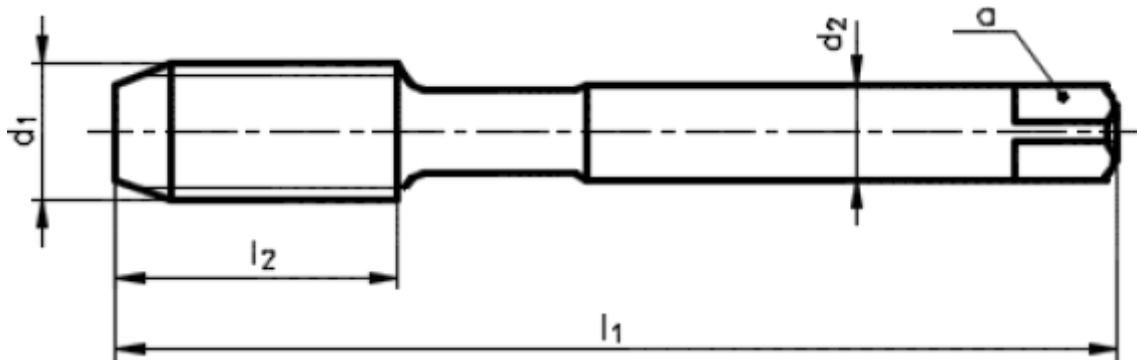


Machine tap with spiral flute 40°

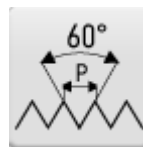


CATALOGUE NUMBER: 4280NX

High performance machine tap with spiral flutes, metric, DIN 376, TiCN coated, suitable for case hardened and nitriding steels, stainless steels with strength up to 1000 N/mm², spheroidal and malleable cast iron, aluminium alloys, copper and zinc alloys.



THREAD M
ISO Metric coarse thread



PROFILE SKETCH
60°



THREAD STANDARD
DIN13



TYPE VA
Tap for stainless steels



TAP MATERIAL
Vanadium extra high speed steel HSSE V3



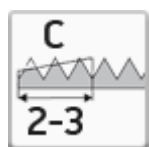
COATING
Titanium carbonitridenitride coating



TAP STANDARD
DIN 376



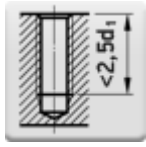
THREAD TOLERANCE
ISO 2 - 6H



CHAMFER C
Length 2-3 pitch



SPIRAL FLUTE ANGLE
40°



HOLE TYPE

Blind hole (thread length $< 2,5 d_1$)

Select product model

ID	D1	P	Tolerance	l1	l2	d2	a	Price excl. VAT	Price incl. VAT
042038332120000	M12	1,75	6H	110	18	9	7	81.10 EUR	98.13 EUR
042038332160000	M16	2	6H	110	20	12	9	118.10 EUR	142.90 EUR
042038332200000	M20	2,5	6H	140	25	16	12	176.65 EUR	213.75 EUR
042038332220000	M22	2,5	6H	140	25	18	14,5	Ask for price	
042038332240000	M24	3	6H	160	30	18	14,5	225.30 EUR	272.61 EUR
042038332270000	M27	3	6H	160	30	20	16	298.30 EUR	360.94 EUR
042038332300000	M30	3,5	6H	180	35	22	18	351.70 EUR	425.56 EUR
042038332330000	M33	3,5	6H	180	35	25	20	415.90 EUR	503.24 EUR
042038332360000	M36	4	6H	200	40	28	22	441.35 EUR	534.03 EUR

Use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Aluminium alloys si content $< 10\%$	blind hole (thread length $L < 1,5d_1$)	15-20	Cutting Oil/Emulsion	Possible use
Aluminium alloys si content $< 10\%$	blind hole (thread length $L < 2xd_1$)	15-20	Cutting Oil/Emulsion	Possible use
Aluminium alloys si content $< 10\%$	blind hole (thread length $L < 2,5xd_1$)	15-20	Cutting Oil/Emulsion	Possible use
Aluminium alloys si content $< 10\%$	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$)	15-20	Cutting Oil/Emulsion	Possible use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Aluminium alloys si content > 10%	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	12-15	Cutting Oil/Emulsion	Recommended use
Aluminium alloys si content > 10%	blind hole (thread length L < 1,5xd1)	12-15	Cutting Oil/Emulsion	Recommended use
Aluminium alloys si content > 10%	blind hole (thread length L < 2xd1)	12-15	Cutting Oil/Emulsion	Recommended use
Aluminium alloys si content > 10%	blind hole (thread length L < 2,5xd1)	12-15	Cutting Oil/Emulsion	Recommended use
Case hardened steels and nitriding steels up to 1100 N/mm2	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	10-12	Cutting Oil/Emulsion	Recommended use
Case hardened steels and nitriding steels up to 1100 N/mm2	blind hole (thread length L < 1,5xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Case hardened steels and nitriding steels up to 1100 N/mm2	blind hole (thread length L < 2xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Case hardened steels and nitriding steels up to 1100 N/mm2	blind hole (thread length L < 2,5xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Copper alloys (long chipping)	blind hole (thread length L < 2xd1)	10-12	Cutting Oil/Emulsion	Possible use
Copper alloys (long chipping)	blind hole (thread length L < 1,5xd1)	10-12	Cutting Oil/Emulsion	Possible use
Copper alloys (long chipping)	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	10-12	Cutting Oil/Emulsion	Possible use
Copper alloys (long chipping)	blind hole (thread length L < 2,5xd1)	10-12	Cutting Oil/Emulsion	Possible use
Copper alloys (short chipping)	blind hole (thread length L < 1,5xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Copper alloys (short chipping)	blind hole (thread length L < 2xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Copper alloys (short chipping)	blind hole (thread length L < 2,5xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Copper alloys (short chipping)	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	10-12	Cutting Oil/Emulsion	Recommended use
Free cutting steels up to 800 N/mm2	blind hole (thread length L < 1,5xd1)	10-12	Cutting Oil/Emulsion	Possible use
Free cutting steels up to 800 N/mm2	blind hole (thread length L < 2xd1)	10-12	Cutting Oil/Emulsion	Possible use
Free cutting steels up to 800 N/mm2	blind hole (thread length L < 2,5xd1)	10-12	Cutting Oil/Emulsion	Possible use
Free cutting steels up to 800 N/mm2	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	10-12	Cutting Oil/Emulsion	Possible use
Heat-treated steels up to 1100 N/mm2	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	10-12	Cutting Oil/Emulsion	Recommended use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Heat-treated steels up to 1100 N/mm ²	blind hole (thread length $L < 1,5d_1$)	10-12	Cutting Oil/Emulsion	Recommended use
Heat-treated steels up to 1100 N/mm ²	blind hole (thread length $L < 2xd_1$)	10-12	Cutting Oil/Emulsion	Recommended use
Heat-treated steels up to 1100 N/mm ²	blind hole (thread length $L < 2,5d_1$)	10-12	Cutting Oil/Emulsion	Recommended 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
Plain cast steels up to 800 N/mm ²	blind hole (thread length $L < 2xd_1$)	10-12	Cutting Oil/Emulsion	Possible use
Plain cast steels up to 800 N/mm ²	blind hole (thread length $L < 2,5d_1$)	10-12	Cutting Oil/Emulsion	Possible use
Plain cast steels up to 800 N/mm ²	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$)	10-12	Cutting Oil/Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$)	12-15	Cutting Oil/Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length $L < 1,5d_1$)	12-15	Cutting Oil/Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length $L < 2xd_1$)	12-15	Cutting Oil/Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length $L < 2,5d_1$)	12-15	Cutting Oil/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 $\geq L+d_1$)	10-12	Cutting Oil/Emulsion	Recommended use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm ²	blind hole (thread length $L < 1,5d_1$)	10-12	Cutting Oil/Emulsion	Recommended use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm ²	blind hole (thread length $L < 2xd_1$)	10-12	Cutting Oil/Emulsion	Recommended use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm ²	blind hole (thread length $L < 2,5d_1$)	10-12	Cutting Oil/Emulsion	Recommended use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm ²	blind hole (thread length $L < 1,5d_1$)	10-12	Cutting Oil/Emulsion	Recommended use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm ²	blind hole (thread length $L < 2xd_1$)	10-12	Cutting Oil/Emulsion	Recommended use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm ²	blind hole (thread length $L < 2,5d_1$)	10-12	Cutting Oil/Emulsion	Recommended 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 $\geq L+d_1$)	10-12	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 $\geq L+d_1$)	10-12	Cutting Oil/Emulsion	Possible use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Structural steels and heat-treated 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 $L < 2,5xd_1$)	10-12	Cutting Oil/Emulsion	Possible use
Tool steels up to 1100 N/mm ²	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$)	10-12	Cutting Oil/Emulsion	Recommended use
Tool steels up to 1100 N/mm ²	blind hole (thread length $L < 1,5xd_1$)	10-12	Cutting Oil/Emulsion	Recommended use
Tool steels up to 1100 N/mm ²	blind hole (thread length $L < 2xd_1$)	10-12	Cutting Oil/Emulsion	Recommended use
Tool steels up to 1100 N/mm ²	blind hole (thread length $L < 2,5xd_1$)	10-12	Cutting Oil/Emulsion	Recommended use
Unalloyed aluminium	blind hole (thread length $L < 1,5xd_1$)	15-30	Cutting Oil/Emulsion	Possible use
Unalloyed aluminium	blind hole (thread length $L < 2xd_1$)	15-30	Cutting Oil/Emulsion	Possible use
Unalloyed aluminium	blind hole (thread length $L < 2,5xd_1$)	15-30	Cutting Oil/Emulsion	Possible use
Unalloyed aluminium	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$)	15-30	Cutting Oil/Emulsion	Possible use
Unalloyed copper	blind hole (thread length $L < 1,5xd_1$)	15-20	Cutting Oil/Emulsion	Possible use
Unalloyed copper	blind hole (thread length $L < 2xd_1$)	15-20	Cutting Oil/Emulsion	Possible use
Unalloyed copper	blind hole (thread length $L < 2,5xd_1$)	15-20	Cutting Oil/Emulsion	Possible use
Unalloyed copper	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$)	15-20	Cutting Oil/Emulsion	Possible use
Zinc and zinc alloys	blind hole (thread length $L < 1,5xd_1$)	10-12	Cutting Oil/Emulsion	Possible use
Zinc and zinc alloys	blind hole (thread length $L < 2xd_1$)	10-12	Cutting Oil/Emulsion	Possible use
Zinc and zinc alloys	blind hole (thread length $L < 2,5xd_1$)	10-12	Cutting Oil/Emulsion	Possible use
Zinc and zinc alloys	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$)	10-12	Cutting Oil/Emulsion	Possible use