

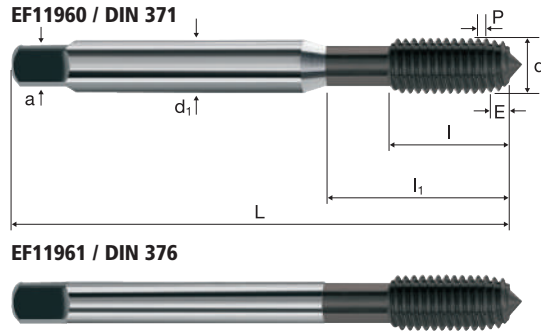
Cold forming taps for inserts



EG M **6H mod**

HSS PM/F

Form E



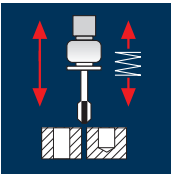
Al Aluminium > 99% **Al** Aluminium Alloy **Cu** Copper **CuZn Brass**

Example: Order-N°.		Article-N°.		ø-Code						F-DLC
		EF11960		044						EF11960
Ø Code	d	P	L	l	l ₁	d ₁	a			
044	EGM 3	0.50	63	13	21	4.5	3.4	3	3.40	●
058	EGM 4	0.70	70	15	25	6.0	4.9	4	4.60	●
084	EGM 5	0.80	80	17	30	6.0	4.9	4	5.70	●
088	EGM 6	1.00	90	20	35	8.0	6.2	4	6.80	●
160	EGM 8	1.25	100	22	39	10.0	8.0	4	9.00	●

Example: Order-N°.		Article-N°.		ø-Code						F-DLC
		EF11961		174						EF11961
Ø Code	d	P	L	l	l ₁	d ₁	a			
174	EGM10	1.50	110	25	50	9.0	7.0	5	11.20	●
240	EGM12	1.75	110	26	58	11.0	9.0	5	13.40	●

CF

Application



Material

Unalloyed aluminium

EG-M	ø [mm]	P [mm]	v_c			v_c			v_c		
			$1.5 \times d$	n [min ⁻¹]	v_f [100%]	$2.0 \times d$	n [min ⁻¹]	v_f [100%]	$3.0 \times d$	n [min ⁻¹]	v_f [100%]
EGM 3	3.650	0.50	25	2180	1090	20	1745	873	15	1310	655
EGM 4	4.910	0.70	25	1620	1134	20	1295	906	15	970	679
EGM 5	6.040	0.80	25	1320	1056	20	1055	844	15	790	632
EGM 6	7.300	1.00	25	1090	1090	20	870	870	15	655	655
EGM 8	9.624	1.25	25	825	1031	20	660	825	15	495	619
EGM 10	11.948	1.50	25	665	998	20	535	803	15	400	600
EGM 12	14.274	1.75	25	555	971	20	445	779	15	335	586

Wrought aluminium alloys Si < 6% not hardened

EGM 3	3.650	0.50	30	2615	1308	25	2180	1090	20	1745	873
EGM 4	4.910	0.70	30	1945	1362	25	1620	1134	20	1295	906
EGM 5	6.040	0.80	30	1580	1264	25	1320	1056	20	1055	844
EGM 6	7.300	1.00	30	1310	1310	25	1090	1090	20	870	870
EGM 8	9.624	1.25	30	990	1238	25	825	1031	20	660	825
EGM 10	11.948	1.50	30	800	1200	25	665	998	20	535	803
EGM 12	14.274	1.75	30	670	1173	25	555	971	20	445	779

Unalloyed copper



EGM 3	3.650	0.50	15	1310	655	10	870	435	10	870	435
EGM 4	4.910	0.70	15	970	679	10	650	455	10	650	455
EGM 5	6.040	0.80	15	790	632	10	525	420	10	525	420
EGM 6	7.300	1.00	15	655	655	10	435	435	10	435	435
EGM 8	9.624	1.25	15	495	619	10	330	413	10	330	413
EGM 10	11.948	1.50	15	400	600	10	265	398	10	265	398
EGM 12	14.274	1.75	15	335	586	10	225	394	10	225	394

Non ferrous metal $A_s > 15\%$



EGM 3	3.650	0.50	15	1310	655	10	870	435	10	870	435
EGM 4	4.910	0.70	15	970	679	10	650	455	10	650	455
EGM 5	6.040	0.80	15	790	632	10	525	420	10	525	420
EGM 6	7.300	1.00	15	655	655	10	435	435	10	435	435
EGM 8	9.624	1.25	15	495	619	10	330	413	10	330	413
EGM 10	11.948	1.50	15	400	600	10	265	398	10	265	398
EGM 12	14.274	1.75	15	335	586	10	225	394	10	225	394