

Cold forming taps duroform

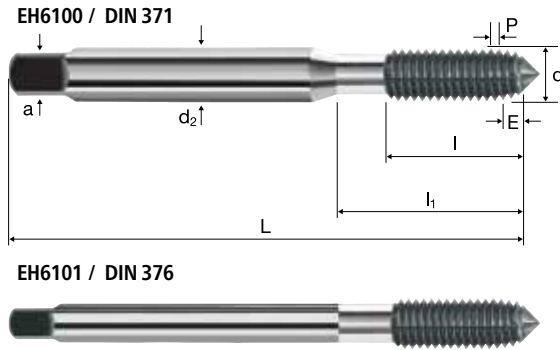


M **ISO 2 (6H)**

60° **HM MG10**

DIN 371/376

Form E



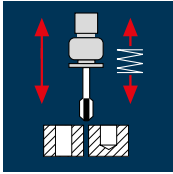
Rm < 850 **Rm 850-1100** **Inox Stainless** **Aluminium Copper**

Example: Order-N°.		Article-N°.		a-Code							TiCN
Order-N°.		EH6100		044							EH6100
Ø Code	d	P	L	l	l ₁	d ₂	a				
044	M 3	0.50	56	12.00	18.0	3.5	2.7	3	2.80		●
058	M 4	0.70	63	13.00	21.0	4.5	3.4	4	3.70		●
084	M 5	0.80	70	15.00	25.0	6.0	4.9	4	4.60		●
088	M 6	1.00	80	17.00	30.0	6.0	4.9	4	5.50		●
160	M 8	1.25	90	20.00	35.0	8.0	6.2	5	7.40		●
174	M 10	1.50	100	22.00	39.0	10.0	8.0	5	9.30		●

Example: Order-N°.		Article-N°.		a-Code							TiCN
Order-N°.		EH6101		240							EH6101
Ø Code	d	P	L	l	l ₁	d ₂	a				
240	M 12	1.75	110	24.00	50.0	9.0	7.0	7	11.20		●

CF

Application



Material

Steel
< 850 N/mm²
A₅ > 10%



Steel
850 - 1100 N/mm²
A₅ > 10%



Unalloyed aluminium



Wrought aluminium alloys
Si < 6%
not hardened



Unalloyed copper



Non ferrous metal
A₅ > 15%



Stainless steel
ferritic/martensitic
A₅ > 10%



Stainless steel
[Cr-Ni/1.4301]



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 ⁻¹]	v _f [100%]	n [min ⁻¹]	v _f [100%]	n [min ⁻¹]	v _f [100%]	n [min ⁻¹]	v _f [100%]	
M3	3.000	0.50	35	3715	1858	30	3185	1593	25	2655	1328
M4	4.000	0.70	35	2785	1950	30	2385	1670	25	1990	1393
M5	5.000	0.80	35	2230	1784	30	1910	1528	25	1590	1272
M6	6.000	1.00	35	1855	1855	30	1590	1590	25	1325	1325
M8	8.000	1.25	35	1395	1744	30	1195	1494	25	995	1244
M10	10.000	1.50	35	1115	1673	30	955	1433	25	795	1193
M12	12.000	1.75	35	930	1628	30	795	1391	25	665	1164
M3	3.000	0.50	30	3185	1593	25	2655	1328	20	2120	1060
M4	4.000	0.70	30	2385	1670	25	1990	1393	20	1590	1113
M5	5.000	0.80	30	1910	1528	25	1590	1272	20	1275	1020
M6	6.000	1.00	30	1590	1590	25	1325	1325	20	1060	1060
M8	8.000	1.25	30	1195	1494	25	995	1244	20	795	994
M10	10.000	1.50	30	955	1433	25	795	1193	20	635	953
M12	12.000	1.75	30	795	1391	25	665	1164	20	530	928
M3	3.000	0.50	50	5305	2653	40	4245	2123	30	3185	1593
M4	4.000	0.70	50	3980	2786	40	3185	2230	30	2385	1670
M5	5.000	0.80	50	3185	2548	40	2545	2036	30	1910	1528
M6	6.000	1.00	50	2655	2655	40	2120	2120	30	1590	1590
M8	8.000	1.25	50	1990	2488	40	1590	1988	30	1195	1494
M10	10.000	1.50	50	1590	2385	40	1275	1913	30	955	1433
M12	12.000	1.75	50	1325	2319	40	1060	1855	30	795	1391
M3	3.000	0.50	80	8490	4245	60	6365	3183	40	4245	2123
M4	4.000	0.70	80	6365	4456	60	4775	3343	40	3185	2230
M5	5.000	0.80	80	5095	4076	60	3820	3056	40	2545	2036
M6	6.000	1.00	80	4245	4245	60	3185	3185	40	2120	2120
M8	8.000	1.25	80	3185	3981	60	2385	2981	40	1590	1988
M10	10.000	1.50	80	2545	3818	60	1910	2865	40	1275	1913
M12	12.000	1.75	80	2120	3710	60	1590	2783	40	1060	1855
M3	3.000	0.50	60	6365	3183	40	4245	2123	30	3185	1593
M4	4.000	0.70	60	4775	3343	40	3185	2230	30	2385	1670
M5	5.000	0.80	60	3820	3056	40	2545	2036	30	1910	1528
M6	6.000	1.00	60	3185	3185	40	2120	2120	30	1590	1590
M8	8.000	1.25	60	2385	2981	40	1590	1988	30	1195	1494
M10	10.000	1.50	60	1910	2865	40	1275	1913	30	955	1433
M12	12.000	1.75	60	1590	2783	40	1060	1855	30	795	1391
M3	3.000	0.50	50	5305	2653	30	3185	1593	25	2655	1328
M4	4.000	0.70	50	3980	2786	30	2385	1670	25	1990	1393
M5	5.000	0.80	50	3185	2548	30	1910	1528	25	1590	1272
M6	6.000	1.00	50	2655	2655	30	1590	1590	25	1325	1325
M8	8.000	1.25	50	1990	2488	30	1195	1494	25	995	1244
M10	10.000	1.50	50	1590	2385	30	955	1433	25	795	1193
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M6	6.000	1.00	30	1590	1590	25	1325	1325	20	1060	1060
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M12	12.000	1.75	30	795	1391	25	665	1164	20	530	928
M3	3.000	0.50	30	3185	1593	25	2655	1328	20	2120	1060
M4	4.000	0.70	30	2385	1670	25	1990	1393	20	1590	1113
M5	5.000	0.80	30	1910	1528	25	1590	1272	20	1275	1020
M6	6.000	1.00	30	1590	1590	25	1325	1325	20	1060	1060
M8	8.000	1.25	30	1195	1494	25	995	1244	20	795	994
M10	10.000	1.50	30	955	1433	25	795	1193	20	635	953
M12	12.000	1.75	30	795	1391	25	665	1164	20	530	928