

ATORN Machine tap

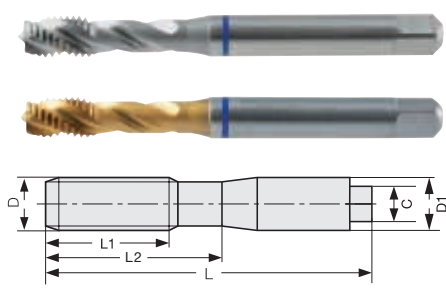
M
60°
HSS-E
DIN 371
DIN 376
ISO 2 6H
C 2-3
40°
2,5xD
TiN
i Vc/fz
398 400

- ISO 6H metric thread
- 40°, spiral-flute
- Type C, 2-3 thread chamfer
- DIN 371 construction dimensions = up to M10, DIN 376 = from M12
- **Cutting material: HSS-E, HSS-E TiN**
- For blind-hole threads
- Strong chip removal to the rear for long-chipping materials
- Minimal thread relief grinding
- Possible thread depth 2.5 x D

Up to 1000 N/mm²

material	● very well suited	steel			stainless steel			cast iron		titanium alloys	superalloys Fe/NiCo-based		aluminium		copper	graphite	hardened steel			
	○ well suited	< 700 N/mm ²	< 1000 N/mm ²	< 1400 N/mm ²	ferrit./martens.	austenitic	duplex	GG/GTS	GGG		< 30 HRc	≥ 30 HRc	< 8 % Si	≥ 8 % Si	Cu-alloy	GRP/CFP/thermo.	< 55 HRc	< 60 HRc	≥ 60 HRc	
134200....	●	12	10		○	○			○											
134205....	●	22	18		○	○			○											

Cutting speed Vc m/min. Please adjust these guidelines according to clamping operation and machine set-up.



D mm	Pitch mm	L mm	L1 mm	L2 mm	D1 mm	C mm	Tapping hole Ø mm	art.no.		€	
								134200	134205	TiN	€
M 2	0.4	45	8	-	2.8	2.1	1.60	134200 0020	21,20	134205 0020	30,30
M 2.5	0.45	50	9	-	2.8	2.1	2.05	134200 0025	21,20	134205 0025	30,30
M 3	0.5	56	6	18	3.5	2.7	2.50	134200 0030	16,90	134205 0030	26,70
M 4	0.7	63	7	21	4.5	3.4	3.30	134200 0040	16,90	134205 0040	26,70
M 5	0.8	70	8	25	6	4.9	4.20	134200 0050	17,-	134205 0050	26,80
M 6	1	80	10	30	6	4.9	5.00	134200 0060	17,25	134205 0060	28,-
M 8	1.25	90	13	35	8	6.2	6.80	134200 0080	21,60	134205 0080	32,90
M 10	1.5	100	15	39	10	8	8.50	134200 0100	25,70	134205 0100	38,20
M 12	1.75	110	18	-	9	7	10.25	134200 0120	36,60	134205 0120	52,70
M 14	2	110	20	-	11	9	12.00	134200 0140	52,20		
M 16	2	110	20	-	12	9	14.00	134200 0160	54,90	134205 0160	77,70
M 20	2.5	140	25	-	16	12	17.50	134200 0200	89,90	134205 0200	128,50
M 24	3	160	30	-	18	14.5	21.00	134200 0240	130,50	134205 0240	175,-
M 30	3.5	180	35	-	22	18	26.50	134200 0300	250,-	134205 0300	305,-

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Clamping jaw finde

www.spannbackenfinde.de