

Cold forming taps

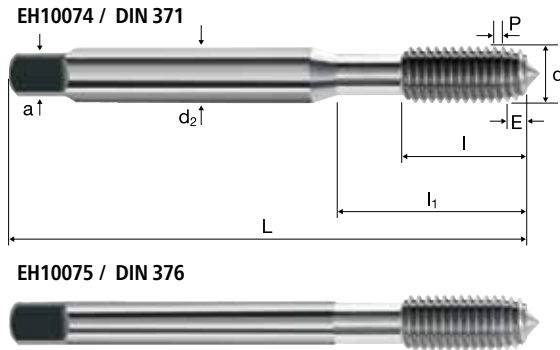


M **ISO 3 (6G)**

60° **HSS PM/F**

DIN 371/376

Form E



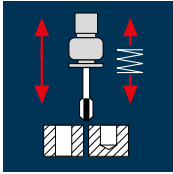
Rm < 850 **Rm 850-1100** **Inox Stainless**

Example: Order-N°.		Article-N°.		a-Code							TiCN
Order-N°.		EH10074		034							EH10074
Ø Code	d	P	L	l	l ₁	d ₂	a	⊘	⌘		
034	M 2	0.40	45	8.00	-	2.8	2.1	3	1.80		●
036	M 2.2	0.45	45	9.00	-	2.8	2.1	3	2.00		●
040	M 2.5	0.45	50	9.00	-	2.8	2.1	3	2.30		●
044	M 3	0.50	56	12.00	18.0	3.5	2.7	3	2.80		●
058	M 4	0.70	63	13.00	21.0	4.5	3.4	3	3.70		●
084	M 5	0.80	70	15.00	25.0	6.0	4.9	4	4.60		●
088	M 6	1.00	80	17.00	30.0	6.0	4.9	4	5.50		●
160	M 8	1.25	90	20.00	35.0	8.0	6.2	5	7.40		●
174	M 10	1.50	100	22.00	39.0	10.0	8.0	5	9.30		●

Example: Order-N°.		Article-N°.		a-Code							TiCN
Order-N°.		EH10075		240							EH10075
Ø Code	d	P	L	l	l ₁	d ₂	a	⊘	⌘		
240	M 12	1.75	110	24.00	40.0	9.0	7.0	7	11.20		●
244	M 14	2.00	110	26.00	40.0	11.0	9.0	7	13.10		●
246	M 16	2.00	110	27.00	40.0	12.0	9.0	7	15.10		●

CF

Application



Material

Steel
< 850 N/mm²
A_S > 10%



Steel
< 850 N/mm²
A_S > 10%



Steel
850 - 1100 N/mm²
A_S > 10%



Steel
850 - 1100 N/mm²
A_S > 10%



Stainless steel
ferritic/martensitic
A_S > 10%



Stainless steel
ferritic/martensitic
A_S > 10%



Stainless steel
[Cr-Ni/1.4301]



Stainless steel
[Cr-Ni/1.4301]



M	d [mm]	P [mm]	v _c 1.5 x d			v _c 2.0 x d			v _c 3.0 x d		
			n [min ⁻¹]	v _f [100%]	n [min ⁻¹]	v _f [100%]	n [min ⁻¹]	v _f [100%]	n [min ⁻¹]	v _f [100%]	
M2	2.000	0.40	20	3185	1274	15	2385	954	10	1590	636
M2.2	2.200	0.45	20	2895	1303	15	2170	977	10	1445	650
M2.5	2.500	0.45	20	2545	1145	15	1910	860	10	1275	574
M3	3.000	0.50	20	2120	1060	15	1590	795	10	1060	530
M4	4.000	0.70	20	1590	1113	15	1195	837	10	795	557
M5	5.000	0.80	20	1275	1020	15	955	764	10	635	508
M6	6.000	1.00	20	1060	1060	15	795	795	10	530	530
M8	8.000	1.25	20	795	994	15	595	744	10	400	500
M10	10.000	1.50	20	635	953	15	475	713	10	320	480
M12	12.000	1.75	20	530	928	15	400	700	10	265	464
M14	14.000	2.00	20	455	910	15	340	680	10	225	450
M16	16.000	2.00	20	400	800	15	300	600	10	200	400
M2	2.000	0.40	15	2385	954	10	1590	636	-	-	-
M2.2	2.200	0.45	15	2170	977	10	1445	650	-	-	-
M2.5	2.500	0.45	15	1910	860	10	1275	574	-	-	-
M3	3.000	0.50	15	1590	795	10	1060	530	-	-	-
M4	4.000	0.70	15	1195	837	10	795	557	-	-	-
M5	5.000	0.80	15	955	764	10	635	508	-	-	-
M6	6.000	1.00	15	795	795	10	530	530	-	-	-
M8	8.000	1.25	15	595	744	10	400	500	-	-	-
M10	10.000	1.50	15	475	713	10	320	480	-	-	-
M12	12.000	1.75	15	400	700	10	265	464	-	-	-
M14	14.000	2.00	15	340	680	10	225	450	-	-	-
M16	16.000	2.00	15	300	600	10	200	400	-	-	-
M2	2.000	0.40	15	2385	954	10	1590	636	-	-	-
M2.2	2.200	0.45	15	2170	977	10	1445	650	-	-	-
M2.5	2.500	0.45	15	1910	860	10	1275	574	-	-	-
M3	3.000	0.50	15	1590	795	10	1060	530	-	-	-
M4	4.000	0.70	15	1195	837	10	795	557	-	-	-
M5	5.000	0.80	15	955	764	10	635	508	-	-	-
M6	6.000	1.00	15	795	795	10	530	530	-	-	-
M8	8.000	1.25	15	595	744	10	400	500	-	-	-
M10	10.000	1.50	15	475	713	10	320	480	-	-	-
M12	12.000	1.75	15	400	700	10	265	464	-	-	-
M14	14.000	2.00	15	340	680	10	225	450	-	-	-
M16	16.000	2.00	15	300	600	10	200	400	-	-	-
M2	2.000	0.40	15	2385	954	10	1590	636	-	-	-
M2.2	2.200	0.45	15	2170	977	10	1445	650	-	-	-
M2.5	2.500	0.45	15	1910	860	10	1275	574	-	-	-
M3	3.000	0.50	15	1590	795	10	1060	530	-	-	-
M4	4.000	0.70	15	1195	837	10	795	557	-	-	-
M5	5.000	0.80	15	955	764	10	635	508	-	-	-
M6	6.000	1.00	15	795	795	10	530	530	-	-	-
M8	8.000	1.25	15	595	744	10	400	500	-	-	-
M10	10.000	1.50	15	475	713	10	320	480	-	-	-
M12	12.000	1.75	15	400	700	10	265	464	-	-	-
M14	14.000	2.00	15	340	680	10	225	450	-	-	-
M16	16.000	2.00	15	300	600	10	200	400	-	-	-