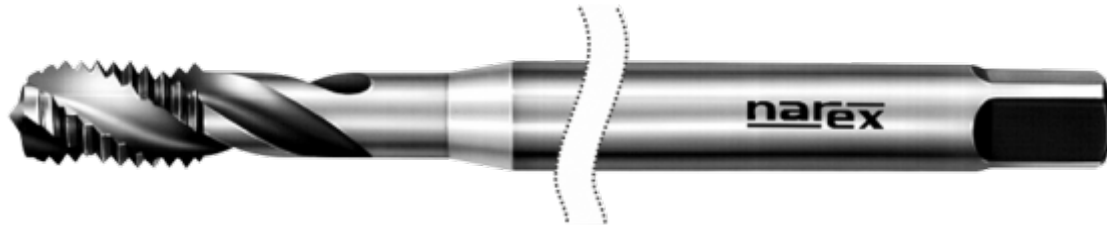


# Extra long shank machine tap with right-hand spiral flutes 40°, L=150 mm

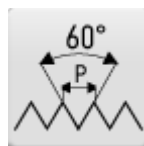


## CATALOGUE NUMBER: 2050XXXL

Machine tap with spiral flutes, metric, extended to L= 150 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.



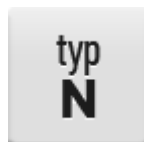
**THREAD M**  
ISO Metric coarse thread



**PROFILE SKETCH**  
60°



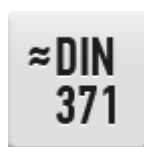
**THREAD STANDARD**  
DIN13



**TYPE N**  
Tap for steels up to 800 N/mm<sup>2</sup>



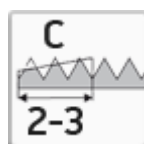
**TAP MATERIAL**  
Super high speed steel



**TAP STANDARD**  
~ DIN 371



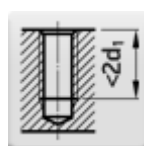
**THREAD TOLERANCE**  
ISO 2 - 6H



**CHAMFER C**  
Length 2-3 pitch



**SPIRAL FLUTE ANGLE**  
40°



**HOLE TYPE**  
Blind hole (thread length < 2 d<sub>1</sub>)

# Select product model

| ID              | D1  | P    | Tolerance | I1  | I2 | d2  | a   | Price excl. VAT | Price incl. VAT |
|-----------------|-----|------|-----------|-----|----|-----|-----|-----------------|-----------------|
| 042331118040000 | M4  | 0,7  | 6H        | 150 | 13 | 4,5 | 3,4 | 20.50 EUR       | 24.81 EUR       |
| 042331118050000 | M5  | 0,8  | 6H        | 150 | 16 | 6   | 4,9 | 21.25 EUR       | 25.71 EUR       |
| 042331118060000 | M6  | 1    | 6H        | 150 | 19 | 6   | 4,9 | 22.10 EUR       | 26.74 EUR       |
| 042331118080000 | M8  | 1,25 | 6H        | 150 | 22 | 8   | 6,2 | 25.45 EUR       | 30.79 EUR       |
| 042331118100000 | M10 | 1,5  | 6H        | 150 | 24 | 10  | 8   | 30.05 EUR       | 36.36 EUR       |
| 042331118120000 | M12 | 1,75 | 6H        | 150 | 29 | 12  | 9   | 36.95 EUR       | 44.71 EUR       |

## Use

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

| <b>MACHINED MATERIAL</b>                                  | <b>HOLE TYPE</b>   | <b>CUTTING SPEED</b> | <b>LUBRICATION</b>   | <b>USE</b>      |
|---|--|----------------------|----------------------|-----------------|
| Spheroidal graphite cast iron and malleable cast iron     | blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1) | 4-7                  | Emulsion             | Possible use    |
| Spheroidal graphite cast iron and malleable cast iron     | blind hole (thread length L < 2,5xd1)                            | 4-7                  | Emulsion             | Possible use    |
| Spheroidal graphite cast iron and malleable cast iron     | blind hole (thread length L < 1,5xd1)                            | 4-7                  | Emulsion             | Possible use    |
| Spheroidal graphite cast iron and malleable cast iron     | blind hole (thread length L < 2xd1)                              | 4-7                  | Emulsion             | Possible use    |
| Structural steels and heat-treated steels up to 800 N/mm2 | blind hole (thread length L < 1,5xd1)                            | 10-14                | Cutting Oil/Emulsion | Recommended use |
| Structural steels and heat-treated steels up to 800 N/mm2 | blind hole (thread length L < 2xd1)                              | 10-14                | Cutting Oil/Emulsion | Recommended use |
| Structural steels and heat-treated steels up to 800 N/mm2 | blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1) | 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](mailto:sales@narexzd.cz)  
Web: [www.narexzd.cz](http://www.narexzd.cz)