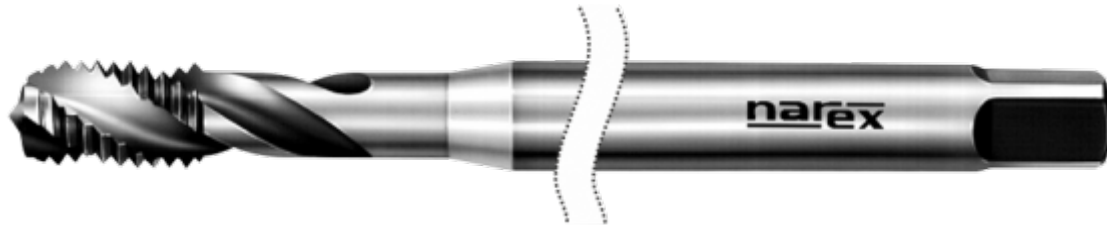


Extra long shank machine tap with right-hand spiral flutes 40°, L=100 mm

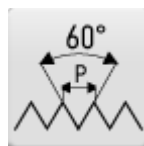


CATALOGUE NUMBER: 2050XL

Machine tap with spiral flutes, metric, extended to L= 100 mm, the rest of dimensions like DIN 371, suitable for structural steels, cast steels, free cutting steels, spheroidal and malleable cast iron, aluminium alloys Si<10 % and long chipping copper alloys.



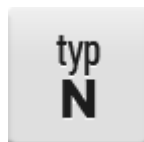
THREAD M
ISO Metric coarse thread



PROFILE SKETCH
60°



THREAD STANDARD
DIN13



TYPE N
Tap for steels up to 800 N/mm²



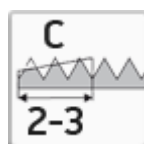
TAP MATERIAL
Super high speed steel



TAP STANDARD
~ DIN 371



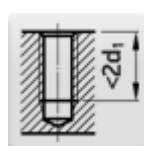
THREAD TOLERANCE
ISO 2 - 6H



CHAMFER C
Length 2-3 pitch



SPIRAL FLUTE ANGLE
40°



HOLE TYPE
Blind hole (thread length < 2 d₁)

Select product model

| ID | D1 | P | Tolerance | I1 | I2 | d2 | a | Price excl. VAT | Price incl. VAT |
|-----------------|-----|------|-----------|-----|----|-----|-----|-----------------|-----------------|
| 042131118030000 | M3 | 0,5 | 6H | 100 | 11 | 3,5 | 2,7 | 18.40 EUR | 22.26 EUR |
| 042131118040000 | M4 | 0,7 | 6H | 100 | 13 | 4,5 | 3,4 | 18.40 EUR | 22.26 EUR |
| 042131118050000 | M5 | 0,8 | 6H | 100 | 16 | 6 | 4,9 | 19.05 EUR | 23.05 EUR |
| 042131118060000 | M6 | 1 | 6H | 100 | 19 | 6 | 4,9 | 19.85 EUR | 24.02 EUR |
| 042131118080000 | M8 | 1,25 | 6H | 100 | 22 | 8 | 6,2 | 22.80 EUR | 27.59 EUR |
| 042131118100000 | M10 | 1,5 | 6H | 100 | 24 | 10 | 8 | 26.95 EUR | 32.61 EUR |
| 042131118120000 | M12 | 1,75 | 6H | 100 | 29 | 12 | 9 | 33.15 EUR | 40.11 EUR |

Use

| MACHINED MATERIAL | HOLE TYPE | CUTTING SPEED | LUBRICATION | USE |
|-----------------------------------|--|---------------|----------------------|-----------------|
| Aluminium alloys si content < 10% | blind hole (thread length < 1,5 d1, pilot drilling depth $\geq L+d1$) | 14-20 | Emulsion | Recommended use |
| Aluminium alloys si content < 10% | blind hole (thread length $L < 1,5xd1$) | 14-20 | Emulsion | Recommended use |
| Aluminium alloys si content < 10% | blind hole (thread length $L < 2xd1$) | 14-20 | Emulsion | Recommended use |
| Copper alloys (long chipping) | blind hole (thread length $L < 2xd1$) | 6-10 | Cutting Oil | Possible use |
| Copper alloys (long chipping) | blind hole (thread length < 1,5 d1, pilot drilling depth $\geq L+d1$) | 6-10 | Cutting Oil | Possible use |
| Copper alloys (long chipping) | blind hole (thread length $L < 1,5xd1$) | 6-10 | Cutting Oil | Possible use |
| Plain cast steels up to 800 N/mm2 | blind hole (thread length $L < 2xd1$) | 10-14 | Cutting Oil/Emulsion | Recommended use |
| Plain cast steels up to 800 N/mm2 | blind hole (thread length < 1,5 d1, pilot drilling depth $\geq L+d1$) | 10-14 | Cutting Oil/Emulsion | Recommended use |

| MACHINED MATERIAL | HOLE TYPE | CUTTING SPEED | LUBRICATION | USE |
|---|---|----------------------|----------------------|-----------------|
| Plain cast steels up to 800 N/mm ² | blind hole (thread length $L < 1,5d_1$) | 10-14 | Cutting Oil/Emulsion | Recommended use |
| Spheroidal graphite cast iron and malleable cast iron | blind hole (thread length $L < 1,5d_1$) | 4-7 | Emulsion | Possible use |
| Spheroidal graphite cast iron and malleable cast iron | blind hole (thread length $L < 2d_1$) | 4-7 | Emulsion | Possible use |
| Spheroidal graphite cast iron and malleable cast iron | blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$) | 4-7 | Emulsion | Possible use |
| Spheroidal graphite cast iron and malleable cast iron | blind hole (thread length $L < 2,5d_1$) | 4-7 | Emulsion | Possible use |
| Structural steels and heat-treated steels up to 800 N/mm ² | blind hole (thread length $L < 2d_1$) | 10-14 | Cutting Oil/Emulsion | Recommended use |
| Structural steels and heat-treated steels up to 800 N/mm ² | blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$) | 10-14 | Cutting Oil/Emulsion | Recommended use |
| Structural steels and heat-treated steels up to 800 N/mm ² | blind hole (thread length $L < 1,5d_1$) | 10-14 | Cutting Oil/Emulsion | Recommended 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
Web: www.narexzd.cz