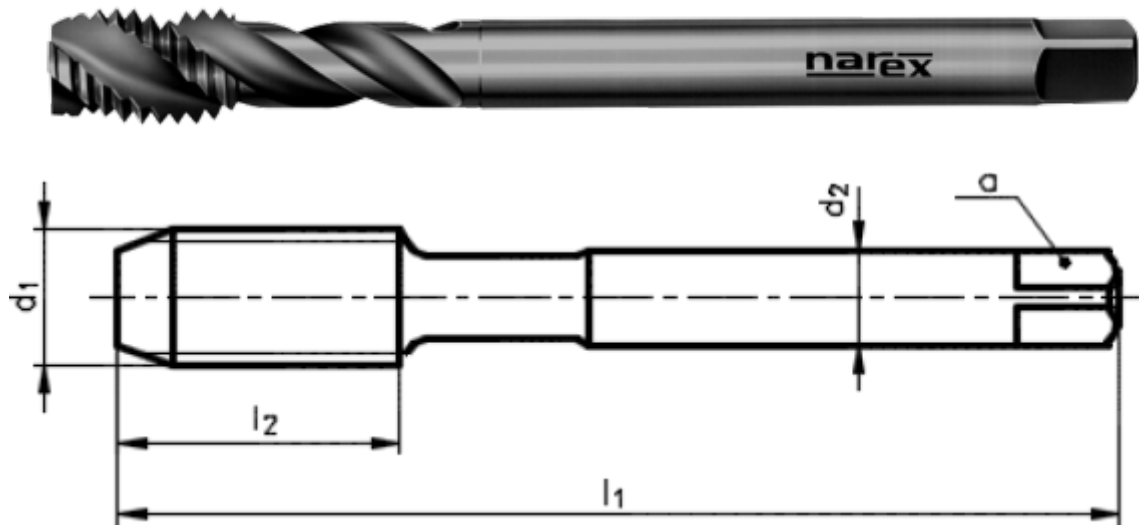


Machine tap with right-hand spiral flutes 40°



CATALOGUE NUMBER: 4690

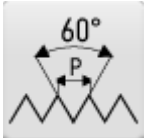
Machine tap with spiral flute, metric and metric fine, DIN 376, DIN 374, steam oxidized, suitable for case hardened and nitriding steels, heat-treated steels, tool steels, possible use in aluminium alloys with Si > 10 %

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/mm²

HSSE V3

TAP MATERIAL
Vanadium extra high speed steel HSSE V3

OX

COATING
Oxidation

DIN 376

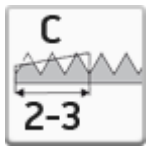
TAP STANDARD
DIN 376

DIN 374

TAP STANDARD
DIN 374

ISO 2 6H

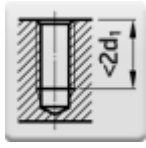
THREAD TOLERANCE
ISO 2 - 6H



CHAMFER C
Length 2-3 pitch



SPIRAL FLUTE ANGLE
40°



HOLE TYPE
Blind hole (thread length <math>< 2 d_1</math>)

Select product model

ID	D1	P	Tolerance	l1	l2	d2	a	Price excl. VAT	Price incl. VAT
041537336030000	M3	0,5	6H	56	5	2,2	-	13.50 EUR	16.34 EUR
041537336040000	M4	0,7	6H	63	7	2,8	2,1	13.90 EUR	16.82 EUR
041537336050000	M5	0,8	6H	70	8	3,5	2,7	14.35 EUR	17.36 EUR
041537336060000	M6	1	6H	80	10	4,5	3,4	14.35 EUR	17.36 EUR
041537336080000	M8	1,25	6H	90	13	6	4,9	15.75 EUR	19.06 EUR
041537336100000	M10	1,5	6H	100	15	7	5,5	19.75 EUR	23.90 EUR
041537336120000	M12	1,75	6H	110	18	9	7	22.90 EUR	27.71 EUR
041537336140000	M14	2	6H	110	20	11	9	28.70 EUR	34.73 EUR
041537336160000	M16	2	6H	110	20	12	9	31.45 EUR	38.05 EUR
041537336180000	M18	2,5	6H	125	25	14	11	45.35 EUR	54.87 EUR
041537336200000	M20	2,5	6H	140	25	16	12	46.85 EUR	56.69 EUR
041537336220000	M22	2,5	6H	140	25	18	14,5	62.75 EUR	75.93 EUR
041537336240000	M24	3	6H	160	30	18	14,5	59.65 EUR	72.18 EUR
041537336270000	M27	3	6H	160	30	20	16	80.05 EUR	96.86 EUR
041537336300000	M30	3,5	6H	180	35	22	18	100.80 EUR	121.97 EUR
041537536068000	M6	0,75	6H	80	10	4,5	3,4	20.35 EUR	24.62 EUR
041537536087000	M8	1	6H	90	13	6	4,9	20.35 EUR	24.62 EUR
041537536088000	M8	0,75	6H	80	10	6	4,9	22.15 EUR	26.80 EUR
041537536107000	M10	1	6H	90	12	7	5,5	21.95 EUR	26.56 EUR
041537536125000	M12	1,5	6H	100	14	9	7	24.60 EUR	29.77 EUR
041537536127000	M12	1	6H	100	14	9	7	26.10 EUR	31.58 EUR

ID	D1	P	Tolerance	l1	l2	d2	a	Price excl. VAT	Price incl. VAT
041537536145000	M14	1,5	6H	100	16	11	9	32.05 EUR	38.78 EUR
041537536165000	M16	1,5	6H	100	16	12	9	38.85 EUR	47.01 EUR
041537536185000	M18	1,5	6H	110	20	14	11	44.00 EUR	53.24 EUR
041537536205000	M20	1,5	6H	125	20	16	12	50.40 EUR	60.98 EUR

Use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Heat-treated steels up to 1100 N/mm2	blind hole (thread length $L < 1,5 \times d1$)	3-5	Cutting Oil	Possible use
Heat-treated steels up to 1100 N/mm2	blind hole (thread length $L < 2 \times d1$)	3-5	Cutting Oil	Possible use
Heat-treated steels up to 1100 N/mm2	blind hole (thread length $< 1,5 \times d1$, pilot drilling depth $\geq L + d1$)	3-5	Cutting Oil	Possible use

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