

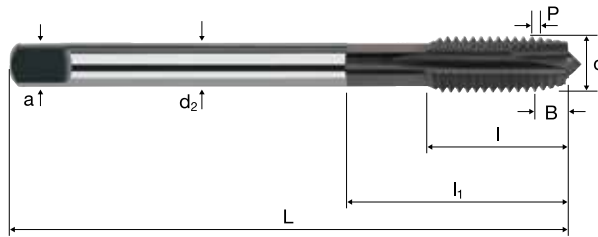
Taps titap



M **ISO 2 (6H)**

HSS PM/F

Form B

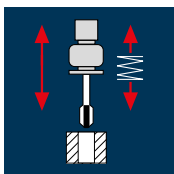


M

Ti
Titanium

| Example: Order-N° | | | | | | | | | | TRIBO |
|--------------------------------------------|------|------|-----|-------|----------------|----------------|------|---|-------|---------------|
| Article-N° ET0706 ø-Code 240 | | | | | | | | | | ET0706 |
| Ø Code | d | P | L | I | I ₁ | d ₂ | a | | | |
| 240 | M 12 | 1.75 | 110 | 24.00 | 40.0 | 9.0 | 7.0 | 3 | 10.40 | ● |
| 244 | M 14 | 2.00 | 110 | 26.00 | 40.0 | 11.0 | 9.0 | 3 | 12.20 | ● |
| 246 | M 16 | 2.00 | 110 | 27.00 | 40.0 | 12.0 | 9.0 | 3 | 14.20 | ● |
| 312 | M 18 | 2.50 | 125 | 30.00 | 45.0 | 14.0 | 11.0 | 4 | 15.70 | ● |
| 314 | M 20 | 2.50 | 140 | 32.00 | 50.0 | 16.0 | 12.0 | 4 | 17.70 | ● |
| 316 | M 22 | 2.50 | 140 | 32.00 | 50.0 | 18.0 | 14.5 | 4 | 19.70 | ● |
| 320 | M 24 | 3.00 | 160 | 34.00 | 60.0 | 18.0 | 14.5 | 4 | 21.20 | ● |
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Application



Material

Titanium alloys
> 300 HB
[Ti6Al4V]



| 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%] | | | |
| M12 | 12.000 | 1.75 | 5 | 135 | 236 | 4 | 105 | 184 | 3 | 80 | 140 |
| M14 | 14.000 | 2.00 | 5 | 115 | 230 | 4 | 90 | 180 | 3 | 70 | 140 |
| M16 | 16.000 | 2.00 | 5 | 100 | 200 | 4 | 80 | 160 | 3 | 60 | 120 |
| M18 | 18.000 | 2.50 | 5 | 90 | 225 | 4 | 70 | 175 | 3 | 55 | 138 |
| M20 | 20.000 | 2.50 | 5 | 80 | 200 | 4 | 65 | 163 | 3 | 50 | 125 |
| M22 | 22.000 | 2.50 | 5 | 70 | 175 | 4 | 60 | 150 | 3 | 45 | 113 |
| M24 | 24.000 | 3.00 | 5 | 65 | 195 | 4 | 55 | 165 | 3 | 40 | 120 |