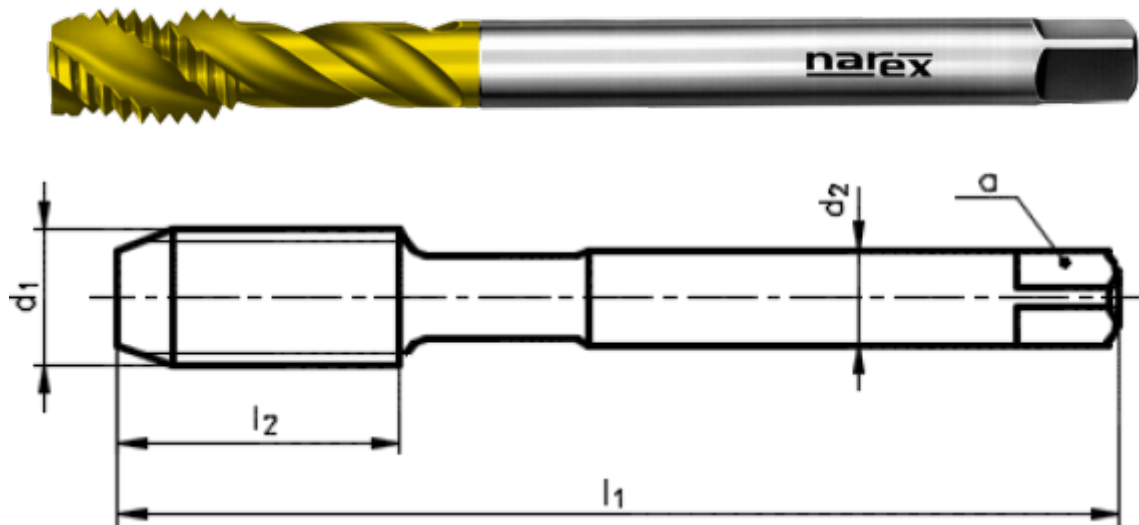


Machine tap with right-hand spiral flutes 35°



CATALOGUE NUMBER: 4060

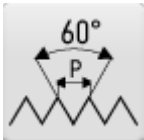
Machine tap with spiral flutes, metric, DIN 376, DIN 374, TiN coated, suitable for structural steels, cast steels, free cutting steels, spheroidal and malleable cast iron, aluminium alloys and long chipping copper alloys.

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/mm²

HSSE

TAP MATERIAL
Super high speed steel

TiN

COATING
Titanium nitride coating

DIN 376

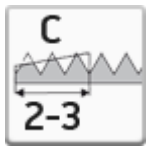
TAP STANDARD
DIN 376

DIN 374

TAP STANDARD
DIN 374

ISO 2 6H

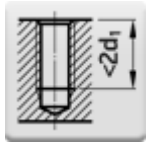
THREAD TOLERANCE
ISO 2 - 6H



CHAMFER C
Length 2-3 pitch



SPIRAL FLUTE ANGLE
40°



HOLE TYPE
Blind hole (thread length <math>< 2 d_1</math>)

Select product model

ID	D1	P	Tolerance	l1	l2	d2	a	Price excl. VAT	Price incl. VAT
041535318030000	M3	0,5	6H	56	5	2,2	-	14.00 EUR	16.94 EUR
041535318040000	M4	0,7	6H	63	7	2,8	2,1	14.25 EUR	17.24 EUR
041535318050000	M5	0,8	6H	70	8	3,5	2,7	14.65 EUR	17.73 EUR
041535318060000	M6	1	6H	80	10	4,5	3,4	14.65 EUR	17.73 EUR
041535318070000	M7	1	6H	80	10	5,5	4,3	20.10 EUR	24.32 EUR
041535318080000	M8	1,25	6H	90	13	6	4,9	16.25 EUR	19.66 EUR
041535318100000	M10	1,5	6H	100	15	7	5,5	20.20 EUR	24.44 EUR
041535318120000	M12	1,75	6H	110	18	9	7	23.60 EUR	28.56 EUR
041535318140000	M14	2	6H	110	20	11	9	29.35 EUR	35.51 EUR
041535318160000	M16	2	6H	110	20	12	9	32.30 EUR	39.08 EUR
041535318180000	M18	2,5	6H	125	25	14	11	46.75 EUR	56.57 EUR
041535318200000	M20	2,5	6H	140	25	16	12	48.15 EUR	58.26 EUR
041535318220000	M22	2,5	6H	140	25	18	14,5	64.55 EUR	78.11 EUR
041535318240000	M24	3	6H	160	30	18	14,5	61.45 EUR	74.35 EUR
041535318270000	M27	3	6H	160	30	20	16	82.55 EUR	99.89 EUR
041535318300000	M30	3,5	6H	180	35	22	18	103.85 EUR	125.66 EUR
041535318330000	M33	3,5	6H	180	35	25	20	156.60 EUR	189.49 EUR
041535318360000	M36	4	6H	200	40	28	22	156.60 EUR	189.49 EUR
041535518041000	M4	0,5	6H	63	7	2,8	2,1	21.05 EUR	25.47 EUR
041535518051000	M5	0,5	6H	70	8	3,5	2,7	21.25 EUR	25.71 EUR
041535518061000	M6	0,5	6H	80	10	4,5	3,4	21.25 EUR	25.71 EUR

ID	D1	P	Tolerance	l1	l2	d2	a	Price excl. VAT	Price incl. VAT
041535518068000	M6	0,75	6H	80	10	4,5	3,4	21.20 EUR	25.65 EUR
041535518078000	M7	0,75	6H	80	10	5,5	4,3	24.95 EUR	30.19 EUR
041535518087000	M8	1	6H	90	13	6	4,9	21.20 EUR	25.65 EUR
041535518088000	M8	0,75	6H	80	10	6	4,9	23.20 EUR	28.07 EUR
041535518097000	M9	1	6H	90	13	7	5,5	30.25 EUR	36.60 EUR
041535518106000	M10	1,25	6H	100	15	7	5,5	31.45 EUR	38.05 EUR
041535518107000	M10	1	6H	90	12	7	5,5	22.80 EUR	27.59 EUR
041535518108000	M10	0,75	6H	90	12	7	5,5	36.30 EUR	43.92 EUR
041535518117000	M11	1	6H	90	12	8	6,2	33.85 EUR	40.96 EUR
041535518125000	M12	1,5	6H	100	14	9	7	25.85 EUR	31.28 EUR
041535518126000	M12	1,25	6H	100	14	9	7	35.25 EUR	42.65 EUR
041535518127000	M12	1	6H	100	14	9	7	27.30 EUR	33.03 EUR
041535518145000	M14	1,5	6H	100	16	11	9	33.50 EUR	40.54 EUR
041535518146000	M14	1,25	6H	100	16	11	9	36.70 EUR	44.41 EUR
041535518147000	M14	1	6H	100	16	11	9	35.25 EUR	42.65 EUR
041535518157000	M15	1	6H	100	16	12	9	46.60 EUR	56.39 EUR
041535518165000	M16	1,5	6H	100	16	12	9	40.65 EUR	49.19 EUR
041535518167000	M16	1	6H	100	16	12	9	41.60 EUR	50.34 EUR
041535518184000	M18	2	6H	125	20	14	11	55.05 EUR	66.61 EUR
041535518185000	M18	1,5	6H	110	20	14	11	46.25 EUR	55.96 EUR
041535518187000	M18	1	6H	110	20	14	11	51.50 EUR	62.32 EUR
041535518204000	M20	2	6H	140	20	16	12	71.75 EUR	86.82 EUR
041535518205000	M20	1,5	6H	125	20	16	12	52.65 EUR	63.71 EUR
041535518207000	M20	1	6H	125	20	16	12	57.15 EUR	69.15 EUR
041535518224000	M22	2	6H	140	20	18	14,5	77.70 EUR	94.02 EUR
041535518225000	M22	1,5	6H	125	20	18	14,5	60.40 EUR	73.08 EUR
041535518227000	M22	1	6H	125	20	18	14,5	74.80 EUR	90.51 EUR
041535518244000	M24	2	6H	140	22	18	14,5	74.55 EUR	90.21 EUR
041535518245000	M24	1,5	6H	140	22	18	14,5	66.35 EUR	80.28 EUR
041535518247000	M24	1	6H	140	22	18	14,5	79.60 EUR	96.32 EUR
041535518255000	M25	1,5	6H	140	22	18	14,5	112.10 EUR	135.64 EUR
041535518265000	M26	1,5	6H	140	22	18	14,5	92.65 EUR	112.11 EUR

ID	D1	P	Tolerance	l1	l2	d2	a	Price excl. VAT	Price incl. VAT
041535518274000	M27	2	6H	140	22	20	16	107.20 EUR	129.71 EUR
041535518275000	M27	1,5	6H	140	22	20	16	96.00 EUR	116.16 EUR
041535518277000	M27	1	6H	140	22	20	16	111.40 EUR	134.79 EUR
041535518284000	M28	2	6H	140	22	20	16	110.65 EUR	133.89 EUR
041535518285000	M28	1,5	6H	140	22	20	16	106.55 EUR	128.93 EUR
041535518304000	M30	2	6H	150	26	22	18	123.35 EUR	149.25 EUR
041535518305000	M30	1,5	6H	150	26	22	18	116.25 EUR	140.66 EUR
041535518307000	M30	1	6H	150	26	22	18	129.65 EUR	156.88 EUR
041535518325000	M32	1,5	6H	150	26	22	18	134.10 EUR	162.26 EUR
041535518334000	M33	2	6H	160	28	25	20	163.70 EUR	198.08 EUR
041535518335000	M33	1,5	6H	160	28	25	20	161.00 EUR	194.81 EUR
041535518355000	M35	1,5	6H	170	28	28	22	171.35 EUR	207.33 EUR
041535518363000	M36	3	6H	200	36	28	22	192.45 EUR	232.86 EUR
041535518364000	M36	2	6H	170	28	28	22	210.20 EUR	254.34 EUR
041535518365000	M36	1,5	6H	170	28	28	22	158.10 EUR	191.30 EUR

Use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Aluminium alloys si content < 10%	blind hole (thread length $L < 1,5d1$)	15-30	Emulsion	Recommended use
Aluminium alloys si content < 10%	blind hole (thread length $L < 2xd1$)	15-30	Emulsion	Recommended use
Aluminium alloys si content < 10%	blind hole (thread length $< 1,5 d1$, pilot drilling depth $\geq L+d1$)	15-30	Emulsion	Recommended use
Aluminium alloys si content > 10%	blind hole (thread length $< 1,5 d1$, pilot drilling depth $\geq L+d1$)	14-20	Emulsion	Possible use
Aluminium alloys si content > 10%	blind hole (thread length $L < 1,5xd1$)	14-20	Emulsion	Possible use
Aluminium alloys si content > 10%	blind hole (thread length $L < 2xd1$)	14-20	Emulsion	Possible use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Copper alloys (long chipping)	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$)	10-15	Cutting Oil	Possible use
Copper alloys (long chipping)	blind hole (thread length $L < 1,5d_1$)	10-15	Cutting Oil	Possible use
Copper alloys (long chipping)	blind hole (thread length $L < 2xd_1$)	10-15	Cutting Oil	Possible use
Plain cast steels up to 800 N/mm ²	blind hole (thread length $L < 2xd_1$)	12-15	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 800 N/mm ²	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$)	12-15	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 800 N/mm ²	blind hole (thread length $L < 1,5xd_1$)	12-15	Cutting Oil/Emulsion	Recommended use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length $L < 2xd_1$)	6-8	Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$)	6-8	Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length $L < 2,5xd_1$)	6-8	Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length $L < 1,5xd_1$)	6-8	Emulsion	Possible use
Structural steels and heat-treated steels up to 800 N/mm ²	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$)	12-15	Cutting Oil/Emulsion	Recommended use
Structural steels and heat-treated steels up to 800 N/mm ²	blind hole (thread length $L < 1,5xd_1$)	12-15	Cutting Oil/Emulsion	Recommended use
Structural steels and heat-treated steels up to 800 N/mm ²	blind hole (thread length $L < 2xd_1$)	12-15	Cutting Oil/Emulsion	Recommended use