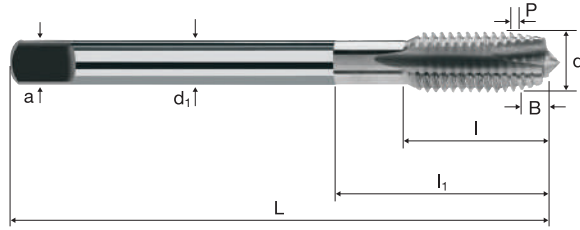


Taps u-tap



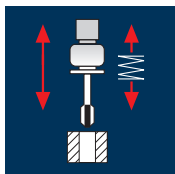
M	ISO 2 (6H)
	HSS-E Co5



Rm < 850							Inox Stainless		GG(G) Aluminium Copper
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		Article-N°.		ø-Code						VAP	
Example: Order-N°.		E10801		240						E10801	EV10801
ø Code	d	P	L	I	I1	d1	a				
240	M12	1.75	110	24	40	9.0	7.0	3	10.20	●	●
244	M14	2.00	110	26	40	11.0	9.0	3	12.00	●	●
246	M16	2.00	110	27	40	12.0	9.0	3	14.00	●	●
312	M18	2.50	125	30	45	14.0	11.0	4	15.50	●	●
314	M20	2.50	140	32	50	16.0	12.0	4	17.50	●	●
316	M22	2.50	140	32	50	18.0	14.5	4	19.50	●	●
320	M24	3.00	160	34	60	18.0	14.5	4	21.00	●	●

Application



Material

Steel
< 500 N/mm²

M	ø [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%]	n [min ⁻¹]	v _f [100%]	n [min ⁻¹]	v _f [100%]			
M12	12.0	1.75	18	475	831	15	400	700	12	320	560
M14	14.0	2.00	18	410	820	15	340	680	12	275	550
M16	16.0	2.00	18	360	720	15	300	600	12	240	480
M18	18.0	2.50	18	320	800	15	265	663	12	210	525
M20	20.0	2.50	18	285	713	15	240	600	12	190	475
M22	22.0	2.50	18	260	650	15	215	538	12	175	438
M24	24.0	3.00	18	240	720	15	200	600	12	160	480

Steel
500 - 850 N/mm²

M12	12.0	1.75	15	400	700	10	265	464	8	210	368
M14	14.0	2.00	15	340	680	10	225	450	8	180	360
M16	16.0	2.00	15	300	600	10	200	400	8	160	320
M18	18.0	2.50	15	265	663	10	175	438	8	140	350
M20	20.0	2.50	15	240	600	10	160	400	8	125	313
M22	22.0	2.50	15	215	538	10	145	363	8	115	288
M24	24.0	3.00	15	200	600	10	135	405	8	105	315

Wrought aluminium
alloys Si < 6%
hardened

M12	12.0	1.75	15	400	700	12	320	560	10	265	464
M14	14.0	2.00	15	340	680	12	275	550	10	225	450
M16	16.0	2.00	15	300	600	12	240	480	10	200	400
M18	18.0	2.50	15	265	663	12	210	525	10	175	438
M20	20.0	2.50	15	240	600	12	190	475	10	160	400
M22	22.0	2.50	15	215	538	12	175	438	10	145	363
M24	24.0	3.00	15	200	600	12	160	480	10	135	405

Recommendation:
uncoated

Stainless steel
[Cr-Ni/1.4301]



M12	12.0	1.75	5	135	236	4	105	184	3	80	140
M14	14.0	2.00	5	115	230	4	90	180	3	70	140
M16	16.0	2.00	5	100	200	4	80	160	3	60	120
M18	18.0	2.50	5	90	225	4	70	175	3	55	138
M20	20.0	2.50	5	80	200	4	65	163	3	50	125
M22	22.0	2.50	5	70	175	4	60	150	3	45	113
M24	24.0	3.00	5	65	195	4	55	165	3	40	120