

# Threading tool sets

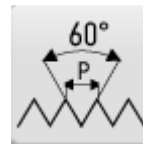


## CATALOGUE NUMBER: 9930

C-VA-RSP Set of taps cat. No. 2290 M3, M4, M5, M6, M8, M10 and cat. No. 4290 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



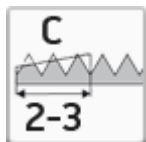
**TYPE VA**  
Tap for stainless steels



**TAP MATERIAL**  
Super high speed steel



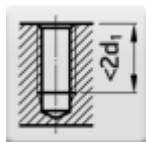
**THREAD TOLERANCE**  
ISO 2 - 6H



**CHAMFER C**  
Length 2-3 pitch



**SPIRAL FLUTE ANGLE**  
35°



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

# Select product model

ID	Price excl. VAT	Price incl. VAT
041139445503000	143.85 EUR	174.06 EUR

## Use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Case hardened steels and nitriding steels up to 1100 N/mm <sup>2</sup>	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	3-5	Cutting Oil	Possible use
Case hardened steels and nitriding steels up to 1100 N/mm <sup>2</sup>	blind hole (thread length L < 1,5xd1)	3-5	Cutting Oil	Possible use
Case hardened steels and nitriding steels up to 1100 N/mm <sup>2</sup>	blind hole (thread length L < 2xd1)	3-5	Cutting Oil	Possible use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm <sup>2</sup>	blind hole (thread length L < 2xd1)	4-7	Cutting Oil	Possible use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm <sup>2</sup>	blind hole (thread length L < 1,5xd1)	4-7	Cutting Oil	Possible use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm <sup>2</sup>	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	4-7	Cutting Oil	Possible use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm <sup>2</sup>	blind hole (thread length L < 2xd1)	3-5	Cutting Oil	Possible use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm <sup>2</sup>	blind hole (thread length < 1,5 d1, pilot drilling depth ≥ L+d1)	3-5	Cutting Oil	Possible use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm <sup>2</sup>	blind hole (thread length L < 1,5xd1)	3-5	Cutting Oil	Possible use

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