

# Taps

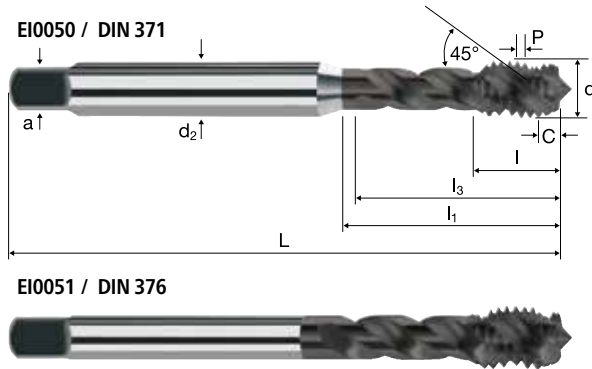


**M** **ISO 2 (6H)**

**60°** **HSS PM/F**

**DIN 371/376**

**X-P**  
**Form C**

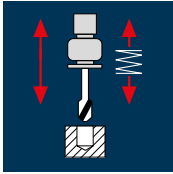


**Al** Aluminium > 99%    **Al** Aluminium Alloy    **Al** Aluminium Cast    **Cu** Copper    **Plastic** Thermo-plast

Example: Order-N°.										Article-N°. a-Code		INTEGRAL			
										EI0050		034		EI0050	
Ø Code	d	P	L	l	l <sub>1</sub>	l <sub>3</sub>	d <sub>2</sub>	a							
034	M 2	0.40	45	8.00	-	10.5	2.8	2.1	3	1.60			●		
040	M 2.5	0.45	50	9.00	-	13.0	2.8	2.1	3	2.05			●		
044	M 3	0.50	56	5.00	18.0	16.0	3.5	2.7	3	2.50			●		
058	M 4	0.70	63	7.00	21.0	19.0	4.5	3.4	3	3.30			●		
084	M 5	0.80	70	8.00	25.0	23.0	6.0	4.9	3	4.20			●		
088	M 6	1.00	80	10.00	30.0	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	3	8.50			●		

Example: Order-N°.										Article-N°. a-Code		INTEGRAL			
										EI0051		240		EI0051	
Ø Code	d	P	L	l	l <sub>1</sub>	l <sub>3</sub>	d <sub>2</sub>	a							
240	M 12	1.75	110	18.00	50.0	48.0	9.0	7.0	3	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	4	19.50			●		
320	M 24	3.00	160	30.00	74.0	72.0	18.0	14.5	4	21.00			●		

## Application



## Material

Unalloyed aluminium



Unalloyed aluminium



Wrought aluminium alloys  
Si < 6%  
not hardened



Wrought aluminium alloys  
Si < 6%  
not hardened



Wrought aluminium alloys  
Si < 6%  
hardened



Wrought aluminium alloys  
Si < 6%  
hardened



Unalloyed copper



Unalloyed copper



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 <sup>-1</sup> ]	$v_f$ [100%]	n [min <sup>-1</sup> ]	$v_f$ [100%]	n [min <sup>-1</sup> ]	$v_f$ [100%]	n [min <sup>-1</sup> ]	$v_f$ [100%]	
M2	2.000	0.40	25	3980	1592	21	3340	1336	17	2705	1082
M2.5	2.500	0.45	25	3185	1433	21	2675	1204	17	2165	974
M3	3.000	0.50	25	2655	1328	21	2230	1115	17	1805	903
M4	4.000	0.70	25	1990	1393	21	1670	1169	17	1355	949
M5	5.000	0.80	25	1590	1272	21	1335	1068	17	1080	864
M6	6.000	1.00	25	1325	1325	21	1115	1115	17	900	900
M8	8.000	1.25	25	995	1244	21	835	1044	17	675	844
M10	10.000	1.50	25	795	1193	21	670	1005	17	540	810
M12	12.000	1.75	25	665	1164	21	555	971	17	450	788
M14	14.000	2.00	25	570	1140	21	475	950	17	385	770
M16	16.000	2.00	25	495	990	21	420	840	17	340	680
M18	18.000	2.50	25	440	1100	21	370	925	17	300	750
M20	20.000	2.50	25	400	1000	21	335	838	17	270	675
M22	22.000	2.50	25	360	900	21	305	763	17	245	613
M24	24.000	3.00	25	330	990	21	280	840	17	225	675
M2	2.000	0.40	27	4295	1718	24	3820	1528	18	2865	1146
M2.5	2.500	0.45	27	3440	1548	24	3055	1375	18	2290	1031
M3	3.000	0.50	27	2865	1433	24	2545	1273	18	1910	955
M4	4.000	0.70	27	2150	1505	24	1910	1337	18	1430	1001
M5	5.000	0.80	27	1720	1376	24	1530	1224	18	1145	916
M6	6.000	1.00	27	1430	1430	24	1275	1275	18	955	955
M8	8.000	1.25	27	1075	1344	24	955	1194	18	715	894
M10	10.000	1.50	27	860	1290	24	765	1148	18	575	863
M12	12.000	1.75	27	715	1251	24	635	1111	18	475	831
M14	14.000	2.00	27	615	1230	24	545	1090	18	410	820
M16	16.000	2.00	27	535	1070	24	475	950	18	360	720
M18	18.000	2.50	27	475	1188	24	425	1063	18	320	800
M20	20.000	2.50	27	430	1075	24	380	950	18	285	713
M22	22.000	2.50	27	390	975	24	345	863	18	260	650
M24	24.000	3.00	27	360	1080	24	320	960	18	240	720
M2	2.000	0.40	21	3340	1336	18	2865	1146	15	2385	954
M2.5	2.500	0.45	21	2675	1204	18	2290	1031	15	1910	860
M3	3.000	0.50	21	2230	1115	18	1910	955	15	1590	795
M4	4.000	0.70	21	1670	1169	18	1430	1001	15	1195	837
M5	5.000	0.80	21	1335	1068	18	1145	916	15	955	764
M6	6.000	1.00	21	1115	1115	18	955	955	15	795	795
M8	8.000	1.25	21	835	1044	18	715	894	15	595	744
M10	10.000	1.50	21	670	1005	18	575	863	15	475	713
M12	12.000	1.75	21	555	971	18	475	831	15	400	700
M14	14.000	2.00	21	475	950	18	410	820	15	340	680
M16	16.000	2.00	21	420	840	18	360	720	15	300	600
M18	18.000	2.50	21	370	925	18	320	800	15	265	663
M20	20.000	2.50	21	335	838	18	285	713	15	240	600
M22	22.000	2.50	21	305	763	18	260	650	15	215	538
M24	24.000	3.00	21	280	840	18	240	720	15	200	600
M2	2.000	0.40	20	3185	1274	18	2865	1146	16	2545	1018
M2.5	2.500	0.45	20	2545	1145	18	2290	1031	16	2035	916
M3	3.000	0.50	20	2120	1060	18	1910	955	16	1700	850
M4	4.000	0.70	20	1590	1113	18	1430	1001	16	1275	893
M5	5.000	0.80	20	1275	1020	18	1145	916	16	1020	816
M6	6.000	1.00	20	1060	1060	18	955	955	16	850	850
M8	8.000	1.25	20	795	994	18	715	894	16	635	794
M10	10.000	1.50	20	635	953	18	575	863	16	510	765
M12	12.000	1.75	20	530	928	18	475	831	16	425	744
M14	14.000	2.00	20	455	910	18	410	820	16	365	730
M16	16.000	2.00	20	400	800	18	360	720	16	320	640
M18	18.000	2.50	20	355	888	18	320	800	16	285	713
M20	20.000	2.50	20	320	800	18	285	713	16	255	638
M22	22.000	2.50	20	290	725	18	260	650	16	230	575
M24	24.000	3.00	20	265	795	18	240	720	16	210	630