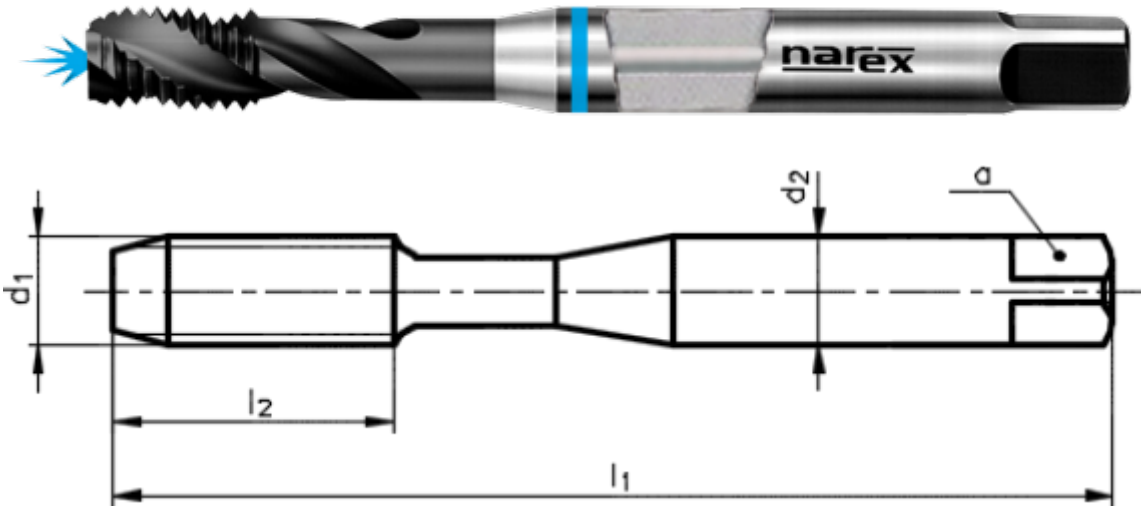
Machine tap with right-hand spiral flutes 35°



CATALOGUE NUMBER: 2320IKZ

Machine tap with spiral flutes and axial cooling, metric, DIN 371, Balinit Hardlube coated, suitable for case hardened and nitriding steels, stainless steels with strength up to 1000 N/mm2, tools steels, spheroidal and malleable cast iron, unalloyed copper and long chipping copper alloys.

M

THREAD M
ISO Metric coarse thread

PROFILE SKETCH
60°

DIN 13

THREAD STANDARD
DIN13

typ VA

TYPE VA
Tap for stainless steels

HSSE PM

TAP MATERIAL
Powder high speed steel

HL

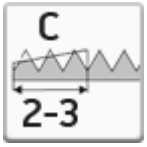
COATING
Balinit® Hardlube coating (titanium aluminiumnitride + tungsten carbide)

DIN 371

TAP STANDARD
DIN 371

ISO 2 6H

THREAD TOLERANCE
ISO 2 - 6H

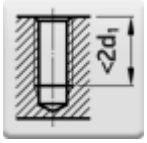


CHAMFER C
Length 2-3 pitch

SPIRAL FLUTE ANGLE
35°

IKZ

COOLING METHOD
Internal axial coolant supply



HOLE TYPE
Blind hole (thread length < 2 d1)

Select product model

ID	D1	P	Tolerance	l1	l2	d2	a	Price excl. VAT	Price incl. VAT
041636182060000	M6	1	6H	80	10	6	4,9	**40.75** EUR	**49.31** EUR
041636182080000	M8	1,25	6H	90	13	8	6,2	**44.80** EUR	**54.21** EUR
041636182100000	M10	1,5	6H	100	15	10	8	**51.50** EUR	**62.32** EUR

Use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Case hardened steels and nitriding steels up to 1100 N/mm2	blind hole (thread length L < 2xd1)	6-8	Cutting Oil/Emulsion	Recommended use
Case hardened steels and nitriding steels up to 1100 N/mm2	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	6-8	Cutting Oil/Emulsion	Recommended use
Case hardened steels and nitriding steels up to 1100 N/mm2	blind hole (thread length L < 1,5xd1)	6-8	Cutting Oil/Emulsion	Recommended use
Copper alloys (long chipping)	blind hole (thread length L < 1,5xd1)	12-20	Cutting Oil	Recommended use
Copper alloys (long chipping)	blind hole (thread length L < 2xd1)	12-20	Cutting Oil	Recommended use
Copper alloys (long chipping)	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	12-20	Cutting Oil	Recommended use
Heat-treated steels up to 1100 N/mm2	blind hole (thread length L < 1,5xd1)	4-6	Cutting Oil/Emulsion	Possible use
Heat-treated steels up to 1100 N/mm2	blind hole (thread length L < 2xd1)	4-6	Cutting Oil/Emulsion	Possible use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Heat-treated steels up to 1100 N/mm2	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	4-6	Cutting Oil/Emulsion	Possible use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm2	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	8-14	Cutting Oil	Recommended use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm2	blind hole (thread length L < 1,5xd1)	8-14	Cutting Oil	Recommended use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm2	blind hole (thread length L < 2xd1)	8-14	Cutting Oil	Recommended 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)	6-10	Cutting Oil	Recommended use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm2	blind hole (thread length L < 1,5xd1)	6-10	Cutting Oil	Recommended use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm2	blind hole (thread length L < 2xd1)	6-10	Cutting Oil	Recommended use
Tool steels up to 1100 N/mm2	blind hole (thread length L < 1,5xd1)	6-8	Cutting Oil/Emulsion	Recommended use
Tool steels up to 1100 N/mm2	blind hole (thread length L < 2xd1)	6-8	Cutting Oil/Emulsion	Recommended use
Tool steels up to 1100 N/mm2	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	6-8	Cutting Oil/Emulsion	Recommended use
Unalloyed copper	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	10-15	Cutting Oil	Recommended use
Unalloyed copper	blind hole (thread length L < 1,5xd1)	10-15	Cutting Oil	Recommended use
Unalloyed copper	blind hole (thread length L < 2xd1)	10-15	Cutting Oil	Recommended use

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