

Taps polytap-R




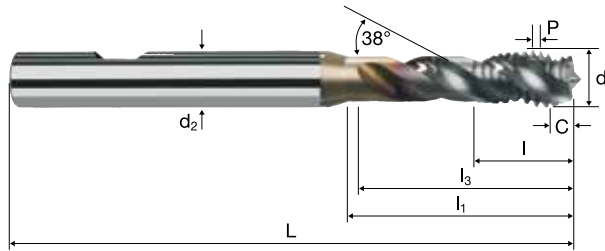
M ISO 2
(6H)

60°
HSS
PM/F

DIN
1835B
ISO
3338





X-P
Form C

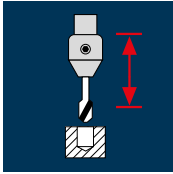



M

Rm < 850 Rm 850-1100 Inox Stainless GG(G) Aluminium

Example: Order-Nº. EH0229 044										TiCN
										EH0229
\emptyset Code	d	P	L	I	I ₁	I ₃	d ₂ h6			
044	M 3	0.50	63	5.00	18.0	16.0	6.0	3	2.50	●
058	M 4	0.70	66	7.00	21.0	19.0	6.0	3	3.30	●
084	M 5	0.80	70	8.00	25.0	23.0	6.0	3	4.20	●
088	M 6	1.00	80	10.00	30.0	28.0	6.0	3	5.00	●
160	M 8	1.25	90	13.00	35.0	33.0	8.0	3	6.80	●
174	M 10	1.50	100	15.00	39.0	37.0	10.0	3	8.50	●
240	M 12	1.75	110	18.00	45.0	43.0	12.0	3	10.20	●
244	M 14	2.00	110	20.00	46.0	44.0	16.0	4	12.00	●
246	M 16	2.00	110	20.00	50.0	48.0	16.0	4	14.00	●
312	M 18	2.50	125	25.00	60.0	58.0	16.0	4	15.50	●
314	M 20	2.50	140	25.00	64.0	62.0	16.0	4	17.50	●

Application



Material

Steel
< 500 N/mm²



M	d [mm]	P [mm]	v_c 1.0 x d	n [min ⁻¹]	v_c 1.5 x d	n [min ⁻¹]	v_c 2.0 x d	n [min ⁻¹]
M3	3.000	0.50	25	2655	22	2335	15	1590
M4	4.000	0.70	25	1990	22	1750	15	1195
M5	5.000	0.80	25	1590	22	1400	15	955
M6	6.000	1.00	25	1325	22	1165	15	795
M8	8.000	1.25	25	995	22	875	15	595
M10	10.000	1.50	25	795	22	700	15	475
M12	12.000	1.75	25	665	22	585	15	400
M16	16.000	2.00	25	495	22	440	15	300
M20	20.000	2.50	25	400	22	350	15	240

Steel
500 - 850 N/mm²



M3	3.000	0.50	22	2335	20	2120	12	1275
M4	4.000	0.70	22	1750	20	1590	12	955
M5	5.000	0.80	22	1400	20	1275	12	765
M6	6.000	1.00	22	1165	20	1060	12	635
M8	8.000	1.25	22	875	20	795	12	475
M10	10.000	1.50	22	700	20	635	12	380
M12	12.000	1.75	22	585	20	530	12	320
M16	16.000	2.00	22	440	20	400	12	240
M20	20.000	2.50	22	350	20	320	12	190

Steel
850 - 1100 N/mm²



M3	3.000	0.50	18	1910	12	1275	8	850
M4	4.000	0.70	18	1430	12	955	8	635
M5	5.000	0.80	18	1145	12	765	8	510
M6	6.000	1.00	18	955	12	635	8	425
M8	8.000	1.25	18	715	12	475	8	320
M10	10.000	1.50	18	575	12	380	8	255
M12	12.000	1.75	18	475	12	320	8	210
M16	16.000	2.00	18	360	12	240	8	160
M20	20.000	2.50	18	285	12	190	8	125

Cast iron
GG



M3	3.000	0.50	18	1910	15	1590	12	1275
M4	4.000	0.70	18	1430	15	1195	12	955
M5	5.000	0.80	18	1145	15	955	12	765
M6	6.000	1.00	18	955	15	795	12	635
M8	8.000	1.25	18	715	15	595	12	475
M10	10.000	1.50	18	575	15	475	12	380
M12	12.000	1.75	18	475	15	400	12	320
M16	16.000	2.00	18	360	15	300	12	240
M20	20.000	2.50	18	285	15	240	12	190

Stainless steel
[Cr-Ni/1.4301]



M3	3.000	0.50	4	425	3	320	2	210
M4	4.000	0.70	4	320	3	240	2	160
M5	5.000	0.80	4	255	3	190	2	125
M6	6.000	1.00	4	210	3	160	2	105
M8	8.000	1.25	4	160	3	120	2	80
M10	10.000	1.50	4	125	3	95	2	65
M12	12.000	1.75	4	105	3	80	2	55
M16	16.000	2.00	4	80	3	60	2	40
M20	20.000	2.50	4	65	3	50	2	30

Wrought aluminium alloys
Si < 6%
hardened



M3	3.000	0.50	25	2655	22	2335	15	1590
M4	4.000	0.70	25	1990	22	1750	15	1195
M5	5.000	0.80	25	1590	22	1400	15	955
M6	6.000	1.00	25	1325	22	1165	15	795
M8	8.000	1.25	25	995	22	875	15	595
M10	10.000	1.50	25	795	22	700	15	475
M12	12.000	1.75	25	665	22	585	15	400
M16	16.000	2.00	25	495	22	440	15	300
M20	20.000	2.50	25	400	22	350	15	240