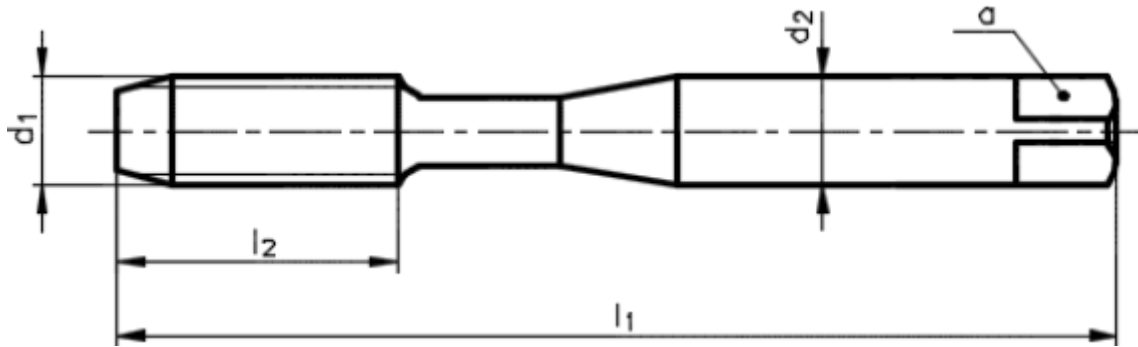


Machine tap with right-hand spiral flutes 35°

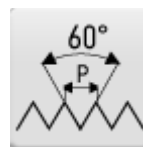


CATALOGUE NUMBER: 2210

Machine tap with spiral flutes, metric, DIN 371, TiN coated, suitable for universal use.



THREAD M
ISO Metric coarse thread



PROFILE SKETCH
60°



THREAD STANDARD
DIN13



TYPE UNI
Tap for universal applications



TAP MATERIAL
Vanadium extra high speed steel HSSE V3



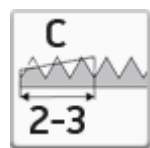
COATING
Titanium nitride coating



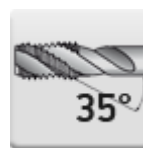
TAP STANDARD
DIN 371



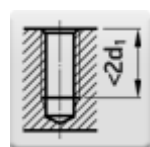
THREAD TOLERANCE
ISO 2 - 6H



CHAMFER C
Length 2-3 pitch



SPIRAL FLUTE ANGLE
35°



HOLE TYPE
Blind hole (thread length <math>< 2 d_1</math>)

Select product model

ID	D1	P	Tolerance	I1	I2	d2	a	Price excl. VAT	Price incl. VAT
041535124030000	M3	0,5	6H	56	5	3,5	2,7	15.10 EUR	18.27 EUR
041535124040000	M4	0,7	6H	63	7	4,5	3,4	15.10 EUR	18.27 EUR
041535124050000	M5	0,8	6H	70	8	6	4,9	15.40 EUR	18.63 EUR
041535124060000	M6	1	6H	80	10	6	4,9	16.10 EUR	19.48 EUR
041535124080000	M8	1,25	6H	90	13	8	6,2	18.65 EUR	22.57 EUR
041535124100000	M10	1,5	6H	100	15	10	8	21.95 EUR	26.56 EUR

Use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Aluminium alloys si content < 10%	blind hole (thread length $L < 2 \times d1$)	12-20	Emulsion	Recommended use
Aluminium alloys si content < 10%	blind hole (thread length $< 1,5 d1$, pilot drilling depth $\geq L+d1$)	12-20	Emulsion	Recommended use
Aluminium alloys si content < 10%	blind hole (thread length $L < 1,5 \times d1$)	12-20	Emulsion	Recommended use
Aluminium alloys si content > 10%	blind hole (thread length $L < 2 \times d1$)	12-20	Emulsion	Possible use
Aluminium alloys si content > 10%	blind hole (thread length $< 1,5 d1$, pilot drilling depth $\geq L+d1$)	12-20	Emulsion	Possible use
Aluminium alloys si content > 10%	blind hole (thread length $L < 1,5 \times d1$)	12-20	Emulsion	Possible use
Case hardened steels and nitriding steels up to 1100 N/mm ²	blind hole (thread length $L < 1,5 \times d1$)	4-6	Cutting Oil/Emulsion	Recommended use
Case hardened steels and nitriding steels up to 1100 N/mm ²	blind hole (thread length $L < 2 \times d1$)	4-6	Cutting Oil/Emulsion	Recommended use
Case hardened steels and nitriding steels up to 1100 N/mm ²	blind hole (thread length $< 1,5 d1$, pilot drilling depth $\geq L+d1$)	4-6	Cutting Oil/Emulsion	Recommended use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Copper alloys (long chipping)	blind hole (thread length $L < 2 \times d_1$)	12-20	Cutting Oil	Recommended use
Copper alloys (long chipping)	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$)	12-20	Cutting Oil	Recommended use
Copper alloys (long chipping)	blind hole (thread length $L < 1,5 \times d_1$)	12-20	Cutting Oil	Recommended use
Free cutting steels up to 800 N/mm ²	blind hole (thread length $L < 2 \times d_1$)	8-10	Cutting Oil/Emulsion	Possible use
Free cutting steels up to 800 N/mm ²	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$)	8-10	Cutting Oil/Emulsion	Possible use
Free cutting steels up to 800 N/mm ²	blind hole (thread length $L < 1,5 \times d_1$)	8-10	Cutting Oil/Emulsion	Possible use
Grey cast iron	blind hole (thread length $L < 2 \times d_1$)	8-12	Emulsion	Possible use
Grey cast iron	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$)	8-12	Emulsion	Possible use
Grey cast iron	blind hole (thread length $L < 2,5 \times d_1$)	8-12	Emulsion	Possible use
Grey cast iron	blind hole (thread length $L < 1,5 \times d_1$)	8-12	Emulsion	Possible use
Heat-treated steels up to 1100 N/mm ²	blind hole (thread length $L < 1,5 \times d_1$)	4-6	Cutting Oil/Emulsion	Recommended use
Heat-treated steels up to 1100 N/mm ²	blind hole (thread length $L < 2 \times d_1$)	4-6	Cutting Oil/Emulsion	Recommended use
Heat-treated steels up to 1100 N/mm ²	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$)	4-6	Cutting Oil/Emulsion	Recommended use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length $L < 1,5 \times d_1$)	7-10	Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length $L < 2 \times d_1$)	7-10	Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$)	7-10	Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length $L < 2,5 \times d_1$)	7-10	Emulsion	Possible use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm ²	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$)	6-10	Cutting Oil	Possible use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm ²	blind hole (thread length $L < 1,5 \times d_1$)	6-10	Cutting Oil	Possible use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm ²	blind hole (thread length $L < 2 \times d_1$)	6-10	Cutting Oil	Possible use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm ²	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$)	4-7	Cutting Oil	Possible use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm ²	blind hole (thread length $L < 1,5 \times d_1$)	4-7	Cutting Oil	Possible use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm ²	blind hole (thread length $L < 2 \times d_1$)	4-7	Cutting Oil	Possible use
Structural steels and heat-treated steels up to 800 N/mm ²	blind hole (thread length $L < 2 \times d_1$)	8-10	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 $\geq L + d_1$)	8-10	Cutting Oil/Emulsion	Recommended use
Structural steels and heat-treated steels up to 800 N/mm ²	blind hole (thread length $L < 1,5 \times d_1$)	8-10	Cutting Oil/Emulsion	Recommended use
Tool steels up to 1100 N/mm ²	blind hole (thread length $L < 1,5 \times d_1$)	4-6	Cutting Oil/Emulsion	Possible use
Tool steels up to 1100 N/mm ²	blind hole (thread length $L < 2 \times d_1$)	4-6	Cutting Oil/Emulsion	Possible use
Tool steels up to 1100 N/mm ²	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L + d_1$)	4-6	Cutting Oil/Emulsion	Possible use

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