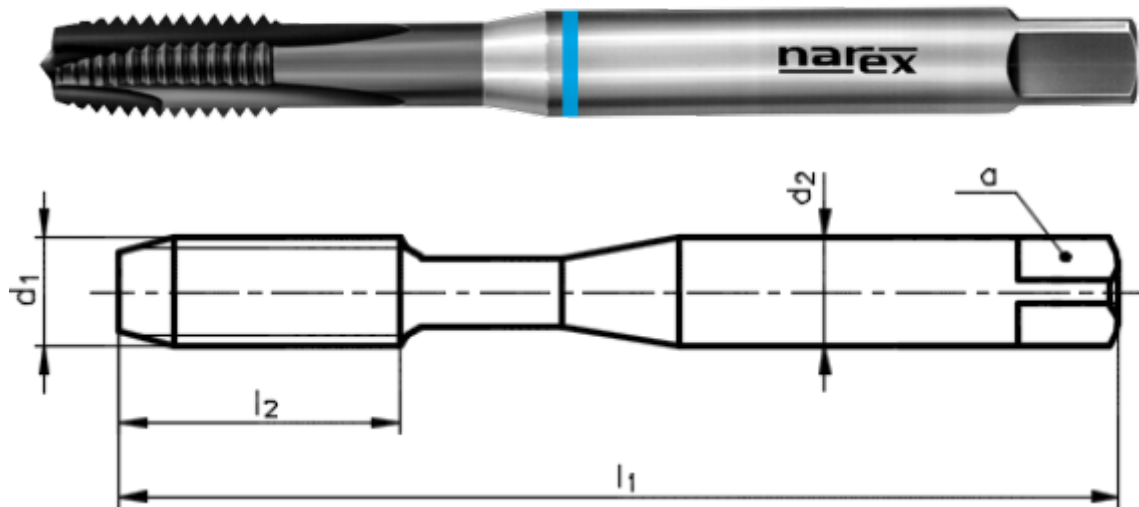


Machine tap with straight flutes and spiral point

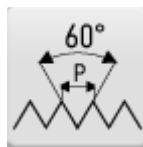


CATALOGUE NUMBER: 1870

Machine tap with straight flutes and spiral point, metric, DIN 371, Balinit Hardlube coated, suitable for case hardened and nitriding steels, stainless steels with strength up to 1000 N/mm², unalloyed copper and long chipping copper alloys, possible use in tool steels.



THREAD M
ISO Metric coarse thread



PROFILE SKETCH
60°



THREAD STANDARD
DIN13



TYPE VA
Tap for stainless steels



TAP MATERIAL
Powder high speed steel



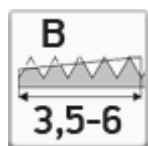
COATING
Balinit® Hardlube coating (titanium aluminiumnitride + tungsten carbide)



TAP STANDARD
DIN 371



THREAD TOLERANCE
ISO 2 - 6H



CHAMFER B
Length 3,5-6 pitch



HOLE TYPE
Through hole (thread length $L > 1,5 \times d_1$)

Select product model

ID	D1	P	Tolerance	I1	I2	d2	a	Price excl. VAT	Price incl. VAT
041536084030000	M3	0,5	6H	56	9	3,5	2,7	19.95 EUR	24.14 EUR
041536084040000	M4	0,7	6H	63	12	4,5	3,4	20.40 EUR	24.68 EUR
041536084050000	M5	0,8	6H	70	13	6	4,9	21.50 EUR	26.02 EUR
041536084060000	M6	1	6H	80	15	6	4,9	21.50 EUR	26.02 EUR
041536084080000	M8	1,25	6H	90	18	8	6,2	24.90 EUR	30.13 EUR
041536084100000	M10	1,5	6H	100	20	10	8	29.85 EUR	36.12 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)	6-8	Cutting Oil/Emulsion	Recommended use
Case hardened steels and nitriding steels up to 1100 N/mm2	through hole (thread length L > 1,5xd1)	6-8	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
Stainless steels and heat resisting steels with strength 450 - 800 N/mm2	through hole (thread length L > 1,5xd1)	8-14	Cutting Oil	Recommended use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm2	through hole (thread length L < 1,5xd1)	8-14	Cutting Oil	Recommended use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm2	through hole (thread length L > 1,5xd1)	6-10	Cutting Oil	Recommended use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm2	through hole (thread length L < 1,5xd1)	6-10	Cutting Oil	Recommended use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Tool steels up to 1100 N/mm ²	through hole (thread length L < 1,5xd1)	4-6	Cutting Oil/Emulsion	Possible use
Tool steels up to 1100 N/mm ²	through hole (thread length L > 1,5xd1)	4-6	Cutting Oil/Emulsion	Possible use
Unalloyed copper	through hole (thread length L < 1,5xd1)	10-15	Cutting Oil	Recommended use
Unalloyed copper	through hole (thread length L > 1,5xd1)	10-15	Cutting Oil	Recommended use

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