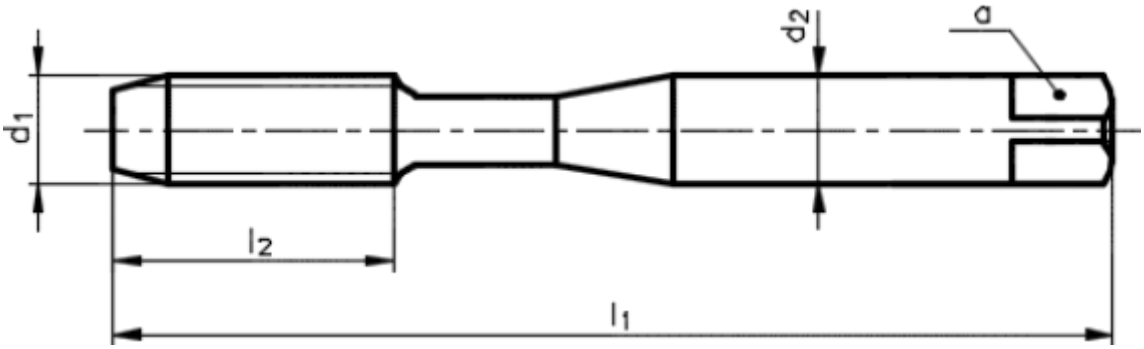
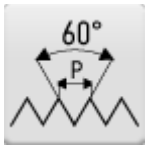
Machine tap with right-hand spiral flutes 40°



CATALOGUE NUMBER: 2680

Machine tap with spiral flute, metric, DIN 371, TiCN coated, suitable for case hardened and nitriding steels, heat-treated steels, tool steels, spheroidal and malleable cast iron

THREAD M
ISO Metric coarse thread



PROFILE SKETCH
60°

THREAD STANDARD
DIN13

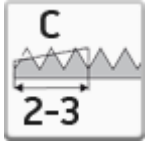
TYPE H
Tap for steels up to 1100 N/mm2

TAP MATERIAL
Vanadium extra high speed steel HSSE V3

COATING
Titanium carbonitridenitride coating

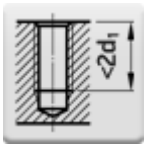
TAP STANDARD
DIN 371

THREAD TOLERANCE
ISO 2 - 6H



CHAMFER C
Length 2-3 pitch

SPIRAL FLUTE ANGLE
40°



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
041538136030000	M3	0,5	6H	56	5	3,5	2,7	**16.50** EUR	**19.97** EUR
041538136040000	M4	0,7	6H	63	7	4,5	3,4	**16.50** EUR	**19.97** EUR
041538136050000	M5	0,8	6H	70	8	6	4,9	**16.80** EUR	**20.33** EUR
041538136060000	M6	1	6H	80	10	6	4,9	**17.60** EUR	**21.30** EUR
041538136080000	M8	1,25	6H	90	13	8	6,2	**20.35** EUR	**24.62** EUR
041538136100000	M10	1,5	6H	100	15	10	8	**23.95** EUR	**28.98** EUR

Use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Aluminium alloys si content > 10%	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	12-20	Emulsion	Recommended use
Aluminium alloys si content > 10%	blind hole (thread length L < 2,5xd1)	12-20	Emulsion	Recommended use
Aluminium alloys si content > 10%	blind hole (thread length L < 1,5xd1)	12-20	Emulsion	Recommended use
Aluminium alloys si content > 10%	blind hole (thread length L < 2xd1)	12-20	Emulsion	Recommended use
Case hardened steels and nitriding steels up to 1100 N/mm2	blind hole (thread length L < 2xd1)	3-5	Cutting Oil/Emulsion	Possible use
Case hardened steels and nitriding steels up to 1100 N/mm2	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	3-5	Cutting Oil/Emulsion	Possible 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 < 1,5xd1)	3-5	Cutting Oil/Emulsion	Possible use
Heat-treated steels up to 1100 N/mm2	blind hole (thread length L < 2xd1)	6-8	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)	6-8	Cutting Oil/Emulsion	Recommended use
Heat-treated steels up to 1100 N/mm2	blind hole (thread length L < 1,5xd1)	6-8	Cutting Oil/Emulsion	Recommended use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length L < 1,5xd1)	7-10	Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length L < 2xd1)	7-10	Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	7-10	Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length L < 2,5xd1)	7-10	Emulsion	Possible use
Tool steels up to 1100 N/mm2	blind hole (thread length L < 2xd1)	3-5	Cutting Oil/Emulsion	Possible use
Tool steels up to 1100 N/mm2	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	3-5	Cutting Oil/Emulsion	Possible use
Tool steels up to 1100 N/mm2	blind hole (thread length L < 1,5xd1)	3-5	Cutting Oil/Emulsion	Possible use

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