

# Gewindebohrer x-tap

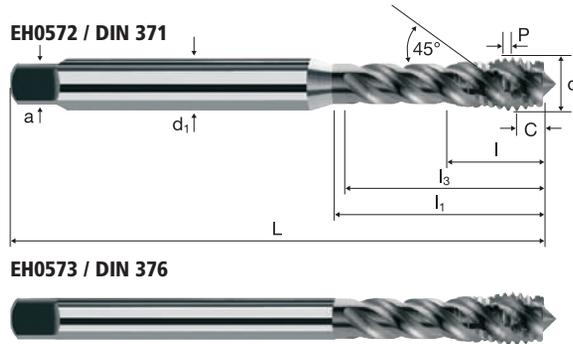


**M** ISO 3 (6G)

60° **HSS PM/F**

DIN 371/376

X-P Form C



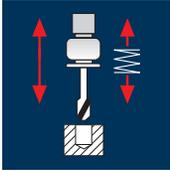
**M**

**Rm** < 850      **Rm** 850-1100

Beispiel: Bestell-Nr.		Artikel-Nr.		ø-Code								TiCN
		<b>EH0572</b>		<b>034</b>								<b>EH0572</b>
Ø Code	d	P	L	l	l <sub>1</sub>	l <sub>3</sub>	d <sub>1</sub>	a	⊘	Δ		
034	M 2	0.40	45	8	—	10.5	2.8	2.1	3	+0.015		●
040	M 2.5	0.45	50	9	—	13.0	2.8	2.1	3	+0.015		●
044	M 3	0.50	56	5	—	16.0	3.5	2.7	3	+0.016		●
058	M 4	0.70	63	7	—	19.0	4.5	3.4	3	+0.019		●
084	M 5	0.80	70	8	—	23.0	6.0	4.9	3	+0.020		●
088	M 6	1.00	80	10	—	28.0	6.0	4.9	3	+0.024		●
160	M 8	1.25	90	13	35.0	33.0	8.0	6.2	3	+0.025		●
174	M10	1.50	100	15	39.0	37.0	10.0	8.0	4	+0.028		●

Beispiel: Bestell-Nr.		Artikel-Nr.		ø-Code								TiCN
		<b>EH0573</b>		<b>240</b>								<b>EH0573</b>
Ø Code	d	P	L	l	l <sub>1</sub>	l <sub>3</sub>	d <sub>1</sub>	a	⊘	Δ		
240	M12	1.75	110	18	50.0	48.0	9.0	7.0	4	+0.032		●
246	M16	2.00	110	20	58.0	56.0	12.0	9.0	4	+0.034		●
314	M20	2.50	140	25	72.0	70.0	16.0	12.0	4	+0.036		●
320	M24	3.00	160	30	74.0	72.0	18.0	14.5	5	+0.042		●

## Anwendung



## Werkstoff

Stahl  
500 - 850 N/mm<sup>2</sup>

Stahl  
500 - 850 N/mm<sup>2</sup>

Stahl  
850 - 1100 N/mm<sup>2</sup>

Stahl  
850 - 1100 N/mm<sup>2</sup>

M	ø [mm]	P [mm]	v <sub>c</sub> 1.0 x d			v <sub>c</sub> 1.5 x d			v <sub>c</sub> 2.0 x d		
			n [min <sup>-1</sup> ]	v <sub>f</sub> [100%]	n [min <sup>-1</sup> ]	v <sub>f</sub> [100%]	n [min <sup>-1</sup> ]	v <sub>f</sub> [100%]			
M 2	2.0	0.40	32	5095	2038	28	4455	1782	22	3500	1400
M 2.5	2.5	0.45	32	4075	1834	28	3565	1604	22	2800	1260
M 3	3.0	0.50	32	3395	1698	28	2970	1485	22	2335	1168
M 4	4.0	0.70	32	2545	1782	28	2230	1561	22	1750	1225
M 5	5.0	0.80	32	2035	1628	28	1785	1428	22	1400	1120
M 6	6.0	1.00	32	1700	1700	28	1485	1485	22	1165	1165
M 8	8.0	1.25	32	1275	1594	28	1115	1394	22	875	1094
M10	10.0	1.50	32	1020	1530	28	890	1335	22	700	1050
M12	12.0	1.75	32	850	1488	28	745	1304	22	585	1024
M16	16.0	2.00	32	635	1270	28	555	1110	22	440	880
M20	20.0	2.50	32	510	1275	28	445	1113	22	350	875
M24	24.0	3.00	32	425	1275	28	370	1110	22	290	870
M 2	2.0	0.40	20	3185	1274	16	2545	1018	10	1590	636
M 2.5	2.5	0.45	20	2545	1145	16	2035	916	10	1275	574
M 3	3.0	0.50	20	2120	1060	16	1700	850	10	1060	530
M 4	4.0	0.70	20	1590	1113	16	1275	893	10	795	557
M 5	5.0	0.80	20	1275	1020	16	1020	816	10	635	508
M 6	6.0	1.00	20	1060	1060	16	850	850	10	530	530
M 8	8.0	1.25	20	795	994	16	635	794	10	400	500
M10	10.0	1.50	20	635	953	16	510	765	10	320	480
M12	12.0	1.75	20	530	928	16	425	744	10	265	464
M16	16.0	2.00	20	400	800	16	320	640	10	200	400
M20	20.0	2.50	20	320	800	16	255	638	10	160	400
M24	24.0	3.00	20	265	795	16	210	630	10	135	405