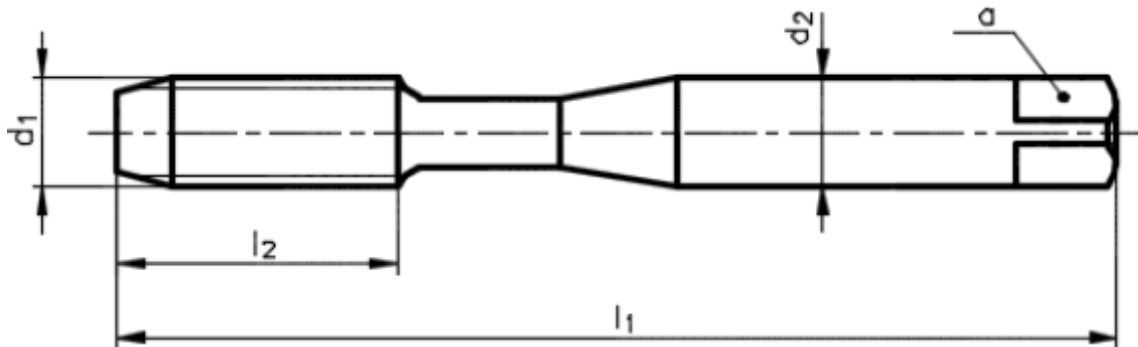


Machine tap with right-hand spiral flutes 50°

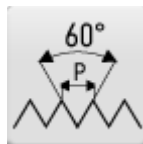


CATALOGUE NUMBER: 2220NX

High performance machine tap with 50° spiral flutes, metric, DIN 371, Balinit Hardlube 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
Powder high speed steel



COATING
Balinit® Hardlube coating (titanium aluminiumnitride + tungsten carbide)



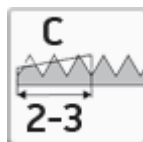
TAP STANDARD
DIN 371



THREAD TOLERANCE
ISO 2 - 6HX



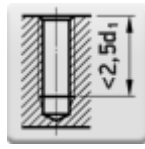
THREAD TOLERANCE
ISO 3 - 6GX



CHAMFER C
Length 2-3 pitch



SPIRAL FLUTE ANGLE
50°



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
042036124020000	M2	0,4	6HX	45	8	2,8	2,1	40.65 EUR	49.19 EUR
042036124025000	M2,5	0,45	6HX	50	9	2,8	2,1	39.80 EUR	48.16 EUR
042036124030000	M3	0,5	6HX	56	5	3,5	2,7	37.60 EUR	45.50 EUR
042036124040000	M4	0,7	6HX	63	7	4,5	3,4	38.65 EUR	46.77 EUR
042036124050000	M5	0,8	6HX	70	8	6	4,9	39.80 EUR	48.16 EUR
042036124060000	M6	1	6HX	80	10	6	4,9	40.55 EUR	49.07 EUR
042036124080000	M8	1,25	6HX	90	13	8	6,2	49.65 EUR	60.08 EUR
042036124100000	M10	1,5	6HX	100	15	10	8	60.20 EUR	72.84 EUR
042036126030000	M3	0,5	6GX	56	5	3,5	2,7	37.60 EUR	45.50 EUR
042036126040000	M4	0,7	6GX	63	7	4,5	3,4	38.65 EUR	46.77 EUR
042036126050000	M5	0,8	6GX	70	8	6	4,9	39.80 EUR	48.16 EUR
042036126060000	M6	1	6GX	80	10	6	4,9	55.00 EUR	66.55 EUR
042036126080000	M8	1,25	6GX	90	13	8	6,2	66.30 EUR	80.22 EUR
042036126100000	M10	1,5	6GX	100	15	10	8	80.25 EUR	97.10 EUR

Use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Aluminium alloys si content < 10%	blind hole (thread length L < 1,5xd1)	15-20	Cutting Oil/Emulsion	Recommended use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Aluminium alloys si content < 10%	blind hole (thread length $L < 2 \times d1$)	15-20	Cutting Oil/Emulsion	Recommended use
Aluminium alloys si content < 10%	blind hole (thread length $< 1,5 d1$, pilot drilling depth $\geq L+d1$)	15-20	Cutting Oil/Emulsion	Recommended use
Aluminium alloys si content < 10%	blind hole (thread length $L < 2,5 \times d1$)	15-20	Cutting Oil/Emulsion	Recommended use
Aluminium alloys si content > 10%	blind hole (thread length $< 1,5 d1$, pilot drilling depth $\geq L+d1$)	10-15	Cutting Oil/Emulsion	Recommended use
Aluminium alloys si content > 10%	blind hole (thread length $L < 2,5 \times d1$)	10-15	Cutting Oil/Emulsion	Recommended use
Aluminium alloys si content > 10%	blind hole (thread length $L < 1,5 \times d1$)	10-15	Cutting Oil/Emulsion	Recommended use
Aluminium alloys si content > 10%	blind hole (thread length $L < 2 \times d1$)	10-15	Cutting Oil/Emulsion	Recommended use
Case hardened steels and nitriding steels up to 1100 N/mm ²	blind hole (thread length $L < 2,5 \times d1$)	10-12	Cutting Oil/Emulsion	Recommended use
Case hardened steels and nitriding steels up to 1100 N/mm ²	blind hole (thread length $L < 1,5 \times d1$)	10-12	Cutting Oil/Emulsion	Recommended use
Case hardened steels and nitriding steels up to 1100 N/mm ²	blind hole (thread length $L < 2 \times d1$)	10-12	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 $\geq L+d1$)	10-12	Cutting Oil/Emulsion	Recommended use
Copper alloys (long chipping)	blind hole (thread length $L < 1,5 \times d1$)	10-12	Cutting Oil/Emulsion	Recommended use
Copper alloys (long chipping)	blind hole (thread length $L < 2 \times d1$)	10-12	Cutting Oil/Emulsion	Recommended use
Copper alloys (long chipping)	blind hole (thread length $< 1,5 d1$, pilot drilling depth $\geq L+d1$)	10-12	Cutting Oil/Emulsion	Recommended use
Copper alloys (long chipping)	blind hole (thread length $L < 2,5 \times d1$)	10-12	Cutting Oil/Emulsion	Recommended use
Copper alloys (short chipping)	blind hole (thread length $< 1,5 d1$, pilot drilling depth $\geq L+d1$)	10-12	Cutting Oil/Emulsion	Recommended use
Copper alloys (short chipping)	blind hole (thread length $L < 2,5 \times d1$)	10-12	Cutting Oil/Emulsion	Recommended use
Copper alloys (short chipping)	blind hole (thread length $L < 1,5 \times d1$)	10-12	Cutting Oil/Emulsion	Recommended use
Copper alloys (short chipping)	blind hole (thread length $L < 2 \times d1$)	10-12	Cutting Oil/Emulsion	Recommended use
Free cutting steels up to 800 N/mm ²	blind hole (thread length $L < 2 \times d1$)	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 < 1,5 d1, pilot drilling depth ≥ L+d1)	10-12	Cutting Oil/Emulsion	Recommended use
Free cutting steels up to 800 N/mm2	blind hole (thread length L < 2,5xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Free cutting steels up to 800 N/mm2	blind hole (thread length L < 1,5xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Grey cast iron	blind hole (thread length L < 2xd1)	15-20	Cutting Oil/Emulsion	Recommended use
Grey cast iron	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	15-20	Cutting Oil/Emulsion	Recommended use
Grey cast iron	blind hole (thread length L < 2,5xd1)	15-20	Cutting Oil/Emulsion	Recommended use
Grey cast iron	blind hole (thread length L < 1,5xd1)	15-20	Cutting Oil/Emulsion	Recommended use
Heat-treated steels up to 1100 N/mm2	blind hole (thread length L < 2xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Heat-treated steels up to 1100 N/mm2	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	10-12	Cutting Oil/Emulsion	Recommended use
Heat-treated steels up to 1100 N/mm2	blind hole (thread length L < 2,5xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Heat-treated steels up to 1100 N/mm2	blind hole (thread length L < 1,5xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Heat-treated steels up to 1400 N/mm2	blind hole (thread length L < 2,5xd1)	10-12	Cutting oil for high resistance steels	Recommended use
Heat-treated steels up to 1400 N/mm2	blind hole (thread length L < 1,5xd1)	10-12	Cutting oil for high resistance steels	Recommended use
Heat-treated steels up to 1400 N/mm2	blind hole (thread length L < 2xd1)	10-12	Cutting oil for high resistance steels	Recommended use
Heat-treated steels up to 1400 N/mm2	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	10-12	Cutting oil for high resistance steels	Recommended use
High-alloyed steels up to 1400 N/mm2	blind hole (thread length L < 2xd1)	10-12	Cutting oil for high resistance steels	Recommended use
High-alloyed steels up to 1400 N/mm2	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	10-12	Cutting oil for high resistance steels	Recommended use
High-alloyed steels up to 1400 N/mm2	blind hole (thread length L < 2,5xd1)	10-12	Cutting oil for high resistance steels	Recommended use
High-alloyed steels up to 1400 N/mm2	blind hole (thread length L < 1,5xd1)	10-12	Cutting oil for high resistance steels	Recommended use
Plain cast steels up to 500 N/mm2	blind hole (thread length L < 2,5xd1)	15-25	Cutting Oil/Emulsion	Recommended use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Plain cast steels up to 500 N/mm2	blind hole (thread length $L < 1,5d_1$)	15-25	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 500 N/mm2	blind hole (thread length $L < 2d_1$)	15-25	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 500 N/mm2	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$)	15-25	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 800 N/mm2	blind hole (thread length $L < 2d_1$)	10-12	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 800 N/mm2	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$)	10-12	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 800 N/mm2	blind hole (thread length $L < 2,5d_1$)	10-12	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 800 N/mm2	blind hole (thread length $L < 1,5d_1$)	10-12	Cutting Oil/Emulsion	Recommended use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length $L < 2,5d_1$)	10-15	Cutting Oil/Emulsion	Recommended use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length $L < 1,5d_1$)	10-15	Cutting Oil/Emulsion	Recommended use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length $L < 2d_1$)	10-15	Cutting Oil/Emulsion	Recommended use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$)	10-15	Cutting Oil/Emulsion	Recommended use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm2	blind hole (thread length $L < 2d_1$)	10-12	Cutting Oil/Emulsion	Recommended use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm2	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$)	10-12	Cutting Oil/Emulsion	Recommended use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm2	blind hole (thread length $L < 2,5d_1$)	10-12	Cutting Oil/Emulsion	Recommended use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm2	blind hole (thread length $L < 1,5d_1$)	10-12	Cutting Oil/Emulsion	Recommended use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm2	blind hole (thread length $L < 2,5d_1$)	10-12	Cutting Oil/Emulsion	Recommended use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm2	blind hole (thread length $L < 1,5d_1$)	10-12	Cutting Oil/Emulsion	Recommended use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm2	blind hole (thread length $L < 2d_1$)	10-12	Cutting Oil/Emulsion	Recommended use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm2	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	10-12	Cutting Oil/Emulsion	Recommended use
Structural steels and heat-treated steels up to 800 N/mm2	blind hole (thread length L < 2,5xd1)	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 L < 2xd1)	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 L < 1,5xd1)	15-25	Cutting Oil/Emulsion	Recommended use
Structural steels up to 500 N/mm2	blind hole (thread length L < 2,5xd1)	15-25	Cutting Oil/Emulsion	Recommended use
Structural steels up to 500 N/mm2	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	15-25	Cutting Oil/Emulsion	Recommended use
Structural steels up to 500 N/mm2	blind hole (thread length L < 2xd1)	15-25	Cutting Oil/Emulsion	Recommended use
Tool steels up to 1100 N/mm2	blind hole (thread length L < 2,5xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Tool steels up to 1100 N/mm2	blind hole (thread length L < 1,5xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Tool steels up to 1100 N/mm2	blind hole (thread length L < 2xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Tool steels up to 1100 N/mm2	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	10-12	Cutting Oil/Emulsion	Recommended use
Unalloyed aluminium	blind hole (thread length L < 2xd1)	15-30	Cutting Oil/Emulsion	Recommended use
Unalloyed aluminium	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	15-30	Cutting Oil/Emulsion	Recommended use
Unalloyed aluminium	blind hole (thread length L < 2,5xd1)	15-30	Cutting Oil/Emulsion	Recommended use
Unalloyed aluminium	blind hole (thread length L < 1,5xd1)	15-30	Cutting Oil/Emulsion	Recommended use
Unalloyed copper	blind hole (thread length L < 1,5xd1)	15-25	Cutting Oil/Emulsion	Recommended use
Unalloyed copper	blind hole (thread length L < 2xd1)	15-25	Cutting Oil/Emulsion	Recommended use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Unalloyed copper	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	15-25	Cutting Oil/Emulsion	Recommended use
Unalloyed copper	blind hole (thread length L < 2,5xd1)	15-25	Cutting Oil/Emulsion	Recommended use
Zinc and zinc alloys	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	10-12	Cutting Oil/Emulsion	Recommended use
Zinc and zinc alloys	blind hole (thread length L < 2,5xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Zinc and zinc alloys	blind hole (thread length L < 1,5xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Zinc and zinc alloys	blind hole (thread length L < 2xd1)	10-12	Cutting Oil/Emulsion	Recommended use