,25	6HX	90	22	8	6,2	115.05 EUR	139.21 EUR
043036046100090	M10	1,5	6HX	100	24	10	8	124.25 EUR	150.34 EUR

Use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Aluminium alloys si content < 10%	through hole (thread length $L > 1,5 \times d1$)	15-25	Cutting Oil/Emulsion	Possible use
Aluminium alloys si content < 10%	through hole (thread length $L < 1,5 \times d1$)	15-25	Cutting Oil/Emulsion	Possible use
Aluminium alloys si content > 10%	through hole (thread length $L < 1,5 \times d1$)	15-20	Cutting Oil/Emulsion	Recommended use
Aluminium alloys si content > 10%	through hole (thread length $L > 1,5 \times d1$)	15-20	Cutting Oil/Emulsion	Recommended use
Case hardened steels and nitriding steels up to 1100 N/mm ²	through hole (thread length $L < 1,5 \times d1$)	10-12	Cutting Oil/Emulsion	Recommended use
Case hardened steels and nitriding steels up to 1100 N/mm ²	through hole (thread length $L > 1,5 \times d1$)	10-12	Cutting Oil/Emulsion	Recommended use
Copper alloys (long chipping)	through hole (thread length $L > 1,5 \times d1$)	12-15	Cutting Oil/Emulsion	Possible use
Copper alloys (long chipping)	through hole (thread length $L < 1,5 \times d1$)	12-15	Cutting Oil/Emulsion	Possible use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Copper alloys (short chipping)	through hole (thread length $L > 1,5 \times d_1$)	10-15	Cutting Oil/Emulsion	Recommended use
Copper alloys (short chipping)	through hole (thread length $L < 1,5 \times d_1$)	10-15	Cutting Oil/Emulsion	Recommended use
Free cutting steels up to 800 N/mm ²	through hole (thread length $L > 1,5 \times d_1$)	20-25	Cutting Oil/Emulsion	Possible use
Free cutting steels up to 800 N/mm ²	through hole (thread length $L < 1,5 \times d_1$)	20-25	Cutting Oil/Emulsion	Possible use
Grey cast iron	through hole (thread length $L < 1,5 \times d_1$)	15-20	Cutting Oil/Emulsion	Possible use
Grey cast iron	blind hole (thread length $< 1,5 \times d_1$, pilot drilling depth $\geq L + d_1$)	15-25	Cutting Oil/Emulsion	Possible use
Grey cast iron	through hole (thread length $L > 1,5 \times d_1$)	15-20	Cutting Oil/Emulsion	Possible use
Heat-treated steels up to 1100 N/mm ²	through hole (thread length $L > 1,5 \times d_1$)	10-12	Cutting Oil/Emulsion	Recommended use
Heat-treated steels up to 1100 N/mm ²	through hole (thread length $L < 1,5 \times d_1$)	10-12	Cutting Oil/Emulsion	Recommended use
Heat-treated steels up to 1400 N/mm ²	through hole (thread length $L < 1,5 \times d_1$)	10-15	Cutting Oil/Emulsion	Recommended use
Heat-treated steels up to 1400 N/mm ²	through hole (thread length $L > 1,5 \times d_1$)	10-15	Cutting Oil/Emulsion	Recommended use
High-alloyed steels up to 1400 N/mm ²	through hole (thread length $L < 1,5 \times d_1$)	10-15	Cutting Oil/Emulsion	Recommended use
High-alloyed steels up to 1400 N/mm ²	through hole (thread length $L > 1,5 \times d_1$)	10-15	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 500 N/mm ²	through hole (thread length $L < 1,5 \times d_1$)	15-30	Cutting Oil/Emulsion	Possible use
Plain cast steels up to 500 N/mm ²	through hole (thread length $L > 1,5 \times d_1$)	15-30	Cutting Oil/Emulsion	Possible use
Plain cast steels up to 800 N/mm ²	through hole (thread length $L < 1,5 \times d_1$)	20-25	Cutting Oil/Emulsion	Possible use
Plain cast steels up to 800 N/mm ²	through hole (thread length $L > 1,5 \times d_1$)	20-25	Cutting Oil/Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	through hole (thread length $L < 1,5 \times d_1$)	15-20	Cutting Oil/Emulsion	Recommended use
Spheroidal graphite cast iron and malleable cast iron	through hole (thread length $L > 1,5 \times d_1$)	15-20	Cutting Oil/Emulsion	Recommended use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm ²	through hole (thread length $L > 1,5 \times d_1$)	12-15	Cutting Oil/Emulsion	Recommended use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Stainless steels and heat resisting steels with strength 450 - 800 N/mm ²	through hole (thread length L < 1,5xd1)	12-15	Cutting Oil/Emulsion	Recommended use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm ²	through hole (thread length L > 1,5xd1)	12-15	Cutting Oil/Emulsion	Recommended use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm ²	through hole (thread length L < 1,5xd1)	12-15	Cutting Oil/Emulsion	Recommended use
Structural steels and heat-treated steels up to 800 N/mm ²	through hole (thread length L > 1,5xd1)	20-25	Cutting Oil/Emulsion	Possible use
Structural steels and heat-treated steels up to 800 N/mm ²	through hole (thread length L < 1,5xd1)	20-25	Cutting Oil/Emulsion	Possible use
Structural steels up to 500 N/mm ²	through hole (thread length L < 1,5xd1)	15-30	Cutting Oil/Emulsion	Possible use
Structural steels up to 500 N/mm ²	through hole (thread length L > 1,5xd1)	15-30	Cutting Oil/Emulsion	Possible use
Tool steels up to 1100 N/mm ²	through hole (thread length L > 1,5xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Tool steels up to 1100 N/mm ²	through hole (thread length L < 1,5xd1)	10-12	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
Unalloyed copper	through hole (thread length L < 1,5xd1)	15-30	Cutting Oil/Emulsion	Possible use
Unalloyed copper	through hole (thread length L > 1,5xd1)	15-30	Cutting Oil/Emulsion	Possible use
Zinc and zinc alloys	through hole (thread length L < 1,5xd1)	12-15	Cutting Oil/Emulsion	Possible use
Zinc and zinc alloys	through hole (thread length L > 1,5xd1)	12-15	Cutting Oil/Emulsion	Possible use

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