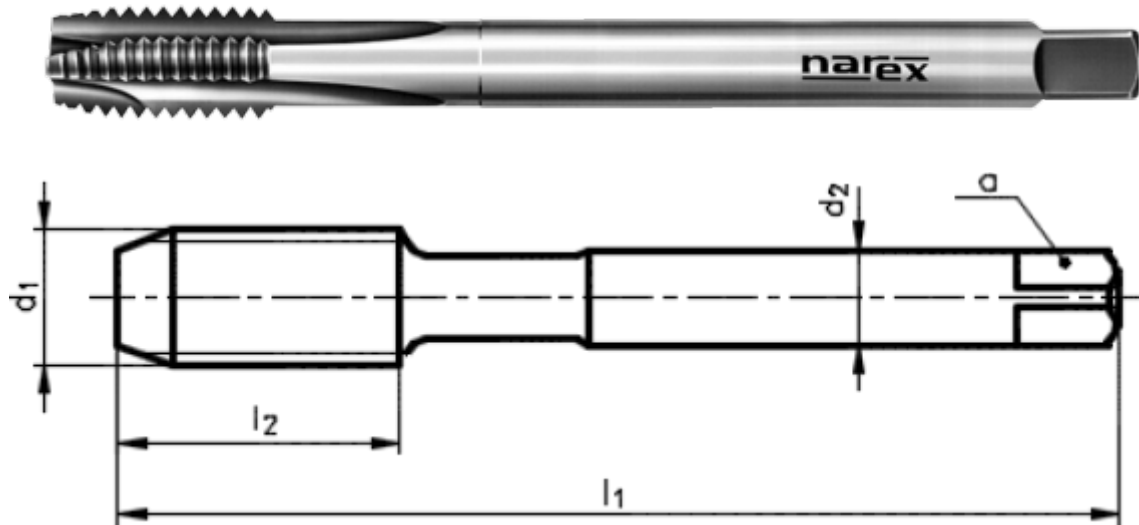


# Machine tap with straight flutes and spiral point



## CATALOGUE NUMBER: 3500

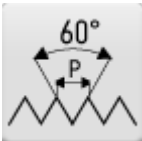
Machine tap with straight flutes and spiral point, metric and metric fine, DIN 376, DIN 374, suitable for structural steels, plain cast steels, free cutting steels, short chipping copper alloys, spheroidal and malleable cast iron, aluminium alloys with Si<10 %.

**M**

**THREAD M**  
ISO Metric coarse thread

**MF**

**THREAD MF**  
ISO Metric fine thread



**PROFILE SKETCH**  
60°

**DIN 13**

**THREAD STANDARD**  
DIN13

typ  
**N**

**TYPE N**  
Tap for steels up to 800 N/mm<sup>2</sup>

**HSSE**

**TAP MATERIAL**  
Super high speed steel

**DIN 376**

**TAP STANDARD**  
DIN 376

**DIN 374**

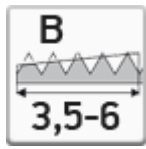
**TAP STANDARD**  
DIN 374

**ISO 2 6H**

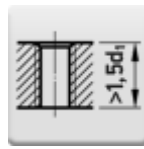
**THREAD TOLERANCE**  
ISO 2 - 6H

**ISO 3 6G**

**THREAD TOLERANCE**  
ISO 3 - 6G



**CHAMFER B**  
Length 3,5-6 pitch



**HOLE TYPE**  
Through hole (thread length  $L > 1,5 \times d1$ )

## Select product model

ID	D1	P	Tolerance	l1	l2	d2	a	Price excl. VAT	Price incl. VAT
041531252030000	M3	0,5	6H	56	9	2,2	-	9.00 EUR	10.89 EUR
041531252040000	M4	0,7	6H	63	12	2,8	2,1	9.20 EUR	11.13 EUR
041531252050000	M5	0,8	6H	70	13	3,5	2,7	8.75 EUR	10.59 EUR
041531252060000	M6	1	6H	80	15	4,5	3,4	8.95 EUR	10.83 EUR
041531252070000	M7	1	6H	80	15	5,5	4,3	10.90 EUR	13.19 EUR
041531252080000	M8	1,25	6H	90	18	6	4,9	9.50 EUR	11.50 EUR
041531252100000	M10	1,5	6H	100	20	7	5,5	10.95 EUR	13.25 EUR
041531252120000	M12	1,75	6H	110	23	9	7	13.30 EUR	16.09 EUR
041531252140000	M14	2	6H	110	25	11	9	16.65 EUR	20.15 EUR
041531252160000	M16	2	6H	110	25	12	9	18.85 EUR	22.81 EUR
041531252180000	M18	2,5	6H	125	30	14	11	26.50 EUR	32.07 EUR
041531252200000	M20	2,5	6H	140	30	16	12	28.15 EUR	34.06 EUR
041531252220000	M22	2,5	6H	140	30	18	14,5	39.30 EUR	47.55 EUR
041531252240000	M24	3	6H	160	36	18	14,5	37.20 EUR	45.01 EUR
041531252270000	M27	3	6H	160	36	20	16	49.65 EUR	60.08 EUR
041531252300000	M30	3,5	6H	180	40	22	18	60.10 EUR	72.72 EUR
041531252330000	M33	3,5	6H	180	42	25	20	71.10 EUR	86.03 EUR
041531252360000	M36	4	6H	200	50	28	22	88.30 EUR	106.84 EUR
041531254120000	M12	1,75	6G	110	23	9	7	13.30 EUR	16.09 EUR
041531254140000	M14	2	6G	110	25	11	9	16.65 EUR	20.15 EUR
041531254160000	M16	2	6G	110	25	12	9	18.85 EUR	22.81 EUR
041531452040000	M4	0,5	6H	63	12	2,8	2,1	12.70 EUR	15.37 EUR
041531452051000	M5	0,5	6H	70	13	3,5	2,7	13.50 EUR	16.34 EUR
041531452068000	M6	0,75	6H	80	15	4,5	3,4	13.45 EUR	16.27 EUR

ID	D1	P	Tolerance	l1	l2	d2	a	Price excl. VAT	Price incl. VAT
041531452069000	M6	0,5	6H	80	15	4,5	3,4	13.65 EUR	16.52 EUR
041531452078000	M7	0,75	6H	80	15	5,5	4,3	14.65 EUR	17.73 EUR
041531452087000	M8	1	6H	90	18	6	4,9	13.65 EUR	16.52 EUR
041531452088000	M8	0,75	6H	80	15	6	4,9	15.05 EUR	18.21 EUR
041531452106000	M10	1,25	6H	100	20	7	5,5	17.90 EUR	21.66 EUR
041531452107000	M10	1	6H	90	20	7	5,5	14.20 EUR	17.18 EUR
041531452108000	M10	0,75	6H	90	20	7	5,5	19.55 EUR	23.66 EUR
041531452125000	M12	1,5	6H	100	21	9	7	15.55 EUR	18.82 EUR
041531452126000	M12	1,25	6H	100	21	9	7	18.55 EUR	22.45 EUR
041531452127000	M12	1	6H	100	21	9	7	16.50 EUR	19.97 EUR
041531452145000	M14	1,5	6H	100	21	11	9	20.70 EUR	25.05 EUR
041531452146000	M14	1,25	6H	100	21	11	9	20.90 EUR	25.29 EUR
041531452147000	M14	1	6H	100	21	11	9	21.95 EUR	26.56 EUR
041531452155000	M15	1,5	6H	100	21	12	9	33.40 EUR	40.41 EUR
041531452157000	M15	1	6H	100	21	12	9	26.05 EUR	31.52 EUR
041531452165000	M16	1,5	6H	100	21	12	9	23.50 EUR	28.44 EUR
041531452167000	M16	1	6H	100	21	12	9	24.70 EUR	29.89 EUR
041531452184000	M18	2	6H	125	24	14	11	32.70 EUR	39.57 EUR
041531452185000	M18	1,5	6H	110	24	14	11	29.15 EUR	35.27 EUR
041531452187000	M18	1	6H	110	24	14	11	31.80 EUR	38.48 EUR
041531452204000	M20	2	6H	140	30	16	12	44.60 EUR	53.97 EUR
041531452205000	M20	1,5	6H	125	24	16	12	32.75 EUR	39.63 EUR
041531452207000	M20	1	6H	125	24	16	12	34.25 EUR	41.44 EUR
041531452224000	M22	2	6H	140	30	18	14,5	47.65 EUR	57.66 EUR
041531452225000	M22	1,5	6H	125	24	18	14,5	34.70 EUR	41.99 EUR
041531452227000	M22	1	6H	125	24	18	14,5	47.65 EUR	57.66 EUR
041531452244000	M24	2	6H	140	26	18	14,5	42.75 EUR	51.73 EUR
041531452245000	M24	1,5	6H	140	26	18	14,5	38.10 EUR	46.10 EUR
041531452247000	M24	1	6H	140	26	18	14,5	50.85 EUR	61.53 EUR
041531452255000	M25	1,5	6H	140	26	18	14,5	68.40 EUR	82.76 EUR
041531452265000	M26	1,5	6H	140	26	18	14,5	49.10 EUR	59.41 EUR
041531452274000	M27	2	6H	140	26	20	16	57.75 EUR	69.88 EUR

ID	D1	P	Tolerance	l1	l2	d2	a	Price excl. VAT	Price incl. VAT
041531452275000	M27	1,5	6H	140	26	20	16	54.60 EUR	66.07 EUR
041531452277000	M27	1	6H	140	26	20	16	63.40 EUR	76.71 EUR
041531452284000	M28	2	6H	140	26	20	16	60.85 EUR	73.63 EUR
041531452285000	M28	1,5	6H	140	26	20	16	56.35 EUR	68.18 EUR
041531452304000	M30	2	6H	150	28	22	18	65.95 EUR	79.80 EUR
041531452305000	M30	1,5	6H	150	28	22	18	60.45 EUR	73.14 EUR
041531452307000	M30	1	6H	150	28	22	18	70.75 EUR	85.61 EUR
041531452325000	M32	1,5	6H	150	28	22	18	72.10 EUR	87.24 EUR
041531452334000	M33	2	6H	160	30	25	20	81.10 EUR	98.13 EUR
041531452335000	M33	1,5	6H	160	30	25	20	80.35 EUR	97.22 EUR
0415314523355000	M35	1,5	6H	170	30	28	22	98.20 EUR	118.82 EUR
041531452363000	M36	3	6H	200	42	28	22	111.30 EUR	134.67 EUR
041531452364000	M36	2	6H	170	30	28	22	100.30 EUR	121.36 EUR
041531452365000	M36	1,5	6H	170	30	28	22	89.30 EUR	108.05 EUR

## Use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Aluminium alloys si content < 10%	through hole (thread length L < 1,5xd1)	14-20	Emulsion	Recommended use
Aluminium alloys si content < 10%	through hole (thread length L > 1,5xd1)	14-20	Emulsion	Recommended use
Aluminium alloys si content > 10%	through hole (thread length L < 1,5xd1)	12-15	Emulsion	Possible use
Aluminium alloys si content > 10%	through hole (thread length L > 1,5xd1)	12-15	Emulsion	Possible use
Copper alloys (short chipping)	through hole (thread length L > 1,5xd1)	12-20	Cutting Oil/Emulsion	Possible use
Copper alloys (short chipping)	through hole (thread length L < 1,5xd1)	12-20	Cutting Oil/Emulsion	Possible use

<b>MACHINED MATERIAL</b>	<b>HOLE TYPE</b>	<b>CUTTING SPEED</b>	<b>LUBRICATION</b>	<b>USE</b>
Free cutting steels up to 800 N/mm <sup>2</sup>	through hole (thread length $L > 1,5d_1$ )	10-14	Cutting Oil/Emulsion	Possible use
Free cutting steels up to 800 N/mm <sup>2</sup>	through hole (thread length $L < 1,5d_1$ )	10-14	Cutting Oil/Emulsion	Possible use
Plain cast steels up to 500 N/mm <sup>2</sup>	through hole (thread length $L < 1,5d_1$ )	6-10	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 500 N/mm <sup>2</sup>	through hole (thread length $L > 1,5d_1$ )	6-10	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 800 N/mm <sup>2</sup>	through hole (thread length $L > 1,5d_1$ )	10-14	Cutting Oil/Emulsion	Possible use
Plain cast steels up to 800 N/mm <sup>2</sup>	through hole (thread length $L < 1,5d_1$ )	10-14	Cutting Oil/Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	through hole (thread length $L < 1,5d_1$ )	4-7	Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length $< 1,5 d_1$ , pilot drilling depth $\geq L+d_1$ )	4-7	Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	through hole (thread length $L > 1,5d_1$ )	4-7	Emulsion	Possible use
Structural steels and heat-treated steels up to 800 N/mm <sup>2</sup>	through hole (thread length $L > 1,5d_1$ )	10-14	Cutting Oil/Emulsion	Recommended use
Structural steels and heat-treated steels up to 800 N/mm <sup>2</sup>	through hole (thread length $L < 1,5d_1$ )	10-14	Cutting Oil/Emulsion	Recommended use
Structural steels up to 500 N/mm <sup>2</sup>	through hole (thread length $L > 1,5d_1$ )	5-8	Cutting Oil/Emulsion	Possible use
Structural steels up to 500 N/mm <sup>2</sup>	through hole (thread length $L < 1,5d_1$ )	5-8	Cutting Oil/Emulsion	Possible use

**NAREX Ždánice, spol. s r.o.**

Městečko 250  
696 32 Ždánice, Česká republika

Tel.: +420 518 607 111  
Fax: +420 518 607 153  
E-mail: [sales@narexzd.cz](mailto:sales@narexzd.cz)  
Web: [www.narexzd.cz](http://www.narexzd.cz)