




Taps x-tap

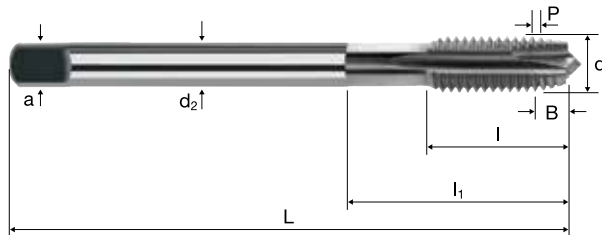


MF **ISO 2**
(6H)

 **HSS**
PM/F



 **DIN**
374 

 **X-P**
Form B

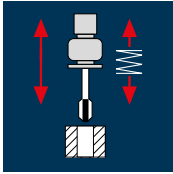


Rm < 850 **Rm** 850-1100 **Rm** 1100-1300

MF

Example: Order-N°.										TiCN
Article-N°. ø-Code										EH1258
EH1258 070										
Ø Code	d	P	L	I	I ₁	d ₂	a			
070	M 12	0.75	100	18.00	39.0	9.0	7.0	3	11.30	●
072	M 14	0.75	100	18.00	39.0	11.0	9.0	3	13.30	●
074	M 16	0.75	100	18.00	39.0	12.0	9.0	3	15.30	●
094	M 12	1.00	100	18.00	39.0	9.0	7.0	3	11.00	●
095	M 13	1.00	100	18.00	39.0	11.0	7.0	3	12.00	●
096	M 14	1.00	100	18.00	39.0	11.0	9.0	3	13.00	●
097	M 15	1.00	100	18.00	39.0	12.0	9.0	3	14.00	●
098	M 16	1.00	100	18.00	39.0	12.0	9.0	3	15.00	●
099	M 17	1.00	100	18.00	39.0	12.0	9.0	4	16.00	●
100	M 18	1.00	110	20.00	45.0	14.0	11.0	4	17.00	●
102	M 20	1.00	125	20.00	50.0	16.0	12.0	4	19.00	●
164	M 12	1.25	100	22.00	39.0	9.0	7.0	3	10.80	●
166	M 14	1.25	100	22.00	39.0	11.0	9.0	3	12.80	●
168	M 16	1.25	100	22.00	39.0	12.0	9.0	3	14.80	●
176	M 12	1.50	100	22.00	39.0	9.0	7.0	3	10.50	●
178	M 14	1.50	100	22.00	39.0	11.0	9.0	3	12.50	●
180	M 16	1.50	100	22.00	39.0	12.0	9.0	3	14.50	●
182	M 18	1.50	110	22.00	45.0	14.0	11.0	4	16.50	●
184	M 20	1.50	125	25.00	50.0	16.0	12.0	4	18.50	●
186	M 22	1.50	125	26.00	50.0	18.0	14.5	4	20.50	●
188	M 24	1.50	140	27.00	52.0	18.0	14.5	4	22.50	●

Application



Material

Steel
500 - 850 N/mm²



MF	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%]	
M12	12.000	0.75	25	665	499	20	530	398	15	400	300
M14	14.000	0.75	25	570	428	20	455	341	15	340	255
M16	16.000	0.75	25	495	371	20	400	300	15	300	225
M12	12.000	1.00	25	665	665	20	530	530	15	400	400
M13	13.000	1.00	25	610	610	20	490	490	15	365	365
M14	14.000	1.00	25	570	570	20	455	455	15	340	340
M16	16.000	1.00	25	495	495	20	400	400	15	300	300
M18	18.000	1.00	25	440	440	20	355	355	15	265	265
M20	20.000	1.00	25	400	400	20	320	320	15	240	240

Steel
500 - 850 N/mm²



M12	12.000	1.25	25	665	831	20	530	663	15	400	500
M14	14.000	1.25	25	570	713	20	455	569	15	340	425
M16	16.000	1.25	25	495	619	20	400	500	15	300	375
M12	12.000	1.50	25	665	998	20	530	795	15	400	600
M14	14.000	1.50	25	570	855	20	455	683	15	340	510
M16	16.000	1.50	25	495	743	20	400	600	15	300	450
M18	18.000	1.50	25	440	660	20	355	533	15	265	398
M20	20.000	1.50	25	400	600	20	320	480	15	240	360
M24	24.000	1.50	25	330	495	20	265	398	15	200	300

Steel
850 - 1100 N/mm²



M12	12.000	0.75	20	530	398	15	400	300	12	320	240
M14	14.000	0.75	20	455	341	15	340	255	12	275	206
M16	16.000	0.75	20	400	300	15	300	225	12	240	180
M12	12.000	1.00	20	530	530	15	400	400	12	320	320
M13	13.000	1.00	20	490	490	15	365	365	12	295	295
M14	14.000	1.00	20	455	455	15	340	340	12	275	275
M16	16.000	1.00	20	400	400	15	300	300	12	240	240
M18	18.000	1.00	20	355	355	15	265	265	12	210	210
M20	20.000	1.00	20	320	320	15	240	240	12	190	190

Steel
850 - 1100 N/mm²



M12	12.000	1.25	20	530	663	15	400	500	12	320	400
M14	14.000	1.25	20	455	569	15	340	425	12	275	344
M16	16.000	1.25	20	400	500	15	300	375	12	240	300
M12	12.000	1.50	20	530	795	15	400	600	12	320	480
M14	14.000	1.50	20	455	683	15	340	510	12	275	413
M16	16.000	1.50	20	400	600	15	300	450	12	240	360
M18	18.000	1.50	20	355	533	15	265	398	12	210	315
M20	20.000	1.50	20	320	480	15	240	360	12	190	285
M24	24.000	1.50	20	265	398	15	200	300	12	160	240

Steel
1100 - 1300 N/mm²



M12	12.000	0.75	7	185	139	4	105	79	-	-	-
M14	14.000	0.75	7	160	120	4	90	68	-	-	-
M16	16.000	0.75	7	140	105	4	80	60	-	-	-
M12	12.000	1.00	7	185	185	4	105	105	-	-	-
M13	13.000	1.00	7	170	170	4	100	100	-	-	-
M14	14.000	1.00	7	160	160	4	90	90	-	-	-
M16	16.000	1.00	7	140	140	4	80	80	-	-	-
M18	18.000	1.00	7	125	125	4	70	70	-	-	-
M20	20.000	1.00	7	110	110	4	65	65	-	-	-

Steel
1100 - 1300 N/mm²



M12	12.000	1.25	7	185	231	4	105	131	-	-	-
M14	14.000	1.25	7	160	200	4	90	113	-	-	-
M16	16.000	1.25	7	140	175	4	80	100	-	-	-
M12	12.000	1.50	7	185	278	4	105	158	-	-	-
M14	14.000	1.50	7	160	240	4	90	135	-	-	-
M16	16.000	1.50	7	140	210	4	80	120	-	-	-
M18	18.000	1.50	7	125	188	4	70	105	-	-	-
M20	20.000	1.50	7	110	165	4	65	98	-	-	-
M24	24.000	1.50	7	95	143	4	55	83	-	-	-