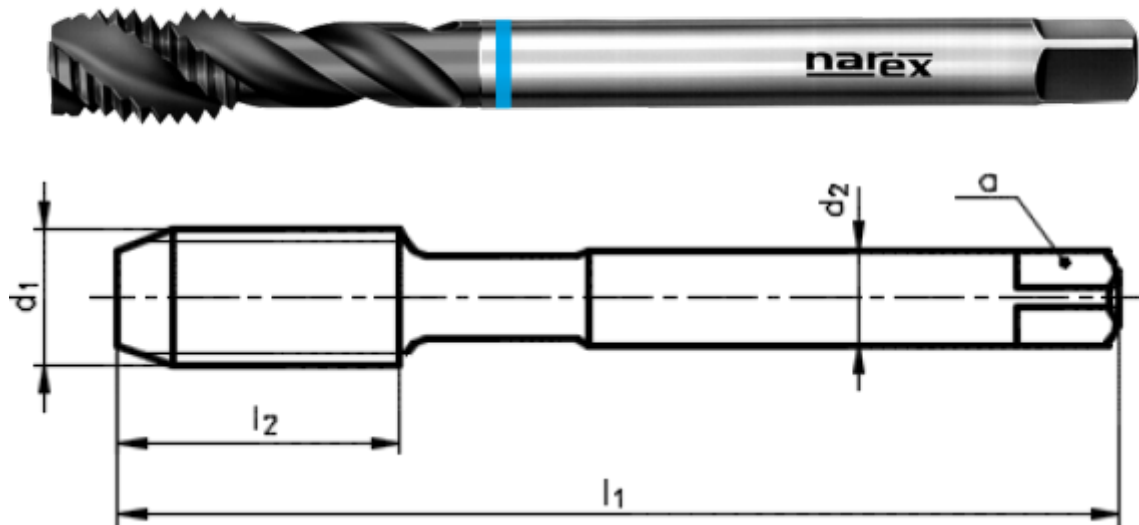


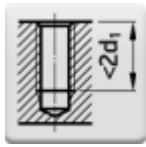
Machine tap with right-hand spiral flutes 35°



CATALOGUE NUMBER: 4320

Machine tap with spiral flutes, metric, DIN 376, Balinit Hardlube coated, suitable for case hardened and nitriding steels, stainless steels with strength up to 1000 N/mm², tools steels, spheroidal and malleable cast iron, unalloyed copper and long chipping copper alloys.

	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 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	I1	I2	d2	a	Price excl. VAT	Price incl. VAT
041536382120000	M12	1,75	6H	110	18	9	7	43.35 EUR	52.45 EUR

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 $L < 2 \times d_1$)	6-8	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 $\geq L + d_1$)	6-8	Cutting Oil/Emulsion	Recommended use
Case hardened steels and nitriding steels up to 1100 N/mm ²	blind hole (thread length $L < 1,5 \times d_1$)	6-8	Cutting Oil/Emulsion	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 $L < 1,5 \times d_1$)	12-20	Cutting Oil	Recommended use
Copper alloys (long chipping)	blind hole (thread length $L < 2 \times d_1$)	12-20	Cutting Oil	Recommended use
Heat-treated steels up to 1100 N/mm ²	blind hole (thread length $L < 1,5 \times d_1$)	4-6	Cutting Oil/Emulsion	Possible use
Heat-treated steels up to 1100 N/mm ²	blind hole (thread length $L < 2 \times d_1$)	4-6	Cutting Oil/Emulsion	Possible 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	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 $L < 1,5d_1$)	8-14	Cutting Oil	Recommended use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm ²	blind hole (thread length $L < 2d_1$)	8-14	Cutting Oil	Recommended 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 $\geq L+d_1$)	8-14	Cutting Oil	Recommended use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm ²	blind hole (thread length $L < 1,5d_1$)	6-10	Cutting Oil	Recommended use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm ²	blind hole (thread length $L < 2d_1$)	6-10	Cutting Oil	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 $\geq L+d_1$)	6-10	Cutting Oil	Recommended use
Tool steels up to 1100 N/mm ²	blind hole (thread length $L < 2d_1$)	6-8	Cutting Oil/Emulsion	Recommended use
Tool steels up to 1100 N/mm ²	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$)	6-8	Cutting Oil/Emulsion	Recommended use
Tool steels up to 1100 N/mm ²	blind hole (thread length $L < 1,5d_1$)	6-8	Cutting Oil/Emulsion	Recommended use
Unalloyed copper	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$)	10-15	Cutting Oil	Recommended use
Unalloyed copper	blind hole (thread length $L < 1,5d_1$)	10-15	Cutting Oil	Recommended use
Unalloyed copper	blind hole (thread length $L < 2d_1$)	10-15	Cutting Oil	Recommended use

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