

# Taps durotap H

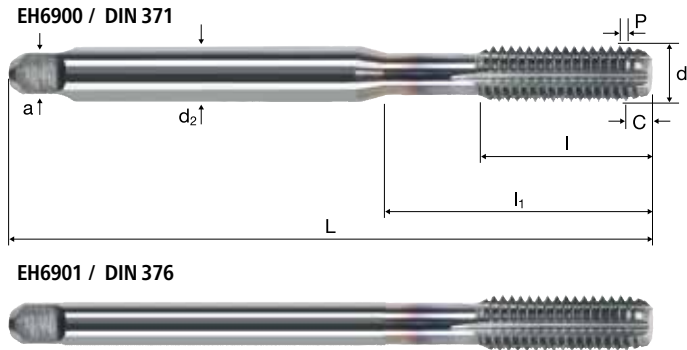


**M** **ISO 2 (6H)**

**60°** **HM MG10**

**DIN 371/376**

**Form C**

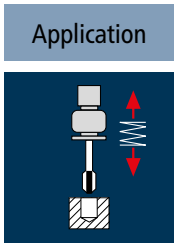


M

**HRC 48-56** **HRC 56-60** **HRC > 60**

Example: Order-N°.		Article-N°.		a-Code							TiCN
Order-N°.		EH6900		058							EH6900
Ø Code	d	P	L	l	l <sub>1</sub>	d <sub>2</sub>	a				
058	M 4	0.70	63	13.00	21.0	4.5	3.4	4	3.40		●
084	M 5	0.80	70	15.00	25.0	6.0	4.9	4	4.30		●
088	M 6	1.00	80	17.00	30.0	6.0	4.9	4	5.10		●
160	M 8	1.25	90	20.00	35.0	8.0	6.2	5	6.90		●
174	M 10	1.50	100	22.00	39.0	10.0	8.0	5	8.60		●

Example: Order-N°.		Article-N°.		a-Code							TiCN
Order-N°.		EH6901		240							EH6901
Ø Code	d	P	L	l	l <sub>1</sub>	d <sub>2</sub>	a				
240	M 12	1.75	110	24.00	40.0	9.0	7.0	5	10.40		●
244	M 14	2.00	110	26.00	40.0	11.0	9.0	5	12.20		●
246	M 16	2.00	110	27.00	40.0	12.0	9.0	5	14.20		●



### Material

Hardened tool steel  
48 - 52 HRC

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 <sup>-1</sup> ]	$v_f$ [100%]	$v_c$	$n$ [min <sup>-1</sup> ]	$v_f$ [100%]	$v_c$	$n$ [min <sup>-1</sup> ]	$v_f$ [100%]	
M4	4.000	0.70	8	635	445	6	475	333	4	320	224
M5	5.000	0.80	8	510	408	6	380	304	4	255	204
M6	6.000	1.00	8	425	425	6	320	320	4	210	210
M8	8.000	1.25	8	320	400	6	240	300	4	160	200
M10	10.000	1.50	8	255	383	6	190	285	4	125	188
M12	12.000	1.75	8	210	368	6	160	280	4	105	184
M14	14.000	2.00	8	180	360	6	135	270	4	90	180
M16	16.000	2.00	8	160	320	6	120	240	4	80	160

Hardened tool steel  
52 - 56 HRC

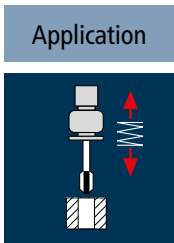
M4	4.000	0.70	6	475	333	4	320	224	3	240	168
M5	5.000	0.80	6	380	304	4	255	204	3	190	152
M6	6.000	1.00	6	320	320	4	210	210	3	160	160
M8	8.000	1.25	6	240	300	4	160	200	3	120	150
M10	10.000	1.50	6	190	285	4	125	188	3	95	143
M12	12.000	1.75	6	160	280	4	105	184	3	80	140
M14	14.000	2.00	6	135	270	4	90	180	3	70	140
M16	16.000	2.00	6	120	240	4	80	160	3	60	120

Hardened tool steel  
56 - 60 HRC

M4	4.000	0.70	4	320	224	2	160	112	-	-	-
M5	5.000	0.80	4	255	204	2	125	100	-	-	-
M6	6.000	1.00	4	210	210	2	105	105	-	-	-
M8	8.000	1.25	4	160	200	2	80	100	-	-	-
M10	10.000	1.50	4	125	188	2	65	98	-	-	-
M12	12.000	1.75	4	105	184	2	55	96	-	-	-
M14	14.000	2.00	4	90	180	2	45	90	-	-	-
M16	16.000	2.00	4	80	160	2	40	80	-	-	-

Hardened tool steel  
> 60 HRC

M4	4.000	0.70	2	160	112	1.5	120	84	-	-	-
M5	5.000	0.80	2	125	100	1.5	95	76	-	-	-
M6	6.000	1.00	2	105	105	1.5	80	80	-	-	-
M8	8.000	1.25	2	80	100	1.5	60	75	-	-	-
M10	10.000	1.50	2	65	98	1.5	50	75	-	-	-
M12	12.000	1.75	2	55	96	1.5	40	70	-	-	-
M14	14.000	2.00	2	45	90	1.5	35	70	-	-	-
M16	16.000	2.00	2	40	80	1.5	30	60	-	-	-



### Material

Hardened tool steel  
48 - 52 HRC

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 <sup>-1</sup> ]	$v_f$ [100%]	$v_c$	$n$ [min <sup>-1</sup> ]	$v_f$ [100%]	$v_c$	$n$ [min <sup>-1</sup> ]	$v_f$ [100%]	
M4	4.000	0.70	8	635	445	6	475	333	4	320	224
M5	5.000	0.80	8	510	408	6	380	304	4	255	204
M6	6.000	1.00	8	425	425	6	320	320	4	210	210
M8	8.000	1.25	8	320	400	6	240	300	4	160	200
M10	10.000	1.50	8	255	383	6	190	285	4	125	188
M12	12.000	1.75	8	210	368	6	160	280	4	105	184
M14	14.000	2.00	8	180	360	6	135	270	4	90	180
M16	16.000	2.00	8	160	320	6	120	240	4	80	160

Hardened tool steel  
52 - 56 HRC

M4	4.000	0.70	6	475	333	4	320	224	3	240	168
M5	5.000	0.80	6	380	304	4	255	204	3	190	152
M6	6.000	1.00	6	320	320	4	210	210	3	160	160
M8	8.000	1.25	6	240	300	4	160	200	3	120	150
M10	10.000	1.50	6	190	285	4	125	188	3	95	143
M12	12.000	1.75	6	160	280	4	105	184	3	80	140
M14	14.000	2.00	6	135	270	4	90	180	3	70	140
M16	16.000	2.00	6	120	240	4	80	160	3	60	120

Hardened tool steel  
56 - 60 HRC

M4	4.000	0.70	4	320	224	2	160	112	-	-	-
M5	5.000	0.80	4	255	204	2	125	100	-	-	-
M6	6.000	1.00	4	210	210	2	105	105	-	-	-
M8	8.000	1.25	4	160	200	2	80	100	-	-	-
M10	10.000	1.50	4	125	188	2	65	98	-	-	-
M12	12.000	1.75	4	105	184	2	55	96	-	-	-
M14	14.000	2.00	4	90	180	2	45	90	-	-	-
M16	16.000	2.00	4	80	160	2	40	80	-	-	-

Hardened tool steel  
> 60 HRC

M4	4.000	0.70	2	160	112	1.5	120	84	-	-	-
M5	5.000	0.80	2	125	100	1.5	95	76	-	-	-
M6	6.000	1.00	2	105	105	1.5	80	80	-	-	-
M8	8.000	1.25	2	80	100	1.5	60	75	-	-	-
M10	10.000	1.50	2	65	98	1.5	50	75	-	-	-
M12	12.000	1.75	2	55	96	1.5	40	70	-	-	-
M14	14.000	2.00	2	45	90	1.5	35	70	-	-	-
M16	16.000	2.00	2	40	80	1.5	30	60	-	-	-