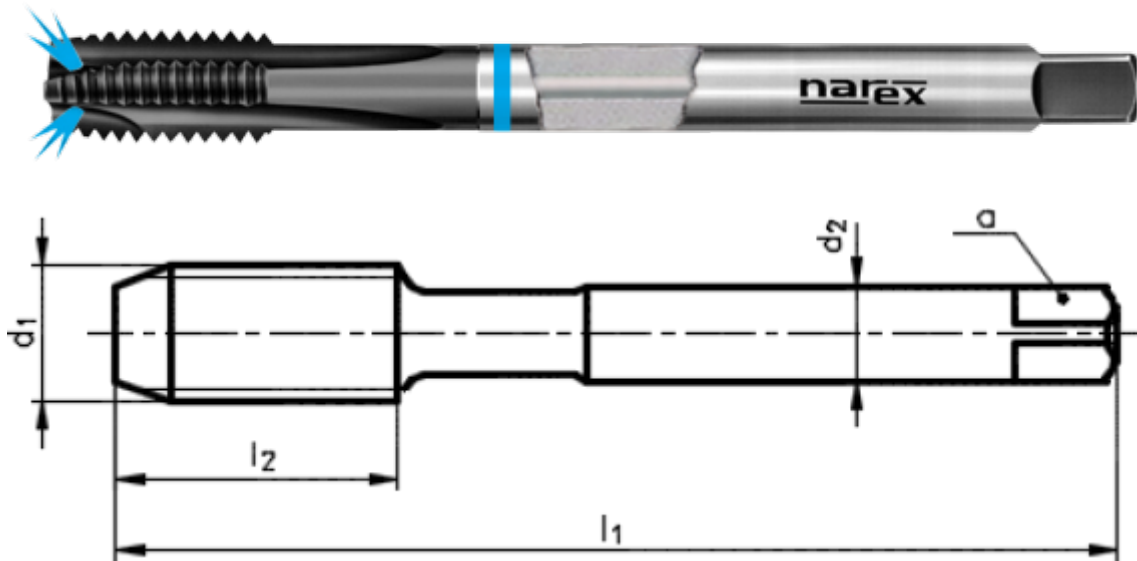


Machine tap with straight flutes and spiral point

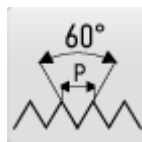


CATALOGUE NUMBER: 3870IKZN

Machine tap with straight flutes and spiral point, metric, DIN 376, Balinit Hardlube coated, radial cooling, suitable for case hardened and nitriding steels, stainless steels with strength up to 1000 N/mm², unalloyed copper and long chipping copper alloys, possible use in tool steels.



THREAD M
ISO Metric coarse thread



PROFILE SKETCH
60°



THREAD STANDARD
DIN13



TYPE VA
Tap for stainless steels



TAP MATERIAL
Powder high speed steel



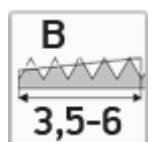
COATING
Balinit® Hardlube coating (titanium aluminiumnitride + tungsten carbide)



TAP STANDARD
DIN 376



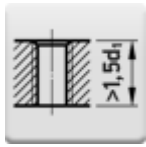
THREAD TOLERANCE
ISO 2 - 6H



CHAMFER B
Length 3,5-6 pitch



COOLING METHOD
Internal axial coolant supply with hole outlets in the flutes



HOLE TYPE

Through hole (thread length $L > 1,5xd1$)

Select product model

ID	D1	P	Tolerance	l1	l2	d2	a	Price excl. VAT	Price incl. VAT
041636284120090	M12	1,75	6H	110	23	9	7	77.15 EUR	93.35 EUR

Use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Case hardened steels and nitriding steels up to 1100 N/mm ²	through hole (thread length $L > 1,5xd1$)	6-8	Cutting Oil/Emulsion	Recommended use
Case hardened steels and nitriding steels up to 1100 N/mm ²	through hole (thread length $L < 1,5xd1$)	6-8	Cutting Oil/Emulsion	Recommended use
Copper alloys (long chipping)	through hole (thread length $L < 1,5xd1$)	12-20	Cutting Oil	Recommended use
Copper alloys (long chipping)	through hole (thread length $L > 1,5xd1$)	12-20	Cutting Oil	Recommended use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm ²	through hole (thread length $L < 1,5xd1$)	8-14	Cutting Oil	Recommended use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm ²	through hole (thread length $L > 1,5xd1$)	8-14	Cutting Oil	Recommended use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm ²	through hole (thread length $L > 1,5xd1$)	6-10	Cutting Oil	Recommended use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm ²	through hole (thread length $L < 1,5xd1$)	6-10	Cutting Oil	Recommended use
Tool steels up to 1100 N/mm ²	through hole (thread length $L < 1,5xd1$)	4-6	Cutting Oil/Emulsion	Possible use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Tool steels up to 1100 N/mm ²	through hole (thread length L > 1,5xd1)	4-6	Cutting Oil/Emulsion	Possible use
Unalloyed copper	through hole (thread length L > 1,5xd1)	10-15	Cutting Oil	Recommended use
Unalloyed copper	through hole (thread length L < 1,5xd1)	10-15	Cutting Oil	Recommended use

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