

Taps x-tap

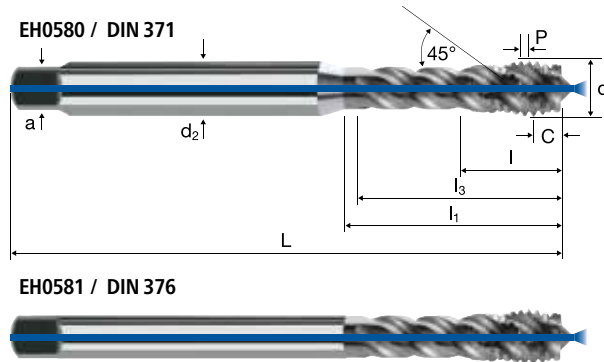
Incool



M **ISO 2 (6H)**

HSS PM/F

Form C

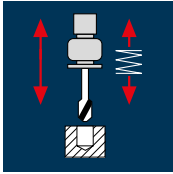


Rm < 850 **Rm 850-1100**

Example: Order-N°.		Article-N°.		a-Code								TiCN
		EH0580		058								EH0580
Ø Code	d	P	L	l	l ₁	l ₃	d ₂	a				
058	M 4	0.70	63	7.00	-	19.0	4.5	3.4	3	3.30		●
084	M 5	0.80	70	8.00	-	23.0	6.0	4.9	3	4.20		●
088	M 6	1.00	80	10.00	-	28.0	6.0	4.9	3	5.00		●
160	M 8	1.25	90	13.00	35.0	33.0	8.0	6.2	3	6.80		●
174	M 10	1.50	100	15.00	39.0	37.0	10.0	8.0	4	8.50		●

Example: Order-N°.		Article-N°.		a-Code								TiCN
		EH0581		240								EH0581
Ø Code	d	P	L	l	l ₁	l ₃	d ₂	a				
240	M 12	1.75	110	18.00	50.0	48.0	9.0	7.0	4	10.20		●
244	M 14	2.00	110	20.00	58.0	56.0	11.0	9.0	4	12.00		●
246	M 16	2.00	110	20.00	58.0	56.0	12.0	9.0	4	14.00		●
312	M 18	2.50	125	25.00	65.0	63.0	14.0	11.0	4	15.50		●
314	M 20	2.50	140	25.00	72.0	70.0	16.0	12.0	4	17.50		●
316	M 22	2.50	140	25.00	72.0	70.0	18.0	14.5	5	19.50		●
320	M 24	3.00	160	30.00	74.0	72.0	18.0	14.5	5	21.00		●

Application



Material

Steel
500 - 850 N/mm²



Steel
500 - 850 N/mm²



Steel
850 - 1100 N/mm²



Steel
850 - 1100 N/mm²



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]	v_f [100%]	v_c [min ⁻¹]	v_f [100%]	v_c [min ⁻¹]	v_f [100%]	
M4	4.000	0.70	32	2545	1782	28	2230	1561	22	1750	1225
M5	5.000	0.80	32	2035	1628	28	1785	1428	22	1400	1120
M6	6.000	1.00	32	1700	1700	28	1485	1485	22	1165	1165
M8	8.000	1.25	32	1275	1594	28	1115	1394	22	875	1094
M10	10.000	1.50	32	1020	1530	28	890	1335	22	700	1050
M12	12.000	1.75	32	850	1488	28	745	1304	22	585	1024
M14	14.000	2.00	32	730	1460	28	635	1270	22	500	1000
M16	16.000	2.00	32	635	1270	28	555	1110	22	440	880
M18	18.000	2.50	32	565	1413	28	495	1238	22	390	975
M20	20.000	2.50	32	510	1275	28	445	1113	22	350	875
M22	22.000	2.50	32	465	1163	28	405	1013	22	320	800
M24	24.000	3.00	32	425	1275	28	370	1110	22	290	870
M4	4.000	0.70	20	1590	1113	16	1275	893	10	795	557
M5	5.000	0.80	20	1275	1020	16	1020	816	10	635	508
M6	6.000	1.00	20	1060	1060	16	850	850	10	530	530
M8	8.000	1.25	20	795	994	16	635	794	10	400	500
M10	10.000	1.50	20	635	953	16	510	765	10	320	480
M12	12.000	1.75	20	530	928	16	425	744	10	265	464
M14	14.000	2.00	20	455	910	16	365	730	10	225	450
M16	16.000	2.00	20	400	800	16	320	640	10	200	400
M18	18.000	2.50	20	355	888	16	285	713	10	175	438
M20	20.000	2.50	20	320	800	16	255	638	10	160	400
M22	22.000	2.50	20	290	725	16	230	575	10	145	363
M24	24.000	3.00	20	265	795	16	210	630	10	135	405