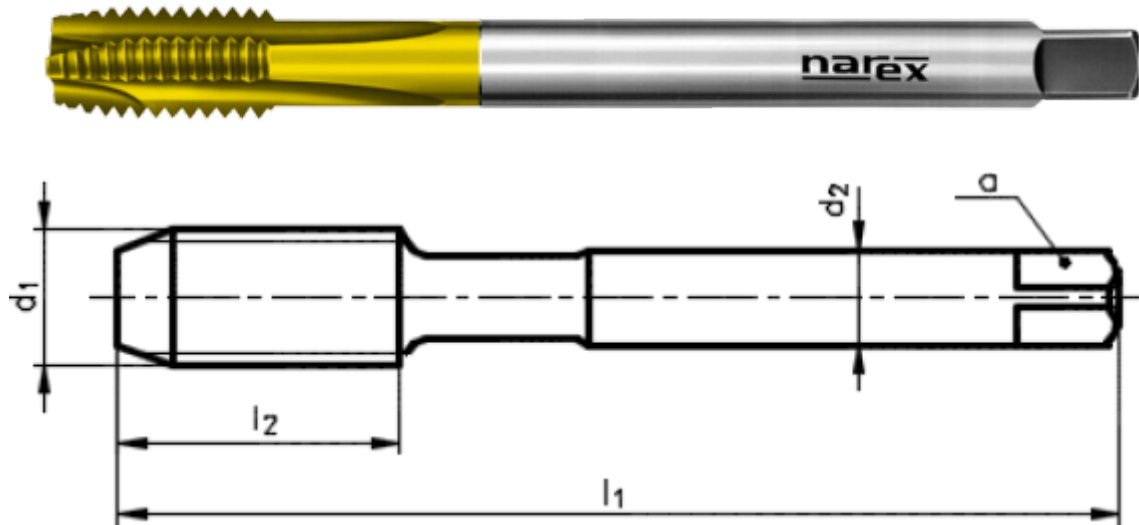


Machine tap with straight flutes and spiral point



CATALOGUE NUMBER: 3510

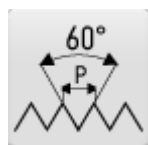
Machine tap with straight flutes and spiral point, metric and metric fine, DIN 376, DIN 374, TiN coated, suitable for structural steels, plain cast steels, free cutting steels, possible use in short chipping copper alloys, spheroidal and malleable cast iron, aluminium alloys Si<10 %



THREAD M
ISO Metric coarse thread



THREAD MF
ISO Metric fine thread



PROFILE SKETCH
60°



THREAD STANDARD
DIN13



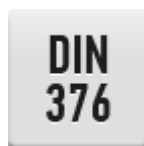
TYPE N
Tap for steels up to 800 N/mm²



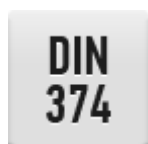
TAP MATERIAL
Super high speed steel



COATING
Titanium nitride coating



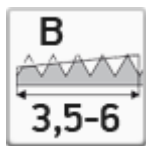
TAP STANDARD
DIN 376



TAP STANDARD
DIN 374



THREAD TOLERANCE
ISO 2 - 6H



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
041535252030000	M3	0,5	6H	56	9	2,2	-	14.40 EUR	17.42 EUR
041535252040000	M4	0,7	6H	63	12	2,8	2,1	14.65 EUR	17.73 EUR
041535252050000	M5	0,8	6H	70	13	3,5	2,7	14.05 EUR	17.00 EUR
041535252060000	M6	1	6H	80	15	4,5	3,4	14.35 EUR	17.36 EUR
041535252070000	M7	1	6H	80	15	5,5	4,3	17.35 EUR	20.99 EUR
041535252080000	M8	1,25	6H	90	18	6	4,9	15.25 EUR	18.45 EUR
041535252100000	M10	1,5	6H	100	20	7	5,5	17.50 EUR	21.18 EUR
041535252120000	M12	1,75	6H	110	23	9	7	21.30 EUR	25.77 EUR
041535252140000	M14	2	6H	110	25	11	9	26.55 EUR	32.13 EUR
041535252160000	M16	2	6H	110	25	12	9	30.25 EUR	36.60 EUR
041535252180000	M18	2,5	6H	125	30	14	11	42.35 EUR	51.24 EUR
041535252200000	M20	2,5	6H	140	30	16	12	45.05 EUR	54.51 EUR
041535252220000	M22	2,5	6H	140	30	18	14,5	62.80 EUR	75.99 EUR
041535252240000	M24	3	6H	160	36	18	14,5	59.50 EUR	72.00 EUR
041535252270000	M27	3	6H	160	36	20	16	79.50 EUR	96.20 EUR
041535252300000	M30	3,5	6H	180	40	22	18	96.05 EUR	116.22 EUR
041535252330000	M33	3,5	6H	180	42	25	20	113.70 EUR	137.58 EUR
041535252360000	M36	4	6H	200	50	28	22	141.25 EUR	170.91 EUR
041535452041000	M4	0,5	6H	63	12	2,8	2,1	19.05 EUR	23.05 EUR
041535452051000	M5	0,5	6H	70	13	3,5	2,7	20.15 EUR	24.38 EUR
041535452068000	M6	0,75	6H	80	15	4,5	3,4	20.10 EUR	24.32 EUR
041535452069000	M6	0,5	6H	80	15	4,5	3,4	20.35 EUR	24.62 EUR
041535452078000	M7	0,75	6H	80	15	5,5	4,3	22.05 EUR	26.68 EUR
041535452087000	M8	1	6H	90	18	6	4,9	20.35 EUR	24.62 EUR

ID	D1	P	Tolerance	l1	l2	d2	a	Price excl. VAT	Price incl. VAT
041535452088000	M8	0,75	6H	80	15	6	4,9	22.50 EUR	27.23 EUR
041535452106000	M10	1,25	6H	100	20	7	5,5	26.75 EUR	32.37 EUR
041535452107000	M10	1	6H	90	20	7	5,5	21.20 EUR	25.65 EUR
041535452108000	M10	0,75	6H	90	20	7	5,5	29.20 EUR	35.33 EUR
041535452125000	M12	1,5	6H	100	21	9	7	23.30 EUR	28.19 EUR
041535452126000	M12	1,25	6H	100	21	9	7	27.80 EUR	33.64 EUR
041535452127000	M12	1	6H	100	21	9	7	24.80 EUR	30.01 EUR
041535452145000	M14	1,5	6H	100	21	11	9	30.90 EUR	37.39 EUR
041535452146000	M14	1,25	6H	100	21	11	9	31.25 EUR	37.81 EUR
041535452147000	M14	1	6H	100	21	11	9	32.85 EUR	39.75 EUR
041535452155000	M15	1,5	6H	100	21	12	9	50.15 EUR	60.68 EUR
041535452157000	M15	1	6H	100	21	12	9	39.00 EUR	47.19 EUR
041535452165000	M16	1,5	6H	100	21	12	9	35.25 EUR	42.65 EUR
041535452167000	M16	1	6H	100	21	12	9	36.90 EUR	44.65 EUR
041535452184000	M18	2	6H	125	24	14	11	49.00 EUR	59.29 EUR
041535452185000	M18	1,5	6H	110	24	14	11	43.75 EUR	52.94 EUR
041535452187000	M18	1	6H	110	24	14	11	47.65 EUR	57.66 EUR
041535452204000	M20	2	6H	140	30	16	12	66.85 EUR	80.89 EUR
041535452205000	M20	1,5	6H	125	24	16	12	49.10 EUR	59.41 EUR
041535452207000	M20	1	6H	125	24	16	12	51.40 EUR	62.19 EUR
041535452224000	M22	2	6H	140	30	18	14,5	71.50 EUR	86.52 EUR
041535452225000	M22	1,5	6H	125	24	18	14,5	52.00 EUR	62.92 EUR
041535452227000	M22	1	6H	125	24	18	14,5	71.50 EUR	86.52 EUR
041535452244000	M24	2	6H	140	26	18	14,5	64.15 EUR	77.62 EUR
041535452245000	M24	1,5	6H	140	26	18	14,5	57.10 EUR	69.09 EUR
041535452247000	M24	1	6H	140	26	18	14,5	76.40 EUR	92.44 EUR
041535452255000	M25	1,5	6H	140	26	18	14,5	102.60 EUR	124.15 EUR
041535452265000	M26	1,5	6H	140	26	18	14,5	73.55 EUR	89.00 EUR
041535452274000	M27	2	6H	140	26	20	16	86.65 EUR	104.85 EUR
041535452275000	M27	1,5	6H	140	26	20	16	81.90 EUR	99.10 EUR
041535452277000	M27	1	6H	140	26	20	16	95.05 EUR	115.01 EUR
041535452284000	M28	2	6H	140	26	20	16	91.20 EUR	110.35 EUR

ID	D1	P	Tolerance	l1	l2	d2	a	Price excl. VAT	Price incl. VAT
041535452285000	M28	1,5	6H	140	26	20	16	84.45 EUR	102.18 EUR
041535452304000	M30	2	6H	150	28	22	18	98.95 EUR	119.73 EUR
041535452305000	M30	1,5	6H	150	28	22	18	90.75 EUR	109.81 EUR
041535452307000	M30	1	6H	150	28	22	18	106.05 EUR	128.32 EUR
041535452325000	M32	1,5	6H	150	28	22	18	108.25 EUR	130.98 EUR
041535452334000	M33	2	6H	160	30	25	20	121.60 EUR	147.14 EUR
041535452335000	M33	1,5	6H	160	30	25	20	120.60 EUR	145.93 EUR
041535452355000	M35	1,5	6H	170	30	28	22	147.25 EUR	178.17 EUR
041535452363000	M36	3	6H	200	42	28	22	166.80 EUR	201.83 EUR
041535452364000	M36	2	6H	170	30	28	22	150.35 EUR	181.92 EUR
041535452365000	M36	1,5	6H	170	30	28	22	133.90 EUR	162.02 EUR

Use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Aluminium alloys si content < 10%	through hole (thread length L > 1,5xd1)	15-30	Emulsion	Recommended use
Aluminium alloys si content < 10%	through hole (thread length L < 1,5xd1)	15-30	Emulsion	Recommended use
Aluminium alloys si content > 10%	through hole (thread length L > 1,5xd1)	14-20	Emulsion	Possible use
Aluminium alloys si content > 10%	through hole (thread length L < 1,5xd1)	14-20	Emulsion	Possible use
Copper alloys (short chipping)	through hole (thread length L > 1,5xd1)	15-25	Cutting Oil/Emulsion	Possible use
Copper alloys (short chipping)	through hole (thread length L < 1,5xd1)	15-25	Cutting Oil/Emulsion	Possible use
Free cutting steels up to 800 N/mm2	through hole (thread length L > 1,5xd1)	10-14	Cutting Oil/Emulsion	Recommended use
Free cutting steels up to 800 N/mm2	through hole (thread length L < 1,5xd1)	10-14	Cutting Oil/Emulsion	Recommended use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Plain cast steels up to 500 N/mm ²	through hole (thread length $L > 1,5 \times d_1$)	8-12	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 500 N/mm ²	through hole (thread length $L < 1,5 \times d_1$)	8-12	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 800 N/mm ²	through hole (thread length $L < 1,5 \times d_1$)	12-15	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 800 N/mm ²	through hole (thread length $L > 1,5 \times d_1$)	12-15	Cutting Oil/Emulsion	Recommended use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L + d_1$)	6-8	Emulsion	Recommended use
Spheroidal graphite cast iron and malleable cast iron	through hole (thread length $L > 1,5 \times d_1$)	6-8	Emulsion	Recommended use
Spheroidal graphite cast iron and malleable cast iron	through hole (thread length $L < 1,5 \times d_1$)	6-8	Emulsion	Recommended use
Structural steels and heat-treated steels up to 800 N/mm ²	through hole (thread length $L < 1,5 \times d_1$)	12-15	Cutting Oil/Emulsion	Recommended use
Structural steels and heat-treated steels up to 800 N/mm ²	through hole (thread length $L > 1,5 \times d_1$)	12-15	Cutting Oil/Emulsion	Recommended use
Structural steels up to 500 N/mm ²	through hole (thread length $L < 1,5 \times d_1$)	6-10	Cutting Oil/Emulsion	Recommended use
Structural steels up to 500 N/mm ²	through hole (thread length $L > 1,5 \times d_1$)	6-10	Cutting Oil/Emulsion	Recommended use