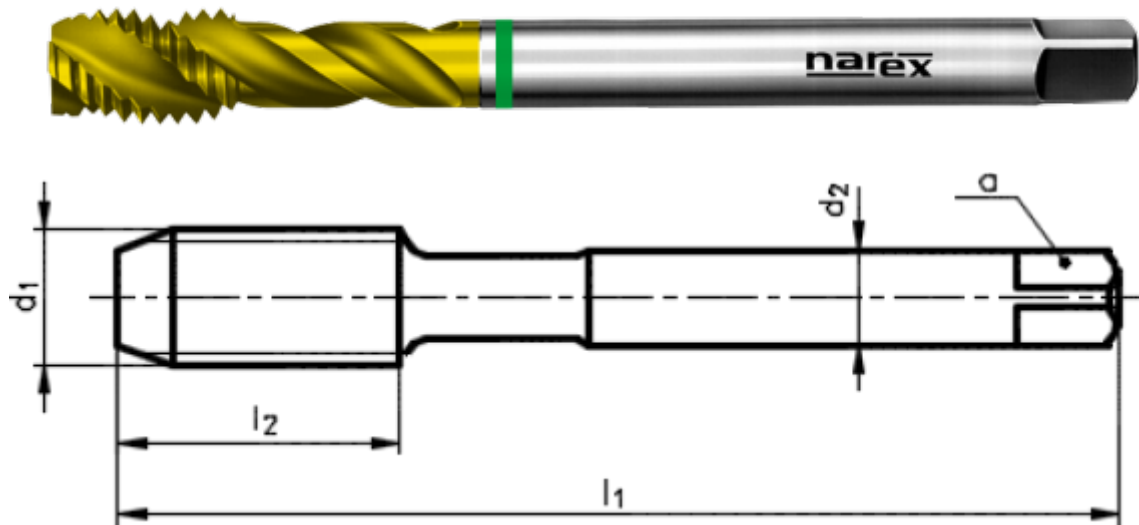


Machine tap with right-hand spiral flutes 35°

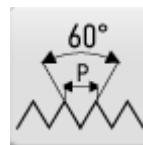


CATALOGUE NUMBER: 4210

Machine tap with spiral flutes, metric, DIN 376, TiN coated, suitable for universal use.



THREAD M
ISO Metric coarse thread



PROFILE SKETCH
60°



THREAD STANDARD
DIN13



TYPE UNI
Tap for universal applications



TAP MATERIAL
Vanadium extra high speed steel HSSE V3



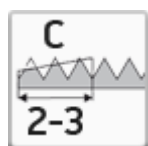
COATING
Titanium nitride coating



TAP STANDARD
DIN 376



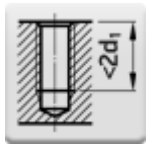
THREAD TOLERANCE
ISO 2 - 6H



CHAMFER C
Length 2-3 pitch



SPIRAL FLUTE ANGLE
35°



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
041535324120000	M12	1,75	6H	110	18	9	7	28.70 EUR	34.73 EUR
041535324140000	M14	2	6H	110	20	11	9	35.85 EUR	43.38 EUR
041535324160000	M16	2	6H	110	20	12	9	39.40 EUR	47.67 EUR
041535324180000	M18	2,5	6H	125	25	14	11	56.80 EUR	68.73 EUR
041535324200000	M20	2,5	6H	140	25	16	12	58.55 EUR	70.85 EUR

Use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Aluminium alloys si content $< 10\%$	blind hole (thread length $L < 2xd_1$)	12-20	Emulsion	Recommended use
Aluminium alloys si content $< 10\%$	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$)	12-20	Emulsion	Recommended use
Aluminium alloys si content $< 10\%$	blind hole (thread length $L < 1,5xd_1$)	12-20	Emulsion	Recommended use
Aluminium alloys si content $> 10\%$	blind hole (thread length $L < 2xd_1$)	12-20	Emulsion	Possible use
Aluminium alloys si content $> 10\%$	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$)	12-20	Emulsion	Possible use
Aluminium alloys si content $> 10\%$	blind hole (thread length $L < 1,5xd_1$)	12-20	Emulsion	Possible use
Case hardened steels and nitriding steels up to 1100 N/mm ²	blind hole (thread length $L < 1,5xd_1$)	4-6	Cutting Oil/Emulsion	Recommended use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Case hardened steels and nitriding steels up to 1100 N/mm ²	blind hole (thread length $L < 2d_1$)	4-6	Cutting Oil/Emulsion	Recommended use
Case hardened steels and nitriding steels up to 1100 N/mm ²	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$)	4-6	Cutting Oil/Emulsion	Recommended use
Copper alloys (long chipping)	blind hole (thread length $L < 2xd_1$)	12-20	Cutting Oil	Recommended use
Copper alloys (long chipping)	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$)	12-20	Cutting Oil	Recommended use
Copper alloys (long chipping)	blind hole (thread length $L < 1,5xd_1$)	12-20	Cutting Oil	Recommended use
Free cutting steels up to 800 N/mm ²	blind hole (thread length $L < 2xd_1$)	8-10	Cutting Oil/Emulsion	Possible use
Free cutting steels up to 800 N/mm ²	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$)	8-10	Cutting Oil/Emulsion	Possible use
Free cutting steels up to 800 N/mm ²	blind hole (thread length $L < 1,5xd_1$)	8-10	Cutting Oil/Emulsion	Possible use
Grey cast iron	blind hole (thread length $L < 2xd_1$)	8-12	Emulsion	Possible use
Grey cast iron	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$)	8-12	Emulsion	Possible use
Grey cast iron	blind hole (thread length $L < 2,5xd_1$)	8-12	Emulsion	Possible use
Grey cast iron	blind hole (thread length $L < 1,5xd_1$)	8-12	Emulsion	Possible use
Heat-treated steels up to 1100 N/mm ²	blind hole (thread length $L < 1,5xd_1$)	4-6	Cutting Oil/Emulsion	Recommended use
Heat-treated steels up to 1100 N/mm ²	blind hole (thread length $L < 2xd_1$)	4-6	Cutting Oil/Emulsion	Recommended use
Heat-treated steels up to 1100 N/mm ²	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$)	4-6	Cutting Oil/Emulsion	Recommended use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length $L < 1,5xd_1$)	7-10	Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length $L < 2xd_1$)	7-10	Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$)	7-10	Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length $L < 2,5xd_1$)	7-10	Emulsion	Possible use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm ²	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$)	6-10	Cutting Oil	Possible use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm ²	blind hole (thread length $L < 1,5xd_1$)	6-10	Cutting Oil	Possible use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Stainless steels and heat resisting steels with strength 450 - 800 N/mm ²	blind hole (thread length $L < 2 \times d_1$)	6-10	Cutting Oil	Possible use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm ²	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L + d_1$)	4-7	Cutting Oil	Possible use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm ²	blind hole (thread length $L < 1,5 \times d_1$)	4-7	Cutting Oil	Possible use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm ²	blind hole (thread length $L < 2 \times d_1$)	4-7	Cutting Oil	Possible use
Structural steels and heat-treated steels up to 800 N/mm ²	blind hole (thread length $L < 2 \times d_1$)	8-10	Cutting Oil/Emulsion	Recommended use
Structural steels and heat-treated steels up to 800 N/mm ²	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L + d_1$)	8-10	Cutting Oil/Emulsion	Recommended use
Structural steels and heat-treated steels up to 800 N/mm ²	blind hole (thread length $L < 1,5 \times d_1$)	8-10	Cutting Oil/Emulsion	Recommended use
Tool steels up to 1100 N/mm ²	blind hole (thread length $L < 1,5 \times d_1$)	4-6	Cutting Oil/Emulsion	Possible use
Tool steels up to 1100 N/mm ²	blind hole (thread length $L < 2 \times d_1$)	4-6	Cutting Oil/Emulsion	Possible use
Tool steels up to 1100 N/mm ²	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L + d_1$)	4-6	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
Web: www.narexzd.cz