

# Threading tool sets

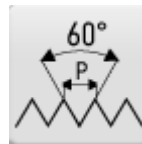


## CATALOGUE NUMBER: 9900

C-N-B Set of taps cat. No. 1540 M3, M4, M5, M6, M8, M10 and cat. No. 3540 M12 + core drills DIN 338 2,5, 3,3, 4,2, 5,0, 6,8, 8,5, 10,2



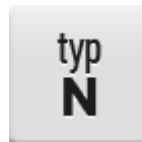
**THREAD M**  
ISO Metric coarse thread



**PROFILE SKETCH**  
60°



**THREAD STANDARD**  
DIN13



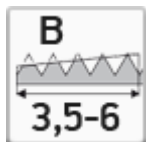
**TYPE N**  
Tap for steels up to 800 N/mm<sup>2</sup>



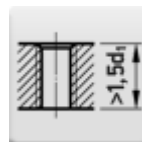
**TAP MATERIAL**  
Super high speed steel



**THREAD TOLERANCE**  
ISO 2 - 6H



**CHAMFER B**  
Length 3,5-6 pitch



**HOLE TYPE**  
Through hole (thread length  $L > 1,5 \times d_1$ )

# Select product model

ID	Price excl. VAT	Price incl. VAT
041139445500000	109.65 EUR	132.68 EUR

## Use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Aluminium alloys si content < 10%	through hole (thread length L < 1,5xd1)	14-20	Emulsion	Recommended use
Aluminium alloys si content < 10%	through hole (thread length L > 1,5xd1)	14-20	Emulsion	Recommended use
Aluminium alloys si content > 10%	through hole (thread length L < 1,5xd1)	12-15	Emulsion	Possible use
Aluminium alloys si content > 10%	through hole (thread length L > 1,5xd1)	12-15	Emulsion	Possible use
Plain cast steels up to 500 N/mm2	through hole (thread length L > 1,5xd1)	6-10	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 500 N/mm2	through hole (thread length L < 1,5xd1)	6-10	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 800 N/mm2	through hole (thread length L < 1,5xd1)	12-15	Cutting Oil/Emulsion	Possible use
Plain cast steels up to 800 N/mm2	through hole (thread length L > 1,5xd1)	12-15	Cutting Oil/Emulsion	Possible use
Structural steels and heat-treated steels up to 800 N/mm2	through hole (thread length L > 1,5xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Structural steels and heat-treated steels up to 800 N/mm2	through hole (thread length L < 1,5xd1)	10-12	Cutting Oil/Emulsion	Recommended use
Zinc and zinc alloys	through hole (thread length L < 1,5xd1)	10-12	Emulsion	Recommended use

<b>MACHINED MATERIAL</b>	<b>HOLE TYPE</b>	<b>CUTTING SPEED</b>	<b>LUBRICATION</b>	<b>USE</b>
Zinc and zinc alloys	through hole (thread length $L > 1,5 \times d_1$ )	10-12	Emulsion	Recommended use

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