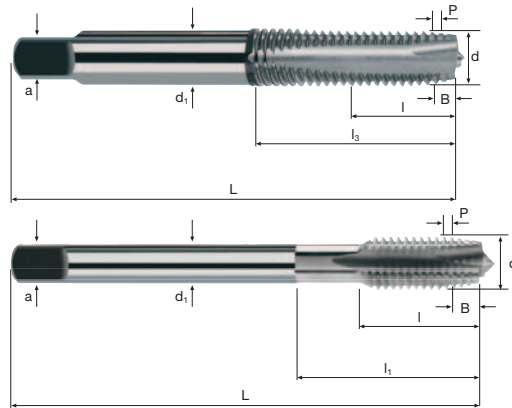
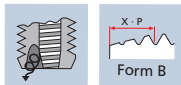
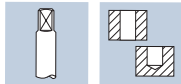


Taps n-tap



M ISO 2
(6H)

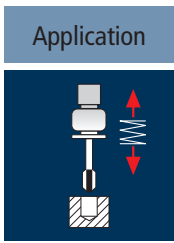
HSS
PM/F



M

Nickel-Alloys

Example: Order-N°.											Article-N°.		ø-Code	
											E0598		.034	
Ø Code	d	P	L	l	l ₁	l ₃	d ₁	a						
.034	M 2	0.40	41	8	–	11	2.8	2.1	2	1.70*	●			
.040	M 2.5	0.45	44	9	–	13	2.8	2.1	2	2.10	●			
.044	M 3	0.50	48	11	–	16	3.5	2.7	3	2.60*	●			
.058	M 4	0.70	53	13	–	19	4.5	3.4	3	3.40	●			
.084	M 5	0.80	58	15	–	22	6.0	4.9	3	4.30	●			
.088	M 6	1.00	66	17	–	28	6.0	4.9	3	5.10	●			
.160	M 8	1.25	72	20	–	34	8.0	6.2	3	6.90	●			
.174	M10	1.50	80	22	–	37	10.0	8.0	3	8.60	●			
.240	M12	1.75	89	24	40	–	9.0	7.0	3	10.40	●			
.244	M14	2.00	95	26	40	–	11.0	9.0	3	12.20	●			
.246	M16	2.00	102	27	40	–	12.0	9.0	3	14.20	●			
.312	M18	2.50	112	30	45	–	14.0	11.0	3	15.70	●			
.314	M20	2.50	112	32	45	–	16.0	12.0	3	17.70	●			
.316	M22	2.50	118	32	50	–	18.0	14.5	4	19.70	●			
.320	M24	3.00	130	34	60	–	18.0	14.5	4	21.20	●			
* The given dimension is out of norm														



Material

Nickel base alloys
not hardened

M	ø [mm]	P [mm]	v_c 1.0 x d	n [min ⁻¹]	v_f [100%]	v_c 1.5 x d	n [min ⁻¹]	v_f [100%]
M 2	2.0	0.40	3	475	190	2	320	128
M 2.5	2.5	0.45	3	380	171	2	255	115
M 3	3.0	0.50	3	320	160	2	210	105
M 4	4.0	0.70	3	240	168	2	160	112
M 5	5.0	0.80	3	190	152	2	125	100
M 6	6.0	1.00	3	160	160	2	105	105
M 8	8.0	1.25	3	120	150	2	80	100
M10	10.0	1.50	3	95	143	2	65	98
M12	12.0	1.75	3	80	140	2	55	96

Nickel base alloys
not hardened

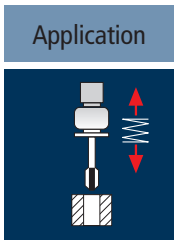
M14	14.0	2.00	3	70	140	2	45	90
M16	16.0	2.00	3	60	120	2	40	80
M18	18.0	2.50	3	55	138	2	35	88
M20	20.0	2.50	3	50	125	2	30	75
M22	22.0	2.50	3	45	113	2	30	75
M24	24.0	3.00	3	40	120	2	25	75

Nickel base alloys
hardened

M 2	2.0	0.40	2	320	128	2	320	128
M 2.5	2.5	0.45	2	255	115	2	255	115
M 3	3.0	0.50	2	210	105	2	210	105
M 4	4.0	0.70	2	160	112	2	160	112
M 5	5.0	0.80	2	125	100	2	125	100
M 6	6.0	1.00	2	105	105	2	105	105
M 8	8.0	1.25	2	80	100	2	80	100
M10	10.0	1.50	2	65	98	2	65	98
M12	12.0	1.75	2	55	96	2	55	96

Nickel base alloys
hardened

M14	14.0	2.00	2	45	90	2	45	90
M16	16.0	2.00	2	40	80	2	40	80
M18	18.0	2.50	2	35	88	2	35	88
M20	20.0	2.50	2	30	75	2	30	75
M22	22.0	2.50	2	30	75	2	30	75
M24	24.0	3.00	2	25	75	2	25	75



Material

Nickel base alloys
not hardened

M	ø [mm]	P [mm]	v_c 1.0 x d	n [min ⁻¹]	v_f [100%]	v_c 1.5 x d	n [min ⁻¹]	v_f [100%]
M 2	2.0	0.40	3	475	190	2	320	128
M 2.5	2.5	0.45	3	380	171	2	255	115
M 3	3.0	0.50	3	320	160	2	210	105
M 4	4.0	0.70	3	240	168	2	160	112
M 5	5.0	0.80	3	190	152	2	125	100
M 6	6.0	1.00	3	160	160	2	105	105
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Nickel base alloys
not hardened

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M18	18.0	2.50	3	55	138	2	35	88
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M22	22.0	2.50	3	45	113	2	30	75
M24	24.0	3.00	3	40	120	2	25	75

Nickel base alloys
hardened

M 2	2.0	0.40	2	320	128	2	320	128
M 2.5	2.5	0.45	2	255	115	2	255	115
M 3	3.0	0.50	2	210	105	2	210	105
M 4	4.0	0.70	2	160	112	2	160	112
M 5	5.0	0.80	2	125	100	2	125	100
M 6	6.0	1.00	2	105	105	2	105	105
M 8	8.0	1.25	2	80	100	2	80	100
M 10	10.0	1.50	2	65	98	2	65	98
M 12	12.0	1.75	2	55	96	2	55	96

Nickel base alloys
hardened

M14	14.0	2.00	2	45	90	2	45	90
M16	16.0	2.00	2	40	80	2	40	80
M18	18.0	2.50	2	35	88	2	35	88
M20	20.0	2.50	2	30	75	2	30	75
M22	22.0	2.50	2	30	75	2	30	75
M24	24.0	3.00	2	25	75	2	25	75