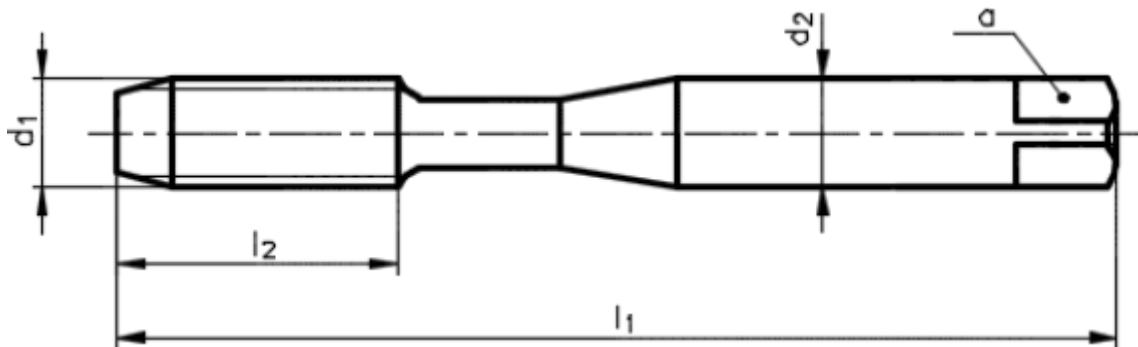


# Machine tap with right-hand spiral flutes 35°

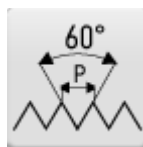


## CATALOGUE NUMBER: 2320

Machine tap with spiral flutes, metric, DIN 371, Balinit Hardlube coated, suitable for case hardened and nitriding steels, stainless steels with strength up to 1000 N/mm<sup>2</sup>, tools steels, spheroidal and malleable cast iron, unalloyed copper and long chipping copper alloys.



**THREAD M**  
ISO Metric coarse thread



**PROFILE SKETCH**  
60°



**THREAD STANDARD**  
DIN13



**TYPE VA**  
Tap for stainless steels



**TAP MATERIAL**  
Powder high speed steel



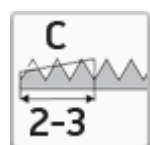
**COATING**  
Balinit® Hardlube coating (titanium aluminiumnitride + tungsten carbide)



**TAP STANDARD**  
DIN 371



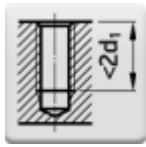
**THREAD TOLERANCE**  
ISO 2 - 6H



**CHAMFER C**  
Length 2-3 pitch



**SPIRAL FLUTE ANGLE**  
35°



#### HOLE TYPE

Blind hole (thread length  $< 2 d1$ )

## Select product model

ID	D1	P	Tolerance	I1	I2	d2	a	Price excl. VAT	Price incl. VAT
041536182030000	M3	0,5	6H	56	5	3,5	2,7	22.85 EUR	27.65 EUR
041536182040000	M4	0,7	6H	63	7	4,5	3,4	22.85 EUR	27.65 EUR
041536182050000	M5	0,8	6H	70	8	6	4,9	23.45 EUR	28.37 EUR
041536182060000	M6	1	6H	80	10	6	4,9	24.40 EUR	29.52 EUR
041536182080000	M8	1,25	6H	90	13	8	6,2	28.45 EUR	34.42 EUR
041536182100000	M10	1,5	6H	100	15	10	8	33.50 EUR	40.54 EUR

## Use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Case hardened steels and nitriding steels up to 1100 N/mm <sup>2</sup>	blind hole (thread length $L < 1,5d1$ )	6-8	Cutting Oil/Emulsion	Recommended use
Case hardened steels and nitriding steels up to 1100 N/mm <sup>2</sup>	blind hole (thread length $L < 2d1$ )	6-8	Cutting Oil/Emulsion	Recommended use
Case hardened steels and nitriding steels up to 1100 N/mm <sup>2</sup>	blind hole (thread length $< 1,5 d1$ , pilot drilling depth $\geq L+d1$ )	6-8	Cutting Oil/Emulsion	Recommended use
Copper alloys (long chipping)	blind hole (thread length $L < 1,5d1$ )	12-20	Cutting Oil	Recommended use
Copper alloys (long chipping)	blind hole (thread length $L < 2d1$ )	12-20	Cutting Oil	Recommended use
Copper alloys (long chipping)	blind hole (thread length $< 1,5 d1$ , pilot drilling depth $\geq L+d1$ )	12-20	Cutting Oil	Recommended use

<b>MACHINED MATERIAL</b>	<b>HOLE TYPE</b>	<b>CUTTING SPEED</b>	<b>LUBRICATION</b>	<b>USE</b>
Heat-treated steels up to 1100 N/mm <sup>2</sup>	blind hole (thread length < 1,5 d <sub>1</sub> , pilot drilling depth ≥ L+d <sub>1</sub> )	4-6	Cutting Oil/Emulsion	Possible use
Heat-treated steels up to 1100 N/mm <sup>2</sup>	blind hole (thread length L < 1,5x d <sub>1</sub> )	4-6	Cutting Oil/Emulsion	Possible use
Heat-treated steels up to 1100 N/mm <sup>2</sup>	blind hole (thread length L < 2x d <sub>1</sub> )	4-6	Cutting Oil/Emulsion	Possible use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm <sup>2</sup>	blind hole (thread length L < 2x d <sub>1</sub> )	8-14	Cutting Oil	Recommended use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm <sup>2</sup>	blind hole (thread length < 1,5 d <sub>1</sub> , pilot drilling depth ≥ L+d <sub>1</sub> )	8-14	Cutting Oil	Recommended use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm <sup>2</sup>	blind hole (thread length L < 1,5x d <sub>1</sub> )	8-14	Cutting Oil	Recommended use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm <sup>2</sup>	blind hole (thread length L < 2x d <sub>1</sub> )	6-10	Cutting Oil	Recommended use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm <sup>2</sup>	blind hole (thread length < 1,5 d <sub>1</sub> , pilot drilling depth ≥ L+d <sub>1</sub> )	6-10	Cutting Oil	Recommended use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm <sup>2</sup>	blind hole (thread length L < 1,5x d <sub>1</sub> )	6-10	Cutting Oil	Recommended use
Tool steels up to 1100 N/mm <sup>2</sup>	blind hole (thread length < 1,5 d <sub>1</sub> , pilot drilling depth ≥ L+d <sub>1</sub> )	6-8	Cutting Oil/Emulsion	Recommended use
Tool steels up to 1100 N/mm <sup>2</sup>	blind hole (thread length L < 1,5x d <sub>1</sub> )	6-8	Cutting Oil/Emulsion	Recommended use
Tool steels up to 1100 N/mm <sup>2</sup>	blind hole (thread length L < 2x d <sub>1</sub> )	6-8	Cutting Oil/Emulsion	Recommended use
Unalloyed copper	blind hole (thread length L < 2x d <sub>1</sub> )	10-15	Cutting Oil	Recommended use
Unalloyed copper	blind hole (thread length < 1,5 d <sub>1</sub> , pilot drilling depth ≥ L+d <sub>1</sub> )	10-15	Cutting Oil	Recommended use
Unalloyed copper	blind hole (thread length L < 1,5x d <sub>1</sub> )	10-15	Cutting Oil	Recommended use

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