

Cold forming taps Lightform Steel

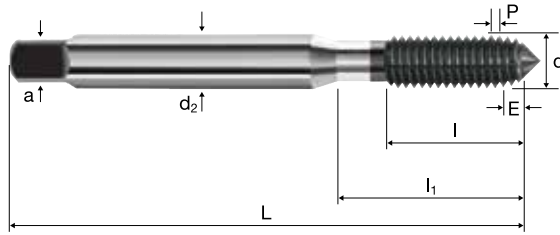


M **ISO 2**
(6H)

HSS
PM/F

DIN
376

Form C

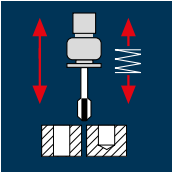


Rm < 850 **Rm** 850-1100 **Inox** Stainless

										LONGCUT
										EL10081
Example: Order-Nº. EL10081 240										
		Article-Nº.		ø-Code						
Ø Code	d	P	L	I	I ₁	d ₂	a			
240	M 12	1.75	110	24.00	40.0	9.0	7.0	5	11.20	●
244	M 14	2.00	110	26.00	40.0	11.0	9.0	5	13.10	●
246	M 16	2.00	110	27.00	40.0	12.0	9.0	5	15.10	●

CF

Application



Material

Steel
< 850 N/mm²
A₅ > 10%



Steel
850 - 1100 N/mm²
A₅ > 10%



Stainless steel
ferritic/martensitic
A₅ > 10%



Stainless steel
[Cr-Ni/1.4301]



M	d [mm]	P [mm]	v_c 1.5 x d			v_c 2.0 x d			v_c 3.0 x d		
			n [min ⁻¹]	v_f [100%]	v_c [min ⁻¹]	n [min ⁻¹]	v_f [100%]	v_c [min ⁻¹]	n [min ⁻¹]	v_f [100%]	
M12	12.000	1.75	20	530	928	15	400	700	10	265	464
M14	14.000	2.00	20	455	910	15	340	680	10	225	450
M16	16.000	2.00	20	400	800	15	300	600	10	200	400
M12	12.000	1.75	15	400	700	10	265	464	-	-	-
M14	14.000	2.00	15	340	680	10	225	450	-	-	-
M16	16.000	2.00	15	300	600	10	200	400	-	-	-
M12	12.000	1.75	15	400	700	10	265	464	-	-	-
M14	14.000	2.00	15	340	680	10	225	450	-	-	-
M16	16.000	2.00	15	300	600	10	200	400	-	-	-