

Taps

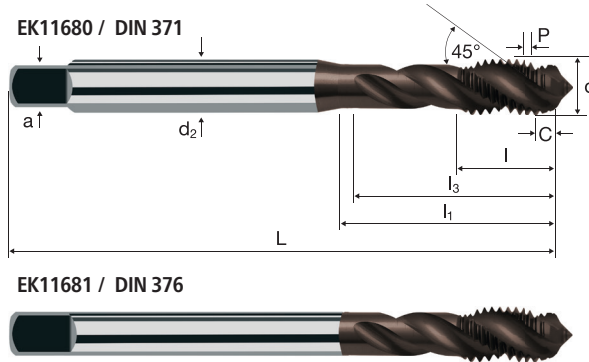


UNC **2B**

60° **HSS-E Co5**

DIN 371/376

X-P
Form C



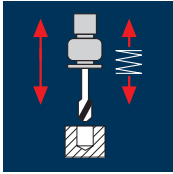
Rm < 850 **Rm 850-1100**

| Example: Order-N°: EK11680 701 | | | | | | | | | | | TiAlN | | |
|---|-------|--------|--------|-----|-------|----------------|----------------|----------------|-----|---|----------------|---|--|
| Article-N°: EK11680 α-Code: 701 | | | | | | | | | | | EK11680 | | |
| Ø Code | d | P(TPI) | d (mm) | L | l | l ₁ | l ₃ | d ₂ | a | | | | |
| 701 | Nr.2 | -56.0 | 2.184 | 45 | 5.00 | 14.5 | 12.5 | 2.8 | 2.1 | 3 | 1.85 | ● | |
| 703 | Nr.4 | -40.0 | 2.845 | 56 | 7.00 | 18.0 | 14.0 | 3.5 | 2.7 | 3 | 2.35 | ● | |
| 705 | Nr.6 | -32.0 | 3.505 | 56 | 8.00 | 20.0 | 16.0 | 4.0 | 3.0 | 3 | 2.85 | ● | |
| 706 | Nr.8 | -32.0 | 4.166 | 63 | 8.00 | 21.0 | 17.0 | 4.5 | 3.4 | 3 | 3.50 | ● | |
| 707 | Nr.10 | -24.0 | 4.826 | 70 | 11.00 | 25.0 | 21.0 | 6.0 | 4.9 | 3 | 3.90 | ● | |
| 708 | Nr.12 | -24.0 | 5.486 | 80 | 11.00 | 30.0 | 26.0 | 6.0 | 4.9 | 3 | 4.50 | ● | |
| 709 | 1/4 | -20.0 | 6.350 | 80 | 13.00 | 30.0 | 26.0 | 7.0 | 5.5 | 3 | 5.10 | ● | |
| 710 | 5/16 | -18.0 | 7.938 | 90 | 14.00 | 35.0 | 31.0 | 8.0 | 6.2 | 3 | 6.60 | ● | |
| 711 | 3/8 | -16.0 | 9.525 | 100 | 16.00 | 39.0 | 35.0 | 10.0 | 8.0 | 3 | 8.00 | ● | |

| Example: Order-N°: EK11681 712 | | | | | | | | | | | TiAlN | | |
|---|------|--------|--------|-----|-------|----------------|----------------|----------------|------|---|----------------|---|--|
| Article-N°: EK11681 α-Code: 712 | | | | | | | | | | | EK11681 | | |
| Ø Code | d | P(TPI) | d (mm) | L | l | l ₁ | l ₃ | d ₂ | a | | | | |
| 712 | 7/16 | -14.0 | 11.113 | 100 | 18.00 | 42.0 | 38.0 | 8.0 | 6.2 | 3 | 9.40 | ● | |
| 713 | 1/2 | -13.0 | 12.700 | 110 | 20.00 | 49.0 | 45.0 | 9.0 | 7.0 | 3 | 10.80 | ● | |
| 714 | 9/16 | -12.0 | 14.288 | 110 | 21.00 | 53.0 | 49.0 | 11.0 | 9.0 | 3 | 12.20 | ● | |
| 715 | 5/8 | -11.0 | 15.875 | 110 | 24.00 | 53.0 | 49.0 | 12.0 | 9.0 | 4 | 13.50 | ● | |
| 716 | 3/4 | -10.0 | 19.050 | 125 | 25.00 | 62.0 | 58.0 | 14.0 | 11.0 | 4 | 16.50 | ● | |
| 717 | 7/8 | -9.0 | 22.225 | 140 | 28.00 | 62.0 | 58.0 | 18.0 | 14.5 | 4 | 19.50 | ● | |

MF
G
UN
EG

Application



Material

Steel
500 - 850 N/mm²



Steel
500 - 850 N/mm²



Steel
850 - 1100 N/mm²



Steel
850 - 1100 N/mm²



| UNC | P(TPI) | 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%] | f | n [min ⁻¹] | v _f [100%] | f | n [min ⁻¹] | v _f [100%] | f |
| Nr.2 | -56.0 | 2.184 | 0.454 | 25 | 3645 | 1655 | 22 | 3205 | 1455 | 18 | 2625 | 1192 |
| Nr.4 | -40.0 | 2.845 | 0.635 | 25 | 2795 | 1775 | 22 | 2460 | 1562 | 18 | 2015 | 1280 |
| Nr.6 | -32.0 | 3.505 | 0.794 | 25 | 2270 | 1802 | 22 | 2000 | 1588 | 18 | 1635 | 1298 |
| Nr.8 | -32.0 | 4.166 | 0.794 | 25 | 1910 | 1517 | 22 | 1680 | 1334 | 18 | 1375 | 1092 |
| Nr.10 | -24.0 | 4.826 | 1.058 | 25 | 1650 | 1746 | 22 | 1450 | 1534 | 18 | 1185 | 1254 |
| Nr.12 | -24.0 | 5.486 | 1.058 | 25 | 1450 | 1534 | 22 | 1275 | 1349 | 18 | 1045 | 1106 |
| 1/4 | -20.0 | 6.350 | 1.270 | 25 | 1255 | 1594 | 22 | 1105 | 1403 | 18 | 900 | 1143 |
| 5/16 | -18.0 | 7.938 | 1.411 | 25 | 1000 | 1411 | 22 | 880 | 1242 | 18 | 720 | 1016 |
| 3/8 | -16.0 | 9.525 | 1.588 | 25 | 835 | 1326 | 22 | 735 | 1167 | 18 | 600 | 953 |
| 7/16 | -14.0 | 11.113 | 1.814 | 25 | 715 | 1297 | 22 | 630 | 1143 | 18 | 515 | 934 |
| 1/2 | -13.0 | 12.700 | 1.954 | 25 | 625 | 1221 | 22 | 550 | 1075 | 18 | 450 | 879 |
| 9/16 | -12.0 | 14.288 | 2.117 | 25 | 555 | 1175 | 22 | 490 | 1037 | 18 | 400 | 847 |
| 5/8 | -11.0 | 15.875 | 2.309 | 25 | 500 | 1155 | 22 | 440 | 1016 | 18 | 360 | 831 |
| 3/4 | -10.0 | 19.050 | 2.540 | 25 | 420 | 1067 | 22 | 370 | 940 | 18 | 300 | 762 |
| 7/8 | -9.0 | 22.225 | 2.822 | 25 | 360 | 1016 | 22 | 315 | 889 | 18 | 260 | 734 |
| | | | | | | | | | | | | |
| | | | | | | | | | | | | |
| Nr.2 | -56.0 | 2.184 | 0.454 | 16 | 2330 | 1058 | 13 | 1895 | 860 | 8 | 1165 | 529 |
| Nr.4 | -40.0 | 2.845 | 0.635 | 16 | 1790 | 1137 | 13 | 1455 | 924 | 8 | 895 | 568 |
| Nr.6 | -32.0 | 3.505 | 0.794 | 16 | 1455 | 1155 | 13 | 1180 | 937 | 8 | 725 | 576 |
| Nr.8 | -32.0 | 4.166 | 0.794 | 16 | 1225 | 973 | 13 | 995 | 790 | 8 | 610 | 484 |
| Nr.10 | -24.0 | 4.826 | 1.058 | 16 | 1055 | 1116 | 13 | 855 | 905 | 8 | 530 | 561 |
| Nr.12 | -24.0 | 5.486 | 1.058 | 16 | 930 | 984 | 13 | 755 | 799 | 8 | 465 | 492 |
| 1/4 | -20.0 | 6.350 | 1.270 | 16 | 800 | 1016 | 13 | 650 | 826 | 8 | 400 | 508 |
| 5/16 | -18.0 | 7.938 | 1.411 | 16 | 640 | 903 | 13 | 520 | 734 | 8 | 320 | 452 |
| 3/8 | -16.0 | 9.525 | 1.588 | 16 | 535 | 850 | 13 | 435 | 691 | 8 | 265 | 421 |
| 7/16 | -14.0 | 11.113 | 1.814 | 16 | 460 | 834 | 13 | 370 | 671 | 8 | 230 | 417 |
| 1/2 | -13.0 | 12.700 | 1.954 | 16 | 400 | 782 | 13 | 325 | 635 | 8 | 200 | 391 |
| 9/16 | -12.0 | 14.288 | 2.117 | 16 | 355 | 752 | 13 | 290 | 614 | 8 | 180 | 381 |
| 5/8 | -11.0 | 15.875 | 2.309 | 16 | 320 | 739 | 13 | 260 | 600 | 8 | 160 | 369 |
| 3/4 | -10.0 | 19.050 | 2.540 | 16 | 265 | 673 | 13 | 215 | 546 | 8 | 135 | 343 |
| 7/8 | -9.0 | 22.225 | 2.822 | 16 | 230 | 649 | 13 | 185 | 522 | 8 | 115 | 325 |
| | | | | | | | | | | | | |
| | | | | | | | | | | | | |