

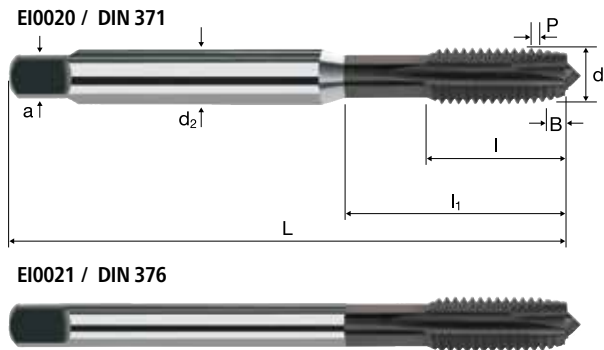
# Taps



**M** ISO 2 (6H)

**HSS PM/F**

**Form B**

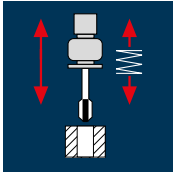


			<b>Al</b> Aluminium > 99%	<b>Al</b> Aluminium Alloy	<b>Al</b> Aluminium Cast		<b>Cu</b> Copper	<b>Plastic</b> Thermo- plast	
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Example: Order-N°.										Article-N°.	α-Code	INTEGRAL
										E10020	034	E10020
∅ Code	d	P	L	l	l <sub>1</sub>	d <sub>2</sub>	a					
034	M 2	0.40	45	8.00	-	2.8	2.1	2	1.60			●
040	M 2.5	0.45	50	9.00	-	2.8	2.1	2	2.05			●
044	M 3	0.50	56	12.00	18.0	3.5	2.7	2	2.50			●
058	M 4	0.70	63	13.00	21.0	4.5	3.4	2	3.30			●
084	M 5	0.80	70	15.00	25.0	6.0	4.9	2	4.20			●
088	M 6	1.00	80	17.00	30.0	6.0	4.9	2	5.00			●
160	M 8	1.25	90	20.00	35.0	8.0	6.2	2	6.80			●
174	M 10	1.50	100	22.00	39.0	10.0	8.0	2	8.50			●

Example: Order-N°.										Article-N°.	α-Code	INTEGRAL
										E10021	240	E10021
∅ 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	3	10.20			●
244	M 14	2.00	110	26.00	40.0	11.0	9.0	3	12.00			●
246	M 16	2.00	110	27.00	40.0	12.0	9.0	3	14.00			●
312	M 18	2.50	125	30.00	45.0	14.0	11.0	3	15.50			●
314	M 20	2.50	140	32.00	50.0	16.0	12.0	3	17.50			●
316	M 22	2.50	140	32.00	50.0	18.0	14.5	3	19.50			●
320	M 24	3.00	160	34.00	60.0	18.0	14.5	3	21.00			●

## Application



## Material

Unalloyed aluminium



Unalloyed aluminium



Wrought aluminium alloys  
Si < 6%  
not hardened



Wrought aluminium alloys  
Si < 6%  
not hardened



Wrought aluminium alloys  
Si < 6%  
hardened



Wrought aluminium alloys  
Si < 6%  
hardened



Unalloyed copper



Unalloyed copper



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%]	n [min <sup>-1</sup> ]	$v_f$ [100%]	n [min <sup>-1</sup> ]	$v_f$ [100%]	n [min <sup>-1</sup> ]	$v_f$ [100%]	
M2	2.000	0.40	23	3660	1464	19	3025	1210	16	2545	1018
M2.5	2.500	0.45	23	2930	1319	19	2420	1089	16	2035	916
M3	3.000	0.50	23	2440	1220	19	2015	1008	16	1700	850
M4	4.000	0.70	23	1830	1281	19	1510	1057	16	1275	893
M5	5.000	0.80	23	1465	1172	19	1210	968	16	1020	816
M6	6.000	1.00	23	1220	1220	19	1010	1010	16	850	850
M8	8.000	1.25	23	915	1144	19	755	944	16	635	794
M10	10.000	1.50	23	730	1095	19	605	908	16	510	765
M12	12.000	1.75	23	610	1068	19	505	884	16	425	744
M14	14.000	2.00	23	525	1050	19	430	860	16	365	730
M16	16.000	2.00	23	460	920	19	380	760	16	320	640
M18	18.000	2.50	23	405	1013	19	335	838	16	285	713
M20	20.000	2.50	23	365	913	19	300	750	16	255	638
M22	22.000	2.50	23	335	838	19	275	688	16	230	575
M24	24.000	3.00	23	305	915	19	250	750	16	210	630
M2	2.000	0.40	35	5570	2228	30	4775	1910	25	3980	1592
M2.5	2.500	0.45	35	4455	2005	30	3820	1719	25	3185	1433
M3	3.000	0.50	35	3715	1858	30	3185	1593	25	2655	1328
M4	4.000	0.70	35	2785	1950	30	2385	1670	25	1990	1393
M5	5.000	0.80	35	2230	1784	30	1910	1528	25	1590	1272
M6	6.000	1.00	35	1855	1855	30	1590	1590	25	1325	1325
M8	8.000	1.25	35	1395	1744	30	1195	1494	25	995	1244
M10	10.000	1.50	35	1115	1673	30	955	1433	25	795	1193
M12	12.000	1.75	35	930	1628	30	795	1391	25	665	1164
M14	14.000	2.00	35	795	1590	30	680	1360	25	570	1140
M16	16.000	2.00	35	695	1390	30	595	1190	25	495	990
M18	18.000	2.50	35	620	1550	30	530	1325	25	440	1100
M20	20.000	2.50	35	555	1388	30	475	1188	25	400	1000
M22	22.000	2.50	35	505	1263	30	435	1088	25	360	900
M24	24.000	3.00	35	465	1395	30	400	1200	25	330	990
M2	2.000	0.40	20	3185	1274	17	2705	1082	14	2230	892
M2.5	2.500	0.45	20	2545	1145	17	2165	974	14	1785	803
M3	3.000	0.50	20	2120	1060	17	1805	903	14	1485	743
M4	4.000	0.70	20	1590	1113	17	1355	949	14	1115	781
M5	5.000	0.80	20	1275	1020	17	1080	864	14	890	712
M6	6.000	1.00	20	1060	1060	17	900	900	14	745	745
M8	8.000	1.25	20	795	994	17	675	844	14	555	694
M10	10.000	1.50	20	635	953	17	540	810	14	445	668
M12	12.000	1.75	20	530	928	17	450	788	14	370	648
M14	14.000	2.00	20	455	910	17	385	770	14	320	640
M16	16.000	2.00	20	400	800	17	340	680	14	280	560
M18	18.000	2.50	20	355	888	17	300	750	14	250	625
M20	20.000	2.50	20	320	800	17	270	675	14	225	563
M22	22.000	2.50	20	290	725	17	245	613	14	205	513
M24	24.000	3.00	20	265	795	17	225	675	14	185	555
M2	2.000	0.40	21	3340	1336	18	2865	1146	15	2385	954
M2.5	2.500	0.45	21	2675	1204	18	2290	1031	15	1910	860
M3	3.000	0.50	21	2230	1115	18	1910	955	15	1590	795
M4	4.000	0.70	21	1670	1169	18	1430	1001	15	1195	837
M5	5.000	0.80	21	1335	1068	18	1145	916	15	955	764
M6	6.000	1.00	21	1115	1115	18	955	955	15	795	795
M8	8.000	1.25	21	835	1044	18	715	894	15	595	744
M10	10.000	1.50	21	670	1005	18	575	863	15	475	713
M12	12.000	1.75	21	555	971	18	475	831	15	400	700
M14	14.000	2.00	21	475	950	18	410	820	15	340	680
M16	16.000	2.00	21	420	840	18	360	720	15	300	600
M18	18.000	2.50	21	370	925	18	320	800	15	265	663
M20	20.000	2.50	21	335	838	18	285	713	15	240	600
M22	22.000	2.50	21	305	763	18	260	650	15	215	538
M24	24.000	3.00	21	280	840	18	240	720	15	200	600