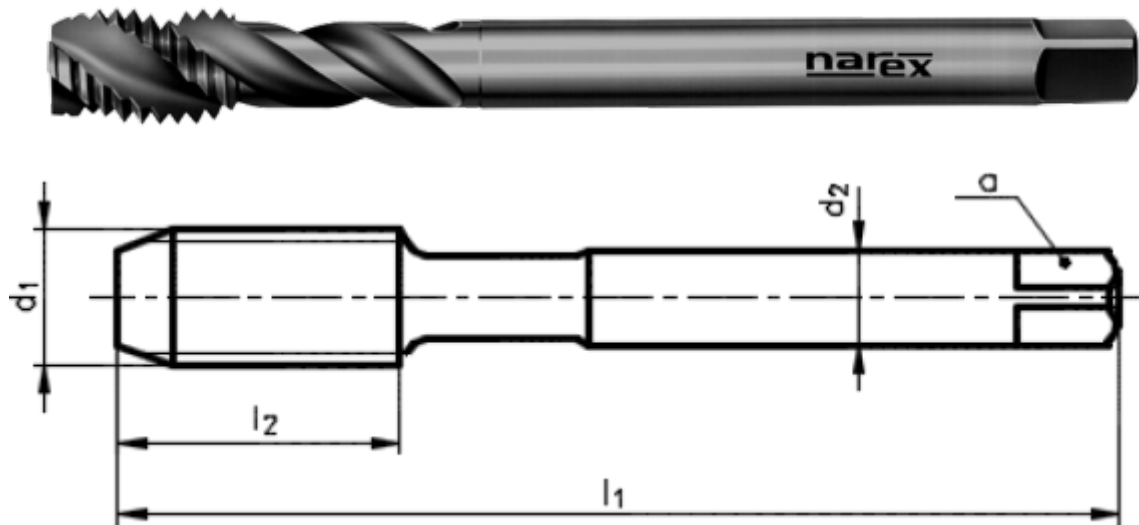


Machine tap with right-hand spiral flutes 35°



CATALOGUE NUMBER: 4090

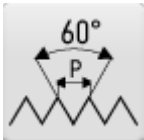
Machine tap with spiral flutes, metric, DIN 376, DIN 374 steam oxidized, suitable for structural steels, cast steels, free cutting steels, aluminium alloys and zinc alloys.

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

OX

COATING
Oxidation

DIN 376

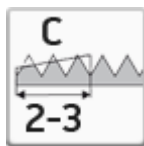
TAP STANDARD
DIN 376

DIN 374

TAP STANDARD
DIN 374

ISO 2 6H

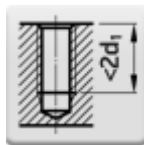
THREAD TOLERANCE
ISO 2 - 6H



CHAMFER C
Length 2-3 pitch



SPIRAL FLUTE ANGLE
40°



HOLE TYPE
Blind hole (thread length $< 2 d_1$)

Select product model

ID	D1	P	Tolerance	l1	l2	d2	a	Price excl. VAT	Price incl. VAT
041537318040000	M4	0,7	6H	63	7	2,8	2,1	9.35 EUR	11.31 EUR
041537318050000	M5	0,8	6H	70	8	3,5	2,7	9.55 EUR	11.56 EUR
041537318060000	M6	1	6H	80	10	4,5	3,4	9.55 EUR	11.56 EUR
041537318070000	M7	1	6H	80	10	5,5	4,3	13.20 EUR	15.97 EUR
041537318080000	M8	1,25	6H	90	13	6	4,9	10.70 EUR	12.95 EUR
041537318100000	M10	1,5	6H	100	15	7	5,5	13.25 EUR	16.03 EUR
041537318120000	M12	1,75	6H	110	18	9	7	15.50 EUR	18.76 EUR
041537318140000	M14	2	6H	110	20	11	9	19.20 EUR	23.23 EUR
041537318160000	M16	2	6H	110	20	12	9	21.25 EUR	25.71 EUR
041537318180000	M18	2,5	6H	125	25	14	11	30.70 EUR	37.15 EUR
041537318200000	M20	2,5	6H	140	25	16	12	31.60 EUR	38.24 EUR
041537318220000	M22	2,5	6H	140	25	18	14,5	42.35 EUR	51.24 EUR
041537318240000	M24	3	6H	160	30	18	14,5	40.40 EUR	48.88 EUR
041537318270000	M27	3	6H	160	30	20	16	54.25 EUR	65.64 EUR
041537318300000	M30	3,5	6H	180	35	22	18	68.25 EUR	82.58 EUR
041537318330000	M33	3,5	6H	180	35	25	20	102.90 EUR	124.51 EUR
041537318360000	M36	4	6H	200	40	28	22	102.90 EUR	124.51 EUR
041537518041000	M4	0,5	6H	63	8	2,8	2,1	14.70 EUR	17.79 EUR
041537518051000	M5	0,5	6H	70	8	3,5	2,7	15.05 EUR	18.21 EUR
041537518061000	M6	0,5	6H	80	10	4,5	3,4	15.05 EUR	18.21 EUR
041537518068000	M6	0,75	6H	80	10	4,5	3,4	15.00 EUR	18.15 EUR

ID	D1	P	Tolerance	l1	l2	d2	a	Price excl. VAT	Price incl. VAT
041537518078000	M7	0,75	6H	80	10	5,5	4,3	17.50 EUR	21.18 EUR
041537518087000	M8	1	6H	90	13	6	4,9	15.00 EUR	18.15 EUR
041537518088000	M8	0,75	6H	80	10	6	4,9	16.25 EUR	19.66 EUR
041537518097000	M9	1	6H	90	13	7	5,5	21.20 EUR	25.65 EUR
041537518106000	M10	1,25	6H	100	15	7	5,5	22.05 EUR	26.68 EUR
041537518107000	M10	1	6H	90	12	7	5,5	16.00 EUR	19.36 EUR
041537518108000	M10	0,75	6H	90	12	7	5,5	25.40 EUR	30.73 EUR
041537518117000	M11	1	6H	90	12	8	6,2	23.65 EUR	28.62 EUR
041537518125000	M12	1,5	6H	100	14	9	7	18.10 EUR	21.90 EUR
041537518126000	M12	1,25	6H	100	14	9	7	24.80 EUR	30.01 EUR
041537518127000	M12	1	6H	100	14	9	7	19.15 EUR	23.17 EUR
041537518145000	M14	1,5	6H	100	16	11	9	23.55 EUR	28.50 EUR
041537518146000	M14	1,25	6H	100	16	11	9	25.80 EUR	31.22 EUR
041537518147000	M14	1	6H	100	16	11	9	24.80 EUR	30.01 EUR
041537518157000	M15	1	6H	100	16	12	9	32.75 EUR	39.63 EUR
041537518165000	M16	1,5	6H	100	16	12	9	28.60 EUR	34.61 EUR
041537518167000	M16	1	6H	100	16	12	9	29.15 EUR	35.27 EUR
041537518184000	M18	2	6H	125	20	14	11	38.60 EUR	46.71 EUR
041537518185000	M18	1,5	6H	110	20	14	11	32.30 EUR	39.08 EUR
041537518187000	M18	1	6H	110	20	14	11	36.05 EUR	43.62 EUR
041537518204000	M20	2	6H	140	20	16	12	50.35 EUR	60.92 EUR
041537518205000	M20	1,5	6H	125	20	16	12	36.85 EUR	44.59 EUR
041537518207000	M20	1	6H	125	20	16	12	40.05 EUR	48.46 EUR
041537518224000	M22	2	6H	140	20	18	14,5	54.45 EUR	65.88 EUR
041537518225000	M22	1,5	6H	125	20	18	14,5	42.40 EUR	51.30 EUR
041537518227000	M22	1	6H	125	20	18	14,5	52.40 EUR	63.40 EUR
041537518244000	M24	2	6H	140	22	18	14,5	52.25 EUR	63.22 EUR
041537518245000	M24	1,5	6H	140	22	18	14,5	46.50 EUR	56.27 EUR
041537518247000	M24	1	6H	140	22	18	14,5	55.70 EUR	67.40 EUR
041537518255000	M25	1,5	6H	140	22	18	14,5	78.55 EUR	95.05 EUR
041537518265000	M26	1,5	6H	140	22	18	14,5	64.85 EUR	78.47 EUR
041537518274000	M27	2	6H	140	22	20	16	75.00 EUR	90.75 EUR

ID	D1	P	Tolerance	l1	l2	d2	a	Price excl. VAT	Price incl. VAT
041537518275000	M27	1,5	6H	140	22	20	16	67.25 EUR	81.37 EUR
041537518277000	M27	1	6H	140	22	20	16	77.95 EUR	94.32 EUR
041537518284000	M28	2	6H	140	22	20	16	77.50 EUR	93.78 EUR
041537518285000	M28	1,5	6H	140	22	20	16	74.60 EUR	90.27 EUR
041537518304000	M30	2	6H	150	26	22	18	86.40 EUR	104.54 EUR
041537518305000	M30	1,5	6H	150	26	22	18	81.40 EUR	98.49 EUR
041537518307000	M30	1	6H	150	26	22	18	90.80 EUR	109.87 EUR
041537518325000	M32	1,5	6H	150	26	22	18	94.00 EUR	113.74 EUR
041537518334000	M33	2	6H	160	28	25	20	114.75 EUR	138.85 EUR
041537518335000	M33	1,5	6H	160	28	25	20	112.70 EUR	136.37 EUR
041537518355000	M35	1,5	6H	170	28	28	22	120.00 EUR	145.20 EUR
041537518363000	M36	3	6H	200	36	28	22	134.85 EUR	163.17 EUR
041537518364000	M36	2	6H	170	28	28	22	147.10 EUR	177.99 EUR
041537518365000	M36	1,5	6H	170	28	28	22	110.70 EUR	133.95 EUR

Use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Aluminium alloys si content < 10%	blind hole (thread length $L < 1,5 \times d1$)	14-20	Emulsion	Possible use
Aluminium alloys si content < 10%	blind hole (thread length $L < 2 \times d1$)	14-20	Emulsion	Possible use
Aluminium alloys si content < 10%	blind hole (thread length $< 1,5 \times d1$, pilot drilling depth $\geq L + d1$)	14-20	Emulsion	Possible use
Aluminium alloys si content > 10%	blind hole (thread length $L < 1,5 \times d1$)	12-15	Emulsion	Possible use
Aluminium alloys si content > 10%	blind hole (thread length $L < 2 \times d1$)	12-15	Emulsion	Possible use
Aluminium alloys si content > 10%	blind hole (thread length $< 1,5 \times d1$, pilot drilling depth $\geq L + d1$)	12-15	Emulsion	Possible use
Plain cast steels up to 800 N/mm2	blind hole (thread length $L < 2 \times d1$)	10-12	Cutting Oil/Emulsion	Possible use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Plain cast steels up to 800 N/mm ²	blind hole (thread length < 1,5 d ₁ , pilot drilling depth ≥ L+d ₁)	10-12	Cutting Oil/Emulsion	Possible use
Plain cast steels up to 800 N/mm ²	blind hole (thread length L < 1,5d ₁)	10-12	Cutting Oil/Emulsion	Possible use
Structural steels and heat-treated steels up to 800 N/mm ²	blind hole (thread length L < 2xd ₁)	10-12	Cutting Oil/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 ≥ L+d ₁)	10-12	Cutting Oil/Emulsion	Possible use
Structural steels and heat-treated steels up to 800 N/mm ²	blind hole (thread length L < 1,5xd ₁)	10-12	Cutting Oil/Emulsion	Possible use
Zinc and zinc alloys	blind hole (thread length L < 1,5xd ₁)	8-10	Emulsion	Recommended use
Zinc and zinc alloys	blind hole (thread length L < 2xd ₁)	8-10	Emulsion	Recommended use
Zinc and zinc alloys	blind hole (thread length < 1,5 d ₁ , pilot drilling depth ≥ L+d ₁)	8-10	Emulsion	Recommended use

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