

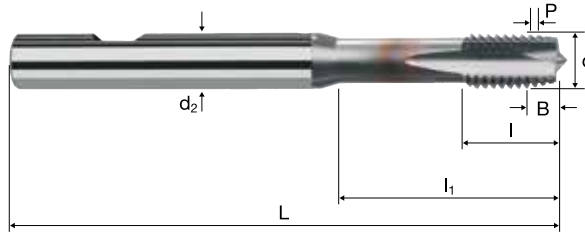
Taps polytap-R



M **ISO 2**
(6H)

HSS
PM/F

 X - P
Form B

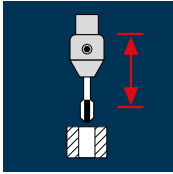


M

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

		Article-N°.		ø-Code						TiCN
Example: Order-N°.		EH0109		044						EH0109
Ø Code	d	P	L	I	I ₁	d ₂ h ₆				
044	M 3	0.50	63	5.00	18.0	6.0	3	2.50		●
058	M 4	0.70	66	7.00	21.0	6.0	3	3.30		●
084	M 5	0.80	70	8.00	25.0	6.0	3	4.20		●
088	M 6	1.00	80	10.00	30.0	6.0	3	5.00		●
160	M 8	1.25	90	13.00	35.0	8.0	3	6.80		●
174	M 10	1.50	100	15.00	39.0	10.0	3	8.50		●
240	M 12	1.75	110	18.00	45.0	12.0	3	10.20		●
244	M 14	2.00	110	20.00	46.0	16.0	3	12.00		●
246	M 16	2.00	110	20.00	50.0	16.0	3	14.00		●
312	M 18	2.50	125	25.00	60.0	16.0	4	15.50		●
314	M 20	2.50	140	25.00	64.0	16.0	4	17.50		●

Application



Material

Steel
< 500 N/mm²



M	d [mm]	P [mm]	v_c 1.5 x d	n [min ⁻¹]	v_c 2.0 x d	n [min ⁻¹]	v_c 3.0 x d	n [min ⁻¹]
M3	3.000	0.50	25	2655	20	2120	15	1590
M4	4.000	0.70	25	1990	20	1590	15	1195
M5	5.000	0.80	25	1590	20	1275	15	955
M6	6.000	1.00	25	1325	20	1060	15	795
M8	8.000	1.25	25	995	20	795	15	595
M10	10.000	1.50	25	795	20	635	15	475
M12	12.000	1.75	25	665	20	530	15	400
M16	16.000	2.00	25	495	20	400	15	300
M20	20.000	2.50	25	400	20	320	15	240

Steel
500 - 850 N/mm²



M3	3.000	0.50	22	2335	18	1910	12	1275
M4	4.000	0.70	22	1750	18	1430	12	955
M5	5.000	0.80	22	1400	18	1145	12	765
M6	6.000	1.00	22	1165	18	955	12	635
M8	8.000	1.25	22	875	18	715	12	475
M10	10.000	1.50	22	700	18	575	12	380
M12	12.000	1.75	22	585	18	475	12	320
M16	16.000	2.00	22	440	18	360	12	240
M20	20.000	2.50	22	350	18	285	12	190

Steel
850 - 1100 N/mm²



M3	3.000	0.50	18	1910	12	1275	10	1060
M4	4.000	0.70	18	1430	12	955	10	795
M5	5.000	0.80	18	1145	12	765	10	635
M6	6.000	1.00	18	955	12	635	10	530
M8	8.000	1.25	18	715	12	475	10	400
M10	10.000	1.50	18	575	12	380	10	320
M12	12.000	1.75	18	475	12	320	10	265
M16	16.000	2.00	18	360	12	240	10	200
M20	20.000	2.50	18	285	12	190	10	160

Cast iron
GG



M3	3.000	0.50	22	2335	20	2120	18	1910
M4	4.000	0.70	22	1750	20	1590	18	1430
M5	5.000	0.80	22	1400	20	1275	18	1145
M6	6.000	1.00	22	1165	20	1060	18	955
M8	8.000	1.25	22	875	20	795	18	715
M10	10.000	1.50	22	700	20	635	18	575
M12	12.000	1.75	22	585	20	530	18	475
M16	16.000	2.00	22	440	20	400	18	360
M20	20.000	2.50	22	350	20	320	18	285

Stainless steel
[Cr-Ni/1.4301]



M3	3.000	0.50	6	635	4	425	3	320
M4	4.000	0.70	6	475	4	320	3	240
M5	5.000	0.80	6	380	4	255	3	190
M6	6.000	1.00	6	320	4	210	3	160
M8	8.000	1.25	6	240	4	160	3	120
M10	10.000	1.50	6	190	4	125	3	95
M12	12.000	1.75	6	160	4	105	3	80
M16	16.000	2.00	6	120	4	80	3	60
M20	20.000	2.50	6	95	4	65	3	50

Wrought aluminium alloys
Si < 6%
hardened



M3	3.000	0.50	25	2655	20	2120	15	1590
M4	4.000	0.70	25	1990	20	1590	15	1195
M5	5.000	0.80	25	1590	20	1275	15	955
M6	6.000	1.00	25	1325	20	1060	15	795
M8	8.000	1.25	25	995	20	795	15	595
M10	10.000	1.50	25	795	20	635	15	475
M12	12.000	1.75	25	665	20	530	15	400
M16	16.000	2.00	25	495	20	400	15	300
M20	20.000	2.50	25	400	20	320	15	240