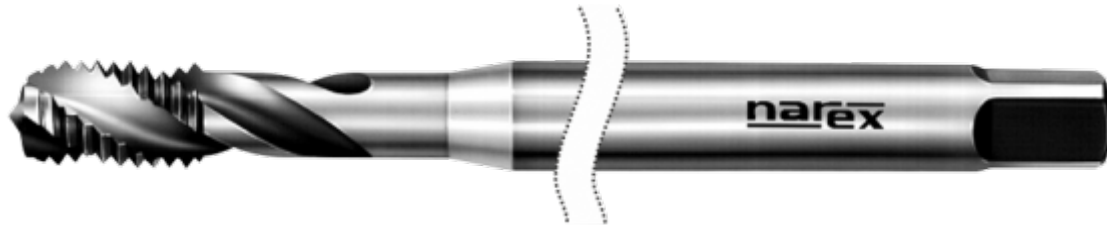


Extra long shank machine tap with right-hand spiral flutes 40°, L=120 mm

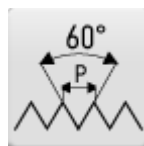


CATALOGUE NUMBER: 2050XXL

Machine tap with spiral flutes, metric, extended to L= 120 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.



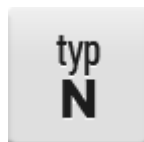
THREAD M
ISO Metric coarse thread



PROFILE SKETCH
60°



THREAD STANDARD
DIN13



TYPE N
Tap for steels up to 800 N/mm²



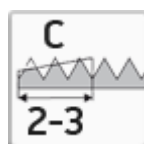
TAP MATERIAL
Super high speed steel



TAP STANDARD
~ DIN 371



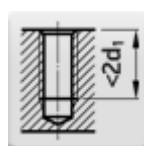
THREAD TOLERANCE
ISO 2 - 6H



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
042231118040000	M4	0,7	6H	120	13	4,5	3,4	19.70 EUR	23.84 EUR
042231118050000	M5	0,8	6H	120	16	6	4,9	20.40 EUR	24.68 EUR
042231118060000	M6	1	6H	120	19	6	4,9	21.25 EUR	25.71 EUR
042231118080000	M8	1,25	6H	120	22	8	6,2	24.45 EUR	29.58 EUR
042231118100000	M10	1,5	6H	120	24	10	8	28.85 EUR	34.91 EUR
042231118120000	M12	1,75	6H	120	29	12	9	35.55 EUR	43.02 EUR

Use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Aluminium alloys si content < 10%	blind hole (thread length $L < 1,5d_1$)	14-20	Emulsion	Recommended use
Aluminium alloys si content < 10%	blind hole (thread length $L < 2xd_1$)	14-20	Emulsion	Recommended use
Aluminium alloys si content < 10%	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$)	14-20	Emulsion	Recommended use
Copper alloys (long chipping)	blind hole (thread length $L < 1,5xd_1$)	6-10	Cutting Oil	Possible use
Copper alloys (long chipping)	blind hole (thread length $L < 2xd_1$)	6-10	Cutting Oil	Possible use
Copper alloys (long chipping)	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$)	6-10	Cutting Oil	Possible use
Plain cast steels up to 800 N/mm2	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$)	10-14	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 800 N/mm2	blind hole (thread length $L < 1,5xd_1$)	10-14	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 800 N/mm2	blind hole (thread length $L < 2xd_1$)	10-14	Cutting Oil/Emulsion	Recommended use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length $L < 2 \times d_1$)	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 $L < 2,5 \times d_1$)	4-7	Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length $L < 1,5 \times d_1$)	4-7	Emulsion	Possible 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 $L < 1,5 \times d_1$)	10-14	Cutting Oil/Emulsion	Recommended use
Structural steels and heat-treated steels up to 800 N/mm ²	blind hole (thread length $L < 2 \times d_1$)	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