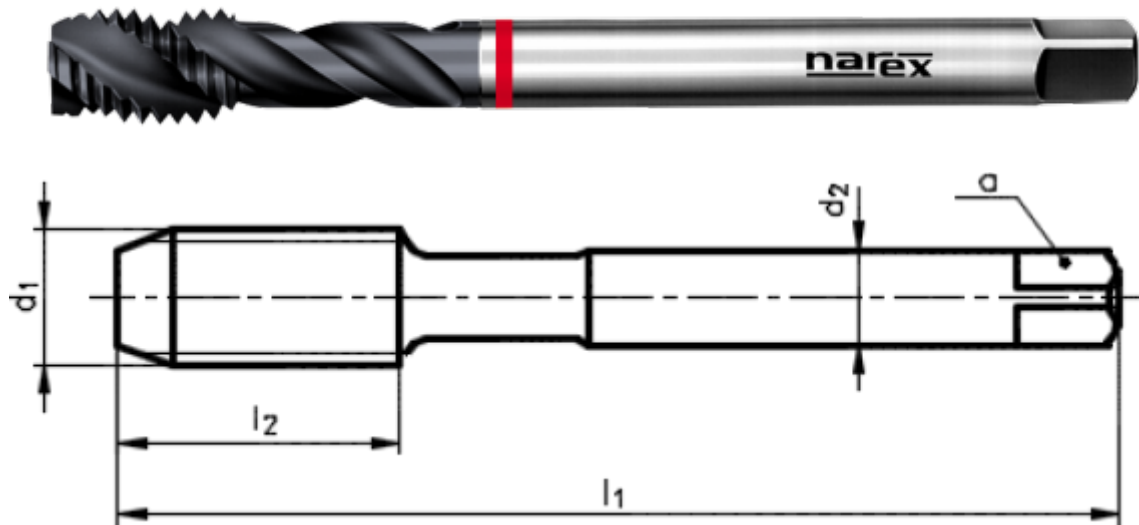


# Machine tap with right-hand spiral flutes 40°



## CATALOGUE NUMBER: 4680

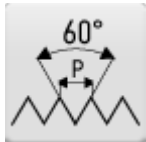
Machine tap with spiral flute, metric and metric fine, DIN 376, DIN 374, TiCN coated, suitable for case hardened and nitriding steels, heat-treated steels, tool steels, spheroidal and malleable cast iron

**M**

**THREAD M**  
ISO Metric coarse thread

**MF**

**THREAD MF**  
ISO Metric fine thread



**PROFILE SKETCH**  
60°

**DIN 13**

**THREAD STANDARD**  
DIN13

**typ H**

**TYPE H**  
Tap for steels up to 1100 N/mm<sup>2</sup>

**HSSE V3**

**TAP MATERIAL**  
Vanadium extra high speed steel HSSE V3

**TiCN**

**COATING**  
Titanium carbonitridenitride coating

**DIN 376**

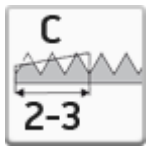
**TAP STANDARD**  
DIN 376

**DIN 374**

**TAP STANDARD**  
DIN 374

**ISO 2 6H**

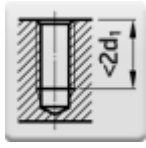
**THREAD TOLERANCE**  
ISO 2 - 6H



**CHAMFER C**  
Length 2-3 pitch



**SPIRAL FLUTE ANGLE**  
40°



**HOLE TYPE**  
Blind hole (thread length < 2 d1)

## Select product model

ID	D1	P	Tolerance	l1	l2	d2	a	Price excl. VAT	Price incl. VAT
041538336030000	M3	0,5	6H	56	5	2,2	-	18.55 EUR	22.45 EUR
041538336040000	M4	0,7	6H	63	7	2,8	2,1	18.80 EUR	22.75 EUR
041538336050000	M5	0,8	6H	70	8	3,5	2,7	19.70 EUR	23.84 EUR
041538336060000	M6	1	6H	80	10	4,5	3,4	19.70 EUR	23.84 EUR
041538336080000	M8	1,25	6H	90	13	6	4,9	21.50 EUR	26.02 EUR
041538336100000	M10	1,5	6H	100	15	7	5,5	26.80 EUR	32.43 EUR
041538336120000	M12	1,75	6H	110	18	9	7	31.40 EUR	37.99 EUR
041538336140000	M14	2	6H	110	20	11	9	39.20 EUR	47.43 EUR
041538336160000	M16	2	6H	110	20	12	9	43.00 EUR	52.03 EUR
041538336180000	M18	2,5	6H	125	25	14	11	61.90 EUR	74.90 EUR
041538336200000	M20	2,5	6H	140	25	16	12	64.00 EUR	77.44 EUR
041538336220000	M22	2,5	6H	140	25	18	14,5	85.75 EUR	103.76 EUR
041538336240000	M24	3	6H	160	30	18	14,5	81.65 EUR	98.80 EUR
041538336270000	M27	3	6H	160	30	20	16	109.40 EUR	132.37 EUR
041538336300000	M30	3,5	6H	180	35	22	18	137.90 EUR	166.86 EUR
041538536068000	M6	0,75	6H	80	10	4,5	3,4	28.85 EUR	34.91 EUR
041538536087000	M8	1	6H	90	13	6	4,9	28.85 EUR	34.91 EUR
041538536088000	M8	0,75	6H	80	10	6	4,9	31.50 EUR	38.12 EUR
041538536107000	M10	1	6H	90	12	7	5,5	31.15 EUR	37.69 EUR
041538536125000	M12	1,5	6H	100	14	9	7	34.90 EUR	42.23 EUR
041538536127000	M12	1	6H	100	14	9	7	36.95 EUR	44.71 EUR

ID	D1	P	Tolerance	l1	l2	d2	a	Price excl. VAT	Price incl. VAT
041538536145000	M14	1,5	6H	100	16	11	9	45.45 EUR	54.99 EUR
041538536165000	M16	1,5	6H	100	16	12	9	55.05 EUR	66.61 EUR
041538536185000	M18	1,5	6H	110	20	14	11	62.45 EUR	75.56 EUR
041538536205000	M20	1,5	6H	125	20	16	12	71.30 EUR	86.27 EUR

## Use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Aluminium alloys si content > 10%	blind hole (thread length $L < 1,5 \times d1$ )	12-20	Emulsion	Recommended use
Aluminium alloys si content > 10%	blind hole (thread length $L < 2 \times d1$ )	12-20	Emulsion	Recommended use
Aluminium alloys si content > 10%	blind hole (thread length $< 1,5 \times d1$ , pilot drilling depth $\geq L + d1$ )	12-20	Emulsion	Recommended use
Aluminium alloys si content > 10%	blind hole (thread length $L < 2,5 \times d1$ )	12-20	Emulsion	Recommended use
Case hardened steels and nitriding steels up to 1100 N/mm <sup>2</sup>	blind hole (thread length $L < 1,5 \times d1$ )	3-5	Cutting Oil/Emulsion	Possible use
Case hardened steels and nitriding steels up to 1100 N/mm <sup>2</sup>	blind hole (thread length $L < 2 \times d1$ )	3-5	Cutting Oil/Emulsion	Possible use
Case hardened steels and nitriding steels up to 1100 N/mm <sup>2</sup>	blind hole (thread length $< 1,5 \times d1$ , pilot drilling depth $\geq L + d1$ )	3-5	Cutting Oil/Emulsion	Possible use
Heat-treated steels up to 1100 N/mm <sup>2</sup>	blind hole (thread length $< 1,5 \times d1$ , pilot drilling depth $\geq L + d1$ )	6-8	Cutting Oil/Emulsion	Recommended use
Heat-treated steels up to 1100 N/mm <sup>2</sup>	blind hole (thread length $L < 1,5 \times d1$ )	6-8	Cutting Oil/Emulsion	Recommended use
Heat-treated steels up to 1100 N/mm <sup>2</sup>	blind hole (thread length $L < 2 \times d1$ )	6-8	Cutting Oil/Emulsion	Recommended use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length $L < 2 \times d1$ )	7-10	Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length $< 1,5 \times d1$ , pilot drilling depth $\geq L + d1$ )	7-10	Emulsion	Possible use

<b>MACHINED MATERIAL</b>	<b>HOLE TYPE</b>	<b>CUTTING SPEED</b>	<b>LUBRICATION</b>	<b>USE</b>
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length $L < 2,5 \times d_1$ )	7-10	Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length $L < 1,5 \times d_1$ )	7-10	Emulsion	Possible use
Tool steels up to 1100 N/mm <sup>2</sup>	blind hole (thread length $< 1,5 d_1$ , pilot drilling depth $\geq L+d_1$ )	3-5	Cutting Oil/Emulsion	Possible use
Tool steels up to 1100 N/mm <sup>2</sup>	blind hole (thread length $L < 1,5 \times d_1$ )	3-5	Cutting Oil/Emulsion	Possible use
Tool steels up to 1100 N/mm <sup>2</sup>	blind hole (thread length $L < 2 \times d_1$ )	3-5	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](mailto:sales@narexzd.cz)  
Web: [www.narexzd.cz](http://www.narexzd.cz)