

Taps c-tap

Incool

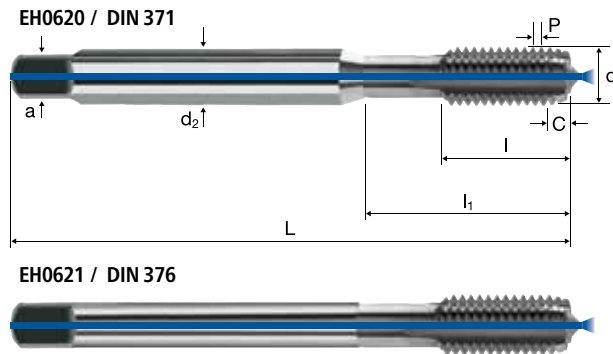


M ISO 2 (6H)

60° **HSS PM/F**

DIN 371/376

X-P Form C



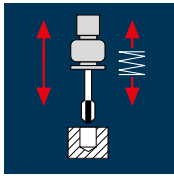
M



Example: Order-N°.										Article-N°. a-Code		TiCN	
										EH0620		EH0620	
Ø Code	d	P	L	l	l ₁	d ₂	a						
058	M 4	0.70	63	13.00	21.0	4.5	3.4	3	3.30				●
084	M 5	0.80	70	15.00	25.0	6.0	4.9	3	4.20				●
088	M 6	1.00	80	17.00	30.0	6.0	4.9	4	5.00				●
160	M 8	1.25	90	20.00	35.0	8.0	6.2	4	6.80				●
174	M 10	1.50	100	22.00	39.0	10.0	8.0	4	8.50				●

Example: Order-N°.										Article-N°. a-Code		TiCN	
										EH0621		EH0621	
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	4	10.20				●
244	M 14	2.00	110	26.00	40.0	11.0	9.0	4	12.00				●
246	M 16	2.00	110	27.00	40.0	12.0	9.0	4	14.00				●
312	M 18	2.50	125	30.00	45.0	14.0	11.0	4	15.50				●
314	M 20	2.50	140	32.00	50.0	16.0	12.0	4	17.50				●
316	M 22	2.50	140	32.00	50.0	18.0	14.5	5	19.50				●
320	M 24	3.00	160	34.00	60.0	18.0	14.5	5	21.00				●

Application



Material

Cast iron
GG

Cast iron
GG

Cast iron
GGG

Cast iron
GGG

M	d [mm]	P [mm]	v_c 1.0 x d			v_c 1.5 x d			v_c 2.0 x d		
			n [min ⁻¹]	v_f [100%]	v_c [min ⁻¹]	n [min ⁻¹]	v_f [100%]	v_c [min ⁻¹]	n [min ⁻¹]	v_f [100%]	
M4	4.000	0.70	28	2230	1561	24	1910	1337	20	1590	1113
M5	5.000	0.80	28	1785	1428	24	1530	1224	20	1275	1020
M6	6.000	1.00	28	1485	1485	24	1275	1275	20	1060	1060
M8	8.000	1.25	28	1115	1394	24	955	1194	20	795	994
M10	10.000	1.50	28	890	1335	24	765	1148	20	635	953
M12	12.000	1.75	28	745	1304	24	635	1111	20	530	928
M14	14.000	2.00	28	635	1270	24	545	1090	20	455	910
M16	16.000	2.00	28	555	1110	24	475	950	20	400	800
M18	18.000	2.50	28	495	1238	24	425	1063	20	355	888
M20	20.000	2.50	28	445	1113	24	380	950	20	320	800
M22	22.000	2.50	28	405	1013	24	345	863	20	290	725
M24	24.000	3.00	28	370	1110	24	320	960	20	265	795
M4	4.000	0.70	20	1590	1113	18	1430	1001	15	1195	837
M5	5.000	0.80	20	1275	1020	18	1145	916	15	955	764
M6	6.000	1.00	20	1060	1060	18	955	955	15	795	795
M8	8.000	1.25	20	795	994	18	715	894	15	595	744
M10	10.000	1.50	20	635	953	18	575	863	15	475	713
M12	12.000	1.75	20	530	928	18	475	831	15	400	700
M14	14.000	2.00	20	455	910	18	410	820	15	340	680
M16	16.000	2.00	20	400	800	18	360	720	15	300	600
M18	18.000	2.50	20	355	888	18	320	800	15	265	663
M20	20.000	2.50	20	320	800	18	285	713	15	240	600
M22	22.000	2.50	20	290	725	18	260	650	15	215	538
M24	24.000	3.00	20	265	795	18	240	720	15	200	600