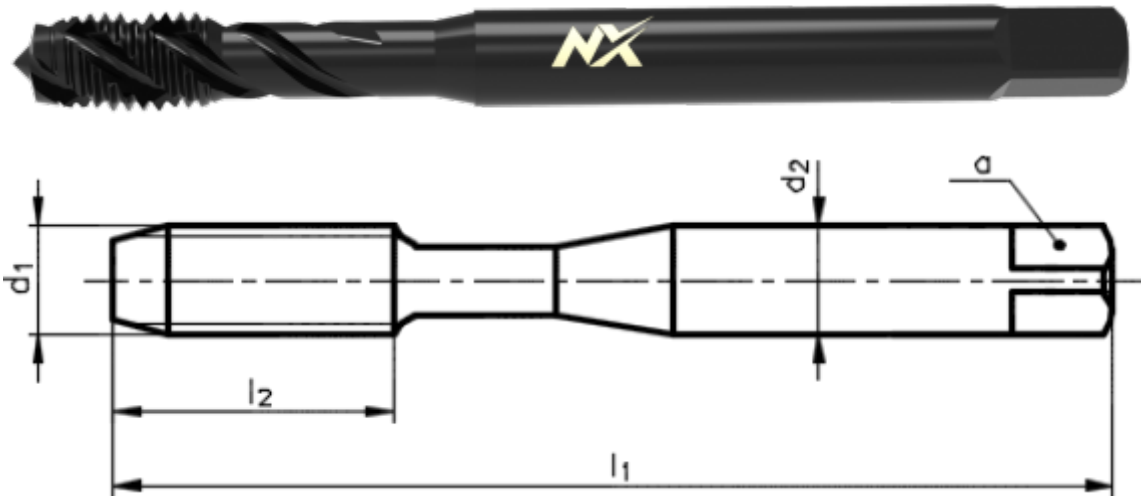
Machine tap with right-hand spiral flutes 40°



CATALOGUE NUMBER: 2090NX

High precision machine tap with 40° spiral, metric, DIN 371, steam oxided, suitable for structural steels, cast steels, free cutting steels, spheroidal and malleable cast iron, aluminium alloys Si<10 %, long chipping copper alloys.

M

THREAD M
ISO Metric coarse thread

PROFILE SKETCH
60°

DIN 13

THREAD STANDARD
DIN13

typ N

TYPE N
Tap for steels up to 800 N/mm2

HSSE V3

TAP MATERIAL
Vanadium extra high speed steel HSSE V3

OX

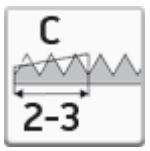
COATING
Oxidation

DIN 371

TAP STANDARD
DIN 371

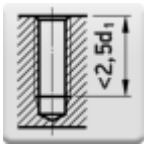
ISO 2 6H

THREAD TOLERANCE
ISO 2 - 6H



CHAMFER C
Length 2-3 pitch

SPIRAL FLUTE ANGLE
40°



HOLE TYPE
Blind hole (thread length < 2,5 d1)

Select product model

ID	D1	P	Tolerance	l1	l2	d2	a	Price excl. VAT	Price incl. VAT
042037118030000	M3	0,5	6H	56	5	3,5	2,7	**21.65** EUR	**26.20** EUR
042037118040000	M4	0,7	6H	63	7	4,5	3,4	**21.65** EUR	**26.20** EUR
042037118050000	M5	0,8	6H	70	8	6	4,9	**23.30** EUR	**28.19** EUR
042037118060000	M6	1	6H	80	10	6	4,9	**23.30** EUR	**28.19** EUR
042037118080000	M8	1,25	6H	90	13	8	6,2	**31.70** EUR	**38.36** EUR
042037118100000	M10	1,5	6H	100	15	10	8	**37.20** EUR	**45.01** EUR

Use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Aluminium alloys si content < 10%	blind hole (thread length L < 1,5xd1)	10-12	Cutting Oil/Emulsion	Possible use
Aluminium alloys si content < 10%	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	10-12	Cutting Oil/Emulsion	Possible use
Aluminium alloys si content < 10%	blind hole (thread length L < 2xd1)	10-12	Cutting Oil/Emulsion	Possible use
Aluminium alloys si content > 10%	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	10-12	Cutting Oil/Emulsion	Possible use
Aluminium alloys si content > 10%	blind hole (thread length L < 2xd1)	10-12	Cutting Oil/Emulsion	Possible use
Aluminium alloys si content > 10%	blind hole (thread length L < 1,5xd1)	10-12	Cutting Oil/Emulsion	Possible use
Free cutting steels up to 800 N/mm2	blind hole (thread length L < 2xd1)	10-12	Cutting Oil/Emulsion	Recommended use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Free cutting steels up to 800 N/mm2	blind hole (thread length L < 1,5xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Free cutting steels up to 800 N/mm2	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	10-12	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 500 N/mm2	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	10-12	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 500 N/mm2	blind hole (thread length L < 2xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 500 N/mm2	blind hole (thread length L < 1,5xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 800 N/mm2	blind hole (thread length L < 1,5xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 800 N/mm2	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	10-12	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 800 N/mm2	blind hole (thread length L < 2xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	6-10	Cutting Oil/Emulsion	Alternative use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length L < 2xd1)	6-10	Cutting Oil/Emulsion	Alternative use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length L < 1,5xd1)	6-10	Cutting Oil/Emulsion	Alternative use
Structural steels and heat-treated steels up to 800 N/mm2	blind hole (thread length L < 2xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Structural steels and heat-treated steels up to 800 N/mm2	blind hole (thread length L < 1,5xd1)	10-12	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)	10-12	Cutting Oil/Emulsion	Recommended use
Structural steels up to 500 N/mm2	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	10-12	Cutting Oil/Emulsion	Recommended use
Structural steels up to 500 N/mm2	blind hole (thread length L < 2xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Structural steels up to 500 N/mm2	blind hole (thread length L < 1,5xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Unalloyed aluminium	blind hole (thread length L < 1,5xd1)	10-12	Cutting Oil/Emulsion	Possible use
Unalloyed aluminium	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	10-12	Cutting Oil/Emulsion	Possible use
Unalloyed aluminium	blind hole (thread length L < 2xd1)	10-12	Cutting Oil/Emulsion	Possible use

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