



# Taps polytap-R

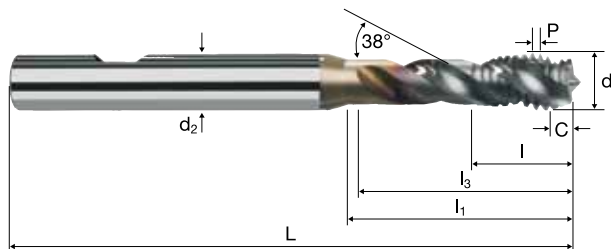


**MF** **ISO 2**  
(6H)

 **HSS**  
**PM/F**

 **DIN**  
**1835B**  
**ISO**  
**3338**

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





**Rm**  
< 850

**Rm**  
850-1100

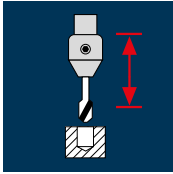
**Inox**  
Stainless

**GG(G)**  
Aluminium

**MF**

Example: Order-N°.		Article-N°.		ø-Code						TiCN	
		<b>EH1229</b>		<b>031</b>						<b>EH1229</b>	
Ø Code	d	P	L	l	l <sub>1</sub>	l <sub>3</sub>	d <sub>2</sub> h6				
031	M 3	0.35	63	5.00	18.0	16.0	6.0	3	2.65		●
046	M 4	0.50	66	7.00	21.0	19.0	6.0	3	3.50		●
048	M 5	0.50	70	8.00	25.0	23.0	6.0	3	4.50		●
050	M 6	0.50	80	10.00	30.0	28.0	6.0	3	5.50		●
064	M 6	0.75	80	10.00	30.0	28.0	6.0	3	5.20		●
066	M 8	0.75	90	13.00	35.0	33.0	8.0	3	7.20		●
068	M 10	0.75	100	15.00	39.0	37.0	10.0	3	9.20		●
090	M 8	1.00	90	13.00	35.0	37.0	8.0	3	7.00		●
092	M 10	1.00	100	15.00	39.0	37.0	10.0	3	9.00		●
094	M 12	1.00	110	11.00	39.0	37.0	12.0	3	11.00		●
096	M 14	1.00	110	11.00	46.0	44.0	16.0	4	13.00		●
098	M 16	1.00	110	12.00	50.0	48.0	16.0	4	15.00		●
162	M 10	1.25	100	15.00	39.0	37.0	10.0	3	8.80		●
164	M 12	1.25	110	15.00	39.0	37.0	12.0	3	10.80		●
176	M 12	1.50	110	15.00	39.0	37.0	12.0	3	10.50		●
178	M 14	1.50	110	15.00	46.0	44.0	16.0	4	12.50		●
180	M 16	1.50	110	15.00	50.0	48.0	16.0	4	14.50		●
184	M 20	1.50	140	20.00	64.0	62.0	16.0	4	18.50		●

## Application



## Material

Steel  
500 - 850 N/mm<sup>2</sup>



MF	d [mm]	P [mm]	$v_c$ 1.0 x d	n [min <sup>-1</sup> ]	$v_c$ 1.5 x d	n [min <sup>-1</sup> ]	$v_c$ 2.0 x d	n [min <sup>-1</sup> ]
M3	3.000	0.35	22	2335	20	2120	12	1275
M4	4.000	0.50	22	1750	20	1590	12	955
M5	5.000	0.50	22	1400	20	1275	12	765
M6	6.000	0.50	22	1165	20	1060	12	635
M6	6.000	0.75	22	1165	20	1060	12	635
M8	8.000	0.75	22	875	20	795	12	475
M10	10.000	0.75	22	700	20	635	12	380
M8	8.000	1.00	22	875	20	795	12	475
M10	10.000	1.00	22	700	20	635	12	380

Steel  
500 - 850 N/mm<sup>2</sup>



M12	12.000	1.00	22	585	20	530	12	320
M14	14.000	1.00	22	500	20	455	12	275
M16	16.000	1.00	22	440	20	400	12	240
M10	10.000	1.25	22	700	20	635	12	380
M12	12.000	1.25	22	585	20	530	12	320
M12	12.000	1.50	22	585	20	530	12	320
M14	14.000	1.50	22	500	20	455	12	275
M16	16.000	1.50	22	440	20	400	12	240
M20	20.000	1.50	22	350	20	320	12	190

Steel  
850 - 1100 N/mm<sup>2</sup>



M3	3.000	0.35	18	1910	12	1275	8	850
M4	4.000	0.50	18	1430	12	955	8	635
M5	5.000	0.50	18	1145	12	765	8	510
M6	6.000	0.50	18	955	12	635	8	425
M6	6.000	0.75	18	955	12	635	8	425
M8	8.000	0.75	18	715	12	475	8	320
M10	10.000	0.75	18	575	12	380	8	255
M8	8.000	1.00	18	715	12	475	8	320
M10	10.000	1.00	18	575	12	380	8	255

Steel  
850 - 1100 N/mm<sup>2</sup>



M12	12.000	1.00	18	475	12	320	8	210
M14	14.000	1.00	18	410	12	275	8	180
M16	16.000	1.00	18	360	12	240	8	160
M10	10.000	1.25	18	575	12	380	8	255
M12	12.000	1.25	18	475	12	320	8	210
M12	12.000	1.50	18	475	12	320	8	210
M14	14.000	1.50	18	410	12	275	8	180
M16	16.000	1.50	18	360	12	240	8	160
M20	20.000	1.50	18	285	12	190	8	125

Stainless steel  
[Cr-Ni/1.4301]



M3	3.000	0.35	4	425	3	320	2	210
M4	4.000	0.50	4	320	3	240	2	160
M5	5.000	0.50	4	255	3	190	2	125
M6	6.000	0.50	4	210	3	160	2	105
M6	6.000	0.75	4	210	3	160	2	105
M8	8.000	0.75	4	160	3	120	2	80
M10	10.000	0.75	4	125	3	95	2	65
M8	8.000	1.00	4	160	3	120	2	80
M10	10.000	1.00	4	125	3	95	2	65

Stainless steel  
[Cr-Ni/1.4301]



M12	12.000	1.00	4	105	3	80	2	55
M14	14.000	1.00	4	90	3	70	2	45
M16	16.000	1.00	4	80	3	60	2	40
M10	10.000	1.25	4	125	3	95	2	65
M12	12.000	1.25	4	105	3	80	2	55
M12	12.000	1.50	4	105	3	80	2	55
M14	14.000	1.50	4	90	3	70	2	45
M16	16.000	1.50	4	80	3	60	2	40
M20	20.000	1.50	4	65	3	50	2	30

Wrought aluminium alloys  
Si < 6%  
hardened



M3	3.000	0.35	22	2335	20	2120	12	1275
M4	4.000	0.50	22	1750	20	1590	12	955
M5	5.000	0.50	22	1400	20	1275	12	765
M6	6.000	0.50	22	1165	20	1060	12	635
M6	6.000	0.75	22	1165	20	1060	12	635
M8	8.000	0.75	22	875	20	795	12	475
M10	10.000	0.75	22	700	20	635	12	380
M8	8.000	1.00	22	875	20	795	12	475
M10	10.000	1.00	22	700	20	635	12	380

Wrought aluminium alloys  
Si < 6%  
hardened



M12	12.000	1.00	22	585	20	530	12	320
M14	14.000	1.00	22	500	20	455	12	275
M16	16.000	1.00	22	440	20	400	12	240
M10	10.000	1.25	22	700	20	635	12	380
M12	12.000	1.25	22	585	20	530	12	320
M12	12.000	1.50	22	585	20	530	12	320
M14	14.000	1.50	22	500	20	455	12	275
M16	16.000	1.50	22	440	20	400	12	240
M20	20.000	1.50	22	350	20	320	12	190