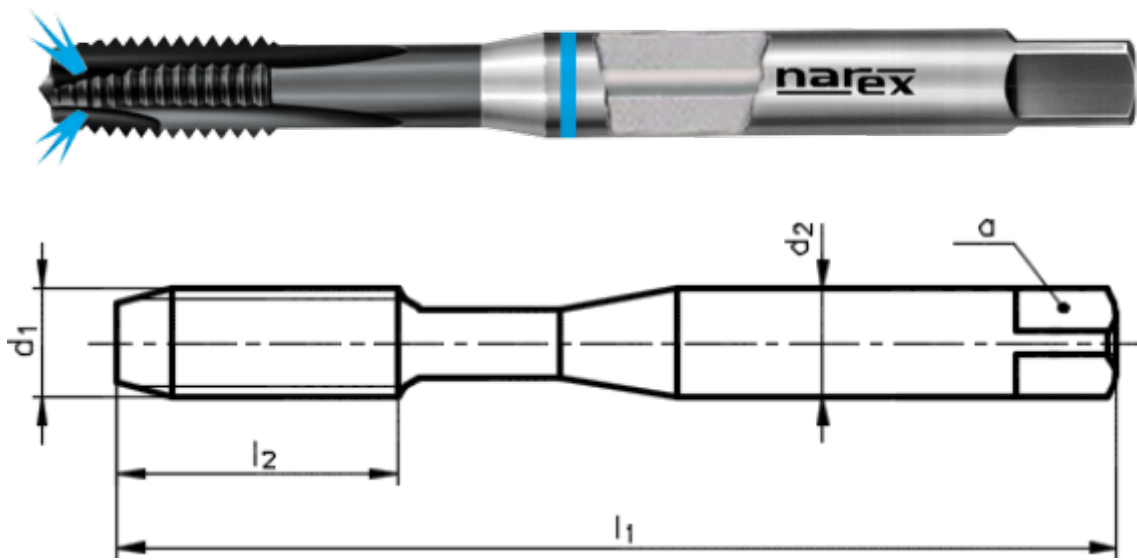


# Machine tap with straight flutes and spiral point

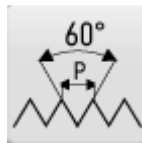


## CATALOGUE NUMBER: 1870IKZN

Machine tap with straight flutes and spiral point, metric, DIN 371, Balinit Hardlube coated, radial cooling, suitable for case hardened and nitriding steels, stainless steels with strength up to 1000 N/mm<sup>2</sup>, 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



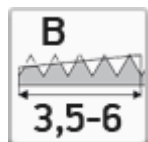
**COATING**  
Balinit® Hardlube coating (titanium aluminiumnitride + tungsten carbide)



**TAP STANDARD**  
DIN 371



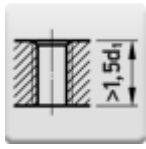
**THREAD TOLERANCE**  
ISO 2 - 6H



**CHAMFER B**  
Length 3,5-6 pitch



**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	I1	I2	d2	a	Price excl. VAT	Price incl. VAT
041636084060090	M6	1	6H	80	15	6	4,9	52.55 EUR	63.59 EUR
041636084080090	M8	1,25	6H	90	18	8	6,2	57.55 EUR	69.64 EUR
041636084100090	M10	1,5	6H	100	20	10	8	64.15 EUR	77.62 EUR

## Use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Case hardened steels and nitriding steels up to 1100 N/mm <sup>2</sup>	through hole (thread length $L > 1,5 \times d1$ )	6-8	Cutting Oil/Emulsion	Recommended use
Case hardened steels and nitriding steels up to 1100 N/mm <sup>2</sup>	through hole (thread length $L < 1,5 \times d1$ )	6-8	Cutting Oil/Emulsion	Recommended use
Copper alloys (long chipping)	through hole (thread length $L < 1,5 \times d1$ )	12-20	Cutting Oil	Recommended use
Copper alloys (long chipping)	through hole (thread length $L > 1,5 \times d1$ )	12-20	Cutting Oil	Recommended use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm <sup>2</sup>	through hole (thread length $L < 1,5 \times d1$ )	8-14	Cutting Oil	Recommended use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm <sup>2</sup>	through hole (thread length $L > 1,5 \times d1$ )	8-14	Cutting Oil	Recommended use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm <sup>2</sup>	through hole (thread length $L < 1,5 \times d1$ )	6-10	Cutting Oil	Recommended use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm <sup>2</sup>	through hole (thread length $L > 1,5 \times d1$ )	6-10	Cutting Oil	Recommended use

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