

Cold forming taps

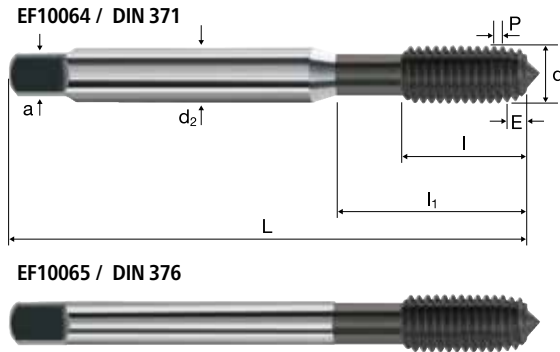


M **ISO 3 (6G)**

60° **HSS PM/F**

DIN 371/376

Form E



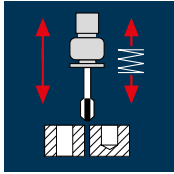
Al Aluminium > 99% **Al** Aluminium Alloy **Cu** Copper **CuZn Brass**

Example: Order-N°.		Article-N°.		a-Code								F-DLC
		EF10064		034								EF10064
Ø Code	d	P	L	l	l ₁	d ₂	a					
034	M 2	0.40	45	8.00	-	2.8	2.1	3	1.80		●	
036	M 2.2	0.45	45	9.00	-	2.8	2.1	3	2.00		●	
040	M 2.5	0.45	50	9.00	-	2.8	2.1	3	2.30		●	
044	M 3	0.50	56	12.00	18.0	3.5	2.7	3	2.80		●	
058	M 4	0.70	63	13.00	21.0	4.5	3.4	3	3.70		●	
084	M 5	0.80	70	15.00	25.0	6.0	4.9	4	4.60		●	
088	M 6	1.00	80	17.00	30.0	6.0	4.9	4	5.50		●	
160	M 8	1.25	90	20.00	35.0	8.0	6.2	4	7.40		●	
174	M 10	1.50	100	22.00	39.0	10.0	8.0	4	9.30		●	

Example: Order-N°.		Article-N°.		a-Code								F-DLC
		EF10065		240								EF10065
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	5	11.20		●	
244	M 14	2.00	110	26.00	40.0	11.0	9.0	5	13.10		●	
246	M 16	2.00	110	27.00	40.0	12.0	9.0	5	15.10		●	

CF

Application



Material

Unalloyed aluminium



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 ⁻¹]	v_f [100%]	n [min ⁻¹]	v_f [100%]	n [min ⁻¹]	v_f [100%]	n [min ⁻¹]	v_f [100%]	
M2	2.000	0.40	25	3980	1592	20	3185	1274	15	2385	954
M2.2	2.200	0.45	25	3615	1627	20	2895	1303	15	2170	977
M2.5	2.500	0.45	25	3185	1433	20	2545	1145	15	1910	860
M3	3.000	0.50	25	2655	1328	20	2120	1060	15	1590	795
M4	4.000	0.70	25	1990	1393	20	1590	1113	15	1195	837
M5	5.000	0.80	25	1590	1272	20	1275	1020	15	955	764
M6	6.000	1.00	25	1325	1325	20	1060	1060	15	795	795
M8	8.000	1.25	25	995	1244	20	795	994	15	595	744
M10	10.000	1.50	25	795	1193	20	635	953	15	475	713

Unalloyed aluminium



M12	12.000	1.75	25	665	1164	20	530	928	15	400	700
M14	14.000	2.00	25	570	1140	20	455	910	15	340	680
M16	16.000	2.00	25	495	990	20	400	800	15	300	600

Wrought aluminium alloys
Si < 6%
not hardened



M2	2.000	0.40	30	4775	1910	25	3980	1592	20	3185	1274
M2.2	2.200	0.45	30	4340	1953	25	3615	1627	20	2895	1303
M2.5	2.500	0.45	30	3820	1719	25	3185	1433	20	2545	1145
M3	3.000	0.50	30	3185	1593	25	2655	1328	20	2120	1060
M4	4.000	0.70	30	2385	1670	25	1990	1393	20	1590	1113
M5	5.000	0.80	30	1910	1528	25	1590	1272	20	1275	1020
M6	6.000	1.00	30	1590	1590	25	1325	1325	20	1060	1060
M8	8.000	1.25	30	1195	1494	25	995	1244	20	795	994
M10	10.000	1.50	30	955	1433	25	795	1193	20	635	953

Wrought aluminium alloys
Si < 6%
not hardened



M12	12.000	1.75	30	795	1391	25	665	1164	20	530	928
M14	14.000	2.00	30	680	1360	25	570	1140	20	455	910
M16	16.000	2.00	30	595	1190	25	495	990	20	400	800

Unalloyed copper



M2	2.000	0.40	15	2385	954	10	1590	636	10	1590	636
M2.2	2.200	0.45	15	2170	977	10	1445	650	10	1445	650
M2.5	2.500	0.45	15	1910	860	10	1275	574	10	1275	574
M3	3.000	0.50	15	1590	795	10	1060	530	10	1060	530
M4	4.000	0.70	15	1195	837	10	795	557	10	795	557
M5	5.000	0.80	15	955	764	10	635	508	10	635	508
M6	6.000	1.00	15	795	795	10	530	530	10	530	530
M8	8.000	1.25	15	595	744	10	400	500	10	400	500
M10	10.000	1.50	15	475	713	10	320	480	10	320	480

Unalloyed copper



M12	12.000	1.75	15	400	700	10	265	464	10	265	464
M14	14.000	2.00	15	340	680	10	225	450	10	225	450
M16	16.000	2.00	15	300	600	10	200	400	10	200	400

Non ferrous metal
A₅ > 15%



M2	2.000	0.40	15	2385	954	10	1590	636	10	1590	636
M2.2	2.200	0.45	15	2170	977	10	1445	650	10	1445	650
M2.5	2.500	0.45	15	1910	860	10	1275	574	10	1275	574
M3	3.000	0.50	15	1590	795	10	1060	530	10	1060	530
M4	4.000	0.70	15	1195	837	10	795	557	10	795	557
M5	5.000	0.80	15	955	764	10	635	508	10	635	508
M6	6.000	1.00	15	795	795	10	530	530	10	530	530
M8	8.000	1.25	15	595	744	10	400	500	10	400	500
M10	10.000	1.50	15	475	713	10	320	480	10	320	480

Non ferrous metal
A₅ > 15%



M12	12.000	1.75	15	400	700	10	265	464	10	265	464
M14	14.000	2.00	15	340	680	10	225	450	10	225	450
M16	16.000	2.00	15	300	600	10	200	400	10	200	400