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CoroTap™ P ≤ 350 HB

M	DIN 371≤10 376≥12	6HX		3XD	HSS-E-PM		B 3.5-5			Cool TOP		EP03P	M1 - M30	14
M	DIN 371≤10 376≥12	6HX		3XD	HSS-E-PM		B 3.5-5			Cool TOP		EP09P	M4 - M30	16
M	DIN ANSI	6HX		3XD	HSS-E-PM		B 3.5-5			Cool TOP		EP03PA	M3 - M24	18
M	ISO 529	6H		2.5XD	HSS-PM		B 3.5-5			Cool TOP		E049	M3 - M20	20
M	DIN 371≤10 376≥12	6HX		3XD	HSS-E-PM		C 2-3	λ48°		Cool TOP		EX03P	M1.6 - M30	22
M	DIN 371≤10 376≥12	6HX		3XD	HSS-E-PM		C 2-3	λ48°		Cool TOP		EX09P	M4 - M30	24
M	DIN ANSI	6HX		3XD	HSS-E-PM		C 2-3	λ48°		Cool TOP		EX03PA	M3 - M24	26
M	ISO 529	6H		2.5XD	HSS-PM		C 2-3	λ45°		Cool TOP		E050	M3 - M20	28
M	ISO 529	6H		2.5XD	HSS-PM		C 2-3	λ45°		Cool TOP		E051	M6 - M20	30
MF	DIN 374	6HX		3XD	HSS-E-PM		B 3.5-5			Cool TOP		EP13P	M4 - M30	32
MF	DIN ANSI	6HX		3XD	HSS-E-PM		B 3.5-5			Cool TOP		EP13PA	M8 - M18	34
MF	DIN 374	6HX		3XD	HSS-E-PM		C 2-3	λ48°		Cool TOP		EX13P	M4 - M30	36
MF	DIN ANSI	6HX		3XD	HSS-E-PM		C 2-3	λ48°		Cool TOP		EX13PA	M8 - M18	38
UNC	DIN ANSI	2B 3B		3XD	HSS-E-PM		B 3.5-5			Cool TOP		EP23PA	No.2 - 1"	40
UNC	DIN ANSI	2BX		3XD	HSS-E-PM		B 3.5-5			Cool TOP		EP29PA	1/4 - 1"	42
UNC	ISO 529	2B		2.5XD	HSS-PM		B 3.5-5			Cool TOP		E057	No.6 - 3/4	44
UNC	DIN ANSI	2B 3B		3XD	HSS-E-PM		C 2-3	λ48°		Cool TOP		EX23PA	No.2 - 1"	46
UNC	DIN ANSI	2BX		3XD	HSS-E-PM		C 2-3	λ48°		Cool TOP		EX29PA	1/4 - 1"	48
UNC	ISO 529	2B		2.5XD	HSS-PM		C 2-3	λ45°		Cool TOP		E058	No.6 - 3/4	50
UNF	DIN ANSI	2B 3B		3XD	HSS-E-PM		B 3.5-5			Cool TOP		EP33PA	No.8 - 1"	52
UNF	DIN ANSI	2BX		3XD	HSS-E-PM		B 3.5-5			Cool TOP		EP39PA	No.10 - 5/8	54
UNF	DIN ANSI	2B 3B		3XD	HSS-E-PM		C 2-3	λ48°		Cool TOP		EX33PA	No.8 - 1"	56

CoroTap™ P ≤ 350 HB

UNF	DIN ANSI	2BX		3XD	HSS-E-PM		C 2-3	λ48°		Cool TOP		EX39PA	No.10 - 5/8	58

CoroTap™ P 30-48 HRC

M	~DIN 371	6H		2.5XD	HSS-E-PM		B 3.5-5			Cool TOP		E324	M3 - M10	60
M	DIN 376	6H		2.5XD	HSS-E-PM		B 3.5-5			Cool TOP		E326	M12 - M20	60
M	DIN ANSI	6H		2.5XD	HSS-E-PM		B 3.5-5			Cool TOP		E854	M3 - M20	62
M	~DIN 371	6H		1.5XD	HSS-E-PM		C 2-3	λ15°		Cool TOP		E314	M3 - M10	64
M	DIN 376	6H		1.5XD	HSS-E-PM		C 2-3	λ15°		Cool TOP		E316	M12 - M20	64
M	DIN ANSI	6H		1.5XD	HSS-E-PM		C 2-3	λ15°		Cool TOP		E864	M3 - M20	66
MF	DIN ANSI	6H		2.5XD	HSS-E-PM		B 3.5-5			Cool TOP		E855	M10 - M12	68
MF	DIN ANSI	6H		1.5XD	HSS-E-PM		C 2-3	λ15°		Cool TOP		E865	M10 - M12	70
UNC	DIN ANSI	2B		2.5XD	HSS-E-PM		B 3.5-5			Cool TOP		E874	No.4 - 3/4	72
UNC	DIN ANSI	2B		1.5XD	HSS-E-PM		C 2-3	λ15°		Cool TOP		E884	No.4 - 3/4	74
UNF	DIN ANSI	2B		2.5XD	HSS-E-PM		B 3.5-5			Cool TOP		E875	No.10 - 3/4	76
UNF	DIN ANSI	2B		1.5XD	HSS-E-PM		C 2-3	λ15°		Cool TOP		E885	No.10 - 3/4	78

CoroTap™ K

M	DIN 371≤10 376≥12	6HX		2.5XD	HM		C 2-3			Cool TOP		T101	M5 - M16	80
M	DIN 371≤10 376≥12	6H		2XD	HM		C 2-3	λ15°				T105	M3 - M12	82
M	DIN 371≤10 376≥12	6H		3XD	HM		C 2-3	λ15°				T106	M5 - M12	84
MF	DIN 374	6HX		2.5XD	HM		C 2-3			Cool TOP		T120	M8 - M14	86
M	DIN 371	6HX		2XD	HSS-E-PM		C 2-3			Cool TOP		E446	M3 - M10	88
M	DIN 376	6HX		2XD	HSS-E-PM		C 2-3			Cool TOP		E447	M8 - M24	88

CoroTap™ K

M	DIN 371	6HX		2.5XD	HSS-E-PM		C 2-3			Cool TOP		E462	M6 - M10	90
M	DIN 376	6HX		2.5XD	HSS-E-PM		C 2-3			Cool TOP		E463	M12 - M20	90
M	DIN ANSI	6HX		2XD	HSS-E-PM		C 2-3			Cool TOP		E835	M6 - M18	92
M	DIN ANSI	6HX		2XD	HSS-E-PM		E 1.5-2			Cool TOP		E825	M6 - M18	94
M	DIN ANSI	6HX		2.5XD	HSS-E-PM		C 2-3			Cool TOP		E837	M6 - M20	96
M	DIN ANSI	6HX		2.5XD	HSS-E-PM		E 1.5-2			Cool TOP		E827	M6 - M20	98
M	ISO 529	6HX		2XD	HSS-E		C 2-3			Cool TOP		E053	M3 - M20	100
MF	DIN 374	6HX		2XD	HSS-E-PM		C 2-3			N		E269	M10 - M20	102
MF	DIN ANSI	6HX		2XD	HSS-E-PM		C 2-3			Cool TOP		E836	M10 - M14	104
MF	DIN ANSI	6HX		2.5XD	HSS-E-PM		C 2-3			Cool TOP		E838	M10 - M14	106
MF	ISO 529	6HX		2XD	HSS-E		C 2-3			Cool TOP		E054	M8 - M16	108
UNC	DIN ANSI	2BX		2XD	HSS-E-PM		C 2-3			Cool TOP		E830	1/4 - 7/8	110
UNC	DIN ANSI	2BX		2XD	HSS-E-PM		E 1.5-2			Cool TOP		E839	1/4 - 7/8	112
UNC	DIN ANSI	2BX		2.5XD	HSS-E-PM		C 2-3			Cool TOP		E832	1/4 - 1/2	114
UNC	DIN ANSI	2BX		2.5XD	HSS-E-PM		E 1.5-2			Cool TOP		E822	1/4 - 1/2	116
UNC	ISO 529	2B		2XD	HSS-E		C 2-3			Cool TOP		E059	1/4 - 3/4	118
UNF	DIN ANSI	2BX		2XD	HSS-E-PM		C 2-3			Cool TOP		E831	1/4 - 7/8	120
UNF	DIN ANSI	2BX		2XD	HSS-E-PM		E 1.5-2			Cool TOP		E821	1/4 - 3/4	122
UNF	DIN ANSI	2BX		2.5XD	HSS-E-PM		C 2-3			Cool TOP		E833	1/4 - 1/2	124
UNF	DIN ANSI	2BX		2.5XD	HSS-E-PM		E 1.5-2			Cool TOP		E823	1/4 - 7/16	126
G	DIN 5156	Normal		2XD	HSS-E		C 2-3			N		E416	1/8 - 1"	128

Spectrum™ Tap

M	DIN 371≤10 376≥12	6H		2.5XD	HSS-PM		B 3.5-5					P K N S O	EP006H	M2 - M30	130
M	DIN 371≤10 376≥12	6H		2.5XD	HSS-PM		B 3.5-5			ST		P M K	EP016H	M2 - M30	132
M	DIN 371≤10 376≥12	6G		2.5XD	HSS-PM		B 3.5-5					P K N S O	EP006G	M3 - M20	134
M	DIN 371≤10 376≥12	6G		2.5XD	HSS-PM		B 3.5-5			ST		P M K	EP016G	M3 - M20	136
M	DIN 371≤10 376≥12	6H		3XD	HSS-E		B 3.5-5			Cool TOP		P M K N S	E616	M3 - M20	138
M	ANSI	6H		2.5XD	HSS-PM		B 3.5-5					P K N S O	E005	M4 - M20	140
M	ANSI	6H		2.5XD	HSS-PM		B 3.5-5			ST		P M K	E006	M4 - M20	142
M	ISO 529	6H		2.5XD	HSS-PM		B 3.5-5					P K N S O	E000	M1.6 - M24	144
M	ISO 529	6H		2.5XD	HSS-PM		B 3.5-5			ST		P M K	E001	M1.6 - M24	146
M	DIN 371	6H		1.5XD	HSS-E		C 2-3	λ15°				P N	E207	M2- M10	148
M	DIN 376	6H		1.5XD	HSS-E		C 2-3	λ15°				P N	E258	M4- M36	148
M	DIN 371	6H		1.5XD	HSS-E		C 2-3	λ15°		TiN		P N S	E212	M3- M10	150
M	DIN 376	6H		1.5XD	HSS-E		C 2-3	λ15°		TiN		P N S	E263	M12- M36	150
M	DIN 371	6H		2.5XD	HSS-E		C 2-3	λ40°				P N	E195	M3 - M10	152
M	DIN 376	6H		2.5XD	HSS-E		C 2-3	λ40°				P N	E245	M12 - M30	152
M	DIN 371≤10 376≥12	6H		2.5XD	HSS-PM		C 2-3	λ45°				P N S O	EX006H	M2 - M64	154
M	DIN 371≤10 376≥12	6H		2.5XD	HSS-PM		C 2-3	λ45°		ST		P M	EX016H	M2 - M64	156
M	DIN 371≤10 376≥12	6G		2.5XD	HSS-PM		C 2-3	λ45°				P N S O	EX006G	M3 - M20	158
M	DIN 371≤10 376≥12	6G		2.5XD	HSS-PM		C 2-3	λ45°		ST		P M	EX016G	M3 - M20	160
M	DIN 371≤10 376≥12	6H		3XD	HSS-E		C 2-3	λ45°		Cool TOP		P M K N S	E615	M3 - M20	162
M	ANSI	6H		2.5XD	HSS-PM		C 2-3	λ45°				P N S O	E007	M4- M20	164
M	ANSI	6H		2.5XD	HSS-PM		C 2-3	λ45°		ST		P M	E008	M4- M20	166

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Spectrum™ Tap

M	ISO 529	6H		2.5XD	HSS-PM		C 2-3	λ45°				P N S O	E002	M2 - M24	168
M	ISO 529	6H		2.5XD	HSS-PM		C 2-3	λ45°		ST		P M	E003	M2 - M24	170
MF	DIN 374	6H		2.5XD	HSS-PM		B 3.5-5					P K N S O	EP10	M4 - M30	172
MF	DIN 374	6H		2.5XD	HSS-PM		B 3.5-5			ST		P M K	EP11	M4 - M30	174
MF	ANSI	6H		2.5XD	HSS-PM		B 3.5-5					P K N S O	E015	M8- M18	176
MF	ANSI	6H		2.5XD	HSS-PM		B 3.5-5			ST		P M K	E016	M8- M18	178
MF	ISO 529	6H		2.5XD	HSS-PM		B 3.5-5					P K N S O	E010	M4 - M24	180
MF	ISO 529	6H		2.5XD	HSS-PM		B 3.5-5			ST		P M K	E011	M4 - M24	182
MF	DIN 374	6H		2.5XD	HSS-PM		C 2-3	λ45°				P N S O	EX10	M4 - M30	184
MF	DIN 374	6H		2.5XD	HSS-PM		C 2-3	λ45°		ST		P M	EX11	M4 - M30	186
MF	ANSI	6H		2.5XD	HSS-PM		C 2-3	λ45°				P N S O	E017	M8- M18	188
MF	ANSI	6H		2.5XD	HSS-PM		C 2-3	λ45°		ST		P M	E018	M8- M18	190
MF	ISO 529	6H		2.5XD	HSS-PM		C 2-3	λ45°				P N S O	E012	M4 - M22	192
MF	ISO 529	6H		2.5XD	HSS-PM		C 2-3	λ45°		ST		P M	E013	M4 - M22	194
UNC	DIN 2184-1	2B		2.5XD	HSS-PM		B 3.5-5					P K N S O	EP20	No.4 - 1"	196
UNC	DIN 2184-1	2B		2.5XD	HSS-PM		B 3.5-5			ST		P M K	EP21	No.4 - 1"	198
UNC	ANSI	3B		2.5XD	HSS-PM		B 3.5-5					P K N S O	E025	No.6 - 1"	200
UNC	ANSI	3B		2.5XD	HSS-PM		B 3.5-5			ST		P M K	E026	No.2 - 1"	202
UNC	ISO 529	2B		2.5XD	HSS-PM		B 3.5-5					P K N S O	E020	No.2 - 1"	204
UNC	ISO 529	2B		2.5XD	HSS-PM		B 3.5-5			ST		P M K	E021	No.2 - 1"	206
UNC	DIN 2184-1	2B		2.5XD	HSS-PM		C 2-3	λ45°				P N S O	EX20	No.4 - 1"	208
UNC	DIN 2184-1	2B		2.5XD	HSS-PM		C 2-3	λ45°		ST		P M	EX21	No.4 - 1"	210

Spectrum™ Tap

UNC	ANSI	3B		2.5XD	HSS-PM		C 2-3	λ45°			P N S O	E027	No.6 - 1"	212
UNC	ANSI	3B		2.5XD	HSS-PM		C 2-3	λ45°		ST	P M	E028	No.4 - 1"	214
UNC	ISO 529	2B		2.5XD	HSS-PM		C 2-3	λ45°			P N S O	E022	No.2 - 1"	216
UNC	ISO 529	2B		2.5XD	HSS-PM		C 2-3	λ45°		ST	P M	E023	No.2 - 1"	218
UNF	DIN 2184-1	2B		2.5XD	HSS-PM		B 3.5-5				P K N S O	EP30	No.8 - 1"	220
UNF	DIN 2184-1	2B		2.5XD	HSS-PM		B 3.5-5			ST	P M K	EP31	No.8 - 1"	222
UNF	ANSI	3B		2.5XD	HSS-PM		B 3.5-5				P K N S O	E035	No.6 - 1"	224
UNF	ANSI	3B		2.5XD	HSS-PM		B 3.5-5			ST	P M K	E036	No.10 - 1"	226
UNF	ISO 529	2B		2.5XD	HSS-PM		B 3.5-5				P K N S O	E030	No.8 - 1"	228
UNF	ISO 529	2B		2.5XD	HSS-PM		B 3.5-5			ST	P M K	E031	No.8 - 1"	230
UNF	DIN 2184-1	2B		2.5XD	HSS-PM		C 2-3	λ45°			P N S O	EX30	No.8 - 1"	232
UNF	DIN 2184-1	2B		2.5XD	HSS-PM		C 2-3	λ45°		ST	P M	EX31	No.8 - 1"	234
UNF	ANSI	3B		2.5XD	HSS-PM		C 2-3	λ45°			P N S O	E037	No.10 - 1"	236
UNF	ANSI	3B		2.5XD	HSS-PM		C 2-3	λ45°		ST	P M	E038	No.10 - 1"	238
UNF	ISO 529	2B		2.5XD	HSS-PM		C 2-3	λ45°			P N S O	E032	No.8 - 1"	240
UNF	ISO 529	2B		2.5XD	HSS-PM		C 2-3	λ45°		ST	P M	E033	No.8 - 1"	242
G	DIN 5156	Normal		2.5XD	HSS-E		B 3.5-5				P K N S O	EP40	1/8 - 1"	244
G	DIN 5156	Normal		2.5XD	HSS-E		B 3.5-5			ST	P M K	EP41	1/8 - 1"	246
G	DIN 5156	Normal		2.5XD	HSS-E		C 2-3	λ45°			P N S O	EX40	1/8 - 1.1/2	248
G	DIN 5156	Normal		2.5XD	HSS-E		C 2-3	λ45°		ST	P M	EX41	1/8 - 1.1/2	250
NPT	DIN ANSI	Normal		1.5XD	HSS-E		C 2-3	λ15°		ST	P M K N S	E735	1/16 - 1"	252
NPTF	DIN ANSI	Normal		1.5XD	HSS-E		C 2-3	λ15°		ST	P M K N S	E737	1/16- 3/4	254

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M	DIN 2174	6HX		3XD	HM		C 2-3			TiCN		P M N S	T115	M3 - M10	256
M	DIN 2174	6HX		3XD	HM		C 2-3			TiCN		P M N S	T116	M5 - M12	258
M	DIN 2174	6HX		3XD	HSS-E		C 2-3.5					P N	E301	M1 - M24	260
M	DIN 2174	6HX		3XD	HSS-E		C 2-3.5			TiN		P M N S	E302	M1 - M24	262
M	DIN 2174	6HX		3XD	HSS-E		C 2-3.5			CrN		P M N S	E306	M3 - M12	264
M	DIN 2174	6GX		3XD	HSS-E		C 2-3.5			TiN		P M N S	E309	M3 - M12	266
M	DIN 2174	6HX		3XD	HSS-E		E 1.5-2			TiN		P M N S	E305	M3 - M10	268
M	DIN 2174	6GX		3XD	HSS-E		E 1.5-2			TiN		P M N S	E310	M3 - M10	270
M	DIN 2174	6HX		3.5XD	HSS-E		C 2-3.5			TiN		P M N S	E308	M3 - M24	272
M	DIN 2174	6HX		3.5XD	HSS-E		C 2-3.5			TiN		P M N S	E315	M5 - M12	274
M	DIN ANSI	6H		3XD	HSS-PM		C 2-3			TiN		P M N S	E890	M3 - M20	276
M	ANSI	6HX		2.5XD	HSS-PM		C 2-3					P N	E094	M3- M10	278
M	ISO 529	6HX		2.5XD	HSS-PM		C 2-3					P N	E090	M2 - M16	280
M	ISO 529	6HX		2.5XD	HSS-PM		C 2-3			TiN		P M N S	E091	M2 - M16	282
M	ISO 529	6HX		2.5XD	HSS-PM		C 2-3			TiN		P M N S	E096	M3 - M16	284
M	ISO 529	6HX		2.5XD	HSS-PM		C 2-3			CrN		P M N S	E097	M2 - M16	286
M	ISO 529	6HX		3XD	HSS-PM		C 2-3			TiN		P M N S	E099	M4 - M16	288
MF	DIN 2174	6HX		3XD	HSS-E		C 2-3.5			TiN		P M N S	E317	M5 - M16	290
MF	DIN ANSI	6H		3XD	HSS-PM		C 2-3			TiN		P M N S	E891	M10 - M12	292
UNC	DIN ANSI	2B		2.5XD	HSS-PM		C 2-3					P N	E064	No.4 - 3/8	294
UNC	DIN ANSI	2B		3XD	HSS-PM		C 2-3			TiN		P M N S	E892	No.4 - 1 "	296
UNC	ISO 529	2BX		2.5XD	HSS		C 2-3					P N	E523	No.4 - 3/8	298

Spectrum™ Tap

UNC	ISO 529	2BX		2.5XD	HSS		C 2-3			CrN		P M N S	E596	No.4 - 3/8	300
UNC	ANSI	2B		2.5XD	HSS-PM		C 2-3					P N	E074	No.10 - 3/8	302
UNF	DIN ANSI	2B		3XD	HSS-PM		C 2-3			TiN		P M N S	E893	No.10 - 1"	304
UNF	ISO 529	2BX		2.5XD	HSS		C 2-3					P N	E530	No.10 - 7/16	306
EGM Insert	DIN 40435	6H mod.		3XD	HSS-E		C 2-3.5			TiN		P M N S	E323	M3 - M12	308

M | DIN 371≤10 376≥12 | 6HX | 3XD | HSS-E-PM | B 3.5-5 | Cool TOP

EP03P

- M Strojní závitník CoroTap™ P lamač třísek, přímá drážka
- M Gépi Menetfúró CoroTap™ P Terelőéles
- M Gwintowniki maszynowe CoroTap™ P ze skośną powierzchnią natarcia
- M Tarozi de masina CoroTap™ P Varf spiral
- M Машинные метчики CoroTap™ P Криволинейная задняя поверхность
- M Machine CoroTap™ P Spiral Point

CoroTap™ 210 P

P	
P 1	24-54
P 2	17-36
P 3	17-36
P 4	24-54
P 5	17-36
Vc[m/min]	

Din EN C45/ 1.0503/ AISI 1045/ SS1650
MC-code: P1.2.Z.AN
220 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
P1	M1.6	0.35	55	10950	3833	M1.6	0.35	45	8952	3133	M1.6	0.35	38	7658	2680
	M2	0.40	55	8760	3504	M2	0.40	45	7162	2865	M2	0.40	38	6126	2450
	M3	0.5	55	5840	2920.0	M3	0.5	45	4775	2387.5	M3	0.5	38	4084	2042
	M4	0.7	55	4380	3066.0	M4	0.7	45	3581	2506.7	M4	0.7	38	3063	2144.1
	M5	0.8	55	3504	2803.2	M5	0.8	45	2865	2292.0	M5	0.8	38	2451	1960.8
	M6	1	55	2920	2920.0	M6	1	45	2387	2387.0	M6	1	38	2042	2042.0
	M8	1.25	55	2190	2737.5	M8	1.25	45	1790	2237.5	M8	1.25	38	1532	1915.0
	M10	1.5	55	1752	2628.0	M10	1.5	45	1432	2148.0	M10	1.5	38	1225	1837.5
	M12	1.75	55	1460	2555.0	M12	1.75	45	1194	2089.5	M12	1.75	38	1021	1786.8
	M16	2	48	962	1924.0	M16	2	40	787	1574.0	M16	2	34	673	1346.0
	M20	2.5	44	696	1740.0	M20	2.5	36	569	1422.5	M20	2.5	31	487	1217.5
	M24	3	40	534	1602.0	M24	3	33	437	1311.0	M24	3	28	374	1122.0
	M30	3	36	387	1161.0	M30	3	30	316	948.0	M30	3	25	270	810.0

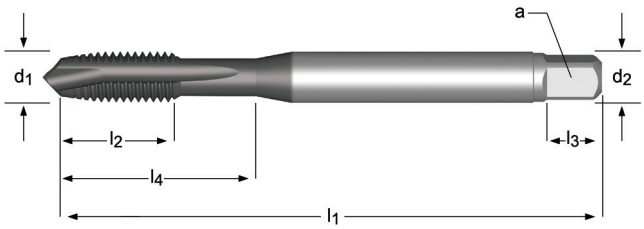
Din EN 42CrMo4/ 1.7225/ SS2244
MC-code: P2.2.Z.AN
241 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
P2	M1.6	0.35	37	7300	2555	M1.6	0.35	30	5968	2089	M1.6	0.35	26	5105	1787
	M2	0.40	37	5840	2336	M2	0.40	30	4775	1910	M2	0.40	26	4084	1634
	M3	0.5	37	3893	1946.5	M3	0.5	30	3183	1591.5	M3	0.5	26	2723	1361.5
	M4	0.7	37	2920	2044.0	M4	0.7	30	2387	1670.9	M4	0.7	26	2042	1429.4
	M5	0.8	37	2336	1868.8	M5	0.8	30	1910	1528.0	M5	0.8	26	1634	1307.2
	M6	1	37	1947	1947.0	M6	1	30	1592	1592.0	M6	1	26	1361	1361.0
	M8	1.25	37	1460	1825.0	M8	1.25	30	1194	1492.5	M8	1.25	26	1021	1276.3
	M10	1.5	37	1168	1752.0	M10	1.5	30	955	1432.5	M10	1.5	26	817	1225.5
	M12	1.75	37	973	1702.8	M12	1.75	30	796	1393.0	M12	1.75	26	681	1191.8
	M16	2	32	641	1282.0	M16	2	26	524	1048.0	M16	2	23	449	898.0
	M20	2.5	29	464	1160.0	M20	2.5	24	379	947.5	M20	2.5	20	325	812.5
	M24	3	27	356	1068.0	M24	3	22	291	873.0	M24	3	19	249	747.0
	M30	3	24	258	774.0	M30	3	20	211	633.0	M30	3	17	180	540.0

1.2344/ AISI H13/ SS2242
MC-code: P3.0.Z.AN
235 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
P3	M1.6	0.35	37	7300	2555	M1.6	0.35	30	5968	2089	M1.6	0.35	26	5105	1787
	M2	0.40	37	5840	2336	M2	0.40	30	4775	1910	M2	0.40	26	4084	1634
	M3	0.5	37	3893	1946.5	M3	0.5	30	3183	1591.5	M3	0.5	26	2723	1361.5
	M4	0.7	37	2920	2044.0	M4	0.7	30	2387	1670.9	M4	0.7	26	2042	1429.4
	M5	0.8	37	2336	1868.8	M5	0.8	30	1910	1528.0	M5	0.8	26	1634	1307.2
	M6	1	37	1947	1947.0	M6	1	30	1592	1592.0	M6	1	26	1361	1361.0
	M8	1.25	37	1460	1825.0	M8	1.25	30	1194	1492.5	M8	1.25	26	1021	1276.3
	M10	1.5	37	1168	1752.0	M10	1.5	30	955	1432.5	M10	1.5	26	817	1225.5
	M12	1.75	37	973	1702.8	M12	1.75	30	796	1393.0	M12	1.75	26	681	1191.8
	M16	2	32	641	1282.0	M16	2	26	524	1048.0	M16	2	23	449	898.0
	M20	2.5	29	464	1160.0	M20	2.5	24	379	947.5	M20	2.5	20	325	812.5
	M24	3	27	356	1068.0	M24	3	22	291	873.0	M24	3	19	249	747.0
	M30	3	24	258	774.0	M30	3	20	211	633.0	M30	3	17	180	540.0

EP03P



M	P mm	l_1 mm	l_2 mm	d_2 Ø mm	◪ a mm	l_3 mm	z	↔	l_4 mm	e-Code
1	0.25	40	5	2.5	2.1	5	2	0.75		**EP03PM1**
1.2	0.25	40	5	2.5	2.1	5	2	0.95		**EP03PM1.2**
1.4	0.30	40	6.5	2.5	2.1	5	2	1.1		**EP03PM1.4**
1.6	0.35	40	7	2.5	2.1	5	2	1.25		**EP03PM1.6**
1.8	0.35	40	7	2.5	2.1	5	2	1.45		**EP03PM1.8**
2	0.40	45	6	2.8	2.1	5	2	1.6	9	**EP03PM2**
2.2	0.45	45	7	2.8	2.1	5	2	1.75	12	**EP03PM2.2**
2.3	0.40	45	7	2.8	2.1	5	2	1.85	12	**EP03PM2.3**
2.5	0.45	50	8	2.8	2.1	5	2	2.05	12.5	**EP03PM2.5**
2.6	0.45	50	8	2.8	2.1	5	2	2.15	12.5	**EP03PM2.6**
3	0.50	56	9	3.5	2.7	6	3	2.5	18	**EP03PM3**
3.5	0.60	56	11	4.0	3.0	6	3	2.9	20	**EP03PM3.5**
4	0.70	63	12	4.5	3.4	6	3	3.3	21	**EP03PM4**
4	0.70	63	12	2.8	2.1	5	3	3.3		**EP03PM4DIN376**
5	0.80	70	13	6.0	4.9	8	3	4.2	25	**EP03PM5**
5	0.80	70	13	3.5	2.7	6	3	4.2		**EP03PM5DIN376**
6	1.00	80	15	6.0	4.9	8	3	5	30	**EP03PM6**
6	1.00	80	15	4.5	3.4	6	3	5		**EP03PM6DIN376**
7	1.00	80	15	7.0	5.5	8	3	6	30	**EP03PM7**
8	1.25	90	18	8.0	6.2	9	3	6.8	35	**EP03PM8**
8	1.25	90	18	6.0	4.9	8	3	6.8		**EP03PM8DIN376**
10	1.50	100	20	10.0	8.0	11	3	8.5	39	**EP03PM10**
10	1.50	100	20	7.0	5.5	8	3	8.5		**EP03PM10DIN376**
12	1.75	110	23	9.0	7.0	10	4	10.3		**EP03PM12**
14	2.00	110	25	11.0	9.0	12	4	12		**EP03PM14**
16	2.00	110	25	12.0	9.0	12	4	14		**EP03PM16**
18	2.50	125	30	14.0	11.0	14	4	15.5		**EP03PM18**
20	2.50	140	30	16.0	12.0	15	4	17.5		**EP03PM20**
22	2.50	140	34	18.0	14.5	17	4	19.5		**EP03PM22**
24	3.00	160	38	18.0	14.5	17	4	21		**EP03PM24**
27	3.00	160	38	20.0	16.0	19	4	24		**EP03PM27**
30	3.50	180	45	22.0	18.0	21	4	26.5		**EP03PM30**

M | DIN 371≤10 376≥12 | 6HX | 3XD | HSS-E-PM | B 3.5-5 | Cool TOP

EP09P

- M Strojní závitník CoroTap™ P lamač třísek, přímá drážka
- M Gépi Menetfúró CoroTap™ P Terelőéles
- M Gwintowniki maszynowe CoroTap™ P ze skośną powierzchnią natarcia
- M Tarozi de masina CoroTap™ P Varf spiral
- M Машинные метчики CoroTap™ P Криволинейная задняя поверхность
- M Machine CoroTap™ P Spiral Point

CoroTap™ 210 P

P	
P 1	32-54
P 2	28-48
P 3	28-48
P 4	32-54
P 5	28-48
Vc[m/min]	

Din EN C45/ 1.0503/ AISI 1045/ SS1650
MC-code: P1.2.Z.AN
220 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
P1	M1.6	0.35	55	10950	3833	M1.6	0.35	45	8952	3133	M1.6	0.35	38	7658	2680
	M2	0.40	55	8760	3504	M2	0.40	45	7162	2865	M2	0.40	38	6126	2450
	M3	0.5	55	5840	2920.0	M3	0.5	45	4775	2387.5	M3	0.5	38	4084	2042
	M4	0.7	55	4380	3066.0	M4	0.7	45	3581	2506.7	M4	0.7	38	3063	2144.1
	M5	0.8	55	3504	2803.2	M5	0.8	45	2865	2292.0	M5	0.8	38	2451	1960.8
	M6	1	55	2920	2920.0	M6	1	45	2387	2387.0	M6	1	38	2042	2042.0
	M8	1.25	55	2190	2737.5	M8	1.25	45	1790	2237.5	M8	1.25	38	1532	1915.0
	M10	1.5	55	1752	2628.0	M10	1.5	45	1432	2148.0	M10	1.5	38	1225	1837.5
	M12	1.75	55	1460	2555.0	M12	1.75	45	1194	2089.5	M12	1.75	38	1021	1786.8
	M16	2	48	962	1924.0	M16	2	40	787	1574.0	M16	2	34	673	1346.0
	M20	2.5	44	696	1740.0	M20	2.5	36	569	1422.5	M20	2.5	31	487	1217.5
	M24	3	40	534	1602.0	M24	3	33	437	1311.0	M24	3	28	374	1122.0
	M30	3	36	387	1161.0	M30	3	30	316	948.0	M30	3	25	270	810.0

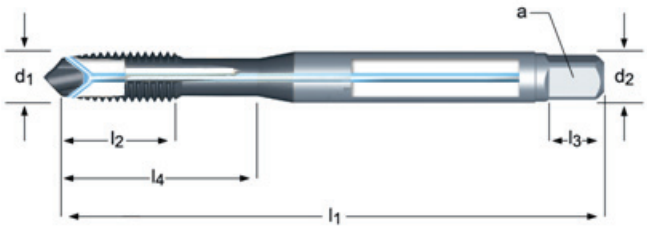
Din EN 42CrMo4/ 1.7225/ SS2244
MC-code: P2.2.Z.AN2
41 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
P2	M1.6	0.35	49	9733	3407	M1.6	0.35	40	7958	2785	M1.6	0.35	34	6807	2382
	M2	0.40	49	7786	3114	M2	0.40	40	6366	2546	M2	0.40	34	5446	2178
	M3	0.5	49	5191	2595.5	M3	0.5	40	4244	2122.0	M3	0.5	34	3630	1815.0
	M4	0.7	49	3893	2725.1	M4	0.7	40	3183	2228.1	M4	0.7	34	2723	1906.1
	M5	0.8	49	3115	2492.0	M5	0.8	40	2546	2036.8	M5	0.8	34	2178	1742.4
	M6	1	49	2595	2595.0	M6	1	40	2122	2122.0	M6	1	34	1815	1815.0
	M8	1.25	49	1947	2433.8	M8	1.25	40	1592	1990.0	M8	1.25	34	1361	1701.3
	M10	1.5	49	1557	2335.5	M10	1.5	40	1273	1909.5	M10	1.5	34	1089	1633.5
	M12	1.75	49	1298	2271.5	M12	1.75	40	1061	1856.8	M12	1.75	34	908	1589.0
	M16	2	43	855	1710.0	M16	2	35	699	1398.0	M16	2	30	598	1196.0
	M20	2.5	39	619	1547.5	M20	2.5	32	506	1265.0	M20	2.5	27	433	1082.5
	M24	3	36	475	1425.0	M24	3	29	388	1164.0	M24	3	25	332	996.0
	M30	3	32	344	1032.0	M30	3	26	281	843.0	M30	3	23	240	720.0

1.2344/ AISI H13/ SS2242
MC-code: P3.0.Z.AN
235 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
P3	M1.6	0.35	49	9733	3407	M1.6	0.35	40	7958	2785	M1.6	0.35	34	6807	2382
	M2	0.40	49	7786	3114	M2	0.40	40	6366	2546	M2	0.40	34	5446	2178
	M3	0.5	49	5191	2595.5	M3	0.5	40	4244	2122.0	M3	0.5	34	3630	1815.0
	M4	0.7	49	3893	2725.1	M4	0.7	40	3183	2228.1	M4	0.7	34	2723	1906.1
	M5	0.8	49	3115	2492.0	M5	0.8	40	2546	2036.8	M5	0.8	34	2178	1742.4
	M6	1	49	2595	2595.0	M6	1	40	2122	2122.0	M6	1	34	1815	1815.0
	M8	1.25	49	1947	2433.8	M8	1.25	40	1592	1990.0	M8	1.25	34	1361	1701.3
	M10	1.5	49	1557	2335.5	M10	1.5	40	1273	1909.5	M10	1.5	34	1089	1633.5
	M12	1.75	49	1298	2271.5	M12	1.75	40	1061	1856.8	M12	1.75	34	908	1589.0
	M16	2	43	855	1710.0	M16	2	35	699	1398.0	M16	2	30	598	1196.0
	M20	2.5	39	619	1547.5	M20	2.5	32	506	1265.0	M20	2.5	27	433	1082.5
	M24	3	36	475	1425.0	M24	3	29	388	1164.0	M24	3	25	332	996.0
	M30	3	32	344	1032.0	M30	3	26	281	843.0	M30	3	23	240	720.0

EP09P



M	P mm	l_1 mm	l_2 mm	d_2 Ø mm	◪ a mm	l_3 mm	z	↔	l_4 mm	e-Code
4	0.70	63	12	4.5	3.4	6	3	3.3	21	**EP09PM4**
5	0.80	70	13	6.0	4.9	8	3	4.2	25	**EP09PM5**
6	1.00	80	15	6.0	4.9	8	3	5	30	**EP09PM6**
7	1.00	80	15	7.0	5.5	8	3	6	30	**EP09PM7**
8	1.25	90	18	8.0	6.2	9	3	6.8	35	**EP09PM8**
10	1.50	100	20	10.0	8.0	11	3	8.5	39	**EP09PM10**
12	1.75	110	23	9.0	7.0	10	4	10.3		**EP09PM12**
14	2.00	110	25	11.0	9.0	12	4	12		**EP09PM14**
16	2.00	110	25	12.0	9.0	12	4	14		**EP09PM16**
18	2.50	125	30	14.0	11.0	14	4	15.5		**EP09PM18**
20	2.50	140	30	16.0	12.0	15	4	17.5		**EP09PM20**
22	2.50	140	34	18.0	14.5	17	4	19.5		**EP09PM22**
24	3.00	160	38	18.0	14.5	17	4	21		**EP09PM24**
27	3.00	160	38	20.0	16.0	19	4	24		**EP09PM27**
30	3.50	180	45	22.0	18.0	21	4	26.5		**EP09PM30**

M | DIN ANSI | 6HX | 3XD | HSS-E-PM | B 3.5-5 | Cool TOP

EP03PA

- M Strojní závitník CoroTap™ P lamač třísek, přímá drážka
- M Gépi Menetfúró CoroTap™ P Terelőéles
- M Gwintowniki maszynowe CoroTap™ P Ze skośną powierzchnią natarcia
- M Tarozi de masina CoroTap™ P Varf spiral
- M Машинные метчики CoroTap™ P Криволинейная задняя поверхность
- M Machine CoroTap™ P Spiral Point

CoroTap™ 210 P

P	
P 1	24-54
P 2	17-36
P 3	17-36
P 4	24-54
P 5	17-36
Vc[m/min]	

Din EN C45/ 1.0503/ AISI 1045/ SS1650
MC-code: P1.2.Z.AN
220 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
P1	M1.6	0.35	55	10950	3833	M1.6	0.35	45	8952	3133	M1.6	0.35	38	7658	2680
	M2	0.40	55	8760	3504	M2	0.40	45	7162	2865	M2	0.40	38	6126	2450
	M3	0.5	55	5840	2920.0	M3	0.5	45	4775	2387.5	M3	0.5	38	4084	2042
	M4	0.7	55	4380	3066.0	M4	0.7	45	3581	2506.7	M4	0.7	38	3063	2144.1
	M5	0.8	55	3504	2803.2	M5	0.8	45	2865	2292.0	M5	0.8	38	2451	1960.8
	M6	1	55	2920	2920.0	M6	1	45	2387	2387.0	M6	1	38	2042	2042.0
	M8	1.25	55	2190	2737.5	M8	1.25	45	1790	2237.5	M8	1.25	38	1532	1915.0
	M10	1.5	55	1752	2628.0	M10	1.5	45	1432	2148.0	M10	1.5	38	1225	1837.5
	M12	1.75	55	1460	2555.0	M12	1.75	45	1194	2089.5	M12	1.75	38	1021	1786.8
	M16	2	48	962	1924.0	M16	2	40	787	1574.0	M16	2	34	673	1346.0
	M20	2.5	44	696	1740.0	M20	2.5	36	569	1422.5	M20	2.5	31	487	1217.5
	M24	3	40	534	1602.0	M24	3	33	437	1311.0	M24	3	28	374	1122.0
	M30	3	36	387	1161.0	M30	3	30	316	948.0	M30	3	25	270	810.0

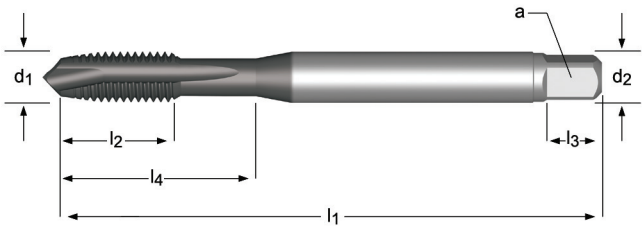
Din EN 42CrMo4/ 1.7225/ SS2244
MC-code: P2.2.Z.AN
241 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
P2	M1.6	0.35	37	7300	2555	M1.6	0.35	30	5968	2089	M1.6	0.35	26	5105	1787
	M2	0.40	37	5840	2336	M2	0.40	30	4775	1910	M2	0.40	26	4084	1634
	M3	0.5	37	3893	1946.5	M3	0.5	30	3183	1591.5	M3	0.5	26	2723	1361.5
	M4	0.7	37	2920	2044.0	M4	0.7	30	2387	1670.9	M4	0.7	26	2042	1429.4
	M5	0.8	37	2336	1868.8	M5	0.8	30	1910	1528.0	M5	0.8	26	1634	1307.2
	M6	1	37	1947	1947.0	M6	1	30	1592	1592.0	M6	1	26	1361	1361.0
	M8	1.25	37	1460	1825.0	M8	1.25	30	1194	1492.5	M8	1.25	26	1021	1276.3
	M10	1.5	37	1168	1752.0	M10	1.5	30	955	1432.5	M10	1.5	26	817	1225.5
	M12	1.75	37	973	1702.8	M12	1.75	30	796	1393.0	M12	1.75	26	681	1191.8
	M16	2	32	641	1282.0	M16	2	26	524	1048.0	M16	2	23	449	898.0
	M20	2.5	29	464	1160.0	M20	2.5	24	379	947.5	M20	2.5	20	325	812.5
	M24	3	27	356	1068.0	M24	3	22	291	873.0	M24	3	19	249	747.0
	M30	3	24	258	774.0	M30	3	20	211	633.0	M30	3	17	180	540.0

1.2344/ AISI H13/ SS2242
MC-code: P3.0.Z.AN
235 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
P3	M1.6	0.35	37	7300	2555	M1.6	0.35	30	5968	2089	M1.6	0.35	26	5105	1787
	M2	0.40	37	5840	2336	M2	0.40	30	4775	1910	M2	0.40	26	4084	1634
	M3	0.5	37	3893	1946.5	M3	0.5	30	3183	1591.5	M3	0.5	26	2723	1361.5
	M4	0.7	37	2920	2044.0	M4	0.7	30	2387	1670.9	M4	0.7	26	2042	1429.4
	M5	0.8	37	2336	1868.8	M5	0.8	30	1910	1528.0	M5	0.8	26	1634	1307.2
	M6	1	37	1947	1947.0	M6	1	30	1592	1592.0	M6	1	26	1361	1361.0
	M8	1.25	37	1460	1825.0	M8	1.25	30	1194	1492.5	M8	1.25	26	1021	1276.3
	M10	1.5	37	1168	1752.0	M10	1.5	30	955	1432.5	M10	1.5	26	817	1225.5
	M12	1.75	37	973	1702.8	M12	1.75	30	796	1393.0	M12	1.75	26	681	1191.8
	M16	2	32	641	1282.0	M16	2	26	524	1048.0	M16	2	23	449	898.0
	M20	2.5	29	464	1160.0	M20	2.5	24	379	947.5	M20	2.5	20	325	812.5
	M24	3	27	356	1068.0	M24	3	22	291	873.0	M24	3	19	249	747.0
	M30	3	24	258	774.0	M30	3	20	211	633.0	M30	3	17	180	540.0

EP03PA



M	P mm	l_1 mm	l_2 inch	d_2 Ø inch /	⧄ a inch	z	↔	↔	l_4 inch	EDP # or Stock No.	e-Code
3	0.50	56	0.3543	0.1410	0.1100	2	2.5	N40	0.6983	46093263	**EP03PAM3**
4	0.70	63	0.5118	0.1680	0.1310	3	3.30	N30	0.8337	46093264	**EP03PAM4**
5	0.80	70	0.5512	0.1940	0.1520	3	4.20	N19	1.0843	46093265	**EP03PAM5**
6	1.00	80	0.5906	0.2550	0.1910	3	5.00	N9	0.9681	46093266	**EP03PAM6**
8	1.25	90	0.7087	0.3180	0.2380	3	6.80	H	1.3060	46093267	**EP03PAM8**
10	1.50	100	0.7874	0.3810	0.2860	3	8.50	Q	1.4871	46093268	**EP03PAM10**
12	1.75	110	0.9060	0.3670	0.2750	4	10.30	Y		46093269	**EP03PAM12**
14	2.00	110	0.9060	0.4290	0.3220	4	12.00	15/32		46093270	**EP03PAM14**
16	2.00	110	0.9060	0.4800	0.3600	4	14.00	35/64		46093271	**EP03PAM16**
18	2.50	125	1.1810	0.5420	0.4060	4	15.50	39/64		46093272	**EP03PAM18**
20	2.50	140	1.4170	0.6520	0.4890	4	17.50	11/16		46093273	**EP03PAM20**
24	3.00	160	1.4170	0.7590	0.5670	4	21.0	53/64		46093274	**EP03PAM24**

M | ISO 529 | 6H | 2.5XD | HSS-PM | B 3.5-5 | Cool TOP

E049

- M Strojní závitník CoroTap™ P lamač třísek, přímá drážka
- M Gépi Menetfúró CoroTap™ P Terelőéles
- M Gwintowniki maszynowe CoroTap™ P ze skośną powierzchnią natarcia
- M Tarozi de masina CoroTap™ P Varf spiral
- M Машинные метчики CoroTap™ P Криволинейная задняя поверхность
- M Machine CoroTap™ P Spiral Point

CoroTap™ 200 P

P	
P 1	24-48
P 2	9-36
P 3	9-36
P 4	24-38
P 5	9-36
Vc[m/min]	

Din EN C45/ 1.0503/ AISI 1045/ SS1650 MC-code: P1.2.Z.AN 220 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
P1	M3	0.5	39	4153	2076.5	M3	0.5	32	3395	1697.5	M3	0.5	27	2904	1452.0
	M4	0.7	39	3115	2180.5	M4	0.7	32	2546	1782.2	M4	0.7	27	2178	1524.6
	M5	0.8	39	2492	1993.6	M5	0.8	32	2037	1629.6	M5	0.8	27	1743	1394.4
	M6	1	39	2076	2076.0	M6	1	32	1698	1698.0	M6	1	27	1452	1452.0
	M8	1.25	39	1557	1946.3	M8	1.25	32	1273	1591.3	M8	1.25	27	1089	1361.3
	M10	1.5	39	1246	1869.0	M10	1.5	32	1019	1528.5	M10	1.5	27	871	1306.5
	M12	1.75	39	1038	1816.5	M12	1.75	32	849	1485.8	M12	1.75	27	726	1270.5
	M16	2	34	684	1368.0	M16	2	28	559	1118.0	M16	2	24	478	956.0
	M20	2.5	31	495	1237.5	M20	2.5	25	405	1012.5	M20	2.5	22	346	865.0

Din EN 42CrMo4/ 1.7225/ SS2244 MC-code: P2.2.Z.AN 241 HB

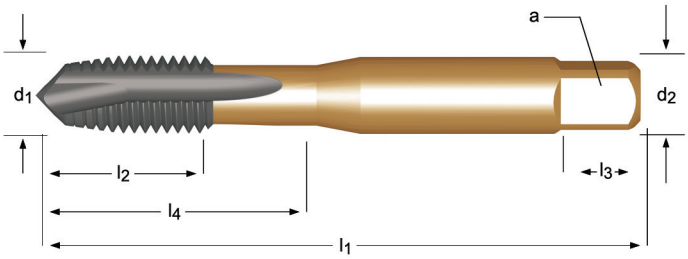
	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
P2	M3	0.5	27	2855	1427.5	M3	0.5	22	2334	1167.0	M3	0.5	19	1997	998.5
	M4	0.7	27	2141	1498.7	M4	0.7	22	1751	1225.7	M4	0.7	19	1498	1048.6
	M5	0.8	27	1713	1370.4	M5	0.8	22	1401	1120.8	M5	0.8	19	1198	958.4
	M6	1	27	1428	1428.0	M6	1	22	1167	1167.0	M6	1	19	998	998.0
	M8	1.25	27	1071	1338.8	M8	1.25	22	875	1093.8	M8	1.25	19	749	936.3
	M10	1.5	27	857	1285.5	M10	1.5	22	700	1050.0	M10	1.5	19	599	898.5
	M12	1.75	27	714	1249.5	M12	1.75	22	584	1022.0	M12	1.75	19	499	873.3
	M16	2	24	470	940.0	M16	2	19	385	770.0	M16	2	17	329	658.0
	M20	2.5	21	340	850.0	M20	2.5	17	278	695.0	M20	2.5	15	238	595.0

1.2344/ AISI H13/ SS2242 MC-code: P3.0.Z.AN 235 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
P3	M3	0.5	27	2855	1427.5	M3	0.5	22	2334	1167.0	M3	0.5	19	1997	998.5
	M4	0.7	27	2141	1498.7	M4	0.7	22	1751	1225.7	M4	0.7	19	1498	1048.6
	M5	0.8	27	1713	1370.4	M5	0.8	22	1401	1120.8	M5	0.8	19	1198	958.4
	M6	1	27	1428	1428.0	M6	1	22	1167	1167.0	M6	1	19	998	998.0
	M8	1.25	27	1071	1338.8	M8	1.25	22	875	1093.8	M8	1.25	19	749	936.3
	M10	1.5	27	857	1285.5	M10	1.5	22	700	1050.0	M10	1.5	19	599	898.5
	M12	1.75	27	714	1249.5	M12	1.75	22	584	1022.0	M12	1.75	19	499	873.3
	M16	2	24	470	940.0	M16	2	19	385	770.0	M16	2	17	329	658.0
	M20	2.5	21	340	850.0	M20	2.5	17	278	695.0	M20	2.5	15	238	595.0

E049

P



M	P mm	l_1 mm	l_2 mm	d_2 Ø mm	a mm	l_3 mm	z	↔	l_4 mm	e-Code
3	0.50	48	12.5	3.15	2.50	5	3	2.5	12.5	**E049M3**
4	0.70	53	14	4.00	3.15	6	3	3.3	14	**E049M4**
5	0.80	58	11	5.00	4.00	7	3	4.2	22	**E049M5**
6	1.00	66	13	6.30	5.00	8	3	5.0	26	**E049M6**
8	1.25	72	16	8.00	6.30	9	3	6.8	29	**E049M8**
10	1.50	80	18	10.00	8.00	11	3	8.5	34	**E049M10**
12	1.75	89	22	9.00	7.10	10	3	10.3		**E049M12**
16	2.00	102	24	12.50	10.00	13	3	14.0		**E049M16**
20	2.50	112	29	14.00	11.20	14	4	17.5		**E049M20**

M | DIN 371≤10 376≥12 | 6HX | 3XD | HSS-E-PM | C 2-3 | λ48° | Cool TOP

EX03P

- M Strojní závitník CoroTap™ P, zpětný kužel a šroubovitá drážka 48°
- M Gépi Menetfúró CoroTap™ P Csavart hornyú 48°
- M Gwintowniki maszynowe CoroTap™ P, zbieżny nakrój, śrubowy rowek wiórowy 48°
- M Tarozi de masina CoroTap™ P Canal elicoidal 48°
- M CoroTap™ P Спиральная стружечная канавка 48°
- M Machine CoroTap™ P, back tapered Spiral Flute 48°

CoroTap™ 370 P

P	
P 1	20-48
P 2	16-30
P 3	16-30
P 4	20-48
P 5	16-30
Vc[m/min]	

Din EN C45/ 1.0503/ AISI 1045/ SS1650
MC-code: P1.2.Z.AN
220 HB

P1	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	M1.6	0.35	49	9733	3407	M1.6	0.35	40	7958	2785	M1.6	0.35	34	6807	2382
	M2	0.40	49	7786	3114	M2	0.40	40	6366	2546	M2	0.40	34	5446	2178
	M3	0.5	49	5191	2595.5	M3	0.5	40	4244	2122.0	M3	0.5	34	3630	1815
	M4	0.7	49	3893	2725.1	M4	0.7	40	3183	2228.1	M4	0.7	34	2723	1906.1
	M5	0.8	49	3115	2492.0	M5	0.8	40	2546	2036.8	M5	0.8	34	2178	1742.4
	M6	1	49	2595	2595.0	M6	1	40	2122	2122.0	M6	1	34	1815	1815.0
	M8	1.25	49	1947	2433.8	M8	1.25	40	1592	1990.0	M8	1.25	34	1361	1701.3
	M10	1.5	49	1557	2335.5	M10	1.5	40	1273	1909.5	M10	1.5	34	1089	1633.5
	M12	1.75	49	1298	2271.5	M12	1.75	40	1061	1856.8	M12	1.75	34	908	1589.0
	M16	2	43	855	1710.0	M16	2	35	699	1398.0	M16	2	30	598	1196.0
	M20	2.5	39	619	1547.5	M20	2.5	32	506	1265.0	M20	2.5	27	433	1082.5
	M24	3	36	475	1425.0	M24	3	29	388	1164.0	M24	3	25	332	996.0
	M30	3	32	344	1032.0	M30	3	26	281	843.0	M30	3	23	240	720.0

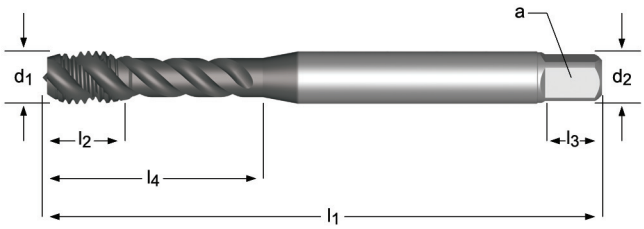
Din EN 42CrMo4/ 1.7225/ SS2244
MC-code: P2.2.Z.AN
241 HB

P2	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	M1.6	0.35	31	6083	2129	M1.6	0.35	25	4974	1741	M1.6	0.35	21	4254	1489
	M2	0.40	31	4867	1947	M2	0.40	25	3979	1592	M2	0.40	21	3403	1361
	M3	0.5	31	3244	1622.0	M3	0.5	25	2653	1326.5	M3	0.5	21	2269	1134.5
	M4	0.7	31	2433	1703.1	M4	0.7	25	1989	1392.3	M4	0.7	21	1702	1191.4
	M5	0.8	31	1947	1557.6	M5	0.8	25	1592	1273.6	M5	0.8	21	1361	1088.8
	M6	1	31	1622	1622.0	M6	1	25	1326	1326.0	M6	1	21	1134	1134.0
	M8	1.25	31	1217	1521.3	M8	1.25	25	995	1243.8	M8	1.25	21	851	1063.8
	M10	1.5	31	973	1459.5	M10	1.5	25	796	1194.0	M10	1.5	21	681	1021.5
	M12	1.75	31	811	1419.3	M12	1.75	25	663	1160.3	M12	1.75	21	567	992.3
	M16	2	27	534	1068.0	M16	2	22	437	874.0	M16	2	19	374	748.0
	M20	2.5	24	387	967.5	M20	2.5	20	316	790.0	M20	2.5	17	270	675.0
	M24	3	22	297	891.0	M24	3	18	243	729.0	M24	3	16	208	624.0
	M30	3	20	215	645.0	M30	3	17	176	528.0	M30	3	14	150	450.0

1.2344/ AISI H13/ SS2242
MC-code: P3.0.Z.AN
235 HB

P3	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	M1.6	0.35	31	6083	2129	M1.6	0.35	25	4974	1741	M1.6	0.35	21	4254	1489
	M2	0.40	31	4867	1947	M2	0.40	25	3979	1592	M2	0.40	21	3403	1361
	M3	0.5	31	3244	1622.0	M3	0.5	25	2653	1326.5	M3	0.5	21	2269	1134.5
	M4	0.7	31	2433	1703.1	M4	0.7	25	1989	1392.3	M4	0.7	21	1702	1191.4
	M5	0.8	31	1947	1557.6	M5	0.8	25	1592	1273.6	M5	0.8	21	1361	1088.8
	M6	1	31	1622	1622.0	M6	1	25	1326	1326.0	M6	1	21	1134	1134.0
	M8	1.25	31	1217	1521.3	M8	1.25	25	995	1243.8	M8	1.25	21	851	1063.8
	M10	1.5	31	973	1459.5	M10	1.5	25	796	1194.0	M10	1.5	21	681	1021.5
	M12	1.75	31	811	1419.3	M12	1.75	25	663	1160.3	M12	1.75	21	567	992.3
	M16	2	27	534	1068.0	M16	2	22	437	874.0	M16	2	19	374	748.0
	M20	2.5	24	387	967.5	M20	2.5	20	316	790.0	M20	2.5	17	270	675.0
	M24	3	22	297	891.0	M24	3	18	243	729.0	M24	3	16	208	624.0
	M30	3	20	215	645.0	M30	3	17	176	528.0	M30	3	14	150	450.0

EX03P



M	P mm	l_1 mm	l_2 mm	d_2 Ø mm	◪ a mm	l_3 mm	z	↔	l_4 mm	e-Code
1.6	0.35	40	6	2.5	2.1	5	2	1.25		**EX03PM1.6**
2	0.40	45	4	2.8	2.1	5	3	1.6	9	**EX03PM2**
2.2	0.45	45	4	2.8	2.1	5	3	1.75	12	**EX03PM2.2**
2.3	0.40	45	4	2.8	2.1	5	3	1.85	12	**EX03PM2.3**
2.5	0.45	50	4	2.8	2.1	5	3	2.05	12.5	**EX03PM2.5**
2.6	0.45	50	4	2.8	2.1	5	3	2.15	12.5	**EX03PM2.6**
3	0.50	56	6	3.5	2.7	6	3	2.5	18	**EX03PM3**
3.5	0.60	56	7	4.0	3.0	6	3	2.9	20	**EX03PM3.5**
4	0.70	63	7	4.5	3.4	6	3	3.3	21	**EX03PM4**
5	0.80	70	8	6.0	4.9	8	3	4.2	25	**EX03PM5**
5	0.80	70	8	3.5	2.7	6	3	4.2		**EX03PM5DIN376**
6	1.00	80	10	6.0	4.9	8	3	5	30	**EX03PM6**
6	1.00	80	10	4.5	3.4	6	3	5		**EX03PM6DIN376**
7	1.00	80	10	7.0	5.5	8	3	6	31	**EX03PM7**
8	1.25	90	12	8.0	6.2	9	3	6.8	35	**EX03PM8**
8	1.25	90	13	6.0	4.9	8	3	6.8		**EX03PM8DIN376**
10	1.50	100	15	10.0	8.0	11	3	8.5	39	**EX03PM10**
10	1.50	100	15	7.0	5.5	8	3	8.5		**EX03PM10DIN376**
12	1.75	110	16	9.0	7.0	10	3	10.3		**EX03PM12**
14	2.00	110	20	11.0	9.0	12	3	12		**EX03PM14**
16	2.00	110	20	12.0	9.0	12	4	14		**EX03PM16**
18	2.50	125	25	14.0	11.0	14	4	15.5		**EX03PM18**
20	2.50	140	25	16.0	12.0	15	4	17.5		**EX03PM20**
22	2.50	140	25	18.0	14.5	17	4	19.5		**EX03PM22**
24	3.00	160	30	18.0	14.5	17	4	21		**EX03PM24**
27	3.00	160	30	20.0	16.0	19	4	24		**EX03PM27**
30	3.50	180	36	22.0	18.0	21	4	26.5		**EX03PM30**

M | DIN 371≤10 376≥12 | 6HX | 3XD | HSS-E-PM | C 2-3 | λ48° | Cool TOP

EX09P

- M Strojní závitník CoroTap™ P, zpětný kužel a šroubovitá drážka 48°
- M Gépi Menetfúró CoroTap™ P Csavart hornyú 48°
- M Gwintowniki maszynowe CoroTap™ P, zbieżny nakrój, śrubowy rowek wiórowy 48°
- M Tarozi de masina CoroTap™ P Canal elicoidal 48°
- M CoroTap™ P Спиральная стружечная канавка 48°
- M Machine CoroTap™ P, back tapered Spiral Flute 48°

CoroTap™ 370 P

P	
P 1	24-54
P 2	20-43
P 3	20-43
P 4	24-54
P 5	20-43
Vc[m/min]	

Din EN C45/ 1.0503/ AISI 1045/ SS1650
MC-code: P1.2.Z.AN
220 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
P1	M1.6	0.35	55	10950	3833	M1.6	0.35	45	8952	3133	M1.6	0.35	38	7658	2680
	M2	0.40	55	8760	3504	M2	0.40	45	7162	2865	M2	0.40	38	6126	2450
	M3	0.5	55	5840	2920.0	M3	0.5	45	4775	2387.5	M3	0.5	38	4084	2042
	M4	0.7	55	4380	3066.0	M4	0.7	45	3581	2506.7	M4	0.7	38	3063	2144.1
	M5	0.8	55	3504	2803.2	M5	0.8	45	2865	2292.0	M5	0.8	38	2451	1960.8
	M6	1	55	2920	2920.0	M6	1	45	2387	2387.0	M6	1	38	2042	2042.0
	M8	1.25	55	2190	2737.5	M8	1.25	45	1790	2237.5	M8	1.25	38	1532	1915.0
	M10	1.5	55	1752	2628.0	M10	1.5	45	1432	2148.0	M10	1.5	38	1225	1837.5
	M12	1.75	55	1460	2555.0	M12	1.75	45	1194	2089.5	M12	1.75	38	1021	1786.8
	M16	2	48	962	1924.0	M16	2	40	787	1574.0	M16	2	34	673	1346.0
	M20	2.5	44	696	1740.0	M20	2.5	36	569	1422.5	M20	2.5	31	487	1217.5
	M24	3	40	534	1602.0	M24	3	33	437	1311.0	M24	3	28	374	1122.0
	M30	3	36	387	1161.0	M30	3	30	316	948.0	M30	3	25	270	810.0

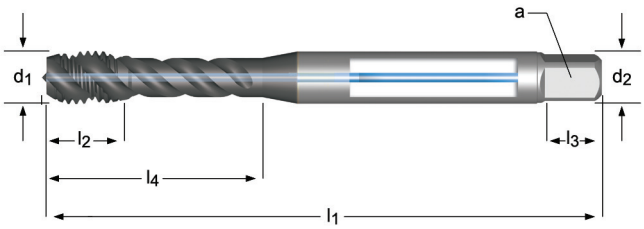
Din EN 42CrMo4/ 1.7225/ SS2244
MC-code: P2.2.Z.AN
241 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
P2	M1.6	0.35	43	8516	2981	M1.6	0.35	35	6963	2437	M1.6	0.35	30	5956	2085
	M2	0.40	43	6813	2725	M2	0.40	35	5570	2228	M2	0.40	30	4765	1906
	M3	0.5	43	4542	2271.0	M3	0.5	35	3714	1857.0	M3	0.5	30	3177	1588.5
	M4	0.7	43	3407	2384.9	M4	0.7	35	2785	1949.5	M4	0.7	30	2382	1667.4
	M5	0.8	43	2725	2180.0	M5	0.8	35	2228	1782.4	M5	0.8	30	1906	1524.8
	M6	1	43	2271	2271.0	M6	1	35	1857	1857.0	M6	1	30	1588	1588.0
	M8	1.25	43	1703	2128.8	M8	1.25	35	1393	1741.3	M8	1.25	30	1191	1488.8
	M10	1.5	43	1363	2044.5	M10	1.5	35	1114	1671.0	M10	1.5	30	953	1429.5
	M12	1.75	43	1136	1988.0	M12	1.75	35	928	1624.0	M12	1.75	30	794	1389.5
	M16	2	38	748	1496.0	M16	2	31	612	1224.0	M16	2	26	523	1046.0
	M20	2.5	34	541	1352.5	M20	2.5	28	443	1107.5	M20	2.5	24	379	947.5
	M24	3	31	416	1248.0	M24	3	26	340	1020.0	M24	3	22	291	873.0
	M30	3	28	301	903.0	M30	3	23	246	738.0	M30	3	20	210	630.0

1.2344/ AISI H13/ SS2242
MC-code: P3.0.Z.AN
235 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
P3	M1.6	0.35	43	8516	2981	M1.6	0.35	35	6963	2437	M1.6	0.35	30	5956	2085
	M2	0.40	43	6813	2725	M2	0.40	35	5570	2228	M2	0.40	30	4765	1906
	M3	0.5	43	4542	2271.0	M3	0.5	35	3714	1857.0	M3	0.5	30	3177	1588.5
	M4	0.7	43	3407	2384.9	M4	0.7	35	2785	1949.5	M4	0.7	30	2382	1667.4
	M5	0.8	43	2725	2180.0	M5	0.8	35	2228	1782.4	M5	0.8	30	1906	1524.8
	M6	1	43	2271	2271.0	M6	1	35	1857	1857.0	M6	1	30	1588	1588.0
	M8	1.25	43	1703	2128.8	M8	1.25	35	1393	1741.3	M8	1.25	30	1191	1488.8
	M10	1.5	43	1363	2044.5	M10	1.5	35	1114	1671.0	M10	1.5	30	953	1429.5
	M12	1.75	43	1136	1988.0	M12	1.75	35	928	1624.0	M12	1.75	30	794	1389.5
	M16	2	38	748	1496.0	M16	2	31	612	1224.0	M16	2	26	523	1046.0
	M20	2.5	34	541	1352.5	M20	2.5	28	443	1107.5	M20	2.5	24	379	947.5
	M24	3	31	416	1248.0	M24	3	26	340	1020.0	M24	3	22	291	873.0
	M30	3	28	301	903.0	M30	3	23	246	738.0	M30	3	20	210	630.0

EX09P



M	P mm	l_1 mm	l_2 mm	d_2 Ø mm	◪ a mm	l_3 mm	z	↔	l_4 mm	e-Code
4	0.70	63	7	4.5	3.4	6	3	3.3	21	**EX09PM4**
5	0.80	70	8	6.0	4.9	8	3	4.2	25	**EX09PM5**
6	1.00	80	10	6.0	4.9	8	3	5	31	**EX09PM6**
7	1.00	80	10	7.0	5.5	8	3	6	31	**EX09PM7**
8	1.25	90	12	8.0	6.2	9	3	6.8	35	**EX09PM8**
10	1.50	100	15	10.0	8.0	11	3	8.5	39	**EX09PM10**
12	1.75	110	16	9.0	7.0	10	3	10.3		**EX09PM12**
14	2.00	110	20	11.0	9.0	12	3	12		**EX09PM14**
16	2.00	110	20	12.0	9.0	12	4	14		**EX09PM16**
18	2.50	125	25	14.0	11.0	14	4	15.5		**EX09PM18**
20	2.50	140	25	16.0	12.0	15	4	17.5		**EX09PM20**
22	2.50	140	25	18.0	14.5	17	4	19.5		**EX09PM22**
24	3.00	160	30	18.0	14.5	17	4	21		**EX09PM24**
27	3.00	160	30	20.0	16.0	19	4	24		**EX09PM27**
30	3.50	180	36	22.0	18.0	21	4	26.5		**EX09PM30**

M | DIN ANSI | 6HX | 3XD | HSS-E-PM | C 2-3 | λ48° | Cool TOP

EX03PA

- M Strojní závitník CoroTap™ P, zpětný kužel a šroubovitá drážka 48°
- M Gépi Menetfúró CoroTap™ P Csavart hornyú 48°
- M Gwintowniki maszynowe CoroTap™ P, zbieżny nakrój, śrubowy rowek wiórowy 48°
- M Tarozi de masina CoroTap™ P Canal elicoidal 48°
- M CoroTap™ P Спиральная стружечная канавка 48°
- M Machine CoroTap™ P, back tapered Spiral Flute 48°

CoroTap™ 370 P

P	
P 1	20-48
P 2	16-30
P 3	16-30
P 4	20-48
P 5	16-30
Vc[m/min]	

Din EN C45/ 1.0503/ AISI 1045/ SS1650
MC-code: P1.2.Z.AN
220 HB

P1	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	M1.6	0.35	49	9733	3407	M1.6	0.35	40	7958	2785	M1.6	0.35	34	6807	2382
	M2	0.40	49	7786	3114	M2	0.40	40	6366	2546	M2	0.40	34	5446	2178
	M3	0.5	49	5191	2595.5	M3	0.5	40	4244	2122.0	M3	0.5	34	3630	1815
	M4	0.7	49	3893	2725.1	M4	0.7	40	3183	2228.1	M4	0.7	34	2723	1906.1
	M5	0.8	49	3115	2492.0	M5	0.8	40	2546	2036.8	M5	0.8	34	2178	1742.4
	M6	1	49	2595	2595.0	M6	1	40	2122	2122.0	M6	1	34	1815	1815.0
	M8	1.25	49	1947	2433.8	M8	1.25	40	1592	1990.0	M8	1.25	34	1361	1701.3
	M10	1.5	49	1557	2335.5	M10	1.5	40	1273	1909.5	M10	1.5	34	1089	1633.5
	M12	1.75	49	1298	2271.5	M12	1.75	40	1061	1856.8	M12	1.75	34	908	1589.0
	M16	2	43	855	1710.0	M16	2	35	699	1398.0	M16	2	30	598	1196.0
	M20	2.5	39	619	1547.5	M20	2.5	32	506	1265.0	M20	2.5	27	433	1082.5
	M24	3	36	475	1425.0	M24	3	29	388	1164.0	M24	3	25	332	996.0
	M30	3	32	344	1032.0	M30	3	26	281	843.0	M30	3	23	240	720.0

Din EN 42CrMo4/ 1.7225/ SS2244
MC-code: P2.2.Z.AN
241 HB

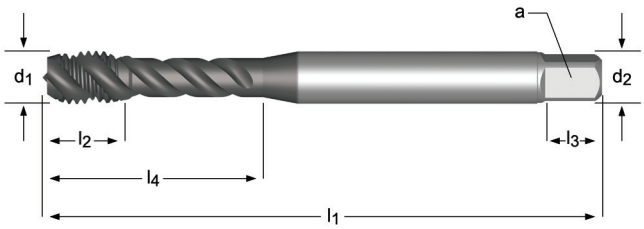
P2	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	M1.6	0.35	31	6083	2129	M1.6	0.35	25	4974	1741	M1.6	0.35	21	4254	1489
	M2	0.40	31	4867	1947	M2	0.40	25	3979	1592	M2	0.40	21	3403	1361
	M3	0.5	31	3244	1622.0	M3	0.5	25	2653	1326.5	M3	0.5	21	2269	1134.5
	M4	0.7	31	2433	1703.1	M4	0.7	25	1989	1392.3	M4	0.7	21	1702	1191.4
	M5	0.8	31	1947	1557.6	M5	0.8	25	1592	1273.6	M5	0.8	21	1361	1088.8
	M6	1	31	1622	1622.0	M6	1	25	1326	1326.0	M6	1	21	1134	1134.0
	M8	1.25	31	1217	1521.3	M8	1.25	25	995	1243.8	M8	1.25	21	851	1063.8
	M10	1.5	31	973	1459.5	M10	1.5	25	796	1194.0	M10	1.5	21	681	1021.5
	M12	1.75	31	811	1419.3	M12	1.75	25	663	1160.3	M12	1.75	21	567	992.3
	M16	2	27	534	1068.0	M16	2	22	437	874.0	M16	2	19	374	748.0
	M20	2.5	24	387	967.5	M20	2.5	20	316	790.0	M20	2.5	17	270	675.0
	M24	3	22	297	891.0	M24	3	18	243	729.0	M24	3	16	208	624.0
	M30	3	20	215	645.0	M30	3	17	176	528.0	M30	3	14	150	450.0

1.2344/ AISI H13/ SS2242
MC-code: P3.0.Z.AN
235 HB

P3	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	M1.6	0.35	31	6083	2129	M1.6	0.35	25	4974	1741	M1.6	0.35	21	4254	1489
	M2	0.40	31	4867	1947	M2	0.40	25	3979	1592	M2	0.40	21	3403	1361
	M3	0.5	31	3244	1622.0	M3	0.5	25	2653	1326.5	M3	0.5	21	2269	1134.5
	M4	0.7	31	2433	1703.1	M4	0.7	25	1989	1392.3	M4	0.7	21	1702	1191.4
	M5	0.8	31	1947	1557.6	M5	0.8	25	1592	1273.6	M5	0.8	21	1361	1088.8
	M6	1	31	1622	1622.0	M6	1	25	1326	1326.0	M6	1	21	1134	1134.0
	M8	1.25	31	1217	1521.3	M8	1.25	25	995	1243.8	M8	1.25	21	851	1063.8
	M10	1.5	31	973	1459.5	M10	1.5	25	796	1194.0	M10	1.5	21	681	1021.5
	M12	1.75	31	811	1419.3	M12	1.75	25	663	1160.3	M12	1.75	21	567	992.3
	M16	2	27	534	1068.0	M16	2	22	437	874.0	M16	2	19	374	748.0
	M20	2.5	24	387	967.5	M20	2.5	20	316	790.0	M20	2.5	17	270	675.0
	M24	3	22	297	891.0	M24	3	18	243	729.0	M24	3	16	208	624.0
	M30	3	20	215	645.0	M30	3	17	176	528.0	M30	3	14	150	450.0

EX03PA

P



M	P mm	l_1 mm	l_2 inch	d_2 Ø inch /	⧄ a inch	z			l_4 inch	EDP # or Stock No.	e-Code
3	0.50	56	0.2360	0.1410	0.1100	3	2.50	N40	0.6250	46093494	**EX03PAM3**
4	0.70	63	0.2756	0.1680	0.1310	3	3.30	N30	0.8337	46093495	**EX03PAM4**
5	0.80	70	0.3150	0.1940	0.1520	3	4.20	N19	1.0843	46093496	**EX03PAM5**
6	1.00	80	0.4213	0.2550	0.1910	3	5.00	N9	0.9799	46093497	**EX03PAM6**
8	1.25	90	0.4764	0.3180	0.2380	3	6.80	H	1.3060	46093498	**EX03PAM8**
10	1.50	100	0.5945	0.3810	0.2860	3	8.50	Q	1.4871	46093499	**EX03PAM10**
12	1.75	110	0.7090	0.3670	0.2750	3	10.30	Y		46093560	**EX03PAM12**
14	2.00	110	0.7870	0.4290	0.3220	3	12.00	15/32		46093561	**EX03PAM14**
16	2.00	110	1.0630	0.4800	0.3600	4	14.00	35/64		46093562	**EX03PAM16**
18	2.50	125	1.1810	0.5420	0.4060	4	15.80	5/8		46093563	**EX03PAM18**
20	2.50	140	1.1810	0.6520	0.4890	4	17.50	11/16		46093564	**EX03PAM20**
24	3.00	160	1.1810	0.7590	0.5670	4	21.0	53/64		46093565	**EX03PAM24**

M | ISO 529 | 6H | 2.5XD | HSS-PM | C 2-3 | λ45° | Cool TOP

E050

- M Strojní závitník CoroTap™ P, šroubovitá drážka 45°
- M Gépi Menetfúró CoroTap™ P Csavart hornyú 45°
- M Gwintowniki maszynowe CoroTap™ P, śrubowy rowek wiórowy 45°
- M Tarozi de masina CoroTap™ P Canal elicoidal 45°
- M Машинные метчики CoroTap™ P Спиральная стружечная канавка 45°
- M Machine CoroTap™ P Spiral Flute 45°

CoroTap™ 360 P

P	
P 1	24-48
P 2	9-36
P 3	9-36
P 4	24-38
P 5	9-36
Vc[m/min]	

Din EN C45/ 1.0503/ AISI 1045/ SS1650 MC-code: P1.2.Z.AN 220 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
P1	M3	0.5	39	4153	2076.5	M3	0.5	32	3395	1697.5	M3	0.5	27	2904	1452.0
	M4	0.7	39	3115	2180.5	M4	0.7	32	2546	1782.2	M4	0.7	27	2178	1524.6
	M5	0.8	39	2492	1993.6	M5	0.8	32	2037	1629.6	M5	0.8	27	1743	1394.4
	M6	1	39	2076	2076.0	M6	1	32	1698	1698.0	M6	1	27	1452	1452.0
	M8	1.25	39	1557	1946.3	M8	1.25	32	1273	1591.3	M8	1.25	27	1089	1361.3
	M10	1.5	39	1246	1869.0	M10	1.5	32	1019	1528.5	M10	1.5	27	871	1306.5
	M12	1.75	39	1038	1816.5	M12	1.75	32	849	1485.8	M12	1.75	27	726	1270.5
	M16	2	34	684	1368.0	M16	2	28	559	1118.0	M16	2	24	478	956.0
	M20	2.5	31	495	1237.5	M20	2.5	25	405	1012.5	M20	2.5	22	346	865.0

Din EN 42CrMo4/ 1.7225/ SS2244 MC-code: P2.2.Z.AN 241 HB

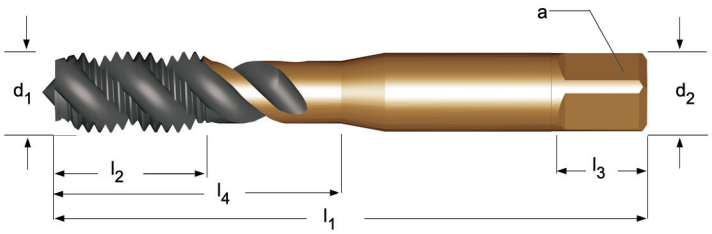
	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
P2	M3	0.5	27	2855	1427.5	M3	0.5	22	2334	1167.0	M3	0.5	19	1997	998.5
	M4	0.7	27	2141	1498.7	M4	0.7	22	1751	1225.7	M4	0.7	19	1498	1048.6
	M5	0.8	27	1713	1370.4	M5	0.8	22	1401	1120.8	M5	0.8	19	1198	958.4
	M6	1	27	1428	1428.0	M6	1	22	1167	1167.0	M6	1	19	998	998.0
	M8	1.25	27	1071	1338.8	M8	1.25	22	875	1093.8	M8	1.25	19	749	936.3
	M10	1.5	27	857	1285.5	M10	1.5	22	700	1050.0	M10	1.5	19	599	898.5
	M12	1.75	27	714	1249.5	M12	1.75	22	584	1022.0	M12	1.75	19	499	873.3
	M16	2	24	470	940.0	M16	2	19	385	770.0	M16	2	17	329	658.0
	M20	2.5	21	340	850.0	M20	2.5	17	278	695.0	M20	2.5	15	238	595.0

1.2344/ AISI H13/ SS2242 MC-code: P3.0.Z.AN 235 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
P3	M3	0.5	27	2855	1427.5	M3	0.5	22	2334	1167.0	M3	0.5	19	1997	998.5
	M4	0.7	27	2141	1498.7	M4	0.7	22	1751	1225.7	M4	0.7	19	1498	1048.6
	M5	0.8	27	1713	1370.4	M5	0.8	22	1401	1120.8	M5	0.8	19	1198	958.4
	M6	1	27	1428	1428.0	M6	1	22	1167	1167.0	M6	1	19	998	998.0
	M8	1.25	27	1071	1338.8	M8	1.25	22	875	1093.8	M8	1.25	19	749	936.3
	M10	1.5	27	857	1285.5	M10	1.5	22	700	1050.0	M10	1.5	19	599	898.5
	M12	1.75	27	714	1249.5	M12	1.75	22	584	1022.0	M12	1.75	19	499	873.3
	M16	2	24	470	940.0	M16	2	19	385	770.0	M16	2	17	329	658.0
	M20	2.5	21	340	850.0	M20	2.5	17	278	695.0	M20	2.5	15	238	595.0

E050

P



M	P mm	l_1 mm	l_2 mm	d_2 Ø mm	a mm	l_3 mm	z	↔	l_4 mm	e-Code
3	0.50	48	6	3.15	2.50	5	3	2.5	12.5	**E050M3**
4	0.70	53	7	4.00	3.15	6	3	3.3	19	**E050M4**
5	0.80	58	8	5.00	4.00	7	3	4.2	22	**E050M5**
6	1.00	66	10	6.30	5.00	8	3	5.0	27	**E050M6**
8	1.25	72	12	8.00	6.30	9	3	6.8	31	**E050M8**
10	1.50	80	15	10.00	8.00	11	3	8.5	35	**E050M10**
12	1.75	89	16	9.00	7.10	10	3	10.3		**E050M12**
16	2.00	102	18	12.50	10.00	13	4	14.0		**E050M16**
20	2.50	112	29	14.00	11.20	14	4	17.5		**E050M20**

M | ISO 529 | 6H | 2.5XD | HSS-PM | C 2-3 | λ45° | Cool TOP

E051

- M Strojní závitník CoroTap™ P, šroubovitá drážka 45°
- M Gépi Menetfúró CoroTap™ P Csavart hornyú 45°
- M Gwintowniki maszynowe CoroTap™ P, śrubowy rowek wiórowy 45°
- M Tarozi de masina CoroTap™ P Canal elicoidal 45°
- M Машинные метчики CoroTap™ P Спиральная стружечная канавка 45°
- M Machine CoroTap™ P Spiral Flute 45°

CoroTap™ 360 P

P	
P 1	24-48
P 2	9-36
P 3	9-36
P 4	24-38
P 5	9-36
Vc[m/min]	

Din EN C45/ 1.0503/ AISI 1045/ SS1650 MC-code: P1.2.Z.AN 220 HB

P1	↓ 1.5xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	M3	0.5	39	4153	2076.5
	M4	0.7	39	3115	2180.5
	M5	0.8	39	2492	1993.6
	M6	1	39	2076	2076.0
	M8	1.25	39	1557	1946.3
	M10	1.5	39	1246	1869.0
	M12	1.75	39	1038	1816.5
	M16	2	34	684	1368.0
	M20	2.5	31	495	1237.5

P1	↓ 2xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	M3	0.5	32	3395	1697.5
	M4	0.7	32	2546	1782.2
	M5	0.8	32	2037	1629.6
	M6	1	32	1698	1698.0
	M8	1.25	32	1273	1591.3
	M10	1.5	32	1019	1528.5
	M12	1.75	32	849	1485.8
	M16	2	28	559	1118.0
	M20	2.5	25	405	1012.5

P1	↓ 2.5xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	M3	0.5	27	2904	1452.0
	M4	0.7	27	2178	1524.6
	M5	0.8	27	1743	1394.4
	M6	1	27	1452	1452.0
	M8	1.25	27	1089	1361.3
	M10	1.5	27	871	1306.5
	M12	1.75	27	726	1270.5
	M16	2	24	478	956.0
	M20	2.5	22	346	865.0

Din EN 42CrMo4/ 1.7225/ SS2244 MC-code: P2.2.Z.AN 241 HB

P2	↓ 1.5xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	M3	0.5	27	2855	1427.5
	M4	0.7	27	2141	1498.7
	M5	0.8	27	1713	1370.4
	M6	1	27	1428	1428.0
	M8	1.25	27	1071	1338.8
	M10	1.5	27	857	1285.5
	M12	1.75	27	714	1249.5
	M16	2	24	470	940.0
	M20	2.5	21	340	850.0

P2	↓ 2xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	M3	0.5	22	2334	1167.0
	M4	0.7	22	1751	1225.7
	M5	0.8	22	1401	1120.8
	M6	1	22	1167	1167.0
	M8	1.25	22	875	1093.8
	M10	1.5	22	700	1050.0
	M12	1.75	22	584	1022.0
	M16	2	19	385	770.0
	M20	2.5	17	278	695.0

P2	↓ 2.5xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	M3	0.5	19	1997	998.5
	M4	0.7	19	1498	1048.6
	M5	0.8	19	1198	958.4
	M6	1	19	998	998.0
	M8	1.25	19	749	936.3
	M10	1.5	19	599	898.5
	M12	1.75	19	499	873.3
	M16	2	17	329	658.0
	M20	2.5	15	238	595.0

1.2344/ AISI H13/ SS2242 MC-code: P3.0.Z.AN 235 HB

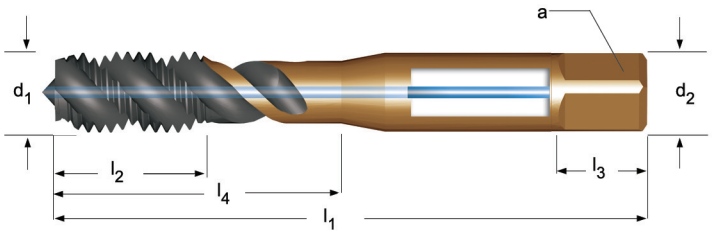
P3	↓ 1.5xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	M3	0.5	27	2855	1427.5
	M4	0.7	27	2141	1498.7
	M5	0.8	27	1713	1370.4
	M6	1	27	1428	1428.0
	M8	1.25	27	1071	1338.8
	M10	1.5	27	857	1285.5
	M12	1.75	27	714	1249.5
	M16	2	24	470	940.0
	M20	2.5	21	340	850.0

P3	↓ 2xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	M3	0.5	22	2334	1167.0
	M4	0.7	22	1751	1225.7
	M5	0.8	22	1401	1120.8
	M6	1	22	1167	1167.0
	M8	1.25	22	875	1093.8
	M10	1.5	22	700	1050.0
	M12	1.75	22	584	1022.0
	M16	2	19	385	770.0
	M20	2.5	17	278	695.0

P3	↓ 2.5xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	M3	0.5	19	1997	998.5
	M4	0.7	19	1498	1048.6
	M5	0.8	19	1198	958.4
	M6	1	19	998	998.0
	M8	1.25	19	749	936.3
	M10	1.5	19	599	898.5
	M12	1.75	19	499	873.3
	M16	2	17	329	658.0
	M20	2.5	15	238	595.0

E051

P



M	P mm	l_1 mm	l_2 mm	d_2 Ø mm	⧄ a mm	l_3 mm	z	↔	l_4 mm	e-Code
6	1.00	66	10	6.30	5.00	8	3	5	27	**E051M6**
8	1.25	72	12	8.00	6.30	9	3	6.8	31	**E051M8**
10	1.50	80	15	10.0	8.00	11	3	8.5	35	**E051M10**
12	1.75	89	16	9.00	7.10	10	3	10.3		**E051M12**
16	2.00	102	18	12.50	10.00	13	4	14		**E051M16**
20	2.50	112	29	14.00	11.20	14	4	17.5		**E051M20**

MF | DIN 374 | 6HX | 3XD | HSS-E-PM | B 3.5-5 | Cool TOP

EP13P

- MF Strojní závitník CoroTap™ P lamač třísek, přímá drážka
- MF Gépi Menetfúró CoroTap™ P Terelőéles
- MF Gwintowniki maszynowe CoroTap™ P, ze skośną powierzchnią natarcia
- MF Tarozi de masina CoroTap™ P Varf spiral
- MF Машинные метчики CoroTap™ P Криволинейная задняя поверхность
- MF Machine CoroTap™ P Spiral Point

CoroTap™ 210 P

P	
P 1	24-54
P 2	20-36
P 3	20-36
P 4	24-54
P 5	20-36
Vc[m/min]	

Din EN C45/ 1.0503/ AISI 1045/ SS1650
MC-code: P1.2.Z.AN
220 HB

P1	↓ 1.5xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	6	0.75	55	2920	2190.0
	8	1	55	2190	2190.0
	10	1	55	1752	1752.0
	10	1.25	55	1752	2190.0
	12	1	55	1460	1460.0
	12	1.25	55	1460	1825.0
	12	1.5	55	1460	2190.0
	14	1.5	51	1168	1752.0
	16	1.5	48	962	1443.0
	18	1.5	46	811	1216.5
	20	1.5	44	696	1044.0

P1	↓ 2xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	6	0.75	45	2387	1790.3
	8	1	45	1790	1790.0
	10	1	45	1432	1432.0
	10	1.25	45	1432	1790.0
	12	1	45	1194	1194.0
	12	1.25	45	1194	1492.5
	12	1.5	45	1194	1791.0
	14	1.5	42	955	1432.5
	16	1.5	40	787	1180.5
	18	1.5	37	663	994.5
	20	1.5	36	569	853.5

P1	↓ 2.5xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	6	0.75	38	2042	1531.5
	8	1	38	1532	1532.0
	10	1	38	1225	1225.0
	10	1.25	38	1225	1531.3
	12	1	38	1021	1021.0
	12	1.25	38	1021	1276.3
	12	1.5	38	1021	1531.5
	14	1.5	36	817	1225.5
	16	1.5	34	673	1009.5
	18	1.5	32	567	850.5
	20	1.5	31	487	730.5

Din EN 42CrMo4/ 1.7225/ SS2244
MC-code: P2.2.Z.AN
241 HB

P2	↓ 1.5xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	6	0.75	37	1947	1460.3
	8	1	37	1460	1460.0
	10	1	37	1168	1168.0
	10	1.25	37	1168	1460.0
	12	1	37	973	973.0
	12	1.25	37	973	1216.3
	12	1.5	37	973	1459.5
	14	1.5	34	778	1167.0
	16	1.5	32	641	961.5
	18	1.5	31	541	811.5
	20	1.5	29	464	696.0

P2	↓ 2xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	6	0.75	30	1592	1194.0
	8	1	30	1194	1194.0
	10	1	30	955	955.0
	10	1.25	30	955	1193.8
	12	1	30	796	796.0
	12	1.25	30	796	995.0
	12	1.5	30	796	1194.0
	14	1.5	28	636	954.0
	16	1.5	26	524	786.0
	18	1.5	25	442	663.0
	20	1.5	24	379	568.5

P2	↓ 2.5xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	6	0.75	26	1361	1020.8
	8	1	26	1021	1021.0
	10	1	26	817	817.0
	10	1.25	26	817	1021.3
	12	1	26	681	681.0
	12	1.25	26	681	851.3
	12	1.5	26	681	1021.5
	14	1.5	24	544	816.0
	16	1.5	23	449	673.5
	18	1.5	21	378	567.0
	20	1.5	20	325	487.5

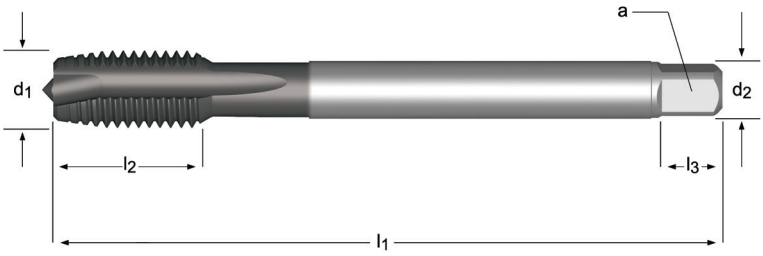
1.2344/ AISI H13/ SS2242
MC-code: P3.0.Z.AN
235 HB

P3	↓ 1.5xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	6	0.75	37	1947	1460.3
	8	1	37	1460	1460.0
	10	1	37	1168	1168.0
	10	1.25	37	1168	1460.0
	12	1	37	973	973.0
	12	1.25	37	973	1216.3
	12	1.5	37	973	1459.5
	14	1.5	34	778	1167.0
	16	1.5	32	641	961.5
	18	1.5	31	541	811.5
	20	1.5	29	464	696.0

P3	↓ 2xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	6	0.75	30	1592	1194.0
	8	1	30	1194	1194.0
	10	1	30	955	955.0
	10	1.25	30	955	1193.8
	12	1	30	796	796.0
	12	1.25	30	796	995.0
	12	1.5	30	796	1194.0
	14	1.5	28	636	954.0
	16	1.5	26	524	786.0
	18	1.5	25	442	663.0
	20	1.5	24	379	568.5

P3	↓ 2.5xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	6	0.75	26	1361	1020.8
	8	1	26	1021	1021.0
	10	1	26	817	817.0
	10	1.25	26	817	1021.3
	12	1	26	681	681.0
	12	1.25	26	681	851.3
	12	1.5	26	681	1021.5
	14	1.5	24	544	816.0
	16	1.5	23	449	673.5
	18	1.5	21	378	567.0
	20	1.5	20	325	487.5

EP13P



MF	P mm	l_1 mm	l_2 mm	d_2 Ø mm	a mm	l_3 mm	z	↔	e-Code
4	0.50	63	12	2.8	2.1	5	3	3.5	**EP13PM4X.5**
5	0.50	70	13	3.5	2.7	6	3	4.5	**EP13PM5X.5**
6	0.75	80	15	4.5	3.4	6	3	5.3	**EP13PM6X.75**
8	0.75	80	15	6.0	4.9	8	3	7.3	**EP13PM8X.75**
8	1.00	90	18	6.0	4.9	8	3	7	**EP13PM8X1.0**
10	0.75	90	18	7.0	5.5	8	3	9.3	**EP13PM10X.75**
10	1.00	90	18	7.0	5.5	8	3	9	**EP13PM10X1.0**
10	1.25	100	20	7.0	5.5	8	3	8.8	**EP13PM10X1.25**
12	1.00	100	21	9.0	7.0	10	4	11	**EP13PM12X1.0**
12	1.25	100	21	9.0	7.0	10	4	10.8	**EP13PM12X1.25**
12	1.50	100	21	9.0	7.0	10	4	10.5	**EP13PM12X1.5**
14	1.00	100	21	11.0	9.0	12	4	13	**EP13PM14X1.0**
14	1.25	100	21	11.0	9.0	12	4	13	**EP13PM14X1.25**
14	1.50	100	21	11.0	9.0	12	4	12.5	**EP13PM14X1.5**
16	1.00	100	21	12.0	9.0	12	4	15	**EP13PM16X1.0**
16	1.50	100	21	12.0	9.0	12	4	14.5	**EP13PM16X1.5**
18	1.00	110	24	14.0	11.0	14	4	17	**EP13PM18X1.0**
18	1.50	110	24	14.0	11.0	14	4	16.5	**EP13PM18X1.5**
20	1.00	125	24	16.0	12.0	15	4	19	**EP13PM20X1.0**
20	1.50	125	24	16.0	12.0	15	4	18.5	**EP13PM20X1.5**
22	1.50	125	25	18.0	14.5	17	4	20.5	**EP13PM22X1.5**
24	1.50	140	28	18.0	14.5	17	4	22.5	**EP13PM24X1.5**
24	2.00	140	28	18.0	14.5	17	4	22	**EP13PM24X2.0**
25	1.50	140	28	18.0	14.5	17	4	23.5	**EP13PM25X1.5**
26	1.50	140	28	18.0	14.5	17	4	24.5	**EP13PM26X1.5**
27	1.50	140	28	20.0	16.0	19	4	25.5	**EP13PM27X1.5**
27	2.00	140	28	20.0	16.0	19	4	25	**EP13PM27X2.0**
28	1.50	140	28	20.0	16.0	19	4	26.5	**EP13PM28X1.5**
30	1.50	150	28	22.0	18.0	21	4	28.5	**EP13PM30X1.5**
30	2.00	150	28	22.0	18.0	21	4	28	**EP13PM30X2.0**

MF | DIN ANSI | 6HX | 3XD | HSS-E-PM | B 3.5-5 | Cool TOP

EP13PA

- M Strojní závitník CoroTap™ P lamač třísek, přímá drážka
- M Gépi Menetfúró CoroTap™ P Terelőéles
- M Gwintowniki maszynowe CoroTap™ P ze skośną powierzchnią natarcia
- M Tarozi de masina CoroTap™ P Varf spiral
- M Машинные метчики CoroTap™ P Криволинейная задняя поверхность
- M Machine CoroTap™ P Spiral Point

CoroTap™ 210 P

P	
P 1	24-54
P 2	20-36
P 3	20-36
P 4	24-54
P 5	20-36
Vc[m/min]	

Din EN C45/ 1.0503/ AISI 1045/ SS1650
MC-code: P1.2.Z.AN
220 HB

P1	↓ 1.5xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	6	0.75	55	2920	2190.0
	8	1	55	2190	2190.0
	10	1	55	1752	1752.0
	10	1.25	55	1752	2190.0
	12	1	55	1460	1460.0
	12	1.25	55	1460	1825.0
	12	1.5	55	1460	2190.0
	14	1.5	51	1168	1752.0
	16	1.5	48	962	1443.0
	18	1.5	46	811	1216.5
	20	1.5	44	696	1044.0

P1	↓ 2xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	6	0.75	45	2387	1790.3
	8	1	45	1790	1790.0
	10	1	45	1432	1432.0
	10	1.25	45	1432	1790.0
	12	1	45	1194	1194.0
	12	1.25	45	1194	1492.5
	12	1.5	45	1194	1791.0
	14	1.5	42	955	1432.5
	16	1.5	40	787	1180.5
	18	1.5	37	663	994.5
	20	1.5	36	569	853.5

P1	↓ 2.5xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	6	0.75	38	2042	1531.5
	8	1	38	1532	1532.0
	10	1	38	1225	1225.0
	10	1.25	38	1225	1531.3
	12	1	38	1021	1021.0
	12	1.25	38	1021	1276.3
	12	1.5	38	1021	1531.5
	14	1.5	36	817	1225.5
	16	1.5	34	673	1009.5
	18	1.5	32	567	850.5
	20	1.5	31	487	730.5

Din EN 42CrMo4/ 1.7225/ SS2244
MC-code: P2.2.Z.AN
241 HB

P2	↓ 1.5xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	6	0.75	37	1947	1460.3
	8	1	37	1460	1460.0
	10	1	37	1168	1168.0
	10	1.25	37	1168	1460.0
	12	1	37	973	973.0
	12	1.25	37	973	1216.3
	12	1.5	37	973	1459.5
	14	1.5	34	778	1167.0
	16	1.5	32	641	961.5
	18	1.5	31	541	811.5
	20	1.5	29	464	696.0

P2	↓ 2xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	6	0.75	30	1592	1194.0
	8	1	30	1194	1194.0
	10	1	30	955	955.0
	10	1.25	30	955	1193.8
	12	1	30	796	796.0
	12	1.25	30	796	995.0
	12	1.5	30	796	1194.0
	14	1.5	28	636	954.0
	16	1.5	26	524	786.0
	18	1.5	25	442	663.0
	20	1.5	24	379	568.5

P2	↓ 2.5xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	6	0.75	26	1361	1020.8
	8	1	26	1021	1021.0
	10	1	26	817	817.0
	10	1.25	26	817	1021.3
	12	1	26	681	681.0
	12	1.25	26	681	851.3
	12	1.5	26	681	1021.5
	14	1.5	24	544	816.0
	16	1.5	23	449	673.5
	18	1.5	21	378	567.0
	20	1.5	20	325	487.5

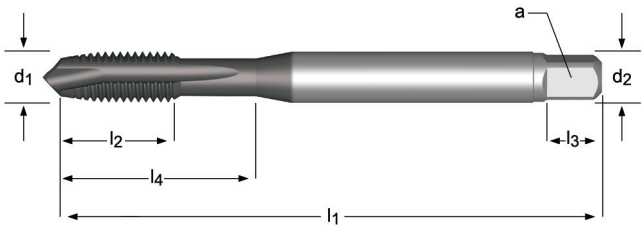
1.2344/ AISI H13/ SS2242
MC-code: P3.0.Z.AN
235 HB

P3	↓ 1.5xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	6	0.75	37	1947	1460.3
	8	1	37	1460	1460.0
	10	1	37	1168	1168.0
	10	1.25	37	1168	1460.0
	12	1	37	973	973.0
	12	1.25	37	973	1216.3
	12	1.5	37	973	1459.5
	14	1.5	34	778	1167.0
	16	1.5	32	641	961.5
	18	1.5	31	541	811.5
	20	1.5	29	464	696.0

P3	↓ 2xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	6	0.75	30	1592	1194.0
	8	1	30	1194	1194.0
	10	1	30	955	955.0
	10	1.25	30	955	1193.8
	12	1	30	796	796.0
	12	1.25	30	796	995.0
	12	1.5	30	796	1194.0
	14	1.5	28	636	954.0
	16	1.5	26	524	786.0
	18	1.5	25	442	663.0
	20	1.5	24	379	568.5

P3	↓ 2.5xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	6	0.75	26	1361	1020.8
	8	1	26	1021	1021.0
	10	1	26	817	817.0
	10	1.25	26	817	1021.3
	12	1	26	681	681.0
	12	1.25	26	681	851.3
	12	1.5	26	681	1021.5
	14	1.5	24	544	816.0
	16	1.5	23	449	673.5
	18	1.5	21	378	567.0
	20	1.5	20	325	487.5

EP13PA



MF	P mm	l_1 mm	l_2 inch	d_2 Ø inch /	⧄ a inch	z	↔	↔	l_4 inch	EDP # or Stock No.	e-Code
8	1.00	90	0.7087	0.3180	0.2380	3	7.00	J	1.3060	46093334	**EP13PAM8X1.0**
10	1.25	100	0.7874	0.3810	0.2860	3	8.75	S	1.4871	46093335	**EP13PAM10X1.25**
12	1.25	110	0.9060	0.3670	0.2750	4	10.80	27/64		46093336	**EP13PAM12X1.25**
12	1.50	110	0.9060	0.3670	0.2750	4	10.50	Z		46093337	**EP13PAM12X1.5**
14	1.50	110	0.9060	0.4290	0.3220	4	12.50	31/64		46093338	**EP13PAM14X1.5**
16	1.50	110	0.9060	0.4800	0.3600	4	14.50	37/64		46093339	**EP13PAM16X1.5**
18	1.50	125	1.1810	0.5420	0.4060	4	16.50	21/32		46093350	**EP13PAM18X1.5**

MF | DIN 374 | 6HX | 3XD | HSS-E-PM | C 2-3 | λ48° | Cool TOP

EX13P

- MF Strojní závitník CoroTap™ P, zpětný kužel a šroubovitá drážka 48°
- MF Gépi Menetfúró CoroTap™ P Csavart hornyú 48°
- MF Gwintowniki maszynowe CoroTap™ P, zbieżny nakrój, śrubowy rowek wiórowy 48°°
- MF Tarozi de masina CoroTap™ P Canal elicoidal 48°
- MF CoroTap™ P Спиральная стружечная канавка 48°
- MF Machine CoroTap™ P, back tapered Spiral Flute 48°

CoroTap™ 370 P

P	
P 1	20-48
P 2	16-30
P 3	16-30
P 4	20-48
P 5	16-30
Vc[m/min]	

Din EN C45/ 1.0503/ AISI 1045/ SS1650
MC-code: P1.2.Z.AN
220 HB

	↓ 1.5xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2.5xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
P1	6	0.75	49	2595	1946.3	6	0.75	40	2122	1591.5	6	0.75	34	1815	1361.3
	8	1	49	1947	1947.0	8	1	40	1592	1592.0	8	1	34	1361	1361.0
	10	1	49	1557	1557.0	10	1	40	1273	1273.0	10	1	34	1089	1089.0
	10	1.25	49	1557	1946.3	10	1.25	40	1273	1591.3	10	1.25	34	1089	1361.3
	12	1	49	1298	1298.0	12	1	40	1061	1061.0	12	1	34	908	908.0
	12	1.25	49	1298	1622.5	12	1.25	40	1061	1326.3	12	1.25	34	908	1135.0
	12	1.5	49	1298	1947.0	12	1.5	40	1061	1591.5	12	1.5	34	908	1362.0
	14	1.5	46	1038	1557.0	14	1.5	37	849	1273.5	14	1.5	32	726	1089.0
	16	1.5	43	855	1282.5	16	1.5	35	699	1048.5	16	1.5	30	598	897.0
	18	1.5	41	721	1081.5	18	1.5	33	589	883.5	18	1.5	29	504	756.0
	20	1.5	39	619	928.5	20	1.5	32	506	759.0	20	1.5	27	433	649.5

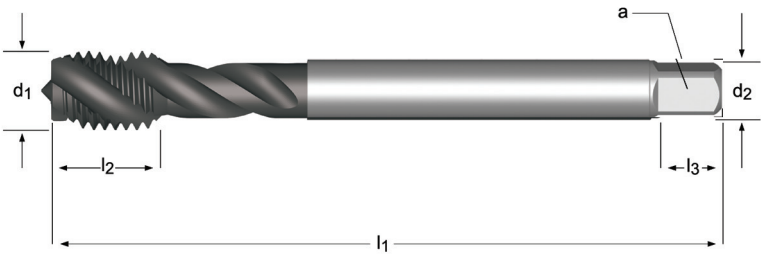
Din EN 42CrMo4/ 1.7225/ SS2244
MC-code: P2.2.Z.AN
241 HB

	↓ 1.5xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2.5xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
P2	6	0.75	31	1622	1216.5	6	0.75	25	1326	994.5	6	0.75	21	1134	850.5
	8	1	31	1217	1217.0	8	1	25	995	995.0	8	1	21	851	851.0
	10	1	31	973	973.0	10	1	25	796	796.0	10	1	21	681	681.0
	10	1.25	31	973	1216.3	10	1.25	25	796	995.0	10	1.25	21	681	851.3
	12	1	31	811	811.0	12	1	25	663	663.0	12	1	21	567	567.0
	12	1.25	31	811	1013.8	12	1.25	25	663	828.8	12	1.25	21	567	708.8
	12	1.5	31	811	1216.5	12	1.5	25	663	994.5	12	1.5	21	567	850.5
	14	1.5	29	649	973.5	14	1.5	23	530	795.0	14	1.5	20	454	681.0
	16	1.5	27	534	801.0	16	1.5	22	437	655.5	16	1.5	19	374	561.0
	18	1.5	25	451	676.5	18	1.5	21	368	552.0	18	1.5	18	315	472.5
	20	1.5	24	387	580.5	20	1.5	20	316	474.0	20	1.5	17	270	405.0

1.2344/ AISI H13/ SS2242
MC-code: P3.0.Z.AN
235 HB

	↓ 1.5xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2.5xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
P3	6	0.75	31	1622	1216.5	6	0.75	25	1326	994.5	6	0.75	21	1134	850.5
	8	1	31	1217	1217.0	8	1	25	995	995.0	8	1	21	851	851.0
	10	1	31	973	973.0	10	1	25	796	796.0	10	1	21	681	681.0
	10	1.25	31	973	1216.3	10	1.25	25	796	995.0	10	1.25	21	681	851.3
	12	1	31	811	811.0	12	1	25	663	663.0	12	1	21	567	567.0
	12	1.25	31	811	1013.8	12	1.25	25	663	828.8	12	1.25	21	567	708.8
	12	1.5	31	811	1216.5	12	1.5	25	663	994.5	12	1.5	21	567	850.5
	14	1.5	29	649	973.5	14	1.5	23	530	795.0	14	1.5	20	454	681.0
	16	1.5	27	534	801.0	16	1.5	22	437	655.5	16	1.5	19	374	561.0
	18	1.5	25	451	676.5	18	1.5	21	368	552.0	18	1.5	18	315	472.5
	20	1.5	24	387	580.5	20	1.5	20	316	474.0	20	1.5	17	270	405.0

EX13P



MF	P mm	l_1 mm	l_2 mm	d_2 Ø mm	a mm	l_3 mm	z	↔	e-Code
4	0.50	63	7	2.8	2.1	5	3	3.5	**EX13PM4X.50**
5	0.50	70	8	3.5	2.7	6	3	4.5	**EX13PM5X.50**
6	0.75	80	10	4.5	3.4	6	3	5.3	**EX13PM6X.75**
8	0.75	80	13	6.0	4.9	8	3	7.3	**EX13PM8X.75**
8	1.00	90	13	6.0	4.9	8	3	7	**EX13PM8X1.0**
10	0.75	90	13	7.0	5.5	8	3	9.3	**EX13PM10X.75**
10	1.00	90	13	7.0	5.5	8	3	9	**EX13PM10X1.0**
10	1.25	100	15	7.0	5.5	8	3	8.8	**EX13PM10X1.25**
12	1.00	100	15	9.0	7.0	10	3	11	**EX13PM12X1.0**
12	1.25	100	15	9.0	7.0	10	3	10.8	**EX13PM12X1.25**
12	1.50	100	15	9.0	7.0	10	3	10.5	**EX13PM12X1.5**
14	1.00	100	15	11.0	9.0	12	3	13	**EX13PM14X1.0**
14	1.25	100	15	11.0	9.0	12	3	12.8	**EX13PM14X1.25**
14	1.50	100	15	11.0	9.0	12	3	12.5	**EX13PM14X1.5**
16	1.00	100	15	12.0	9.0	12	4	15	**EX13PM16X1.0**
16	1.50	100	15	12.0	9.0	12	4	14.5	**EX13PM16X1.5**
18	1.00	110	17	14.0	11.0	14	4	17	**EX13PM18X1.0**
18	1.50	110	17	14.0	11.0	14	4	16.5	**EX13PM18X1.5**
20	1.00	125	17	16.0	12.0	15	4	19	**EX13PM20X1.0**
20	1.50	125	17	16.0	12.0	15	4	18.5	**EX13PM20X1.5**
22	1.50	125	17	18.0	14.5	17	4	20.5	**EX13PM22X1.5**
24	1.50	140	20	18.0	14.5	17	4	22.5	**EX13PM24X1.5**
24	2.00	140	20	18.0	14.5	17	4	22	**EX13PM24X2.0**
25	1.50	140	20	18.0	14.5	17	4	23.5	**EX13PM25X1.5**
26	1.50	140	20	18.0	14.5	17	4	24.5	**EX13PM26X1.5**
27	1.50	140	20	20.0	16.0	19	4	25.5	**EX13PM27X1.5**
27	2.00	140	20	20.0	16.0	19	4	25	**EX13PM27X2.0**
28	1.50	140	20	20.0	16.0	19	4	26.5	**EX13PM28X1.5**
30	1.50	150	20	22.0	18.0	21	4	28.5	**EX13PM30X1.5**
30	2.00	150	20	22.0	18.0	21	4	28	**EX13PM30X2.0**

MF | DIN ANSI | 6HX | 3XD | HSS-E-PM | C 2-3 | λ48° | Cool TOP

EX13PA

- MF Strojní závitník CoroTap™ P, zpětný kužel a šroubovitá drážka 48°
- MF Gépi Menetfúró CoroTap™ P Csavart hornyú 48°
- MF Gwintowniki maszynowe CoroTap™ P, zbieżny nakrój, śrubowy rowek wiórowy 48°
- MF Tarozi de masina CoroTap™ P Canal elicoidal 48°
- MF CoroTap™ P Спиральная стружечная канавка 48°
- MF Machine CoroTap™ P, back tapered Spiral Flute 48°

CoroTap™ 370 P

P	
P 1	20-48
P 2	16-30
P 3	16-30
P 4	20-48
P 5	16-30
Vc[m/min]	

Din EN C45/ 1.0503/ AISI 1045/ SS1650
MC-code: P1.2.Z.AN
220 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
P1	6	0.75	49	2595	1946.3	6	0.75	40	2122	1591.5	6	0.75	34	1815	1361.3
	8	1	49	1947	1947.0	8	1	40	1592	1592.0	8	1	34	1361	1361.0
	10	1	49	1557	1557.0	10	1	40	1273	1273.0	10	1	34	1089	1089.0
	10	1.25	49	1557	1946.3	10	1.25	40	1273	1591.3	10	1.25	34	1089	1361.3
	12	1	49	1298	1298.0	12	1	40	1061	1061.0	12	1	34	908	908.0
	12	1.25	49	1298	1622.5	12	1.25	40	1061	1326.3	12	1.25	34	908	1135.0
	12	1.5	49	1298	1947.0	12	1.5	40	1061	1591.5	12	1.5	34	908	1362.0
	14	1.5	46	1038	1557.0	14	1.5	37	849	1273.5	14	1.5	32	726	1089.0
	16	1.5	43	855	1282.5	16	1.5	35	699	1048.5	16	1.5	30	598	897.0
	18	1.5	41	721	1081.5	18	1.5	33	589	883.5	18	1.5	29	504	756.0
	20	1.5	39	619	928.5	20	1.5	32	506	759.0	20	1.5	27	433	649.5

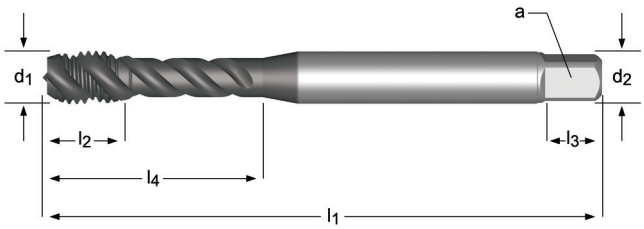
Din EN 42CrMo4/ 1.7225/ SS2244
MC-code: P2.2.Z.AN
241 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
P2	6	0.75	31	1622	1216.5	6	0.75	25	1326	994.5	6	0.75	21	1134	850.5
	8	1	31	1217	1217.0	8	1	25	995	995.0	8	1	21	851	851.0
	10	1	31	973	973.0	10	1	25	796	796.0	10	1	21	681	681.0
	10	1.25	31	973	1216.3	10	1.25	25	796	995.0	10	1.25	21	681	851.3
	12	1	31	811	811.0	12	1	25	663	663.0	12	1	21	567	567.0
	12	1.25	31	811	1013.8	12	1.25	25	663	828.8	12	1.25	21	567	708.8
	12	1.5	31	811	1216.5	12	1.5	25	663	994.5	12	1.5	21	567	850.5
	14	1.5	29	649	973.5	14	1.5	23	530	795.0	14	1.5	20	454	681.0
	16	1.5	27	534	801.0	16	1.5	22	437	655.5	16	1.5	19	374	561.0
	18	1.5	25	451	676.5	18	1.5	21	368	552.0	18	1.5	18	315	472.5
	20	1.5	24	387	580.5	20	1.5	20	316	474.0	20	1.5	17	270	405.0

1.2344/ AISI H13/ SS2242
MC-code: P3.0.Z.AN
235 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
P3	6	0.75	31	1622	1216.5	6	0.75	25	1326	994.5	6	0.75	21	1134	850.5
	8	1	31	1217	1217.0	8	1	25	995	995.0	8	1	21	851	851.0
	10	1	31	973	973.0	10	1	25	796	796.0	10	1	21	681	681.0
	10	1.25	31	973	1216.3	10	1.25	25	796	995.0	10	1.25	21	681	851.3
	12	1	31	811	811.0	12	1	25	663	663.0	12	1	21	567	567.0
	12	1.25	31	811	1013.8	12	1.25	25	663	828.8	12	1.25	21	567	708.8
	12	1.5	31	811	1216.5	12	1.5	25	663	994.5	12	1.5	21	567	850.5
	14	1.5	29	649	973.5	14	1.5	23	530	795.0	14	1.5	20	454	681.0
	16	1.5	27	534	801.0	16	1.5	22	437	655.5	16	1.5	19	374	561.0
	18	1.5	25	451	676.5	18	1.5	21	368	552.0	18	1.5	18	315	472.5
	20	1.5	24	387	580.5	20	1.5	20	316	474.0	20	1.5	17	270	405.0

EX13PA



MF	P mm	l_1 mm	l_2 inch	d_2 Ø inch /	⧄ a inch	z	↔	↔	l_4 inch	EDP # or Stock No.	e-Code
8	1.00	90	0.4764	0.3180	0.2380	3	7.00	J	1.3060	46094061	**EX13PAM8X1.0**
10	1.25	100	0.5945	0.3810	0.2860	3	8.75	S	1.4871	46094062	**EX13PAM10X1.25**
12	1.25	110	0.7090	0.3670	0.2750	3	10.80	27/64		46094063	**EX13PAM12X1.25**
12	1.50	110	0.7090	0.3670	0.2750	3	10.50	Z		46094064	**EX13PAM12X1.5**
14	1.50	110	0.7870	0.4290	0.3220	3	12.50	31/64		46094065	**EX13PAM14X1.5**
16	1.50	110	0.7874	0.4800	0.3600	4	14.50	37/64		46094066	**EX13PAM16X1.5**
18	1.50	125	0.9840	0.5420	0.4060	4	16.50			46094067	**EX13PAM18X1.5**

UNC | DIN ANSI | 2B 3B | 3XD | HSS-E-PM | B 3.5-5 | Cool TOP

EP23PA

- UNC Strojní závitník CoroTap™ P lamač třísek, přímá drážka
- UNC Gépi Menetfúró CoroTap™ P Terelőéles
- UNC Gwintowniki maszynowe CoroTap™ P ze skośną powierzchnią natarcia
- UNC Tarozi de masina CoroTap™ P Varf spiral
- UNC Машинные метчики CoroTap™ P Криволинейная задняя поверхность
- UNC Machine CoroTap™ P Spiral Point

CoroTap™ 210 P

P	
P 1	24-54
P 2	20-36
P 3	20-36
P 4	24-54
P 5	20-36
Vc[m/min]	

Din EN C45/ 1.0503/ AISI 1045/ SS1650 MC-code: P1.2.Z.AN 220 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
P1	2-56	56	55	8022	3638.6	2-56	56	45	6559	2975	2-56	56	38	5610	2544.5
	4-40	40	55	6158	3910.3	4-40	40	45	5035	3197.2	4-40	40	38	4307	2734.9
	6-32	32	55	4991	3961.6	6-32	32	45	4081	3239.3	6-32	32	38	3491	2771.0
	8-32	32	55	4201	4446.1	8-32	32	45	3435	3635.4	8-32	32	38	2938	3109.4
	10-24	24	55	3630	3841.8	10-24	24	45	2968	3141.1	10-24	24	38	2539	2687.1
	1/4	20	55	2759	3503.9	1/4	20	45	2256	2865.1	1/4	20	38	1930	2451.1
	5/16	18	55	2207	3114.3	5/16	18	45	1804	2545.6	5/16	18	38	1544	2178.8
	3/8	16	55	1839	2919.4	3/8	16	45	1504	2387.6	3/8	16	38	1286	2041.5
	7/16	14	55	1577	2861.1	7/16	14	45	1289	2338.6	7/16	14	38	1103	2001.2
	1/2	13	54	1345	2627.9	1/2	13	44	1099	2147.3	1/2	13	38	940	1836.6
	5/8	11	49	973	2246.7	5/8	11	40	796	1838.0	5/8	11	34	680	1570.2
	3/4	10	45	747	1897.4	3/4	10	37	611	1551.9	3/4	10	31	522	1325.9
	1"	8	39	492	1562.1	1"	8	32	402	1276.4	1"	8	27	344	1092.2

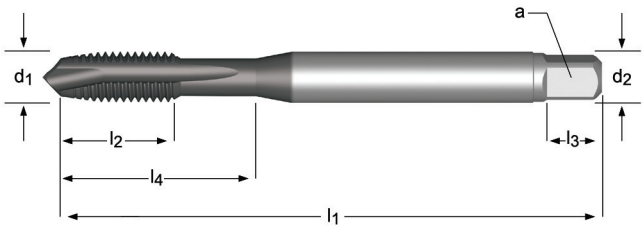
Din EN 42CrMo4/ 1.7225/ SS2244 MC-code: P2.2.Z.AN 241 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
P2	2-56	56	37	5348	2425.7	2-56	56	30	4372	1983	2-56	56	26	3740	1696.4
	4-40	40	37	4105	2606.7	4-40	40	30	3357	2131.7	4-40	40	26	2871	1823.1
	6-32	32	37	3328	2641.6	6-32	32	30	2721	2159.8	6-32	32	26	2327	1847.1
	8-32	32	37	2801	2964.4	8-32	32	30	2290	2423.6	8-32	32	26	1959	2073.3
	10-24	24	37	2420	2561.2	10-24	24	30	1979	2094.4	10-24	24	26	1693	1791.8
	1/4	20	37	1839	2335.5	1/4	20	30	1504	1910.1	1/4	20	26	1286	1633.2
	5/16	18	37	1471	2075.7	5/16	18	30	1203	1697.6	5/16	18	26	1029	1452.0
	3/8	16	37	1226	1946.3	3/8	16	30	1003	1592.3	3/8	16	26	858	1362.1
	7/16	14	37	1051	1906.8	7/16	14	30	859	1558.5	7/16	14	26	735	1333.5
	1/2	13	36	896	1750.6	1/2	13	29	733	1432.2	1/2	13	25	627	1225.1
	5/8	11	32	649	1498.6	5/8	11	26	530	1223.8	5/8	11	23	454	1048.3
	3/4	10	30	498	1264.9	3/4	10	24	407	1033.8	3/4	10	21	348	883.9
	1"	8	26	328	1041.4	1"	8	21	268	850.9	1"	8	18	229	727.1

1.2344/ AISI H13/ SS2242 MC-code: P3.0.Z.AN 235 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
P3	2-56	56	37	5348	2425.7	2-56	56	30	4372	1983	2-56	56	26	3740	1696.4
	4-40	40	37	4105	2606.7	4-40	40	30	3357	2131.7	4-40	40	26	2871	1823.1
	6-32	32	37	3328	2641.6	6-32	32	30	2721	2159.8	6-32	32	26	2327	1847.1
	8-32	32	37	2801	2964.4	8-32	32	30	2290	2423.6	8-32	32	26	1959	2073.3
	10-24	24	37	2420	2561.2	10-24	24	30	1979	2094.4	10-24	24	26	1693	1791.8
	1/4	20	37	1839	2335.5	1/4	20	30	1504	1910.1	1/4	20	26	1286	1633.2
	5/16	18	37	1471	2075.7	5/16	18	30	1203	1697.6	5/16	18	26	1029	1452.0
	3/8	16	37	1226	1946.3	3/8	16	30	1003	1592.3	3/8	16	26	858	1362.1
	7/16	14	37	1051	1906.8	7/16	14	30	859	1558.5	7/16	14	26	735	1333.5
	1/2	13	36	896	1750.6	1/2	13	29	733	1432.2	1/2	13	25	627	1225.1
	5/8	11	32	649	1498.6	5/8	11	26	530	1223.8	5/8	11	23	454	1048.3
	3/4	10	30	498	1264.9	3/4	10	24	407	1033.8	3/4	10	21	348	883.9
	1"	8	26	328	1041.4	1"	8	21	268	850.9	1"	8	18	229	727.1

EP23PA



UNC	TPI	l_1 mm	l_2 Inch	d_2 Ø Inch /	⧄ a Inch	z	Limits	↔	↔	l_4 Inch	e-Code
2	56	45	0.2760	0.1410	0.1100	2	H1	N50	1.85	0.4720	**EP23PA2-56**
4	40	56	0.3543	0.1410	0.1100	3	H2	N43	2.35	0.6681	**EP23PA4-40**
5	40	56	0.3543	0.1410	0.1100	3	H2	N38	2.65	0.6983	**EP23PA5-40**
6	32	56	0.4331	0.1410	0.1100	3	H3	N36	2.85	0.7954	**EP23PA6-32**
8	32	63	0.5118	0.1680	0.1310	3	H3	N29	3.50	0.8337	**EP23PA8-32**
8	32	63	0.5118	0.1680	0.1310	3	H5	N29	3.50	0.8337	**EP23PA8-32H5**
10	24	70	0.5512	0.1940	0.1520	3	H3	N25	3.90	1.0843	**EP23PA10-24**
1/4	20	80	0.5906	0.2550	0.1910	3	H3	N7	5.10	0.9681	**EP23PA1/4**
1/4	20	80	0.5906	0.2550	0.1910	3	H5	N7	5.10	0.9681	**EP23PA1/4H5**
5/16	18	90	0.7087	0.3180	0.2380	3	H3	F	6.60	1.3060	**EP23PA5/16**
5/16	18	90	0.7087	0.3180	0.2380	3	H5	F	6.60	1.3060	**EP23PA5/16H5**
3/8	16	100	0.7874	0.3810	0.2860	3	H3	5/16	8.00	1.4871	**EP23PA3/8**
3/8	16	100	0.7874	0.3810	0.2860	3	H5	5/16	8.00	1.4871	**EP23PA3/8H5**
7/16	14	100	0.7870	0.3230	0.2420	4	H3	U	9.40		**EP23PA7/16**
1/2	13	110	0.9060	0.3670	0.2750	4	H3	27/64	10.80		**EP23PA1/2**
1/2	13	110	0.9060	0.3670	0.2750	4	H5	27/64	10.80		**EP23PA1/2H5**
5/8	11	110	0.9060	0.4800	0.3600	4	H3	17/32	13.50		**EP23PA5/8**
5/8	11	110	0.9060	0.4800	0.3600	4	H5	17/32	13.50		**EP23PA5/8H5**
3/4	10	125	1.1810	0.5900	0.4420	4	H3	21/32	16.50		**EP23PA3/4**
3/4	10	125	1.1810	0.5900	0.4420	4	H5	21/32	16.50		**EP23PA3/4H5**
7/8	9	140	1.3385	0.6970	0.5230	4	H4	49/64	19.50		**EP23PA7/8**
1“	8	160	1.4170	0.8000	0.6000	4	H4	7/8	22.25		**EP23PA1**

UNC | DIN ANSI | 2BX | 3XD | HSS-E-PM | B 3.5-5 | Cool TOP

EP29PA

- UNC Strojní závitník CoroTap™ P lamač třísek, přímá drážka
- UNC Gépi Menetfúró CoroTap™ P Terelőéles
- UNC Gwintowniki maszynowe CoroTap™ P ze skośną powierzchnią natarcia
- UNC Tarozi de masina CoroTap™ P Varf spiral
- UNC Машинные метчики CoroTap™ P Криволинейная задняя поверхность
- UNC Machine CoroTap™ P Spiral Point

CoroTap™ 210 P

P	
P 1	32-54
P 2	28-48
P 3	28-48
P 4	32-54
P 5	28-48
Vc[m/min]	

Din EN C45/ 1.0503/ AISI 1045/ SS1650
MC-code: P1.2.Z.AN
220 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
P1	2-56	56	55	8022	3638.55	2-56	56	45	6559	2975	2-56	56	38	5610	2544.5
	4-40	40	55	6158	3910.33	4-40	40	45	5035	3197.2	4-40	40	38	4307	2734.9
	6-32	32	55	4991	3961.6	6-32	32	45	4081	3239.3	6-32	32	38	3491	2771.0
	8-32	24	55	4201	4446.1	8-32	24	45	3435	3635.4	8-32	24	38	2938	3109.4
	10-24	24	55	3630	3841.8	10-24	24	45	2968	3141.1	10-24	24	38	2539	2687.1
	1/4	20	55	2759	3503.9	1/4	20	45	2256	2865.1	1/4	20	38	1930	2451.1
	5/16	18	55	2207	3114.3	5/16	18	45	1804	2545.6	5/16	18	38	1544	2178.8
	3/8	16	55	1839	2919.4	3/8	16	45	1504	2387.6	3/8	16	38	1286	2041.5
	7/16	14	55	1577	2861.1	7/16	14	45	1289	2338.6	7/16	14	38	1103	2001.2
	1/2	13	54	1345	2627.9	1/2	13	44	1099	2147.3	1/2	13	38	940	1836.6
	5/8	11	49	973	2246.7	5/8	11	40	796	1838.0	5/8	11	34	680	1570.2
	3/4	10	45	747	1897.4	3/4	10	37	611	1551.9	3/4	10	31	522	1325.9
	1"	8	39	492	1562.1	1"	8	32	402	1276.4	1"	8	27	344	1092.2

Din EN 42CrMo4/ 1.7225/ SS2244
MC-code: P2.2.Z.AN
241 HB

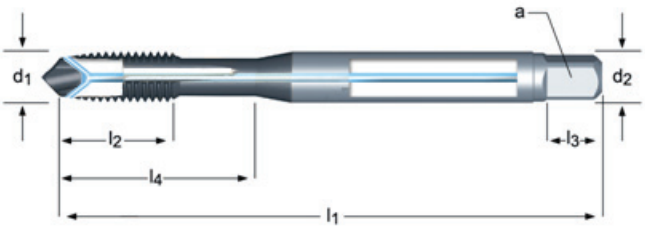
	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
P2	2-56	56	49	7130	3234	2-56	56	40	5830	2644.3	2-56	56	34	4987	2262
	4-40	40	49	5474	3476	4-40	40	40	4475	2841.6	4-40	40	34	3828	2430.8
	6-32	32	49	4437	3521.9	6-32	32	40	3627	2878.9	6-32	32	34	3103	2463.0
	8-32	24	49	3734	3951.8	8-32	24	40	3053	3231.1	8-32	24	34	2612	2764.4
	10-24	24	49	3227	3415.2	10-24	24	40	2638	2791.9	10-24	24	34	2257	2388.7
	1/4	20	49	2452	3114.0	1/4	20	40	2005	2546.4	1/4	20	34	1715	2178.1
	5/16	18	49	1962	2768.6	5/16	18	40	1604	2263.4	5/16	18	34	1372	1936.0
	3/8	16	49	1635	2595.6	3/8	16	40	1337	2122.5	3/8	16	34	1143	1814.5
	7/16	14	49	1401	2541.8	7/16	14	40	1146	2079.2	7/16	14	34	980	1778.0
	1/2	13	48	1195	2334.8	1/2	13	39	977	1908.9	1/2	13	33	836	1633.4
	5/8	11	43	865	1997.4	5/8	11	35	707	1632.5	5/8	11	30	605	1397.0
	3/4	10	40	664	1686.6	3/4	10	32	543	1379.2	3/4	10	28	464	1178.6
	1"	8	35	438	1390.7	1"	8	29	358	1136.7	1"	8	24	306	971.6

1.2344/ AISI H13/ SS2242
MC-code: P3.0.Z.AN
235 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
P3	2-56	56	49	7130	3234	2-56	56	40	5830	2644.3	2-56	56	34	4987	2262
	4-40	40	49	5474	3476	4-40	40	40	4475	2841.6	4-40	40	34	3828	2430.8
	6-32	32	49	4437	3521.9	6-32	32	40	3627	2878.9	6-32	32	34	3103	2463.0
	8-32	24	49	3734	3951.8	8-32	24	40	3053	3231.1	8-32	24	34	2612	2764.4
	10-24	24	49	3227	3415.2	10-24	24	40	2638	2791.9	10-24	24	34	2257	2388.7
	1/4	20	49	2452	3114.0	1/4	20	40	2005	2546.4	1/4	20	34	1715	2178.1
	5/16	18	49	1962	2768.6	5/16	18	40	1604	2263.4	5/16	18	34	1372	1936.0
	3/8	16	49	1635	2595.6	3/8	16	40	1337	2122.5	3/8	16	34	1143	1814.5
	7/16	14	49	1401	2541.8	7/16	14	40	1146	2079.2	7/16	14	34	980	1778.0
	1/2	13	48	1195	2334.8	1/2	13	39	977	1908.9	1/2	13	33	836	1633.4
	5/8	11	43	865	1997.4	5/8	11	35	707	1632.5	5/8	11	30	605	1397.0
	3/4	10	40	664	1686.6	3/4	10	32	543	1379.2	3/4	10	28	464	1178.6
	1"	8	35	438	1390.7	1"	8	29	358	1136.7	1"	8	24	306	971.6

EP29PA

P



UNC	TPI	l_1 mm	l_2 Inch	d_2 Ø Inch /	⧄ a Inch	z	↔	↔	l_4 Inch	e-Code
1/4	20	80	0.5906	0.2550	0.1910	3	N7	5.10	0.9681	**EP29PA1/4**
5/16	18	90	0.7087	0.3180	0.2380	3	F	6.60	1.3060	**EP29PA5/16**
3/8	16	100	0.7874	0.3810	0.2860	3	5/16	8.00	1.4871	**EP29PA3/8**
7/16	14	100	0.7870	0.3230	0.2420	4	U	9.40		**EP29PA7/16**
1/2	13	110	0.9060	0.3670	0.2750	4	27/64	10.80		**EP29PA1/2**
5/8	11	110	0.9060	0.4800	0.3600	4	17/32	13.50		**EP29PA5/8**
3/4	10	125	1.1810	0.5900	0.4420	4	21/32	16.50		**EP29PA3/4**
7/8	9	140	1.3385	0.6970	0.5230	4	49/64	19.5		**EP29PA7/8**
1“	8	160	1.4170	0.8000	0.6000	4	7/8	22.25		**EP29PA1**

UNC | ISO 529 | 2B | 2.5XD | HSS-PM | B 3.5-5 | Cool TOP

E057

- UNC Strojní závitník CoroTap™ P lamač třísek, přímá drážka
- UNC Gépi Menetfúró CoroTap™ P Terelőéles
- UNC Gwintowniki maszynowe CoroTap™ P ze skośną powierzchnią natarcia
- UNC Tarozi de masina CoroTap™ P Varf spiral
- UNC Машинные метчики CoroTap™ P Криволинейная задняя поверхность
- UNC Machine CoroTap™ P Spiral Point

CoroTap™ 200 P

P	
P 1	24-48
P 2	9-36
P 3	9-36
P 4	24-38
P 5	9-36
Vc[m/min]	

Din EN C45/ 1.0503/ AISI 1045/ SS1650 MC-code: P1.2.Z.AN 220 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
P1	6-32	32	39	3549	2817.0	6-32	32	32	2902	2303.5	6-32	32	27	2482	1970.1
	8-32	32	39	2988	2371.7	8-32	32	32	2443	1939.1	8-32	32	27	2089	1658.1
	10-24	24	39	2581	2731.6	10-24	24	32	2111	2234.1	10-24	24	27	1805	1910.3
	1/4	20	39	1962	2491.7	1/4	20	32	1604	2037.1	1/4	20	27	1372	1742.4
	5/16	18	39	1569	2214.0	5/16	18	32	1283	1810.5	5/16	18	27	1098	1549.4
	3/8	16	39	1308	2076.5	3/8	16	32	1069	1697.0	3/8	16	27	915	1452.6
	7/16	14	39	1121	2033.8	7/16	14	32	917	1663.7	7/16	14	27	784	1422.4
	1/2	13	38	956	1867.9	1/2	13	31	782	1527.9	1/2	13	27	669	1307.1
	5/8	11	35	692	1597.9	5/8	11	28	566	1306.9	5/8	11	24	484	1117.6
	3/4	10	32	531	1348.7	3/4	10	26	434	1102.4	3/4	10	22	371	942.3

Din EN 42CrMo4/ 1.7225/ SS2244 MC-code: P2.2.Z.AN 241 HB

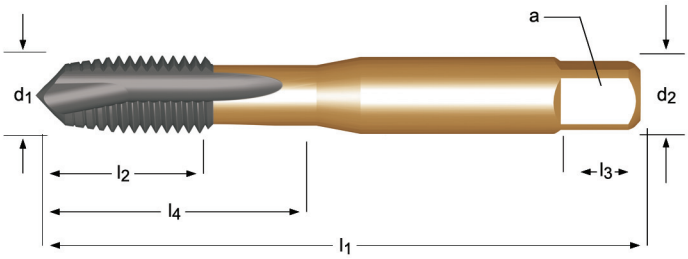
	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
P2	6-32	32	27	2440	1936.8	6-32	32	22	1995	1583.5	6-32	32	19	1707	1354.9
	8-32	32	27	2054	1630.4	8-32	32	22	1679	1332.7	8-32	32	19	1436	1139.8
	10-24	24	27	1775	1878.5	10-24	24	22	1451	1535.6	10-24	24	19	1241	1313.4
	1/4	20	27	1349	1713.2	1/4	20	22	1103	1400.8	1/4	20	19	943	1197.6
	5/16	18	27	1079	1522.6	5/16	18	22	882	1244.6	5/16	18	19	755	1065.4
	3/8	16	27	899	1427.2	3/8	16	22	735	1166.8	3/8	16	19	629	998.5
	7/16	14	27	771	1398.8	7/16	14	22	630	1143.0	7/16	14	19	539	977.9
	1/2	13	26	657	1283.7	1/2	13	21	538	1051.2	1/2	13	18	460	898.8
	5/8	11	24	476	1099.1	5/8	11	19	389	898.2	5/8	11	17	333	768.9
	3/4	10	22	365	927.1	3/4	10	18	299	759.5	3/4	10	15	255	647.7

1.2344/ AISI H13/ SS2242 MC-code: P3.0.Z.AN 235 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
P3	6-32	32	27	2440	1936.8	6-32	32	22	1995	1583.5	6-32	32	19	1707	1354.9
	8-32	32	27	2054	1630.4	8-32	32	22	1679	1332.7	8-32	32	19	1436	1139.8
	10-24	24	27	1775	1878.5	10-24	24	22	1451	1535.6	10-24	24	19	1241	1313.4
	1/4	20	27	1349	1713.2	1/4	20	22	1103	1400.8	1/4	20	19	943	1197.6
	5/16	18	27	1079	1522.6	5/16	18	22	882	1244.6	5/16	18	19	755	1065.4
	3/8	16	27	899	1427.2	3/8	16	22	735	1166.8	3/8	16	19	629	998.5
	7/16	14	27	771	1398.8	7/16	14	22	630	1143.0	7/16	14	19	539	977.9
	1/2	13	26	657	1283.7	1/2	13	21	538	1051.2	1/2	13	18	460	898.8
	5/8	11	24	476	1099.1	5/8	11	19	389	898.2	5/8	11	17	333	768.9
	3/4	10	22	365	927.1	3/4	10	18	299	759.5	3/4	10	15	255	647.7

E057

P



UNC	TPI	d_1 nom mm	l_1 mm	l_2 mm	d_2 Ø mm	⧄ a mm	l_3 mm	z	↔	l_4 mm	e-Code
6	32	3.505	50	14	3.55	2.80	5	3	2.85	14	**E0576-32**
8	32	4.166	53	9.5	4.50	3.55	6	3	3.50	17	**E0578-32**
10	24	4.826	58	11	5.00	4.00	7	3	3.90	20	**E05710-24**
1/4	20	6.350	66	13	6.30	5.00	8	3	5.10	26	**E0571/4**
5/16	18	7.938	72	16	8.00	6.30	9	3	6.60	29	**E0575/16**
3/8	16	9.525	80	18	10.00	8.00	11	3	8.00	32	**E0573/8**
1/2	13	12.700	89	22	9.00	7.10	10	3	10.80		**E0571/2**
5/8	11	15.875	102	24	12.50	10.00	13	3	13.50		**E0575/8**
3/4	10	19.050	112	29	14.00	11.20	14	4	16.50		**E0573/4**

UNC | DIN ANSI | 2B 3B | 3XD | HSS-E-PM | C 2-3 | λ48° | Cool TOP

EX23PA

- UNC Strojní závitník CoroTap™ P, zpětný kužel a šroubovitá drážka 48°
- UNC Gépi Menetfúró CoroTap™ P Csavart hornyú 48°
- UNC Gwintowniki maszynowe CoroTap™ P, zbieżny nakrój, śrubowy rowek wiórowy 48°
- UNC Tarozi de masina CoroTap™ P Canal elicoidal 48°
- UNC CoroTap™ P Спиральная стружечная канавка 48°
- UNC Machine CoroTap™ P, back tapered Spiral Flute 48°

CoroTap™ 370 P

P	
P 1	20-48
P 2	16-30
P 3	16-30
P 4	20-48
P 5	16-30
Vc[m/min]	

Din EN C45/ 1.0503/ AISI 1045/ SS1650
MC-code: P1.2.Z.AN
220 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
P1	2-56	56	49	7130	3234	2-56	56	40	5830	2644.3	2-56	56	34	4987	2262
	4-40	40	49	5474	3476	4-40	40	40	4475	2841.6	4-40	40	34	3828	2430.8
	6-32	32	49	4437	3521.9	6-32	32	40	3627	2878.9	6-32	32	34	3103	2463.0
	8-32	32	49	3734	3951.8	8-32	32	40	3053	3231.1	8-32	32	34	2612	2764.4
	10-24	24	49	3227	3415.2	10-24	24	40	2638	2791.9	10-24	24	34	2257	2388.7
	1/4	20	49	2452	3114.0	1/4	20	40	2005	2546.4	1/4	20	34	1715	2178.1
	5/16	18	49	1962	2768.6	5/16	18	40	1604	2263.4	5/16	18	34	1372	1936.0
	3/8	16	49	1635	2595.6	3/8	16	40	1337	2122.5	3/8	16	34	1143	1814.5
	7/16	14	49	1401	2541.8	7/16	14	40	1146	2079.2	7/16	14	34	980	1778.0
	1/2	13	48	1195	2334.8	1/2	13	39	977	1908.9	1/2	13	33	836	1633.4
	5/8	11	43	865	1997.4	5/8	11	35	707	1632.5	5/8	11	30	605	1397.0
	3/4	10	40	664	1686.6	3/4	10	32	543	1379.2	3/4	10	28	464	1178.6
	1"	8	35	438	1390.7	1"	8	29	358	1136.7	1"	8	24	306	971.6

Din EN 42CrMo4/ 1.7225/ SS2244
MC-code: P2.2.Z.AN
241 HB

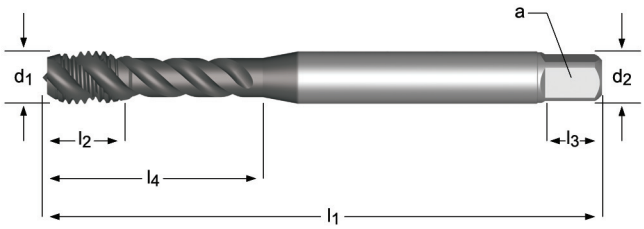
	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
P2	2-56	56	31	4457	2021.6	2-56	56	25	3644	1652.8	2-56	56	21	3117	1413.8
	4-40	40	31	3421	2172.3	4-40	40	25	2797	1776.1	4-40	40	21	2393	1519.6
	6-32	32	31	2773	2201.1	6-32	32	25	2267	1799.4	6-32	32	21	1939	1539.1
	8-32	32	31	2334	2470.2	8-32	32	25	1908	2019.3	8-32	32	21	1632	1727.2
	10-24	24	31	2017	2134.7	10-24	24	25	1649	1745.2	10-24	24	21	1410	1492.3
	1/4	20	31	1533	1946.9	1/4	20	25	1253	1591.3	1/4	20	21	1072	1361.4
	5/16	18	31	1226	1730.0	5/16	18	25	1002	1413.9	5/16	18	21	858	1210.7
	3/8	16	31	1022	1622.4	3/8	16	25	835	1325.6	3/8	16	21	715	1135.1
	7/16	14	31	876	1589.3	7/16	14	25	716	1299.0	7/16	14	21	613	1112.2
	1/2	13	30	747	1459.5	1/2	13	24	611	1193.8	1/2	13	21	522	1019.9
	5/8	11	27	541	1249.2	5/8	11	22	442	1020.6	5/8	11	19	378	872.8
	3/4	10	25	415	1054.1	3/4	10	20	339	861.1	3/4	10	17	290	736.6
	1"	8	22	273	866.8	1"	8	18	224	711.2	1"	8	15	191	606.4

1.2344/ AISI H13/ SS2242
MC-code: P3.0.Z.AN
235 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
P3	2-56	56	31	4457	2021.6	2-56	56	25	3644	1652.8	2-56	56	21	3117	1413.8
	4-40	40	31	3421	2172.3	4-40	40	25	2797	1776.1	4-40	40	21	2393	1519.6
	6-32	32	31	2773	2201.1	6-32	32	25	2267	1799.4	6-32	32	21	1939	1539.1
	8-32	32	31	2334	2470.2	8-32	32	25	1908	2019.3	8-32	32	21	1632	1727.2
	10-24	24	31	2017	2134.7	10-24	24	25	1649	1745.2	10-24	24	21	1410	1492.3
	1/4	20	31	1533	1946.9	1/4	20	25	1253	1591.3	1/4	20	21	1072	1361.4
	5/16	18	31	1226	1730.0	5/16	18	25	1002	1413.9	5/16	18	21	858	1210.7
	3/8	16	31	1022	1622.4	3/8	16	25	835	1325.6	3/8	16	21	715	1135.1
	7/16	14	31	876	1589.3	7/16	14	25	716	1299.0	7/16	14	21	613	1112.2
	1/2	13	30	747	1459.5	1/2	13	24	611	1193.8	1/2	13	21	522	1019.9
	5/8	11	27	541	1249.2	5/8	11	22	442	1020.6	5/8	11	19	378	872.8
	3/4	10	25	415	1054.1	3/4	10	20	339	861.1	3/4	10	17	290	736.6
	1"	8	22	273	866.8	1"	8	18	224	711.2	1"	8	15	191	606.4

EX23PA

P



UNC	TPI	l_1 mm	l_2 Inch	d_2 Ø Inch /	⧄ a Inch	z	Limits	↔	↔	l_4 Inch	e-Code
2	56	45	0.1570	0.1410	0.1100	3	H1	N50	1.85	0.4720	**EX23PA2-56**
4	40	56	0.2559	0.1410	0.1100	3	H2	N43	2.35	0.6681	**EX23PA4-40**
5	40	56	0.2559	0.1410	0.1100	3	H2	N38	2.65	0.6983	**EX23PA5-40**
6	32	56	0.2559	0.1410	0.1100	3	H3	N36	2.85	0.7954	**EX23PA6-32**
8	32	63	0.2756	0.1680	0.1310	3	H3	N29	3.50	0.8337	**EX23PA8-32**
8	32	63	0.2756	0.1680	0.1310	3	H5	N29	3.50	0.8337	**EX23PA8-32H5**
10	24	70	0.3150	0.1940	0.1520	3	H3	N25	3.90	1.0843	**EX23PA10-24**
1/4	20	80	0.4016	0.2550	0.1910	3	H3	N7	5.10	0.9720	**EX23PA1/4**
1/4	20	80	0.4016	0.2550	0.1910	3	H5	N7	5.10	0.9720	**EX23PA1/4H5**
5/16	18	90	0.4724	0.3180	0.2380	3	H3	F	6.60	1.3060	**EX23PA5/16**
5/16	18	90	0.4724	0.3180	0.2380	3	H5	F	6.60	1.3060	**EX23PA5/16H5**
3/8	16	100	0.6220	0.3810	0.2860	3	H3	5/16	8.00	1.4989	**EX23PA3/8**
3/8	16	100	0.6220	0.3810	0.2860	3	H5	5/16	8.00	1.4989	**EX23PA3/8H5**
7/16	14	100	0.5910	0.3230	0.2420	3	H3	U	9.40		**EX23PA7/16**
1/2	13	110	0.7090	0.3670	0.2750	3	H3	27/64	10.80		**EX23PA1/2**
1/2	13	110	0.7090	0.3670	0.2750	3	H5	27/64	10.80		**EX23PA1/2H5**
5/8	11	110	0.7874	0.4800	0.3600	4	H3	17/32	13.50		**EX23PA5/8**
5/8	11	110	0.7874	0.4800	0.3600	4	H5	17/32	13.50		**EX23PA5/8H5**
3/4	10	125	0.9843	0.5900	0.4420	4	H3	21/32	16.50		**EX23PA3/4**
3/4	10	125	0.9843	0.5900	0.4420	4	H5	21/32	16.50		**EX23PA3/4H5**
7/8	9	140	0.9843	0.6969	0.5228	4	H4	49/64	19.50		**EX23PA7/8**
1“	8	160	1.1810	0.8000	0.6000	4	H4	7/8	22.25		**EX23PA1**

UNC | DIN ANSI | 2BX | 3XD | HSS-E-PM | C 2-3 | λ48° | Cool TOP

EX29PA

- UNC Strojní závitník CoroTap™ P, zpětný kužel a šroubovitá drážka 48°
- UNC Gépi Menetfúró CoroTap™ P Csavart hornyú 48°
- UNC Gwintowniki maszynowe CoroTap™ P, zbieżny nakrój, śrubowy rowek wiórowy 48°
- UNC Tarozi de masina CoroTap™ P Canal elicoidal 48°
- UNC CoroTap™ P Спиральная стружечная канавка 48°
- UNC Machine CoroTap™ P, back tapered Spiral Flute 48°

CoroTap™ 370 P

P	
P 1	24-54
P 2	20-43
P 3	20-43
P 4	24-54
P 5	20-43
Vc[m/min]	

Din EN C45/ 1.0503/ AISI 1045/ SS1650
MC-code: P1.2.Z.AN
220 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
P1	2-56	56	55	8022	3638.6	2-56	56	45	6559	2975	2-56	56	38	5610	2544.5
	4-40	40	55	6158	3910.3	4-40	40	45	5035	3197.2	4-40	40	38	4307	2734.9
	6-32	32	55	4991	3961.6	6-32	32	45	4081	3239.3	6-32	32	38	3491	2771.0
	8-32	32	55	4201	4446.1	8-32	32	45	3435	3635.4	8-32	32	38	2938	3109.4
	10-24	24	55	3630	3841.8	10-24	24	45	2968	3141.1	10-24	24	38	2539	2687.1
	1/4	20	55	2759	3503.9	1/4	20	45	2256	2865.1	1/4	20	38	1930	2451.1
	5/16	18	55	2207	3114.3	5/16	18	45	1804	2545.6	5/16	18	38	1544	2178.8
	3/8	16	55	1839	2919.4	3/8	16	45	1504	2387.6	3/8	16	38	1286	2041.5
	7/16	14	55	1577	2861.1	7/16	14	45	1289	2338.6	7/16	14	38	1103	2001.2
	1/2	13	54	1345	2627.9	1/2	13	44	1099	2147.3	1/2	13	38	940	1836.6
	5/8	11	49	973	2246.7	5/8	11	40	796	1838.0	5/8	11	34	680	1570.2
	3/4	10	45	747	1897.4	3/4	10	37	611	1551.9	3/4	10	31	522	1325.9
	1"	8	39	492	1562.1	1"	8	32	402	1276.4	1"	8	27	344	1092.2

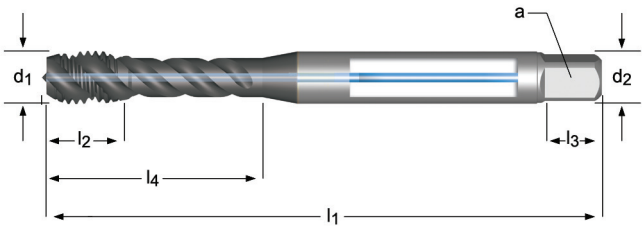
Din EN 42CrMo4/ 1.7225/ SS2244
MC-code: P2.2.Z.AN
241 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
P2	2-56	56	43	6239	2829.8	2-56	56	35	5101	2313.7	2-56	56	30	4363	1978.9
	4-40	40	43	4790	3041.7	4-40	40	35	3916	2486.7	4-40	40	30	3350	2127.3
	6-32	32	43	3882	3081.3	6-32	32	35	3174	2519.4	6-32	32	30	2715	2155.0
	8-32	32	43	3268	3458.6	8-32	32	35	2672	2827.9	8-32	32	30	2285	2418.3
	10-24	24	43	2824	2988.7	10-24	24	35	2309	2443.7	10-24	24	30	1975	2090.2
	1/4	20	43	2146	2725.4	1/4	20	35	1754	2227.6	1/4	20	30	1501	1906.3
	5/16	18	43	1717	2422.9	5/16	18	35	1403	1979.8	5/16	18	30	1201	1694.7
	3/8	16	43	1431	2271.7	3/8	16	35	1170	1857.4	3/8	16	30	1000	1587.5
	7/16	14	43	1226	2224.3	7/16	14	35	1003	1819.7	7/16	14	30	858	1556.7
	1/2	13	42	1046	2043.7	1/2	13	34	855	1670.5	1/2	13	29	731	1428.3
	5/8	11	38	757	1748.0	5/8	11	31	619	1429.3	5/8	11	26	529	1221.5
	3/4	10	35	581	1475.7	3/4	10	28	475	1206.5	3/4	10	24	406	1031.2
	1"	8	31	383	1216.0	1"	8	25	313	993.8	1"	8	21	268	850.9

1.2344/ AISI H13/ SS2242
MC-code: P3.0.Z.AN
235 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
P3	2-56	56	43	6239	28.29	2-56	56	35	5101	2313.7	2-56	56	30	4363	1978.9
	4-40	40	43	4790	3041.7	4-40	40	35	3916	2486.7	4-40	40	30	3350	2127.3
	6-32	32	43	3882	3081.3	6-32	32	35	3174	2519.4	6-32	32	30	2715	2155.0
	8-32	32	43	3268	3458.6	8-32	32	35	2672	2827.9	8-32	32	30	2285	2418.3
	10-24	24	43	2824	2988.7	10-24	24	35	2309	2443.7	10-24	24	30	1975	2090.2
	1/4	20	43	2146	2725.4	1/4	20	35	1754	2227.6	1/4	20	30	1501	1906.3
	5/16	18	43	1717	2422.9	5/16	18	35	1403	1979.8	5/16	18	30	1201	1694.7
	3/8	16	43	1431	2271.7	3/8	16	35	1170	1857.4	3/8	16	30	1000	1587.5
	7/16	14	43	1226	2224.3	7/16	14	35	1003	1819.7	7/16	14	30	858	1556.7
	1/2	13	42	1046	2043.7	1/2	13	34	855	1670.5	1/2	13	29	731	1428.3
	5/8	11	38	757	1748.0	5/8	11	31	619	1429.3	5/8	11	26	529	1221.5
	3/4	10	35	581	1475.7	3/4	10	28	475	1206.5	3/4	10	24	406	1031.2
	1"	8	31	383	1216.0	1"	8	25	313	993.8	1"	8	21	268	850.9

EX29PA



UNC	TPI	l_1 mm	l_2 Inch	d_2 Ø Inch /	⧄ a Inch	z	↔	↔	l_4 Inch	e-Code
1/4	20	80	0.4016	0.2550	0.1910	3	N7	5.10	0.9720	**EX29PA1/4**
5/16	18	90	0.4724	0.3180	0.2380	3	F	6.60	1.3060	**EX29PA5/16**
3/8	16	100	0.6220	0.3810	0.2860	3	5/16	5/16	1.4989	**EX29PA3/8**
7/16	14	100	0.5910	0.3230	0.2420	3	U	9.40		**EX29PA7/16**
1/2	13	110	0.7090	0.3670	0.2750	3	27/64	10.80		**EX29PA1/2**
5/8	11	110	0.7874	0.4800	0.3600	4	17/32	13.50		**EX29PA5/8**
3/4	10	125	0.9843	0.5900	0.4420	4	21/32	16.50		**EX29PA3/4**
7/8	9	140	0.9843	0.6969	0.5228	4	49/64	19.50		**EX29PA7/8**
1“	8	160	1.1810	0.8000	0.6000	4	7/8	22.25		**EX29PA1**

UNC | ISO 529 | 2B | 2.5XD | HSS-PM | C 2-3 | λ45° | Cool TOP

E058

- UNC Strojní závitník CoroTap™ P, šroubovitá drážka 45°
- UNC Gépi Menetfúró CoroTap™ P Csavart hornyú 45°
- UNC Gwintowniki maszynowe CoroTap™ P, śrubowy rowek wiórowy 45°
- UNC Tarozi de masina CoroTap™ P Canal elicoidal 45°
- UNC Машинные метчики CoroTap™ P Спиральная стружечная канавка 45°
- UNC Machine CoroTap™ P Spiral Flute 45°

CoroTap™ 360 P

P	
P 1	24-48
P 2	9-36
P 3	9-36
P 4	24-38
P 5	9-36
Vc[m/min]	

Din EN C45/ 1.0503/ AISI 1045/ SS1650 MC-code: P1.2.Z.AN 220 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
P1	6-32	32	39	3549	2817.0	6-32	32	32	2902	2303.5	6-32	32	27	2482	1970.1
	8-32	32	39	2988	2371.7	8-32	32	32	2443	1939.1	8-32	32	27	2089	1658.1
	10-24	24	39	2581	2731.6	10-24	24	32	2111	2234.1	10-24	24	27	1805	1910.3
	1/4	20	39	1962	2491.7	1/4	20	32	1604	2037.1	1/4	20	27	1372	1742.4
	5/16	18	39	1569	2214.0	5/16	18	32	1283	1810.5	5/16	18	27	1098	1549.4
	3/8	16	39	1308	2076.5	3/8	16	32	1069	1697.0	3/8	16	27	915	1452.6
	7/16	14	39	1121	2033.8	7/16	14	32	917	1663.7	7/16	14	27	784	1422.4
	1/2	13	38	956	1867.9	1/2	13	31	782	1527.9	1/2	13	27	669	1307.1
	5/8	11	35	692	1597.9	5/8	11	28	566	1306.9	5/8	11	24	484	1117.6
	3/4	10	32	531	1348.7	3/4	10	26	434	1102.4	3/4	10	22	371	942.3

Din EN 42CrMo4/ 1.7225/ SS2244 MC-code: P2.2.Z.AN 241 HB

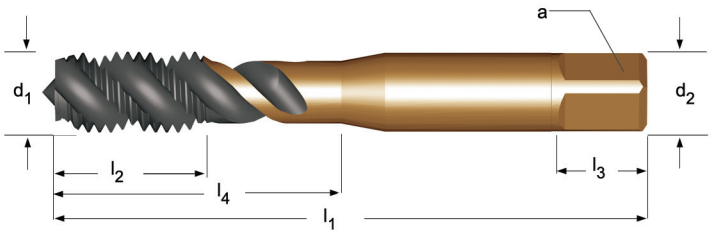
	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
P2	6-32	32	27	2440	1936.8	6-32	32	22	1995	1583.5	6-32	32	19	1707	1354.9
	8-32	32	27	2054	1630.4	8-32	32	22	1679	1332.7	8-32	32	19	1436	1139.8
	10-24	24	27	1775	1878.5	10-24	24	22	1451	1535.6	10-24	24	19	1241	1313.4
	1/4	20	27	1349	1713.2	1/4	20	22	1103	1400.8	1/4	20	19	943	1197.6
	5/16	18	27	1079	1522.6	5/16	18	22	882	1244.6	5/16	18	19	755	1065.4
	3/8	16	27	899	1427.2	3/8	16	22	735	1166.8	3/8	16	19	629	998.5
	7/16	14	27	771	1398.8	7/16	14	22	630	1143.0	7/16	14	19	539	977.9
	1/2	13	26	657	1283.7	1/2	13	21	538	1051.2	1/2	13	18	460	898.8
	5/8	11	24	476	1099.1	5/8	11	19	389	898.2	5/8	11	17	333	768.9
	3/4	10	22	365	927.1	3/4	10	18	299	759.5	3/4	10	15	255	647.7

1.2344/ AISI H13/ SS2242 MC-code: P3.0.Z.AN 235 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
P3	6-32	32	27	2440	1936.8	6-32	32	22	1995	1583.5	6-32	32	19	1707	1354.9
	8-32	32	27	2054	1630.4	8-32	32	22	1679	1332.7	8-32	32	19	1436	1139.8
	10-24	24	27	1775	1878.5	10-24	24	22	1451	1535.6	10-24	24	19	1241	1313.4
	1/4	20	27	1349	1713.2	1/4	20	22	1103	1400.8	1/4	20	19	943	1197.6
	5/16	18	27	1079	1522.6	5/16	18	22	882	1244.6	5/16	18	19	755	1065.4
	3/8	16	27	899	1427.2	3/8	16	22	735	1166.8	3/8	16	19	629	998.5
	7/16	14	27	771	1398.8	7/16	14	22	630	1143.0	7/16	14	19	539	977.9
	1/2	13	26	657	1283.7	1/2	13	21	538	1051.2	1/2	13	18	460	898.8
	5/8	11	24	476	1099.1	5/8	11	19	389	898.2	5/8	11	17	333	768.9
	3/4	10	22	365	927.1	3/4	10	18	299	759.5	3/4	10	15	255	647.7

E058

P



UNC	TPI	d_1 nom mm	l_1 mm	l_2 mm	d_2 Ø mm	⧄ a mm	l_3 mm	z	↔	l_4 mm	e-Code
6	32	3.505	50	14	3.55	2.80	5	3	2.85	14	**E0586-32**
8	32	4.166	53	9.5	4.50	3.55	6	3	3.50	17	**E0588-32**
10	24	4.826	58	11	5.00	4.00	7	3	3.90	20	**E05810-24**
1/4	20	6.350	66	13	6.30	5.00	8	3	5.10	28	**E0581/4**
5/16	18	7.938	72	16	8.00	6.30	9	3	6.60	31	**E0585/16**
3/8	16	9.525	80	18	10.00	8.00	11	3	8.00	34	**E0583/8**
1/2	13	12.700	89	22	9.00	7.10	10	3	10.80		**E0581/2**
5/8	11	15.875	102	24	12.50	10.00	13	4	13.50		**E0585/8**
3/4	10	19.050	112	29	14.00	11.20	14	4	16.50		**E0583/4**

UNF | DIN ANSI | 2B 3B | 3XD | HSS-E-PM | B 3.5-5 | Cool TOP

EP33PA

- UNF Strojní závitník CoroTap™ P lamač třísek, přímá drážka
- UNF Gépi Menetfúró CoroTap™ P Terelőéles
- UNF Gwintowniki maszynowe CoroTap™ P ze skośną powierzchnią natarcia
- UNF Tarozi de masina CoroTap™ P Varf spiral
- UNF Машинные метчики CoroTap™ P Криволинейная задняя поверхность
- UNF Machine CoroTap™ P Spiral Point

CoroTap™ 210 P

P	
P 1	24-54
P 2	20-36
P 3	20-36
P 4	24-54
P 5	20-36
Vc[m/min]	

Din EN C45/ 1.0503/ AISI 1045/ SS1650 MC-code: P1.2.Z.AN 220 HB

	↓ 1.5xD UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2xD UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2.5xD UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
P1	8-36	36	55	4205	2966.9	8-36	36	45	3438	2425.7	8-36	36	38	2941	2075.0
	10-32	32	55	3635	2885.3	10-32	32	45	2972	2359.0	10-32	32	38	2542	2017.7
	1/4	28	55	2759	2502.8	1/4	28	45	2256	2046.5	1/4	28	38	1930	1750.8
	5/16	24	55	2206	2334.7	5/16	24	45	1804	1909.2	5/16	24	38	1543	1633.0
	3/8	24	55	1838	1945.2	3/8	24	45	1503	1590.7	3/8	24	38	1286	1361.0
	7/16	20	55	1577	2002.8	7/16	20	45	1289	1637.0	7/16	20	38	1103	1400.8
	1/2	20	54	1345	1708.2	1/2	20	44	1099	1395.7	1/2	20	38	940	1193.8
	9/16	18	51	1133	1598.8	9/16	18	42	927	1308.1	9/16	18	36	793	1119.0
	5/8	18	49	973	1373.0	5/8	18	40	795	1121.8	5/8	18	34	680	959.6
	3/4	16	45	747	1185.9	3/4	16	37	611	970.0	3/4	16	31	522	828.7
	7/8	14	42	597	1083.1	7/8	14	34	488	885.4	7/8	14	29	418	758.4
	1"	12	39	492	1041.4	1"	12	32	402	850.9	1"	12	27	344	728.1

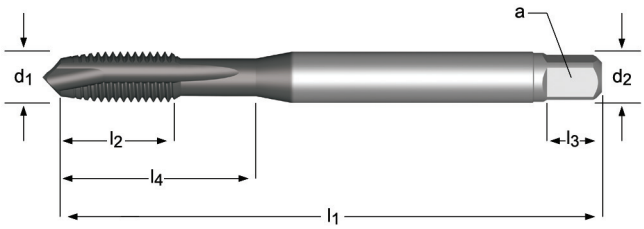
Din EN 42CrMo4/ 1.7225/ SS2244 MC-code: P2.2.Z.AN 241 HB

	↓ 1.5xD UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2xD UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2.5xD UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
P2	8-36	36	37	2804	1978.4	8-36	36	30	2292	1617.1	8-36	36	26	1961	1383.6
	10-32	32	37	2423	1923.3	10-32	32	30	1981	1572.4	10-32	32	26	1695	1345.4
	1/4	28	37	1839	1668.2	1/4	28	30	1504	1364.3	1/4	28	26	1286	1166.6
	5/16	24	37	1471	1556.8	5/16	24	30	1203	1273.2	5/16	24	26	1029	1089.0
	3/8	24	37	1226	1297.5	3/8	24	30	1002	1060.5	3/8	24	26	857	907.0
	7/16	20	37	1051	1334.8	7/16	20	30	860	1092.2	7/16	20	26	735	933.5
	1/2	20	36	896	1137.9	1/2	20	29	733	930.9	1/2	20	25	627	796.3
	9/16	18	34	756	1066.8	9/16	18	28	618	872.1	9/16	18	24	528	745.1
	5/8	18	32	648	914.4	5/8	18	26	530	747.9	5/8	18	23	453	639.2
	3/4	16	30	498	790.6	3/4	16	24	407	646.1	3/4	16	21	348	552.5
	7/8	14	28	398	722.1	7/8	14	23	326	591.5	7/8	14	19	279	506.2
	1"	12	26	328	694.3	1"	12	21	268	567.3	1"	12	18	229	484.7

1.2344/ AISI H13/ SS2242 MC-code: P3.0.Z.AN 235 HB

	↓ 1.5xD UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2xD UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2.5xD UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
P3	8-36	36	37	2804	1978.4	8-36	36	30	2292	1617.1	8-36	36	26	1961	1383.6
	10-32	32	37	2423	1923.3	10-32	32	30	1981	1572.4	10-32	32	26	1695	1345.4
	1/4	28	37	1839	1668.2	1/4	28	30	1504	1364.3	1/4	28	26	1286	1166.6
	5/16	24	37	1471	1556.8	5/16	24	30	1203	1273.2	5/16	24	26	1029	1089.0
	3/8	24	37	1226	1297.5	3/8	24	30	1002	1060.5	3/8	24	26	857	907.0
	7/16	20	37	1051	1334.8	7/16	20	30	860	1092.2	7/16	20	26	735	933.5
	1/2	20	36	896	1137.9	1/2	20	29	733	930.9	1/2	20	25	627	796.3
	9/16	18	34	756	1066.8	9/16	18	28	618	872.1	9/16	18	24	528	745.1
	5/8	18	32	648	914.4	5/8	18	26	530	747.9	5/8	18	23	453	639.2
	3/4	16	30	498	790.6	3/4	16	24	407	646.1	3/4	16	21	348	552.5
	7/8	14	28	398	722.1	7/8	14	23	326	591.5	7/8	14	19	279	506.2
	1"	12	26	328	694.3	1"	12	21	268	567.3	1"	12	18	229	484.7

EP33PA



UNF	TPI	l_1 mm	l_2 Inch	d_2 Ø Inch /	⧄ a Inch	z	Limits	↔	↔	l_4 Inch	e-Code
8	36	63	0.5118	0.1680	0.1310	3	H2	N28	3.50	0.8337	**EP33PA8-36**
10	32	70	0.5512	0.1940	0.1520	3	H3	N21	4.10	1.0843	**EP33PA10-32**
1/4	28	80	0.5906	0.2550	0.1910	3	H3	N3	5.50	0.9681	**EP33PA1/4**
1/4	28	80	0.5906	0.2550	0.1910	3	H4	N3	5.50	0.9681	**EP33PA1/4H4**
5/16	24	90	0.7087	0.3180	0.2380	3	H3	I	6.90	1.3060	**EP33PA5/16**
5/16	24	90	0.7087	0.3180	0.2380	3	H4	I	6.90	1.3060	**EP33PA5/16H4**
3/8	24	100	0.7874	0.3810	0.2860	3	H3	Q	8.50	1.4871	**EP33PA3/8**
3/8	24	100	0.7874	0.3810	0.2860	3	H4	Q	8.50	1.4871	**EP33PA3/8H4**
7/16	20	100	0.7870	0.3230	0.2420	4	H3	25/64	9.90		**EP33PA7/16**
1/2	20	110	0.9060	0.3670	0.2750	4	H3	29/64	11.50		**EP33PA1/2**
1/2	20	110	0.9060	0.3670	0.2750	4	H5	29/64	11.50		**EP33PA1/2H5**
5/8	18	110	0.9060	0.4800	0.3600	4	H3	37/64	14.50		**EP33PA5/8**
5/8	18	110	0.9060	0.4800	0.3600	4	H5	37/64	14.50		**EP33PA5/8H5**
3/4	16	125	1.1810	0.5900	0.4420	4	H3	11/16	17.50		**EP33PA3/4**
3/4	16	125	1.1810	0.5900	0.4420	4	H5	11/16	17.50		**EP33PA3/4H5**
7/8	14	140	1.3385	0.6969	0.5228	4	H4	13/16	20.50		**EP33PA7/8**
1“	12	160	1.4170	0.8000	0.6000	4	H4	59/64	23.25		**EP33PA1-12**

UNF | DIN ANSI | 2BX | 3XD | HSS-E-PM | B 3.5-5 | Cool TOP

EP39PA

- UNF Strojní závitník CoroTap™ P lamač třísek, přímá drážka
- UNF Gépi Menetfúró CoroTap™ P Terelőéles
- UNF Gwintowniki maszynowe CoroTap™ P ze skośną powierzchnią natarcia
- UNF Tarozi de masina CoroTap™ P Varf spiral
- UNF Машинные метчики CoroTap™ P Криволинейная задняя поверхность
- UNF Machine CoroTap™ P Spiral Point

CoroTap™ 210 P

P	
P 1	32-54
P 2	28-48
P 3	28-48
P 4	32-54
P 5	28-48
Vc[m/min]	

Din EN C45/ 1.0503/ AISI 1045/ SS1650
MC-code: P1.2.Z.AN
220 HB

	↓ 1.5xD				↓ 2xD				↓ 2.5xD			
	UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
P1	8-36	36	55	4205	2966.9	8-36	36	45	3438	2425.7	8-36	36	38	2941	2075.0
	10-32	32	55	3635	2885.3	10-32	32	45	2972	2359.0	10-32	32	38	2542	2017.7
	1/4	28	55	2759	2502.8	1/4	28	45	2256	2046.5	1/4	28	38	1930	1750.8
	5/16	24	55	2206	2334.7	5/16	24	45	1804	1909.2	5/16	24	38	1543	1633.0
	3/8	24	55	1838	1945.2	3/8	24	45	1503	1590.7	3/8	24	38	1286	1361.0
	7/16	20	55	1577	2002.8	7/16	20	45	1289	1637.0	7/16	20	38	1103	1400.8
	1/2	20	54	1345	1708.2	1/2	20	44	1099	1395.7	1/2	20	38	940	1193.8
	9/16	18	51	1133	1598.8	9/16	18	42	927	1308.1	9/16	18	36	793	1119.0
	5/8	18	49	973	1373.0	5/8	18	40	795	1121.8	5/8	18	34	680	959.6
	3/4	16	45	747	1185.9	3/4	16	37	611	970.0	3/4	16	31	522	828.7
	7/8	14	42	597	1083.1	7/8	14	34	488	885.4	7/8	14	29	418	758.4
	1"	12	39	492	1041.4	1"	12	32	402	850.9	1"	12	27	344	728.1

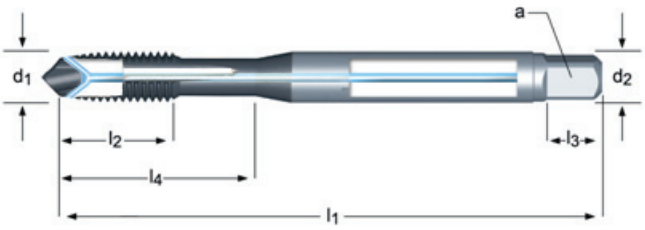
Din EN 42CrMo4/ 1.7225/ SS2244
MC-code: P2.2.Z.AN
241 HB

	↓ 1.5xD				↓ 2xD				↓ 2.5xD			
	UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
P2	8-36	36	49	3738	2637.4	8-36	36	40	3056	2156.2	8-36	36	34	2614	1844.3
	10-32	32	49	3231	2564.6	10-32	32	40	2642	2097.1	10-32	32	34	2260	1793.9
	1/4	28	49	2452	2224.3	1/4	28	40	2005	1818.8	1/4	28	34	1715	1555.8
	5/16	24	49	1961	2075.4	5/16	24	40	1604	1697.6	5/16	24	34	1372	1452.0
	3/8	24	49	1634	1729.3	3/8	24	40	1336	1413.9	3/8	24	34	1143	1209.7
	7/16	20	49	1402	1780.5	7/16	20	40	1146	1455.4	7/16	20	34	980	1244.6
	1/2	20	48	1195	1517.7	1/2	20	39	977	1240.8	1/2	20	33	836	1061.7
	9/16	18	45	1007	1421.0	9/16	18	37	824	1162.8	9/16	18	32	705	994.8
	5/8	18	43	865	1220.6	5/8	18	35	707	997.7	5/8	18	30	605	853.7
	3/4	16	40	664	1054.1	3/4	16	32	543	862.0	3/4	16	28	464	736.6
	7/8	14	37	531	963.4	7/8	14	30	434	787.4	7/8	14	26	371	673.1
	1"	12	35	438	927.1	1"	12	29	358	757.8	1"	12	24	306	647.7

1.2344/ AISI H13/ SS2242
MC-code: P3.0.Z.AN
235 HB

	↓ 1.5xD				↓ 2xD				↓ 2.5xD			
	UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
P3	8-36	36	49	3738	2637.4	8-36	36	40	3056	2156.2	8-36	36	34	2614	1844.3
	10-32	32	49	3231	2564.6	10-32	32	40	2642	2097.1	10-32	32	34	2260	1793.9
	1/4	28	49	2452	2224.3	1/4	28	40	2005	1818.8	1/4	28	34	1715	1555.8
	5/16	24	49	1961	2075.4	5/16	24	40	1604	1697.6	5/16	24	34	1372	1452.0
	3/8	24	49	1634	1729.3	3/8	24	40	1336	1413.9	3/8	24	34	1143	1209.7
	7/16	20	49	1402	1780.5	7/16	20	40	1146	1455.4	7/16	20	34	980	1244.6
	1/2	20	48	1195	1517.7	1/2	20	39	977	1240.8	1/2	20	33	836	1061.7
	9/16	18	45	1007	1421.0	9/16	18	37	824	1162.8	9/16	18	32	705	994.8
	5/8	18	43	865	1220.6	5/8	18	35	707	997.7	5/8	18	30	605	853.7
	3/4	16	40	664	1054.1	3/4	16	32	543	862.0	3/4	16	28	464	736.6
	7/8	14	37	531	963.4	7/8	14	30	434	787.4	7/8	14	26	371	673.1
	1"	12	35	438	927.1	1"	12	29	358	757.8	1"	12	24	306	647.7

EP39PA



UNF	TPI	l_1 mm	l_2 Inch	d_2 Ø Inch /	◪ a Inch	z	↔	↔	l_4 Inch	e-Code
10	32	70	0.5512	0.1940	0.1520	3	N21	4.10	1.0843	**EP39PA10-32**
1/4	28	80	0.5906	0.2550	0.1910	3	N3	5.50	0.9681	**EP39PA1/4**
5/16	24	90	0.7087	0.3180	0.2380	3	I	6.90	1.3060	**EP39PA5/16**
3/8	24	100	0.7874	0.3810	0.2860	3	Q	8.50	1.4871	**EP39PA3/8**
1/2	20	110	0.9060	0.3670	0.2750	4	29/64	11.50		**EP39PA1/2**
5/8	18	110	0.9060	0.4800	0.3600	4	37/64	14.50		**EP39PA5/8**

UNF | DIN ANSI | 2B 3B | 3XD | HSS-E-PM | C 2-3 | λ48° | Cool TOP

EX33PA

- UNF Strojní závitník CoroTap™ P, zpětný kužel a šroubovitá drážka 48°
- UNF Gépi Menetfúró CoroTap™ P Csavart hornyú 48°
- UNF Gwintowniki maszynowe CoroTap™ P, zbieżny nakrój, śrubowy rowek wiórowy 48°
- UNF Tarozi de masina CoroTap™ P Canal elicoidal 48°
- UNF CoroTap™ P Спиральная стружечная канавка 48°
- UNF Machine CoroTap™ P, back tapered Spiral Flute 48°

CoroTap™ 370 P

P	
P 1	20-48
P 2	16-30
P 3	16-30
P 4	20-48
P 5	16-30
Vc[m/min]	

Din EN C45/ 1.0503/ AISI 1045/ SS1650
MC-code: P1.2.Z.AN
220 HB

	↓ 1.5xD UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2xD UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2.5xD UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
P1	8-36	36	49	3738	2637.4	8-36	36	40	3056	2156.2	8-36	36	34	2614	1844.3
	10-32	32	49	3231	2564.6	10-32	32	40	2642	2097.1	10-32	32	34	2260	1793.9
	1/4	28	49	2452	2224.3	1/4	28	40	2005	1818.8	1/4	28	34	1715	1555.8
	5/16	24	49	1961	2075.4	5/16	24	40	1604	1697.6	5/16	24	34	1372	1452.0
	3/8	24	49	1634	1729.3	3/8	24	40	1336	1413.9	3/8	24	34	1143	1209.7
	7/16	20	49	1402	1780.5	7/16	20	40	1146	1455.4	7/16	20	34	980	1244.6
	1/2	20	48	1195	1517.7	1/2	20	39	977	1240.8	1/2	20	33	836	1061.7
	9/16	18	45	1007	1421.0	9/16	18	37	824	1162.8	9/16	18	32	705	994.8
	5/8	18	43	865	1220.6	5/8	18	35	707	997.7	5/8	18	30	605	853.7
	3/4	16	40	664	1054.1	3/4	16	32	543	862.0	3/4	16	28	464	736.6
	7/8	14	37	531	963.4	7/8	14	30	434	787.4	7/8	14	26	371	673.1
	1"	12	35	438	927.1	1"	12	29	358	757.8	1"	12	24	306	647.7

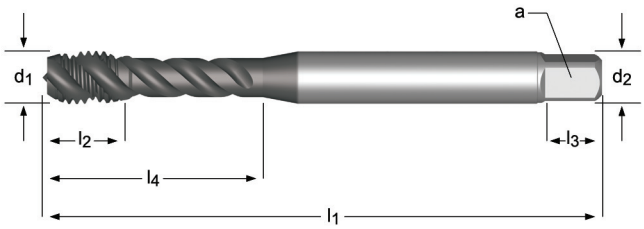
Din EN 42CrMo4/ 1.7225/ SS2244
MC-code: P2.2.Z.AN
241 HB

	↓ 1.5xD UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2xD UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2.5xD UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
P2	8-36	36	31	2336	1648.2	8-36	36	25	1910	1347.6	8-36	36	21	1634	1152.9
	10-32	32	31	2019	1602.6	10-32	32	25	1651	1310.5	10-32	32	21	1412	1120.8
	1/4	28	31	1533	1390.7	1/4	28	25	1253	1136.7	1/4	28	21	1072	972.5
	5/16	24	31	1226	1297.5	5/16	24	25	1002	1060.5	5/16	24	21	857	907.0
	3/8	24	31	1021	1080.6	3/8	24	25	835	883.7	3/8	24	21	714	755.7
	7/16	20	31	876	1112.5	7/16	20	25	716	909.3	7/16	20	21	613	778.5
	1/2	20	30	747	948.7	1/2	20	24	611	776.0	1/2	20	21	522	662.9
	9/16	18	28	630	889.0	9/16	18	23	515	726.7	9/16	18	20	440	620.9
	5/8	18	27	540	762.0	5/8	18	22	442	623.7	5/8	18	19	378	533.4
	3/4	16	25	415	658.8	3/4	16	20	339	538.2	3/4	16	17	290	460.4
	7/8	14	23	332	602.3	7/8	14	19	271	491.7	7/8	14	16	232	420.9
	1"	12	22	273	577.9	1"	12	18	224	474.1	1"	12	15	191	404.3

1.2344/ AISI H13/ SS2242
MC-code: P3.0.Z.AN
235 HB

	↓ 1.5xD UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2xD UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2.5xD UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
P3	8-36	36	31	2336	1648.2	8-36	36	25	1910	1347.6	8-36	36	21	1634	1152.9
	10-32	32	31	2019	1602.6	10-32	32	25	1651	1310.5	10-32	32	21	1412	1120.8
	1/4	28	31	1533	1390.7	1/4	28	25	1253	1136.7	1/4	28	21	1072	972.5
	5/16	24	31	1226	1297.5	5/16	24	25	1002	1060.5	5/16	24	21	857	907.0
	3/8	24	31	1021	1080.6	3/8	24	25	835	883.7	3/8	24	21	714	755.7
	7/16	20	31	876	1112.5	7/16	20	25	716	909.3	7/16	20	21	613	778.5
	1/2	20	30	747	948.7	1/2	20	24	611	776.0	1/2	20	21	522	662.9
	9/16	18	28	630	889.0	9/16	18	23	515	726.7	9/16	18	20	440	620.9
	5/8	18	27	540	762.0	5/8	18	22	442	623.7	5/8	18	19	378	533.4
	3/4	16	25	415	658.8	3/4	16	20	339	538.2	3/4	16	17	290	460.4
	7/8	14	23	332	602.3	7/8	14	19	271	491.7	7/8	14	16	232	420.9
	1"	12	22	273	577.9	1"	12	18	224	474.1	1"	12	15	191	404.3

EX33PA



UNF	TPI	l_1 mm	l_2 Inch	d_2 Ø Inch /	⧄ a Inch	z	Limits	↔	↔	l_4 Inch	e-Code
8	36	63	0.2756	0.1680	0.1310	3	H2	N28	3.50	0.8337	**EX33PA8-36**
10	32	70	0.3150	0.1940	0.1520	3	H3	N21	4.10	1.0843	**EX33PA10-32**
1/4	28	80	0.4016	0.2550	0.1910	3	H3	N3	5.50	0.9720	**EX33PA1/4**
1/4	28	80	0.4016	0.2550	0.1910	3	H4	N3	5.50	0.9720	**EX33PA1/4H4**
5/16	24	90	0.4724	0.3180	0.2380	3	H3	I	6.90	1.3060	**EX33PA5/16**
5/16	24	90	0.4724	0.3180	0.2380	3	H4	I	6.90	1.3060	**EX33PA5/16H4**
3/8	24	100	0.6220	0.3810	0.2860	3	H3	Q	8.50	1.4989	**EX33PA3/8**
3/8	24	100	0.6220	0.3810	0.2860	3	H4	Q	8.50	1.4989	**EX33PA3/8H4**
7/16	20	100	0.5910	0.3230	0.2420	3	H3	25/64	9.90		**EX33PA7/16**
1/2	20	110	0.7090	0.3670	0.2750	3	H3	29/64	11.50		**EX33PA1/2**
1/2	20	110	0.7090	0.3670	0.2750	3	H5	29/64	11.50		**EX33PA1/2H5**
5/8	18	110	0.7874	0.4800	0.3600	4	H3	37/64	14.50		**EX33PA5/8**
5/8	18	110	0.7874	0.4800	0.3600	4	H5	37/64	14.50		**EX33PA5/8H5**
3/4	16	125	0.9843	0.5900	0.4420	4	H3	11/16	17.50		**EX33PA3/4**
3/4	16	125	0.9843	0.5900	0.4420	4	H5	11/16	17.50		**EX33PA3/4H5**
7/8	14	140	0.9843	0.6969	0.5228	4	H4	13/16	20.50		**EX33PA7/8**
1“	12	160	1.1810	0.8000	0.6000	4	H4	59/64	23.25		**EX33PA1-12**

UNF | DIN ANSI | 2BX | 3XD | HSS-E-PM | C 2-3 | λ48° | Cool TOP

EX39PA

- UNF Strojní závitník CoroTap™ P, zpětný kužel a šroubovitá drážka 48°
- UNF Gépi Menetfúró CoroTap™ P Csavart hornyú 48°
- UNF Gwintowniki maszynowe CoroTap™ P, zbieżny nakrój, śrubowy rowek wiórowy 48°
- UNF Tarozi de masina CoroTap™ P Canal elicoidal 48°
- UNF CoroTap™ P Спиральная стружечная канавка 48°
- UNF Machine CoroTap™ P, back tapered Spiral Flute 48°

CoroTap™ 370 P

P	
P 1	24-54
P 2	20-43
P 3	20-43
P 4	24-54
P 5	20-43
Vc[m/min]	

Din EN C45/ 1.0503/ AISI 1045/ SS1650 MC-code: P1.2.Z.AN 220 HB

	↓ 1.5xD UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2xD UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2.5xD UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
P1	8-36	36	55	4205	2966.9	8-36	36	45	3438	2425.7	8-36	36	38	2941	2075.0
	10-32	32	55	3635	2885.3	10-32	32	45	2972	2359.0	10-32	32	38	2542	2017.7
	1/4	28	55	2759	2502.8	1/4	28	45	2256	2046.5	1/4	28	38	1930	1750.8
	5/16	24	55	2206	2334.7	5/16	24	45	1804	1909.2	5/16	24	38	1543	1633.0
	3/8	24	55	1838	1945.2	3/8	24	45	1503	1590.7	3/8	24	38	1286	1361.0
	7/16	20	55	1577	2002.8	7/16	20	45	1289	1637.0	7/16	20	38	1103	1400.8
	1/2	20	54	1345	1708.2	1/2	20	44	1099	1395.7	1/2	20	38	940	1193.8
	9/16	18	51	1133	1598.8	9/16	18	42	927	1308.1	9/16	18	36	793	1119.0
	5/8	18	49	973	1373.0	5/8	18	40	795	1121.8	5/8	18	34	680	959.6
	3/4	16	45	747	1185.9	3/4	16	37	611	970.0	3/4	16	31	522	828.7
	7/8	14	42	597	1083.1	7/8	14	34	488	885.4	7/8	14	29	418	758.4
	1"	12	39	492	1041.4	1"	12	32	402	850.9	1"	12	27	344	728.1

Din EN 42CrMo4/ 1.7225/ SS2244 MC-code: P2.2.Z.AN 241 HB

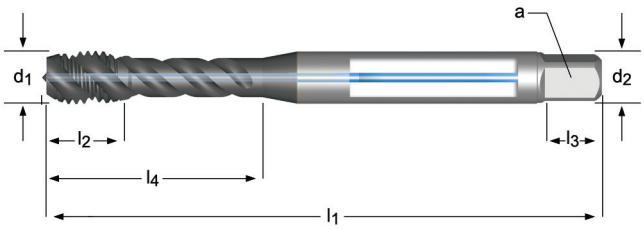
	↓ 1.5xD UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2xD UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2.5xD UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
P2	8-36	36	43	3271	2307.9	8-36	36	35	2674	1886.7	8-36	36	30	2288	1614.3
	10-32	32	43	2827	2243.9	10-32	32	35	2311	1834.4	10-32	32	30	1977	1569.2
	1/4	28	43	2146	1946.7	1/4	28	35	1754	1591.1	1/4	28	30	1501	1361.6
	5/16	24	43	1716	1816.1	5/16	24	35	1403	1484.8	5/16	24	30	1200	1270.0
	3/8	24	43	1430	1513.4	3/8	24	35	1169	1237.2	3/8	24	30	1000	1058.3
	7/16	20	43	1226	1557.0	7/16	20	35	1003	1273.8	7/16	20	30	858	1089.7
	1/2	20	42	1046	1328.4	1/2	20	34	855	1085.9	1/2	20	29	731	928.4
	9/16	18	40	881	1243.2	9/16	18	32	721	1017.4	9/16	18	28	616	869.2
	5/8	18	38	756	1066.8	5/8	18	31	618	872.1	5/8	18	26	529	746.5
	3/4	16	35	581	922.3	3/4	16	28	475	754.1	3/4	16	24	406	644.5
	7/8	14	32	465	843.6	7/8	14	27	380	689.4	7/8	14	23	325	589.6
	1"	12	31	383	810.7	1"	12	25	313	662.5	1"	12	21	268	567.3

1.2344/ AISI H13/ SS2242 MC-code: P3.0.Z.AN 235 HB

	↓ 1.5xD UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2xD UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2.5xD UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
P3	8-36	36	43	3271	2307.9	8-36	36	35	2674	1886.7	8-36	36	30	2288	1614.3
	10-32	32	43	2827	2243.9	10-32	32	35	2311	1834.4	10-32	32	30	1977	1569.2
	1/4	28	43	2146	1946.7	1/4	28	35	1754	1591.1	1/4	28	30	1501	1361.6
	5/16	24	43	1716	1816.1	5/16	24	35	1403	1484.8	5/16	24	30	1200	1270.0
	3/8	24	43	1430	1513.4	3/8	24	35	1169	1237.2	3/8	24	30	1000	1058.3
	7/16	20	43	1226	1557.0	7/16	20	35	1003	1273.8	7/16	20	30	858	1089.7
	1/2	20	42	1046	1328.4	1/2	20	34	855	1085.9	1/2	20	29	731	928.4
	9/16	18	40	881	1243.2	9/16	18	32	721	1017.4	9/16	18	28	616	869.2
	5/8	18	38	756	1066.8	5/8	18	31	618	872.1	5/8	18	26	529	746.5
	3/4	16	35	581	922.3	3/4	16	28	475	754.1	3/4	16	24	406	644.5
	7/8	14	32	465	843.6	7/8	14	27	380	689.4	7/8	14	23	325	589.6
	1"	12	31	383	810.7	1"	12	25	313	662.5	1"	12	21	268	567.3

EX39PA

P



UNF	TPI	l_1 mm	l_2 Inch	d_2 Ø Inch /	◪ a Inch	z	↔	↔	l_4 Inch	e-Code
10	32	70	0.3150	0.1940	0.1520	3	N21	4.10	1.0843	**EX39PA10-32**
1/4	28	80	0.4016	0.2550	0.1910	3	N3	5.50	0.9720	**EX39PA1/4**
5/16	24	90	0.4724	0.3180	0.2380	3	I	6.90	1.3060	**EX39PA5/16**
3/8	24	100	0.6220	0.3810	0.2860	3	Q	8.50	1.4989	**EX39PA3/8**
1/2	20	110	0.7090	0.3670	0.2750	3	29/64	11.50		**EX39PA1/2**
5/8	18	110	0.7874	0.4800	0.3600	4	37/64	14.50		**EX39PA5/8**

E324 / E326

SANDVIK Coromant

E324	M	~DIN 371	6H		2.5XD	HSS-E-PM	B 3.5-5			Cool TOP
E326	M	DIN 376	6H		2.5XD	HSS-E-PM	B 3.5-5			Cool TOP

- M Strojní závitník CoroTap™ P lamač třísek, přímá drážka
- M Gépi Menetfúró CoroTap™ P Terelőéles
- M Gwintowniki maszynowe CoroTap™ P ze skośną powierzchnią natarcia
- M Tarozi de masina CoroTap™ P Varf spiral
- M Машинные метчики CoroTap™ P Криволинейная задняя поверхность
- M Machine CoroTap™ P Spiral Point

CoroTap™ 200 P

P	
P 1	- - -
P 2	9-20
P 3	9-20
P 4	- - -
P 5	9-20
Vc[m/min]	

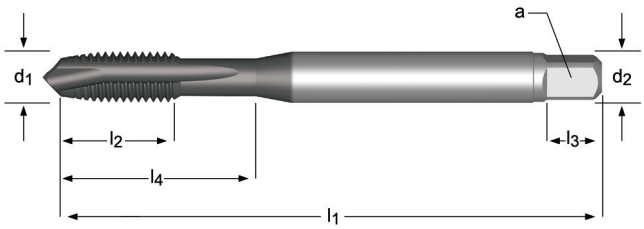
Din EN 42CrMo4/ 1.7225/ SS2244 MC-code: P2.5.Z.HT 311HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
P2	M3	0.5	21	2206	1103.0	M3	0.5	17	1804	902.0	M3	0.5	15	1543	771.5
	M4	0.7	21	1655	1158.5	M4	0.7	17	1353	947.1	M4	0.7	15	1157	809.9
	M5	0.8	21	1324	1059.2	M5	0.8	17	1082	865.6	M5	0.8	15	926	740.8
	M6	1	21	1103	1103.0	M6	1	17	902	902.0	M6	1	15	771	771.0
	M8	1.25	21	827	1033.8	M8	1.25	17	676	845.0	M8	1.25	15	579	723.8
	M10	1.5	21	662	993.0	M10	1.5	17	541	811.5	M10	1.5	15	463	694.5
	M12	1.75	21	552	966.0	M12	1.75	17	451	789.3	M12	1.75	15	386	675.5
	M16	2	18	363	726.0	M16	2	15	297	594.0	M16	2	13	254	508.0
	M20	2.5	17	263	657.5	M20	2.5	14	215	537.5	M20	2.5	12	184	460.0

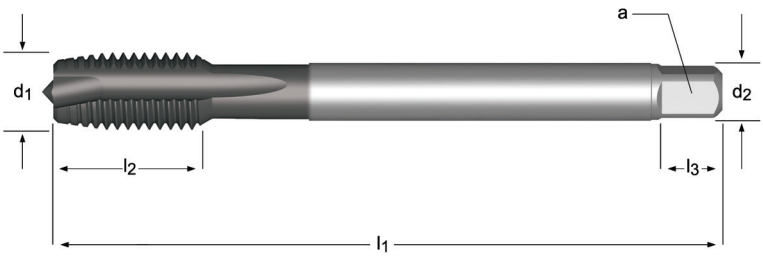
Toolox 44 MC-code: P2.5.Z.HT 415 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
P2	M3	0.5	13	1428	714.0	M3	0.5	11	1167	583.5	M3	0.5	9	998	499.0
	M4	0.7	13	1071	749.7	M4	0.7	11	875	612.5	M4	0.7	9	749	524.3
	M5	0.8	13	857	685.6	M5	0.8	11	700	560.0	M5	0.8	9	599	479.2
	M6	1	13	714	714.0	M6	1	11	584	584.0	M6	1	9	499	499.0
	M8	1.25	13	535	668.8	M8	1.25	11	438	547.5	M8	1.25	9	374	467.5
	M10	1.5	13	428	642.0	M10	1.5	11	350	525.0	M10	1.5	9	300	450.0
	M12	1.75	13	357	624.8	M12	1.75	11	292	511.0	M12	1.75	9	250	437.5
	M16	2	12	235	470.0	M16	2	10	192	384.0	M16	2	8	164	328.0
	M20	2.5	11	170	425.0	M20	2.5	9	139	347.5	M20	2.5	7	119	297.5

E324 / E326



E324



E326

M	P mm	l_1 mm	l_2 mm	d_2 Ø mm	◪ a mm	l_3 mm	z	↔	l_4 mm	E324		E326
3	0.50	63	12	4.5	3.4	6	3	2.6	21	**E324M3**	1)	
4	0.70	70	13	6.0	4.9	8	3	3.4	25	**E324M4**	1)	
5	0.80	80	15	6.0	4.9	8	3	4.3	30	**E324M5**	1)	
6	1.00	90	18	8.0	6.2	9	3	5.1	35	**E324M6**	1)	
8	1.25	100	20	10.0	8.0	11	3	6.9	39	**E324M8**	1)	
10	1.50	100	20	10.0	8.0	11	3	8.7	39	**E324M10**		
12	1.75	110	23	9.0	7.0	10	4	10.3				**E326M12**
14	2.00	110	25	11.0	9.0	12	4	12				**E326M14**
16	2.00	110	25	12.0	9.0	12	4	14				**E326M16**
18	2.50	125	30	14.0	11.0	14	4	15.5				**E326M18**
20	2.50	140	30	16.0	12.0	15	4	17.5				**E326M20**

1) Zesílená stopka a čtyřhran / Erősített szár és lapolás / Wzmocniony chwyt / Coada si antrenor intarite / С усиленным хвостовиком и четырехгранником / Reinforced shank and square

M | DIN ANSI | 6H | 2.5XD | HSS-E-PM | B 3.5-5 | Cool TOP

E854

- M Strojní závitník CoroTap™ P lamač třísek, přímá drážka
- M Gépi Menetfúró CoroTap™ P Terelőéles
- M Gwintowniki maszynowe CoroTap™ P ze skośną powierzchnią natarcia
- M Tarozi de masina CoroTap™ P Varf spiral
- M Машинные метчики CoroTap™ P Криволинейная задняя поверхность
- M Machine CoroTap™ P Spiral Point

CoroTap™ 200 P

P	
P 1	- - -
P 2	9-20
P 3	9-20
P 4	- - -
P 5	9-20
Vc[m/min]	

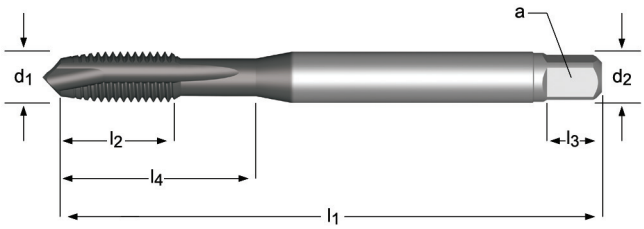
Din EN 42CrMo4/ 1.7225/ SS2244 MC-code: P2.5.Z.HT 311HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
P2	M3	0.5	21	2206	1103.0	M3	0.5	17	1804	902.0	M3	0.5	15	1543	771.5
	M4	0.7	21	1655	1158.5	M4	0.7	17	1353	947.1	M4	0.7	15	1157	809.9
	M5	0.8	21	1324	1059.2	M5	0.8	17	1082	865.6	M5	0.8	15	926	740.8
	M6	1	21	1103	1103.0	M6	1	17	902	902.0	M6	1	15	771	771.0
	M8	1.25	21	827	1033.8	M8	1.25	17	676	845.0	M8	1.25	15	579	723.8
	M10	1.5	21	662	993.0	M10	1.5	17	541	811.5	M10	1.5	15	463	694.5
	M12	1.75	21	552	966.0	M12	1.75	17	451	789.3	M12	1.75	15	386	675.5
	M16	2	18	363	726.0	M16	2	15	297	594.0	M16	2	13	254	508.0
	M20	2.5	17	263	657.5	M20	2.5	14	215	537.5	M20	2.5	12	184	460.0

Toolox 44 MC-code: P2.5.Z.HT 415 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
P2	M3	0.5	13	1428	714.0	M3	0.5	11	1167	583.5	M3	0.5	9	998	499.0
	M4	0.7	13	1071	749.7	M4	0.7	11	875	612.5	M4	0.7	9	749	524.3
	M5	0.8	13	857	685.6	M5	0.8	11	700	560.0	M5	0.8	9	599	479.2
	M6	1	13	714	714.0	M6	1	11	584	584.0	M6	1	9	499	499.0
	M8	1.25	13	535	668.8	M8	1.25	11	438	547.5	M8	1.25	9	374	467.5
	M10	1.5	13	428	642.0	M10	1.5	11	350	525.0	M10	1.5	9	300	450.0
	M12	1.75	13	357	624.8	M12	1.75	11	292	511.0	M12	1.75	9	250	437.5
	M16	2	12	235	470.0	M16	2	10	192	384.0	M16	2	8	164	328.0
	M20	2.5	11	170	425.0	M20	2.5	9	139	347.5	M20	2.5	7	119	297.5

E854



M	P mm	l_1 mm	l_2 inch	d_2 Ø inch /	⧄ a inch	z	↔	↔	l_4 inch	EDP # or Stock No.	e-Code	
3	0.50	63	0.5118	0.1680	0.1310	3	2.50	N40	0.8337	0629314	**E854M3**	1)
4	0.70	70	0.5945	0.1940	0.1520	3	3.30	N30	1.1001	0629321	**E854M4**	1)
5	0.80	80	0.6693	0.2550	0.1910	3	4.20	N19	0.9996	0629338	**E854M5**	1)
6	1.00	90	0.7953	0.3180	0.2380	3	5.00	N9	1.3375	0629345	**E854M6**	1)
8	1.25	100	0.7874	0.3810	0.2860	3	6.80	H	1.4871	0629352	**E854M8**	1)
10	1.50	100	0.7874	0.3810	0.2860	3	8.50	Q	1.4871	0629369	**E854M10**	
12	1.75	110	0.9060	0.3670	0.2750	4	10.30	Y		0629376	**E854M12**	
14	2.00	110	0.9060	0.4290	0.3220	4	12.00	15/32		0637883	**E854M14**	
16	2.00	110	0.9060	0.4800	0.3600	4	14.00	35/64		0637890	**E854M16**	
18	2.50	125	1.1810	0.5420	0.4060	4	15.50	39/64		0637906	**E854M18**	
20	2.50	140	1.1470	0.6520	0.4890	4	17.50	11/16		0637913	**E854M20**	

3) Zesílená stopka a čtyřhran / Erősített szár és lapolás / Wzmocniony chwyt / Coada si antrenor intarite / С усиленным хвостовиком и четырехгранником / Reinforced shank and square

E314 / E316

SANDVIK Coromant

E314

M | ~DIN 371 | 6H | 1.5XD | HSS-E-PM | C 2-3 | λ15° | Cool TOP

E316

M | DIN 376 | 6H | 1.5XD | HSS-E-PM | C 2-3 | λ15° | Cool TOP

- M Strojní závitník CoroTap™ P, šroubovitá drážka 15°
- M Gépi Menetfúró CoroTap™ P Csavart hornyú 15°
- M Gwintowniki maszynowe CoroTap™ P, śrubowy rowek wiórowy 15°
- M Tarozi de masina CoroTap™ P Canal elicoidal 15°
- M Машинные метчики CoroTap™ P Спиральная стружечная канавка 15°
- M Machine CoroTap™ P Spiral Flute 15°

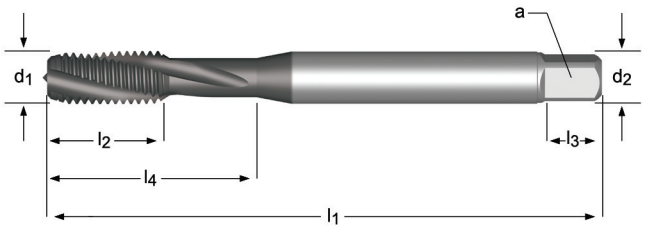
CoroTap™ 300 P

P	
P 1	- - -
P 2	9-20
P 3	9-20
P 4	- - -
P 5	9-20
Vc[m/min]	

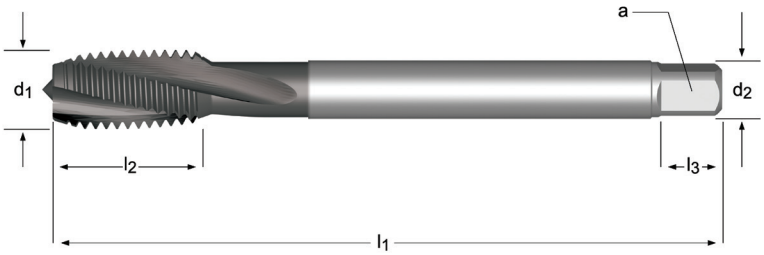
		↓ 1.5xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
Din EN 42CrMo4/ 1.7225/ SS2244 MC-code: P2.5.Z.HT 311HB	P2	M3	0.5	21	2206	1103.0
		M4	0.7	21	1655	1158.5
		M5	0.8	21	1324	1059.2
		M6	1	21	1103	1103.0
		M8	1.25	21	827	1033.8
		M10	1.5	21	662	993.0
		M12	1.75	21	552	966.0
		M16	2	18	363	726.0
		M20	2.5	17	263	657.5

		↓ 1.5xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
Toolox 44 MC-code: P2.5.Z.HT 415 HB	P2	M3	0.5	13	1428	714.0
		M4	0.7	13	1071	749.7
		M5	0.8	13	857	685.6
		M6	1	13	714	714.0
		M8	1.25	13	535	668.8
		M10	1.5	13	428	642.0
		M12	1.75	13	357	624.8
		M16	2	12	235	470.0
		M20	2.5	11	170	425.0

E314 / E316



E314



E316

M	P mm	l_1 mm	l_2 mm	d_2 Ø mm	◪ a mm	l_3 mm	z	↔	l_4 mm	E314	E316
3	0.50	63	12	4.5	3.4	6	3	2.6	21	**E314M3** [1]	
4	0.70	70	13	6.0	4.9	8	3	3.4	25	**E314M4** [1]	
5	0.80	80	15	6.0	4.9	8	3	4.3	30	**E314M5** [1]	
6	1.00	90	18	8.0	6.2	9	3	5.1	35	**E314M6** [1]	
8	1.25	100	20	10.0	8.0	11	3	6.9	39	**E314M8** [1]	
10	1.50	100	20	10.0	8.0	11	3	8.7	39	**E314M10**	
12	1.75	110	23	9.0	7.0	10	4	10.3			**E316M12**
14	2.00	110	25	11	9.0	12	4	12			**E316M14**
16	2.00	110	25	12	9	12	4	14			**E316M16**
18	2.50	125	30	14.0	11.0	14	4	15.5			**E316M18**
20	2.50	140	30	16.0	12.0	15	4	17.5			**E316M20**

[1] Zesílená stopka a čtyřhran / Erősített szár és lapolás / Wzmocniony chwyt / Coada si antrenor intarite / С усиленным хвостовиком и четырехгранником / Reinforced shank and square

M | DIN ANSI | 6H | 1.5XD | HSS-E-PM | C 2-3 | λ15° | Cool TOP

E864

- M Strojní závitník CoroTap™ P, šroubovitá drážka 15°
- M Gépi Menetfúró CoroTap™ P Csavart hornyú 15°
- M Gwintowniki maszynowe CoroTap™ P, śrubowy rowek wiórowy 15°
- M Tarozi de masina CoroTap™ P Canal elicoidal 15°
- M Машинные метчики CoroTap™ P Спиральная стружечная канавка 15°
- M Machine CoroTap™ P Spiral Flute 15°

CoroTap™ 300 P

P	
P 1	- - -
P 2	9-20
P 3	9-20
P 4	- - -
P 5	9-20
Vc[m/min]	

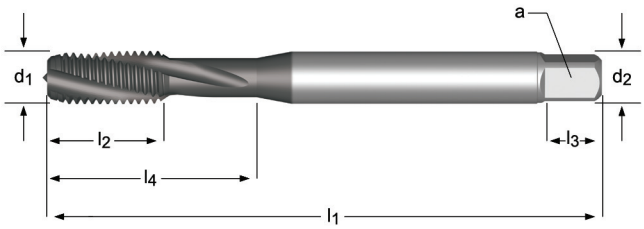
Din EN 42CrMo4/ 1.7225/ SS2244 MC-code: P2.5.Z.HT 311HB — P2

↓ 1.5xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
M3	0.5	21	2206	1103.0
M4	0.7	21	1655	1158.5
M5	0.8	21	1324	1059.2
M6	1	21	1103	1103.0
M8	1.25	21	827	1033.8
M10	1.5	21	662	993.0
M12	1.75	21	552	966.0
M16	2	18	363	726.0
M20	2.5	17	263	657.5

Toolox 44 MC-code: P2.5.Z.HT 415 HB — P2

↓ 1.5xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
M3	0.5	13	1428	714.0
M4	0.7	13	1071	749.7
M5	0.8	13	857	685.6
M6	1	13	714	714.0
M8	1.25	13	535	668.8
M10	1.5	13	428	642.0
M12	1.75	13	357	624.8
M16	2	12	235	470.0
M20	2.5	11	170	425.0

E864



M	P mm	l_1 mm	l_2 inch	d_2 Ø inch /	⧄ a inch	z	↔	↔	l_4 inch	EDP # or Stock No.	e-Code	
3	0.50	63	0.5118	0.1680	0.1310	3	2.50	N40	0.8337	0629697	**E864M3**	1)
4	0.70	70	0.5945	0.1940	0.1520	3	3.30	N30	1.1001	0629703	**E864M4**	1)
5	0.80	80	0.6693	0.2550	0.1910	3	4.20	N19	0.9996	0629710	**E864M5**	1)
6	1.00	90	0.7953	0.3180	0.2380	3	5.00	N9	1.3375	0629727	**E864M6**	1)
8	1.25	100	0.7874	0.3810	0.2860	3	6.80	H	1.4871	0629734	**E864M8**	1)
10	1.50	100	0.7874	0.3810	0.2860	3	8.50	Q	1.4871	0629741	**E864M10**	
12	1.75	110	0.9060	0.3670	0.2750	4	10.30	Y		0629758	**E864M12**	
14	2.00	110	0.9060	0.4290	0.3220	4	12.00	15/32		0637920	**E864M14**	
16	2.00	110	0.9060	0.4800	0.3600	4	14.00	35/64		0637937	**E864M16**	
18	2.50	125	1.1810	0.5420	0.4060	4	15.50	39/64		0637944	**E864M18**	
20	2.50	140	1.4170	0.6520	0.4890	4	17.50	11/16		0637951	**E864M20**	

3) Zesílená stopka a čtyřhran / Erősített szár és lapolás / Wzmocniony chwyt / Coada si antrenor intarite / С усиленным хвостовиком и четырехгранником / Reinforced shank and square

MF | DIN ANSI | 6H | 2.5XD | HSS-E-PM | B 3.5-5 | Cool TOP

E855

- MF Strojní závitník CoroTap™ P lamač třísek, přímá drážka
- MF Gépi Menetfúró CoroTap™ P Terelőéles
- MF Gwintowniki maszynowe CoroTap™ P ze skośną powierzchnią natarcia
- MF Tarozi de masina CoroTap™ P Varf spiral
- MF Машинные метчики CoroTap™ P Криволинейная задняя поверхность
- MF Machine CoroTap™ P Spiral Point

CoroTap™ 200 P

P	
P 1	- - -
P 2	9-20
P 3	9-20
P 4	- - -
P 5	9-20
Vc[m/min]	

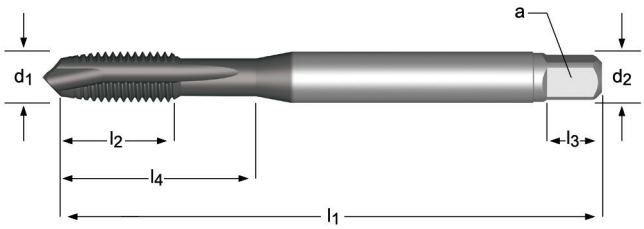
Din EN 42CrMo4/ 1.7225/ SS2244
MC-code: P2.5.Z.HT

	↓ 1.5xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2.5xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
P2	10	1	21	662	662.0	10	1	17	541	541.0	10	1	15	463	463.0
	10	1.25	21	662	827.5	10	1.25	17	541	676.3	10	1.25	15	463	578.8
	12	1	21	552	552.0	12	1	17	451	451.0	12	1	15	386	386.0
	12	1.25	21	552	690.0	12	1.25	17	451	563.8	12	1.25	15	386	482.5
	12	1.5	21	552	828.0	12	1.5	17	451	676.5	12	1.5	15	386	579.0

Toolox 44
MC-code: P2.5.Z.HT
415 HB

	↓ 1.5xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2.5xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
P2	10	1	13	428	428.0	10	1	11	350	350.0	10	1	9	300	300.0
	10	1.25	13	428	535.0	10	1.25	11	350	437.5	10	1.25	9	300	375.0
	12	1	13	357	357.0	12	1	11	292	292.0	12	1	9	250	250.0
	12	1.25	13	357	446.3	12	1.25	11	292	365.0	12	1.25	9	250	312.5
	12	1.5	13	357	535.5	12	1.5	11	292	438.0	12	1.5	9	250	375.0

E855



MF	P mm	l_1 mm	l_2 inch	d_2 Ø inch /	⧄ a inch	z			l_4 inch	EDP # or Stock No.	e-Code
10	1.25	100	0.7874	0.3810	0.2860	3	8.75	S	1.4871	0629383	**E855M10X1.25**
12	1.25	110	0.9060	0.3670	0.2750	4	10.80	27/64		0629390	**E855M12X1.25**

MF | DIN ANSI | 6H | 1.5XD | HSS-E-PM | C 2-3 | λ15° | Cool TOP

E865

- MF Strojní závitník CoroTap™ P, šroubovitá drážka 15°
- MF Gépi Menetfúró CoroTap™ P Csavart hornyú 15°
- MF Gwintowniki maszynowe CoroTap™ P, śrubowy rowek wiórowy 15°
- MF Tarozi de masina CoroTap™ P Canal elicoidal 15°
- MF Машинные метчики CoroTap™ P Спиральная стружечная канавка 15°
- MF Machine CoroTap™ P Spiral Flute 15°

CoroTap™ 300 P

P	
P 1	- - -
P 2	9-20
P 3	9-20
P 4	- - -
P 5	9-20
Vc[m/min]	

Din EN 42CrMo4/ 1.7225/ SS2244
MC-code: P2.5.Z.HT

P2

↓ 1.5xD

MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
10	1	21	662	662.0
10	1.25	21	662	827.5
12	1	21	552	552.0
12	1.25	21	552	690.0
12	1.5	21	552	828.0

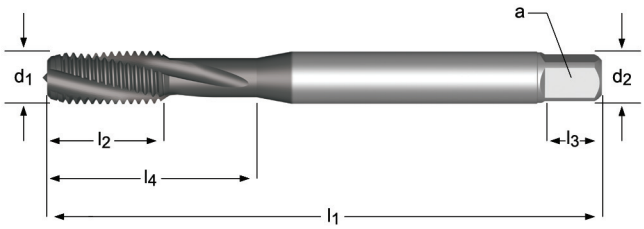
Toolox 44
MC-code: P2.5.Z.HT
415 HB

P2

↓ 1.5xD

MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
10	1	13	428	428.0
10	1.25	13	428	535.0
12	1	13	357	357.0
12	1.25	13	357	446.3
12	1.5	13	357	535.5

E865



MF	P mm	l_1 mm	l_2 inch	d_2 Ø inch /	⧄ a inch	z	↔	↔	l_4 inch	EDP # or Stock No.	e-Code
10	1.25	100	0.7874	0.3810	0.2860	3	8.75	S	1.4871	0629765	**E865M10X1.25**
12	1.25	110	0.9060	0.3670	0.2750	4	10.80	27/64		0629772	**E865M12X1.25**

UNC | DIN ANSI | 2B | 2.5XD | HSS-E-PM | B 3.5-5 | Cool TOP

E874

- UNC Strojní závitník CoroTap™ P lamač třísek, přímá drážka
- UNC Gépi Menetfúró CoroTap™ P Terelőéles
- UNC Gwintowniki maszynowe CoroTap™ P ze skośną powierzchnią natarcia
- UNC Tarozi de masina CoroTap™ P Varf spiral
- UNC Машинные метчики CoroTap™ P Криволинейная задняя поверхность
- UNC Machine CoroTap™ P Spiral Point

CoroTap™ 200 P

P	
P 1	- - -
P 2	9-20
P 3	9-20
P 4	- - -
P 5	9-20
Vc[m/min]	

Din EN 42CrMo4/ 1.7225/ SS2244 MC-code: P2.5.Z.HT 311HB

	↓ 1.5xD UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
P2	4-40	40	21	2326	1477.0
	6-32	32	21	1886	1497.0
	8-32	32	21	1587	1679.6
	10-24	24	21	1371	1451.0
	1/4	20	21	1042	1323.3
	5/16	18	21	834	1176.9
	3/8	16	21	695	1103.3
	7/16	14	21	596	1081.3
	1/2	13	20	508	992.6
	5/8	11	18	368	849.7
	3/4	10	17	282	716.3

	↓ 2xD UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
P2	4-40	40	17	1902	1207.8
	6-32	32	17	1542	1224.0
	8-32	32	17	1298	1373.7
	10-24	24	17	1121	1186.4
	1/4	20	17	852	1082.0
	5/16	18	17	682	962.4
	3/8	16	17	568	901.7
	7/16	14	17	487	883.6
	1/2	13	17	415	810.8
	5/8	11	15	301	695.0
	3/4	10	14	231	586.7

	↓ 2.5xD UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
P2	4-40	40	15	1627	1033.1
	6-32	32	15	1319	1047.0
	8-32	32	15	1110	1174.8
	10-24	24	15	959	1014.9
	1/4	20	15	729	925.8
	5/16	18	15	583	822.7
	3/8	16	15	486	771.5
	7/16	14	15	417	756.6
	1/2	13	14	355	693.6
	5/8	11	13	257	593.4
	3/4	10	12	197	500.4

Toolox 44 MC-code: P2.5.Z.HT 415 HB

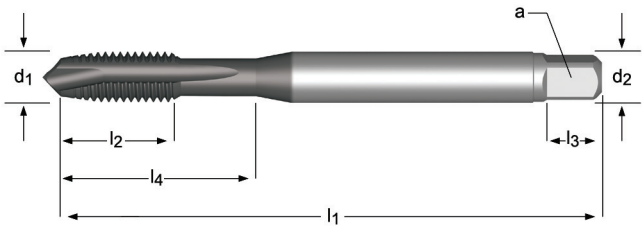
	↓ 1.5xD UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
P2	4-40	40	13	1505	955.7
	6-32	32	13	1220	968.4
	8-32	32	13	1027	1086.9
	10-24	24	13	887	938.7
	1/4	20	13	674	856.0
	5/16	18	13	539	760.6
	3/8	16	13	450	714.4
	7/16	14	13	385	698.5
	1/2	13	13	329	642.8
	5/8	11	12	238	549.6
	3/4	10	11	183	464.8

	↓ 2xD UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
P2	4-40	40	11	1231	781.7
	6-32	32	11	998	792.2
	8-32	32	11	840	889.0
	10-24	24	11	726	768.4
	1/4	20	11	551	699.8
	5/16	18	11	441	622.3
	3/8	16	11	368	584.2
	7/16	14	11	315	571.5
	1/2	13	11	269	525.6
	5/8	11	10	194	448.0
	3/4	10	9	149	378.5

	↓ 2.5xD UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
P2	4-40	40	9	1053	668.7
	6-32	32	9	853	677.1
	8-32	32	9	718	759.9
	10-24	24	9	621	657.2
	1/4	20	9	472	599.4
	5/16	18	9	377	532.0
	3/8	16	9	314	498.5
	7/16	14	9	270	489.9
	1/2	13	9	230	449.4
	5/8	11	8	166	383.3
	3/4	10	8	128	325.1

E874

P



UNC	TPI	l_1 mm	l_2 Inch	d_2 Ø Inch /	◪ a Inch	z	↔	↔	l_4 Inch	e-Code
4	40	56	0.4331	0.1410	0.1100	3	2.35	N43	0.7954	**E8744-40** [3]
5	40	56	0.4331	0.1410	0.1100	3	2.65	N38	0.7954	**E8745-40** [3]
6	32	63	0.5472	0.1680	0.1310	3	2.85	N36	0.8455	**E8746-32** [3]
8	32	70	0.5945	0.1940	0.1520	3	3.50	N29	1.1001	**E8748-32** [3]
10	24	80	0.6693	0.2550	0.1910	3	3.90	N25	0.9996	**E87410-24** [3]
1/4	20	90	0.7953	0.3180	0.2380	3	5.10	N7	1.3375	**E8741/4** [3]
5/16	18	100	0.7874	0.3810	0.2860	3	6.60	F	1.4871	**E8745/16** [3]
3/8	16	100	0.7874	0.3810	0.2860	3	8.00	5/16	1.4871	**E8743/8**
7/16	14	100	0.7870	0.3230	0.2420	4	9.40	U		**E8747/16**
1/2	13	110	0.9060	0.3670	0.2750	4	10.80	27/64		**E8741/2**
5/8	11	110	0.9060	0.4800	0.3600	4	13.50	17/32		**E8745/8**
3/4	10	125	1.1810	0.5900	0.4420	4	16.50	21/32		**E8743/4**

[3] Zesílená stopka a čtyřhran / Erősített szár és lapolásc / Wzmocniony chwyt / Coada si antrenor intarite / С усиленным хвостовиком и четырехгранником / Reinforced shank and square

UNC | DIN ANSI | 2B | 1.5XD | HSS-E-PM | C 2-3 | λ15° | Cool TOP

E884

- UNC Strojní závitník CoroTap™ P, šroubovitá drážka 15°
- UNC Gépi Menetfúró CoroTap™ P Csavart hornyú 15°
- UNC Gwintowniki maszynowe CoroTap™ P, śrubowy rowek wiórowy 15°
- UNC Tarozi de masina CoroTap™ P Canal elicoidal 15°
- UNC Машинные метчики CoroTap™ P Спиральная стружечная канавка 15°
- UNC Machine CoroTap™ P Spiral Flute 15°

CoroTap™ 300 P

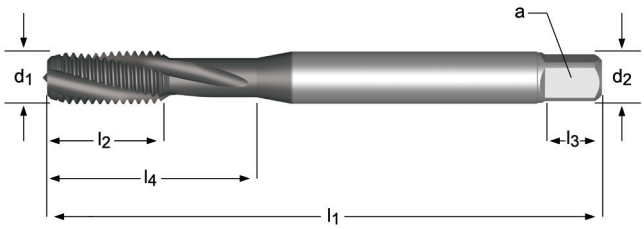
P	
P 1	- - -
P 2	**9-20**
P 3	**9-20**
P 4	- - -
P 5	**9-20**
Vc[m/min]	

		↓ 1.5xD UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
Din EN 42CrMo4/ 1.7225/ SS2244 MC-code: P2.5.Z.HT 311HB	P2	4-40	40	21	2326	1477.0
		6-32	32	21	1886	1497.0
		8-32	32	21	1587	1679.6
		10-24	24	21	1371	1451.0
		1/4	20	21	1042	1323.3
		5/16	18	21	834	1176.9
		3/8	16	21	695	1103.3
		7/16	14	21	596	1081.3
		1/2	13	20	508	992.6
		5/8	11	18	368	849.7
		3/4	10	17	282	716.3

		↓ 1.5xD UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
Toolox 44 MC-code: P2.5.Z.HT 415 HB	P2	4-40	40	13	1505	955.7
		6-32	32	13	1220	968.4
		8-32	32	13	1027	1086.9
		10-24	24	13	887	938.7
		1/4	20	13	674	856.0
		5/16	18	13	539	760.6
		3/8	16	13	450	714.4
		7/16	14	13	385	698.5
		1/2	13	13	329	642.8
		5/8	11	12	238	549.6
		3/4	10	11	183	464.8

E884

P



UNC	TPI	l_1 mm	l_2 Inch	d_2 Ø Inch /	◪ a Inch	z	↔	↔	l_4 Inch	e-Code
4	40	56	0.4331	0.1410	0.1100	3	2.35	N43	0.7954	**E8844-40** [3]
6	32	63	0.5472	0.1680	0.1310	3	2.85	N36	0.8455	**E8846-32** [3]
8	32	70	0.5945	0.1940	0.1520	3	3.50	N29	1.1001	**E8848-32** [3]
10	24	80	0.6693	0.2550	0.1910	3	3.90	N25	0.9996	**E88410-24** [3]
1/4	20	90	0.7953	0.3180	0.2380	3	5.10	N7	1.3375	**E8841/4** [3]
5/16	18	100	0.7874	0.3810	0.2860	3	6.60	F	1.4871	**E8845/16** [3]
3/8	16	100	0.7874	0.3810	0.2860	3	8.00	5/16	1.4871	**E8843/8**
7/16	14	100	0.7870	0.3230	0.2420	4	9.40	U		**E8847/16**
1/2	13	110	0.9060	0.3670	0.2750	4	10.80	27/64		**E8841/2**
5/8	11	110	0.9060	0.4800	0.3600	4	13.50	17/32		**E8845/8**
3/4	10	125	1.1810	0.5900	0.4420	4	16.50	21/32		**E8843/4**

[3] Zesílená stopka a čtyřhran / Erősített szár és lapolás / Wzmocniony chwyt / Coada si antrenor intarite / С усиленным хвостовиком и четырехгранником / Reinforced shank and square

UNF | DIN ANSI | 2B | 2.5XD | HSS-E-PM | B 3.5-5 | Cool TOP

E875

- UNF Strojní závitník CoroTap™ P lamač třísek, přímá drážka
- UNF Gépi Menetfúró CoroTap™ P Terelőéles
- UNF Gwintowniki maszynowe CoroTap™ P Ze skośną powierzchnią natarcia
- UNF Tarozi de masina CoroTap™ P Varf spiral
- UNF Машинные метчики CoroTap™ P Криволинейная задняя поверхность
- UNF Machine CoroTap™ P Spiral Point

CoroTap™ 200 P

P	
P 1	- - -
P 2	9-20
P 3	9-20
P 4	- - -
P 5	9-20
Vc[m/min]	

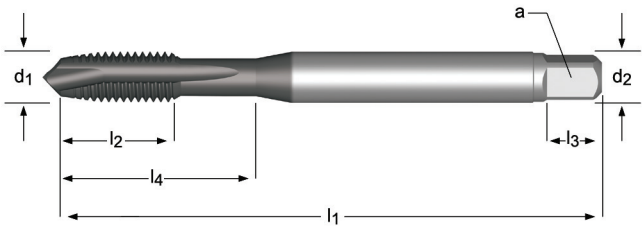
Din EN 42CrMo4/ 1.7225/ SS2244 MC-code: P2.5.Z.HT 311HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
P2	10-32	32	21	1373	1089.8	10-32	32	17	1123	891.4	10-32	32	15	960	762.0
	1/4	28	21	1042	945.2	1/4	28	17	852	772.9	1/4	28	15	729	661.3
	5/16	24	21	834	882.7	5/16	24	17	682	721.8	5/16	24	15	583	617.0
	3/8	24	21	694	734.5	3/8	24	17	568	601.1	3/8	24	15	486	514.4
	7/16	20	21	596	756.9	7/16	20	17	487	618.5	7/16	20	15	417	529.6
	1/2	20	20	508	645.2	1/2	20	17	415	527.1	1/2	20	14	355	450.9
	9/16	18	19	428	604.0	9/16	18	16	350	493.9	9/16	18	13	299	421.9
	5/8	18	18	367	517.9	5/8	18	15	300	423.3	5/8	18	13	257	362.7
	3/4	16	17	282	447.7	3/4	16	14	231	366.7	3/4	16	12	197	312.7

Toolox 44 MC-code: P2.5.Z.HT 415 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
P2	10-32	32	13	888	704.9	10-32	32	11	726	576.3	10-32	32	9	621	492.9
	1/4	28	13	674	611.4	1/4	28	11	551	499.8	1/4	28	9	472	428.2
	5/16	24	13	539	570.4	5/16	24	11	441	466.7	5/16	24	9	377	399.0
	3/8	24	13	449	475.2	3/8	24	11	367	388.4	3/8	24	9	314	332.3
	7/16	20	13	385	489.0	7/16	20	11	315	400.1	7/16	20	9	270	342.9
	1/2	20	13	329	417.8	1/2	20	11	269	341.6	1/2	20	9	230	292.1
	9/16	18	12	277	390.9	9/16	18	10	227	320.3	9/16	18	9	194	273.8
	5/8	18	12	238	335.8	5/8	18	10	194	273.8	5/8	18	8	166	234.2
	3/4	16	11	183	290.5	3/4	16	9	149	236.5	3/4	16	8	128	203.2

E875



UNF	TPI	l_1 mm	l_2 Inch	d_2 Ø Inch /	◪ a Inch	z	↔	↔	l_4 Inch	e-Code
10	32	80	0.6693	0.2550	0.1910	3	4.10	N21	0.9996	**E87510-32** [3]
1/4	28	90	0.7953	0.3180	0.2380	3	5.50	N3	1.3375	**E8751/4** [3]
5/16	24	100	0.7874	0.3810	0.2860	3	6.90	I	1.4871	**E8755/16** [3]
3/8	24	100	0.7874	0.3810	0.2860	3	8.50	Q	1.4871	**E8753/8**
7/16	20	100	0.7870	0.3230	0.2420	4	9.90	25/64		**E8757/16**
1/2	20	110	0.9060	0.3670	0.2750	4	11.50	29/64		**E8751/2**
5/8	18	110	0.9060	0.4800	0.3600	4	14.50	37/64		**E8755/8**
3/4	16	125	1.1810	0.5900	0.4420	4	17.50	11/16		**E8753/4**

[3] Zesílená stopka a čtyřhran / Erősített szár és lapolás / Wzmocniony chwyt / Coada si antrenor intarite / С усиленным хвостовиком и четырехгранником / Reinforced shank and square

UNF | DIN ANSI | 2B | 1.5XD | HSS-E-PM | C 2-3 | λ15° | Cool TOP

E885

- UNF Strojní závitník CoroTap™ P, šroubovitá drážka 15°
- UNF Gépi Menetfúró CoroTap™ P Csavart hornyú 15°
- UNF Gwintowniki maszynowe CoroTap™ P, śrubowy rowek wiórowy 15°
- UNF Tarozi de masina CoroTap™ P Canal elicoidal 15°
- UNF Машинные метчики CoroTap™ P Спиральная стружечная канавка 15°
- UNF Machine CoroTap™ P Spiral Flute 15°

CoroTap™ 300 P

P	
P 1	- - -
P 2	9-20
P 3	9-20
P 4	- - -
P 5	9-20
Vc[m/min]	

Din EN 42CrMo4/ 1.7225/ SS2244 MC-code: P2.5.Z.HT 311HB

	↓ 1.5xD UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
P2	10-32	32	21	1373	1089.8
	1/4	28	21	1042	945.2
	5/16	24	21	834	882.7
	3/8	24	21	694	734.5
	7/16	20	21	596	756.9
	1/2	20	20	508	645.2
	9/16	18	19	428	604.0
	5/8	18	18	367	517.9
	3/4	16	17	282	447.7

Din EN 42CrMo4/ 1.7225/ SS2244 MC-code: P2.5.Z.HT 311HB

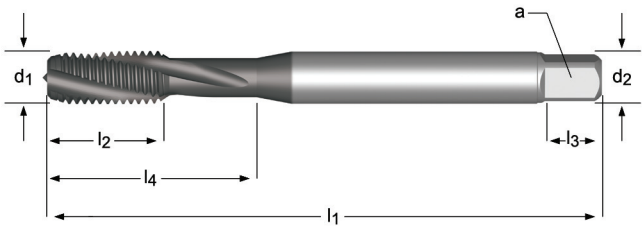
	↓ 1.5xD UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
P2	10-32	32	21	1373	1089.8
	1/4	28	21	1042	945.2
	5/16	24	21	834	882.7
	3/8	24	21	694	734.5
	7/16	20	21	596	756.9
	1/2	20	20	508	645.2
	9/16	18	19	428	604.0
	5/8	18	18	367	517.9
	3/4	16	17	282	447.7

Toolox 44 MC-code: P2.5.Z.HT 415 HB

	↓ 1.5xD UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
P2	10-32	32	13	888	704.9
	1/4	28	13	674	611.4
	5/16	24	13	539	570.4
	3/8	24	13	449	475.2
	7/16	20	13	385	489.0
	1/2	20	13	329	417.8
	9/16	18	12	277	390.9
	5/8	18	12	238	335.8
	3/4	16	11	183	290.5

Toolox 44 MC-code: P2.5.Z.HT 415 HB

	↓ 1.5xD UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
P2	10-32	32	13	888	704.9
	1/4	28	13	674	611.4
	5/16	24	13	539	570.4
	3/8	24	13	449	475.2
	7/16	20	13	385	489.0
	1/2	20	13	329	417.8
	9/16	18	12	277	390.9
	5/8	18	12	238	335.8
	3/4	16	11	183	290.5



UNF	TPI	l_1 mm	l_2 Inch	d_2 Ø Inch /	◪ a Inch	z	↔	↔	l_4 Inch	e-Code
10	32	80	0.6693	0.2550	0.1910	3	4.10	N21	0.9996	**E88510-32** [3]
1/4	28	90	0.7953	0.3180	0.2380	3	5.50	N3	1.3375	**E8851/4** [3]
5/16	24	100	0.7874	0.3810	0.2860	3	6.90	I	1.4871	**E8855/16** [3]
3/8	24	100	0.7874	0.3810	0.2860	3	8.50	Q	1.4871	**E8853/8**
7/16	20	100	0.7870	0.3230	0.2420	4	9.90	25/64		**E8857/16**
1/2	20	110	0.9060	0.3670	0.2750	4	11.50	29/64		**E8851/2**
5/8	18	110	0.9060	0.4800	0.3600	4	14.50	37/64		**E8855/8**
3/4	16	125	1.1810	0.5900	0.4420	4	17.50	11/16		**E8853/4**

[3] Zesílená stopka a čtyřhran / Erősített szár és lapolás / Wzmocniony chwyt / Coada si antrenor intarite / С усиленным хвостовиком и четырехгранником / Reinforced shank and square

M | DIN 371≤10 376≥12 | 6HX | 2.5XD | HM | C 2-3 | Cool TOP

T101

- M Strojní závitník CoroTap™ K přímá drážka
- M Gépi Menetfúró CoroTap™ K egyenes élű
- M Gwintowniki maszynowe CoroTap™ K, prosty rowek wiórowy
- M Tarozi de masina CoroTap™ K Canale drepte
- M Машинные метчики CoroTap™ K Прямая стружечная канавка
- M Machine CoroTap™ K Straight Flute

CoroTap™ 105 K

K	
K 1	30-46
K 2	20-72
K 3	30-46
K 4	- - -
K 5	26-40
Vc[m/min]	

Din EN-GJMW-350-4/ 0.8035 MC-code: K1.1.C.NS 219 HB

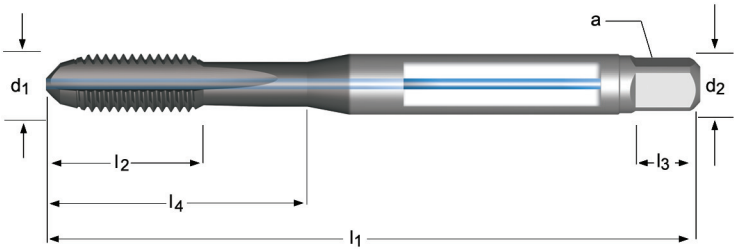
K1	↓ 1.5xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2.5xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	M5	0.8	46	2959	2367.2	M5	0.8	38	2419	1935.2	M5	0.8	33	2069	1655.2
	M6	1	46	2466	2466.0	M6	1	38	2016	2016.0	M6	1	33	1724	1724.0
	M8	1.25	46	1849	2311.3	M8	1.25	38	1512	1890.0	M8	1.25	33	1293	1616.3
	M10	1.5	46	1479	2218.5	M10	1.5	38	1210	1815.0	M10	1.5	33	1035	1552.5
	M12	1.75	46	1233	2157.8	M12	1.75	38	1008	1764.0	M12	1.75	33	862	1508.5
	M16	2	41	812	1624.0	M16	2	33	664	1328.0	M16	2	29	568	1136.0

EN-GJL-250/ 0.0625/ SS0125 MC-code: K2.1.C.UT 215 HB

K2	↓ 1.5xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2.5xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	M5	0.8	73	4672	3737.6	M5	0.8	60	3820	3056.0	M5	0.8	51	3267	2613.6
	M6	1	73	3893	3893.0	M6	1	60	3183	3183.0	M6	1	51	2723	2723.0
	M8	1.25	73	2920	3650.0	M8	1.25	60	2387	2983.8	M8	1.25	51	2042	2552.5
	M10	1.5	73	2336	3504.0	M10	1.5	60	1910	2865.0	M10	1.5	51	1634	2451.0
	M12	1.75	73	1947	3407.3	M12	1.75	60	1592	2786.0	M12	1.75	51	1361	2381.8
	M16	2	64	1283	2566.0	M16	2	53	1049	2098.0	M16	2	45	897	1794.0

EN-GJS-500/ 0.7050/ SS072 7 MC-code: K3.2.C.UT 199 HB

K3	↓ 1.5xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2.5xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	M5	0.8	46	2959	2367.2	M5	0.8	38	2419	1935.2	M5	0.8	33	2069	1655.2
	M6	1	46	2466	2466.0	M6	1	38	2016	2016.0	M6	1	33	1724	1724.0
	M8	1.25	46	1849	2311.3	M8	1.25	38	1512	1890.0	M8	1.25	33	1293	1616.3
	M10	1.5	46	1479	2218.5	M10	1.5	38	1210	1815.0	M10	1.5	33	1035	1552.5
	M12	1.75	46	1233	2157.8	M12	1.75	38	1008	1764.0	M12	1.75	33	862	1508.5
	M16	2	41	812	1624.0	M16	2	33	664	1328.0	M16	2	29	568	1136.0



M	P mm	l_1 mm	l_2 mm	d_2 Ø mm	◪ a mm	l_3 mm	z	↔	l_4 mm	e-Code
5	0.80	70	16	6	4.9	8	4	4.3		**T101M5** [4]
6	1.00	80	19	6	4.9	8	4	5.1	30	**T101M6**
8	1.25	90	22	8	6.2	9	4	6.9	35	**T101M8**
10	1.50	100	24	10	8.0	11	4	8.7	39	**T101M10**
12	1.75	110	23	9	7.0	10	4	10.4		**T101M12**
16	2.00	110	25	12	9.0	12	4	14.25		**T101M16**

[4] Bez krčku / áteso szárú / bez szyjki / fara gat / без занижения / Without neck

M | DIN 371≤10 376≥12 | 6H | 2XD | HM | C 2-3 | λ15°

T105

- M Strojní závitník CoroTap™ K, šroubovitá drážka 15°
- M Gépi Menetfúró CoroTap™ K Csavart hornyú 15°
- M Gwintowniki maszynowe CoroTap™ K, śrubowy rowek wiórowy 15°
- M Tarozi de masina CoroTap™ K Canal elicoidal 15°
- M Машинные метчики CoroTap™ K Спиральная стружечная канавка 15°
- M Machine CoroTap™ K Spiral Flute 15°

CoroTap™ 305 K

K	
K 1	20-30
K 2	12-48
K 3	20-30
K 4	- - -
K 5	12-18
Vc[m/min]	

N	
N 1.3	24-42
N 1.4	24-36
N 2	24-42
Vc[m/min]	

Din EN-GJMW-350-4/ 0.8035 MC-code: K1.1.C.NS 219 HB

	↓ 1.5xD					↓ 2xD				
	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
K1	M3	0.5	31	3244	1622.0	M3	0.5	25	2653	1326.5
	M4	0.7	31	2433	1703.1	M4	0.7	25	1989	1392.3
	M5	0.8	31	1947	1557.6	M5	0.8	25	1592	1273.6
	M6	1	31	1622	1622.0	M6	1	25	1326	1326.0
	M8	1.25	31	1217	1521.3	M8	1.25	25	995	1243.8
	M10	1.5	31	973	1459.5	M10	1.5	25	796	1194.0
	M12	1.75	31	811	1419.3	M12	1.75	25	663	1160.3

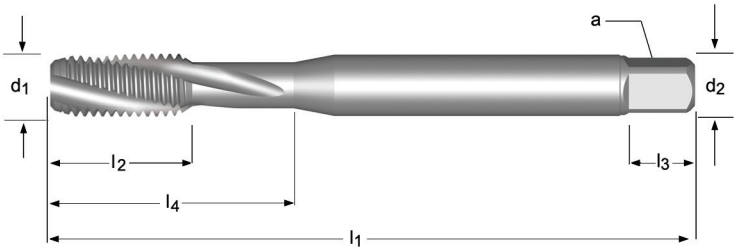
EN-GJL-250/ 0.0625/ SS0125 MC-code: K2.1.C.UT 215 HB

	↓ 1.5xD					↓ 2xD				
	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
K2	M3	0.5	49	5191	2595.5	M3	0.5	40	4244	2122.0
	M4	0.7	49	3893	2725.1	M4	0.7	40	3183	2228.1
	M5	0.8	49	3115	2492.0	M5	0.8	40	2546	2036.8
	M6	1	49	2595	2595.0	M6	1	40	2122	2122.0
	M8	1.25	49	1947	2433.8	M8	1.25	40	1592	1990.0
	M10	1.5	49	1557	2335.5	M10	1.5	40	1273	1909.5
	M12	1.75	49	1298	2271.5	M12	1.75	40	1061	1856.8

EN-GJS-500/ 0.7050/ SS072 7 MC-code: K3.2.C.UT 199 HB

	↓ 1.5xD					↓ 2xD				
	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
K3	M3	0.5	31	3244	1622.0	M3	0.5	25	2653	1326.5
	M4	0.7	31	2433	1703.1	M4	0.7	25	1989	1392.3
	M5	0.8	31	1947	1557.6	M5	0.8	25	1592	1273.6
	M6	1	31	1622	1622.0	M6	1	25	1326	1326.0
	M8	1.25	31	1217	1521.3	M8	1.25	25	995	1243.8
	M10	1.5	31	973	1459.5	M10	1.5	25	796	1194.0
	M12	1.75	31	811	1419.3	M12	1.75	25	663	1160.3

T105



M	P mm	l_1 mm	l_2 mm	d_2 Ø mm	a mm	l_3 mm	z	↔	l_4 mm	e-Code
3	0.50	56	10	3.5	2.7	6	3	2.6		**T105M3** [4]
4	0.70	63	13	4.5	3.4	6	3	3.4		**T105M4** [4]
5	0.80	70	16	6	4.9	8	3	4.3		**T105M5** [4]
6	1.00	80	19	6	4.9	8	3	5.1	30	**T105M6**
8	1.25	90	22	8	6.2	9	3	6.9	35	**T105M8**
10	1.50	100	24	10	8.0	11	3	8.7	39	**T105M10**
12	1.75	110	23	9	7.0	10	3	10.4		**T105M12**

[4] Bez krčku / áteso szárú / bez szyjki / fara gat / без занижения / Without neck

M | DIN 371≤10 376≥12 | 6H | 3XD | HM | C 2-3 | λ15°

T106

- M Strojní závitník CoroTap™ K, šroubovitá drážka 15°
- M Gépi Menetfúró CoroTap™ K Csavart hornyú 15°
- M Gwintowniki maszynowe CoroTap™ K, śrubowy rowek wiórowy 15°
- M Tarozi de masina CoroTap™ K Canal elicoidal 15°
- M Машинные метчики CoroTap™ K Спиральная стружечная канавка 15°
- M Machine CoroTap™ K Spiral Flute 15°

CoroTap™ 305 K

K	
K 1	20-30
K 2	12-48
K 3	20-30
K 4	- - -
K 5	12-18
Vc[m/min]	

N	
N 1.3	24-42
N 1.4	24-36
N 2	24-42
Vc[m/min]	

Din EN-GJMW-350-4/ 0.8035 MC-code: K1.1.C.NS 219 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
K1	M5	0.8	31	1947	1557.6	M5	0.8	25	1592	1273.6	M5	0.8	21	1361	1088.8
	M6	1	31	1622	1622.0	M6	1	25	1326	1326.0	M6	1	21	1134	1134.0
	M8	1.25	31	1217	1521.3	M8	1.25	25	995	1243.8	M8	1.25	21	851	1063.8
	M10	1.5	31	973	1459.5	M10	1.5	25	796	1194.0	M10	1.5	21	681	1021.5
	M12	1.75	31	811	1419.3	M12	1.75	25	663	1160.3	M12	1.75	21	567	992.3

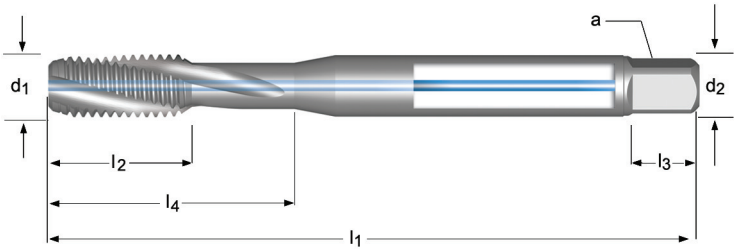
EN-GJL-250/ 0.0625/ SS0125 MC-code: K2.1.C.UT 215 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
K2	M5	0.8	49	3115	2492.0	M5	0.8	40	2546	2036.8	M5	0.8	34	2178	1742.4
	M6	1	49	2595	2595.0	M6	1	40	2122	2122.0	M6	1	34	1815	1815.0
	M8	1.25	49	1947	2433.8	M8	1.25	40	1592	1990.0	M8	1.25	34	1361	1701.3
	M10	1.5	49	1557	2335.5	M10	1.5	40	1273	1909.5	M10	1.5	34	1089	1633.5
	M12	1.75	49	1298	2271.5	M12	1.75	40	1061	1856.8	M12	1.75	34	908	1589.0

EN-GJS-500/ 0.7050/ SS072 7 MC-code: K3.2.C.UT 199 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
K3	M5	0.8	31	1947	1557.6	M5	0.8	25	1592	1273.6	M5	0.8	21	1361	1088.8
	M6	1	31	1622	1622.0	M6	1	25	1326	1326.0	M6	1	21	1134	1134.0
	M8	1.25	31	1217	1521.3	M8	1.25	25	995	1243.8	M8	1.25	21	851	1063.8
	M10	1.5	31	973	1459.5	M10	1.5	25	796	1194.0	M10	1.5	21	681	1021.5
	M12	1.75	31	811	1419.3	M12	1.75	25	663	1160.3	M12	1.75	21	567	992.3

T106



M	P mm	l_1 mm	l_2 mm	d_2 Ø mm	a mm	l_3 mm	z	↔	l_4 mm	e-Code
5	0.80	70	16	6	4.9	8	3	4.3		**T106M5** [4]
6	1.00	80	19	6	4.9	8	3	5.1	30	**T106M6**
8	1.25	90	22	8	6.2	9	3	6.9	35	**T106M8**
10	1.50	100	24	10	8.0	11	3	8.7	39	**T106M10**
12	1.75	110	23	9	7.0	10	3	10.4		**T106M12**

[4] Bez krčku / áteso szárú / bez szyjki / fara gat / без занижения / Without neck

MF | DIN 374 | 6HX | 2.5XD | HM | C 2-3 | Cool TOP

T120

- MF Strojní závitník CoroTap™ K přímá drážka
- MF Gépi Menetfúró CoroTap™ K egyenes élű
- MF Gwintowniki maszynowe CoroTap™ K, prosty rowek wiórowy
- MF Tarozi de masina CoroTap™ K Canale drepte
- MF Машинные метчики CoroTap™ K Прямая стружечная канавка
- MF Machine CoroTap™ K Straight Flute

CoroTap™ 105 K

K	
K 1	30-46
K 2	20-72
K 3	30-46
K 4	- - -
K 5	26-40
Vc[m/min]	

Din EN-GJMW-350-4/ 0.8035 MC-code: K1.1.C.NS 219 HB

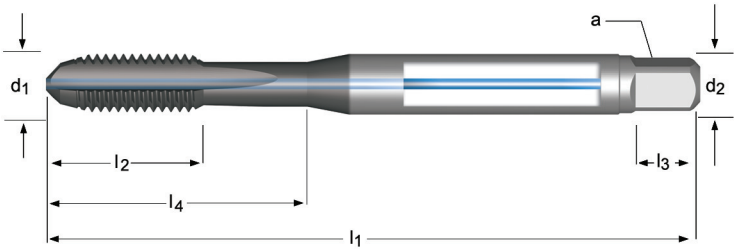
K1	↓ 1.5xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2.5xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	8	1	46	1849	1849.0	8	1	38	1512	1512.0	8	1	33	1293	1293.0
	10	1	46	1479	1479.0	10	1	38	1210	1210.0	10	1	33	1035	1035.0
	12	1.5	46	1233	1849.5	12	1.5	38	1008	1512.0	12	1.5	33	862	1293.0
	14	1.5	43	986	1479.0	14	1.5	35	806	1209.0	14	1.5	30	690	1035.0

EN-GJL-250/ 0.0625/ SS0125 MC-code: K2.1.C.UT 215 HB

K2	↓ 1.5xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2.5xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	8	1	73	2920	2920.0	8	1	60	2387	2387.0	8	1	51	2042	2042.0
	10	1	73	2336	2336.0	10	1	60	1910	1910.0	10	1	51	1634	1634.0
	12	1.5	73	1947	2920.5	12	1.5	60	1592	2388.0	12	1.5	51	1361	2041.5
	14	1.5	68	1557	2335.5	14	1.5	56	1273	1909.5	14	1.5	48	1089	1633.5

EN-GJS-500/ 0.7050/ SS072 7 MC-code: K3.2.C.UT 199 HB

K3	↓ 1.5xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2.5xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	8	1	46	1849	1849.0	8	1	38	1512	1512.0	8	1	33	1293	1293.0
	10	1	46	1479	1479.0	10	1	38	1210	1210.0	10	1	33	1035	1035.0
	12	1.5	46	1233	1849.5	12	1.5	38	1008	1512.0	12	1.5	33	862	1293.0
	14	1.5	43	986	1479.0	14	1.5	35	806	1209.0	14	1.5	30	690	1035.0



MF	P mm	l_1 mm	l_2 mm	d_2 Ø mm	◪ a mm	l_3 mm	z	↔	l_4 mm	e-Code
8	1.00	90	12	6.0	4.9	8	4	7		**T120M8X1.0**
10	1.00	90	14	7.0	5.5	8	4	9		**T120M10X1.0**
12	1.50	100	20	9.0	7.0	10	4	10.5		**T120M12X1.5**
14	1.50	100	21	11.0	9.0	12	4	12.5		**T120M14X1.5**

E446 / E447

SANDVIK Coromant

E446

M | DIN 371 | 6HX | 2XD | HSS-E-PM | C 2-3 | Cool TOP

E447

M | DIN 376 | 6HX | 2XD | HSS-E-PM | C 2-3 | Cool TOP

- M Strojní závitník CoroTap™ K přímá drážka
- M Gépi Menetfúró CoroTap™ K egyenes élű
- M Gwintowniki maszynowe CoroTap™ K, prosty rowek wiórowy
- M Tarozi de masina CoroTap™ K Canale drepte
- M Машинные метчики CoroTap™ K Прямая стружечная канавка
- M Machine CoroTap™ K Straight Flute

CoroTap™ 100 K

K	
K 1	20-30
K 2	20-38
K 3	20-30
K 4	- - -
K 5	14-22
Vc[m/min]	

Din EN-GJMW-350-4/ 0.8035
MC-code: K1.1.C.NS
219 HB

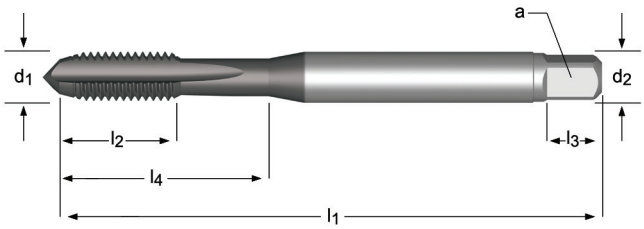
K1	↓ 1.5xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	M3	0.5	31	3244	1622.0	M3	0.5	25	2653	1326.5
	M4	0.7	31	2433	1703.1	M4	0.7	25	1989	1392.3
	M5	0.8	31	1947	1557.6	M5	0.8	25	1592	1273.6
	M6	1	31	1622	1622.0	M6	1	25	1326	1326.0
	M8	1.25	31	1217	1521.3	M8	1.25	25	995	1243.8
	M10	1.5	31	973	1459.5	M10	1.5	25	796	1194.0
	M12	1.75	31	811	1419.3	M12	1.75	25	663	1160.3
	M16	2	27	534	1068.0	M16	2	22	437	874.0
	M20	2.5	24	387	967.5	M20	2.5	20	316	790.0
	M24	3	22	297	891.0	M24	3	18	243	729.0

EN-GJL-250/ 0.0625/ SS0125
MC-code: K2.1.C.UT
215 HB

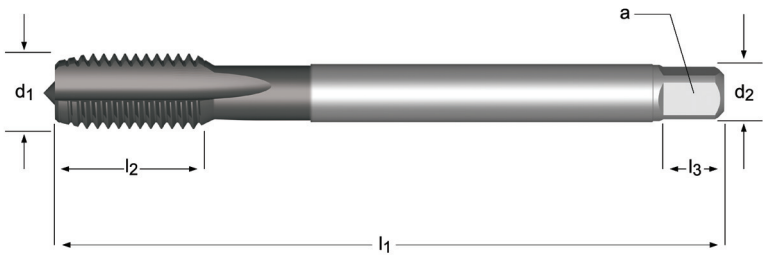
K2	↓ 1.5xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	M3	0.5	37	3893	1946.5	M3	0.5	30	3183	1591.5
	M4	0.7	37	2920	2044.0	M4	0.7	30	2387	1670.9
	M5	0.8	37	2336	1868.8	M5	0.8	30	1910	1528.0
	M6	1	37	1947	1947.0	M6	1	30	1592	1592.0
	M8	1.25	37	1460	1825.0	M8	1.25	30	1194	1492.5
	M10	1.5	37	1168	1752.0	M10	1.5	30	955	1432.5
	M12	1.75	37	973	1702.8	M12	1.75	30	796	1393.0
	M16	2	32	641	1282.0	M16	2	26	524	1048.0
	M20	2.5	29	464	1160.0	M20	2.5	24	379	947.5
	M24	3	27	356	1068.0	M24	3	22	291	873.0

EN-GJS-500/ 0.7050/ SS072 7
MC-code: K3.2.C.UT
199 HB

K3	↓ 1.5xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	M3	0.5	31	3244	1622.0	M3	0.5	25	2653	1326.5
	M4	0.7	31	2433	1703.1	M4	0.7	25	1989	1392.3
	M5	0.8	31	1947	1557.6	M5	0.8	25	1592	1273.6
	M6	1	31	1622	1622.0	M6	1	25	1326	1326.0
	M8	1.25	31	1217	1521.3	M8	1.25	25	995	1243.8
	M10	1.5	31	973	1459.5	M10	1.5	25	796	1194.0
	M12	1.75	31	811	1419.3	M12	1.75	25	663	1160.3
	M16	2	27	534	1068.0	M16	2	22	437	874.0
	M20	2.5	24	387	967.5	M20	2.5	20	316	790.0
	M24	3	22	297	891.0	M24	3	18	243	729.0



E446



E447

M	P mm	l_1 mm	l_2 mm	d_2 Ø mm	◪ a mm	l_3 mm	z	↔	l_4 mm	E446	E447
3	0.50	56	9	3.5	2.7	6	3	2.5	18	**E446M3**	
4	0.70	63	12	4.5	3.4	6	4	3.3	21	**E446M4**	
5	0.80	70	13	6.0	4.9	8	4	4.2	25	**E446M5**	
6	1.00	80	15	6.0	4.9	8	4	5	30	**E446M6**	
8	1.25	90	18	8.0	6.2	9	4	6.8	35	**E446M8**	
10	1.50	100	20	10.0	8.0	11	4	8.5	39	**E446M10**	
8	1.25	90	18	6	4.9	8	4	6.8			**E447M8**
10	1.50	100	20	7	5.5	8	4	8.5			**E447M10**
12	1.75	110	23	9	7.0	10	4	10.3			**E447M12**
14	2.00	110	25	11	9.0	12	4	12			**E447M14**
16	2.00	110	25	12	9.0	12	4	14			**E447M16**
18	2.50	125	30	14	11.0	14	4	15.5			**E447M18**
20	2.50	140	30	16	12.0	15	4	17.5			**E447M20**
22	2.50	140	34	18	14.5	17	4	19.5			**E447M22**
24	3.00	160	38	18	14.5	17	4	21			**E447M24**

E462 / E463

SANDVIK Coromant

E462 M | DIN 371 | 6HX | 2.5XD | HSS-E-PM | C 2-3 | Cool TOP

E463 M | DIN 376 | 6HX | 2.5XD | HSS-E-PM | C 2-3 | Cool TOP

- M Strojní závitník CoroTap™ K přímá drážka
- M Gépi Menetfúró CoroTap™ K egyenes élű
- M Gwintowniki maszynowe CoroTap™ K, prosty rowek wiórowy
- M Tarozi de masina CoroTap™ K Canale drepte
- M Машинные метчики CoroTap™ K Прямая стружечная канавка
- M Machine CoroTap™ K Straight Flute

CoroTap™ 100 K

K	
K 1	20-30
K 2	20-38
K 3	20-30
K 4	- - -
K 5	14-22
Vc[m/min]	

Din EN-GJMW-350-4/ 0.8035 MC-code: K1.1.C.NS 219 HB

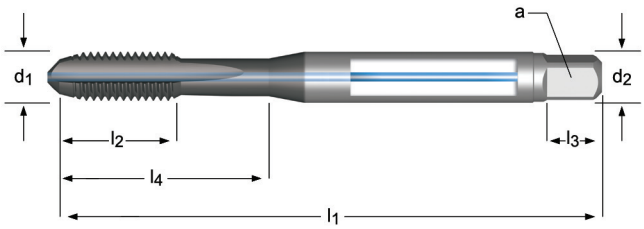
K1	↓ 1.5xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2.5xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	M6	1	31	1622	1622.0	M6	1	25	1326	1326.0	M6	1	21	1134	1134.0
	M8	1.25	31	1217	1521.3	M8	1.25	25	995	1243.8	M8	1.25	21	851	1063.8
	M10	1.5	31	973	1459.5	M10	1.5	25	796	1194.0	M10	1.5	21	681	1021.5
	M12	1.75	31	811	1419.3	M12	1.75	25	663	1160.3	M12	1.75	21	567	992.3
	M16	2	27	534	1068.0	M16	2	22	437	874.0	M16	2	19	374	748.0
	M20	2.5	24	387	967.5	M20	2.5	20	316	790.0	M20	2.5	17	270	675.0

EN-GJL-250/ 0.0625/ SS0125 MC-code: K2.1.C.UT 215 HB

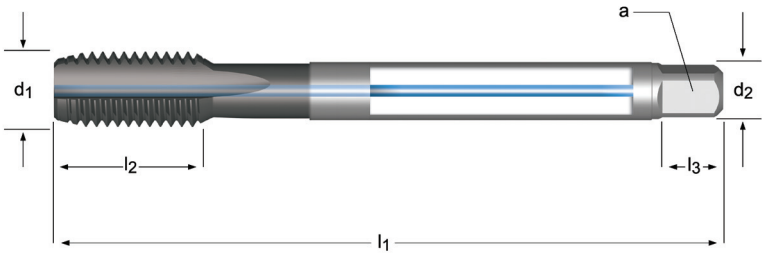
K2	↓ 1.5xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2.5xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	M6	1	37	1947	1947.0	M6	1	30	1592	1592.0	M6	1	26	1361	1361.0
	M8	1.25	37	1460	1825.0	M8	1.25	30	1194	1492.5	M8	1.25	26	1021	1276.3
	M10	1.5	37	1168	1752.0	M10	1.5	30	955	1432.5	M10	1.5	26	817	1225.5
	M12	1.75	37	973	1702.8	M12	1.75	30	796	1393.0	M12	1.75	26	681	1191.8
	M16	2	32	641	1282.0	M16	2	26	524	1048.0	M16	2	23	449	898.0
	M20	2.5	29	464	1160.0	M20	2.5	24	379	947.5	M20	2.5	20	325	812.5

EN-GJS-500/ 0.7050/ SS072 7 MC-code: K3.2.C.UT 199 HB

K3	↓ 1.5xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2.5xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	M6	1	31	1622	1622.0	M6	1	25	1326	1326.0	M6	1	21	1134	1134.0
	M8	1.25	31	1217	1521.3	M8	1.25	25	995	1243.8	M8	1.25	21	851	1063.8
	M10	1.5	31	973	1459.5	M10	1.5	25	796	1194.0	M10	1.5	21	681	1021.5
	M12	1.75	31	811	1419.3	M12	1.75	25	663	1160.3	M12	1.75	21	567	992.3
	M16	2	27	534	1068.0	M16	2	22	437	874.0	M16	2	19	374	748.0
	M20	2.5	24	387	967.5	M20	2.5	20	316	790.0	M20	2.5	17	270	675.0



E462



E463

M	P mm	l_1 mm	l_2 mm	d_2 Ø mm	⧄ a mm	l_3 mm	z	↔	l_4 mm	e-Code	
6	1.00	80	15	6.0	4.9	8	4	5	30	**E462M6**	
8	1.25	90	18	8.0	6.2	9	4	6.8	35	**E462M8**	
10	1.50	100	20	10.0	8.0	11	4	8.5	39	**E462M10**	
12	1.75	110	23	9.0	7.0	10	4	10.3			**E463M12**
14	2.00	110	25	11.0	9.0	12	4	12			**E463M14**
16	2.00	110	25	12.0	9.0	12	4	14			**E463M16**
20	2.50	140	30	16.0	12.0	15	4	17.5			**E463M20**

M | DIN ANSI | 6HX | 2XD | HSS-E-PM | C 2-3 | Cool TOP

E835

- M Strojní závitník CoroTap™ K přímá drážka
- M Gépi Menetfúró CoroTap™ K egyenes élű
- M Gwintowniki maszynowe CoroTap™ K, prosty rowek wiórowy
- M Tarozi de masina CoroTap™ K Canale drepte
- M Машинные метчики CoroTap™ K Прямая стружечная канавка
- M Machine CoroTap™ K Straight Flute

CoroTap™ 100 K

K	
K 1	20-30
K 2	20-38
K 3	20-30
K 4	- - -
K 5	14-22
Vc[m/min]	

Din EN-GJMW-350-4/ 0.8035
MC-code: K1.1.C.NS
219 HB

K1	↓ 1.5xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	M3	0.5	31	3244	1622.0	M3	0.5	25	2653	1326.5
	M4	0.7	31	2433	1703.1	M4	0.7	25	1989	1392.3
	M5	0.8	31	1947	1557.6	M5	0.8	25	1592	1273.6
	M6	1	31	1622	1622.0	M6	1	25	1326	1326.0
	M8	1.25	31	1217	1521.3	M8	1.25	25	995	1243.8
	M10	1.5	31	973	1459.5	M10	1.5	25	796	1194.0
	M12	1.75	31	811	1419.3	M12	1.75	25	663	1160.3
	M16	2	27	534	1068.0	M16	2	22	437	874.0
	M20	2.5	24	387	967.5	M20	2.5	20	316	790.0
	M24	3	22	297	891.0	M24	3	18	243	729.0

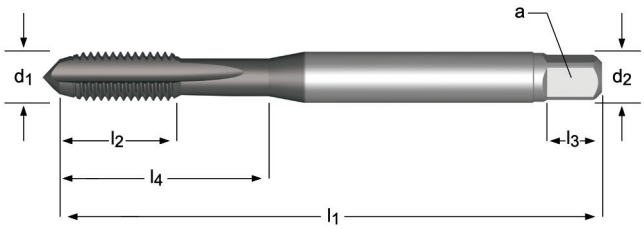
EN-GJL-250/ 0.0625/ SS0125
MC-code: K2.1.C.UT
215 HB

K2	↓ 1.5xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	M3	0.5	37	3893	1946.5	M3	0.5	30	3183	1591.5
	M4	0.7	37	2920	2044.0	M4	0.7	30	2387	1670.9
	M5	0.8	37	2336	1868.8	M5	0.8	30	1910	1528.0
	M6	1	37	1947	1947.0	M6	1	30	1592	1592.0
	M8	1.25	37	1460	1825.0	M8	1.25	30	1194	1492.5
	M10	1.5	37	1168	1752.0	M10	1.5	30	955	1432.5
	M12	1.75	37	973	1702.8	M12	1.75	30	796	1393.0
	M16	2	32	641	1282.0	M16	2	26	524	1048.0
	M20	2.5	29	464	1160.0	M20	2.5	24	379	947.5
	M24	3	27	356	1068.0	M24	3	22	291	873.0

EN-GJS-500/ 0.7050/ SS0727
MC-code: K3.2.C.UT
199 HB

K3	↓ 1.5xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	M3	0.5	31	3244	1622.0	M3	0.5	25	2653	1326.5
	M4	0.7	31	2433	1703.1	M4	0.7	25	1989	1392.3
	M5	0.8	31	1947	1557.6	M5	0.8	25	1592	1273.6
	M6	1	31	1622	1622.0	M6	1	25	1326	1326.0
	M8	1.25	31	1217	1521.3	M8	1.25	25	995	1243.8
	M10	1.5	31	973	1459.5	M10	1.5	25	796	1194.0
	M12	1.75	31	811	1419.3	M12	1.75	25	663	1160.3
	M16	2	27	534	1068.0	M16	2	22	437	874.0
	M20	2.5	24	387	967.5	M20	2.5	20	316	790.0
	M24	3	22	297	891.0	M24	3	18	243	729.0

E835



M	P mm	l_1 mm	l_2 inch	d_2 Ø inch /	◪ a inch	z	↔	↔	l_4 inch	EDP # or Stock No.	e-Code
6	1.00	80	0.5906	0.2550	0.1910	4	N9	5.00	0.9681	0632659	**E835M6**
8	1.25	90	0.7087	0.3180	0.2380	4	H	6.80	1.3060	0632666	**E835M8**
10	1.50	100	0.7874	0.3810	0.2860	4	Q	8.50	1.4871	0632673	**E835M10**
12	1.75	110	0.9060	0.3670	0.2750	4	Y	10.30		0632680	**E835M12**
14	2.00	110	0.9060	0.4290	0.3220	4	15/32	12.00		0632697	**E835M14**
16	2.00	110	0.9060	0.4800	0.3600	4	35/64	14.00		0632703	**E835M16**
18	2.50	125	1.1810	0.5420	0.4060	4	39/64	15.50		0632710	**E835M18**

M | DIN ANSI | 6HX | 2XD | HSS-E-PM | E 1.5-2 | Cool TOP

E825

- M Strojní závitník CoroTap™ K přímá drážka
- M Gépi Menetfúró CoroTap™ K egyenes élű
- M Gwintowniki maszynowe CoroTap™ K, prosty rowek wiórowy
- M Tarozi de masina CoroTap™ K Canale drepte
- M Машинные метчики CoroTap™ K Прямая стружечная канавка
- M Machine CoroTap™ K Straight Flute

CoroTap™ 100 K

K	
K 1	20-30
K 2	20-38
K 3	20-30
K 4	- - -
K 5	14-22
Vc[m/min]	

Din EN-GJMW-350-4/ 0.8035
MC-code: K1.1.C.NS
219 HB

K1	↓ 1.5xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	M3	0.5	31	3244	1622.0	M3	0.5	25	2653	1326.5
	M4	0.7	31	2433	1703.1	M4	0.7	25	1989	1392.3
	M5	0.8	31	1947	1557.6	M5	0.8	25	1592	1273.6
	M6	1	31	1622	1622.0	M6	1	25	1326	1326.0
	M8	1.25	31	1217	1521.3	M8	1.25	25	995	1243.8
	M10	1.5	31	973	1459.5	M10	1.5	25	796	1194.0
	M12	1.75	31	811	1419.3	M12	1.75	25	663	1160.3
	M16	2	27	534	1068.0	M16	2	22	437	874.0
	M20	2.5	24	387	967.5	M20	2.5	20	316	790.0
	M24	3	22	297	891.0	M24	3	18	243	729.0

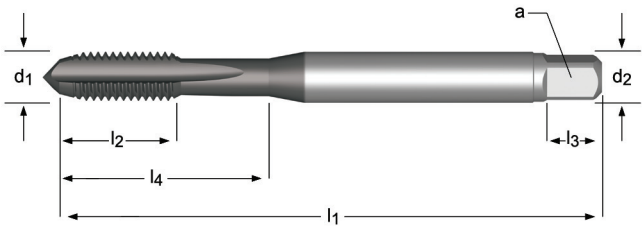
EN-GJL-250/ 0.0625/ SS0125
MC-code: K2.1.C.UT
215 HB

K2	↓ 1.5xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	M3	0.5	37	3893	1946.5	M3	0.5	30	3183	1591.5
	M4	0.7	37	2920	2044.0	M4	0.7	30	2387	1670.9
	M5	0.8	37	2336	1868.8	M5	0.8	30	1910	1528.0
	M6	1	37	1947	1947.0	M6	1	30	1592	1592.0
	M8	1.25	37	1460	1825.0	M8	1.25	30	1194	1492.5
	M10	1.5	37	1168	1752.0	M10	1.5	30	955	1432.5
	M12	1.75	37	973	1702.8	M12	1.75	30	796	1393.0
	M16	2	32	641	1282.0	M16	2	26	524	1048.0
	M20	2.5	29	464	1160.0	M20	2.5	24	379	947.5
	M24	3	27	356	1068.0	M24	3	22	291	873.0

EN-GJS-500/ 0.7050/ SS0727
MC-code: K3.2.C.UT
199 HB

K3	↓ 1.5xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2xD M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	M3	0.5	31	3244	1622.0	M3	0.5	25	2653	1326.5
	M4	0.7	31	2433	1703.1	M4	0.7	25	1989	1392.3
	M5	0.8	31	1947	1557.6	M5	0.8	25	1592	1273.6
	M6	1	31	1622	1622.0	M6	1	25	1326	1326.0
	M8	1.25	31	1217	1521.3	M8	1.25	25	995	1243.8
	M10	1.5	31	973	1459.5	M10	1.5	25	796	1194.0
	M12	1.75	31	811	1419.3	M12	1.75	25	663	1160.3
	M16	2	27	534	1068.0	M16	2	22	437	874.0
	M20	2.5	24	387	967.5	M20	2.5	20	316	790.0
	M24	3	22	297	891.0	M24	3	18	243	729.0

E825



M	P mm	l_1 mm	l_2 inch	d_2 Ø inch /	◪ a inch	z	↔	↔	l_4 inch	EDP # or Stock No.	e-Code
6	1.00	80	0.5910	0.2550	0.1910	4	N9	5.00	1.0073	46067056	**E825M6**
8	1.25	90	0.7090	0.3180	0.2380	4	H	6.80	1.1891	46067057	**E825M8**
10	1.50	100	0.7870	0.3810	0.2860	4	Q	8.50	1.2915	46067051	**E825M10**
12	1.75	110	0.9060	0.3670	0.2750	4	Y	10.30		46067052	**E825M12**
14	2.00	110	0.9060	0.4290	0.3220	4	15/32	12.00		46067053	**E825M14**
16	2.00	110	0.9060	0.4800	0.3600	4	35/64	14.00		46067054	**E825M16**
18	2.50	125	1.1810	0.5420	0.4060	4	39/64	15.50		46067055	**E825M18**

M | DIN ANSI | 6HX | 2.5XD | HSS-E-PM | C 2-3 | Cool TOP

E837

- M Strojní závitník CoroTap™ K přímá drážka
- M Gépi Menetfúró CoroTap™ K egyenes élű
- M Gwintowniki maszynowe CoroTap™ K, prosty rowek wiórowy
- M Tarozi de masina CoroTap™ K Canale drepte
- M Машинные метчики CoroTap™ K Прямая стружечная канавка
- M Machine CoroTap™ K Straight Flute

CoroTap™ 100 K

K	
K 1	20-30
K 2	20-38
K 3	20-30
K 4	- - -
K 5	14-22
Vc[m/min]	

Din EN-GJMW-350-4/ 0.8035 MC-code: K1.1.C.NS 219 HB

	↓ 1.5xD				↓ 2xD				↓ 2.5xD			
	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
K1	M6	1	31	1622	1622.0	M6	1	25	1326	1326.0	M6	1	21	1134	1134.0
	M8	1.25	31	1217	1521.3	M8	1.25	25	995	1243.8	M8	1.25	21	851	1063.8
	M10	1.5	31	973	1459.5	M10	1.5	25	796	1194.0	M10	1.5	21	681	1021.5
	M12	1.75	31	811	1419.3	M12	1.75	25	663	1160.3	M12	1.75	21	567	992.3
	M16	2	27	534	1068.0	M16	2	22	437	874.0	M16	2	19	374	748.0
	M20	2.5	24	387	967.5	M20	2.5	20	316	790.0	M20	2.5	17	270	675.0

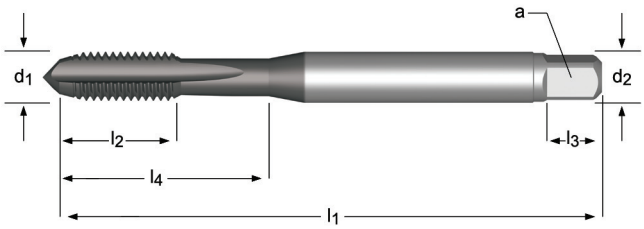
EN-GJL-250/ 0.0625/ SS0125 MC-code: K2.1.C.UT 215 HB

	↓ 1.5xD				↓ 2xD				↓ 2.5xD			
	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
K2	M6	1	37	1947	1947.0	M6	1	30	1592	1592.0	M6	1	26	1361	1361.0
	M8	1.25	37	1460	1825.0	M8	1.25	30	1194	1492.5	M8	1.25	26	1021	1276.3
	M10	1.5	37	1168	1752.0	M10	1.5	30	955	1432.5	M10	1.5	26	817	1225.5
	M12	1.75	37	973	1702.8	M12	1.75	30	796	1393.0	M12	1.75	26	681	1191.8
	M16	2	32	641	1282.0	M16	2	26	524	1048.0	M16	2	23	449	898.0
	M20	2.5	29	464	1160.0	M20	2.5	24	379	947.5	M20	2.5	20	325	812.5

EN-GJS-500/ 0.7050/ SS072 7 MC-code: K3.2.C.UT 199 HB

	↓ 1.5xD				↓ 2xD				↓ 2.5xD			
	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
K3	M6	1	31	1622	1622.0	M6	1	25	1326	1326.0	M6	1	21	1134	1134.0
	M8	1.25	31	1217	1521.3	M8	1.25	25	995	1243.8	M8	1.25	21	851	1063.8
	M10	1.5	31	973	1459.5	M10	1.5	25	796	1194.0	M10	1.5	21	681	1021.5
	M12	1.75	31	811	1419.3	M12	1.75	25	663	1160.3	M12	1.75	21	567	992.3
	M16	2	27	534	1068.0	M16	2	22	437	874.0	M16	2	19	374	748.0
	M20	2.5	24	387	967.5	M20	2.5	20	316	790.0	M20	2.5	17	270	675.0

E837



M	P mm	l_1 mm	l_2 inch	d_2 Ø inch /	◪ a inch	z	↔	↔	l_4 inch	EDP # or Stock No.	e-Code
6	1.00	80	0.5910	0.2550	0.1910	4	N9	5.00	1.0073	0632772	**E837M6**
8	1.25	90	0.7090	0.3180	0.2380	4	H	6.80	1.1891	0632789	**E837M8**
10	1.50	100	0.7870	0.3810	0.2860	4	Q	8.50	1.2915	0632796	**E837M10**
12	1.75	110	0.9060	0.3670	0.2750	4	Y	10.30		0632802	**E837M12**
14	2.00	110	0.9060	0.4290	0.3220	4	15/32	12.00		0632819	**E837M14**
16	2.00	110	0.9060	0.4800	0.3600	4	35/64	14.00		0632826	**E837M16**
20	2.50	140	1.1810	0.6520	0.4890	4	11/16	17.50		0632833	**E837M20**

M | DIN ANSI | 6HX | 2.5XD | HSS-E-PM | E 1.5-2 | Cool TOP

E827

- M Strojní závitník CoroTap™ K přímá drážka
- M Gépi Menetfúró CoroTap™ K egyenes élű
- M Gwintowniki maszynowe CoroTap™ K, prosty rowek wiórowy
- M Tarozi de masina CoroTap™ K Canale drepte
- M Машинные метчики CoroTap™ K Прямая стружечная канавка
- M Machine CoroTap™ K Straight Flute

CoroTap™ 100 K

K	
K 1	20-30
K 2	20-38
K 3	20-30
K 4	- - -
K 5	14-22
Vc[m/min]	

Din EN-GJMW-350-4/ 0.8035 MC-code: K1.1.C.NS 219 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
K1	M6	1	31	1622	1622.0	M6	1	25	1326	1326.0	M6	1	21	1134	1134.0
	M8	1.25	31	1217	1521.3	M8	1.25	25	995	1243.8	M8	1.25	21	851	1063.8
	M10	1.5	31	973	1459.5	M10	1.5	25	796	1194.0	M10	1.5	21	681	1021.5
	M12	1.75	31	811	1419.3	M12	1.75	25	663	1160.3	M12	1.75	21	567	992.3
	M16	2	27	534	1068.0	M16	2	22	437	874.0	M16	2	19	374	748.0
	M20	2.5	24	387	967.5	M20	2.5	20	316	790.0	M20	2.5	17	270	675.0

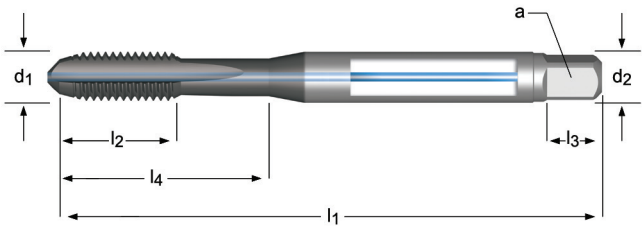
EN-GJL-250/ 0.0625/ SS0125 MC-code: K2.1.C.UT 215 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
K2	M6	1	37	1947	1947.0	M6	1	30	1592	1592.0	M6	1	26	1361	1361.0
	M8	1.25	37	1460	1825.0	M8	1.25	30	1194	1492.5	M8	1.25	26	1021	1276.3
	M10	1.5	37	1168	1752.0	M10	1.5	30	955	1432.5	M10	1.5	26	817	1225.5
	M12	1.75	37	973	1702.8	M12	1.75	30	796	1393.0	M12	1.75	26	681	1191.8
	M16	2	32	641	1282.0	M16	2	26	524	1048.0	M16	2	23	449	898.0
	M20	2.5	29	464	1160.0	M20	2.5	24	379	947.5	M20	2.5	20	325	812.5

EN-GJS-500/ 0.7050/ SS072 7 MC-code: K3.2.C.UT 199 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
K3	M6	1	31	1622	1622.0	M6	1	25	1326	1326.0	M6	1	21	1134	1134.0
	M8	1.25	31	1217	1521.3	M8	1.25	25	995	1243.8	M8	1.25	21	851	1063.8
	M10	1.5	31	973	1459.5	M10	1.5	25	796	1194.0	M10	1.5	21	681	1021.5
	M12	1.75	31	811	1419.3	M12	1.75	25	663	1160.3	M12	1.75	21	567	992.3
	M16	2	27	534	1068.0	M16	2	22	437	874.0	M16	2	19	374	748.0
	M20	2.5	24	387	967.5	M20	2.5	20	316	790.0	M20	2.5	17	270	675.0

E827



M	P mm	l_1 mm	l_2 inch	d_2 Ø inch /	⧄ a inch	z	↔	↔	l_4 inch	EDP # or Stock No.	e-Code
6	1.00	80	0.5910	0.2550	0.1910	4	N9	5.00	1.0073	46067063	**E827M6**
8	1.25	90	0.7090	0.3180	0.2380	4	H	6.80	1.1891	46067064	**E827M8**
10	1.50	100	0.7870	0.3810	0.2860	4	Q	8.50	1.2915	46067058	**E827M10**
12	1.75	110	0.9060	0.3670	0.2750	4	Y	10.30		46067059	**E827M12**
14	2.00	110	0.9060	0.4290	0.3220	4	15/32	12.00		46067060	**E827M14**
16	2.00	110	0.9060	0.4800	0.3600	4	35/64	14.00		46067061	**E827M16**
20	2.50	140	1.1810	0.6520	0.4890	4	11/16	17.50		46067062	**E827M20**

M | ISO 529 | 6HX | 2XD | HSS-E | C 2-3 | Cool TOP

E053

- M Strojní závitník CoroTap™ K přímá drážka
- M Gépi Menetfúró CoroTap™ K egyenes élű
- M Gwintowniki maszynowe CoroTap™ K, prosty rowek wiórowy
- M Tarozi de masina CoroTap™ K Canale drepte
- M Машинные метчики CoroTap™ K Прямая стружечная канавка
- M Machine CoroTap™ K Straight Flute

CoroTap™ 100 K

K	
K 1	20-30
K 2	20-38
K 3	20-30
K 4	- - -
K 5	14-22
Vc[m/min]	

Din EN-GJMW-350-4/ 0.8035 MC-code: K1.1.C.NS 219 HB

	↓ 1.5xD					↓ 2xD				
	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
K1	M3	0.5	31	3244	1622.0	M3	0.5	25	2653	1326.5
	M4	0.7	31	2433	1703.1	M4	0.7	25	1989	1392.3
	M5	0.8	31	1947	1557.6	M5	0.8	25	1592	1273.6
	M6	1	31	1622	1622.0	M6	1	25	1326	1326.0
	M8	1.25	31	1217	1521.3	M8	1.25	25	995	1243.8
	M10	1.5	31	973	1459.5	M10	1.5	25	796	1194.0
	M12	1.75	31	811	1419.3	M12	1.75	25	663	1160.3
	M16	2	27	534	1068.0	M16	2	22	437	874.0
	M20	2.5	24	387	967.5	M20	2.5	20	316	790.0

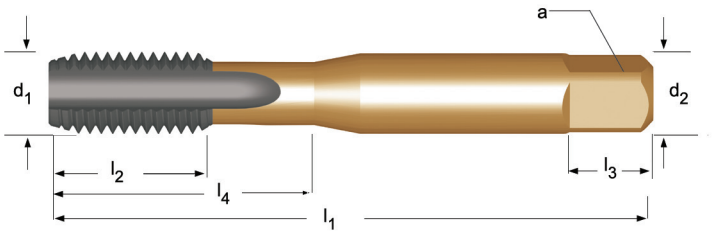
EN-GJL-250/ 0.0625/ SS0125 MC-code: K2.1.C.UT 215 HB

	↓ 1.5xD					↓ 2xD				
	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
K2	M3	0.5	37	3893	1946.5	M3	0.5	30	3183	1591.5
	M4	0.7	37	2920	2044.0	M4	0.7	30	2387	1670.9
	M5	0.8	37	2336	1868.8	M5	0.8	30	1910	1528.0
	M6	1	37	1947	1947.0	M6	1	30	1592	1592.0
	M8	1.25	37	1460	1825.0	M8	1.25	30	1194	1492.5
	M10	1.5	37	1168	1752.0	M10	1.5	30	955	1432.5
	M12	1.75	37	973	1702.8	M12	1.75	30	796	1393.0
	M16	2	32	641	1282.0	M16	2	26	524	1048.0
	M20	2.5	29	464	1160.0	M20	2.5	24	379	947.5

EN-GJS-500/ 0.7050/ SS072 7 MC-code: K3.2.C.UT 199 HB

	↓ 1.5xD					↓ 2xD				
	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]	M	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
K3	M3	0.5	31	3244	1622.0	M3	0.5	25	2653	1326.5
	M4	0.7	31	2433	1703.1	M4	0.7	25	1989	1392.3
	M5	0.8	31	1947	1557.6	M5	0.8	25	1592	1273.6
	M6	1	31	1622	1622.0	M6	1	25	1326	1326.0
	M8	1.25	31	1217	1521.3	M8	1.25	25	995	1243.8
	M10	1.5	31	973	1459.5	M10	1.5	25	796	1194.0
	M12	1.75	31	811	1419.3	M12	1.75	25	663	1160.3
	M16	2	27	534	1068.0	M16	2	22	437	874.0
	M20	2.5	24	387	967.5	M20	2.5	20	316	790.0

E053



M	P mm	l_1 mm	l_2 mm	d_2 Ø mm	⧄ a mm	l_3 mm	z	↔	l_4 mm	e-Code
3	0.50	48	12.5	3.15	2.50	5	3	2.5	12.5	**E053M3**
4	0.70	53	14	4.00	3.15	6	4	3.3	14	**E053M4**
5	0.80	58	11	5.00	4.00	7	4	4.2	22	**E053M5**
6	1.00	66	13	6.30	5.00	8	4	5	26	**E053M6**
8	1.25	72	16	8.00	6.30	9	4	6.8	29	**E053M8**
10	1.50	80	18	10.00	8.00	11	4	8.5	34	**E053M10**
12	1.75	89	22	9.00	7.10	10	4	10.3		**E053M12**
14	2.00	95	24	11.20	9.00	12	4	12		**E053M14**
16	2.00	102	24	12.50	10.00	13	4	14		**E053M16**
20	2.50	112	29	14.00	11.20	14	4	17.5		**E053M20**

MF | DIN 374 | 6HX | 2XD | HSS-E-PM | C 2-3 | N

E269

- MF Strojní závitník CoroTap™ K přímá drážka
- MF Gépi Menetfúró CoroTap™ K egyenes élű
- MF Gwintowniki maszynowe CoroTap™ K, prosty rowek wiórowy
- MF Tarozi de masina CoroTap™ K Canale drepte
- MF Машинные метчики CoroTap™ K Прямая стружечная канавка
- MF Machine CoroTap™ K Straight Flute

CoroTap™ 100 K

K	
K 1	12-18
K 2	16-24
K 3	12-18
K 4	- - -
K 5	6-10
Vc[m/min]	

Din EN-GJMW-350-4/ 0.8035 MC-code: K1.1.C.NS 219 HB

K1	↓ 1.5xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	10	1	18	584	584.0
	10	1.25	18	584	730.0
	12	1	18	487	487.0
	12	1.25	18	487	608.8
	12	1.5	18	487	730.5
	14	1.5	17	389	583.5
	16	1.5	16	321	481.5
	18	1.5	15	270	405.0
	20	1.5	15	232	348.0

K1	↓ 2xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	10	1	15	477	477.0
	10	1.25	15	477	596.3
	12	1	15	398	398.0
	12	1.25	15	398	497.5
	12	1.5	15	398	597.0
	14	1.5	14	318	477.0
	16	1.5	13	262	393.0
	18	1.5	12	221	331.5
	20	1.5	12	190	285.0

EN-GJL-250/ 0.0625/ SS0125 MC-code: K2.1.C.UT 215 HB

K2	↓ 1.5xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	10	1	24	779	779.0
	10	1.25	24	779	973.8
	12	1	24	649	649.0
	12	1.25	24	649	811.3
	12	1.5	24	649	973.5
	14	1.5	23	519	778.5
	16	1.5	21	428	642.0
	18	1.5	20	360	540.0
	20	1.5	19	309	463.5

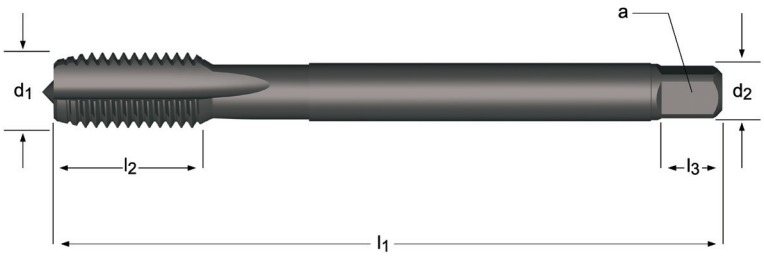
K2	↓ 2xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	10	1	20	637	637.0
	10	1.25	20	637	796.3
	12	1	20	531	531.0
	12	1.25	20	531	663.8
	12	1.5	20	531	796.5
	14	1.5	19	424	636.0
	16	1.5	18	350	525.0
	18	1.5	17	295	442.5
	20	1.5	16	253	379.5

EN-GJS-500/ 0.7050/ SS0727 MC-code: K3.2.C.UT 199 HB

K3	↓ 1.5xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	10	1	18	584	584.0
	10	1.25	18	584	730.0
	12	1	18	487	487.0
	12	1.25	18	487	608.8
	12	1.5	18	487	730.5
	14	1.5	17	389	583.5
	16	1.5	16	321	481.5
	18	1.5	15	270	405.0
	20	1.5	15	232	348.0

K3	↓ 2xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	10	1	15	477	477.0
	10	1.25	15	477	596.3
	12	1	15	398	398.0
	12	1.25	15	398	497.5
	12	1.5	15	398	597.0
	14	1.5	14	318	477.0
	16	1.5	13	262	393.0
	18	1.5	12	221	331.5
	20	1.5	12	190	285.0

E269



MF	P mm	l_1 mm	l_2 mm	d_2 Ø mm	◪ a mm	l_3 mm	z	↔	e-Code
10	1.00	90	20	7	5.5	8	4	9	**E269M10X1.0**
10	1.25	100	20	7	5.5	8	4	8.8	**E269M10X1.25**
12	1.25	100	21	9	7.0	10	4	10.8	**E269M12X1.25**
12	1.50	100	21	9	7.0	10	4	10.5	**E269M12X1.5**
14	1.50	100	21	11	9.0	12	4	12.5	**E269M14X1.5**
16	1.50	100	21	12	9.0	12	4	14.5	**E269M16X1.5**
18	1.50	110	24	14	11.0	14	4	16.5	**E269M18X1.5**
20	1.50	125	24	16	12.0	15	4	18.5	**E269M20X1.5**

MF | DIN ANSI | 6HX | 2XD | HSS-E-PM | C 2-3 | Cool TOP

E836

- MF Strojní závitník CoroTap™ K přímá drážka
- MF Gépi Menetfúró CoroTap™ K egyenes élű
- MF Gwintowniki maszynowe CoroTap™ K, prosty rowek wiórowy
- MF Tarozi de masina CoroTap™ K Canale drepte
- MF Машинные метчики CoroTap™ K Прямая стружечная канавка
- MF Machine CoroTap™ K Straight Flute

CoroTap™ 100 K

K	
K 1	20-30
K 2	20-38
K 3	20-30
K 4	- - -
K 5	14-22
Vc[m/min]	

Din EN-GJMW-350-4/ 0.8035 MC-code: K1.1.C.NS 219 HB

	↓ 1.5xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
K1	8	1	31	1217	1217.0
	10	1	31	973	973.0
	10	1.25	31	973	1216.3
	12	1	31	811	811.0
	12	1.25	31	811	1013.8
	12	1.5	31	811	1216.5
	14	1.5	29	649	973.5

	↓ 2xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
K1	8	1	25	995	995.0
	10	1	25	796	796.0
	10	1.25	25	796	995.0
	12	1	25	663	663.0
	12	1.25	25	663	828.8
	12	1.5	25	663	994.5
	14	1.5	23	530	795.0

EN-GJL-250/ 0.0625/ SS0125 MC-code: K2.1.C.UT 215 HB

	↓ 1.5xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
K2	8	1	37	1460	1460.0
	10	1	37	1168	1168.0
	10	1.25	37	1168	1460.0
	12	1	37	973	973.0
	12	1.25	37	973	1216.3
	12	1.5	37	973	1459.5
	14	1.5	34	778	1167.0

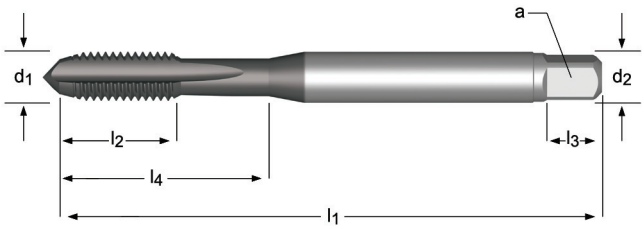
	↓ 2xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
K2	8	1	30	1194	1194.0
	10	1	30	955	955.0
	10	1.25	30	955	1193.8
	12	1	30	796	796.0
	12	1.25	30	796	995.0
	12	1.5	30	796	1194.0
	14	1.5	28	636	954.0

EN-GJS-500/ 0.7050/ SS072 7 MC-code: K3.2.C.UT 199 HB

	↓ 1.5xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
K3	8	1	31	1217	1217.0
	10	1	31	973	973.0
	10	1.25	31	973	1216.3
	12	1	31	811	811.0
	12	1.25	31	811	1013.8
	12	1.5	31	811	1216.5
	14	1.5	29	649	973.5

	↓ 2xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
K3	8	1	25	995	995.0
	10	1	25	796	796.0
	10	1.25	25	796	995.0
	12	1	25	663	663.0
	12	1.25	25	663	828.8
	12	1.5	25	663	994.5
	14	1.5	23	530	795.0

E836



MF	P mm	l_1 mm	l_2 inch	d_2 Ø inch /	⧄ a inch	z	↔	↔	l_4 inch	EDP # or Stock No.	e-Code
10	1.00	100	0.7874	0.3810	0.2860	4	T	9.10	1.4871	0632727	**E836M10X1.0**
10	1.25	100	0.7874	0.3810	0.2860	4	S	8.75	1.4871	0632734	**E836M10X1.25**
12	1.25	110	0.9060	0.3670	0.2750	4	27/64	10.80		0632741	**E836M12X1.25**
12	1.50	110	0.9060	0.3670	0.2750	4	27/64	10.60		0632758	**E836M12X1.5**
14	1.50	110	0.9060	0.4290	0.3220	4	31/64	12.50		0632765	**E836M14X1.5**

MF | DIN ANSI | 6HX | 2XD | HSS-E-PM | C 2-3 | Cool TOP

E838

- MF Strojní závitník CoroTap™ K přímá drážka
- MF Gépi Menetfúró CoroTap™ K egyenes élű
- MF Gwintowniki maszynowe CoroTap™ K, prosty rowek wiórowy
- MF Tarozi de masina CoroTap™ K Canale drepte
- MF Машинные метчики CoroTap™ K Прямая стружечная канавка
- MF Machine CoroTap™ K Straight Flute

CoroTap™ 100 K

K	
K 1	20-30
K 2	20-38
K 3	20-30
K 4	- - -
K 5	14-22
Vc[m/min]	

Din EN-GJMW-350-4/ 0.8035 MC-code: K1.1.C.NS 219 HB

	↓ 1.5xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
K1	8	1	31	1217	1217.0
	10	1	31	973	973.0
	10	1.25	31	973	1216.3
	12	1	31	811	811.0
	12	1.25	31	811	1013.8
	12	1.5	31	811	1216.5
	14	1.5	29	649	973.5

	↓ 2xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
K1	8	1	25	995	995.0
	10	1	25	796	796.0
	10	1.25	25	796	995.0
	12	1	25	663	663.0
	12	1.25	25	663	828.8
	12	1.5	25	663	994.5
	14	1.5	23	530	795.0

EN-GJL-250/ 0.0625/ SS0125 MC-code: K2.1.C.UT 215 HB

	↓ 1.5xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
K2	8	1	37	1460	1460.0
	10	1	37	1168	1168.0
	10	1.25	37	1168	1460.0
	12	1	37	973	973.0
	12	1.25	37	973	1216.3
	12	1.5	37	973	1459.5
	14	1.5	34	778	1167.0

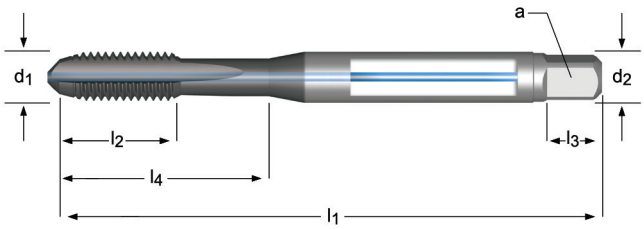
	↓ 2xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
K2	8	1	30	1194	1194.0
	10	1	30	955	955.0
	10	1.25	30	955	1193.8
	12	1	30	796	796.0
	12	1.25	30	796	995.0
	12	1.5	30	796	1194.0
	14	1.5	28	636	954.0

EN-GJS-500/ 0.7050/ SS072 7 MC-code: K3.2.C.UT 199 HB

	↓ 1.5xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
K3	8	1	31	1217	1217.0
	10	1	31	973	973.0
	10	1.25	31	973	1216.3
	12	1	31	811	811.0
	12	1.25	31	811	1013.8
	12	1.5	31	811	1216.5
	14	1.5	29	649	973.5

	↓ 2xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
K3	8	1	25	995	995.0
	10	1	25	796	796.0
	10	1.25	25	796	995.0
	12	1	25	663	663.0
	12	1.25	25	663	828.8
	12	1.5	25	663	994.5
	14	1.5	23	530	795.0

E838



MF	P mm	l_1 mm	l_2 inch	d_2 Ø inch /	◪ a inch	z	↔	↔	l_4 inch	EDP # or Stock No.	e-Code
10	1.25	100	0.7870	0.3810	0.2860	4	S	8.75	1.2915	0632840	**E838M10X1.25**
12	1.50	110	0.9060	0.3670	0.2750	4	27/64	10.60		0632857	**E838M12X1.5**
14	1.50	110	0.9060	0.4290	0.3220	4	31/64	12.50		0632864	**E838M14X1.5**

MF | ISO 529 | 6HX | 2XD | HSS-E | C 2-3 | Cool TOP

E054

- MF Strojní závitník CoroTap™ K přímá drážka
- MF Gépi Menetfúró CoroTap™ K egyenes élű
- MF Gwintowniki maszynowe CoroTap™ K, prosty rowek wiórowy
- MF Tarozi de masina CoroTap™ K Canale drepte
- MF Машинные метчики CoroTap™ K Прямая стружечная канавка
- MF Machine CoroTap™ K Straight Flute

CoroTap™ 100 K

K	
K 1	20-30
K 2	20-38
K 3	20-30
K 4	- - -
K 5	14-22
Vc[m/min]	

Din EN-GJMW-350-4/ 0.8035 MC-code: K1.1.C.NS 219 HB

K1	↓ 1.5xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	8	1	31	1217	1217.0
	10	1	31	973	973.0
	10	1.25	31	973	1216.3
	12	1	31	811	811.0
	12	1.25	31	811	1013.8
	12	1.5	31	811	1216.5
	14	1.5	29	649	973.5

K1	↓ 2xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	8	1	25	995	995.0
	10	1	25	796	796.0
	10	1.25	25	796	995.0
	12	1	25	663	663.0
	12	1.25	25	663	828.8
	12	1.5	25	663	994.5
	14	1.5	23	530	795.0

EN-GJL-250/ 0.0625/ SS0125 MC-code: K2.1.C.UT 215 HB

K2	↓ 1.5xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	8	1	37	1460	1460.0
	10	1	37	1168	1168.0
	10	1.25	37	1168	1460.0
	12	1	37	973	973.0
	12	1.25	37	973	1216.3
	12	1.5	37	973	1459.5
	14	1.5	34	778	1167.0

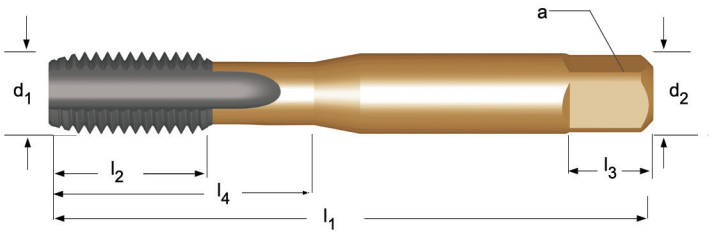
K2	↓ 2xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	8	1	30	1194	1194.0
	10	1	30	955	955.0
	10	1.25	30	955	1193.8
	12	1	30	796	796.0
	12	1.25	30	796	995.0
	12	1.5	30	796	1194.0
	14	1.5	28	636	954.0

EN-GJS-500/ 0.7050/ SS072 7 MC-code: K3.2.C.UT 199 HB

K3	↓ 1.5xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	8	1	31	1217	1217.0
	10	1	31	973	973.0
	10	1.25	31	973	1216.3
	12	1	31	811	811.0
	12	1.25	31	811	1013.8
	12	1.5	31	811	1216.5
	14	1.5	29	649	973.5

K3	↓ 2xD MF	TP	Vc [m/min]	N [rpm]	Vf [mm/min]
	8	1	25	995	995.0
	10	1	25	796	796.0
	10	1.25	25	796	995.0
	12	1	25	663	663.0
	12	1.25	25	663	828.8
	12	1.5	25	663	994.5
	14	1.5	23	530	795.0

E054



MF	P mm	l_1 mm	l_2 mm	d_2 Ø mm	⧄ a mm	l_3 mm	z	↔	l_4 mm	e-Code
8	1.00	72	16	8.00	6.30	9	4	7	29	**E054M8X1.0**
10	1.00	80	18	10.00	8.00	11	4	9	34	**E054M10X1.0**
10	1.25	80	18	10.00	8.00	11	4	8.8	34	**E054M10X1.25**
12	1.00	89	22	9.00	7.10	10	4	11		**E054M12X1.0**
12	1.25	89	22	9.00	7.10	10	4	10.8		**E054M12X1.25**
12	1.50	89	22	9.00	7.10	10	4	10.5		**E054M12X1.5**
14	1.25	95	24	11.20	9.00	12	4	12.8		**E054M14X1.25**
14	1.50	95	24	11.20	9.00	12	4	12.5		**E054M14X1.5**
16	1.50	102	24	12.50	10.00	13	4	14.5		**E054M16X1.5**

UNC | DIN ANSI | 2BX | 2XD | HSS-E-PM | C 2-3 | Cool TOP

E830

- UNC Strojní závitník CoroTap™ K přímá drážka
- UNC Gépi Menetfúró CoroTap™ K egyenes élű
- UNC Gwintowniki maszynowe CoroTap™ K, prosty rowek wiórowy
- UNC Tarozi de masina CoroTap™ K Canale drepte
- UNC Машинные метчики CoroTap™ K Прямая стружечная канавка
- UNC Machine CoroTap™ K Straight Flute

CoroTap™ 100 K

K	
K 1	20-30
K 2	20-38
K 3	20-30
K 4	- - -
K 5	14-22
Vc[m/min]	

Din EN-GJMW-350-4/ 0.8035 MC-code: K1.1.C.NS 219 HB

K1	↓ 1.5xD UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2xD UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
	1/4	20	31	1533	1946.9	1/4	20	25	1253	1591.3
	5/16	18	31	1226	1730.0	5/16	18	25	1002	1413.9
	3/8	16	31	1022	1622.4	3/8	16	25	835	1325.6
	7/16	14	31	876	1589.3	7/16	14	25	716	1299.0
	1/2	13	30	747	1459.5	1/2	13	24	611	1193.8
	5/8	11	27	541	1249.2	5/8	11	22	442	1020.6
	3/4	10	25	415	1054.1	3/4	10	20	339	861.1
	7/8	9	23	332	937.0	7/8	9	19	271	764.8

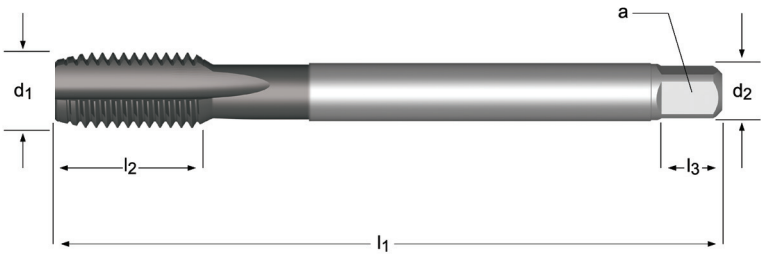
EN-GJL-250/ 0.0625/ SS0125 MC-code: K2.1.C.UT 215 HB

K2	↓ 1.5xD UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2xD UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
	1/4	20	37	1839	2335.5	1/4	20	30	1504	1910.1
	5/16	18	37	1471	2075.7	5/16	18	30	1203	1697.6
	3/8	16	37	1226	1946.3	3/8	16	30	1003	1592.3
	7/16	14	37	1051	1906.8	7/16	14	30	859	1558.5
	1/2	13	36	896	1750.6	1/2	13	29	733	1432.2
	5/8	11	32	649	1498.6	5/8	11	26	530	1223.8
	3/4	10	30	498	1264.9	3/4	10	24	407	1033.8
	7/8	9	28	398	1123.2	7/8	9	23	326	920.0

EN-GJS-500/ 0.7050/ SS072 7 MC-code: K3.2.C.UT 199 HB

K3	↓ 1.5xD UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2xD UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
	1/4	20	31	1533	1946.9	1/4	20	25	1253	1591.3
	5/16	18	31	1226	1730.0	5/16	18	25	1002	1413.9
	3/8	16	31	1022	1622.4	3/8	16	25	835	1325.6
	7/16	14	31	876	1589.3	7/16	14	25	716	1299.0
	1/2	13	30	747	1459.5	1/2	13	24	611	1193.8
	5/8	11	27	541	1249.2	5/8	11	22	442	1020.6
	3/4	10	25	415	1054.1	3/4	10	20	339	861.1
	7/8	9	23	332	937.0	7/8	9	19	271	764.8

E830



UNC	TPI	l_1 mm	l_2 Inch	d_2 Ø Inch /	◪ a Inch	z	↔	↔	l_4 Inch	e-Code
1/4	20	80	0.5906	0.2550	0.1910	4	N7	5.10	0.9681	**E8301/4**
5/16	18	90	0.7087	0.3180	0.2380	4	F	6.60	1.3060	**E8305/16**
3/8	16	100	0.7874	0.3810	0.2860	4	5/16	8.00	1.4871	**E8303/8**
7/16	14	100	0.7890	0.3230	0.2420	4	U	9.40		**E8307/16**
1/2	13	110	0.9060	0.3670	0.2750	4	27/64	10.80		**E8301/2**
5/8	11	110	0.9060	0.4800	0.3600	4	17/32	13.50		**E8305/8**
3/4	10	125	1.1810	0.5900	0.4420	4	21/32	16.50		**E8303/4**
7/8	9	140	1.3385	0.6970	0.5230	4	49/64	19.50		**E8307/8**

UNC | DIN ANSI | 2BX | 2XD | HSS-E-PM | E 1.5-2 | Cool TOP

E839

- UNC Strojní závitník CoroTap™ K přímá drážka
- UNC Gépi Menetfúró CoroTap™ K egyenes élű
- UNC Gwintowniki maszynowe CoroTap™ K, prosty rowek wiórowy
- UNC Tarozi de masina CoroTap™ K Canale drepte
- UNC Машинные метчики CoroTap™ K Прямая стружечная канавка
- UNC Machine CoroTap™ K Straight Flute

CoroTap™ 100 K

K	
K 1	20-30
K 2	20-38
K 3	20-30
K 4	- - -
K 5	14-22

Din EN-GJMW-350-4/ 0.8035 MC-code: K1.1.C.NS 219 HB

	↓ 1.5xD					↓ 2xD				
	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
K1	1/4	20	31	1533	1946.9	1/4	20	25	1253	1591.3
	5/16	18	31	1226	1730.0	5/16	18	25	1002	1413.9
	3/8	16	31	1022	1622.4	3/8	16	25	835	1325.6
	7/16	14	31	876	1589.3	7/16	14	25	716	1299.0
	1/2	13	30	747	1459.5	1/2	13	24	611	1193.8
	5/8	11	27	541	1249.2	5/8	11	22	442	1020.6
	3/4	10	25	415	1054.1	3/4	10	20	339	861.1
	7/8	9	23	332	937.0	7/8	9	19	271	764.8

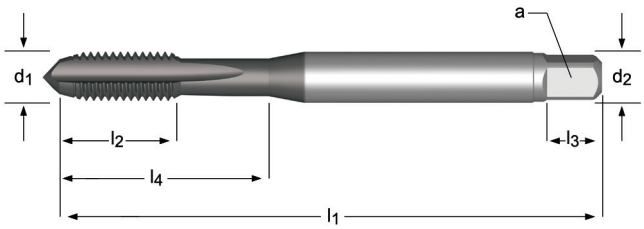
EN-GJL-250/ 0.0625/ SS0125 MC-code: K2.1.C.UT 215 HB

	↓ 1.5xD					↓ 2xD				
	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
K2	1/4	20	37	1839	2335.5	1/4	20	30	1504	1910.1
	5/16	18	37	1471	2075.7	5/16	18	30	1203	1697.6
	3/8	16	37	1226	1946.3	3/8	16	30	1003	1592.3
	7/16	14	37	1051	1906.8	7/16	14	30	859	1558.5
	1/2	13	36	896	1750.6	1/2	13	29	733	1432.2
	5/8	11	32	649	1498.6	5/8	11	26	530	1223.8
	3/4	10	30	498	1264.9	3/4	10	24	407	1033.8
	7/8	9	28	398	1123.2	7/8	9	23	326	920.0

EN-GJS-500/ 0.7050/ SS072 7 MC-code: K3.2.C.UT 199 HB

	↓ 1.5xD					↓ 2xD				
	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
K3	1/4	20	31	1533	1946.9	1/4	20	25	1253	1591.3
	5/16	18	31	1226	1730.0	5/16	18	25	1002	1413.9
	3/8	16	31	1022	1622.4	3/8	16	25	835	1325.6
	7/16	14	31	876	1589.3	7/16	14	25	716	1299.0
	1/2	13	30	747	1459.5	1/2	13	24	611	1193.8
	5/8	11	27	541	1249.2	5/8	11	22	442	1020.6
	3/4	10	25	415	1054.1	3/4	10	20	339	861.1
	7/8	9	23	332	937.0	7/8	9	19	271	764.8

E839



UNC	TPI	l_1 mm	l_2 Inch	d_2 Ø Inch /	⧄ a Inch	z	↔	↔	l_4	e-Code
1/4	20	80	0.5910	0.2550	0.1910	4	N7	5.10	1.0073	**E8391/4**
5/16	18	90	0.7090	0.3180	0.2380	4	F	6.60	1.1891	**E8395/16**
3/8	16	100	0.7870	0.3810	0.2869	4	5/16	8.00	1.2915	**E8393/8**
7/16	14	100	0.7870	0.3230	0.2420	4	U	9.40		**E8397/16**
1/2	13	110	0.9060	0.3670	0.2750	4	27/64	10.80		**E8391/2**
5/8	11	110	0.9060	0.4800	0.3600	4	17/32	13.50		**E8395/8**
3/4	10	125	1.1810	0.5900	0.4420	4	21/32	16.50		**E8393/4**
7/8	9	140	1.3385	0.6970	0.5230	4	49/64	19.50		**E8397/8**

UNC | DIN ANSI | 2BX | 2.5XD | HSS-E-PM | C 2-3 | Cool TOP

E832

- UNC Strojní závitník CoroTap™ K přímá drážka
- UNC Gépi Menetfúró CoroTap™ K egyenes élű
- UNC Gwintowniki maszynowe CoroTap™ K, prosty rowek wiórowy
- UNC Tarozi de masina CoroTap™ K Canale drepte
- UNC Машинные метчики CoroTap™ K Прямая стружечная канавка
- UNC Machine CoroTap™ K Straight Flute

CoroTap™ 100 K

K	
K 1	20-30
K 2	20-38
K 3	20-30
K 4	- - -
K 5	14-22
Vc[m/min]	

Din EN-GJMW-350-4/ 0.8035 MC-code: K1.1.C.NS 219 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
K1	1/4	20	31	1533	1946.9	1/4	20	25	1253	1591.3	1/4	20	21	1072	1361.4
	5/16	18	31	1226	1730.0	5/16	18	25	1002	1413.9	5/16	18	21	858	1210.7
	3/8	16	31	1022	1622.4	3/8	16	25	835	1325.6	3/8	16	21	715	1135.1
	7/16	14	31	876	1589.3	7/16	14	25	716	1299.0	7/16	14	21	613	1112.2
	1/2	13	30	747	1459.5	1/2	13	24	611	1193.8	1/2	13	21	522	1019.9

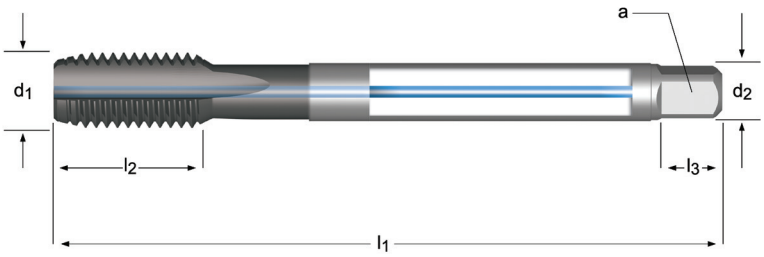
EN-GJL-250/ 0.0625/ SS0125 MC-code: K2.1.C.UT 215 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
K2	1/4	20	37	1839	2335.5	1/4	20	30	1504	1910.1	1/4	20	26	1286	1633.2
	5/16	18	37	1471	2075.7	5/16	18	30	1203	1697.6	5/16	18	26	1029	1452.0
	3/8	16	37	1226	1946.3	3/8	16	30	1003	1592.3	3/8	16	26	858	1362.1
	7/16	14	37	1051	1906.8	7/16	14	30	859	1558.5	7/16	14	26	735	1333.5
	1/2	13	36	896	1750.6	1/2	13	29	733	1432.2	1/2	13	25	627	1225.1

EN-GJS-500/ 0.7050/ SS072 7 MC-code: K3.2.C.UT 199 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
K3	1/4	20	31	1533	1946.9	1/4	20	25	1253	1591.3	1/4	20	21	1072	1361.4
	5/16	18	31	1226	1730.0	5/16	18	25	1002	1413.9	5/16	18	21	858	1210.7
	3/8	16	31	1022	1622.4	3/8	16	25	835	1325.6	3/8	16	21	715	1135.1
	7/16	14	31	876	1589.3	7/16	14	25	716	1299.0	7/16	14	21	613	1112.2
	1/2	13	30	747	1459.5	1/2	13	24	611	1193.8	1/2	13	21	522	1019.9

E832



UNC	TPI	l_1 mm	l_2 Inch	d_2 Ø Inch /	◪ a Inch	z	↔	↔	l_4 Inch	e-Code
1/4	20	80	0.5910	0.2550	0.1910	4	N7	5.10	1.0073	**E8321/4**
5/16	18	90	0.7090	0.3180	0.2380	4	F	6.60	1.1891	**E8325/16**
3/8	16	100	0.7870	0.3810	0.2860	4	5/16	8.00	1.2915	**E8323/8**
7/16	14	100	0.7870	0.3230	0.2420	4	U	9.40		**E8327/16**
1/2	13	110	0.9060	0.3670	0.2750	4	27/64	10.80		**E8321/2**

UNC | DIN ANSI | 2BX | 2.5XD | HSS-E-PM | E 1.5-2 | Cool TOP

E822

- UNC Strojní závitník CoroTap™ K přímá drážka
- UNC Gépi Menetfúró CoroTap™ K egyenes élű
- UNC Gwintowniki maszynowe CoroTap™ K Prosty Rowek Wiórowy
- UNC Tarozi de masina CoroTap™ K Canale drepte
- UNC Машинные метчики CoroTap™ K Прямая стружечная канавка
- UNC Machine CoroTap™ K Straight Flute

CoroTap™ 100 K

K	
K 1	20-30
K 2	20-38
K 3	20-30
K 4	- - -
K 5	14-22

Din EN-GJMW-350-4/ 0.8035 MC-code: K1.1.C.NS 219 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
K1	1/4	20	31	1533	1946.9	1/4	20	25	1253	1591.3	1/4	20	21	1072	1361.4
	5/16	18	31	1226	1730.0	5/16	18	25	1002	1413.9	5/16	18	21	858	1210.7
	3/8	16	31	1022	1622.4	3/8	16	25	835	1325.6	3/8	16	21	715	1135.1
	7/16	14	31	876	1589.3	7/16	14	25	716	1299.0	7/16	14	21	613	1112.2
	1/2	13	30	747	1459.5	1/2	13	24	611	1193.8	1/2	13	21	522	1019.9

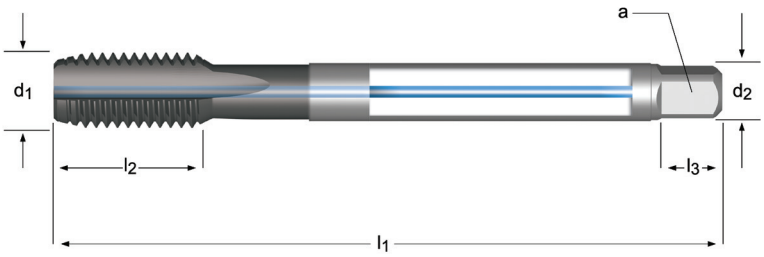
EN-GJL-250/ 0.0625/ SS0125 MC-code: K2.1.C.UT 215 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
K2	1/4	20	37	1839	2335.5	1/4	20	30	1504	1910.1	1/4	20	26	1286	1633.2
	5/16	18	37	1471	2075.7	5/16	18	30	1203	1697.6	5/16	18	26	1029	1452.0
	3/8	16	37	1226	1946.3	3/8	16	30	1003	1592.3	3/8	16	26	858	1362.1
	7/16	14	37	1051	1906.8	7/16	14	30	859	1558.5	7/16	14	26	735	1333.5
	1/2	13	36	896	1750.6	1/2	13	29	733	1432.2	1/2	13	25	627	1225.1

EN-GJS-500/ 0.7050/ SS072 7 MC-code: K3.2.C.UT 199 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
K3	1/4	20	31	1533	1946.9	1/4	20	25	1253	1591.3	1/4	20	21	1072	1361.4
	5/16	18	31	1226	1730.0	5/16	18	25	1002	1413.9	5/16	18	21	858	1210.7
	3/8	16	31	1022	1622.4	3/8	16	25	835	1325.6	3/8	16	21	715	1135.1
	7/16	14	31	876	1589.3	7/16	14	25	716	1299.0	7/16	14	21	613	1112.2
	1/2	13	30	747	1459.5	1/2	13	24	611	1193.8	1/2	13	21	522	1019.9

E822



UNC	TPI	l_1 mm	l_2 Inch	d_2 Ø Inch /	⧄ a Inch	z	↔	↔	l_4	e-Code
1/4	20	80	0.5910	0.2550	0.1910	4	N7	5.10	1.0073	**E8221/4**
5/16	18	90	0.7090	0.3180	0.2380	4	F	6.60	1.1891	**E8225/16**
3/8	16	100	0.7870	0.3810	0.2869	4	5/16	8.00	1.2915	**E8223/8**
7/16	14	100	0.7870	0.3230	0.2420	4	U	9.40		**E8227/16**
1/2	13	110	0.9060	0.3670	0.2750	4	27/64	10.80		**E8221/2**

UNC | ISO 529 | 2B | 2XD | HSS-E | C 2-3 | Cool TOP

E059

- UNC Strojní závitník CoroTap™ K přímá drážka
- UNC Gépi Menetfúró CoroTap™ K egyenes élű
- UNC Gwintowniki maszynowe CoroTap™ K Prosty Rowek Wiórowy
- UNC Tarozi de masina CoroTap™ K Canale drepte
- UNC Машинные метчики CoroTap™ K Прямая стружечная канавка
- UNC Machine CoroTap™ K Straight Flute

CoroTap™ 100 K

K	
K 1	20-30
K 2	20-38
K 3	20-30
K 4	- - -
K 5	14-22
Vc[m/min]	

Din EN-GJMW-350-4/ 0.8035 MC-code: K1.1.C.NS 219 HB

K1	↓ 1.5xD UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2xD UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
	1/4	20	31	1533	1946.9	1/4	20	25	1253	1591.3
	5/16	18	31	1226	1730.0	5/16	18	25	1002	1413.9
	3/8	16	31	1022	1622.4	3/8	16	25	835	1325.6
	7/16	14	31	876	1589.3	7/16	14	25	716	1299.0
	1/2	13	30	747	1459.5	1/2	13	24	611	1193.8
	5/8	11	27	541	1249.2	5/8	11	22	442	1020.6
	3/4	10	25	415	1054.1	3/4	10	20	339	861.1

EN-GJL-250/ 0.0625/ SS0125 MC-code: K2.1.C.UT 215 HB

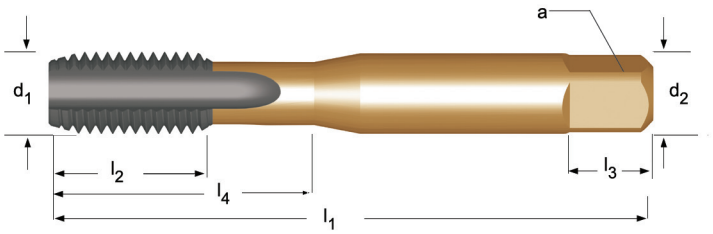
K2	↓ 1.5xD UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2xD UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
	1/4	20	37	1839	2335.5	1/4	20	30	1504	1910.1
	5/16	18	37	1471	2075.7	5/16	18	30	1203	1697.6
	3/8	16	37	1226	1946.3	3/8	16	30	1003	1592.3
	7/16	14	37	1051	1906.8	7/16	14	30	859	1558.5
	1/2	13	36	896	1750.6	1/2	13	29	733	1432.2
	5/8	11	32	649	1498.6	5/8	11	26	530	1223.8
	3/4	10	30	498	1264.9	3/4	10	24	407	1033.8

EN-GJS-500/ 0.7050/ SS072 7 MC-code: K3.2.C.UT 199 HB

K3	↓ 1.5xD UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2xD UNC	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
	1/4	20	31	1533	1946.9	1/4	20	25	1253	1591.3
	5/16	18	31	1226	1730.0	5/16	18	25	1002	1413.9
	3/8	16	31	1022	1622.4	3/8	16	25	835	1325.6
	7/16	14	31	876	1589.3	7/16	14	25	716	1299.0
	1/2	13	30	747	1459.5	1/2	13	24	611	1193.8
	5/8	11	27	541	1249.2	5/8	11	22	442	1020.6
	3/4	10	25	415	1054.1	3/4	10	20	339	861.1

E059

K



UNC	TPI	d_1 nom mm	l_1 mm	l_2 mm	d_2 Ø mm	◪ a mm	l_3 mm	z	↔	l_4 mm	e-Code
1/4	20	6.35	66	13	6.30	5.00	8	4	5.1	26	**E0591/4**
5/16	18	7.94	72	16	8.00	6.30	9	4	6.6	29	**E0595/16**
3/8	16	9.53	80	18	10.00	8.00	11	4	8	32	**E0593/8**
1/2	13	12.70	89	22	9.00	7.10	10	4	10.8		**E0591/2**
5/8	11	15.88	102	24	12.50	10.00	13	4	13.5		**E0595/8**
3/4	10	19.05	112	29	14.00	11.20	14	4	16.5		**E0593/4**

UNF | DIN ANSI | 2BX | 2XD | HSS-E-PM | C 2-3 | Cool TOP

E831

- UNF Strojní závitník CoroTap™ K přímá drážka
- UNF Gépi Menetfúró CoroTap™ K egyenes élű
- UNF Gwintowniki maszynowe CoroTap™ K, prosty rowek wiórowy
- UNF Tarozi de masina CoroTap™ K Canale drepte
- UNF Машинные метчики CoroTap™ K Прямая стружечная канавка
- UNF Machine CoroTap™ K Straight Flute

CoroTap™ 100 K

K	
K 1	20-30
K 2	20-38
K 3	20-30
K 4	- - -
K 5	14-22
Vc[m/min]	

Din EN-GJMW-350-4/ 0.8035 MC-code: K1.1.C.NS 219 HB

K1	↓ 1.5xD UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
	1/4	28	43	2146	1946.7
	5/16	24	43	1716	1816.1
	3/8	24	43	1430	1513.4
	7/16	20	43	1226	1557.0
	1/2	20	42	1046	1328.4
	9/16	18	40	881	1243.2
	5/8	18	38	756	1066.8
	3/4	16	35	581	922.3
	7/8	14	32	465	843.6

K1	↓ 2xD UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
	1/4	28	35	1754	1591.1
	5/16	24	35	1403	1484.8
	3/8	24	35	1169	1237.2
	7/16	20	35	1003	1273.8
	1/2	20	34	855	1085.9
	9/16	18	32	721	1017.4
	5/8	18	31	618	872.1
	3/4	16	28	475	754.1
	7/8	14	27	380	689.4

EN-GJL-250/ 0.0625/ SS0125 MC-code: K2.1.C.UT 215 HB

K2	↓ 1.5xD UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
	1/4	28	37	1839	1668.2
	5/16	24	37	1471	1556.8
	3/8	24	37	1226	1297.5
	7/16	20	37	1051	1334.8
	1/2	20	36	896	1137.9
	9/16	18	34	756	1066.8
	5/8	18	32	648	914.4
	3/4	16	30	498	790.6
	7/8	14	28	398	722.1

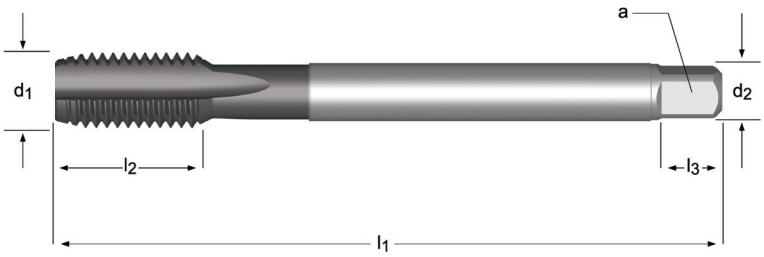
K2	↓ 2xD UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
	1/4	28	30	1504	1364.3
	5/16	24	30	1203	1273.2
	3/8	24	30	1002	1060.5
	7/16	20	30	860	1092.2
	1/2	20	29	733	930.9
	9/16	18	28	618	872.1
	5/8	18	26	530	747.9
	3/4	16	24	407	646.1
	7/8	14	23	326	591.5

EN-GJS-500/ 0.7050/ SS072 7 MC-code: K3.2.C.UT 199 HB

K3	↓ 1.5xD UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
	1/4	28	43	2146	1946.7
	5/16	24	43	1716	1816.1
	3/8	24	43	1430	1513.4
	7/16	20	43	1226	1557.0
	1/2	20	42	1046	1328.4
	9/16	18	40	881	1243.2
	5/8	18	38	756	1066.8
	3/4	16	35	581	922.3
	7/8	14	32	465	843.6

K3	↓ 2xD UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
	1/4	28	35	1754	1591.1
	5/16	24	35	1403	1484.8
	3/8	24	35	1169	1237.2
	7/16	20	35	1003	1273.8
	1/2	20	34	855	1085.9
	9/16	18	32	721	1017.4
	5/8	18	31	618	872.1
	3/4	16	28	475	754.1
	7/8	14	27	380	689.4

E831



UNF	TPI	l_1 mm	l_2 Inch	d_2 Ø Inch /	◪ a Inch	z	↔	↔	l_4 Inch	e-Code
1/4	28	80	0.5906	0.2550	0.1910	4	N3	5.50	0.9681	**E8311/4**
5/16	24	90	0.7087	0.3180	0.2380	4	I	6.90	1.3060	**E8315/16**
3/8	24	100	0.7874	0.3810	0.2860	4	Q	8.50	1.4871	**E8313/8**
7/16	20	100	0.7890	0.3230	0.2420	4	25/64	9.90		**E8317/16**
1/2	20	110	0.9060	0.3670	0.2750	4	29/64	11.50		**E8311/2**
5/8	18	110	0.9060	0.4800	0.3600	4	37/64	14.50		**E8315/8**
3/4	16	125	1.1810	0.5900	0.4420	4	11/16	17.50		**E8313/4**
7/8	14	140	1.3385	0.6970	0.5230	4	13/16	20.40		**E8317/8**

UNF | DIN ANSI | 2BX | 2XD | HSS-E-PM | E 1.5-2 | Cool TOP

E821

- UNF Strojní závitník CoroTap™ K přímá drážka
- UNF Gépi Menetfúró CoroTap™ K egyenes élű
- UNF Gwintowniki maszynowe CoroTap™ K Prosty Rowek Wiórowy
- UNF Tarozi de masina CoroTap™ K Canale drepte
- UNF Машинные метчики CoroTap™ K Прямая стружечная канавка
- UNF Machine CoroTap™ K Straight Flutei

CoroTap™ 100 K

K	
K 1	20-30
K 2	20-38
K 3	20-30
K 4	- - -
K 5	14-22

Din EN-GJMW-350-4/ 0.8035 MC-code: K1.1.C.NS 219 HB

	↓ 1.5xD					↓ 2xD				
	UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
K1	1/4	28	43	2146	1946.7	1/4	28	35	1754	1591.1
	5/16	24	43	1716	1816.1	5/16	24	35	1403	1484.8
	3/8	24	43	1430	1513.4	3/8	24	35	1169	1237.2
	7/16	20	43	1226	1557.0	7/16	20	35	1003	1273.8
	1/2	20	42	1046	1328.4	1/2	20	34	855	1085.9
	9/16	18	40	881	1243.2	9/16	18	32	721	1017.4
	5/8	18	38	756	1066.8	5/8	18	31	618	872.1
	3/4	16	35	581	922.3	3/4	16	28	475	754.1

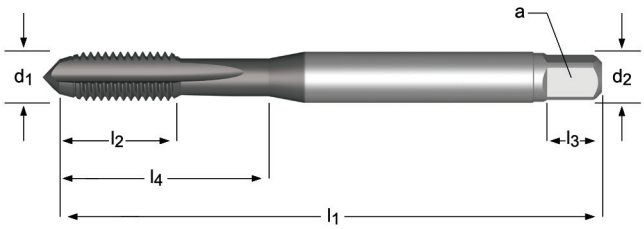
EN-GJL-250/ 0.0625/ SS0125 MC-code: K2.1.C.UT 215 HB

	↓ 1.5xD					↓ 2xD				
	UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
K2	1/4	28	37	1839	1668.2	1/4	28	30	1504	1364.3
	5/16	24	37	1471	1556.8	5/16	24	30	1203	1273.2
	3/8	24	37	1226	1297.5	3/8	24	30	1002	1060.5
	7/16	20	37	1051	1334.8	7/16	20	30	860	1092.2
	1/2	20	36	896	1137.9	1/2	20	29	733	930.9
	9/16	18	34	756	1066.8	9/16	18	28	618	872.1
	5/8	18	32	648	914.4	5/8	18	26	530	747.9
	3/4	16	30	498	790.6	3/4	16	24	407	646.1

EN-GJS-500/ 0.7050/ SS072 7 MC-code: K3.2.C.UT 199 HB

	↓ 1.5xD					↓ 2xD				
	UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
K3	1/4	28	43	2146	1946.7	1/4	28	35	1754	1591.1
	5/16	24	43	1716	1816.1	5/16	24	35	1403	1484.8
	3/8	24	43	1430	1513.4	3/8	24	35	1169	1237.2
	7/16	20	43	1226	1557.0	7/16	20	35	1003	1273.8
	1/2	20	42	1046	1328.4	1/2	20	34	855	1085.9
	9/16	18	40	881	1243.2	9/16	18	32	721	1017.4
	5/8	18	38	756	1066.8	5/8	18	31	618	872.1
	3/4	16	35	581	922.3	3/4	16	28	475	754.1

E821



UNF	TPI	l_1 mm	l_2 Inch	d_2 Ø Inch /	⧄ a Inch	z	↔	↔	l_4	e-Code
1/4	28	80	0.5910	0.2550	0.1910	4	N3	5.50	1.0073	**E8211/4**
5/16	24	90	0.7090	0.3180	0.2380	4	4	6.90		**E8215/16**
3/8	24	100	0.7890	0.3810	0.2860	4	Q	8.50		**E8213/8**
7/16	20	100	0.7890	0.3230	0.2420	4	25/64	9.90		**E8217/16**
1/2	20	110	0.9060	0.3670	0.2750	4	29/64	11.50		**E8211/2**
5/8	18	110	0.9060	0.4800	0.3600	4	37/64	14.50		**E8215/8**
3/4	16	125	1.1810	0.5900	0.4420	4	11/16	17.50		**E8213/4**

UNF | DIN ANSI | 2BX | 2.5XD | HSS-E-PM | C 2-3 | Cool TOP

E833

- UNF Strojní závitník CoroTap™ K přímá drážka
- UNF Gépi Menetfúró CoroTap™ K egyenes élű
- UNF Gwintowniki maszynowe CoroTap™ K, prosty rowek wiórowy
- UNF Tarozi de masina CoroTap™ K Canale drepte
- UNF Машинные метчики CoroTap™ K Прямая стружечная канавка
- UNF Machine CoroTap™ K Straight Flute

CoroTap™ 100 K

K	
K 1	20-30
K 2	20-38
K 3	20-30
K 4	- - -
K 5	14-22
Vc[m/min]	

Din EN-GJMW-350-4/ 0.8035 MC-code: K1.1.C.NS 219 HB

K1	↓ 1.5xD UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2xD UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2.5xD UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
	1/4	28	43	2146	1946.7	1/4	28	35	1754	1591.1	1/4	28	30	1501	1361.6
	5/16	24	43	1716	1816.1	5/16	24	35	1403	1484.8	5/16	24	30	1200	1270.0
	3/8	24	43	1430	1513.4	3/8	24	35	1169	1237.2	3/8	24	30	1000	1058.3
	7/16	20	43	1226	1557.0	7/16	20	35	1003	1273.8	7/16	20	30	858	1089.7
	1/2	20	42	1046	1328.4	1/2	20	34	855	1085.9	1/2	20	29	731	928.4

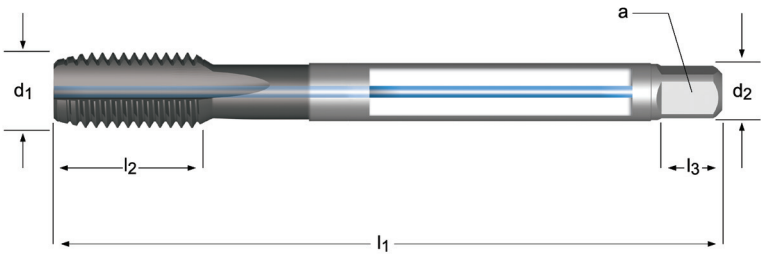
EN-GJL-250/ 0.0625/ SS0125 MC-code: K2.1.C.UT 215 HB

K2	↓ 1.5xD UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2xD UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2.5xD UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
	1/4	28	37	1839	1668.2	1/4	20	30	1504	1910.1	1/4	28	26	1286	1166.6
	5/16	24	37	1471	1556.8	5/16	18	30	1203	1697.6	5/16	24	26	1029	1089.0
	3/8	24	37	1226	1297.5	3/8	16	30	1003	1592.3	3/8	24	26	857	907.0
	7/16	20	37	1051	1334.8	7/16	14	30	859	1558.5	7/16	20	26	735	933.5
	1/2	20	36	896	1137.9	1/2	13	29	733	1432.2	1/2	20	25	627	796.3

EN-GJS-500/ 0.7050/ SS072 7 MC-code: K3.2.C.UT 199 HB

K3	↓ 1.5xD UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2xD UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	↓ 2.5xD UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
	1/4	28	43	2146	1946.7	1/4	28	35	1754	1591.1	1/4	28	30	1501	1361.6
	5/16	24	43	1716	1816.1	5/16	24	35	1403	1484.8	5/16	24	30	1200	1270.0
	3/8	24	43	1430	1513.4	3/8	24	35	1169	1237.2	3/8	24	30	1000	1058.3
	7/16	20	43	1226	1557.0	7/16	20	35	1003	1273.8	7/16	20	30	858	1089.7
	1/2	20	42	1046	1328.4	1/2	20	34	855	1085.9	1/2	20	29	731	928.4

E833



UNF	TPI	l_1 mm	l_2 Inch	d_2 Ø Inch /	◪ a Inch	z	↔	↔	l_4 Inch	e-Code
1/4	28	80	0.5910	0.2550	0.1910	4	N3	5.50	1.0073	**E8331/4**
5/16	24	90	0.7090	0.3180	0.2380	4	I	6.90	1.1891	**E8335/16**
3/8	24	100	0.7870	0.3810	0.2860	4	Q	8.50	1.2915	**E8333/8**
7/16	20	100	0.7870	0.3230	0.2420	4	25/64	9.90		**E8337/16**
1/2	20	110	0.9060	0.3670	0.2750	4	29/64	11.50		**E8331/2**

UNF | DIN ANSI | 2BX | 2.5XD | HSS-E-PM | E 1.5-2 | Cool TOP

E823

- UNF Strojní závitník CoroTap™ K přímá drážka
- UNF Gépi Menetfúró CoroTap™ K egyenes élű
- UNF Gwintowniki maszynowe CoroTap™ K Prosty Rowek Wiórowy
- UNF Tarozi de masina CoroTap™ K Canale drepte
- UNF Машинные метчики CoroTap™ K Прямая стружечная канавка
- UNF Machine CoroTap™ K Straight Flute

CoroTap™ 100 K

K	
K 1	20-30
K 2	20-38
K 3	20-30
K 4	- - -
K 5	14-22

Din EN-GJMW-350-4/ 0.8035 MC-code: K1.1.C.NS 219 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
K1	1/4	28	43	2146	1946.7	1/4	28	35	1754	1591.1	1/4	28	30	1501	1361.6
	5/16	24	43	1716	1816.1	5/16	24	35	1403	1484.8	5/16	24	30	1200	1270.0
	3/8	24	43	1430	1513.4	3/8	24	35	1169	1237.2	3/8	24	30	1000	1058.3
	7/16	20	43	1226	1557.0	7/16	20	35	1003	1273.8	7/16	20	30	858	1089.7
	1/2	20	42	1046	1328.4	1/2	20	34	855	1085.9	1/2	20	29	731	928.4

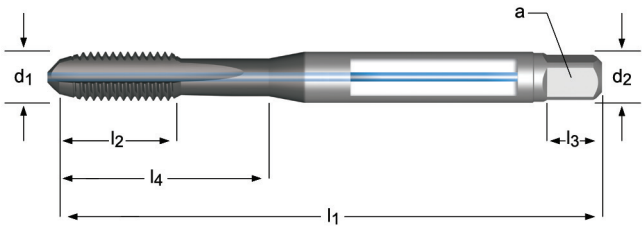
EN-GJL-250/ 0.0625/ SS0125 MC-code: K2.1.C.UT 215 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
K2	1/4	28	37	1839	1668.2	1/4	20	30	1504	1910.1	1/4	28	26	1286	1166.6
	5/16	24	37	1471	1556.8	5/16	18	30	1203	1697.6	5/16	24	26	1029	1089.0
	3/8	24	37	1226	1297.5	3/8	16	30	1003	1592.3	3/8	24	26	857	907.0
	7/16	20	37	1051	1334.8	7/16	14	30	859	1558.5	7/16	20	26	735	933.5
	1/2	20	36	896	1137.9	1/2	13	29	733	1432.2	1/2	20	25	627	796.3

EN-GJS-500/ 0.7050/ SS072 7 MC-code: K3.2.C.UT 199 HB

	↓ 1.5xD					↓ 2xD					↓ 2.5xD				
	UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]	UNF	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
K3	1/4	28	43	2146	1946.7	1/4	28	35	1754	1591.1	1/4	28	30	1501	1361.6
	5/16	24	43	1716	1816.1	5/16	24	35	1403	1484.8	5/16	24	30	1200	1270.0
	3/8	24	43	1430	1513.4	3/8	24	35	1169	1237.2	3/8	24	30	1000	1058.3
	7/16	20	43	1226	1557.0	7/16	20	35	1003	1273.8	7/16	20	30	858	1089.7
	1/2	20	42	1046	1328.4	1/2	20	34	855	1085.9	1/2	20	29	731	928.4

E823



UNF	TPI	l_1 mm	l_2 Inch	d_2 Ø Inch /	◪ a Inch	z	↔	↔	l_4	e-Code
1/4	28	80	0.5910	0.2550	0.1910	4	N3	5.50	1.0073	**E8231/4**
1/2	20	110	0.9060	0.3670	0.2750	4	29/64	11.50		**E8231/2**
7/16	20	100	0.7870	0.3230	0.2420	4	25/64	9.90		**E8237/16**

G | DIN 5156 | Normal | 2XD | HSS-E | C 2-3 | N

E416

- G(BSP) Strojní závitník CoroTap™ K přímá drážka
- G(BSP) Gépi Menetfúró CoroTap™ K egyenes élű
- G(BSP) Gwintowniki maszynowe CoroTap™ K, prosty rowek wiórowy
- G(BSP) Tarozi de masina CoroTap™ K Canale drepte
- G(BSP) Машинные метчики CoroTap™ K Прямая стружечная канавка
- G(BSP) Machine CoroTap™ K Straight Flute

CoroTap™ 100 K

K	
K 1	12-18
K 2	13-24
K 3	12-18
K 4	- - -
K 5	6-10
Vc[m/min]	

Din EN-GJMW-350-4/ 0.8035 MC-code: K1.1.C.NS 219 HB

K1	↓ 1.5xD G	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
	1/8	28	18	600	544.3
	1/4	19	18	426	569.5
	3/8	19	16	302	403.7
	1/2	14	14	217	393.7
	3/4	14	13	155	281.2
	1"	11	12	111	256.3

K1	↓ 2xD G	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
	1/8	28	15	491	445.4
	1/4	19	14	348	465.2
	3/8	19	13	247	330.2
	1/2	14	12	177	321.1
	3/4	14	11	127	230.4
	1"	11	9	91	210.1

EN-GJL-250/ 0.0625/ SS0125 MC-code: K2.1.C.UT 215 HB

K2	↓ 1.5xD G	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
	1/8	28	24	800	725.7
	1/4	19	23	568	759.3
	3/8	19	21	403	538.7
	1/2	14	19	289	524.3
	3/4	14	17	206	373.7
	1"	11	15	148	341.7

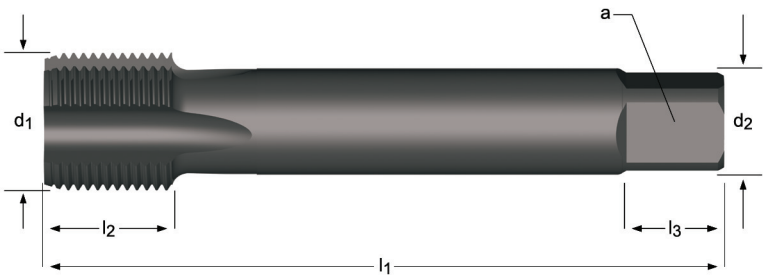
K2	↓ 2xD G	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
	1/8	28	20	654	593.3
	1/4	19	19	464	620.3
	3/8	19	17	330	441.2
	1/2	14	16	236	428.2
	3/4	14	14	169	306.6
	1"	11	13	121	279.4

EN-GJS-500/ 0.7050/ SS072 7 MC-code: K3.2.C.UT 199 HB

K3	↓ 1.5xD G	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
	1/8	28	18	600	544.3
	1/4	19	18	426	569.5
	3/8	19	16	302	403.7
	1/2	14	14	217	393.7
	3/4	14	13	155	281.2
	1"	11	12	111	256.3

K3	↓ 2xD G	TPI	Vc [m/min]	N [rpm]	Vf [mm/min]
	1/8	28	15	491	445.4
	1/4	19	14	348	465.2
	3/8	19	13	247	330.2
	1/2	14	12	177	321.1
	3/4	14	11	127	230.4
	1"	11	9	91	210.1

E416



G(BSP)	TPI	d_1 nom mm	l_1 mm	l_2 mm	d_2 Ø mm	⧄ a mm	l_3 mm	z	↔	e-Code
1/8	28	9.73	90	20	7	5.5	8	4	8.8	**E4161/8**
1/4	19	13.16	100	21	11	9.0	12	4	11.8	**E4161/4**
3/8	19	16.66	100	21	12	9.0	12	5	15.25	**E4163/8**
1/2	14	20.96	125	24	16	12.0	15	5	19	**E4161/2**
3/4	14	26.44	140	28	20	16.0	19	6	24.5	**E4163/4**
1“	11	33.25	160	30	25	20.0	23	6	30.75	**E4161**

M | DIN 371≤10 376≥12 | 6H | 2.5XD | HSS-PM | B 3.5-5

EP006H

- M Strojní závitník Spectrum™ Tap lamač třísek, přímá drážka
- M Gépi Menetfúró Spectrum™ Tap Terelőéles
- M Gwintownik maszynowy Spectrum™ Tap ze skośną powierzchnią natarcia
- M Tarozi de masina Spectrum™ Tap Varf spiral
- M Машинные метчики Spectrum™ Тар Криволинейная задняя поверхность
- M Machine Tap Spectrum™ Tap Spiral Point

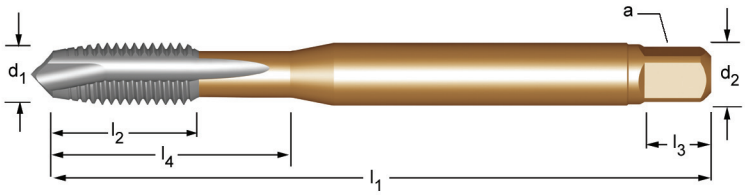
Spectrum™ Tap 200

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**13-30**	M 1		K 1	**12-18**	N 1.1	**13-19**	S 1	**10-14**	H 1		O 1	**24-36**
P 2	**4-19**	M 2		K 2	**6-18**	N 1.2	**28-42**	S 2	**4-14**	H 2		O 2	
P 3	**4-19**	M 3		K 3	**12-18**	N 1.3	**12-24**	S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4	**12-18**	S 4	**4-12**	H 4		O 4	
P 5	**4-19**			K 5	**6-10**	N 2	**12-24**	S 5				O 5	
						N 3.1	**10-14**	S 6				O 6	**24-36**
						N 3.2	**16-36**					O 7	
						N 3.3	**24-36**						
						N 3.4							
						N 4	**24-36**						

$$n = \frac{Vc \times 1000}{\pi \times D}$$

EP006H



M	P mm	l_1 mm	l_2 mm	d_2 Ø mm	◪ a mm	l_3 mm	z	↔	l_4 mm	e-Code	
2	0.40	50	6	2.8	2.1	5	3	1.6	9	**EP00M2**	2)
2.5	0.45	50	8	2.8	2.1	5	3	2.1	12.5	**EP00M2.5**	2)
3	0.50	56	9	3.5	2.7	6	3	2.5	18	**EP00M3**	
3	0.50	56	10	2.2	1.8	4	3	2.5		**EP00M3DIN376**	
3.5	0.60	56	11	4.0	3.0	6	3	2.9	20	**EP00M3.5**	
4	0.70	63	12	4.5	3.4	6	3	3.3	21	**EP00M4**	
4	0.70	63	12	2.8	2.1	5	3	3.3		**EP00M4DIN376**	
4.5	0.75	70	13	6.0	4.9	8	3	3.8	25	**EP00M4.5**	
5	0.80	70	13	6.0	4.9	8	3	4.2	25	**EP00M5**	
5	0.80	70	13	3.5	2.7	6	3	4.2		**EP00M5DIN376**	
6	1.00	80	15	6.0	4.9	8	3	5	30	**EP00M6**	
6	1.00	80	15	4.5	3.4	6	3	5		**EP00M6DIN376**	
7	1.00	80	15	7.0	5.5	8	3	6	30	**EP00M7**	
8	1.25	90	18	8.0	6.2	9	3	6.8	35	**EP00M8**	
8	1.25	90	18	6.0	4.9	8	3	6.8		**EP00M8DIN376**	
10	1.50	100	20	10.0	8.0	11	3	8.5	39	**EP00M10**	
10	1.50	100	20	7.0	5.5	8	3	8.5		**EP00M10DIN376**	
12	1.75	110	23	9.0	7.0	10	3	10.3		**EP00M12**	
14	2.00	110	25	11.0	9.0	12	3	12		**EP00M14**	
16	2.00	110	25	12.0	9.0	12	3	14		**EP00M16**	
18	2.50	125	30	14.0	11.0	14	4	15.5		**EP00M18**	2)
20	2.50	140	30	16.0	12.0	15	4	17.5		**EP00M20**	2)
22	2.50	140	34	18.0	14.5	17	4	19.5		**EP00M22**	2)
24	3.00	160	38	18.0	14.5	17	4	21		**EP00M24**	2)
27	3.00	160	38	20.0	16.0	19	4	24		**EP00M27**	2)
30	3.50	180	45	22.0	18.0	21	4	26.5		**EP00M30**	2)

HSS-E

2)

M | DIN 371≤10 376≥12 | 6H | 2.5XD | HSS-PM | B 3.5-5 | ST

EP016H

- M Strojní závitník Spectrum™ Tap lamač třísek, přímá drážka
- M Gépi Menetfúró Spectrum™ Tap Terelőéles
- M Gwintownik maszynowy Spectrum™ Tap ze skośną powierzchnią natarcia
- M Tarozi de masina Spectrum™ Tap Varf spiral
- M Машинные метчики Spectrum™ Tap Криволинейная задняя поверхность
- M Machine Tap Spectrum™ Tap Spiral Point

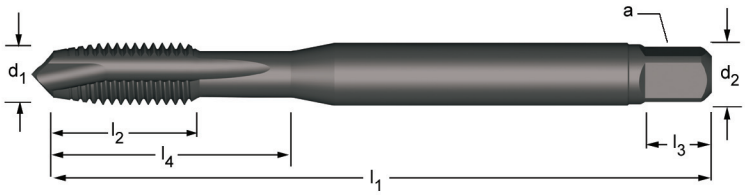
Spectrum™ Tap 200

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**13-30**	M 1	**3-8**	K 1	**12-18**	N 1.1		S 1		H 1		O 1	
P 2	**4-19**	M 2	**5-7**	K 2	**6-18**	N 1.2		S 2		H 2		O 2	
P 3	**4-19**	M 3	**3-5**	K 3	**12-18**	N 1.3		S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4		S 4		H 4		O 4	
P 5	**3-19**			K 5	**6-10**	N 2		S 5				O 5	
						N 3.1		S 6				O 6	
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$

EP016H



M	P mm	l_1 mm	l_2 mm	d_2 Ø mm	a mm	l_3 mm	z	↔	l_4 mm	e-Code	
2	0.40	50	6	2.8	2.1	5	3	1.6	9	**EP01M2**	2)
2.5	0.45	50	8	2.8	2.1	5	3	2.1	12.5	**EP01M2.5**	2)
3	0.50	56	9	3.5	2.7	6	3	2.5	18	**EP01M3**	
3	0.50	56	10	2.2	1.8	4	3	2.5		**EP01M3DIN376**	
3.5	0.60	56	11	4.0	3.0	6	3	2.9	20	**EP01M3.5**	
4	0.70	63	12	4.5	3.4	6	3	3.3	21	**EP01M4**	
4	0.70	63	12	2.8	2.1	5	3	3.3		**EP01M4DIN376**	
4.5	0.75	70	13	6.0	4.9	8	3	3.8	25	**EP01M4.5**	
5	0.80	70	13	6.0	4.9	8	3	4.2	25	**EP01M5**	
5	0.80	70	13	3.5	2.7	6	3	4.2		**EP01M5DIN376**	
6	1.00	80	15	6.0	4.9	8	3	5	30	**EP01M6**	
6	1.00	80	15	4.5	3.4	6	3	5		**EP01M6DIN376**	
7	1.00	80	15	7.0	5.5	8	3	6	30	**EP01M7**	
8	1.25	90	18	8.0	6.2	9	3	6.8	35	**EP01M8**	
8	1.25	90	18	6.0	4.9	8	3	6.8		**EP01M8DIN376**	
10	1.50	100	20	10.0	8.0	11	3	8.5	39	**EP01M10**	
10	1.50	100	20	7.0	5.5	8	3	8.5		**EP01M10DIN376**	
12	1.75	110	23	9.0	7.0	10	3	10.3		**EP01M12**	
14	2.00	110	25	11.0	9.0	12	3	12		**EP01M14**	
16	2.00	110	25	12.0	9.0	12	3	14		**EP01M16**	
18	2.50	125	30	14.0	11.0	14	4	15.5		**EP01M18**	2)
20	2.50	140	30	16.0	12.0	15	4	17.5		**EP01M20**	2)
22	2.50	140	34	18.0	14.5	17	4	19.5		**EP01M22**	2)
24	3.00	160	38	18.0	14.5	17	4	21		**EP01M24**	2)
27	3.00	160	38	20.0	16.0	19	4	24		**EP01M27**	2)
30	3.50	180	45	22.0	18.0	21	4	26.5		**EP01M30**	2)

HSS-E

2)

M | DIN 371≤10 376≥12 | 6G | 2.5XD | HSS-PM | B 3.5-5

EP006G

- M Strojní závitník Spectrum™ Tap lamač třísek, přímá drážka
- M Gépi Menetfúró Spectrum™ Tap Terelőéles
- M Gwintownik maszynowy Spectrum™ Tap ze skośną powierzchnią natarcia
- M Tarozi de masina Spectrum™ Tap Varf spiral
- M Машинные метчики Spectrum™ Тар Криволинейная задняя поверхность
- M Machine Tap Spectrum™ Tap Spiral Point

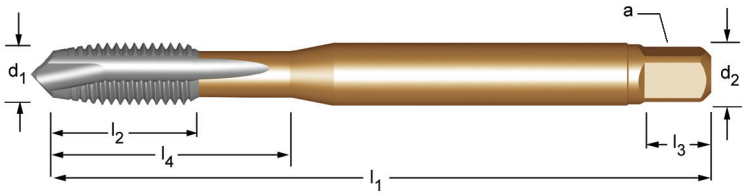
Spectrum™ Tap 200

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**13-30**	M 1		K 1	**12-18**	N 1.1	**13-19**	S 1	**10-14**	H 1		O 1	**24-36**
P 2	**4-19**	M 2		K 2	**6-18**	N 1.2	**28-42**	S 2	**4-14**	H 2		O 2	
P 3	**4-19**	M 3		K 3	**12-18**	N 1.3	**12-24**	S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4	**12-18**	S 4	**4-12**	H 4		O 4	
P 5	**4-19**			K 5	**6-10**	N 2	**12-24**	S 5				O 5	
						N 3.1	**10-14**	S 6				O 6	**24-36**
						N 3.2	**16-36**					O 7	
						N 3.3	**24-36**						
						N 3.4							
						N 4	**24-36**						

$$n = \frac{Vc \times 1000}{\pi \times D}$$

EP006G



M	P mm	l_1 mm	l_2 mm	d_2 Ø mm	⧄ a mm	l_3 mm	z	↔	l_4 mm	e-Code
3	0.50	56	9	3.5	2.7	6	3	2.5	18	**EP00M36G**
4	0.70	63	12	4.5	3.4	6	3	3.3	21	**EP00M46G**
5	0.80	70	13	6.0	4.9	8	3	4.2	25	**EP00M56G**
6	1.00	80	15	6.0	4.9	8	3	5	30	**EP00M66G**
8	1.25	90	18	8.0	6.2	9	3	6.8	35	**EP00M86G**
10	1.50	100	20	10.0	8.0	11	3	8.5	39	**EP00M106G**
12	1.75	110	23	9.0	7.0	10	3	10.3		**EP00M126G**
16	2.00	110	25	12.0	9.0	12	3	14		**EP00M166G**
20	2.50	140	30	16.0	12.0	15	4	17.5		**EP00M206G** [2)]

HSS-E

2)

M | DIN 371≤10 376≥12 | 6G | 2.5XD | HSS-PM | B 3.5-5 | ST

EP016G

- M Strojní závitník Spectrum™ Tap lamač třísek, přímá drážka
- M Gépi Menetfúró Spectrum™ Tap Terelőéles
- M Gwintownik maszynowy Spectrum™ Tap ze skośną powierzchnią natarcia
- M Tarozi de masina Spectrum™ Tap Varf spiral
- M Машинные метчики Spectrum™ Тар Криволинейная задняя поверхность
- M Machine Tap Spectrum™ Tap Spiral Point

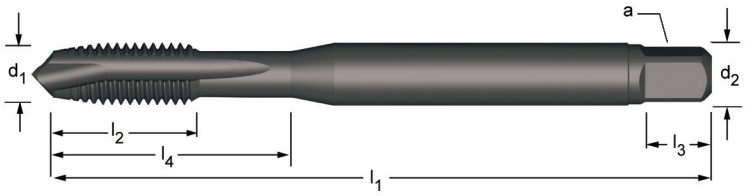
Spectrum™ Tap 200

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**13-30**	M 1	**3-8**	K 1	**12-18**	N 1.1		S 1		H 1		O 1	
P 2	**4-19**	M 2	**5-7**	K 2	**6-18**	N 1.2		S 2		H 2		O 2	
P 3	**4-19**	M 3	**3-5**	K 3	**12-18**	N 1.3		S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4		S 4		H 4		O 4	
P 5	**3-19**			K 5	**6-10**	N 2		S 5				O 5	
						N 3.1		S 6				O 6	
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$

EP016G



M	P mm	l_1 mm	l_2 mm	d_2 Ø mm	◪ a mm	l_3 mm	z	↔	l_4 mm	e-Code
3	0.50	56	9	3.5	2.7	6	3	2.5	18	**EP01M36G**
4	0.70	63	12	4.5	3.4	6	3	3.3	21	**EP01M46G**
5	0.80	70	13	6.0	4.9	8	3	4.2	25	**EP01M56G**
6	1.00	80	15	6.0	4.9	8	3	5	30	**EP01M66G**
8	1.25	90	18	8.0	6.2	9	3	6.8	35	**EP01M86G**
10	1.50	100	20	10.0	8.0	11	3	8.5	39	**EP01M106G**
12	1.75	110	23	9.0	7.0	10	3	10.3		**EP01M126G**
16	2.00	110	25	12.0	9.0	12	3	14		**EP01M166G**
20	2.50	140	30	16.0	12.0	15	4	17.5		**EP01M206G** 2)

HSS-E

2)

M | DIN 371≤10 376≥12 | 6H | 3XD | HSS-E | B 3.5-5 | Cool TOP

E616

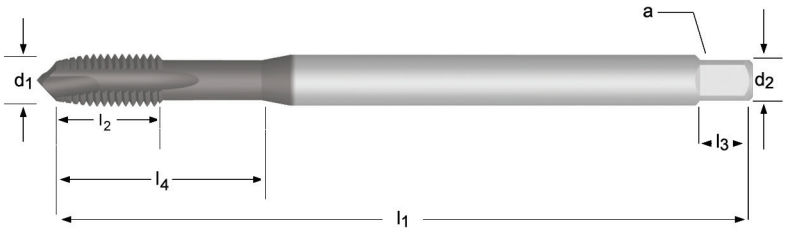
- M Strojní závitník Spectrum™ Tap, prodloužený lamač třísky, přímá drážka
- M Gépi Menetfúró Spectrum™ Tap, extra hosszú Terelőéles
- M Gwintowniki maszynowy, Spectrum™ Tap, Bardzo długi, ze skośną powierzchnią natarcia
- M Tarozi de masina Spectrum™ Tap, extralungi Varf spiral
- M Spectrum™ Tap, Криволинейная задняя поверхность
- M Machine Tap Spectrum™ Tap, Extra Long Spiral Point

Spectrum™ Tap 200

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**22-46**	M 1	**4-8**	K 1	**19-29**	N 1.1	**22-34**	S 1		H 1		O 1	
P 2	**8-34**	M 2	**5-7**	K 2	**13-24**	N 1.2		S 2	**6-8**	H 2		O 2	
P 3	**8-34**	M 3	**4-6**	K 3	**19-29**	N 1.3		S 3		H 3		O 3	
P 4	**22-36**			K 4		N 1.4		S 4	**6-8**	H 4		O 4	
P 5	**4-34**			K 5	**13-19**	N 2		S 5				O 5	
						N 3.1	**14-22**	S 6				O 6	
						N 3.2	**28-54**					O 7	
						N 3.3	**36-54**						
						N 3.4							
						N 4	**36-54**						

$$n = \frac{Vc \times 1000}{\pi \times D}$$



M	P mm	l_1 mm	l_2 mm	d_2 Ø mm	a mm	l_3 mm	z	↔	l_4 mm	e-Code
3	0.50	112	9	3.5	2.7	6	3	2.5	18	**E616M3**
4	0.70	112	12	4.5	3.4	6	3	3.3	21	**E616M4**
5	0.80	125	13	6.0	4.9	8	3	4.2	25	**E616M5**
6	1.00	125	15	6.0	4.9	8	3	5	30	**E616M6**
8	1.25	140	18	8.0	6.2	9	3	6.8	40	**E616M8**
10	1.50	160	20	10.0	8.0	11	3	8.5	50	**E616M10**
12	1.75	180	23	9.0	7.0	10	3	10.2		**E616M12**
14	2.00	180	25	11.0	9.0	12	3	12		**E616M14**
16	2.00	200	25	12.0	9.0	12	3	14		**E616M16**
20	2.50	224	30	16	12.0	15	4	17.5		**E616M20**

M | ANSI | 6H | 2.5XD | HSS-PM | B 3.5-5

E005

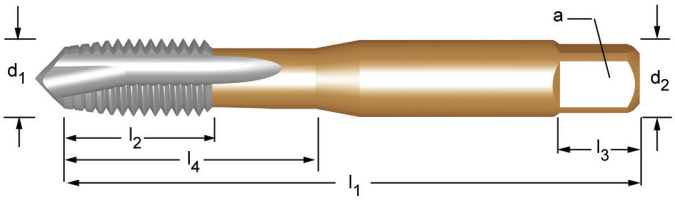
- M Strojní závitník Spectrum™ Tap, prodloužený lamač třísky, přímá drážka
- M Gépi Menetfúró Spectrum™ Tap, extra hosszú Terelőéles
- M Gwintowniki maszynowy, Spectrum™ Tap, Bardzo długi, ze skośną powierzchnią natarcia
- M Tarozi de masina Spectrum™ Tap, extralungi Varf spiral
- M Spectrum™ Tap, Криволинейная задняя поверхность
- M Machine Tap Spectrum™ Tap, Extra Long Spiral Point

Spectrum™ Tap 200

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**13-30**	M 1		K 1	**12-18**	N 1.1	**13-19**	S 1	**10-14**	H 1		O 1	**24-36**
P 2	**4-19**	M 2		K 2	**6-18**	N 1.2	**28-42**	S 2	**4-14**	H 2		O 2	
P 3	**4-19**	M 3		K 3	**12-18**	N 1.3	**12-24**	S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4	**12-18**	S 4	**4-12**	H 4		O 4	
P 5	**4-19**			K 5	**6-10**	N 2	**12-24**	S 5				O 5	
						N 3.1	**10-14**	S 6				O 6	**24-36**
						N 3.2	**16-36**					O 7	
						N 3.3	**24-36**						
						N 3.4							
						N 4	**24-36**						

$$n = \frac{Vc \times 1000}{\pi \times D}$$



M	P mm	l_1 inch	l_2 inch	d_2 Ø inch	⧄ a inch	z	↔	l_4 inch	↔	EDP # or Stock No.	e-Code
4	0.70	2.1/8	0.2484	0.1680	0.1310	2	3.30	0.6526	N30	580301	**E005M4**
4	0.70	2.1/8	0.2484	0.1680	0.1310	3	3.30	0.6526	N30	580318	**E005M43FL**
5	0.80	2.3/8	0.4303	0.1940	0.1520	2	4.20	0.8434	N19	580325	**E005M5**
5	0.80	2.3/8	0.4303	0.1940	0.1520	3	4.20	0.8434	N19	580332	**E005M53FL**
6	1.00	2.1/2	0.5075	0.2550	0.1910	2	5.00	1.0073	N9	580349	**E005M6**
6	1.00	2.1/2	0.5075	0.2550	0.1910	3	5.00	1.0073	N9	580356	**E005M63FL**
8	1.25	2.23/32	0.5939	0.3180	0.2380	2	6.80	1.1891	H	580363	**E005M8**
8	1.25	2.23/32	0.5939	0.3180	0.2380	3	6.80	1.1891	H	580370	**E005M83FL**
10	1.50	2.15/16	0.6020	0.3810	0.2860	2	8.50	1.2915	Q	580387	**E005M10**
10	1.50	2.15/16	0.6020	0.3810	0.2860	3	8.50	1.2915	Q	580394	**E005M103FL**
12	1.75	3.3/8	0.9055	0.3670	0.2750	2	10.30	Y		580400	**E005M12**
12	1.75	3.3/8	0.9055	0.3670	0.2750	3	10.30	Y		580417	**E005M123FL**
14	2.00	3.19/32	0.9843	0.4290	0.3220	3	12.00	15/32		580424	**E005M14**
16	2.00	3.13/16	0.9843	0.4800	0.3600	3	14.00	35/64		580431	**E005M16**
18	2.50	4.1/32	1.1614	0.5420	0.4060	3	15.50	39/64		580448	**E005M18**
20	2.50	4.15/32	1.1614	0.6520	0.4890	3	17.50	11/16		580455	**E005M20**

M | ANSI | 6H | 2.5XD | HSS-PM | B 3.5-5 | ST

E006

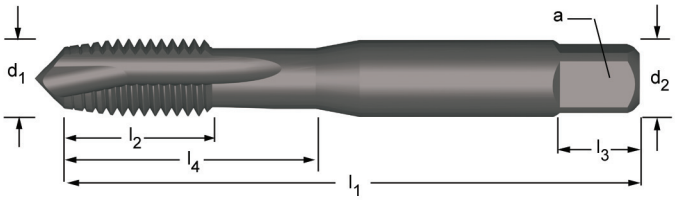
- M Strojní závitník Spectrum™ Tap, prodloužený lamač třísky, přímá drážka
- M Gépi Menetfúró Spectrum™ Tap, extra hosszú Terelőéles
- M Gwintowniki maszynowy, Spectrum™ Tap, Bardzo długi, ze skośną powierzchnią natarcia
- M Tarozi de masina Spectrum™ Tap, extralungi Varf spiral
- M Spectrum™ Tap, Криволинейная задняя поверхность
- M Machine Tap Spectrum™ Tap, Extra Long Spiral Point

Spectrum™ Tap 200

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**13-30**	M 1	**3-8**	K 1	**12-18**	N 1.1		S 1		H 1		O 1	
P 2	**4-19**	M 2	**5-7**	K 2	**6-18**	N 1.2		S 2		H 2		O 2	
P 3	**4-19**	M 3	**3-5**	K 3	**12-18**	N 1.3		S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4		S 4		H 4		O 4	
P 5	**3-19**			K 5	**6-10**	N 2		S 5				O 5	
						N 3.1		S 6				O 6	
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



M	P mm	l_1 inch	l_2 inch	d_2 Ø inch	⧄ a inch	z	↔	l_4 inch	↔	EDP # or Stock No.	e-Code
4	0.70	2.1/8	0.2484	0.1680	0.1310	2	3.30	0.6526	N30	0580462	**E006M4**
4	0.70	2.1/8	0.2484	0.1680	0.1310	3	3.30	0.6526	N30	0583180	**E006M43FL**
5	0.80	2.3/8	0.4303	0.1940	0.1520	2	4.20	0.8434	N19	0580479	**E006M5**
5	0.80	2.3/8	0.4303	0.1940	0.1520	3	4.20	0.8434	N19	0580486	**E006M53FL**
6	1.00	2.1/2	0.5075	0.2550	0.1910	2	5.00	1.0073	N9	0580493	**E006M6**
6	1.00	2.1/2	0.5075	0.2550	0.1910	3	5.00	1.0073	N9	0580509	**E006M63FL**
8	1.25	2.23/32	0.5939	0.3180	0.2380	2	6.80	1.1891	H	0580516	**E006M8**
8	1.25	2.23/32	0.5939	0.3180	0.2380	3	6.80	1.1891	H	0583197	**E006M83FL**
10	1.50	2.15/16	0.6020	0.3810	0.2860	2	8.50	1.2915	Q	0580523	**E006M10**
10	1.50	2.15/16	0.6020	0.3810	0.2860	3	8.50	1.2915	Q	0580530	**E006M103FL**
12	1.75	3.3/8	0.9055	0.3670	0.2750	2	10.30	Y		0580547	**E006M12**
12	1.75	3.3/8	0.9055	0.3670	0.2750	3	10.30	Y		0580554	**E006M123FL**
14	2.00	3.19/32	0.9843	0.4290	0.3220	3	12.00	15/32		0580561	**E006M14**
16	2.00	3.13/16	0.9843	0.4800	0.3600	3	14.00	35/64		0580578	**E006M16**
18	2.50	4.1/32	1.1614	0.5420	0.4060	3	15.50	39/64		0580585	**E006M18**
20	2.50	4.15/32	1.1614	0.6520	0.4890	3	17.50	11/16		0580592	**E006M20**

M | ISO 529 | 6H | 2.5XD | HSS-PM | B 3.5-5

E000

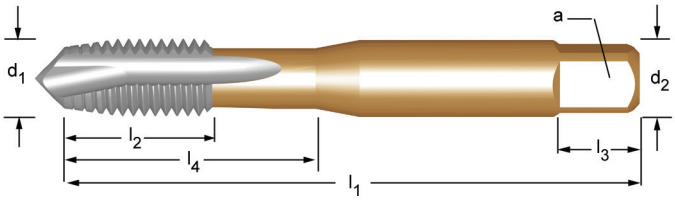
- M Strojní závitník Spectrum™ Tap lamač třísek, přímá drážka
- M Gépi Menetfúró Spectrum™ Tap Terelőéles
- M Gwintownik maszynowy Spectrum™ Tap ze skośną powierzchnią natarcia
- M Tarozi de masina Spectrum™ Tap Varf spiral
- M Машинные метчики Spectrum™ Tap Криволинейная задняя поверхность
- M Machine Tap Spectrum™ Tap Spiral Point

Spectrum™ Tap 200

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**13-30**	M 1		K 1	**12-18**	N 1.1	**13-19**	S 1	**10-14**	H 1		O 1	**24-36**
P 2	**4-19**	M 2		K 2	**6-18**	N 1.2	**28-42**	S 2	**4-14**	H 2		O 2	
P 3	**4-19**	M 3		K 3	**12-18**	N 1.3	**12-24**	S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4	**12-18**	S 4	**4-12**	H 4		O 4	
P 5	**4-19**			K 5	**6-10**	N 2	**12-24**	S 5				O 5	
						N 3.1	**10-14**	S 6				O 6	**24-36**
						N 3.2	**16-36**					O 7	
						N 3.3	**24-36**						
						N 3.4							
						N 4	**24-36**						

$$n = \frac{Vc \times 1000}{\pi \times D}$$



M	P mm	l_1 mm	l_2 mm	d_2 Ø mm	⧄ a mm	l_3 mm	z	↔	l_4 mm	e-Code
1.6	0.35	41	7	2.50	2.00	4	3	1.25	7	**E000M1.6**
2	0.40	41	8	2.50	2.00	4	3	1.6	8	**E000M2**
2.5	0.45	44.5	9.5	2.80	2.24	5	3	2.05	9.5	**E000M2.5**
3	0.50	48	15	3.15	2.50	5	3	2.5	15	**E000M3**
3.5	0.60	50	16	3.55	2.80	5	3	2.9	16	**E000M3.5**
4	0.70	53	17	4.00	3.15	6	3	3.3	17	**E000M4**
5	0.80	58	11	5.00	4.00	7	3	4.2	22	**E000M5**
6	1.00	66	13	6.30	5.00	8	3	5.0	26	**E000M6**
7	1.00	66	13	7.10	5.60	8	3	6.0	26	**E000M7**
8	1.25	72	16	8.00	6.30	9	3	6.8	29	**E000M8**
10	1.50	80	18	10.00	8.00	11	3	8.5	34	**E000M10**
12	1.75	89	22	9.00	7.10	10	3	10.3		**E000M12**
14	2.00	95	24	11.20	9.00	12	3	12.0		**E000M14**
16	2.00	102	24	12.50	10.00	13	3	14.0		**E000M16**
18	2.50	112	29	14.00	11.20	14	4	15.5		**E000M18**
20	2.50	112	29	14.00	11.20	14	4	17.5		**E000M20**
22	2.50	118	29	16.00	12.50	16	4	19.5		**E000M22**
24	3.00	130	35	18.00	14.00	18	4	21.0		**E000M24**

M | ISO 529 | 6H | 2.5XD | HSS-PM | B 3.5-5 | ST

E001

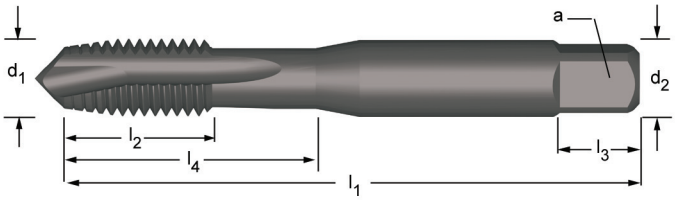
- M Strojní závitník Spectrum™ Tap lamač třísek, přímá drážka
- M Gépi Menetfúró Spectrum™ Tap Terelőéles
- M Gwintownik maszynowy Spectrum™ Tap ze skośną powierzchnią natarcia
- M Tarozi de masina Spectrum™ Tap Varf spiral
- M Машинные метчики Spectrum™ Tap Криволинейная задняя поверхность
- M Machine Tap Spectrum™ Tap Spiral Point

Spectrum™ Tap 200

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**13-30**	M 1	**3-8**	K 1	**12-18**	N 1.1		S 1		H 1		O 1	
P 2	**4-19**	M 2	**5-7**	K 2	**6-18**	N 1.2		S 2		H 2		O 2	
P 3	**4-19**	M 3	**3-5**	K 3	**12-18**	N 1.3		S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4		S 4		H 4		O 4	
P 5	**3-19**			K 5	**6-10**	N 2		S 5				O 5	
						N 3.1		S 6				O 6	
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



M	P mm	l_1 mm	l_2 mm	d_2 Ø mm	⧄ a mm	l_3 mm	z	↔	l_4 mm	e-Code
1.6	0.35	41	7	2.50	2.00	4	3	1.25	7	**E001M1.6**
2	0.40	41	8	2.50	2.00	4	3	1.6	8	**E001M2**
2.5	0.45	44.5	9.5	2.80	2.24	5	3	2.05	9.5	**E001M2.5**
3	0.50	48	15	3.15	2.50	5	3	2.5	15	**E001M3**
3.5	0.60	50	16	3.55	2.80	5	3	2.9	16	**E001M3.5**
4	0.70	53	17	4.00	3.15	6	3	3.3	17	**E001M4**
5	0.80	58	11	5.00	4.00	7	3	4.2	22	**E001M5**
6	1.00	66	13	6.30	5.00	8	3	5.0	26	**E001M6**
7	1.00	66	13	7.10	5.60	8	3	6.0	26	**E001M7**
8	1.25	72	16	8.00	6.30	9	3	6.8	29	**E001M8**
10	1.50	80	18	10.00	8.00	11	3	8.5	34	**E001M10**
12	1.75	89	22	9.00	7.10	10	3	10.3		**E001M12**
14	2.00	95	24	11.20	9.00	12	3	12.0		**E001M14**
16	2.00	102	24	12.50	10.00	13	3	14.0		**E001M16**
18	2.50	112	29	14.00	11.20	14	4	15.5		**E001M18**
20	2.50	112	29	14.00	11.20	14	4	17.5		**E001M20**
22	2.50	118	29	16.00	12.50	16	4	19.5		**E001M22**
24	3.00	130	35	18.00	14.00	18	4	21.0		**E001M24**

E207 / E258

SANDVIK Coromant

E207	M	DIN 371	6H		1.5XD	HSS-E	C 2-3	λ15°		
E258	M	DIN 376	6H		1.5XD	HSS-E	C 2-3	λ15°		

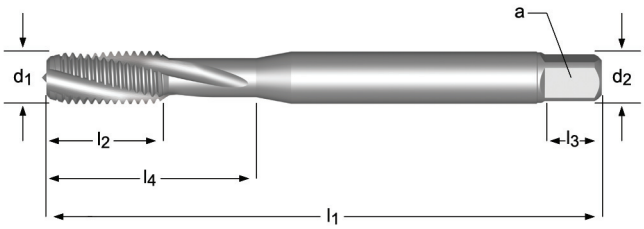
- M Strojní závitník Spectrum™ Tap, šroubovitá drážka 15°
- M Gépi Menetfúró Spectrum™ Tap Csavart hornyú 15°
- M Gwintownik maszynowy Spectrum™ Tap, śrubowy rowek wiórowy 15°
- M Tarozi de masina Spectrum™ Tap Canal elicoidal 15°
- M Машинные метчики Spectrum™ Tap Спиральная стружечная канавка 15°
- M Machine Tap Spectrum™ Tap Spiral Flute 15°

Spectrum™ Tap 300

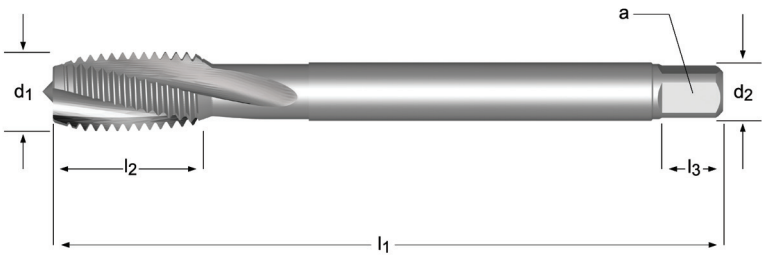
Vc[m/min]

P		M		K		N		S		H		O	
P 1	**10-24**	M 1		K 1		N 1.1	**24-36**	S 1		H 1		O 1	
P 2	**6-14**	M 2		K 2		N 1.2	**12-18**	S 2		H 2		O 2	
P 3	**6-14**	M 3		K 3		N 1.3	**12-18**	S 3		H 3		O 3	
P 4	**10-19**			K 4		N 1.4		S 4		H 4		O 4	
P 5	**6-14**			K 5		N 2		S 5				O 5	
						N 3.1		S 6				O 6	
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



E207



E258

M	P mm	l_1 mm	l_2 mm	d_2 Ø mm	◻ a mm	l_3 mm	z	↔	l_4 mm	E207	E258
2	0.40	45	4	2.8	2.1	5	3	1.6	9	**E207M2**	
2.5	0.45	50	4	2.8	2.1	5	3	2.05	12.5	**E207M2.5**	
3	0.50	56	9	3.5	2.7	6	3	2.5	18	**E207M3**	
3.5	0.60	56	11	4.0	3.0	6	3	2.9	20	**E207M3.5**	
4	0.70	63	12	2.8	2.1	5	3	3.3			**E258M4**
4	0.70	63	12	4.5	3.4	6	3	3.3	21	**E207M4**	
5	0.80	70	13	3.5	2.7	6	3	4.2			**E258M5**
5	0.80	70	13	6.0	4.9	8	3	4.2	25	**E207M5**	
6	1.00	80	15	4.5	3.4	6	3	5			**E258M6**
6	1.00	80	15	6.0	4.9	8	3	5	30	**E207M6**	
7	1.00	80	15	7.0	5.5	8	3	6	30	**E207M7**	
8	1.25	90	18	6.0	4.9	8	3	6.8			**E258M8**
8	1.25	90	18	8.0	6.2	9	3	6.8	35	**E207M8**	
10	1.50	100	20	7.0	5.5	8	3	8.5			**E258M10**
10	1.50	100	20	10.0	8.0	11	3	8.5	39	**E207M10**	
12	1.75	110	23	9.0	7.0	10	3	10.3			**E258M12**
14	2.00	110	25	11.0	9.0	12	3	12			**E258M14**
16	2.00	110	25	12.0	9.0	12	3	14			**E258M16**
18	2.50	125	30	14.0	11.0	14	3	15.5			**E258M18**
20	2.50	140	30	16.0	12.0	15	3	17.5			**E258M20**
22	2.50	140	34	18.0	14.5	17	4	19.5			**E258M22**
24	3.00	160	38	18.0	14.5	17	4	21			**E258M24**
27	3.00	160	38	20.0	16.0	19	4	24			**E258M27**
30	3.50	180	45	22.0	18.0	21	4	26.5			**E258M30**
33	3.50	180	50	25.0	20.0	23	4	29.5			**E258M33**
36	4.00	200	55	28.0	22.0	25	4	32			**E258M36**

E212 / E263

SANDVIK Coromant

E212	M	DIN 371	6H		1.5XD	HSS-E	C 2-3	λ15°			TiN
E263	M	DIN 376	6H		1.5XD	HSS-E	C 2-3	λ15°			TiN

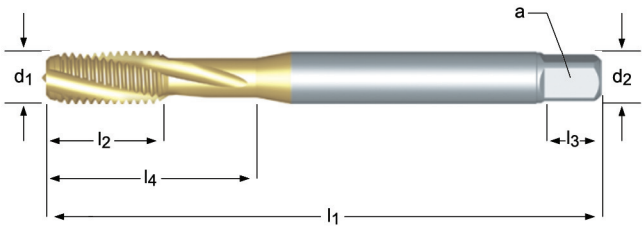
- M Strojní závitník Spectrum™ Tap, šroubovitá drážka 15°
- M Gépi Menetfúró Spectrum™ Tap Csavart hornyú 15°
- M Gwintownik maszynowy Spectrum™ Tap, śrubowy rowek wiórowy 15°
- M Tarozi de masina Spectrum™ Tap Canal elicoidal 15°
- M Машинные метчики Spectrum™ Tap Спиральная стружечная канавка 15°
- M Machine Tap Spectrum™ Tap Spiral Flute 15°

Spectrum™ Tap 300

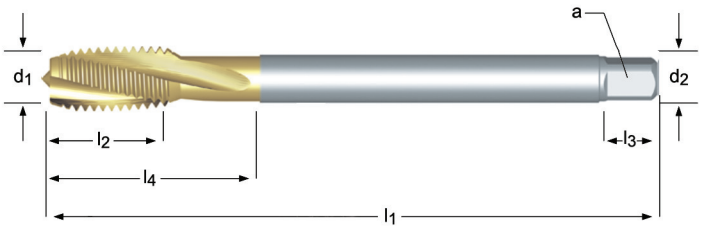
Vc[m/min]

P		M		K		N		S		H		O	
P 1	**19-42**	M 1		K 1		N 1.1	**28-42**	S 1		H 1		O 1	
P 2	**8-29**	M 2		K 2		N 1.2	**16-24**	S 2		H 2		O 2	
P 3	**8-29**	M 3		K 3		N 1.3	**16-24**	S 3		H 3		O 3	
P 4	**19-34**			K 4		N 1.4		S 4	**6-12**	H 4		O 4	
P 5	**8-29**			K 5		N 2		S 5				O 5	
						N 3.1		S 6				O 6	
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



E212



E263

M	P mm	l_1 mm	l_2 mm	d_2 Ø mm	◻ a mm	l_3 mm	z	↔	l_4 mm	E212	E263
3	0.50	56	9	3.5	2.7	5	3	2.5	12.5	**E212M3**	
4	0.70	63	11	4.5	3.4	6	3	3.3	21	**E212M4**	
5	0.80	70	13	6.0	4.9	8	3	4.2	25	**E212M5**	
6	1.00	80	15	6.0	4.9	8	3	5	30	**E212M6**	
8	1.25	90	18	8.0	6.2	9	3	6.8	35	**E212M8**	
10	1.50	100	20	10.0	8.0	11	3	8.5	39	**E212M10**	
12	1.75	110	23	9	7.0	10	3	10.3			**E263M12**
14	2.00	110	25	11	9.0	12	3	12			**E263M14**
16	2.00	110	25	12	9.0	12	3	14			**E263M16**
18	2.50	125	30	14	11.0	14	3	15.5			**E263M18**
20	2.50	140	30	16	12.0	15	3	17.5			**E263M20**
22	2.50	140	34	18	14.5	17	4	19.5			**E263M22**
24	3.00	160	38	18	14.5	17	4	21			**E263M24**
27	3.00	160	38	20	16	19	4	24			**E263M27**
30	3.50	180	45	22	18.0	21	4	26.5			**E263M30**
33	3.50	180	50	25	20.0	23	4	29.5			**E263M33**
36	4.00	200	55	28	22.0	25	4	32			**E263M36**

E195 / E245

SANDVIK Coromant

E195	M	DIN 371	6H		2.5XD	HSS-E	C 2-3	λ40°		
E245	M	DIN 376	6H		2.5XD	HSS-E	C 2-3	λ40°		

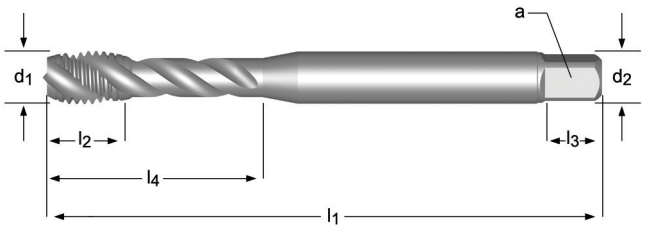
- M Strojní závitník Spectrum™ Tap, zpětný kužel a šroubovitá drážka 40°
- M Gépi Menetfúró Spectrum™ Tap Csavart hornyú 40°
- M Gwintowniki maszynowy, Spectrum™ Tap, zbieżny nakrój, śrubowy rowek wiórowy 40°
- M Tarozi de masina Spectrum™ Tap Canal elicoidal 40°
- M Spectrum™ Tap Спиральная стружечная канавка 40°
- M Machine Tap Spectrum™ Tap, back tapered Spiral Flute 40°

Spectrum™ Tap 360

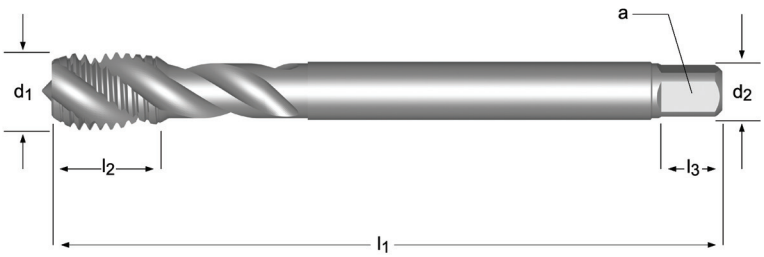
Vc[m/min]

P		M		K		N		S		H		O	
P 1	**10-26**	M 1		K 1		N 1.1	**13-19**	S 1		H 1		O 1	
P 2	**6-14**	M 2		K 2		N 1.2	**28-42**	S 2		H 2		O 2	
P 3	**6-14**	M 3		K 3		N 1.3	**12-24**	S 3		H 3		O 3	
P 4	**10-19**			K 4		N 1.4	**12-18**	S 4		H 4		O 4	
P 5	**6-14**			K 5		N 2		S 5				O 5	
						N 3.1		S 6				O 6	
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



E195



E245

M	P mm	l_1 mm	l_2 mm	d_2 Ø mm	◻ a mm	l_3 mm	z	↔	l_4 mm	E195	E245
3	0.50	56	6	3.5	2.7	6	3	2.5	18	**E195M3**	
4	0.70	63	7	4.5	3.4	6	3	3.3	21	**E195M4**	
5	0.80	70	8	6.0	4.9	8	3	4.2	25	**E195M5**	
6	1.00	80	10	6.0	4.9	8	3	5	30	**E195M6**	
8	1.25	90	13	8.0	6.2	9	3	6.8	35	**E195M8**	
10	1.50	100	15	10.0	8.0	11	3	8.5	39	**E195M10**	
12	1.75	110	18	9	7.0	10	3	10.3			**E245M12**
14	2.00	110	20	11	9.0	12	3	12			**E245M14**
16	2.00	110	20	12	9.0	12	4	14			**E245M16**
18	2.50	125	25	14	11.0	14	4	15.5			**E245M18**
20	2.50	140	25	16	12.0	15	4	17.5			**E245M20**
22	2.50	140	25	18	14.5	17	4	19.5			**E245M22**
24	3.00	160	30	18	14.5	17	4	21			**E245M24**
30	3.5	180	35	22	18.0	21	4	26.5			**E245M30**

M | DIN 371≤10 376≥12 | 6H | 2.5XD | HSS-PM | C 2-3 | λ45°

EX006H

- M Strojní závitník Spectrum™ Tap, šroubovitá drážka 45°
- M Gépi Menetfúró Spectrum™ Tap Csavart hornyú 45°
- M Gwintownik maszynowy Spectrum™ Tap, śrubowy rowek wiórowy 45°
- M Tarozi de masina Spectrum™ Tap Canal elicoidal 45°
- M Машинные метчики Spectrum™ Tap Спиральная стружечная канавка 45°
- M Machine Tap Spectrum™ Tap Spiral Flute 45°

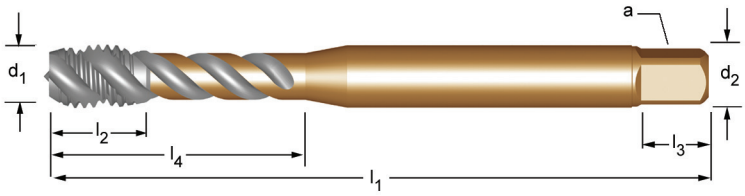
Spectrum™ Tap 360

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**13-30**	M 1		K 1		N 1.1	**13-19**	S 1	**10-14**	H 1		O 1	**24-36**
P 2	**8-19**	M 2		K 2		N 1.2	**28-42**	S 2	**4-14**	H 2		O 2	
P 3	**8-19**	M 3		K 3		N 1.3	**12-24**	S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4	**12-18**	S 4	**4-12**	H 4		O 4	
P 5	**8-19**			K 5		N 2	**12-24**	S 5				O 5	
						N 3.1		S 6				O 6	**24-36**
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$

EX006H



M	P mm	l_1 mm	l_2 mm	d_2 Ø mm	⧄ a mm	l_3 mm	z	↔	l_4 mm	e-Code	
2	0.40	45	4	2.8	2.1	5	3	1.6	9	**EX00M2**	2)
2.5	0.45	50	4	2.8	2.1	5	3	2.05	12.5	**EX00M2.5**	2)
3	0.50	56	6	3.5	2.7	6	3	2.5	18	**EX00M3**	
3.5	0.60	56	7	4.0	3.0	6	3	2.9	20	**EX00M3.5**	
4	0.70	63	7	4.5	3.4	6	3	3.3	21	**EX00M4**	
5	0.80	70	8	6.0	4.9	8	3	4.2	25	**EX00M5**	
6	1.00	80	10	6.0	4.9	8	3	5	31	**EX00M6**	
6	1.00	80	10	4.5	3.4	6	3	5		**EX00M6DIN376**	
7	1.00	80	10	7.0	5.5	8	3	6	31	**EX00M7**	
8	1.25	90	12	8.0	6.2	9	3	6.8	35	**EX00M8**	
8	1.25	90	13	6.0	4.9	8	3	6.8		**EX00M8DIN376**	
10	1.50	100	15	10.0	8.0	11	3	8.5	39	**EX00M10**	
10	1.50	100	15	7.0	5.5	8	3	8.5		**EX00M10DIN376**	
12	1.75	110	16	9.0	7.0	10	3	10.3		**EX00M12**	
14	2.00	110	20	11.0	9.0	12	3	12		**EX00M14**	
16	2.00	110	20	12.0	9.0	12	4	14		**EX00M16**	
18	2.50	125	25	14.0	11.0	14	4	15.5		**EX00M18**	2)
20	2.50	140	25	16.0	12.0	15	4	17.5		**EX00M20**	2)
22	2.50	140	25	18.0	14.5	17	4	19.5		**EX00M22**	2)
24	3.00	160	30	18.0	14.5	17	4	21		**EX00M24**	2)
27	3.00	160	30	20.0	16.0	19	4	24		**EX00M27**	2)
30	3.50	180	36	22.0	18.0	21	4	26.5		**EX00M30**	2)
33	3.50	180	36	25.0	20.0	23	4	29.5		**EX00M33**	2)
36	4.00	200	40	28.0	22.0	25	4	32		**EX00M36**	2)
39	4.00	200	40	32.0	24.0	27	4	35		**EX00M39**	2)
42	4.50	200	45	32.0	24.0	27	4	37.5		**EX00M42**	2)
48	5.00	250	50	36.0	29.0	32	4	43		**EX00M48**	2)
52	5.00	250	50	40.0	32.0	35	5	47		**EX00M52**	2)
56	5.50	250	55	40.0	32.0	35	5	50.5		**EX00M56**	2)
64	6.00	315	60	50.0	39.0	42	6	58		**EX00M64**	2)

HSS-E

2)

M | DIN 371≤10 376≥12 | 6H | 2.5XD | HSS-PM | C 2-3 | λ45° | ST

EX016H

- M Strojní závitník Spectrum™ Tap, šroubovitá drážka 45°
- M Gépi Menetfúró Spectrum™ Tap Csavart hornyú 45°
- M Gwintownik maszynowy Spectrum™ Tap, śrubowy rowek wiórowy 45°
- M Tarozi de masina Spectrum™ Tap Canal elicoidal 45°
- M Машинные метчики Spectrum™ Tap Спиральная стружечная канавка 45°
- M Machine Tap Spectrum™ Tap Spiral Flute 45°

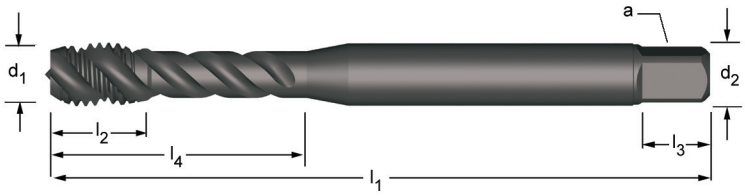
Spectrum™ Tap 360

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**13-30**	M 1	**3-8**	K 1		N 1.1		S 1		H 1		O 1	
P 2	**8-19**	M 2	**5-7**	K 2		N 1.2		S 2		H 2		O 2	
P 3	**8-19**	M 3	**3-5**	K 3		N 1.3		S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4		S 4		H 4		O 4	
P 5	**3-19**			K 5		N 2		S 5				O 5	
						N 3.1		S 6				O 6	
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$

EX016H



M	P mm	l_1 mm	l_2 mm	d_2 Ø mm	◪ a mm	l_3 mm	z	↔	l_4 mm	e-Code	
2	0.40	45	4	2.8	2.1	5	3	1.6	9	**EX01M2**	2)
2.5	0.45	50	4	2.8	2.1	5	3	2.05	12.5	**EX01M2.5**	2)
3	0.50	56	6	3.5	2.7	6	3	2.5	18	**EX01M3**	
3.5	0.60	56	7	4.0	3.0	6	3	2.9	20	**EX01M3.5**	
4	0.70	63	7	4.5	3.4	6	3	3.3	21	**EX01M4**	
5	0.80	70	8	6.0	4.9	8	3	4.2	25	**EX01M5**	
6	1.00	80	10	6.0	4.9	8	3	5	31	**EX01M6**	
6	1.00	80	10	4.5	3.4	6	3	5		**EX01M6DIN376**	
7	1.00	80	10	7.0	5.5	8	3	6	31	**EX01M7**	
8	1.25	90	12	8.0	6.2	9	3	6.8	35	**EX01M8**	
8	1.25	90	13	6.0	4.9	8	3	6.8		**EX01M8DIN376**	
10	1.50	100	15	10.0	8.0	11	3	8.5	39	**EX01M10**	
10	1.50	100	15	7.0	5.5	8	3	8.5		**EX01M10DIN376**	
12	1.75	110	16	9.0	7.0	10	3	10.3		**EX01M12**	
14	2.00	110	20	11.0	9.0	12	3	12		**EX01M14**	
16	2.00	110	20	12.0	9.0	12	4	14		**EX01M16**	
18	2.50	125	25	14.0	11.0	14	4	15.5		**EX01M18**	2)
20	2.50	140	25	16.0	12.0	15	4	17.5		**EX01M20**	2)
22	2.50	140	25	18.0	14.5	17	4	19.5		**EX01M22**	2)
24	3.00	160	30	18.0	14.5	17	4	21		**EX01M24**	2)
27	3.00	160	30	20.0	16.0	19	4	24		**EX01M27**	2)
30	3.50	180	36	22.0	18.0	21	4	26.5		**EX01M30**	2)
33	3.50	180	36	25.0	20.0	23	4	29.5		**EX01M33**	2)
36	4.00	200	40	28.0	22.0	25	4	32		**EX01M36**	2)
39	4.00	200	40	32.0	24.0	27	4	35		**EX01M39**	2)
42	4.50	200	45	32.0	24.0	27	4	37.5		**EX01M42**	2)
48	5.00	250	50	36.0	29.0	32	4	43		**EX01M48**	2)
52	5.00	250	50	40.0	32.0	35	5	47		**EX01M52**	2)
56	5.50	250	55	40.0	32.0	35	5	50.5		**EX01M56**	2)
64	6.00	315	60	50.0	39.0	42	6	58		**EX01M64**	2)

HSS-E

2)

M | DIN 371≤10 376≥12 | 6G | 2.5XD | HSS-PM | C 2-3 | λ45°

EX006G

- M Strojní závitník Spectrum™ Tap, šroubovitá drážka 45°
- M Gépi Menetfúró Spectrum™ Tap Csavart hornyú 45°
- M Gwintownik maszynowy Spectrum™ Tap, śrubowy rowek wiórowy 45°
- M Tarozi de masina Spectrum™ Tap Canal elicoidal 45°
- M Машинные метчики Spectrum™ Tap Спиральная стружечная канавка 45°
- M Machine Tap Spectrum™ Tap Spiral Flute 45°

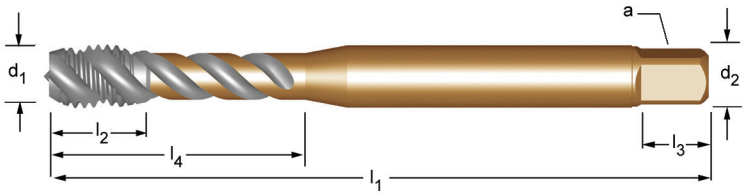
Spectrum™ Tap 360

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**13-30**	M 1		K 1		N 1.1	**13-19**	S 1	**10-14**	H 1		O 1	**24-36**
P 2	**8-19**	M 2		K 2		N 1.2	**28-42**	S 2	**4-14**	H 2		O 2	
P 3	**8-19**	M 3		K 3		N 1.3	**12-24**	S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4	**12-18**	S 4	**4-12**	H 4		O 4	
P 5	**8-19**			K 5		N 2	**12-24**	S 5				O 5	
						N 3.1		S 6				O 6	**24-36**
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$

EX006G



M	P mm	l_1 mm	l_2 mm	d_2 Ø mm	⧄ a mm	l_3 mm	z	↔	l_4 mm	e-Code
3	0.50	56	6	3.5	2.7	6	3	2.5	18	**EX00M36G**
4	0.70	63	7	4.5	3.4	6	3	3.3	21	**EX00M46G**
5	0.80	70	8	6.0	4.9	8	3	4.2	25	**EX00M56G**
6	1.00	80	10	6.0	4.9	8	3	5	31	**EX00M66G**
8	1.25	90	12	8.0	6.2	9	3	6.8	35	**EX00M86G**
10	1.50	100	15	10.0	8.0	11	3	8.5	39	**EX00M106G**
12	1.75	110	16	9.0	7.0	10	3	10.3		**EX00M126G**
14	2.00	110	20	11.0	9.0	12	3	12		**EX00M146G**
16	2.00	110	20	12.0	9.0	12	4	14		**EX00M166G**
20	2.50	140	25	16.0	12.0	15	4	17.5		**EX00M206G** [2]

HSS-E

2)

M | DIN 371≤10 376≥12 | 6G | 2.5XD | HSS-PM | C 2-3 | λ45° | ST

EX016G

- M Strojní závitník Spectrum™ Tap, šroubovitá drážka 45°
- M Gépi Menetfúró Spectrum™ Tap Csavart hornyú 45°
- M Gwintownik maszynowy Spectrum™ Tap, śrubowy rowek wiórowy 45°
- M Tarozi de masina Spectrum™ Tap Canal elicoidal 45°
- M Машинные метчики Spectrum™ Tap Спиральная стружечная канавка 45°
- M Machine Tap Spectrum™ Tap Spiral Flute 45°

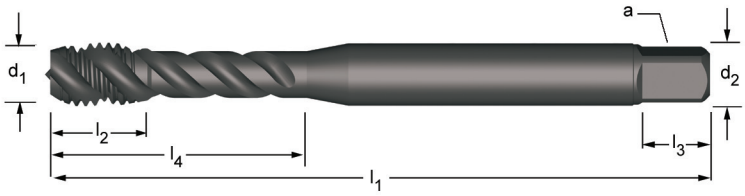
Spectrum™ Tap 360

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**13-30**	M 1	**3-8**	K 1		N 1.1		S 1		H 1		O 1	
P 2	**8-19**	M 2	**5-7**	K 2		N 1.2		S 2		H 2		O 2	
P 3	**8-19**	M 3	**3-5**	K 3		N 1.3		S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4		S 4		H 4		O 4	
P 5	**3-19**			K 5		N 2		S 5				O 5	
						N 3.1		S 6				O 6	
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$

EX016G



M	P mm	l_1 mm	l_2 mm	d_2 Ø mm	⧄ a mm	l_3 mm	z	↔	l_4 mm	e-Code
3	0.50	56	6	3.5	2.7	6	3	2.5	18	**EX01M36G**
4	0.70	63	7	4.5	3.4	6	3	3.3	21	**EX01M46G**
5	0.80	70	8	6.0	4.9	8	3	4.2	25	**EX01M56G**
6	1.00	80	10	6.0	4.9	8	3	5	31	**EX01M66G**
8	1.25	90	12	8.0	6.2	9	3	6.8	35	**EX01M86G**
10	1.50	100	15	10.0	8.0	11	3	8.5	39	**EX01M106G**
12	1.75	110	16	9.0	7.0	10	3	10.3		**EX01M126G**
14	2.00	110	20	11.0	9.0	12	3	12		**EX01M146G**
16	2.00	110	20	12.0	9.0	12	4	14		**EX01M166G**
20	2.50	140	25	16.0	12.0	15	4	17.5		**EX01M206G** [2]

HSS-E

2)

M | DIN 371≤10 376≥12 | 6H | 3XD | HSS-E | C 2-3 | λ45° | Cool TOP

E615

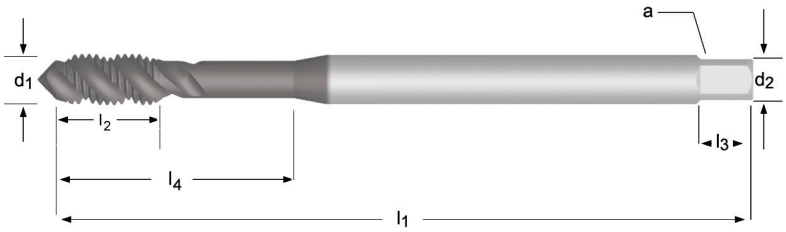
- M Strojní závitník Spectrum™ Tap, prodloužený lamač třísky a šroubovitá drážka 45°
- M Gépi Menetfúró Spectrum™ Tap, extra hosszú Csavart hornyú 45°
- M Gwintownik maszynowy Spectrum™ Tap, zbieżny nakrój, śrubowy rowek wiórowy 45°
- M Tarozi de masina Spectrum™ Tap, extralungi Canal elicoidal 45°
- M Spectrum™ Tap, Спиральная стружечная канавка 45°
- M Machine Tap Spectrum™ Tap, Extra Long Spiral Flute 45°

Spectrum™ Tap 360

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**22-46**	M 1	**4-8**	K 1	**19-29**	N 1.1	**22-34**	S 1		H 1		O 1	
P 2	**8-34**	M 2	**5-7**	K 2	**13-24**	N 1.2		S 2	**6-8**	H 2		O 2	
P 3	**8-34**	M 3	**4-6**	K 3	**19-29**	N 1.3		S 3		H 3		O 3	
P 4	**22-36**			K 4		N 1.4		S 4	**6-8**	H 4		O 4	
P 5	**4-34**			K 5	**13-19**	N 2		S 5				O 5	
						N 3.1	**14-22**	S 6				O 6	
						N 3.2	**28-54**					O 7	
						N 3.3	**36-54**						
						N 3.4							
						N 4	**36-54**						

$$n = \frac{Vc \times 1000}{\pi \times D}$$



M	P mm	l_1 mm	l_2 mm	d_2 Ø mm	◪ a mm	l_3 mm	z	↔	l_4 mm	e-Code
3	0.50	112	6	3.5	2.7	6	3	2.5	18	**E615M3**
4	0.70	112	7	4.5	3.4	6	3	3.3	21	**E615M4**
5	0.80	125	8	6.0	4.9	8	3	4.2	25	**E615M5**
6	1.00	125	10	6.0	4.9	8	3	5	30	**E615M6**
8	1.25	140	13	8.0	6.2	9	3	6.8	40	**E615M8**
10	1.50	160	15	10.0	8.0	11	3	8.5	50	**E615M10**
12	1.75	180	16	9.0	7.0	10	3	10.2		**E615M12**
14	2.00	180	20	11.0	9.0	12	3	12		**E615M14**
16	2.00	200	20	12.0	9.0	12	3	14		**E615M16**
20	2.50	224	25	16	12	15	4	17.5		**E615M20**

M | ANSI | 6H | 2.5XD | HSS-PM | C 2-3 | λ45°

E007

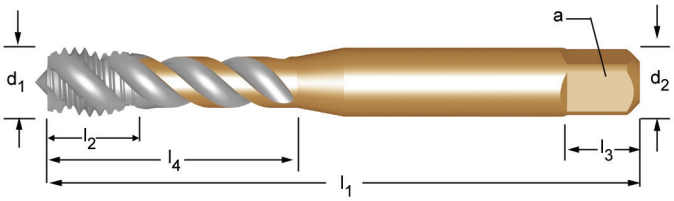
- M Strojní závitník Spectrum™ Tap, zpětný kužel a šroubovitá drážka 45°
- M Gépi Menetfúró Spectrum™ Tap Csavart hornyú 45°
- M Gwintownik maszynowy Spectrum™ Tap, zbieżny nakrój, śrubowy rowek wiórowy 45°
- M Tarozi de masina Spectrum™ Tap Canal elicoidal 45°
- M Spectrum™ Tap Спиральная стружечная канавка 45°
- M Machine Tap Spectrum™ Tap, back tapered Spiral Flute 45°

Spectrum™ Tap 360

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**13-30**	M 1		K 1		N 1.1	**13-19**	S 1	**10-14**	H 1		O 1	**24-36**
P 2	**8-19**	M 2		K 2		N 1.2	**28-42**	S 2	**4-14**	H 2		O 2	
P 3	**8-19**	M 3		K 3		N 1.3	**12-24**	S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4	**12-18**	S 4	**4-12**	H 4		O 4	
P 5	**8-19**			K 5		N 2	**12-24**	S 5				O 5	
						N 3.1		S 6				O 6	**24-36**
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



M	P mm	l_1 inch	l_2 inch	d_2 Ø inch	⧄ a inch	z	↔	l_4 inch	↔	EDP # or Stock No.	e-Code
4	0.70	2.1/8	0.2484	0.1680	0.1310	3	3.30	0.6526	N30	580608	**E007M4**
5	0.80	2.3/8	0.2650	0.1940	0.1520	3	4.20	0.8434	N19	580615	**E007M5**
6	1.00	2.1/2	0.3937	0.2550	0.1910	3	5.00	1.0993	N9	580622	**E007M6**
8	1.25	2.23/32	0.4567	0.3180	0.2380	3	6.80	1.3094	H	580639	**E007M8**
10	1.50	2.15/16	0.5315	0.3810	0.2860	3	8.50	1.4415	Q	580646	**E007M10**
12	1.75	3.3/8	0.6890	0.3670	0.2750	3	10.30	Y		580653	**E007M12**
14	2.00	3.19/32	0.7087	0.4290	0.3220	3	12.00	15/32		580660	**E007M14**
16	2.00	3.13/16	0.7087	0.4800	0.3600	3	14.00	35/64		580677	**E007M16**
18	2.50	4.1/32	0.8858	0.5420	0.4060	3	15.50	39/64		580684	**E007M18**
20	2.50	4.15/32	0.8858	0.6520	0.4890	3	17.50	11/16		580691	**E007M20**

M | ANSI | 6H | 2.5XD | HSS-PM | C 2-3 | λ45° | ST

E008

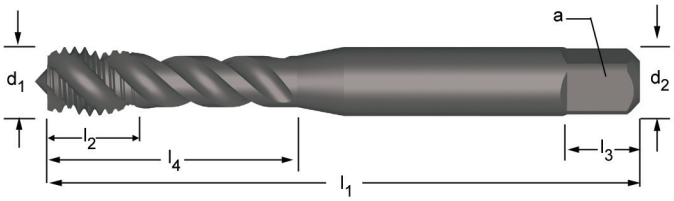
- M Strojní závitník Spectrum™ Tap, zpětný kužel a šroubovitá drážka 45°
- M Gépi Menetfúró Spectrum™ Tap Csavart hornyú 45°
- M Gwintownik maszynowy Spectrum™ Tap, zbieżny nakrój, śrubowy rowek wiórowy 45°
- M Tarozi de masina Spectrum™ Tap Canal elicoidal 45°
- M Spectrum™ Tap Спиральная стружечная канавка 45°
- M Machine Tap Spectrum™ Tap, back tapered Spiral Flute 45°

Spectrum™ Tap 360

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**13-30**	M 1	**3-8**	K 1		N 1.1		S 1		H 1		O 1	
P 2	**8-19**	M 2	**5-7**	K 2		N 1.2		S 2		H 2		O 2	
P 3	**8-19**	M 3	**3-5**	K 3		N 1.3		S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4		S 4		H 4		O 4	
P 5	**3-19**			K 5		N 2		S 5				O 5	
						N 3.1		S 6				O 6	
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



M	P mm	l_1 inch	l_2 inch	d_2 Ø inch	⧄ a inch	z	↔	l_4 inch	↔	EDP # or Stock No.	e-Code
4	0.70	2.1/8	0.2484	0.1680	0.1310	3	3.30	0.6526	N30	0580707	**E008M4**
5	0.80	2.3/8	0.2650	0.1940	0.1520	3	4.20	0.8434	N19	0580714	**E008M5**
6	1.00	2.1/2	0.3937	0.2550	0.1910	3	5.00	1.0993	N9	0580721	**E008M6**
8	1.25	2.23/32	0.4567	0.3180	0.2380	3	6.80	1.3094	H	0580738	**E008M8**
10	1.50	2.15/16	0.5315	0.3810	0.2860	3	8.50	1.4415	Q	0580745	**E008M10**
12	1.75	3.3/8	0.6890	0.3670	0.2750	3	10.30	Y		0580752	**E008M12**
14	2.00	3.19/32	0.7087	0.4290	0.3220	3	12.00	15/32		0580769	**E008M14**
16	2.00	3.13/16	0.7087	0.4800	0.3600	3	14.00	35/64		0580776	**E008M16**
18	2.50	4.1/32	0.8858	0.5420	0.4060	3	15.50	39/64		0580783	**E008M18**
20	2.50	4.15/32	0.8858	0.6520	0.4890	3	17.50	11/16		0580790	**E008M20**

M | ISO 529 | 6H | 2.5XD | HSS-PM | C 2-3 | λ45°

E002

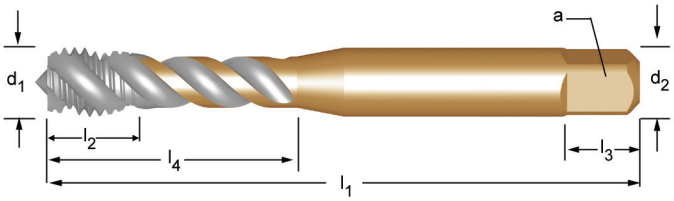
- M Strojní závitník Spectrum™ Tap, šroubovitá drážka 45°
- M Gépi Menetfúró Spectrum™ Tap Csavart hornyú 45°
- M Gwintownik maszynowy Spectrum™ Tap, śrubowy rowek wiórowy 45°
- M Tarozi de masina Spectrum™ Tap Canal elicoidal 45°
- M Машинные метчики Spectrum™ Tap Спиральная стружечная канавка 45°
- M Machine Tap Spectrum™ Tap Spiral Flute 45°

Spectrum™ Tap 360

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**13-30**	M 1		K 1		N 1.1	**13-19**	S 1	**10-14**	H 1		O 1	**24-36**
P 2	**8-19**	M 2		K 2		N 1.2	**28-42**	S 2	**4-14**	H 2		O 2	
P 3	**8-19**	M 3		K 3		N 1.3	**12-24**	S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4	**12-18**	S 4	**4-12**	H 4		O 4	
P 5	**8-19**			K 5		N 2	**12-24**	S 5				O 5	
						N 3.1		S 6				O 6	**24-36**
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



M	P mm	l_1 mm	l_2 mm	d_2 Ø mm	⧄ a mm	l_3 mm	z	↔	l_4 mm	e-Code
2	0.40	41	8	2.50	2.00	4	3	1.6	8	**E002M2**
2.5	0.45	44.5	9.5	2.80	2.24	5	3	2.05	9.5	**E002M2.5**
3	0.50	48	6	3.15	2.50	5	3	2.5	12.5	**E002M3**
3.5	0.60	50	16	3.55	2.80	5	3	2.9	16	**E002M3.5**
4	0.70	53	7	4.00	3.15	6	3	3.3	19	**E002M4**
5	0.80	58	8	5.00	4.00	7	3	4.2	22	**E002M5**
6	1.00	66	10	6.30	5.00	8	3	5.0	27	**E002M6**
7	1.00	66	13	7.10	5.60	8	3	6	26	**E002M7**
8	1.25	72	12	8.00	6.30	9	3	6.8	31	**E002M8**
10	1.50	80	15	10.00	8.00	11	3	8.5	35	**E002M10**
12	1.75	89	16	9.00	7.10	10	3	10.3		**E002M12**
14	2.00	95	18	11.20	9.00	12	3	12.0		**E002M14**
16	2.00	102	18	12.50	10.00	13	4	14.0		**E002M16**
18	2.50	112	29	14.00	11.20	14	4	15.5		**E002M18**
20	2.50	112	29	14.00	11.20	14	4	17.5		**E002M20**
22	2.50	118	29	16.00	12.50	16	4	19.5		**E002M22**
24	3.00	130	35	18.00	14.00	18	4	21.0		**E002M24**

M | ISO 529 | 6H | 2.5XD | HSS-PM | C 2-3 | λ45° | ST

E003

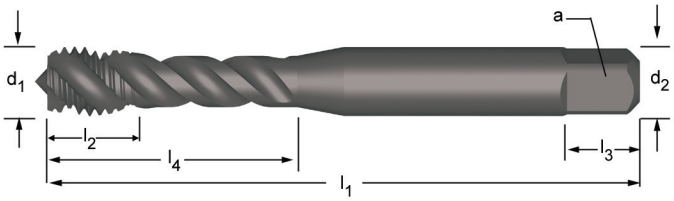
- M Strojní závitník Spectrum™ Tap, šroubovitá drážka 45°
- M Gépi Menetfúró Spectrum™ Tap Csavart hornyú 45°
- M Gwintownik maszynowy Spectrum™ Tap, śrubowy rowek wiórowy 45°
- M Tarozi de masina Spectrum™ Tap Canal elicoidal 45°
- M Машинные метчики Spectrum™ Tap Спиральная стружечная канавка 45°
- M Machine Tap Spectrum™ Tap Spiral Flute 45°

Spectrum™ Tap 360

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**13-30**	M 1	**3-8**	K 1		N 1.1		S 1		H 1		O 1	
P 2	**8-19**	M 2	**5-7**	K 2		N 1.2		S 2		H 2		O 2	
P 3	**8-19**	M 3	**3-5**	K 3		N 1.3		S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4		S 4		H 4		O 4	
P 5	**3-19**			K 5		N 2		S 5				O 5	
						N 3.1		S 6				O 6	
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



M	P mm	l_1 mm	l_2 mm	d_2 Ø mm	⧄ a mm	l_3 mm	z	↔	l_4 mm	e-Code
2	0.40	41	8	2.50	2.00	4	3	1.6	8	**E003M2**
2.5	0.45	44.5	9.5	2.80	2.24	5	3	2.05	9.5	**E003M2.5**
3	0.50	48	6	3.15	2.50	5	3	2.5	12.5	**E003M3**
3.5	0.60	50	16	3.55	2.80	5	3	2.9	16	**E003M3.5**
4	0.70	53	7	4.00	3.15	6	3	3.3	19	**E003M4**
5	0.80	58	8	5.00	4.00	7	3	4.2	22	**E003M5**
6	1.00	66	10	6.30	5.00	8	3	5.0	27	**E003M6**
7	1.00	66	13	7.10	5.60	8	3	6	26	**E003M7**
8	1.25	72	12	8.00	6.30	9	3	6.8	31	**E003M8**
10	1.50	80	15	10.00	8.00	11	3	8.5	35	**E003M10**
12	1.75	89	16	9.00	7.10	10	3	10.3		**E003M12**
14	2.00	95	18	11.20	9.00	12	3	12.0		**E003M14**
16	2.00	102	18	12.50	10.00	13	4	14.0		**E003M16**
18	2.50	112	29	14.00	11.20	14	4	15.5		**E003M18**
20	2.50	112	29	14.00	11.20	14	4	17.5		**E003M20**
22	2.50	118	29	16.00	12.50	16	4	19.5		**E003M22**
24	3.00	130	35	18.00	14.00	18	4	21.0		**E003M24**

EP10

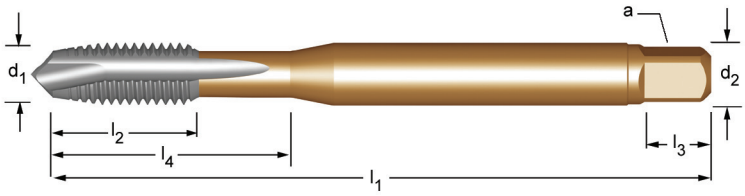
- MF Strojní závitník Spectrum™ Tap lamač třísek, přímá drážka
- MF Gépi Menetfúró Spectrum™ Tap Terelőéles
- MF Gwintownik maszynowy Spectrum™ Tap, ze skośną powierzchnią natarcia
- MF Tarozi de masina Spectrum™ Tap Varf spiral
- MF Машинные метчики Spectrum™ Tap Криволинейная задняя поверхность
- MF Machine Tap Spectrum™ Tap Spiral Point

Spectrum™ Tap 200

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**13-30**	M 1		K 1	**12-18**	N 1.1	**13-19**	S 1	**10-14**	H 1		O 1	**24-36**
P 2	**4-19**	M 2		K 2	**6-18**	N 1.2	**28-42**	S 2	**4-14**	H 2		O 2	
P 3	**4-19**	M 3		K 3	**12-18**	N 1.3	**12-24**	S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4	**12-18**	S 4	**4-12**	H 4		O 4	
P 5	**4-19**			K 5	**6-10**	N 2	**12-24**	S 5				O 5	
						N 3.1	**10-14**	S 6				O 6	**24-36**
						N 3.2	**16-36**					O 7	
						N 3.3	**24-36**						
						N 3.4							
						N 4	**24-36**						

$$n = \frac{Vc \times 1000}{\pi \times D}$$



MF	P mm	l_1 mm	l_2 mm	d_2 Ø mm	◪ a mm	l_3 mm	z	↔	e-Code
4	0.50	63	12	2.8	2.1	5	3	3.5	**EP10M4X.5**
5	0.50	70	13	3.5	2.7	6	3	4.5	**EP10M5X.5**
6	0.75	80	15	4.5	3.4	6	3	5.3	**EP10M6X.75**
8	0.75	80	15	6.0	4.9	8	3	7.3	**EP10M8X.75**
8	1.00	90	18	6.0	4.9	8	3	7	**EP10M8X1.0**
10	0.75	90	18	7.0	5.5	8	3	9.3	**EP10M10X.75**
10	1.00	90	18	7.0	5.5	8	3	9	**EP10M10X1.0**
10	1.25	100	20	7.0	5.5	8	3	8.8	**EP10M10X1.25**
12	1.00	100	21	9.0	7.0	10	3	11	**EP10M12X1.0**
12	1.25	100	21	9.0	7.0	10	3	10.8	**EP10M12X1.25**
12	1.50	100	21	9.0	7.0	10	3	10.5	**EP10M12X1.5**
14	1.00	100	21	11.0	9.0	12	3	13	**EP10M14X1.0**
14	1.25	100	21	11.0	9.0	12	3	13	**EP10M14X1.25**
14	1.50	100	21	11.0	9.0	12	3	12.5	**EP10M14X1.5**
16	1.00	100	21	12.0	9.0	12	3	15	**EP10M16X1.0**
16	1.50	100	21	12.0	9.0	12	3	14.5	**EP10M16X1.5**
18	1.00	110	24	14.0	11.0	14	4	17	**EP10M18X1.0**
18	1.50	110	24	14.0	11.0	14	4	16.5	**EP10M18X1.5** 2)
20	1.00	125	24	16.0	12.0	15	4	19	**EP10M20X1.0** 2)
20	1.50	125	24	16.0	12.0	15	4	18.5	**EP10M20X1.5** 2)
22	1.50	125	25	18.0	14.5	17	4	20.5	**EP10M22X1.5** 2)
24	1.50	140	28	18.0	14.5	17	4	22.5	**EP10M24X1.5** 2)
24	2.00	140	28	18.0	14.5	17	4	22	**EP10M24X2.0** 2)
25	1.50	140	28	18.0	14.5	17	4	23.5	**EP10M25X1.5** 2)
26	1.50	140	28	18.0	14.5	17	4	24.5	**EP10M26X1.5** 2)
27	1.50	140	28	20.0	16.0	19	4	25.5	**EP10M27X1.5** 2)
27	2.00	140	28	20.0	16.0	19	4	25	**EP10M27X2.0** 2)
28	1.50	140	28	20.0	16.0	19	4	26.5	**EP10M28X1.5** 2)
30	1.50	150	28	22.0	18.0	21	4	28.5	**EP10M30X1.5** 2)
30	2.00	150	28	22.0	18.0	21	4	28	**EP10M30X2.0** 2)

HSS-E

2)

MF | DIN 374 | 6H | 2.5XD | HSS-PM | B 3.5-5 | ST

EP11

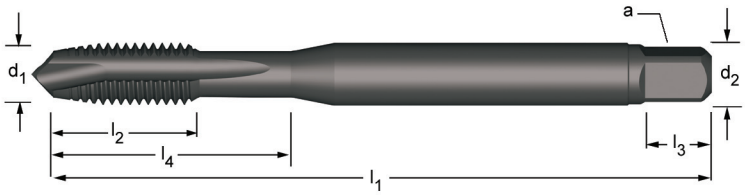
- MF Strojní závitník Spectrum™ Tap lamač třísek, přímá drážka
- MF Gépi Menetfúró Spectrum™ Tap Terelőéles
- MF Gwintownik maszynowy Spectrum™ Tap, ze skośną powierzchnią natarcia
- MF Tarozi de masina Spectrum™ Tap Varf spiral
- MF Машинные метчики Spectrum™ Tap Криволинейная задняя поверхность
- MF Machine Tap Spectrum™ Tap Spiral Point

Spectrum™ Tap 200

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**13-30**	M 1	**3-8**	K 1	**12-18**	N 1.1		S 1		H 1		O 1	
P 2	**4-19**	M 2	**5-7**	K 2	**6-18**	N 1.2		S 2		H 2		O 2	
P 3	**4-19**	M 3	**3-5**	K 3	**12-18**	N 1.3		S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4		S 4		H 4		O 4	
P 5	**3-19**			K 5	**6-10**	N 2		S 5				O 5	
						N 3.1		S 6				O 6	
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



MF	P mm	l_1 mm	l_2 mm	d_2 Ø mm	◪ a mm	l_3 mm	z	↔	e-Code
4	0.50	63	12	2.8	2.1	5	3	3.5	**EP11M4X.5**
5	0.50	70	13	3.5	2.7	6	3	4.5	**EP11M5X.5**
6	0.75	80	15	4.5	3.4	6	3	5.3	**EP11M6X.75**
8	0.75	80	15	6.0	4.9	8	3	7.3	**EP11M8X.75**
8	1.00	90	18	6.0	4.9	8	3	7	**EP11M8X1.0**
10	0.75	90	18	7.0	5.5	8	3	9.3	**EP11M10X.75**
10	1.00	90	18	7.0	5.5	8	3	9	**EP11M10X1.0**
10	1.25	100	20	7.0	5.5	8	3	8.8	**EP11M10X1.25**
12	1.00	100	21	9.0	7.0	10	3	11	**EP11M12X1.0**
12	1.25	100	21	9.0	7.0	10	3	10.8	**EP11M12X1.25**
12	1.50	100	21	9.0	7.0	10	3	10.5	**EP11M12X1.5**
14	1.00	100	21	11.0	9.0	12	3	13	**EP11M14X1.0**
14	1.25	100	21	11.0	9.0	12	3	13	**EP11M14X1.25**
14	1.50	100	21	11.0	9.0	12	3	12.5	**EP11M14X1.5**
16	1.00	100	21	12.0	9.0	12	3	15	**EP11M16X1.0**
16	1.50	100	21	12.0	9.0	12	3	14.5	**EP11M16X1.5**
18	1.00	110	24	14.0	11.0	14	4	17	**EP11M18X1.0**
18	1.50	110	24	14.0	11.0	14	4	16.5	**EP11M18X1.5** 2)
20	1.00	125	24	16.0	12.0	15	4	19	**EP11M20X1.0** 2)
20	1.50	125	24	16.0	12.0	15	4	18.5	**EP11M20X1.5** 2)
22	1.50	125	25	18.0	14.5	17	4	20.5	**EP11M22X1.5** 2)
24	1.50	140	28	18.0	14.5	17	4	22.5	**EP11M24X1.5** 2)
24	2.00	140	28	18.0	14.5	17	4	22	**EP11M24X2.0** 2)
25	1.50	140	28	18.0	14.5	17	4	23.5	**EP11M25X1.5** 2)
26	1.50	140	28	18.0	14.5	17	4	24.5	**EP11M26X1.5** 2)
27	1.50	140	28	20.0	16.0	19	4	25.5	**EP11M27X1.5** 2)
27	2.00	140	28	20.0	16.0	19	4	25	**EP11M27X2.0** 2)
28	1.50	140	28	20.0	16.0	19	4	26.5	**EP11M28X1.5** 2)
30	1.50	150	28	22.0	18.0	21	4	28.5	**EP11M30X1.5** 2)
30	2.00	150	28	22.0	18.0	21	4	28	**EP11M30X2.0** 2)

HSS-E

2)

MF | ANSI | 6H | 2.5XD | HSS-PM | B 3.5-5

E015

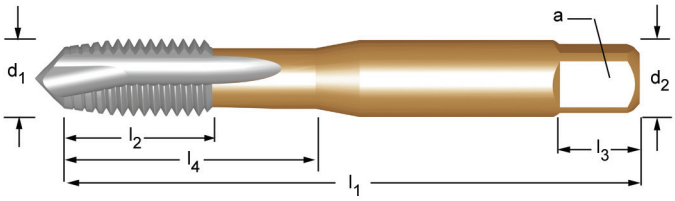
- MF Strojní závitník Spectrum™ Tap lamač třísek, přímá drážka
- MF Gépi Menetfúró Spectrum™ Tap Terelőéles
- MF Gwintownik maszynowy Spectrum™ Tap, ze skośną powierzchnią natarcia
- MF Tarozi de masina Spectrum™ Tap Varf spiral
- MF Машинные метчики Spectrum™ Tap Криволинейная задняя поверхность
- MF Machine Tap Spectrum™ Tap Spiral Point

Spectrum™ Tap 200

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**13-30**	M 1		K 1	**12-18**	N 1.1	**13-19**	S 1	**10-14**	H 1		O 1	**24-36**
P 2	**4-19**	M 2		K 2	**6-18**	N 1.2	**28-42**	S 2	**4-14**	H 2		O 2	
P 3	**4-19**	M 3		K 3	**12-18**	N 1.3	**12-24**	S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4	**12-18**	S 4	**4-12**	H 4		O 4	
P 5	**4-19**			K 5	**6-10**	N 2	**12-24**	S 5				O 5	
						N 3.1	**10-14**	S 6				O 6	**24-36**
						N 3.2	**16-36**					O 7	
						N 3.3	**24-36**						
						N 3.4							
						N 4	**24-36**						

$$n = \frac{Vc \times 1000}{\pi \times D}$$



MF	P mm	l_1 inch	l_2 inch	d_2 Ø inch	⧄ a inch	z	↔	l_4 inch	↔	EDP # or Stock No.	e-Code
8	1.00	2.23/32	0.5939	0.3180	0.2380	3	7.00	1.1891	J	0580912	**E015M8X1.0**
10	1.00	2.15/16	0.6020	0.3810	0.2860	3	9.00	1.2915	T	0580929	**E015M10X1.0**
14	1.50	3.19/32	0.9843	0.4290	0.3220	3	12.50		31/64	0580936	**E015M14X1.5**
18	1.50	4.1/32	1.1614	0.5420	0.4060	3	16.50		41/64	0580943	**E015M18X1.5**

MF | ANSI | 6H | 2.5XD | HSS-PM | B 3.5-5 | ST

E016

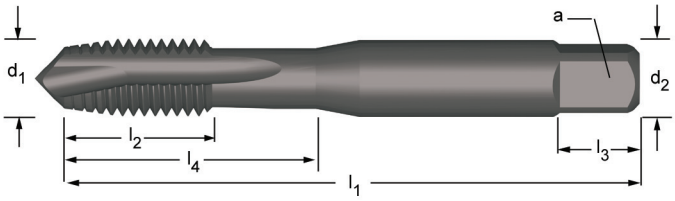
- MF Strojní závitník Spectrum™ Tap lamač třísek, přímá drážka
- MF Gépi Menetfúró Spectrum™ Tap Terelőéles
- MF Gwintownik maszynowy Spectrum™ Tap, ze skośną powierzchnią natarcia
- MF Tarozi de masina Spectrum™ Tap Varf spiral
- MF Машинные метчики Spectrum™ Tap Криволинейная задняя поверхность
- MF Machine Tap Spectrum™ Tap Spiral Point

Spectrum™ Tap 200

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**13-30**	M 1	**3-8**	K 1	**12-18**	N 1.1		S 1		H 1		O 1	
P 2	**4-19**	M 2	**5-7**	K 2	**6-18**	N 1.2		S 2		H 2		O 2	
P 3	**4-19**	M 3	**3-5**	K 3	**12-18**	N 1.3		S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4		S 4		H 4		O 4	
P 5	**3-19**			K 5	**6-10**	N 2		S 5				O 5	
						N 3.1		S 6				O 6	
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



MF	P mm	l_1 inch	l_2 inch	d_2 Ø inch	⧄ a inch	z	↔	l_4 inch	↔	EDP # or Stock No.	e-Code
8	1.00	2.23/32	0.5939	0.3180	0.2380	3	7.00	1.1891	J	0580950	**E016M8X1.0**
10	1.00	2.15/16	0.6020	0.3810	0.2860	3	9.00	1.2915	T	0580967	**E016M10X1.0**
14	1.50	3.19/32	0.9843	0.4290	0.3220	3	12.50		31/64	0580974	**E016M14X1.5**
18	1.50	4.1/32	1.1614	0.5420	0.4060	3	16.50		41/64	0580981	**E016M18X1.5**

MF | ISO 529 | 6H | 2.5XD | HSS-PM | B 3.5-5

E010

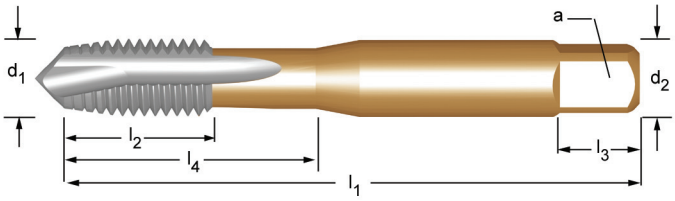
- MF Strojní závitník Spectrum™ Tap lamač třísek, přímá drážka
- MF Gépi Menetfúró Spectrum™ Tap Terelőéles
- MF Gwintownik maszynowy Spectrum™ Tap, ze skośną powierzchnią natarcia
- MF Tarozi de masina Spectrum™ Tap Varf spiral
- MF Машинные метчики Spectrum™ Tap Криволинейная задняя поверхность
- MF Machine Tap Spectrum™ Tap Spiral Point

Spectrum™ Tap 200

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**13-30**	M 1		K 1	**12-18**	N 1.1	**13-19**	S 1	**10-14**	H 1		O 1	**24-36**
P 2	**4-19**	M 2		K 2	**6-18**	N 1.2	**28-42**	S 2	**4-14**	H 2		O 2	
P 3	**4-19**	M 3		K 3	**12-18**	N 1.3	**12-24**	S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4	**12-18**	S 4	**4-12**	H 4		O 4	
P 5	**4-19**			K 5	**6-10**	N 2	**12-24**	S 5				O 5	
						N 3.1	**10-14**	S 6				O 6	**24-36**
						N 3.2	**16-36**					O 7	
						N 3.3	**24-36**						
						N 3.4							
						N 4	**24-36**						

$$n = \frac{Vc \times 1000}{\pi \times D}$$



MF	P mm	l_1 mm	l_2 mm	d_2 Ø mm	◪ a mm	l_3 mm	z	↔	l_4 mm	e-Code
4	0.50	53	17	4.00	3.15	6	3	3.5	17	**E010M4X.5**
5	0.50	58	11	5.00	4.00	7	3	4.5	22	**E010M5X.5**
6	0.50	66	13	6.30	5.00	8	3	5.5	26	**E010M6X.5**
6	0.75	66	13	6.30	5.00	8	3	5.3	26	**E010M6X.75**
8	0.75	72	16	8.00	6.30	9	3	7.3	29	**E010M8X.75**
8	1.00	72	16	8.00	6.30	9	3	7.0	29	**E010M8X1.0**
10	1.00	80	18	10.00	8.00	11	3	9.0	34	**E010M10X1.0**
10	1.25	80	18	10.00	8.00	11	3	8.8	34	**E010M10X1.25**
12	1.00	89	22	9.00	7.10	10	3	11.0		**E010M12X1.0**
12	1.25	89	22	9.00	7.10	10	3	10.8		**E010M12X1.25**
12	1.50	89	22	9.00	7.10	10	3	10.5		**E010M12X1.5**
14	1.00	95	24	11.20	9.00	12	3	13.0		**E010M14X1.0**
14	1.25	95	24	11.20	9.00	12	3	12.8		**E010M14X1.25**
14	1.50	95	24	11.20	9.00	12	3	12.5		**E010M14X1.5**
16	1.00	102	24	12.50	10.00	13	3	15.0		**E010M16X1.0**
16	1.50	102	24	12.50	10.00	13	3	14.5		**E010M16X1.5**
18	1.00	112	29	14.00	11.20	14	4	17.0		**E010M18X1.0**
18	1.50	112	29	14.00	11.20	14	4	16.5		**E010M18X1.5**
20	1.00	112	29	14.00	11.20	14	4	19.0		**E010M20X1.0**
20	1.50	112	29	14.00	11.20	14	4	18.5		**E010M20X1.5**
20	2.00	112	29	14.00	11.20	14	4	18.0		**E010M20X2.0**
22	1.50	118	29	16.00	12.50	16	4	20.5		**E010M22X1.5**
24	1.50	130	35	18.00	14.00	18	4	22.5		**E010M24X1.5**
24	2.00	130	35	18.00	14.00	18	4	22.0		**E010M24X2.0**

MF | ISO 529 | 6H | 2.5XD | HSS-PM | B 3.5-5 | ST

E011

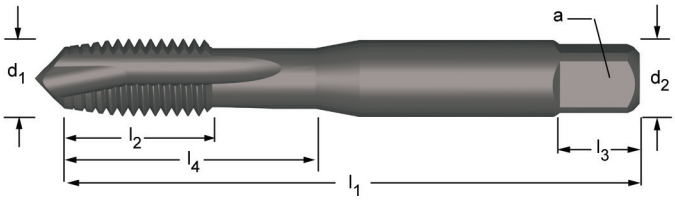
- MF Strojní závitník Spectrum™ Tap lamač třísek, přímá drážka
- MF Gépi Menetfúró Spectrum™ Tap Terelőéles
- MF Gwintownik maszynowy Spectrum™ Tap, ze skośną powierzchnią natarcia
- MF Tarozi de masina Spectrum™ Tap Varf spiral
- MF Машинные метчики Spectrum™ Tap Криволинейная задняя поверхность
- MF Machine Tap Spectrum™ Tap Spiral Point

Spectrum™ Tap 200

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**13-30**	M 1	**3-8**	K 1	**12-18**	N 1.1		S 1		H 1		O 1	
P 2	**4-19**	M 2	**5-7**	K 2	**6-18**	N 1.2		S 2		H 2		O 2	
P 3	**4-19**	M 3	**3-5**	K 3	**12-18**	N 1.3		S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4		S 4		H 4		O 4	
P 5	**3-19**			K 5	**6-10**	N 2		S 5				O 5	
						N 3.1		S 6				O 6	
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



MF	P mm	l_1 mm	l_2 mm	d_2 Ø mm	⧄ a mm	l_3 mm	z	↔	l_4 mm	e-Code
4	0.50	53	17	4.00	3.15	6	3	3.5	14	**E011M4X.5**
5	0.50	58	11	5.00	4.00	7	3	4.5	22	**E011M5X.5**
6	0.50	66	13	6.30	5.00	8	3	5.5	26	**E011M6X.5**
6	0.75	66	13	6.30	5.00	8	3	5.3	26	**E011M6X.75**
8	0.75	72	16	8.00	6.30	9	3	7.3	29	**E011M8X.75**
8	1.00	72	16	8.00	6.30	9	3	7.0	29	**E011M8X1.0**
10	1.00	80	18	10.00	8.00	11	3	9.0	34	**E011M10X1.0**
10	1.25	80	18	10.00	8.00	11	3	8.8	34	**E011M10X1.25**
12	1.00	89	22	9.00	7.10	10	3	11.0		**E011M12X1.0**
12	1.25	89	22	9.00	7.10	10	3	10.8		**E011M12X1.25**
12	1.50	89	22	9.00	7.10	10	3	10.5		**E011M12X1.5**
14	1.00	95	24	11.20	9.00	12	3	13.0		**E011M14X1.0**
14	1.25	95	24	11.20	9.00	12	3	12.8		**E011M14X1.25**
14	1.50	95	24	11.20	9.00	12	3	12.5		**E011M14X1.5**
16	1.00	102	24	12.50	10.00	13	3	15.0		**E011M16X1.0**
16	1.50	102	24	12.50	10.00	13	3	14.5		**E011M16X1.5**
18	1.00	112	29	14.00	11.20	14	4	17.0		**E011M18X1.0**
18	1.50	112	29	14.00	11.20	14	4	16.5		**E011M18X1.5**
20	1.00	112	29	14.00	11.20	14	4	19.0		**E011M20X1.0**
20	1.50	112	29	14.00	11.20	14	4	18.5		**E011M20X1.5**
20	2.00	112	29	14.00	11.20	14	4	18.0		**E011M20X2.0**
22	1.50	118	29	16.00	12.50	16	4	20.5		**E011M22X1.5**
24	1.50	130	35	18.00	14.00	18	4	22.5		**E011M24X1.5**
24	2.00	130	35	18.00	14.00	18	4	22.0		**E011M24X2.0**

MF | DIN 374 | 6H | 2.5XD | HSS-PM | C 2-3 | λ45°

EX10

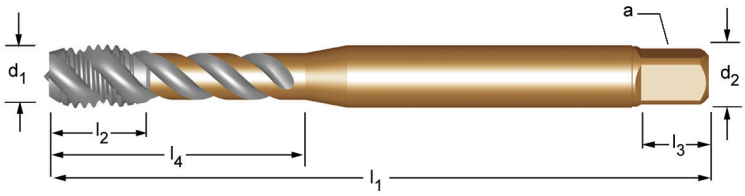
- MF Strojní závitník Spectrum™ Tap, šroubovitá drážka 45°
- MF Gépi Menetfúró Spectrum™ Tap Csavart hornyú 45°
- MF Gwintownik maszynowy Spectrum™ Tap, śrubowy rowek wiórowy 45°
- MF Tarozi de masina Spectrum™ Tap Canal elicoidal 45°
- MF Машинные метчики Spectrum™ Tap Спиральная стружечная канавка 45°
- MF Machine Tap Spectrum™ Tap Spiral Flute 45°

Spectrum™ Tap 360

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**13-30**	M 1		K 1		N 1.1	**13-19**	S 1	**10-14**	H 1		O 1	**24-36**
P 2	**8-19**	M 2		K 2		N 1.2	**28-42**	S 2	**4-14**	H 2		O 2	
P 3	**8-19**	M 3		K 3		N 1.3	**12-24**	S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4	**12-18**	S 4	**4-12**	H 4		O 4	
P 5	**8-19**			K 5		N 2	**12-24**	S 5				O 5	
						N 3.1		S 6				O 6	**24-36**
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



MF	P mm	l_1 mm	l_2 mm	d_2 Ø mm	◪ a mm	l_3 mm	z	↔	e-Code
4	0.50	63	7	2.8	2.1	5	3	3.5	**EX10M4X.50**
5	0.50	70	8	3.5	2.7	6	3	4.5	**EX10M5X.50**
6	0.75	80	10	4.5	3.4	6	3	5.3	**EX10M6X.75**
8	0.75	80	13	6.0	4.9	8	3	7.3	**EX10M8X.75**
8	1.00	90	13	6.0	4.9	8	3	7	**EX10M8X1.0**
10	0.75	90	13	7.0	5.5	8	3	9.3	**EX10M10X.75**
10	1.00	90	13	7.0	5.5	8	3	9	**EX10M10X1.0**
10	1.25	100	15	7.0	5.5	8	3	8.8	**EX10M10X1.25**
12	1.00	100	15	9.0	7.0	10	3	11	**EX10M12X1.0**
12	1.25	100	15	9.0	7.0	10	3	10.8	**EX10M12X1.25**
12	1.50	100	15	9.0	7.0	10	3	10.5	**EX10M12X1.5**
14	1.00	100	15	11.0	9.0	12	3	13	**EX10M14X1.0**
14	1.25	100	15	11.0	9.0	12	3	12.8	**EX10M14X1.25**
14	1.50	100	15	11.0	9.0	12	3	12.5	**EX10M14X1.5**
16	1.00	100	15	12.0	9.0	12	4	15	**EX10M16X1.0**
16	1.50	100	15	12.0	9.0	12	4	14.5	**EX10M16X1.5**
18	1.00	110	17	14.0	11.0	14	4	17	**EX10M18X1.0** 2)
18	1.50	110	17	14.0	11.0	14	4	16.5	**EX10M18X1.5** 2)
20	1.00	125	17	16.0	12.0	15	4	19	**EX10M20X1.0** 2)
20	1.50	125	17	16.0	12.0	15	4	18.5	**EX10M20X1.5** 2)
22	1.50	125	17	18.0	14.5	17	4	20.5	**EX10M22X1.5** 2)
24	1.50	140	20	18.0	14.5	17	4	22.5	**EX10M24X1.5** 2)
24	2.00	140	20	18.0	14.5	17	4	22	**EX10M24X2.0** 2)
25	1.50	140	20	18.0	14.5	17	4	23.5	**EX10M25X1.5** 2)
26	1.50	140	20	18.0	14.5	17	4	24.5	**EX10M26X1.5** 2)
27	1.50	140	20	20.0	16.0	19	4	25.5	**EX10M27X1.5** 2)
27	2.00	140	20	20.0	16.0	19	4	25	**EX10M27X2.0** 2)
28	1.50	140	20	20.0	16.0	19	4	26.5	**EX10M28X1.5** 2)
30	1.50	150	20	22.0	18.0	21	4	28.5	**EX10M30X1.5** 2)
30	2.00	150	20	22.0	18.0	21	4	28	**EX10M30X2.0** 2)

HSS-E

2)

MF | DIN 374 | 6H | 2.5XD | HSS-PM | C 2-3 | λ45° | ST

EX11

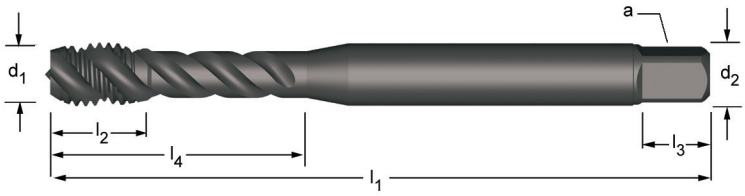
- MF Strojní závitník Spectrum™ Tap, šroubovitá drážka 45°
- MF Gépi Menetfúró Spectrum™ Tap Csavart hornyú 45°
- MF Gwintownik maszynowy Spectrum™ Tap, śrubowy rowek wiórowy 45°
- MF Tarozi de masina Spectrum™ Tap Canal elicoidal 45°
- MF Машинные метчики Spectrum™ Tap Спиральная стружечная канавка 45°
- MF Machine Tap Spectrum™ Tap Spiral Flute 45°

Spectrum™ Tap 360

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**13-30**	M 1	**3-8**	K 1		N 1.1		S 1		H 1		O 1	
P 2	**8-19**	M 2	**5-7**	K 2		N 1.2		S 2		H 2		O 2	
P 3	**8-19**	M 3	**3-5**	K 3		N 1.3		S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4		S 4		H 4		O 4	
P 5	**3-19**			K 5		N 2		S 5				O 5	
						N 3.1		S 6				O 6	
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



MF	P mm	l_1 mm	l_2 mm	d_2 Ø mm	◪ a mm	l_3 mm	z	↔	e-Code
4	0.50	63	7	2.8	2.1	5	3	3.5	**EX11M4X.50**
5	0.50	70	8	3.5	2.7	6	3	4.5	**EX11M5X.50**
6	0.75	80	10	4.5	3.4	6	3	5.3	**EX11M6X.75**
8	0.75	80	13	6.0	4.9	8	3	7.3	**EX11M8X.75**
8	1.00	90	13	6.0	4.9	8	3	7	**EX11M8X1.0**
10	0.75	90	13	7.0	5.5	8	3	9.3	**EX11M10X.75**
10	1.00	90	13	7.0	5.5	8	3	9	**EX11M10X1.0**
10	1.25	100	15	7.0	5.5	8	3	8.8	**EX11M10X1.25**
12	1.00	100	15	9.0	7.0	10	3	11	**EX11M12X1.0**
12	1.25	100	15	9.0	7.0	10	3	10.8	**EX11M12X1.25**
12	1.50	100	15	9.0	7.0	10	3	10.5	**EX11M12X1.5**
14	1.00	100	15	11.0	9.0	12	3	13	**EX11M14X1.0**
14	1.25	100	15	11.0	9.0	12	3	12.8	**EX11M14X1.25**
14	1.50	100	15	11.0	9.0	12	3	12.5	**EX11M14X1.5**
16	1.00	100	15	12.0	9.0	12	4	15	**EX11M16X1.0**
16	1.50	100	15	12.0	9.0	12	4	14.5	**EX11M16X1.5**
18	1.00	110	17	14.0	11.0	14	4	17	**EX11M18X1.0** 2)
18	1.50	110	17	14.0	11.0	14	4	16.5	**EX11M18X1.5** 2)
20	1.00	125	17	16.0	12.0	15	4	19	**EX11M20X1.0** 2)
20	1.50	125	17	16.0	12.0	15	4	18.5	**EX11M20X1.5** 2)
22	1.50	125	17	18.0	14.5	17	4	20.5	**EX11M22X1.5** 2)
24	1.50	140	20	18.0	14.5	17	4	22.5	**EX11M24X1.5** 2)
24	2.00	140	20	18.0	14.5	17	4	22	**EX11M24X2.0** 2)
25	1.50	140	20	18.0	14.5	17	4	23.5	**EX11M25X1.5** 2)
26	1.50	140	20	18.0	14.5	17	4	24.5	**EX11M26X1.5** 2)
27	1.50	140	20	20.0	16.0	19	4	25.5	**EX11M27X1.5** 2)
27	2.00	140	20	20.0	16.0	19	4	25	**EX11M27X2.0** 2)
28	1.50	140	20	20.0	16.0	19	4	26.5	**EX11M28X1.5** 2)
30	1.50	150	20	22.0	18.0	21	4	28.5	**EX11M30X1.5** 2)
30	2.00	150	20	22.0	18.0	21	4	28	**EX11M30X2.0** 2)

HSS-E

2)

MF | ANSI | 6H | 2.5XD | HSS-PM | C 2-3 | λ45°

E017

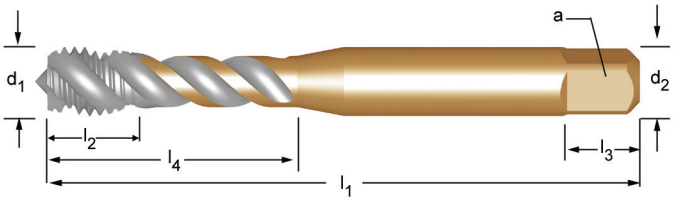
- MF Strojní závitník Spectrum™ Tap, šroubovitá drážka 45°
- MF Gépi Menetfúró Spectrum™ Tap Csavart hornyú 45°
- MF Gwintownik maszynowy Spectrum™ Tap, śrubowy rowek wiórowy 45°
- MF Tarozi de masina Spectrum™ Tap Canal elicoidal 45°
- MF Машинные метчики Spectrum™ Tap Спиральная стружечная канавка 45°
- MF Machine Tap Spectrum™ Tap Spiral Flute 45°

Spectrum™ Tap 360

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**13-30**	M 1		K 1		N 1.1	**13-19**	S 1	**10-14**	H 1		O 1	**24-36**
P 2	**8-19**	M 2		K 2		N 1.2	**28-42**	S 2	**4-14**	H 2		O 2	
P 3	**8-19**	M 3		K 3		N 1.3	**12-24**	S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4	**12-18**	S 4	**4-12**	H 4		O 4	
P 5	**8-19**			K 5		N 2	**12-24**	S 5				O 5	
						N 3.1		S 6				O 6	**24-36**
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



MF	P mm	l_1 inch	l_2 inch	d_2 Ø inch	⧄ a inch	z	↔	l_4 inch	↔	EDP # or Stock No.	e-Code
8	1.00	2.23/32	0.4567	0.3180	0.2380	3	J	1.3094	7.00	0580998	**E017M8X1.0**
10	1.00	2.15/16	0.5315	0.3810	0.2860	3	T	1.4415	9.00	0581001	**E017M10X1.0**
14	1.50	3.19/32	0.7087	0.4290	0.3220	3	31/64		12.50	0581018	**E017M14X1.5**
18	1.50	4.1/32	0.8858	0.5420	0.4060	3	41/64		16.50	0581025	**E017M18X1.5**

MF | ANSI | 6H | 2.5XD | HSS-PM | C 2-3 | λ45° | ST

E018

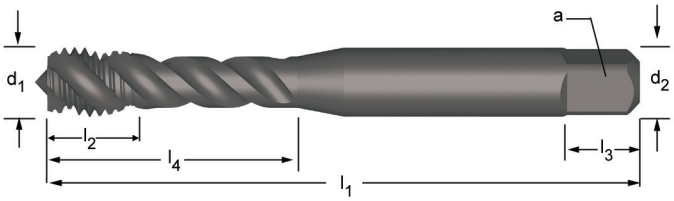
- MF Strojní závitník Spectrum™ Tap, šroubovitá drážka 45°
- MF Gépi Menetfúró Spectrum™ Tap Csavart hornyú 45°
- MF Gwintownik maszynowy Spectrum™ Tap, śrubowy rowek wiórowy 45°
- MF Tarozi de masina Spectrum™ Tap Canal elicoidal 45°
- MF Машинные метчики Spectrum™ Tap Спиральная стружечная канавка 45°
- MF Machine Tap Spectrum™ Tap Spiral Flute 45°

Spectrum™ Tap 360

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**13-30**	M 1	**3-8**	K 1		N 1.1		S 1		H 1		O 1	
P 2	**8-19**	M 2	**5-7**	K 2		N 1.2		S 2		H 2		O 2	
P 3	**8-19**	M 3	**3-5**	K 3		N 1.3		S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4		S 4		H 4		O 4	
P 5	**3-19**			K 5		N 2		S 5				O 5	
						N 3.1		S 6				O 6	
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



MF	P mm	l_1 inch	l_2 inch	d_2 Ø inch	⧄ a inch	z	↔	l_4 inch	↔	EDP # or Stock No.	e-Code
8	1.00	2.23/32	0.4567	0.3180	0.2380	3	J	1.3094	7.00	0581032	**E018M8X1.0**
10	1.00	2.15/16	0.5315	0.3810	0.2860	3	T	1.4415	9.00	0581049	**E018M10X1.0**
14	1.50	3.19/32	0.7087	0.4290	0.3220	3	31/64		12.50	0581056	**E018M14X1.5**
18	1.50	4.1/32	0.8858	0.5420	0.4060	3	41/64		16.50	0581063	**E018M18X1.5**

MF | ISO 529 | 6H | 2.5XD | HSS-PM | C 2-3 | λ45°

E012

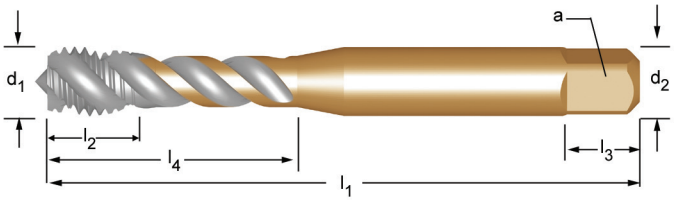
- MF Strojní závitník Spectrum™ Tap, šroubovitá drážka 45°
- MF Gépi Menetfúró Spectrum™ Tap Csavart hornyú 45°
- MF Gwintownik maszynowy Spectrum™ Tap, śrubowy rowek wiórowy 45°
- MF Tarozi de masina Spectrum™ Tap Canal elicoidal 45°
- MF Машинные метчики Spectrum™ Tap Спиральная стружечная канавка 45°
- MF Machine Tap Spectrum™ Tap Spiral Flute 45°

Spectrum™ Tap 360

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**13-30**	M 1		K 1		N 1.1	**13-19**	S 1	**10-14**	H 1		O 1	**24-36**
P 2	**8-19**	M 2		K 2		N 1.2	**28-42**	S 2	**4-14**	H 2		O 2	
P 3	**8-19**	M 3		K 3		N 1.3	**12-24**	S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4	**12-18**	S 4	**4-12**	H 4		O 4	
P 5	**8-19**			K 5		N 2	**12-24**	S 5				O 5	
						N 3.1		S 6				O 6	**24-36**
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



MF	P mm	l_1 mm	l_2 mm	d_2 Ø mm	◪ a mm	l_3 mm	z	↔	l_4 mm	e-Code
4	0.50	53	7	4.0	3.15	6	3	3.5	19	**E012M4X.5**
5	0.50	58	8	5.0	4.0	7	3	4.5	22	**E012M5X.5**
6	0.50	66	10	6.3	5.0	8	3	5.5	27	**E012M6X.5**
6	0.75	66	10	6.3	5.0	8	3	5.3	27	**E012M6X.75**
8	0.75	72	12	8.0	6.3	9	3	7.3	31	**E012M8X.75**
8	1.00	72	12	8.0	6.3	9	3	7.0	31	**E012M8X1.0**
10	1.00	80	15	10.0	8.0	11	3	9.0	35	**E012M10X1.0**
10	1.25	80	15	10.0	8.0	11	3	8.8	35	**E012M10X1.25**
12	1.00	89	16	9.0	7.1	10	3	11.0		**E012M12X1.0**
12	1.25	89	16	9.0	7.1	10	3	10.8		**E012M12X1.25**
12	1.50	89	16	9.0	7.1	10	3	10.5		**E012M12X1.5**
14	1.50	95	18	11.2	9.0	12	3	12.5		**E012M14X1.5**
16	1.00	102	18	12.5	10.0	13	4	15.0		**E012M16X1.0**
16	1.50	102	18	12.5	10.0	13	4	14.5		**E012M16X1.5**
18	1.50	112	29	14.0	11.2	14	4	16.5		**E012M18X1.5**
20	1.50	112	29	14.0	11.2	14	4	18.5		**E012M20X1.5**
22	1.50	118	29	16.0	12.5	16	4	20.5		**E012M22X1.5**

MF | ISO 529 | 6H | 2.5XD | HSS-PM | C 2-3 | λ45° | ST

E013

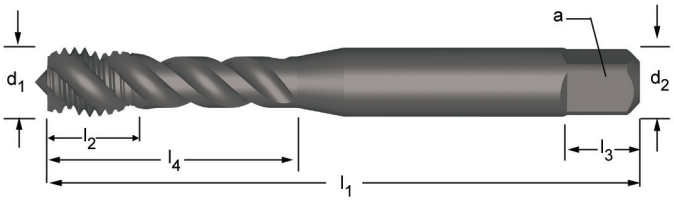
- MF Strojní závitník Spectrum™ Tap, šroubovitá drážka 45°
- MF Gépi Menetfúró Spectrum™ Tap Csavart hornyú 45°
- MF Gwintownik maszynowy Spectrum™ Tap, śrubowy rowek wiórowy 45°
- MF Tarozi de masina Spectrum™ Tap Canal elicoidal 45°
- MF Машинные метчики Spectrum™ Tap Спиральная стружечная канавка 45°
- MF Machine Tap Spectrum™ Tap Spiral Flute 45°

Spectrum™ Tap 360

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**13-30**	M 1	**3-8**	K 1		N 1.1		S 1		H 1		O 1	
P 2	**8-19**	M 2	**5-7**	K 2		N 1.2		S 2		H 2		O 2	
P 3	**8-19**	M 3	**3-5**	K 3		N 1.3		S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4		S 4		H 4		O 4	
P 5	**3-19**			K 5		N 2		S 5				O 5	
						N 3.1		S 6				O 6	
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



MF	P mm	l_1 mm	l_2 mm	d_2 Ø mm	a mm	l_3 mm	z	↔	l_4 mm	e-Code
4	0.50	53	7	4.0	3.15	6	3	3.5	19	**E013M4X.5**
5	0.50	58	8	5.0	4.0	7	3	4.5	22	**E013M5X.5**
6	0.50	66	10	6.3	5.0	8	3	5.5	27	**E013M6X.5**
6	0.75	66	10	6.3	5.0	8	3	5.3	27	**E013M6X.75**
8	0.75	72	12	8.0	6.3	9	3	7.3	31	**E013M8X.75**
8	1.00	72	12	8.0	6.3	9	3	7.0	31	**E013M8X1.0**
10	1.00	80	15	10.0	8.0	11	3	9.0	35	**E013M10X1.0**
10	1.25	80	15	10.0	8.0	11	3	8.8	35	**E013M10X1.25**
12	1.00	89	16	9.0	7.1	10	3	11.0		**E013M12X1.0**
12	1.25	89	16	9.0	7.1	10	3	10.8		**E013M12X1.25**
12	1.50	89	16	9.0	7.1	10	3	10.5		**E013M12X1.5**
14	1.50	95	18	11.2	9.0	12	3	12.5		**E013M14X1.5**
16	1.00	102	18	12.5	10.0	13	4	15.0		**E013M16X1.0**
16	1.50	102	18	12.5	10.0	13	4	14.5		**E013M16X1.5**
18	1.50	112	29	14.0	11.2	14	4	16.5		**E013M18X1.5**
20	1.50	112	29	14.0	11.2	14	4	18.5		**E013M20X1.5**
22	1.50	118	29	16.0	12.5	16	4	20.5		**E013M22X1.5**

UNC | DIN 2184-1 | 2B | 2.5XD | HSS-PM | B 3.5-5

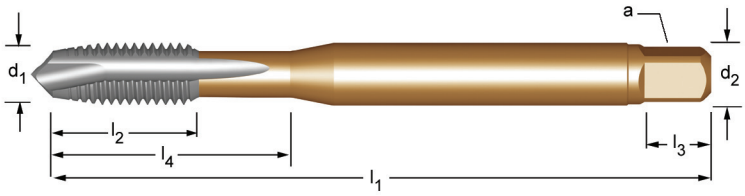
EP20

- UNC Strojní závitník Spectrum™ Tap lamač třísek, přímá drážka
- UNC Gépi Menetfúró Spectrum™ Tap Terelőéles
- UNC Gwintownik maszynowy Spectrum™ Tap ze skośną powierzchnią natarcia
- UNC Tarozi de masina Spectrum™ Tap Varf spiral
- UNC Машинные метчики Spectrum™ Tap Криволинейная задняя поверхность
- UNC Machine Tap Spectrum™ Tap Spiral Point

Spectrum™ Tap 200

Vc[m/min]													
P		M		K		N		S		H		O	
P 1	**13-30**	M 1		K 1	**12-18**	N 1.1	**13-19**	S 1	**10-14**	H 1		O 1	**24-36**
P 2	**4-19**	M 2		K 2	**6-18**	N 1.2	**28-42**	S 2	**4-14**	H 2		O 2	
P 3	**4-19**	M 3		K 3	**12-18**	N 1.3	**12-24**	S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4	**12-18**	S 4	**4-12**	H 4		O 4	
P 5	**4-19**			K 5	**6-10**	N 2	**12-24**	S 5				O 5	
						N 3.1	**10-14**	S 6				O 6	**24-36**
						N 3.2	**16-36**					O 7	
						N 3.3	**24-36**						
						N 3.4							
						N 4	**24-36**						

$$n = \frac{Vc \times 1000}{\pi \times D}$$



UNC	TPI	d_1 nom mm	l_1 mm	l_2 mm	d_2 Ø mm	⧄ a mm	l_3 mm	z	↔	l_4 mm	e-Code
4	40	2.845	56	9	3.5	2.7	6	3	2.35	18	**EP204-40**
5	40	3.175	56	10	3.5	2.7	6	3	2.65	18	**EP205-40**
6	32	3.505	56	11	4.0	3.0	6	3	2.85	20	**EP206-32**
8	32	4.166	63	12	4.5	3.4	8	3	3.5	21	**EP208-32**
10	24	4.826	70	13	6.0	4.9	8	3	3.9	25	**EP2010-24**
12	24	5.486	80	15	6.0	4.9	8	3	4.5	30	**EP2012-24**
1/4	20	6.350	80	15	7.0	5.5	8	3	5.1	30	**EP201/4**
5/16	18	7.938	90	18	8.0	6.2	9	3	6.6	35	**EP205/16**
3/8	16	9.525	100	20	10.0	8.0	11	3	8	39	**EP203/8**
7/16	14	11.112	100	20	8.0	6.2	9	3	9.4		**EP207/16**
1/2	13	12.700	110	23	9.0	7.0	10	3	10.8		**EP201/2**
5/8	11	15.875	110	25	12.0	9.0	12	3	13.5		**EP205/8**
3/4	10	19.050	125	30	14.0	11.0	14	4	16.5		**EP203/4** [2)]
7/8	9	22.225	140	34	18.0	14.5	17	4	19.5		**EP207/8** [2)]
1“	8	25.400	160	38	18.0	14.5	17	4	22.25		**EP201** [2)]

HSS-E

2)

UNC | DIN 2184-1 | 2B | 2.5XD | HSS-PM | B 3.5-5 | ST

EP21

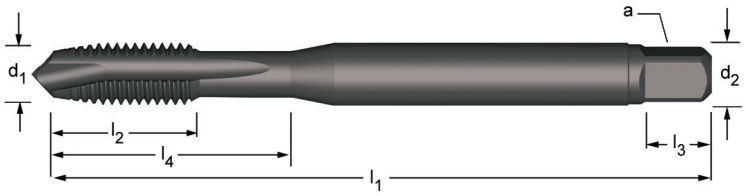
- UNC Strojní závitník Spectrum™ Tap lamač třísek, přímá drážka
- UNC Gépi Menetfúró Spectrum™ Tap Terelőéles
- UNC Gwintownik maszynowy Spectrum™ Tap ze skośną powierzchnią natarcia
- UNC Tarozi de masina Spectrum™ Tap Varf spiral
- UNC Машинные метчики Spectrum™ Tap Криволинейная задняя поверхность
- UNC Machine Tap Spectrum™ Tap Spiral Point

Spectrum™ Tap 200

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**13-30**	M 1	**3-8**	K 1	**12-18**	N 1.1		S 1		H 1		O 1	
P 2	**4-19**	M 2	**5-7**	K 2	**6-18**	N 1.2		S 2		H 2		O 2	
P 3	**4-19**	M 3	**3-5**	K 3	**12-18**	N 1.3		S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4		S 4		H 4		O 4	
P 5	**3-19**			K 5	**6-10**	N 2		S 5				O 5	
						N 3.1		S 6				O 6	
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



UNC	TPI	d_1 nom mm	l_1 mm	l_2 mm	d_2 Ø mm	⧄ a mm	l_3 mm	z	↔	l_4 mm	e-Code
4	40	2.845	56	9	3.5	2.7	6	3	2.35	18	**EP214-40**
5	40	3.175	56	10	3.5	2.7	6	3	2.65	18	**EP215-40**
6	32	3.505	56	11	4.0	3.0	6	3	2.85	20	**EP216-32**
8	32	4.166	63	12	4.5	3.4	8	3	3.5	21	**EP218-32**
10	24	4.826	70	13	6.0	4.9	8	3	3.9	25	**EP2110-24**
12	24	5.486	80	15	6.0	4.9	8	3	4.5	30	**EP2112-24**
1/4	20	6.350	80	15	7.0	5.5	8	3	5.1	30	**EP211/4**
5/16	18	7.938	90	18	8.0	6.2	9	3	6.6	35	**EP215/16**
3/8	16	9.525	100	20	10.0	8.0	11	3	8	39	**EP213/8**
7/16	14	11.112	100	20	8.0	6.2	9	3	9.4		**EP217/16**
1/2	13	12.700	110	23	9.0	7.0	10	3	10.8		**EP211/2**
5/8	11	15.875	110	25	12.0	9.0	12	3	13.5		**EP215/8**
3/4	10	19.050	125	30	14.0	11.0	14	4	16.5		**EP213/4** [2)]
7/8	9	22.225	140	34	18.0	14.5	17	4	19.5		**EP217/8** [2)]
1“	8	25.400	160	38	18.0	14.5	17	4	22.25		**EP211** [2)]

HSS-E

2)

UNC | ANSI | 3B | 2.5XD | HSS-PM | B 3.5-5

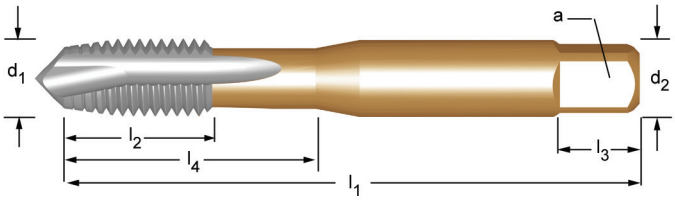
E025

- UNC Strojní závitník Spectrum™ Tap, prodloužený lamač třísky, přímá drážka
- UNC Gépi Menetfúró Spectrum™ Tap, extra hosszú Terelőéles
- UNC Gwintowniki maszynowy, Spectrum™ Tap, Bardzo długi, ze skośną powierzchnią natarcia
- UNC Tarozi de masina Spectrum™ Tap, extralungi Varf spiral
- UNC Spectrum™ Tap, Криволинейная задняя поверхность
- UNC Machine Tap Spectrum™ Tap, Extra Long Spiral Point

Spectrum™ Tap 200

Vc[m/min]													
P		M		K		N		S		H		O	
P 1	**13-30**	M 1		K 1	**12-18**	N 1.1	**13-19**	S 1	**10-14**	H 1		O 1	**24-36**
P 2	**4-19**	M 2		K 2	**6-18**	N 1.2	**28-42**	S 2	**4-14**	H 2		O 2	
P 3	**4-19**	M 3		K 3	**12-18**	N 1.3	**12-24**	S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4	**12-18**	S 4	**4-12**	H 4		O 4	
P 5	**4-19**			K 5	**6-10**	N 2	**12-24**	S 5				O 5	
						N 3.1	**10-14**	S 6				O 6	**24-36**
						N 3.2	**16-36**					O 7	
						N 3.3	**24-36**						
						N 3.4							
						N 4	**24-36**						

$$n = \frac{Vc \times 1000}{\pi \times D}$$



UNC	TPI	l_1 inch	l_2 inch	d_2 Ø inch	⧄ a inch	z	Limits	↔	l_4 inch	↔	EDP # or Stock No.	e-Code
6	32	2“	0.2610	0.1410	0.1100	2	H2	N36	0.5938	2.85	0581070	**E0256-32**
8	32	2.1/8	0.2484	0.1680	0.1310	2	H2	N29	0.6526	3.50	0581087	**E0258-32**
10	24	2.3/8	0.4303	0.1940	0.1520	2	H3	N25	0.8434	3.90	0581094	**E02510-24**
12	24	2.3/8	0.4173	0.2200	0.1650	2	H3	N16	0.8848	4.50	0581100	**E02512-24**
1/4	20	2.1/2	0.5075	0.2550	0.1910	2	H3	N7	1.0073	5.10	0581117	**E0251/4**
1/4	20	2.1/2	0.5075	0.2550	0.1910	3	H3	N7	1.0073	5.10	0581124	**E0251/43FL**
5/16	18	2.23/32	0.5939	0.3180	0.2380	2	H3	F	1.1891	6.60	0581131	**E0255/16**
5/16	18	2.23/32	0.5939	0.3180	0.2380	3	H3	F	1.1891	6.60	0581148	**E0255/163FL**
3/8	16	2.15/16	0.6020	0.3810	0.2860	2	H3	5/16	1.2915	8.00	0581155	**E0253/8**
3/8	16	2.15/16	0.6020	0.3810	0.2860	3	H3	5/16	1.2915	8.00	0581162	**E0253/83FL**
7/16	14	3.5/32	0.9055	0.3230	0.2420	3	H3	U		9.40	0581179	**E0257/16**
1/2	13	3.3/8	0.9055	0.3670	0.2750	2	H3	27/64		10.80	0581186	**E0251/2**
1/2	13	3.3/8	0.9055	0.3670	0.2750	3	H3	27/64		10.80	0581193	**E0251/23FL**
9/16	12	3.19/32	0.9843	0.4290	0.3220	3	H3	31/64		12.20	0581209	**E0259/16**
5/8	11	3.13/16	0.9843	0.4800	0.3600	3	H3	17/32		13.50	0581216	**E0255/8**
3/4	10	4.1/4	1.1614	0.5900	0.4420	3	H4	21/32		16.50	0581223	**E0253/4**
7/8	9	4.11/16	1.1614	0.6970	0.5230	3	H4	49/64		19.50	0581230	**E0257/8**
1“	8	5.1/8	1.3976	0.8000	0.6000	3	H4	7/8		22.25	0581247	**E0251**

UNC | ANSI | 3B | 2.5XD | HSS-PM | B 3.5-5 | ST

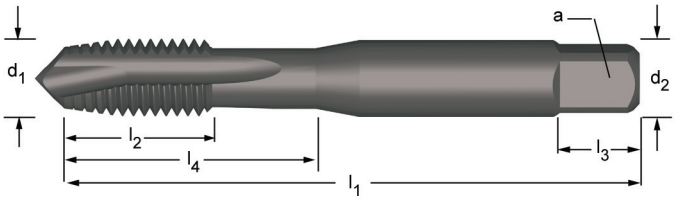
E026

- UNC Strojní závitník Spectrum™ Tap, prodloužený lamač třísky, přímá drážka
- UNC Gépi Menetfúró Spectrum™ Tap, extra hosszú Terelőéles
- UNC Gwintowniki maszynowy, Spectrum™ Tap, Bardzo długi, ze skośną powierzchnią natarcia
- UNC Tarozi de masina Spectrum™ Tap, extralungi Varf spiral
- UNC Spectrum™ Tap, Криволинейная задняя поверхность
- UNC Machine Tap Spectrum™ Tap, Extra Long Spiral Point

Spectrum™ Tap 200

Vc[m/min]													
P		M		K		N		S		H		O	
P 1	**13-30**	M 1	**3-8**	K 1	**12-18**	N 1.1		S 1		H 1		O 1	
P 2	**4-19**	M 2	**5-7**	K 2	**6-18**	N 1.2		S 2		H 2		O 2	
P 3	**4-19**	M 3	**3-5**	K 3	**12-18**	N 1.3		S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4		S 4		H 4		O 4	
P 5	**3-19**			K 5	**6-10**	N 2		S 5				O 5	
						N 3.1		S 6				O 6	
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



UNC	TPI	l_1 inch	l_2 inch	d_2 Ø inch	⧄ a inch	z	Limits	↔	l_4 inch	↔	EDP # or Stock No.	e-Code
2	56	1.3/4	0.3140	0.1410	0.1100	2	H2	N50	0.3140	1.80	0583203	**E0262-56**
4	40	1.7/8	0.6091	0.1410	0.1100	2	H2	N43	0.6091	2.35	0581254	**E0264-40**
5	40	1.15/16	0.7404	0.1410	0.1100	2	H2	N38	0.7404	2.65	0581261	**E0265-40**
6	32	2“	0.2610	0.1410	0.1100	2	H2	N36	0.5938	2.85	0581278	**E0266-32**
8	32	2.1/8	0.2484	0.1680	0.1310	2	H2	N29	0.6526	3.50	0581285	**E0268-32**
10	24	2.3/8	0.4303	0.1940	0.1520	2	H3	N25	0.8434	3.90	0581292	**E02610-24**
12	24	2.3/8	0.4173	0.2200	0.1650	2	H3	N16	0.8848	4.50	0581308	**E02612-24**
1/4	20	2.1/2	0.5075	0.2550	0.1910	2	H3	N7	1.0073	5.10	0581315	**E0261/4**
1/4	20	2.1/2	0.5075	0.2550	0.1910	3	H3	N7	1.0073	5.10	0581339	**E0261/43FL**
1/4	20	2.1/2	0.5075	0.2550	0.1910	3	H11	N7	1.0073	5.10	0581322	**E0261/4H11**
5/16	18	2.23/32	0.5939	0.3180	0.2380	2	H3	F	1.1891	6.60	0581346	**E0265/16**
5/16	18	2.23/32	0.5939	0.3180	0.2380	3	H3	F	1.1891	6.60	0581360	**E0265/163FL**
5/16	18	2.23/32	0.5939	0.3180	0.2380	3	H11	F	1.1891	6.60	0581353	**E0265/16H11**
3/8	16	2.15/16	0.6020	0.3810	0.2860	2	H3	5/16	1.2915	8.00	0581377	**E0263/8**
3/8	16	2.15/16	0.6020	0.3810	0.2860	3	H3	5/16	1.2915	8.00	0581391	**E0263/83FL**
3/8	16	2.15/16	0.6020	0.3810	0.2860	3	H11	5/16	1.2915	8.00	0581384	**E0263/8H11**
7/16	14	3.5/32	0.9055	0.3230	0.2420	3	H3	U		9.40	0581407	**E0267/16**
1/2	13	3.3/8	0.9055	0.3670	0.2750	2	H3	27/64		10.80	0581414	**E0261/2**
1/2	13	3.3/8	0.9055	0.3670	0.2750	3	H3	27/64		10.80	0581438	**E0261/23FL**
1/2	13	3.3/8	0.9055	0.3670	0.2750	3	H11	27/64		10.80	0581421	**E0261/2H11**
9/16	12	3.19/32	0.9843	0.4290	0.3220	3	H3	31/64		12.20	0581445	**E0269/16**
5/8	11	3.13/16	0.9843	0.4800	0.3600	3	H3	17/32		13.50	0581469	**E0265/8**
5/8	11	3.13/16	0.9843	0.4800	0.3600	3	H11	17/32		13.50	0581452	**E0265/8H11**
3/4	10	4.1/4	1.1614	0.5900	0.4420	3	H4	21/32		16.50	0581476	**E0263/4**
7/8	9	4.11/16	1.1614	0.6970	0.5230	3	H4	49/64		19.50	0581483	**E0267/8**
1“	8	5.1/8	1.3976	0.8000	0.6000	3	H4	7/8		22.25	0581490	**E0261**

UNC | ISO 529 | 2B | 2.5XD | HSS-PM | B 3.5-5

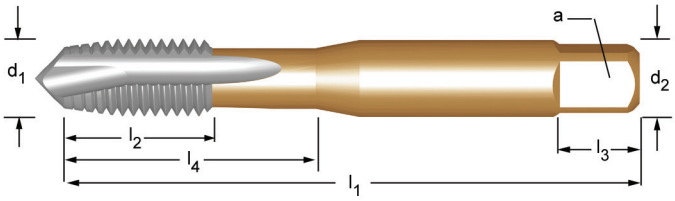
E020

- UNC Strojní závitník Spectrum™ Tap lamač třísek, přímá drážka
- UNC Gépi Menetfúró Spectrum™ Tap Terelőéles
- UNC Gwintownik maszynowy Spectrum™ Tap ze skośną powierzchnią natarcia
- UNC Tarozi de masina Spectrum™ Tap Varf spiral
- UNC Машинные метчики Spectrum™ Tap Криволинейная задняя поверхность
- UNC Machine Tap Spectrum™ Tap Spiral Point

Spectrum™ Tap 200

Vc[m/min]													
P		M		K		N		S		H		O	
P 1	**13-30**	M 1		K 1	**12-18**	N 1.1	**13-19**	S 1	**10-14**	H 1		O 1	**24-36**
P 2	**4-19**	M 2		K 2	**6-18**	N 1.2	**28-42**	S 2	**4-14**	H 2		O 2	
P 3	**4-19**	M 3		K 3	**12-18**	N 1.3	**12-24**	S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4	**12-18**	S 4	**4-12**	H 4		O 4	
P 5	**4-19**			K 5	**6-10**	N 2	**12-24**	S 5				O 5	
						N 3.1	**10-14**	S 6				O 6	**24-36**
						N 3.2	**16-36**					O 7	
						N 3.3	**24-36**						
						N 3.4							
						N 4	**24-36**						

$$n = \frac{Vc \times 1000}{\pi \times D}$$



UNC	TPI	d_1 nom mm	l_1 mm	l_2 mm	d_2 Ø mm	⧄ a mm	l_3 mm	z	↔	l_4 mm	e-Code
2	56	2.184	44.5	9.5	2.80	2.24	5	3	1.85	9.5	**E0202-56**
4	40	2.845	48	14	3.15	2.50	5	3	2.35	14	**E0204-40**
5	40	3.175	48	12.5	3.15	2.50	5	3	2.65	12.5	**E0205-40**
6	32	3.505	50	16	3.55	2.80	5	3	2.85	16	**E0206-32**
8	32	4.166	53	9.5	4.50	3.55	6	3	3.50	17	**E0208-32**
10	24	4.826	58	11	5.00	4.00	7	3	3.90	20	**E02010-24**
12	24	5.486	62	12	5.60	4.50	7	3	4.50	21	**E02012-24**
1/4	20	6.350	66	13	6.30	5.00	8	3	5.10	26	**E0201/4**
5/16	18	7.938	72	16	8.00	6.30	9	3	6.60	29	**E0205/16**
3/8	16	9.525	80	18	10.00	8.00	11	3	8.00	32	**E0203/8**
7/16	14	11.112	85	19	8.00	6.30	9	3	9.40		**E0207/16**
1/2	13	12.700	89	22	9.00	7.10	10	3	10.80		**E0201/2**
5/8	11	15.875	102	24	12.50	10.00	13	3	13.50		**E0205/8**
3/4	10	19.050	112	29	14.00	11.20	14	4	16.50		**E0203/4**
7/8	9	22.225	118	29	16.00	12.50	16	4	19.50		**E0207/8**
1“	8	25.400	130	35	18.00	14.00	18	4	22.25		**E0201**

UNC | ISO 529 | 2B | 2.5XD | HSS-PM | B 3.5-5 | ST

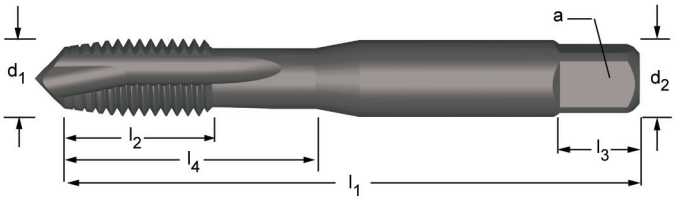
E021

- UNC Strojní závitník Spectrum™ Tap lamač třísek, přímá drážka
- UNC Gépi Menetfúró Spectrum™ Tap Terelőéles
- UNC Gwintownik maszynowy Spectrum™ Tap ze skośną powierzchnią natarcia
- UNC Tarozi de masina Spectrum™ Tap Varf spiral
- UNC Машинные метчики Spectrum™ Tap Криволинейная задняя поверхность
- UNC Machine Tap Spectrum™ Tap Spiral Point

Spectrum™ Tap 200

Vc[m/min]													
P		M		K		N		S		H		O	
P 1	**13-30**	M 1	**3-8**	K 1	**12-18**	N 1.1		S 1		H 1		O 1	
P 2	**4-19**	M 2	**5-7**	K 2	**6-18**	N 1.2		S 2		H 2		O 2	
P 3	**4-19**	M 3	**3-5**	K 3	**12-18**	N 1.3		S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4		S 4		H 4		O 4	
P 5	**3-19**			K 5	**6-10**	N 2		S 5				O 5	
						N 3.1		S 6				O 6	
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



UNC	TPI	d_1 nom mm	l_1 mm	l_2 mm	d_2 Ø mm	⧄ a mm	l_3 mm	z	↔	l_4 mm	e-Code
2	56	2.184	44.5	9.5	2.80	2.24	5	3	1.85	9.5	**E0212-56**
4	40	2.845	48	14	3.15	2.50	5	3	2.35	14	**E0214-40**
5	40	3.175	48	12.5	3.15	2.50	5	3	2.65	12.5	**E0215-40**
6	32	3.505	50	16	3.55	2.80	5	3	2.85	16	**E0216-32**
8	32	4.166	53	9.5	4.50	3.55	6	3	3.50	17	**E0218-32**
10	24	4.826	58	11	5.00	4.00	7	3	3.90	20	**E02110-24**
12	24	5.486	62	12	5.60	4.50	7	3	4.50	21	**E02112-24**
1/4	20	6.350	66	13	6.30	5.00	8	3	5.10	26	**E0211/4**
5/16	18	7.938	72	16	8.00	6.30	9	3	6.60	29	**E0215/16**
3/8	16	9.525	80	18	10.00	8.00	11	3	8.00	32	**E0213/8**
7/16	14	11.112	85	19	8.00	6.30	9	3	9.40		**E0217/16**
1/2	13	12.700	89	22	9.00	7.10	10	3	10.80		**E0211/2**
5/8	11	15.875	102	24	12.50	10.00	13	3	13.50		**E0215/8**
3/4	10	19.050	112	29	14.00	11.20	14	4	16.50		**E0213/4**
7/8	9	22.225	118	29	16.00	12.50	16	4	19.50		**E0217/8**
1“	8	25.400	130	35	18.00	14.00	18	4	22.25		**E0211**

UNC | DIN 2184-1 | 2B | 2.5XD | HSS-PM | C 2-3 | λ45°

EX20

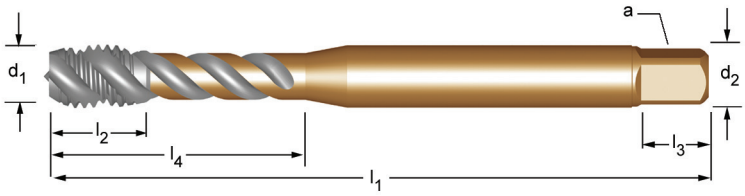
- UNC Strojní závitník Spectrum™ Tap, šroubovitá drážka 45°
- UNC Gépi Menetfúró Spectrum™ Tap Csavart hornyú 45°
- UNC Gwintownik maszynowy Spectrum™ Tap, śrubowy rowek wiórowy 45°
- UNC Tarozi de masina Spectrum™ Tap Canal elicoidal 45°
- UNC Машинные метчики Spectrum™ Tap Спиральная стружечная канавка 45°
- UNC Machine Tap Spectrum™ Tap Spiral Flute 45°

Spectrum™ Tap 360

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**13-30**	M 1		K 1		N 1.1	**13-19**	S 1	**10-14**	H 1		O 1	**24-36**
P 2	**8-19**	M 2		K 2		N 1.2	**28-42**	S 2	**4-14**	H 2		O 2	
P 3	**8-19**	M 3		K 3		N 1.3	**12-24**	S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4	**12-18**	S 4	**4-12**	H 4		O 4	
P 5	**8-19**			K 5		N 2	**12-24**	S 5				O 5	
						N 3.1		S 6				O 6	**24-36**
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



UNC	TPI	d_1 nom mm	l_1 mm	l_2 mm	d_2 Ø mm	⧄ a mm	l_3 mm	z	↔	l_4 mm	e-Code
4	40	2.845	56	6	3.5	2.7	6	3	2.35	18	**EX204-40**
5	40	3.175	56	6	3.5	2.7	6	3	2.65	18	**EX205-40**
6	32	3.505	56	7	4.0	3.0	6	3	2.85	20	**EX206-32**
8	32	4.166	63	7	4.5	3.4	8	3	3.5	21	**EX208-32**
10	24	4.826	70	8	6.0	4.9	8	3	3.9	25	**EX2010-24**
12	24	5.486	80	10	6.0	4.9	8	3	4.5	30	**EX2012-24**
1/4	20	6.350	80	10	7.0	5.5	8	3	5.1	30	**EX201/4**
5/16	18	7.938	90	12	8.0	6.2	9	3	6.6	35	**EX205/16**
3/8	16	9.525	100	15	10.0	8.0	11	3	8	39	**EX203/8**
7/16	14	11.112	100	15	8.0	6.2	9	3	9.4		**EX207/16**
1/2	13	12.700	110	18	9.0	7.0	10	3	10.8		**EX201/2**
5/8	11	15.875	110	20	12.0	9.0	12	4	13.5		**EX205/8**
3/4	10	19.050	125	25	14.0	11.0	14	4	16.5		**EX203/4** 2)
7/8	9	22.225	140	25	18.0	14.5	17	4	19.5		**EX207/8** 2)
1“	8	25.400	160	30	18.0	14.5	17	4	22.25		**EX201** 2)

HSS-E

2)

UNC | DIN 2184-1 | 2B | 2.5XD | HSS-PM | C 2-3 | λ45° | ST

EX21

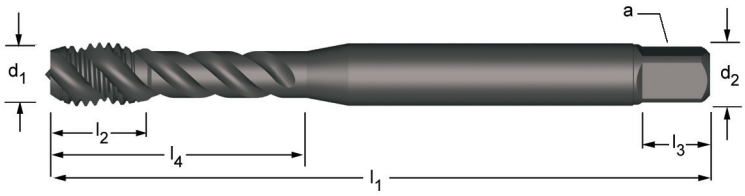
- UNC Strojní závitník Spectrum™ Tap, šroubovitá drážka 45°
- UNC Gépi Menetfúró Spectrum™ Tap Csavart hornyú 45°
- UNC Gwintownik maszynowy Spectrum™ Tap, śrubowy rowek wiórowy 45°
- UNC Tarozi de masina Spectrum™ Tap Canal elicoidal 45°
- UNC Машинные метчики Spectrum™ Tap Спиральная стружечная канавка 45°
- UNC Machine Tap Spectrum™ Tap Spiral Flute 45°

Spectrum™ Tap 360

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**13-30**	M 1	**3-8**	K 1		N 1.1		S 1		H 1		O 1	
P 2	**8-19**	M 2	**5-7**	K 2		N 1.2		S 2		H 2		O 2	
P 3	**8-19**	M 3	**3-5**	K 3		N 1.3		S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4		S 4		H 4		O 4	
P 5	**3-19**			K 5		N 2		S 5				O 5	
						N 3.1		S 6				O 6	
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



UNC	TPI	d_1 nom mm	l_1 mm	l_2 mm	d_2 Ø mm	⧄ a mm	l_3 mm	z	↔	l_4 mm	e-Code
4	40	2.845	56	6	3.5	2.7	6	3	2.35	18	**EX214-40**
5	40	3.175	56	6	3.5	2.7	6	3	2.65	18	**EX215-40**
6	32	3.505	56	7	4.0	3.0	6	3	2.85	20	**EX216-32**
8	32	4.166	63	7	4.5	3.4	8	3	3.5	21	**EX218-32**
10	24	4.826	70	8	6.0	4.9	8	3	3.9	25	**EX2110-24**
12	24	5.486	80	10	6.0	4.9	8	3	4.5	30	**EX2112-24**
1/4	20	6.350	80	10	7.0	5.5	8	3	5.1	30	**EX211/4**
5/16	18	7.938	90	12	8.0	6.2	9	3	6.6	35	**EX215/16**
3/8	16	9.525	100	15	10.0	8.0	11	3	8	39	**EX213/8**
7/16	14	11.112	100	15	8.0	6.2	9	3	9.4		**EX217/16**
1/2	13	12.700	110	18	9.0	7.0	10	3	10.8		**EX211/2**
5/8	11	15.875	110	20	12.0	9.0	12	4	13.5		**EX215/8**
3/4	10	19.050	125	25	14.0	11.0	14	4	16.5		**EX213/4** 2)
7/8	9	22.225	140	25	18.0	14.5	17	4	19.5		**EX217/8** 2)
1“	8	25.400	160	30	18.0	14.5	17	4	22.25		**EX211** 2)

HSS-E

2)

UNC | ANSI | 3B | 2.5XD | HSS-PM | C 2-3 | λ45°

E027

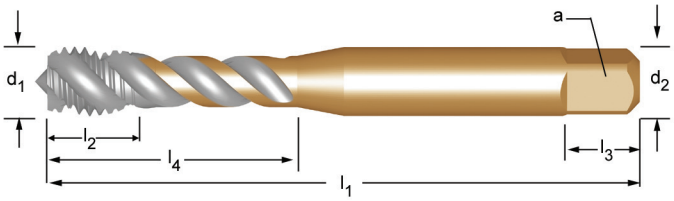
- UNC Strojní závitník Spectrum™ Tap, šroubovitá drážka 45°
- UNC Gépi Menetfúró Spectrum™ Tap Csavart hornyú 45°
- UNC Gwintownik maszynowy Spectrum™ Tap, śrubowy rowek wiórowy 45°
- UNC Tarozi de masina Spectrum™ Tap Canal elicoidal 45°
- UNC Машинные метчики Spectrum™ Tap Спиральная стружечная канавка 45°
- UNC Machine Tap Spectrum™ Tap Spiral Flute 45°

Spectrum™ Tap 360

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**13-30**	M 1		K 1		N 1.1	**13-19**	S 1	**10-14**	H 1		O 1	**24-36**
P 2	**8-19**	M 2		K 2		N 1.2	**28-42**	S 2	**4-14**	H 2		O 2	
P 3	**8-19**	M 3		K 3		N 1.3	**12-24**	S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4	**12-18**	S 4	**4-12**	H 4		O 4	
P 5	**8-19**			K 5		N 2	**12-24**	S 5				O 5	
						N 3.1	**10-14**	S 6				O 6	**24-36**
						N 3.2	**16-36**					O 7	
						N 3.3	**24-36**						
						N 3.4							
						N 4	**24-36**						

$$n = \frac{Vc \times 1000}{\pi \times D}$$



UNC	TPI	l_1 inch	l_2 inch	d_2 Ø inch	⧄ a inch	z	Limits	↔	l_4 inch	↔	EDP # or Stock No.	e-Code
6	32	2“	0.2610	0.1410	0.1100	3	H2	N36	0.5938	2.85	0581506	**E0276-32**
8	32	2.1/8	0.2484	0.1680	0.1310	3	H2	N29	0.6526	3.50	0581513	**E0278-32**
10	24	2.3/8	0.2650	0.1940	0.1520	3	H3	N25	0.8434	3.90	0581520	**E02710-24**
12	24	2.3/8	0.2520	0.2200	0.1650	3	H3	N16	0.8848	4.50	0581537	**E02712-24**
1/4	20	2.1/2	0.3937	0.2550	0.1910	3	H3	N7	1.0993	5.10	0581544	**E0271/4**
5/16	18	2.23/32	0.4567	0.3180	0.2380	3	H3	F	1.3094	6.60	0581551	**E0275/16**
3/8	16	2.15/16	0.5315	0.3810	0.2860	3	H3	5/16	1.4415	8.00	0581568	**E0273/8**
7/16	14	3.5/32	0.6299	0.3230	0.2420	3	H3	U		9.40	0581575	**E0277/16**
1/2	13	3.3/8	0.6890	0.3670	0.2750	3	H3	27/64		10.80	0581582	**E0271/2**
9/16	12	3.19/32	0.7087	0.4290	0.3220	3	H3	31/64		12.20	0581599	**E0279/16**
5/8	11	3.13/16	0.7087	0.4800	0.3600	3	H3	17/32		13.50	0581605	**E0275/8**
3/4	10	4.1/4	0.8858	0.5900	0.4420	3	H4	21/32		16.50	0581612	**E0273/4**
7/8	9	4.11/16	0.9843	0.6970	0.5230	3	H4	49/64		19.50	0581629	**E0277/8**
1“	8	5.1/8	1.1811	0.8000	0.6000	3	H4	7/8		22.25	0581636	**E0271**

UNC ANSI 3B 2.5XD HSS-PM C 2-3 λ45° ST

E028

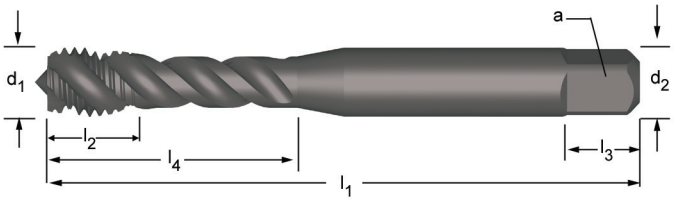
- UNC Strojní závitník Spectrum™ Tap, šroubovitá drážka 45°
- UNC Gépi Menetfúró Spectrum™ Tap Csavart hornyú 45°
- UNC Gwintownik maszynowy Spectrum™ Tap, śrubowy rowek wiórowy 45°
- UNC Tarozi de masina Spectrum™ Tap Canal elicoidal 45°
- UNC Машинные метчики Spectrum™ Tap Спиральная стружечная канавка 45°
- UNC Machine Tap Spectrum™ Tap Spiral Flute 45°

Spectrum™ Tap 360

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**13-30**	M 1	**3-8**	K 1		N 1.1		S 1		H 1		O 1	
P 2	**8-19**	M 2	**5-7**	K 2		N 1.2		S 2		H 2		O 2	
P 3	**8-19**	M 3	**3-5**	K 3		N 1.3		S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4		S 4		H 4		O 4	
P 5	**3-19**			K 5		N 2		S 5				O 5	
						N 3.1		S 6				O 6	
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



UNC	TPI	l_1 inch	l_2 inch	d_2 Ø inch	⧄ a inch	z	Limits	↔	l_4 inch	↔	EDP # or Stock No.	e-Code
4	40	1.7/8	0.6091	0.1410	0.1100	3	H2	N43	0.6091	2.35	0581643	**E0284-40**
5	40	1.15/16	0.7404	0.1410	0.1100	3	H2	N38	0.7404	2.65	0581650	**E0285-40**
6	32	2“	0.2610	0.1410	0.1100	3	H2	N36	0.5938	2.85	0581667	**E0286-32**
8	32	2.1/8	0.2484	0.1680	0.1310	3	H2	N29	0.6526	3.50	0581674	**E0288-32**
10	24	2.3/8	0.2650	0.1940	0.1520	3	H3	N25	0.8434	3.90	0581681	**E02810-24**
12	24	2.3/8	0.2520	0.2200	0.1650	3	H3	N16	0.8848	4.50	0581698	**E02812-24**
1/4	20	2.1/2	0.3937	0.2550	0.1910	3	H3	N7	1.0993	5.10	0581704	**E0281/4**
5/16	18	2.23/32	0.4567	0.3180	0.2380	3	H3	F	1.3094	6.60	0581711	**E0285/16**
3/8	16	2.15/16	0.5315	0.3810	0.2860	3	H3	5/16	1.4415	8.00	0581728	**E0283/8**
3/8	16	2.15/16	0.5315	0.3810	0.2860	3	H5	5/16	1.4415	8.00	0581735	**E0283/8H5**
7/16	14	3.5/32	0.6299	0.3230	0.2420	3	H3	U		9.40	0581742	**E0287/16**
1/2	13	3.3/8	0.6890	0.3670	0.2750	3	H3	27/64		10.80	0581759	**E0281/2**
9/16	12	3.19/32	0.7087	0.4290	0.3220	3	H3	31/64		12.20	0581766	**E0289/16**
5/8	11	3.13/16	0.7087	0.4800	0.3600	3	H3	17/32		13.50	0581773	**E0285/8**
3/4	10	4.1/4	0.8858	0.5900	0.4420	3	H4	21/32		16.50	0581780	**E0283/4**
7/8	9	4.11/16	0.9843	0.6970	0.5230	3	H4	49/64		19.50	0581797	**E0287/8**
1“	8	5.1/8	1.1811	0.8000	0.6000	3	H4	7/8		22.25	0581803	**E0281**

UNC | ISO 529 | 2B | 2.5XD | HSS-PM | C 2-3 | λ45°

E022

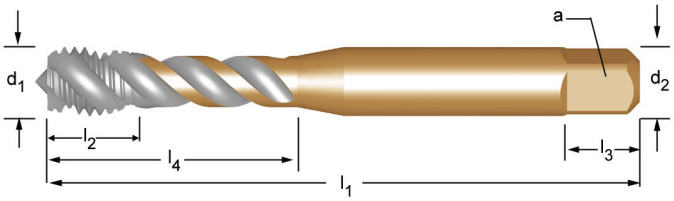
- UNC Strojní závitník Spectrum™ Tap, šroubovitá drážka 45°
- UNC Gépi Menetfúró Spectrum™ Tap Csavart hornyú 45°
- UNC Gwintownik maszynowy Spectrum™ Tap, śrubowy rowek wiórowy 45°
- UNC Tarozi de masina Spectrum™ Tap Canal elicoidal 45°
- UNC Машинные метчики Spectrum™ Tap Спиральная стружечная канавка 45°
- UNC Machine Tap Spectrum™ Tap Spiral Flute 45

Spectrum™ Tap 360

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**13-30**	M 1		K 1		N 1.1	**13-19**	S 1	**10-14**	H 1		O 1	**24-36**
P 2	**8-19**	M 2		K 2		N 1.2	**28-42**	S 2	**4-14**	H 2		O 2	
P 3	**8-19**	M 3		K 3		N 1.3	**12-24**	S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4	**12-18**	S 4	**4-12**	H 4		O 4	
P 5	**8-19**			K 5		N 2	**12-24**	S 5				O 5	
						N 3.1	**10-14**	S 6				O 6	**24-36**
						N 3.2	**16-36**					O 7	
						N 3.3	**24-36**						
						N 3.4							
						N 4	**24-36**						

$$n = \frac{Vc \times 1000}{\pi \times D}$$



UNC	TPI	d_1 nom mm	l_1 mm	l_2 mm	d_2 Ø mm	⧄ a mm	l_3 mm	z	↔	l_4 mm	e-Code
2	56	2.184	44.5	9.5	2.80	2.24	5	2	1.85	9.5	**E0222-56**
4	40	2.845	48	6	3.15	2.50	5	3	2.35	14	**E0224-40**
5	40	3.175	48	6	3.15	2.50	5	3	2.65	12.5	**E0225-40**
6	32	3.505	50	6	3.55	2.80	5	3	2.85	16	**E0226-32**
8	32	4.166	53	7	4.50	3.55	6	3	3.50	17	**E0228-32**
10	24	4.826	58	8	5.00	4.00	7	3	3.90	20	**E02210-24**
12	24	5.486	62	12	5.60	4.50	7	3	4.50	21	**E02212-24**
1/4	20	6.350	66	10	6.30	5.00	8	3	5.10	28	**E0221/4**
5/16	18	7.938	72	12	8.00	6.30	9	3	6.60	31	**E0225/16**
3/8	16	9.525	80	15	10.00	8.00	11	3	8.00	34	**E0223/8**
7/16	14	11.112	85	19	8.00	6.30	9	3	9.40		**E0227/16**
1/2	13	12.700	89	19	9.00	7.10	10	3	10.80		**E0221/2**
5/8	11	15.875	102	24	12.50	10.00	13	4	13.50		**E0225/8**
3/4	10	19.050	112	29	14.00	11.20	14	4	16.50		**E0223/4**
7/8	9	22.225	118	29	16.00	12.50	16	4	19.50		**E0227/8**
1“	8	25.400	130	35	18.00	14.00	18	4	22.25		**E0221**

UNC | ISO 529 | 2B | 2.5XD | HSS-PM | C 2-3 | λ45° | ST

E023

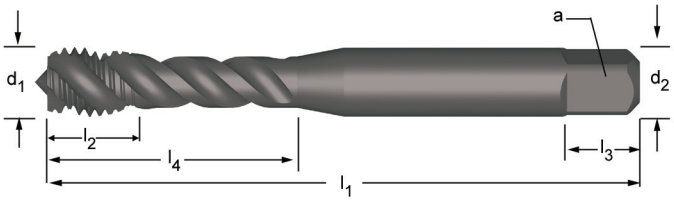
- UNC Strojní závitník Spectrum™ Tap, šroubovitá drážka 45°
- UNC Gépi Menetfúró Spectrum™ Tap Csavart hornyú 45°
- UNC Gwintownik maszynowy Spectrum™ Tap, śrubowy rowek wiórowy 45°
- UNC Tarozi de masina Spectrum™ Tap Canal elicoidal 45°
- UNC Машинные метчики Spectrum™ Tap Спиральная стружечная канавка 45°
- UNC Machine Tap Spectrum™ Tap Spiral Flute 45°

Spectrum™ Tap 360

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**13-30**	M 1	**3-8**	K 1		N 1.1		S 1		H 1		O 1	
P 2	**8-19**	M 2	**5-7**	K 2		N 1.2		S 2		H 2		O 2	
P 3	**8-19**	M 3	**3-5**	K 3		N 1.3		S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4		S 4		H 4		O 4	
P 5	**3-19**			K 5		N 2		S 5				O 5	
						N 3.1		S 6				O 6	
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



UNC	TPI	d_1 nom mm	l_1 mm	l_2 mm	d_2 Ø mm	⧄ a mm	l_3 mm	z	↔	l_4 mm	e-Code
2	56	2.184	44.5	9.5	2.80	2.24	5	2	1.85	9.5	**E0232-56**
4	40	2.845	48	6	3.15	2.50	5	3	2.35	14	**E0234-40**
5	40	3.175	48	6	3.15	2.50	5	3	2.65	12.5	**E0235-40**
6	32	3.505	50	6	3.55	2.80	5	3	2.85	16	**E0236-32**
8	32	4.166	53	7	4.50	3.55	6	3	3.50	17	**E0238-32**
10	24	4.826	58	8	5.00	4.00	7	3	3.90	20	**E02310-24**
12	24	5.486	62	12	5.60	4.50	7	3	4.50	21	**E02312-24**
1/4	20	6.350	66	10	6.30	5.00	8	3	5.10	28	**E0231/4**
5/16	18	7.938	72	12	8.00	6.30	9	3	6.60	31	**E0235/16**
3/8	16	9.525	80	15	10.00	8.00	11	3	8.00	34	**E0233/8**
7/16	14	11.112	85	19	8.00	6.30	9	3	9.40		**E0237/16**
1/2	13	12.700	89	19	9.00	7.10	10	3	10.80		**E0231/2**
5/8	11	15.875	102	24	12.50	10.00	13	4	13.50		**E0235/8**
3/4	10	19.050	112	29	14.00	11.20	14	4	16.50		**E0233/4**
7/8	9	22.225	118	29	16.00	12.50	16	4	19.50		**E0237/8**
1“	8	25.400	130	35	18.00	14.00	18	4	22.25		**E0231**

UNF | DIN 2184-1 | 2B | 2.5XD | HSS-PM | B 3.5-5

EP30

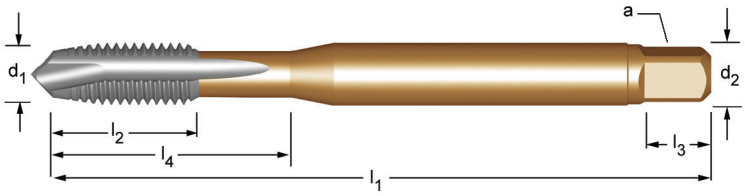
- UNF Strojní závitník Spectrum™ Tap lamač třísek, přímá drážka
- UNF Gépi Menetfúró Spectrum™ Tap Terelőéles
- UNF Gwintownik maszynowy Spectrum™ Tap ze skośną powierzchnią natarcia
- UNF Tarozi de masina Spectrum™ Tap Varf spiral
- UNF Машинные метчики Spectrum™ Tap Криволинейная задняя поверхность
- UNF Machine Tap Spectrum™ Tap Spiral Point

Spectrum™ Tap 200

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**13-30**	M 1		K 1	**12-18**	N 1.1	**13-19**	S 1	**10-14**	H 1		O 1	**24-36**
P 2	**4-19**	M 2		K 2	**6-18**	N 1.2	**28-42**	S 2	**4-14**	H 2		O 2	
P 3	**4-19**	M 3		K 3	**12-18**	N 1.3	**12-24**	S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4	**12-18**	S 4	**4-12**	H 4		O 4	
P 5	**4-19**			K 5	**6-10**	N 2	**12-24**	S 5				O 5	
						N 3.1	**10-14**	S 6				O 6	**24-36**
						N 3.2	**16-36**					O 7	
						N 3.3	**24-36**						
						N 3.4							
						N 4	**24-36**						

$$n = \frac{Vc \times 1000}{\pi \times D}$$



UNF	TPI	d_1 nom mm	l_1 mm	l_2 mm	d_2 Ø mm	◪ a mm	l_3 mm	z	↔	l_4 mm	e-Code
8	36	4.166	63	12	4.5	3.4	8	3	3.5	21	**EP308-36**
10	32	4.826	70	13	6.0	4.9	8	3	4.1	25	**EP3010-32**
1/4	28	6.350	80	15	7.0	5.5	8	3	5.5	30	**EP301/4**
5/16	24	7.938	90	18	8.0	6.2	9	3	6.9	35	**EP305/16**
3/8	24	9.525	100	20	10.0	8.0	11	3	8.5	39	**EP303/8**
7/16	20	11.112	100	20	8.0	6.2	9	3	9.9		**EP307/16**
1/2	20	12.700	110	23	9.0	7.0	10	3	11.5		**EP301/2**
5/8	18	15.875	110	25	12.0	9.0	12	3	14.5		**EP305/8**
3/4	16	19.050	125	30	14.0	11.0	14	4	17.5		**EP303/4** [2]
7/8	14	22.225	140	34	18.0	14.5	17	4	20.4		**EP307/8** [2]
1“	12	25.400	160	38	18.0	14.5	17	4	23.25		**EP301** [2]

HSS-E

2)

UNF | DIN 2184-1 | 2B | 2.5XD | HSS-PM | B 3.5-5 | ST

EP31

- UNF Strojní závitník Spectrum™ Tap lamač třísek, přímá drážka
- UNF Gépi Menetfúró Spectrum™ Tap Terelőéles
- UNF Gwintownik maszynowy Spectrum™ Tap ze skośną powierzchnią natarcia
- UNF Tarozi de masina Spectrum™ Tap Varf spiral
- UNF Машинные метчики Spectrum™ Tap Криволинейная задняя поверхность
- UNF Machine Tap Spectrum™ Tap Spiral Point

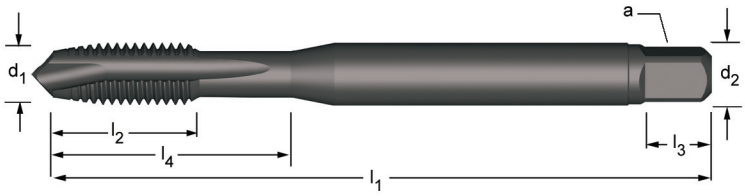
Spectrum™ Tap 200

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**13-30**	M 1	**3-8**	K 1	**12-18**	N 1.1		S 1		H 1		O 1	
P 2	**4-19**	M 2	**5-7**	K 2	**6-18**	N 1.2		S 2		H 2		O 2	
P 3	**4-19**	M 3	**3-5**	K 3	**12-18**	N 1.3		S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4		S 4		H 4		O 4	
P 5	**3-19**			K 5	**6-10**	N 2		S 5				O 5	
						N 3.1		S 6				O 6	
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$

EP31



UNF	TPI	d_1 nom mm	l_1 mm	l_2 mm	d_2 Ø mm	⧄ a mm	l_3 mm	z	↔	l_4 mm	e-Code
8	36	4.166	63	12	4.5	3.4	8	3	3.5	21	**EP318-36**
10	32	4.826	70	13	6.0	4.9	8	3	4.1	25	**EP3110-32**
1/4	28	6.350	80	15	7.0	5.5	8	3	5.5	30	**EP311/4**
5/16	24	7.938	90	18	8.0	6.2	9	3	6.9	35	**EP315/16**
3/8	24	9.525	100	20	10.0	8.0	11	3	8.5	39	**EP313/8**
7/16	20	11.112	100	20	8.0	6.2	9	3	9.9		**EP317/16**
1/2	20	12.700	110	23	9.0	7.0	10	3	11.5		**EP311/2**
5/8	18	15.875	110	25	12.0	9.0	12	3	14.5		**EP315/8**
3/4	16	19.050	125	30	14.0	11.0	14	4	17.5		**EP313/4** [2)]
7/8	14	22.225	140	34	18.0	14.5	17	4	20.4		**EP317/8** [2)]
1“	12	25.400	160	38	18.0	14.5	17	4	23.25		**EP311** [2)]

HSS-E

2)

UNF | ANSI | 3B | 2.5XD | HSS-PM | B 3.5-5

E035

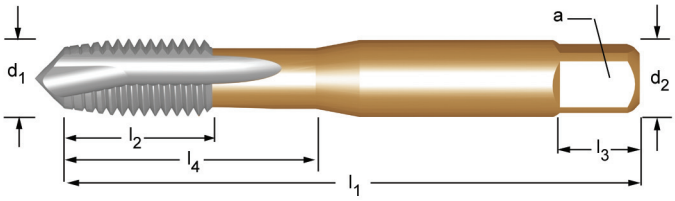
- UNF Strojní závitník Spectrum™ Tap lamač třísek, přímá drážka
- UNF Gépi Menetfúró Spectrum™ Tap Terelőéles
- UNF Gwintownik maszynowy Spectrum™ Tap ze skośną powierzchnią natarcia
- UNF Tarozi de masina Spectrum™ Tap Varf spiral
- UNF Машинные метчики Spectrum™ Tap Криволинейная задняя поверхность
- UNF Machine Tap Spectrum™ Tap Spiral Point

Spectrum™ Tap 200

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**13-30**	M 1		K 1	**12-18**	N 1.1	**13-19**	S 1	**10-14**	H 1		O 1	**24-36**
P 2	**4-19**	M 2		K 2	**6-18**	N 1.2	**28-42**	S 2	**4-14**	H 2		O 2	
P 3	**4-19**	M 3		K 3	**12-18**	N 1.3	**12-24**	S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4	**12-18**	S 4	**4-12**	H 4		O 4	
P 5	**4-19**			K 5	**6-10**	N 2	**12-24**	S 5				O 5	
						N 3.1	**10-14**	S 6				O 6	**24-36**
						N 3.2	**16-36**					O 7	
						N 3.3	**24-36**						
						N 3.4							
						N 4	**24-36**						

$$n = \frac{Vc \times 1000}{\pi \times D}$$



UNF	TPI	l_1 inch	l_2 inch	d_2 Ø inch	⧄ a inch	z	Limits	↔	l_4 inch	↔	EDP # or Stock No.	e-Code
6	40	2“	0.2610	0.1410	0.1100	2	H2	N33	0.5938	2.95	0581957	**E0356-40**
8	36	2.1/8	0.2484	0.1680	0.1310	2	H2	N29	0.6526	3.50	0581964	**E0358-36**
10	32	2.3/8	0.4303	0.1940	0.1520	2	H2	N21	0.8434	4.10	0581971	**E03510-32**
12	28	2.3/8	0.4173	0.2200	0.1650	2	H3	N14	0.8848	4.70	0581988	**E03512-28**
1/4	28	2.1/2	0.5075	0.2550	0.1910	2	H3	N3	1.0073	5.50	0581995	**E0351/4**
1/4	28	2.1/2	0.5075	0.2550	0.1910	3	H3	N3	1.0073	5.50	0582008	**E0351/43FL**
5/16	24	2.23/32	0.5939	0.3180	0.2380	2	H3	I	1.1891	6.90	0582015	**E0355/16**
5/16	24	2.23/32	0.5939	0.3180	0.2380	3	H3	I	1.1891	6.90	0582022	**E0355/163FL**
3/8	24	2.15/16	0.6020	0.3810	0.2860	2	H3	Q	1.2915	8.50	0582039	**E0353/8**
3/8	24	2.15/16	0.6020	0.3810	0.2860	3	H3	Q	1.2915	8.50	0582046	**E0353/83FL**
7/16	20	3.5/32	0.9055	0.3230	0.2420	3	H3	25/64		9.90	0582053	**E0357/163FL**
1/2	20	3.3/8	0.9055	0.3670	0.2750	2	H3	29/64		11.50	0582060	**E0351/2**
1/2	20	3.3/8	0.9055	0.3670	0.2750	3	H3	29/64		11.50	0582077	**E0351/23FL**
9/16	18	3.19/32	0.9843	0.4290	0.3220	3	H3	33/64		12.90	0582084	**E0359/16**
5/8	18	3.13/16	0.9843	0.4800	0.3600	3	H3	37/64		14.50	0582091	**E0355/8**
3/4	16	4.1/4	1.1614	0.5900	0.4420	3	H3	11/16		17.50	0582107	**E0353/4**
7/8	14	4.11/16	1.1614	0.6970	0.5230	3	H4	13/16		20.40	0582114	**E0357/8**
1“	12	5.1/8	1.3976	0.8000	0.6000	3	H4	59/64		23.25	0582121	**E0351-12**
1“	14	5.1/8	1.3976	0.8000	0.6000	3	H4	59/64		23.50	0582138	**E0351-14**

UNF | ANSI | 3B | 2.5XD | HSS-PM | B 3.5-5 | ST

E036

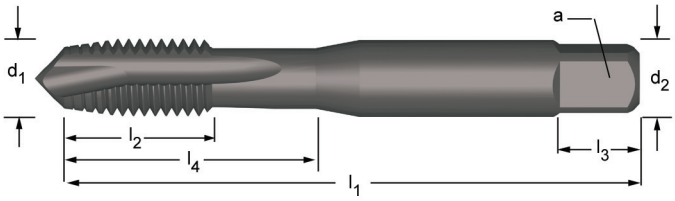
- M Strojní závitník Spectrum™ Tap, prodloužený lamač třísky, přímá drážka
- M Gépi Menetfúró Spectrum™ Tap, extra hosszú Terelőéles
- M Gwintowniki maszynowy, Spectrum™ Tap, Bardzo długi, ze skośną powierzchnią natarcia
- M Tarozi de masina Spectrum™ Tap, extralungi Varf spiral
- M Spectrum™ Tap, Криволинейная задняя поверхность
- M Machine Tap Spectrum™ Tap, Extra Long Spiral Point

Spectrum™ Tap 200

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**13-30**	M 1	**3-8**	K 1	**12-18**	N 1.1		S 1		H 1		O 1	
P 2	**4-19**	M 2	**5-7**	K 2	**6-18**	N 1.2		S 2		H 2		O 2	
P 3	**4-19**	M 3	**3-5**	K 3	**12-18**	N 1.3		S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4		S 4		H 4		O 4	
P 5	**3-19**			K 5	**6-10**	N 2		S 5				O 5	
						N 3.1		S 6				O 6	
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



UNF	TPI	l_1 inch	l_2 inch	d_2 Ø inch	⧄ a inch	z	Limits	↔	l_4 inch	↔	EDP # or Stock No.	e-Code
10	32	2.3/8	0.4303	0.1940	0.1520	2	H2	N21	0.8434	4.10	0582145	**E03610-32**
12	28	2.3/8	0.4173	0.2200	0.1650	2	H3	N14	0.8848	4.70	0582152	**E03612-28**
1/4	28	2.1/2	0.5075	0.2550	0.1910	2	H3	N3	1.0073	5.50	0582169	**E0361/4**
1/4	28	2.1/2	0.5075	0.2550	0.1910	3	H3	N3	1.0073	5.50	0582176	**E0361/43FL**
5/16	24	2.23/32	0.5939	0.3180	0.2380	2	H3	I	1.1891	6.90	0582183	**E0365/16**
5/16	24	2.23/32	0.5939	0.3180	0.2380	3	H3	I	1.1891	6.90	0582190	**E0365/163FL**
3/8	24	2.15/16	0.6020	0.3810	0.2860	2	H3	Q	1.2915	8.50	0582206	**E0363/8**
3/8	24	2.15/16	0.6020	0.3810	0.2860	3	H3	Q	1.2915	8.50	0582213	**E0363/83FL**
7/16	20	3.5/32	0.9055	0.3230	0.2420	3	H3	25/64		9.90	0582220	**E0367/163FL**
1/2	20	3.3/8	0.9055	0.3670	0.2750	2	H3	29/64		11.50	0582237	**E0361/2**
1/2	20	3.3/8	0.9055	0.3670	0.2750	3	H3	29/64		11.50	0582244	**E0361/23FL**
9/16	18	3.19/32	0.9843	0.4290	0.3220	3	H3	33/64		12.90	0582251	**E0369/16**
5/8	18	3.13/16	0.9843	0.4800	0.3600	3	H3	37/64		14.50	0582268	**E0365/8**
3/4	16	4.1/4	1.1614	0.5900	0.4420	3	H3	11/16		17.50	0582275	**E0363/4**
7/8	14	4.11/16	1.1614	0.6970	0.5230	3	H4	13/16		20.40	0582282	**E0367/8**
1“	12	5.1/8	1.3976	0.8000	0.6000	3	H4	59/64		23.25	0582299	**E0361-12**
1“	14	5.1/8	1.3976	0.8000	0.6000	3	H4	59/64		23.50	0582305	**E0361-14**

UNF | ISO 529 | 2B | 2.5XD | HSS-PM | B 3.5-5

E030

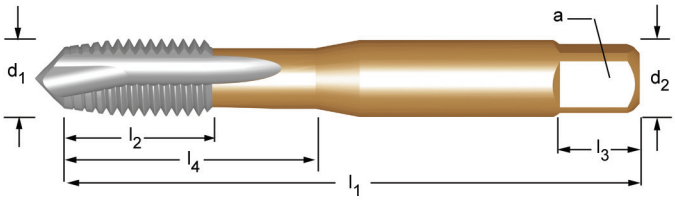
- UNF Strojní závitník Spectrum™ Tap lamač třísek, přímá drážka
- UNF Gépi Menetfúró Spectrum™ Tap Terelőéles
- UNF Gwintownik maszynowy Spectrum™ Tap ze skośną powierzchnią natarcia
- UNF Tarozi de masina Spectrum™ Tap Varf spiral
- UNF Машинные метчики Spectrum™ Tap Криволинейная задняя поверхность
- UNF Machine Tap Spectrum™ Tap Spiral Point

Spectrum™ Tap 200

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**13-30**	M 1		K 1	**12-18**	N 1.1	**13-19**	S 1	**10-14**	H 1		O 1	**24-36**
P 2	**4-19**	M 2		K 2	**6-18**	N 1.2	**28-42**	S 2	**4-14**	H 2		O 2	
P 3	**4-19**	M 3		K 3	**12-18**	N 1.3	**12-24**	S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4	**12-18**	S 4	**4-12**	H 4		O 4	
P 5	**4-19**			K 5	**6-10**	N 2	**12-24**	S 5				O 5	
						N 3.1	**10-14**	S 6				O 6	**24-36**
						N 3.2	**16-36**					O 7	
						N 3.3	**24-36**						
						N 3.4							
						N 4	**24-36**						

$$n = \frac{Vc \times 1000}{\pi \times D}$$



UNF	TPI	d_1 nom mm	l_1 mm	l_2 mm	d_2 Ø mm	⧄ a mm	l_3 mm	z	↔	l_4 mm	e-Code
8	36	4.166	53	9.5	4.50	3.55	6	3	3.50	17	**E0308-36**
10	32	4.826	58	11	5.00	4.00	7	3	4.10	20	**E03010-32**
1/4	28	6.350	66	13	6.30	5.00	8	3	5.50	26	**E0301/4**
5/16	24	7.938	72	16	8.00	6.30	9	3	6.90	29	**E0305/16**
3/8	24	9.525	80	18	10.00	8.00	11	3	8.50	32	**E0303/8**
7/16	20	11.112	85	19	8.00	6.30	9	3	9.90		**E0307/16**
1/2	20	12.700	89	22	9.00	7.10	10	3	11.50		**E0301/2**
9/16	18	14.288	95	24	11.20	9.00	12	3	12.90		**E0309/16**
5/8	18	15.875	102	24	12.50	10.00	13	3	14.50		**E0305/8**
3/4	16	19.050	112	29	14.00	11.20	14	4	17.50		**E0303/4**
7/8	14	22.225	118	29	16.00	12.50	16	4	20.40		**E0307/8**
1“	12	25.400	130	35	18.00	14.00	18	4	23.25		**E0301**

UNF | ISO 529 | 2B | 2.5XD | HSS-PM | B 3.5-5 | ST

E031

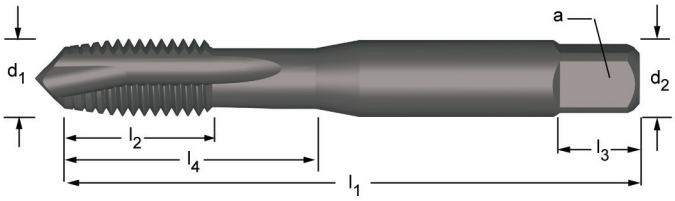
- UNF Strojní závitník Spectrum™ Tap lamač třísek, přímá drážka
- UNF Gépi Menetfúró Spectrum™ Tap Terelőéles
- UNF Gwintownik maszynowy Spectrum™ Tap ze skośną powierzchnią natarcia
- UNF Tarozi de masina Spectrum™ Tap Varf spiral
- UNF Машинные метчики Spectrum™ Tap Криволинейная задняя поверхность
- UNF Machine Tap Spectrum™ Tap Spiral Point

Spectrum™ Tap 200

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**13-30**	M 1	**3-8**	K 1	**12-18**	N 1.1		S 1		H 1		O 1	
P 2	**4-19**	M 2	**5-7**	K 2	**6-18**	N 1.2		S 2		H 2		O 2	
P 3	**4-19**	M 3	**3-5**	K 3	**12-18**	N 1.3		S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4		S 4		H 4		O 4	
P 5	**3-19**			K 5	**6-10**	N 2		S 5				O 5	
						N 3.1		S 6				O 6	
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



UNF	TPI	d_1 nom mm	l_1 mm	l_2 mm	d_2 Ø mm	⧄ a mm	l_3 mm	z	↔	l_4 mm	e-Code
8	36	4.166	53	9.5	4.50	3.55	6	3	3.50	17	**E0318-36**
10	32	4.826	58	11	5.00	4.00	7	3	4.10	20	**E03110-32**
1/4	28	6.350	66	13	6.30	5.00	8	3	5.50	26	**E0311/4**
5/16	24	7.938	72	16	8.00	6.30	9	3	6.90	29	**E0315/16**
3/8	24	9.525	80	18	10.00	8.00	11	3	8.50	32	**E0313/8**
7/16	20	11.112	85	19	8.00	6.30	9	3	9.90		**E0317/16**
1/2	20	12.700	89	22	9.00	7.10	10	3	11.50		**E0311/2**
9/16	18	14.288	95	24	11.20	9.00	12	3	12.90		**E0319/16**
5/8	18	15.875	102	24	12.50	10.00	13	3	14.50		**E0315/8**
3/4	16	19.050	112	29	14.00	11.20	14	4	17.50		**E0313/4**
7/8	14	22.225	118	29	16.00	12.50	16	4	20.40		**E0317/8**
1“	12	25.400	130	35	18.00	14.00	18	4	23.25		**E0311**

UNF | DIN 2184-1 | 2B | 2.5XD | HSS-PM | C 2-3 | λ45°

EX30

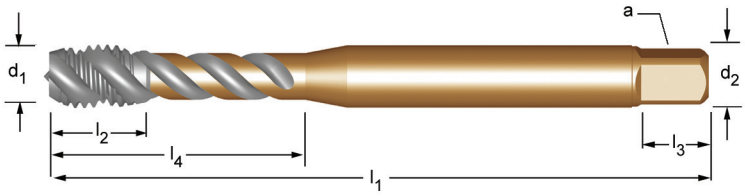
- UNF Strojní závitník Spectrum™ Tap, šroubovitá drážka 45°
- UNF Gépi Menetfúró Spectrum™ Tap Csavart hornyú 45°
- UNF Gwintownik maszynowy Spectrum™ Tap, śrubowy rowek wiórowy 45°
- UNF Tarozi de masina Spectrum™ Tap Canal elicoidal 45°
- UNF Машинные метчики Spectrum™ Tap Спиральная стружечная канавка 45°
- UNF Machine Tap Spectrum™ Tap Spiral Flute 45°

Spectrum™ Tap 360

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**13-30**	M 1		K 1		N 1.1	**13-19**	S 1	**10-14**	H 1		O 1	**24-36**
P 2	**8-19**	M 2		K 2		N 1.2	**28-42**	S 2	**4-14**	H 2		O 2	
P 3	**8-19**	M 3		K 3		N 1.3	**12-24**	S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4	**12-18**	S 4	**4-12**	H 4		O 4	
P 5	**8-19**			K 5		N 2	**12-24**	S 5				O 5	
						N 3.1		S 6				O 6	**24-36**
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



UNF	TPI	d_1 nom mm	l_1 mm	l_2 mm	d_2 Ø mm	a mm	l_3 mm	z	↔	l_4 mm	e-Code
8	36	4.166	63	7	4.5	3.4	8	3	3.5	21	**EX308-36**
10	32	4.826	70	8	6.0	4.9	8	3	4.1	25	**EX3010-32**
1/4	28	6.350	80	10	7.0	5.5	8	3	5.5	30	**EX301/4**
5/16	24	7.938	90	12	8.0	6.2	9	3	6.9	35	**EX305/16**
3/8	24	9.525	100	15	10.0	8.0	11	3	8.5	39	**EX303/8**
7/16	20	11.112	100	15	8.0	6.2	9	3	9.9		**EX307/16**
1/2	20	12.700	110	18	9.0	7.0	10	3	11.5		**EX301/2**
5/8	18	15.875	110	20	12.0	9.0	12	4	14.5		**EX305/8**
3/4	16	19.050	125	25	14.0	11.0	14	4	17.5		**EX303/4** [2]
7/8	14	22.225	140	25	18.0	14.5	17	4	20.4		**EX307/8** [2]
1“	12	25.400	160	30	18.0	14.5	17	4	23.25		**EX301** [2]

HSS-E

2)

UNF | DIN 2184-1 | 2B | 2.5XD | HSS-PM | C 2-3 | λ45° | ST

EX31

- UNF Strojní závitník Spectrum™ Tap, šroubovitá drážka 45°
- UNF Gépi Menetfúró Spectrum™ Tap Csavart hornyú 45°
- UNF Gwintownik maszynowy Spectrum™ Tap, śrubowy rowek wiórowy 45°
- UNF Tarozi de masina Spectrum™ Tap Canal elicoidal 45°
- UNF Машинные метчики Spectrum™ Tap Спиральная стружечная канавка 45°
- UNF Machine Tap Spectrum™ Tap Spiral Flute 45°

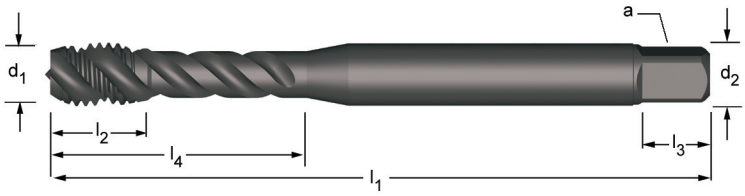
Spectrum™ Tap 360

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**13-30**	M 1	**3-8**	K 1		N 1.1		S 1		H 1		O 1	
P 2	**8-19**	M 2	**5-7**	K 2		N 1.2		S 2		H 2		O 2	
P 3	**8-19**	M 3	**3-5**	K 3		N 1.3		S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4		S 4		H 4		O 4	
P 5	**3-19**			K 5		N 2		S 5				O 5	
						N 3.1		S 6				O 6	
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$

EX31



UNF	TPI	d_1 nom mm	l_1 mm	l_2 mm	d_2 Ø mm	⧄ a mm	l_3 mm	z	↔	l_4 mm	e-Code
8	36	4.166	63	7	4.5	3.4	8	3	3.5	21	**EX318-36**
10	32	4.826	70	8	6.0	4.9	8	3	4.1	25	**EX3110-32**
1/4	28	6.350	80	10	7.0	5.5	8	3	5.5	30	**EX311/4**
5/16	24	7.938	90	12	8.0	6.2	9	3	6.9	35	**EX315/16**
3/8	24	9.525	100	15	10.0	8.0	11	3	8.5	39	**EX313/8**
7/16	20	11.112	100	15	8.0	6.2	9	3	9.9		**EX317/16**
1/2	20	12.700	110	18	9.0	7.0	10	3	11.5		**EX311/2**
5/8	18	15.875	110	20	12.0	9.0	12	4	14.5		**EX315/8**
3/4	16	19.050	125	25	14.0	11.0	14	4	17.5		**EX313/4** [2]
7/8	14	22.225	140	25	18.0	14.5	17	4	20.4		**EX317/8** [2]
1“	12	25.400	160	30	18.0	14.5	17	4	23.25		**EX311** [2]

HSS-E

2)

UNF ANSI 3B 2.5XD HSS-PM C 2-3 λ45°

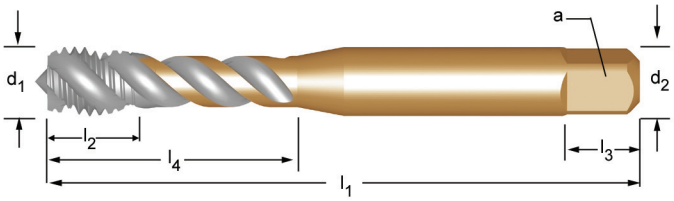
E037

- UNF Strojní závitník Spectrum™ Tap, šroubovitá drážka 45°
- UNF Gépi Menetfúró Spectrum™ Tap Csavart hornyú 45°
- UNF Gwintownik maszynowy Spectrum™ Tap, śrubowy rowek wiórowy 45°
- UNF Tarozi de masina Spectrum™ Tap Canal elicoidal 45°
- UNF Машинные метчики Spectrum™ Tap Спиральная стружечная канавка 45°
- UNF Machine Tap Spectrum™ Tap Spiral Flute 45°

Spectrum™ Tap 360

Vc[m/min]													
P		M		K		N		S		H		O	
P 1	**13-30**	M 1		K 1		N 1.1	**13-19**	S 1	**10-14**	H 1		O 1	**24-36**
P 2	**4-19**	M 2		K 2		N 1.2	**28-42**	S 2	**4-14**	H 2		O 2	
P 3	**4-19**	M 3		K 3		N 1.3	**12-24**	S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4	**12-18**	S 4	**4-12**	H 4		O 4	
P 5	**4-19**			K 5		N 2	**12-24**	S 5				O 5	
						N 3.1		S 6				O 6	**24-36**
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



UNF	TPI	l_1 inch	l_2 inch	d_2 Ø inch	⧄ a inch	z	Limits	↔	l_4 inch	↔	EDP # or Stock No.	e-Code
10	32	2.3/8	0.2650	0.1940	0.1520	3	H2	N21	0.8434	4.10	0582312	**E03710-32**
1/4	28	2.1/2	0.3937	0.2550	0.1910	3	H3	N3	1.0993	5.50	0582329	**E0371/4**
5/16	24	2.23/32	0.4567	0.3180	0.2380	3	H3	I	1.3094	6.90	0582336	**E0375/16**
3/8	24	2.15/16	0.5315	0.3810	0.2860	3	H3	Q	1.4415	8.50	0582343	**E0373/8**
7/16	20	3.5/32	0.6299	0.3230	0.2420	3	H3	25/64		9.90	0582350	**E0377/16**
1/2	20	3.3/8	0.6890	0.3670	0.2750	3	H3	29/64		11.50	0582367	**E0371/2**
9/16	18	3.19/32	0.7087	0.4290	0.3220	3	H3	33/64		12.90	0582374	**E0379/16**
5/8	18	3.13/16	0.7087	0.4800	0.3600	3	H3	37/64		14.50	0582381	**E0375/8**
3/4	16	4.1/4	0.8858	0.5900	0.4420	3	H3	11/16		17.50	0582398	**E0373/4**
7/8	14	4.11/16	0.9843	0.6970	0.5230	3	H4	13/16		20.40	0582404	**E0377/8**
1“	12	5.1/8	1.1811	0.8000	0.6000	3	H4	59/64		23.25	0582411	**E0371-12**
1“	14	5.1/8	1.1811	0.8000	0.6000	3	H4	59/64		23.50	0582428	**E0371-14**

UNF ANSI 3B 2.5XD HSS-PM C 2-3 λ45° ST

E038

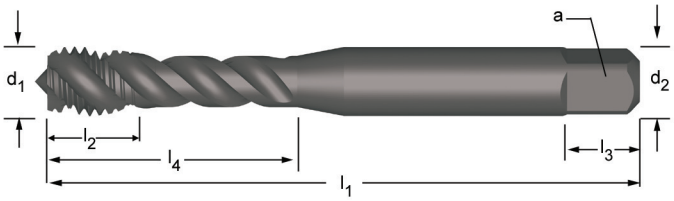
- UNF Strojní závitník Spectrum™ Tap, šroubovitá drážka 45°
- UNF Gépi Menetfúró Spectrum™ Tap Csavart hornyú 45°
- UNF Gwintownik maszynowy Spectrum™ Tap, śrubowy rowek wiórowy 45°
- UNF Tarozi de masina Spectrum™ Tap Canal elicoidal 45°
- UNF Машинные метчики Spectrum™ Tap Спиральная стружечная канавка 45°
- UNF Machine Tap Spectrum™ Tap Spiral Flute 45°

Spectrum™ Tap 360

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**13-30**	M 1	**3-8**	K 1		N 1.1		S 1		H 1		O 1	
P 2	**4-19**	M 2	**5-7**	K 2		N 1.2		S 2		H 2		O 2	
P 3	**4-19**	M 3	**3-5**	K 3		N 1.3		S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4		S 4		H 4		O 4	
P 5	**3-19**			K 5		N 2		S 5				O 5	
						N 3.1		S 6				O 6	
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



UNF	TPI	l_1 inch	l_2 inch	d_2 Ø inch	⧄ a inch	z	Limits		l_4 inch		EDP # or Stock No.	e-Code
10	32	2.3/8	0.2650	0.1940	0.1520	3	H2	N21	0.8434	4.10	0582312	**E03710-32**
1/4	28	2.1/2	0.3937	0.2550	0.1910	3	H3	N3	1.0993	5.50	0582329	**E0371/4**
5/16	24	2.23/32	0.4567	0.3180	0.2380	3	H3	I	1.3094	6.90	0582336	**E0375/16**
3/8	24	2.15/16	0.5315	0.3810	0.2860	3	H3	Q	1.4415	8.50	0582343	**E0373/8**
7/16	20	3.5/32	0.6299	0.3230	0.2420	3	H3	25/64		9.90	0582350	**E0377/16**
1/2	20	3.3/8	0.6890	0.3670	0.2750	3	H3	29/64		11.50	0582367	**E0371/2**
9/16	18	3.19/32	0.7087	0.4290	0.3220	3	H3	33/64		12.90	0582374	**E0379/16**
5/8	18	3.13/16	0.7087	0.4800	0.3600	3	H3	37/64		14.50	0582381	**E0375/8**
3/4	16	4.1/4	0.8858	0.5900	0.4420	3	H3	11/16		17.50	0582398	**E0373/4**
7/8	14	4.11/16	0.9843	0.6970	0.5230	3	H4	13/16		20.40	0582404	**E0377/8**
1“	12	5.1/8	1.1811	0.8000	0.6000	3	H4	59/64		23.25	0582411	**E0371-12**
1“	14	5.1/8	1.1811	0.8000	0.6000	3	H4	59/64		23.50	0582428	**E0371-14**

UNF | ISO 529 | 2B | 2.5XD | HSS-PM | C 2-3 | λ45°

E032

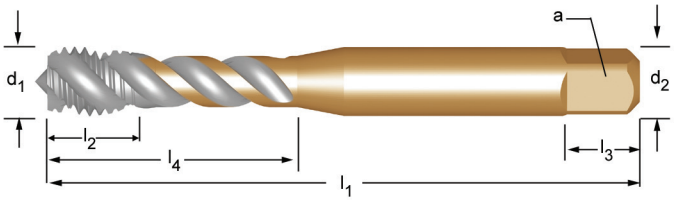
- UNF Strojní závitník Spectrum™ Tap, šroubovitá drážka 45°
- UNF Gépi Menetfúró Spectrum™ Tap Csavart hornyú 45°
- UNF Gwintownik maszynowy Spectrum™ Tap, śrubowy rowek wiórowy 45°
- UNF Tarozi de masina Spectrum™ Tap Canal elicoidal 45°
- UNF Машинные метчики Spectrum™ Tap Спиральная стружечная канавка 45°
- UNF Machine Tap Spectrum™ Tap Spiral Flute 45°

Spectrum™ Tap 360

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**13-30**	M 1		K 1		N 1.1	**13-19**	S 1	**10-14**	H 1		O 1	**24-36**
P 2	**4-19**	M 2		K 2		N 1.2	**28-42**	S 2	**4-14**	H 2		O 2	
P 3	**4-19**	M 3		K 3		N 1.3	**12-24**	S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4	**12-18**	S 4	**4-12**	H 4		O 4	
P 5	**4-19**			K 5		N 2	**12-24**	S 5				O 5	
						N 3.1		S 6				O 6	**24-36**
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



UNF	TPI	d_1 nom mm	l_1 mm	l_2 mm	d_2 Ø mm	⧄ a mm	l_3 mm	z	↔	l_4 mm	e-Code
8	36	4.166	53	7	4.50	3.55	6	3	3.50	17	**E0328-36**
10	32	4.826	58	8	5.00	4.00	7	3	4.10	20	**E03210-32**
1/4	28	6.350	66	10	6.30	5.00	8	3	5.50	28	**E0321/4**
5/16	24	7.938	72	12	8.00	6.30	9	3	6.90	31	**E0325/16**
3/8	24	9.525	80	15	10.00	8.00	11	3	8.50	34	**E0323/8**
7/16	20	11.112	85	19	8.00	6.30	9	3	9.90		**E0327/16**
1/2	20	12.700	89	22	9.00	7.10	10	3	11.50		**E0321/2**
9/16	18	14.288	95	24	11.20	9.00	12	3	12.90		**E0329/16**
5/8	18	15.875	102	24	12.50	10.00	13	4	14.50		**E0325/8**
3/4	16	19.050	112	29	14.00	11.20	14	4	17.50		**E0323/4**
7/8	14	22.225	118	29	16.00	12.50	16	4	20.40		**E0327/8**
1“	12	25.400	130	35	18.00	14.00	18	4	23.25		**E0321**

UNF | ISO 529 | 2B | 2.5XD | HSS-PM | C 2-3 | λ45° | ST

E033

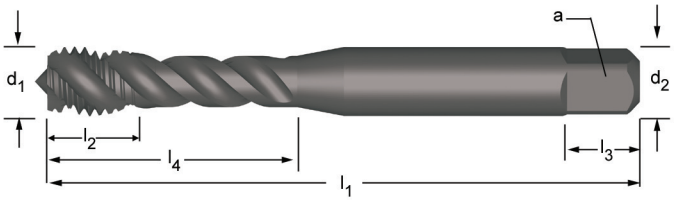
- UNF Strojní závitník Spectrum™ Tap, šroubovitá drážka 45°
- UNF Gépi Menetfúró Spectrum™ Tap Csavart hornyú 45°
- UNF Gwintownik maszynowy Spectrum™ Tap, śrubowy rowek wiórowy 45°
- UNF Tarozi de masina Spectrum™ Tap Canal elicoidal 45°
- UNF Машинные метчики Spectrum™ Tap Спиральная стружечная канавка 45°
- UNF Machine Tap Spectrum™ Tap Spiral Flute 45°

Spectrum™ Tap 360

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**13-30**	M 1	**3-8**	K 1		N 1.1		S 1		H 1		O 1	
P 2	**4-19**	M 2	**5-7**	K 2		N 1.2		S 2		H 2		O 2	
P 3	**4-19**	M 3	**3-5**	K 3		N 1.3		S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4		S 4		H 4		O 4	
P 5	**3-19**			K 5		N 2		S 5				O 5	
						N 3.1		S 6				O 6	
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



UNF	TPI	d_1 nom mm	l_1 mm	l_2 mm	d_2 Ø mm	⧄ a mm	l_3 mm	z	↔	l_4 mm	e-Code
8	36	4.166	53	7	4.50	3.55	6	3	3.50	17	**E0338-36**
10	32	4.826	58	8	5.00	4.00	7	3	4.10	20	**E03310-32**
1/4	28	6.350	66	10	6.30	5.00	8	3	5.50	28	**E0331/4**
5/16	24	7.938	72	12	8.00	6.30	9	3	6.90	31	**E0335/16**
3/8	24	9.525	80	15	10.00	8.00	11	3	8.50	34	**E0333/8**
7/16	20	11.112	85	19	8.00	6.30	9	3	9.90		**E0337/16**
1/2	20	12.700	89	22	9.00	7.10	10	3	11.50		**E0331/2**
9/16	18	14.288	95	24	11.20	9.00	12	3	12.90		**E0339/16**
5/8	18	15.875	102	24	12.50	10.00	13	4	14.50		**E0335/8**
3/4	16	19.050	112	29	14.00	11.20	14	4	17.50		**E0333/4**
7/8	14	22.225	118	29	16.00	12.50	16	4	20.40		**E0337/8**
1“	12	25.400	130	35	18.00	14.00	18	4	23.25		**E0331**

EP40

- G(BSP) Strojní závitník Spectrum™ Tap lamač třísek, přímá drážka
- G(BSP) Gépi Menetfúró Spectrum™ Tap Terelőéles
- G(BSP) Gwintownik maszynowy Spectrum™ Tap ze skośną powierzchnią natarcia
- G(BSP) Tarozi de masina Spectrum™ Tap Varf spiral
- G(BSP) Машинные метчики Spectrum™ Tap Криволинейная задняя поверхность
- G(BSP) Machine Tap Spectrum™ Tap Spiral Point

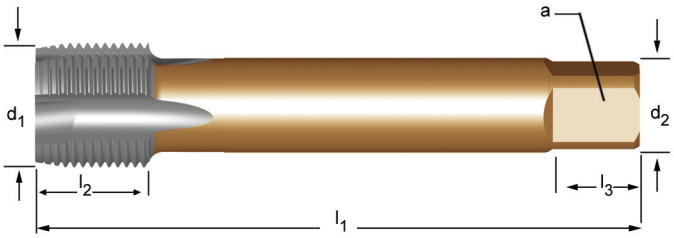
Spectrum™ Tap 200

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**13-30**	M 1		K 1	**12-18**	N 1.1	**13-19**	S 1	**10-14**	H 1		O 1	**24-36**
P 2	**4-19**	M 2		K 2	**6-18**	N 1.2	**28-42**	S 2	**4-14**	H 2		O 2	
P 3	**4-19**	M 3		K 3	**12-18**	N 1.3	**12-24**	S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4	**12-18**	S 4	**4-12**	H 4		O 4	
P 5	**4-19**			K 5	**6-10**	N 2	**12-24**	S 5				O 5	
						N 3.1	**10-14**	S 6				O 6	**24-36**
						N 3.2	**16-36**					O 7	
						N 3.3	**24-36**						
						N 3.4							
						N 4	**24-36**						

$$n = \frac{Vc \times 1000}{\pi \times D}$$

EP40



G(BSP)	TPI	d_1 nom mm	l_1 mm	l_2 mm	d_2 Ø mm	⧄ a mm	l_3 mm	z	↔	e-Code
1/8	28	9.728	90	18	7	5.5	8	3	8.8	**EP401/8**
1/4	19	13.157	100	21	11	9.0	12	3	11.8	**EP401/4**
3/8	19	16.662	100	21	12	9.0	12	4	15.25	**EP403/8**
1/2	14	20.955	125	24	16	12.0	15	4	19	**EP401/2**
5/8	14	22.911	125	24	18	14.5	17	4	21	**EP405/8**
3/4	14	26.441	140	28	20	16.0	19	4	24.5	**EP403/4**
7/8	14	30.201	150	28	22	18.0	21	4	28.25	**EP407/8**
1“	11	33.249	160	30	25	20.0	23	4	30.75	**EP401**

G | DIN 5156 | Normal | 2.5XD | HSS-E | B 3.5-5 | ST

EP41

- G(BSP) Strojní závitník Spectrum™ Tap lamač třísek, přímá drážka
- G(BSP) Gépi Menetfúró Spectrum™ Tap Terelőéles
- G(BSP) Gwintownik maszynowy Spectrum™ Tap ze skośną powierzchnią natarcia
- G(BSP) Tarozi de masina Spectrum™ Tap Varf spiral
- G(BSP) Машинные метчики Spectrum™ Тар Криволинейная задняя поверхность
- G(BSP) Machine Tap Spectrum™ Tap Spiral Point

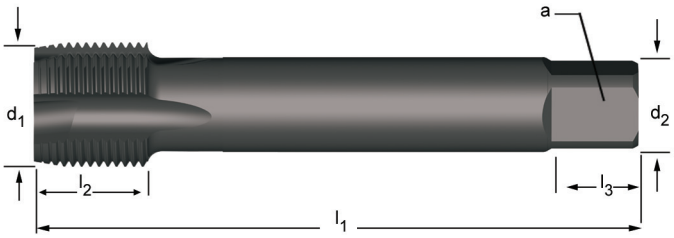
Spectrum™ Tap 200

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**13-30**	M 1	**3-8**	K 1	**12-18**	N 1.1		S 1		H 1		O 1	
P 2	**4-19**	M 2	**5-7**	K 2	**6-18**	N 1.2		S 2		H 2		O 2	
P 3	**4-19**	M 3	**3-5**	K 3	**12-18**	N 1.3		S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4		S 4		H 4		O 4	
P 5	**3-19**			K 5	**6-10**	N 2		S 5				O 5	
						N 3.1		S 6				O 6	
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$

EP41



G(BSP)	TPI	d_1 nom mm	l_1 mm	l_2 mm	d_2 Ø mm	⧄ a mm	l_3 mm	z	↔	e-Code
1/8	28	9.728	90	18	7	5.5	8	3	8.8	**EP411/8**
1/4	19	13.157	100	21	11	9.0	12	3	11.8	**EP411/4**
3/8	19	16.662	100	21	12	9.0	12	4	15.25	**EP413/8**
1/2	14	20.955	125	24	16	12.0	15	4	19	**EP411/2**
5/8	14	22.911	125	24	18	14.5	17	4	21	**EP415/8**
3/4	14	26.441	140	28	20	16.0	19	4	24.5	**EP413/4**
7/8	14	30.201	150	28	22	18.0	21	4	28.25	**EP417/8**
1“	11	33.249	160	30	25	20.0	23	4	30.75	**EP411**

G | DIN 5156 | Normal | 2.5XD | HSS-E | C 2-3 | λ45°

EX40

- G(BSP) Strojní závitník Spectrum™ Tap, šroubovitá drážka 45°
- G(BSP) Gépi Menetfúró Spectrum™ Tap Csavart hornyú 45°
- G(BSP) Gwintownik maszynowy Spectrum™ Tap, śrubowy rowek wiórowy 45°
- G(BSP) Tarozi de masina Spectrum™ Tap Canal elicoidal 45°
- G(BSP) Машинные метчики Spectrum™ Tap Спиральная стружечная канавка 45°
- G(BSP) Machine Tap Spectrum™ Tap Spiral Flute 45°

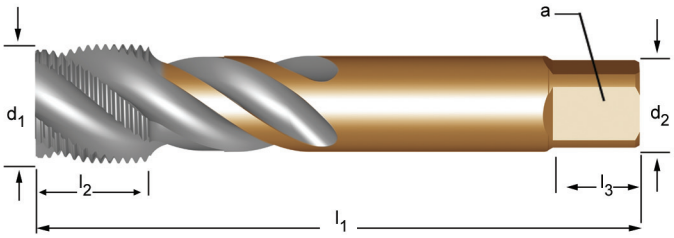
Spectrum™ Tap 360

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**13-30**	M 1		K 1		N 1.1	**13-19**	S 1	**10-14**	H 1		O 1	**24-36**
P 2	**8-19**	M 2		K 2		N 1.2	**28-42**	S 2	**4-14**	H 2		O 2	
P 3	**8-19**	M 3		K 3		N 1.3	**12-24**	S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4	**12-18**	S 4	**4-12**	H 4		O 4	
P 5	**8-19**			K 5		N 2	**12-24**	S 5				O 5	
						N 3.1		S 6				O 6	**24-36**
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$

EX40



G(BSP)	TPI	d_1 nom mm	l_1 mm	l_2 mm	d_2 Ø mm	a mm	l_3 mm	z		e-Code
1/8	28	9.728	90	13	7	5.5	8	3	8.8	**EX401/8**
1/4	19	13.157	100	15	11	9.0	12	3	11.8	**EX401/4**
3/8	19	16.662	100	15	12	9.0	12	4	15.25	**EX403/8**
1/2	14	20.955	125	18	16	12.0	15	4	19	**EX401/2**
5/8	14	22.911	125	18	18	14.5	17	4	21	**EX405/8**
3/4	14	26.441	140	20	20	16.0	19	4	24.5	**EX403/4**
7/8	14	30.201	150	20	22	18.0	21	4	28.25	**EX407/8**
1“	11	33.249	160	22	25	20.0	23	4	30.75	**EX401**
1.1/8	11	37.897	170	22	28	22.0	25	4	35	**EX401.1/8**
1.1/4	11	41.910	170	22	32	24.0	27	4	39.5	**EX401.1/4**
1.1/2	11	47.803	190	23	36	29.0	32	4	45	**EX401.1/2**

G | DIN 5156 | Normal | 2.5XD | HSS-E | C 2-3 | λ45° | ST

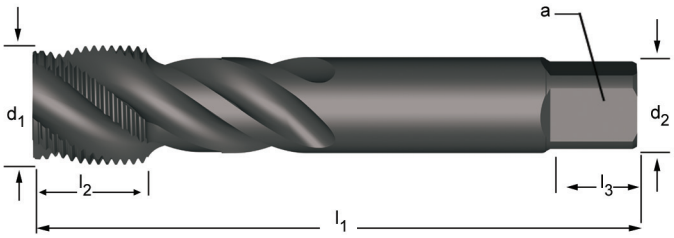
EX41

- G(BSP) Strojní závitník Spectrum™ Tap, šroubovitá drážka 45°
- G(BSP) Gépi Menetfúró Spectrum™ Tap Csavart hornyú 45°
- G(BSP) Gwintownik maszynowy Spectrum™ Tap, śrubowy rowek wiórowy 45°
- G(BSP) Tarozi de masina Spectrum™ Tap Canal elicoidal 45°
- G(BSP) Машинные метчики Spectrum™ Tap Спиральная стружечная канавка 45°
- G(BSP) Machine Tap Spectrum™ Tap Spiral Flute 45°

Spectrum™ Tap 360

Vc[m/min]													
P		M		K		N		S		H		O	
P 1	**13-30**	M 1	**3-8**	K 1		N 1.1		S 1		H 1		O 1	
P 2	**8-19**	M 2	**5-7**	K 2		N 1.2		S 2		H 2		O 2	
P 3	**8-19**	M 3	**3-5**	K 3		N 1.3		S 3		H 3		O 3	
P 4	**13-22**			K 4		N 1.4		S 4		H 4		O 4	
P 5	**3-19**			K 5		N 2		S 5				O 5	
						N 3.1		S 6				O 6	
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



G(BSP)	TPI	d_1 nom mm	l_1 mm	l_2 mm	d_2 Ø mm	⧄ a mm	l_3 mm	z	↔	e-Code
1/8	28	9.728	90	13	7	5.5	8	3	8.8	**EX411/8**
1/4	19	13.157	100	15	11	9.0	12	3	11.8	**EX411/4**
3/8	19	16.662	100	15	12	9.0	12	4	15.25	**EX413/8**
1/2	14	20.955	125	18	16	12.0	15	4	19	**EX411/2**
5/8	14	22.911	125	18	18	14.5	17	4	21	**EX415/8**
3/4	14	26.441	140	20	20	16.0	19	4	24.5	**EX413/4**
7/8	14	30.201	150	20	22	18.0	21	4	28.25	**EX417/8**
1“	11	33.249	160	22	25	20.0	23	4	30.75	**EX411**
1.1/8	11	37.897	170	22	28	22.0	25	4	35	**EX411.1/8**
1.1/4	11	41.910	170	22	32	24.0	27	4	39.5	**EX411.1/4**
1.1/2	11	47.803	190	23	36	29.0	32	4	45	**EX411.1/2**

NPT | DIN ANSI | Normal | 1.5XD | HSS-E | C 2-3 | λ15° | ST

E735

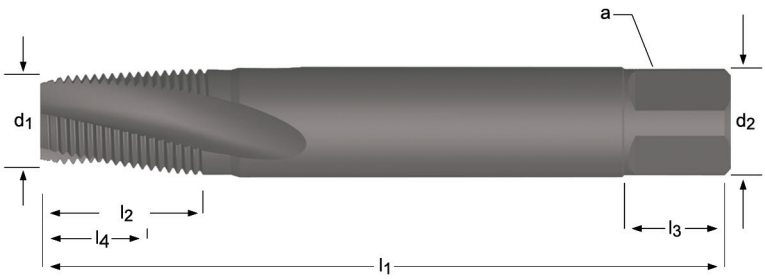
- NPT Strojní závitník Spectrum™ Tap, šroubovitá drážka 15°
- NPT Gépi Menetfúró Spectrum™ Tap Csavart hornyú 15°
- NPT Gwintownik maszynowy Spectrum™ Tap, śrubowy rowek wiórowy 15°
- NPT Tarozi de masina Spectrum™ Tap Canal elicoidal 15°
- NPT Машинные метчики Spectrum™ Tap Спиральная стружечная канавка 15°
- NPT Machine Tap Spectrum™ Tap Spiral Flute 15°

Spectrum™ Tap 300

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**5-7**	M 1	**2-4**	K 1		N 1.1		S 1		H 1		O 1	
P 2	**2-7**	M 2	**2-4**	K 2	**3-11**	N 1.2		S 2	**2-4**	H 2		O 2	
P 3	**2-7**	M 3		K 3		N 1.3	**10-19**	S 3		H 3		O 3	
P 4	**5-7**			K 4		N 1.4	**10-14**	S 4	**2-4**	H 4		O 4	
P 5	**2-7**			K 5		N 2	**10-19**	S 5				O 5	
						N 3.1		S 6				O 6	
						N 3.2	**9-18**					O 7	
						N 3.3	**12-18**						
						N 3.4	**3-5**						
						N 4	**12-18**						

$$n = \frac{Vc \times 1000}{\pi \times D}$$



NPT	TPI	d_1 nom mm	l_1 mm	l_2 mm	d_2 Ø mm	⧄ a mm	l_3 mm	z	↔	↔	l_4 mm	e-Code
1/16	27	7.72	80	14	7.9	5.9	9	3	6.30	D	10.0	**E7351/16**
1/8	27	10.06	90	14	11.1	8.3	9	4	8.50	R	9.8	**E7351/8**
1/4	18	13.36	100	20	14.3	10.7	11	4	11.00	7/16	13.9	**E7351/4**
3/8	18	16.81	110	20	17.8	13.5	13	5	14.50	37/64	15.2	**E7353/8**
1/2	14	20.96	125	26	17.5	13.1	16	5	18.00	23/32	19.0	**E7351/2**
3/4	14	26.29	140	26	23.0	17.2	18	5	23.00	59/64	19.4	**E7353/4**
1“	11.5	32.92	150	31	28.6	21.4	21	5	29.00	1.5/32	23.2	**E7351**

NPTF | DIN ANSI | Normal | 1.5XD | HSS-E | C 2-3 | λ15° | ST

E737

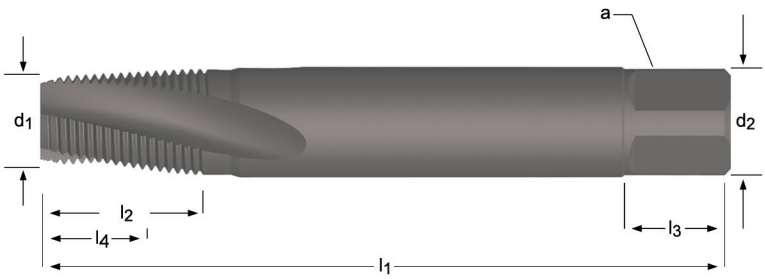
- NPTF Strojní závitník Spectrum™ Tap, šroubovitá drážka 15°
- NPTF Gépi Menetfúró Spectrum™ Tap Csavart hornyú 15°
- NPTF Gwintownik maszynowy Spectrum™ Tap, śrubowy rowek wiórowy 15°
- NPTF Tarozi de masina Spectrum™ Tap Canal elicoidal 15°
- NPTF Машинные метчики Spectrum™ Tap Спиральная стружечная канавка 15°
- NPTF Machine Tap Spectrum™ Tap Spiral Flute 15°

Spectrum™ Tap 300

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**5-7**	M 1	**2-4**	K 1		N 1.1		S 1		H 1		O 1	
P 2	**2-7**	M 2	**2-4**	K 2	**3-11**	N 1.2		S 2	**2-4**	H 2		O 2	
P 3	**2-7**	M 3		K 3		N 1.3	**10-19**	S 3		H 3		O 3	
P 4	**5-7**			K 4		N 1.4	**10-14**	S 4	**2-4**	H 4		O 4	
P 5	**2-7**			K 5		N 2	**10-19**	S 5				O 5	
						N 3.1		S 6				O 6	
						N 3.2	**9-18**					O 7	
						N 3.3	**12-18**						
						N 3.4	**3-5**						
						N 4	**12-18**						

$$n = \frac{Vc \times 1000}{\pi \times D}$$



NPTF	TPI	d_1 min mm	l_1 mm	l_2 mm	d_2 Ø mm	⧄ a mm	l_3 mm	z	↔	↔	e-Code
1/16	27	7.65	80	14	7.9	5.9	9	3	6.10	D	**E7371/16**
1/8	27	9.98	90	14	11.1	8.3	9	4	8.40	Q	**E7371/8**
1/4	18	13.31	100	20	14.3	10.7	11	4	10.9	7/16	**E7371/4**
3/8	18	16.76	110	20	17.8	13.5	13	5	14.25	9/16	**E7373/8**
1/2	14	20.93	125	26	17.5	13.1	16	5	17.5	11/16	**E7371/2**
3/4	14	26.26	140	26	23.0	17.2	18	5	23.00	29/32	**E7373/4**

M | DIN 2174 | 6HX | 3XD | HM | C 2-3 | TiCN

T115

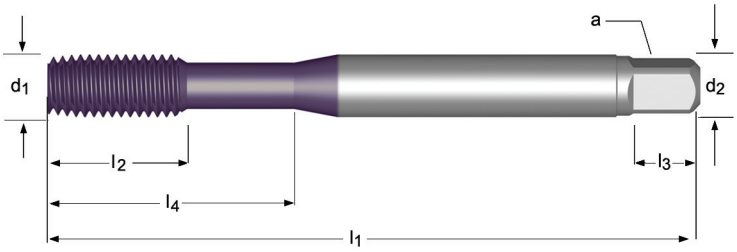
- M Strojní závitník Spectrum™ Tap bezdrážkový
- M Gépi Menetfúró Spectrum™ Tap Menetformázók
- M Gwintowygniatak bezrowkowy Spectrum™ Tap
- M Tarozi de masina Spectrum™ Tap Fara canale
- M Машинные метчики Spectrum™ Tap Без стружечной канавки
- M Machine Tap Spectrum™ Tap Fluteless

Spectrum™ Tap 405

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**32-72**	M 1	**20-30**	K 1		N 1.1	**56-84**	S 1	**28-42**	H 1		O 1	
P 2	**24-48**	M 2	**20-30**	K 2		N 1.2	**64-96**	S 2	**12-42**	H 2		O 2	
P 3	**24-48**	M 3	**20-30**	K 3		N 1.3	**64-96**	S 3		H 3		O 3	
P 4	**32-72**			K 4		N 1.4		S 4		H 4		O 4	
P 5	**20-48**			K 5		N 2	**64-96**	S 5				O 5	
						N 3.1	**32-48**	S 6				O 6	
						N 3.2	**65-97**					O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



M	P mm	l_1 mm	l_2 mm	d_2 Ø mm	◪ a mm	l_3 mm	↔	l_4 mm	e-Code	
3	0.50	56	10	3.5	2.7	6	2.8		**T115M3**	1) 2)
4	0.70	63	13	4.5	3.4	6	3.7		**T115M4**	1) 2)
5	0.80	70	16	6	4.9	8	4.6		**T115M5**	1) 2)
6	1.00	80	19	6	4.9	8	5.5	30	**T115M6**	
8	1.25	90	22	8	6.2	9	7.4	35	**T115M8**	
10	1.50	100	24	10	8.0	11	9.3	39	**T115M10**	

1) Bez krčku / áteső szárú / bez szyjki / fara gat / без занижения / Without neck
2) S plochým koncem / Teljes pont / Nakiełek zewnętrzny / Punct de încheiere / Цилиндрические с плоским концом / Full point

M | DIN 2174 | 6HX | 3XD | HM | C 2-3 | TiCN

T116

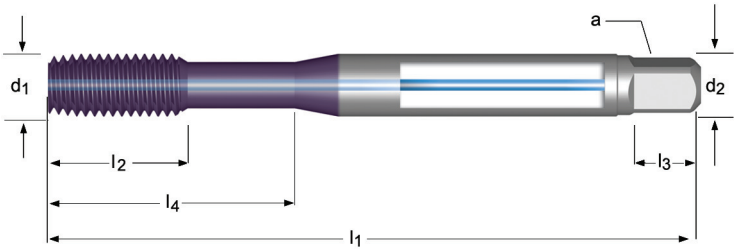
- M Strojní závitník Spectrum™ Tap bezdrážkový
- M Gépi Menetfúró Spectrum™ Tap Menetformázók
- M Gwintowygniatak bezrowkowy Spectrum™ Tap
- M Tarozi de masina Spectrum™ Tap Fara canale
- M Машинные метчики Spectrum™ Tap Без стружечной канавки
- M Machine Tap Spectrum™ Tap Fluteless

Spectrum™ Tap 405

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**32-72**	M 1	**20-30**	K 1		N 1.1	**56-84**	S 1	**28-42**	H 1		O 1	
P 2	**24-48**	M 2	**20-30**	K 2		N 1.2	**64-96**	S 2	**12-42**	H 2		O 2	
P 3	**24-48**	M 3	**20-30**	K 3		N 1.3	**64-96**	S 3		H 3		O 3	
P 4	**32-72**			K 4		N 1.4		S 4		H 4		O 4	
P 5	**20-48**			K 5		N 2	**64-96**	S 5				O 5	
						N 3.1	**32-48**	S 6				O 6	
						N 3.2	**65-97**					O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



M	P mm	l_1 mm	l_2 mm	d_2 Ø mm	◪ a mm	l_3 mm	↔	l_4 mm	e-Code
5	0.80	70	16	6	4.9	8	4.6		**T116M5** [1]
6	1.00	80	19	6	4.9	8	5.5	30	**T116M6**
8	1.25	90	22	8	6.2	9	7.4	35	**T116M8**
10	1.50	100	24	10	8.0	11	9.3	39	**T116M10**
12	1.75	110	23	9	7.0	10	11.2		**T116M12**

[1] S plochým koncem / Teljes pont / Nakiełek zewnętrzny / Punct de încheiere / Цилиндрические с плоским концом / Full point

M | DIN 2174 | 6HX | 3XD | HSS-E | C 2-3.5

E301

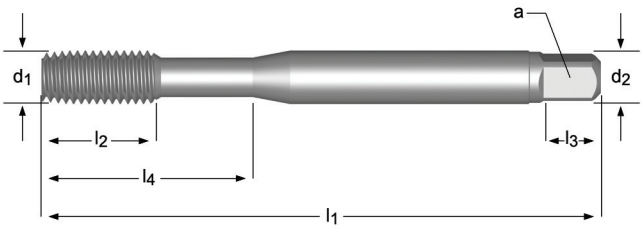
- M Strojní závitník Spectrum™ Tap bezdrážkový
- M Gépi Menetfúró Spectrum™ Tap Menetformázók
- M Gwintowygniatak bezrowkowy Spectrum™ Tap
- M Tarozi de masina Spectrum™ Tap Fara canale
- M Машинные метчики Spectrum™ Tap Без стружечной канавки
- Machine Tap Spectrum™ Tap Fluteless

Spectrum™ Tap 400

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**16-36**	M 1		K 1		N 1.1	**18-26**	S 1		H 1		O 1	
P 2	**16-24**	M 2		K 2		N 1.2	**30-46**	S 2		H 2		O 2	
P 3	**16-24**	M 3		K 3		N 1.3	**18-26**	S 3		H 3		O 3	
P 4	**16-28**			K 4		N 1.4		S 4		H 4		O 4	
P 5	**16-24**			K 5		N 2	**18-26**	S 5				O 5	
						N 3.1		S 6				O 6	
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



M	P mm	l_1 mm	l_2 mm	d_2 Ø mm	◪ a mm	l_3 mm	z	↔	l_4 mm	e-Code
1	0.25	40	5.5	2.5	2.1	5	3	0.90	-	**E301M1** [1]
1.2	0.25	40	5.5	2.5	2.1	5	3	1.10	-	**E301M1.2** [1]
1.4	0.30	40	7	2.5	2.1	5	3	1.25	-	**E301M1.4** [1]
1.6	0.35	40	8	2.5	2.1	5	3	1.45	-	**E301M1.6** [1]
1.7	0.35	40	8	2.5	2.1	5	3	1.55	-	**E301M1.7** [1]
1.8	0.35	40	8	2.5	2.1	5	3	1.65	-	**E301M1.8** [1]
2	0.40	45	6	2.8	2.1	5	3	1.80	11	**E301M2** [1]
2.2	0.45	45	7	2.8	2.1	5	3	2.00	12	**E301M2.2** [1]
2.3	0.40	45	7	2.8	2.1	5	3	2.1	12	**E301M2.3** [1]
2.5	0.45	50	8	2.8	2.1	5	3	2.30	14	**E301M2.5** [1]
2.6	0.45	50	8	2.8	2.1	5	3	2.4	5	**E301M2.6** [1]
3	0.50	56	9	3.5	2.7	6	4	2.80	18	**E301M3** [1]
3.5	0.60	56	11	4.0	3.0	6	4	3.20	20	**E301M3.5** [1]
4	0.70	63	12	4.5	3.4	6	5	3.70	21	**E301M4** [1]
5	0.80	70	13	6.0	4.9	8	5	4.60	25	**E301M5** [1]
6	1.00	80	15	6.0	4.9	8	5	5.50	30	**E301M6** [1]
8	1.25	90	18	8.0	6.2	9	5	7.40	35	**E301M8** [1]
10	1.50	100	20	10.0	8.0	11	5	9.30	39	**E301M10** [1]
12	1.75	110	23	9.0	7.0	10	5	11.20	-	**E301M12**
16	2.00	110	25	12.0	9.0	12	8	15.10	-	**E301M16**
20	2.50	140	30	16.0	12.0	15	8	18.90	-	**E301M20**
24	3.00	160	36	18.0	14.5	17	8	22.7	-	**E301M24**

[1] S plochým koncem/ Teljes pont / Nakiełek zewnętrzny / Punct de încheiere / Цилиндрические с плоским концом / Full point

M | DIN 2174 | 6HX | 3XD | HSS-E | C 2-3.5 | TiN

E302

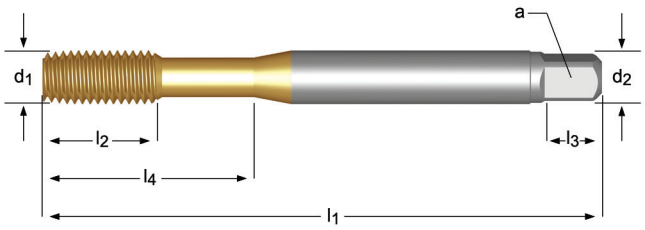
- M Strojní závitník Spectrum™ Tap bezdrážkový
- M Gépi Menetfúró Spectrum™ Tap Menetformázók
- M Gwintowygniatak bezrowkowy Spectrum™ Tap
- M Tarozi de masina Spectrum™ Tap Fara canale
- M Машинные метчики Spectrum™ Tap Без стружечной канавки
- M Machine Tap Spectrum™ Tap Fluteless

Spectrum™ Tap 400

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**32-66**	M 1	**8-22**	K 1		N 1.1	**32-48**	S 1	**16-24**	H 1		O 1	
P 2	**16-48**	M 2	**12-18**	K 2		N 1.2	**44-66**	S 2	**6-24**	H 2		O 2	
P 3	**16-48**	M 3	**8-12**	K 3		N 1.3	**20-48**	S 3		H 3		O 3	
P 4	**32-54**			K 4		N 1.4	**20-30**	S 4	**28-42**	H 4		O 4	
P 5	**8-48**			K 5		N 2	**20-48**	S 5				O 5	
						N 3.1	**20-30**	S 6				O 6	
						N 3.2	**32-48**					O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



M	P mm	l_1 mm	l_2 mm	d_2 Ø mm	◪ a mm	l_3 mm	z	↔	l_4 mm	e-Code
1	0.25	40	5.5	2.5	2.1	5	3	0.90	-	**E302M1** [1]
1.2	0.25	40	5.5	2.5	2.1	5	3	1.10	-	**E302M1.2** [1]
1.4	0.30	40	7	2.5	2.1	5	3	1.25	-	**E302M1.4** [1]
1.6	0.35	40	8	2.5	2.1	5	3	1.45	-	**E302M1.6** [1]
1.7	0.35	40	8	2.5	2.1	5	3	1.55	-	**E302M1.7** [1]
1.8	0.35	40	8	2.5	2.1	5	3	1.65	-	**E302M1.8** [1]
2	0.40	45	6	2.8	2.1	5	3	1.80	11	**E302M2** [1]
2.2	0.45	45	7	2.8	2.1	5	3	2.0	12	**E302M2.2** [1]
2.3	0.40	45	7	2.8	2.1	5	3	2.1	12	**E302M2.3** [1]
2.5	0.45	50	8	2.8	2.1	5	3	2.30	14	**E302M2.5** [1]
2.6	0.45	50	8	2.8	2.1	5	3	2.4	5	**E302M2.6** [1]
3	0.50	56	9	3.5	2.7	6	4	2.80	18	**E302M3** [1]
3.5	0.60	56	11	4.0	3.0	6	4	3.20	20	**E302M3.5** [1]
4	0.70	63	12	4.5	3.4	6	5	3.70	21	**E302M4** [1]
5	0.80	70	13	6.0	4.9	8	5	4.60	25	**E302M5** [1]
6	1.00	80	15	6.0	4.9	8	5	5.50	30	**E302M6** [1]
8	1.25	90	18	8.0	6.2	9	5	7.40	35	**E302M8** [1]
10	1.50	100	20	10.0	8.0	11	5	9.30	39	**E302M10** [1]
12	1.75	110	23	9.0	7.0	10	5	11.20	-	**E302M12**
16	2.00	110	25	12.0	9.0	12	8	15.10	-	**E302M16**
20	2.50	140	30	16.0	12.0	15	8	18.9	-	**E302M20**
24	3.00	160	36	18.0	14.5	17	8	22.70	-	**E302M24**

[1] S plochým koncem / Teljes pont / Nakiełek zewnętrzny / Punct de încheiere / Цилиндрические с плоским концом / Full point

M | DIN 2174 | 6HX | 3XD | HSS-E | C 2-3.5 | CrN

E306

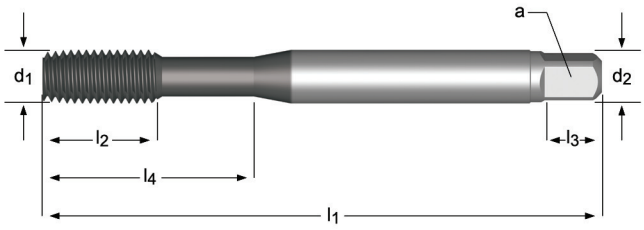
- M Strojní závitník Spectrum™ Tap bezdrážkový
- M Gépi Menetfúró Spectrum™ Tap Menetformázók
- M Gwintowygniatak bezrowkowy Spectrum™ Tap
- M Tarozi de masina Spectrum™ Tap Fara canale
- M Машинные метчики Spectrum™ Тар Без стружечной канавки
- M Machine Tap Spectrum™ Tap Fluteless

Spectrum™ Tap 400

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**32-66**	M 1	**12-22**	K 1		N 1.1	**32-48**	S 1	**16-24**	H 1		O 1	
P 2	**32-48**	M 2	**12-18**	K 2		N 1.2	**44-66**	S 2	**6-24**	H 2		O 2	
P 3	**32-48**	M 3		K 3		N 1.3	**20-48**	S 3		H 3		O 3	
P 4	**32-54**			K 4		N 1.4	**20-30**	S 4	**28-42**	H 4		O 4	
P 5	**12-48**			K 5		N 2	**20-48**	S 5				O 5	
						N 3.1	**20-30**	S 6				O 6	
						N 3.2	**32-48**					O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



M	P mm	l_1 mm	l_2 mm	d_2 Ø mm	a mm	l_3 mm	z	↔	l_4 mm	e-Code
3	0.50	56	9	3.5	2.7	6	4	2.80	18	**E306M3** [1]
4	0.70	63	12	4.5	3.4	6	5	3.70	21	**E306M4** [1]
5	0.80	70	13	6.0	4.9	8	5	4.60	25	**E306M5** [1]
6	1.00	80	15	6.0	4.9	8	5	5.50	30	**E306M6** [1]
8	1.25	90	18	8.0	6.2	9	5	7.40	35	**E306M8** [1]
10	1.50	100	20	10.0	8.0	11	5	9.30	39	**E306M10** [1]
12	1.75	110	23	9.0	7.0	10	5	11.20	-	**E306M12**

[1] S plochým koncem / Teljes pont / Nakiełek zewnętrzny / Punct de încheiere / Цилиндрические с плоским концом / Full point

M | DIN 2174 | 6GX | 3XD | HSS-E | C 2-3.5 | TiN

E309

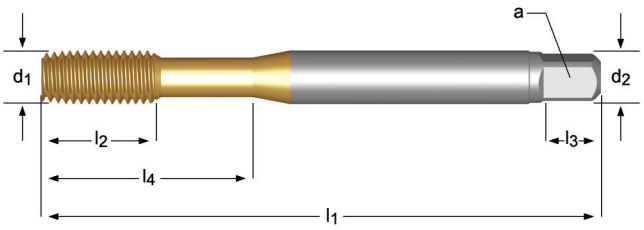
- M Strojní závitník Spectrum™ Tap bezdrážkový
- M Gépi Menetfúró Spectrum™ Tap Menetformázók
- M Gwintowygniatak bezrowkowy Spectrum™ Tap
- M Tarozi de masina Spectrum™ Tap Fara canale
- M Машинные метчики Spectrum™ Тар Без стружечной канавки
- M Machine Tap Spectrum™ Tap Fluteless

Spectrum™ Tap 400

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**32-66**	M 1	**8-22**	K 1		N 1.1	**32-48**	S 1	**16-24**	H 1		O 1	
P 2	**16-48**	M 2	**12-18**	K 2		N 1.2	**44-66**	S 2	**6-24**	H 2		O 2	
P 3	**16-48**	M 3	**8-12**	K 3		N 1.3	**20-48**	S 3		H 3		O 3	
P 4	**32-54**			K 4		N 1.4	**20-30**	S 4	**28-42**	H 4		O 4	
P 5	**8-48**			K 5		N 2	**20-48**	S 5				O 5	
						N 3.1	**20-30**	S 6				O 6	
						N 3.2	**32-48**					O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



M	P mm	l_1 mm	l_2 mm	d_2 Ø mm	◪ a mm	l_3 mm	z	↔	l_4 mm	e-Code
3	0.50	56	9	3.5	2.7	6	4	2.80	18	**E309M3** [1]
3.5	0.60	56	11	4.0	3.0	6	4	3.20	20	**E309M3.5** [1]
4	0.70	63	12	4.5	3.4	6	5	3.70	21	**E309M4** [1]
5	0.80	70	13	6.0	4.9	8	5	4.60	25	**E309M5** [1]
6	1.00	80	15	6.0	4.9	8	5	5.50	30	**E309M6** [1]
8	1.25	90	18	8.0	6.2	9	5	7.40	35	**E309M8** [1]
10	1.50	100	20	10.0	8.0	11	5	9.30	39	**E309M10** [1]
12	1.75	110	23	9.0	7.0	10	5	11.20	-	**E309M12**

[1] S plochým koncem / Teljes pont / Nakiełek zewnętrzny / Punct de încheiere / Цилиндрические с плоским концом / Full point

M | DIN 2174 | 6HX | 3XD | HSS-E | E 1.5-2 | TiN

E305

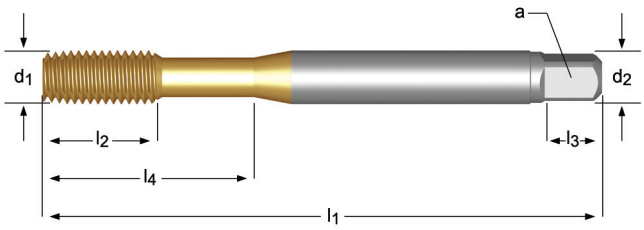
- M Strojní závitník Spectrum™ Tap bezdrážkový
- M Gépi Menetfúró Spectrum™ Tap Menetformázók
- M Gwintowygniatak bezrowkowy Spectrum™ Tap
- M Tarozi de masina Spectrum™ Tap Fara canale
- M Машинные метчики Spectrum™ Tap Без стружечной канавки
- M Machine Tap Spectrum™ Tap Fluteless

Spectrum™ Tap 400

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**32-66**	M 1	**8-22**	K 1		N 1.1	**32-48**	S 1	**16-24**	H 1		O 1	
P 2	**16-48**	M 2	**12-18**	K 2		N 1.2	**44-66**	S 2	**6-24**	H 2		O 2	
P 3	**16-48**	M 3	**8-12**	K 3		N 1.3	**20-48**	S 3		H 3		O 3	
P 4	**32-54**			K 4		N 1.4	**20-30**	S 4	**28-42**	H 4		O 4	
P 5	**8-48**			K 5		N 2	**20-48**	S 5				O 5	
						N 3.1	**20-30**	S 6				O 6	
						N 3.2	**32-48**					O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



M	P mm	l_1 mm	l_2 mm	d_2 Ø mm	a mm	l_3 mm	z	↔	l_4 mm	e-Code
3	0.50	56	9	3.5	2.7	6	4	2.80	18	**E305M3**
4	0.70	63	12	4.5	3.4	6	5	3.70	21	**E305M4**
5	0.80	70	13	6.0	4.9	8	5	4.60	25	**E305M5**
6	1.00	80	15	6.0	4.9	8	5	5.50	30	**E305M6**
8	1.25	90	18	8.0	6.2	9	5	7.40	35	**E305M8**
10	1.50	100	20	10.0	8.0	11	5	9.30	39	**E305M10**

M | DIN 2174 | 6GX | 3XD | HSS-E | E 1.5-2 | TiN

E310

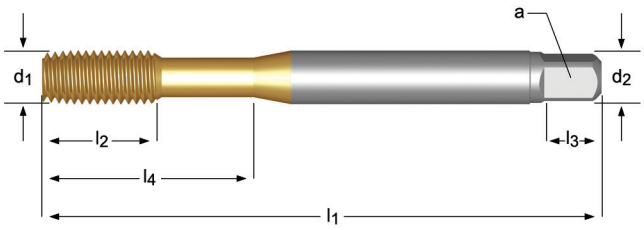
- M Strojní závitník Spectrum™ Tap bezdrážkový
- M Gépi Menetfúró Spectrum™ Tap Menetformázók
- M Gwintowygniatak bezrowkowy Spectrum™ Tap
- M Tarozi de masina Spectrum™ Tap Fara canale
- M Машинные метчики Spectrum™ Тар Без стружечной канавки
- M Machine Tap Spectrum™ Tap Fluteless

Spectrum™ Tap 400

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**32-66**	M 1	**8-22**	K 1		N 1.1	**32-48**	S 1	**16-24**	H 1		O 1	
P 2	**16-48**	M 2	**12-18**	K 2		N 1.2	**44-66**	S 2	**6-24**	H 2		O 2	
P 3	**16-48**	M 3	**8-12**	K 3		N 1.3	**20-48**	S 3		H 3		O 3	
P 4	**32-54**			K 4		N 1.4	**20-30**	S 4	**28-42**	H 4		O 4	
P 5	**8-48**			K 5		N 2	**20-48**	S 5				O 5	
						N 3.1	**20-30**	S 6				O 6	
						N 3.2	**32-48**					O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



M	P mm	l_1 mm	l_2 mm	d_2 Ø mm	a mm	l_3 mm	z	↔	l_4 mm	e-Code
3	0.50	56	9	3.5	2.7	6	4	2.80	18	**E310M3**
4	0.70	63	12	4.5	3.4	6	5	3.70	21	**E310M4**
5	0.80	70	13	6.0	4.9	8	5	4.60	25	**E310M5**
6	1.00	80	15	6.0	4.9	8	5	5.50	30	**E310M6**
8	1.25	90	18	8.0	6.2	9	5	7.40	35	**E310M8**
10	1.50	100	20	10.0	8.0	11	5	9.30	39	**E310M10**

M | DIN 2174 | 6HX | 3.5XD | HSS-E | C 2-3.5 | TiN

E308

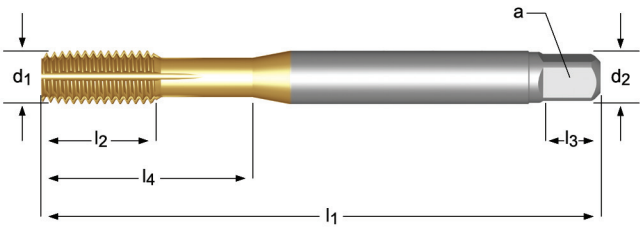
- M Strojní závitník Spectrum™ Tap bezdrážkový
- M Gépi Menetfúró Spectrum™ Tap Menetformázók
- M Gwintowygniatak bezrowkowy Spectrum™ Tap
- M Tarozi de masina Spectrum™ Tap Fara canale
- M Машинные метчики Spectrum™ Тар Без стружечной канавки
- M Machine Tap Spectrum™ Tap Fluteless

Spectrum™ Tap 400

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**32-66**	M 1	**8-22**	K 1		N 1.1	**32-48**	S 1	**16-24**	H 1		O 1	
P 2	**16-48**	M 2	**12-18**	K 2		N 1.2	**44-66**	S 2	**6-24**	H 2		O 2	
P 3	**16-48**	M 3	**8-12**	K 3		N 1.3	**20-48**	S 3		H 3		O 3	
P 4	**32-54**			K 4		N 1.4	**20-30**	S 4	**28-42**	H 4		O 4	
P 5	**8-48**			K 5		N 2	**20-48**	S 5				O 5	
						N 3.1	**20-30**	S 6				O 6	
						N 3.2	**32-48**					O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



M	P mm	l_1 mm	l_2 mm	d_2 Ø mm	◪ a mm	l_3 mm	z	↔	l_4 mm	e-Code
3	0.50	56	9	3.5	2.7	6	4	2.80	18	**E308M3** [1]
4	0.70	63	12	4.5	3.4	6	5	3.70	21	**E308M4** [1]
5	0.80	70	13	6.0	4.9	8	5	4.60	25	**E308M5** [1]
6	1.00	80	15	6.0	4.9	8	5	5.50	30	**E308M6** [1]
7	1.00	80	15	7.0	5.5	8	5	6.50	30	**E308M7** [1]
8	1.25	90	18	8.0	6.2	9	5	7.40	35	**E308M8** [1]
10	1.50	100	20	10.0	8.0	11	5	9.30	39	**E308M10** [1]
12	1.75	110	23	9.0	7.0	10	5	11.20	-	**E308M12**
14	2.00	110	25	11.0	9.0	12	6	13.00	-	**E308M14**
16	2.00	110	25	12.0	9.0	12	6	15.10	-	**E308M16**
20	2.50	140	30	16.0	12.0	15		18.90	-	**E308M20**
24	3.00	160	36	18.0	14.5	17		22.70	-	**E308M24**

[1] S plochým koncem / Teljes pont / Nakiełek zewnętrzny / Punct de încheiere / Цилиндрические с плоским концом / Full point

M | DIN 2174 | 6HX | 3.5XD | HSS-E | C 2-3.5 | TiN

E315

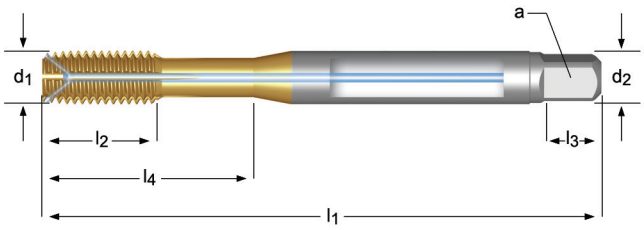
- M Strojní závitník Spectrum™ Tap bezdrážkový
- M Gépi Menetfúró Spectrum™ Tap Menetformázók
- M Gwintowygniatak bezrowkowy Spectrum™ Tap
- M Tarozi de masina Spectrum™ Tap Fara canale
- M Машинные метчики Spectrum™ Тар Без стружечной канавки
- M Machine Tap Spectrum™ Tap Fluteless

Spectrum™ Tap 400

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**32-66**	M 1	**8-22**	K 1		N 1.1	**32-48**	S 1	**16-24**	H 1		O 1	
P 2	**16-48**	M 2	**12-18**	K 2		N 1.2	**44-66**	S 2	**6-24**	H 2		O 2	
P 3	**16-48**	M 3	**8-12**	K 3		N 1.3	**20-48**	S 3		H 3		O 3	
P 4	**32-54**			K 4		N 1.4	**20-30**	S 4	**28-42**	H 4		O 4	
P 5	**8-48**			K 5		N 2	**20-48**	S 5				O 5	
						N 3.1	**20-30**	S 6				O 6	
						N 3.2	**32-48**					O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



M	P mm	l_1 mm	l_2 mm	d_2 Ø mm	a mm	l_3 mm	z	↔	l_4 mm	e-Code
5	0.80	70	13	6.0	4.9	8	5	4.60	25	**E315M5**
6	1.00	80	15	6.0	4.9	8	5	5.50	30	**E315M6**
8	1.25	90	18	8.0	6.2	9	5	7.40	35	**E315M8**
10	1.50	100	20	10.0	8.0	11	5	9.30	39	**E315M10**
12	1.75	110	23	9.0	7.0	10	5	11.20	-	**E315M12**

M | DIN ANSI | 6H | 3XD | HSS-PM | C 2-3 | TiN

E890

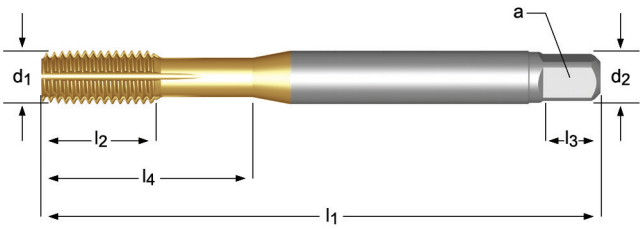
- M Strojní závitník Spectrum™ Tap bezdrážkový
- M Gépi Menetfúró Spectrum™ Tap Menetformázók
- M Gwintowygniatak bezrowkowy Spectrum™ Tap
- M Tarozi de masina Spectrum™ Tap Fara canale
- M Машинные метчики Spectrum™ Тар Без стружечной канавки
- M Machine Tap Spectrum™ Tap Fluteless

Spectrum™ Tap 400

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**32-66**	M 1	**8-22**	K 1		N 1.1	**32-48**	S 1	**16-24**	H 1		O 1	
P 2	**16-48**	M 2	**12-18**	K 2		N 1.2	**44-66**	S 2	**6-24**	H 2		O 2	
P 3	**16-48**	M 3	**8-12**	K 3		N 1.3	**20-48**	S 3		H 3		O 3	
P 4	**32-54**			K 4		N 1.4	**20-30**	S 4	**28-42**	H 4		O 4	
P 5	**8-48**			K 5		N 2	**20-48**	S 5				O 5	
						N 3.1	**20-30**	S 6				O 6	
						N 3.2	**32-48**					O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



M	P mm	l_1 inch	l_2 inch	d_2 Ø inch	⧄ a inch	z	↔	l_4 inch	↔	EDP # or Stock No.	e-Code
3	0.50	56	0.3543	0.1410	0.1100	4	2.80	0.6983	N35	0639733	**E890M3**
4	0.70	63	0.5118	0.1680	0.1310	5	3.70	0.8337	N27	0631546	**E890M4**
5	0.80	70	0.5512	0.1940	0.1520	5	4.60	1.0843	N14	0631553	**E890M5**
6	1.00	80	0.5906	0.2550	0.1910	5	5.50	0.9681	7/32	0631560	**E890M6**
8	1.25	90	0.7087	0.3180	0.2380	5	7.40	1.3060	L	0631577	**E890M8**
10	1.50	100	0.7874	0.3810	0.2860	5	9.30	1.4871	U	0631584	**E890M10**
12	1.75	110	0.9060	0.3670	0.2750	5	11.20		7/16	0631591	**E890M12**
16	2.00	110	0.9060	0.4800	0.3600	8	15.00		19/32	0631607	**E890M16**
18	2.50	125	1.1810	0.5420	0.4060	8	16.75			0631614	**E890M18**
20	2.50	140	1.4170	0.6520	0.4890	8	18.80			0631621	**E890M20**

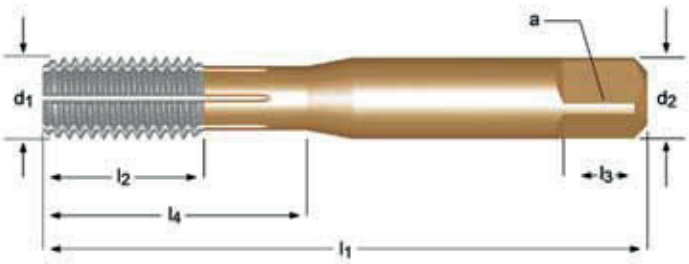
E094

- M Strojní závitník Spectrum™ Tap bezdrážkový
- M Gépi Menetfúró Spectrum™ Tap Menetformázók
- M Gwintowygniatak bezrowkowy Spectrum™ Tap
- M Tarozi de masina Spectrum™ Tap Fara canale
- M Машинные метчики Spectrum™ Тар Без стружечной канавки
- M Machine Tap Spectrum™ Tap Fluteless

Spectrum™ Tap 400

Vc[m/min]													
P		M		K		N		S		H		O	
P 1	**16-36**	M 1		K 1		N 1.1	**18-26**	S 1		H 1		O 1	
P 2	**16-24**	M 2		K 2		N 1.2	**30-46**	S 2		H 2		O 2	
P 3	**16-24**	M 3		K 3		N 1.3	**18-26**	S 3		H 3		O 3	
P 4	**16-28**			K 4		N 1.4		S 4		H 4		O 4	
P 5	**16-24**			K 5		N 2	**18-26**	S 5				O 5	
						N 3.1		S 6				O 6	
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



M	P mm	l_1 inch	l_2 inch	d_2 Ø inch	⧄ a inch	z		l_4 inch		EDP # or Stock No.	e-Code
3	0.50	2“	0.7404	0.1410	0.1100	3	N35	0.7404	2.80	0583128	**E094M3**
4	0.70	2.1/8	0.2484	0.1680	0.1310	4		0.6526	3.70	0583135	**E094M4**
5	0.80	2.3/8	0.4303	0.1940	0.1520	4	N14	0.8434	4.60	0583142	**E094M5**
6	1.00	2.1/2	0.5075	0.2550	0.1910	4	7/32	1.0073	5.50	0583159	**E094M6**
8	1.25	2.23/32	0.5939	0.3180	0.2380	5		1.1891	7.40	0583166	**E094M8**
10	1.50	2.15/16	0.6020	0.3810	0.2860	6		1.2915	9.30	0583173	**E094M10**

M | ISO 529 | 6HX | 2.5XD | HSS-PM | C 2-3

E090

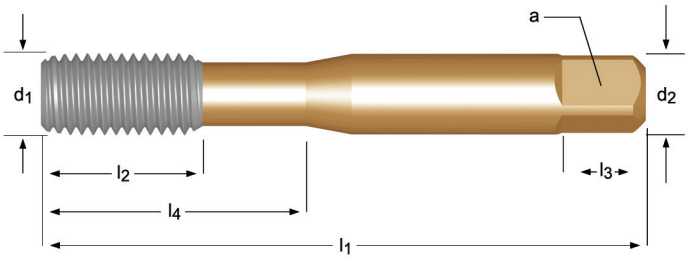
- M Strojní závitník Spectrum™ Tap bezdrážkový
- M Gépi Menetfúró Spectrum™ Tap Menetformázók
- M Gwintowygniatak bezrowkowy Spectrum™ Tap
- M Tarozi de masina Spectrum™ Tap Fara canale
- M Машинные метчики Spectrum™ Tap Без стружечной канавки
- M Machine Tap Spectrum™ Tap Fluteless

Spectrum™ Tap 400

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**16-36**	M 1		K 1		N 1.1	**18-26**	S 1		H 1		O 1	
P 2	**16-24**	M 2		K 2		N 1.2	**30-46**	S 2		H 2		O 2	
P 3	**16-24**	M 3		K 3		N 1.3	**18-26**	S 3		H 3		O 3	
P 4	**16-28**			K 4		N 1.4		S 4		H 4		O 4	
P 5	**16-24**			K 5		N 2	**18-26**	S 5				O 5	
						N 3.1		S 6				O 6	
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



M	P mm	l_1 mm	l_2 mm	d_2 Ø mm	◪ a mm	l_3 mm	↔	l_4 mm	e-Code
2	0.40	41	8	2.50	2.00	4	1.8	8	**E090M2** [1) 2)]
2.5	0.45	44.5	9.5	2.80	2.24	5	2.3	9.5	**E090M2.5** [1) 2)]
3	0.50	48	12.5	3.15	2.50	5	2.8	12.5	**E090M3** [1)]
3.5	0.60	50	14	3.55	2.80	5	3.2	14	**E090M3.5** [1)]
4	0.70	53	14	4.00	3.15	6	3.7	14	**E090M4** [1)]
5	0.80	58	11	5.00	4.00	7	4.6	22	**E090M5** [1)]
6	1.00	66	13	6.30	5.00	8	5.5	26	**E090M6** [1)]
8	1.25	72.0	16	8.00	6.30	9	7.4	29	**E090M8**
10	1.50	80.0	18	10.00	8.00	11	9.3	34	**E090M10**
12	1.75	89.0	22	9.00	7.10	10	11.2	-	**E090M12**
16	2.00	102.0	24	12.50	10.00	13	15.0	-	**E090M16**

HSS-E

[2)]

[1)] S plochým koncem / Teljes pont / Nakiełek zewnętrzny / Punct de încheiere / Цилиндрические с плоским концом / Full point

M | ISO 529 | 6HX | 2.5XD | HSS-PM | C 2-3 | TiN

E091

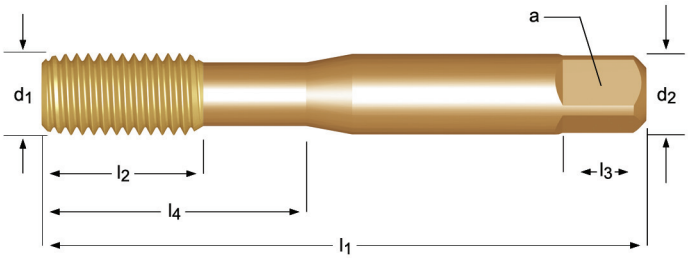
- M Strojní závitník Spectrum™ Tap bezdrážkový
- M Gépi Menetfúró Spectrum™ Tap Menetformázók
- M Gwintowygniatak bezrowkowy Spectrum™ Tap
- M Tarozi de masina Spectrum™ Tap Fara canale
- M Машинные метчики Spectrum™ Tap Без стружечной канавки
- M Machine Tap Spectrum™ Tap Fluteless

Spectrum™ Tap 400

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**32-66**	M 1	**8-22**	K 1		N 1.1	**32-48**	S 1	**16-24**	H 1		O 1	
P 2	**16-48**	M 2	**12-18**	K 2		N 1.2	**44-66**	S 2	**6-24**	H 2		O 2	
P 3	**16-48**	M 3	**8-12**	K 3		N 1.3	**20-48**	S 3		H 3		O 3	
P 4	**32-54**			K 4		N 1.4	**20-30**	S 4	**28-42**	H 4		O 4	
P 5	**8-48**			K 5		N 2	**20-48**	S 5				O 5	
						N 3.1	**20-30**	S 6				O 6	
						N 3.2	**32-48**					O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



M	P mm	l_1 mm	l_2 mm	d_2 Ø mm	◪ a mm	l_3 mm	↔	l_4 mm	e-Code
2	0.40	41	8	2.50	2.00	4	1.8	8	**E091M2** [1) 2)]
2.5	0.45	44.5	9.5	2.80	2.24	5	2.3	9.5	**E091M2.5** [1) 2)]
3	0.50	48	12.5	3.15	2.50	5	2.8	12.5	**E091M3** [1)]
3.5	0.60	50	14	3.55	2.80	5	3.2	14	**E091M3.5** [1)]
4	0.70	53	14	4.00	3.15	6	3.7	14	**E091M4** [1)]
5	0.80	58	11	5.00	4.00	7	4.6	22	**E091M5** [1)]
6	1.00	66	13	6.30	5.00	8	5.5	26	**E091M6** [1)]
8	1.25	72	16	8.00	6.30	9	7.4	29	**E091M8**
10	1.50	80	18	10.00	8.00	11	9.3	34	**E091M10**
12	1.75	89	22	9.00	7.10	10	11.2		**E091M12**
16	2.00	102	24	12.50	10.00	13	15		**E091M16**

HSS-E

[2)]

[1)] S plochým koncem / Teljes pont / Nakiełek zewnętrzny / Punct de încheiere / Цилиндрические с плоским концом / Full point

M | ISO 529 | 6HX | 2.5XD | HSS-PM | C 2-3 | TiN

E096

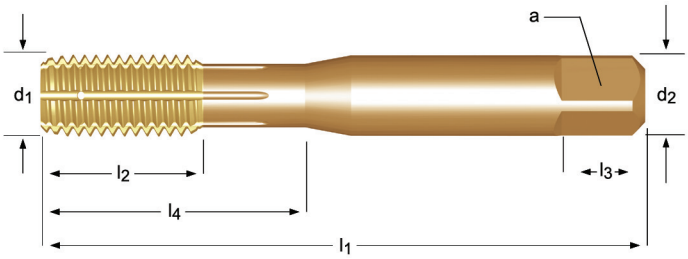
- M Strojní závitník Spectrum™ Tap bezdrážkový
- M Gépi Menetfúró Spectrum™ Tap Menetformázók
- M Gwintowygniatak bezrowkowy Spectrum™ Tap
- M Tarozi de masina Spectrum™ Tap Fara canale
- M Машинные метчики Spectrum™ Tap Без стружечной канавки
- M Machine Tap Spectrum™ Tap Fluteless

Spectrum™ Tap 400

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**32-66**	M 1	**8-22**	K 1		N 1.1	**32-48**	S 1	**16-24**	H 1		O 1	
P 2	**16-48**	M 2	**12-18**	K 2		N 1.2	**44-66**	S 2	**6-24**	H 2		O 2	
P 3	**16-48**	M 3	**8-12**	K 3		N 1.3	**20-48**	S 3		H 3		O 3	
P 4	**32-54**			K 4		N 1.4	**20-30**	S 4	**28-42**	H 4		O 4	
P 5	**8-48**			K 5		N 2	**20-48**	S 5				O 5	
						N 3.1	**20-30**	S 6				O 6	
						N 3.2	**32-48**					O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



M	P mm	l_1 mm	l_2 mm	d_2 Ø mm	⧄ a mm	l_3 mm	↔	l_4 mm	e-Code
3	0.50	48	12.5	3.15	2.50	5	2.8	12.5	**E096M3** [1]
4	0.70	53	14	4.00	3.15	6	3.7	14	**E096M4** [1]
5	0.80	58	11	5.00	4.00	7	4.6	22	**E096M5** [1]
6	1.00	66	13	6.30	5.00	8	5.5	26	**E096M6** [1]
8	1.25	72	16	8.00	6.30	9	7.4	29	**E096M8**
10	1.50	80	18	10.00	8.00	11	9.3	34	**E096M10**
12	1.75	89	22	9.00	7.10	10	11.2		**E096M12**
16	2.00	102	24	12.50	10.00	13	15		**E096M16**

[1] S plochým koncem / Teljes pont / Nakiełek zewnętrzny / Punct de încheiere / Цилиндрические с плоским концом / Full point

M | ISO 529 | 6HX | 2.5XD | HSS-PM | C 2-3 | CrN

E097

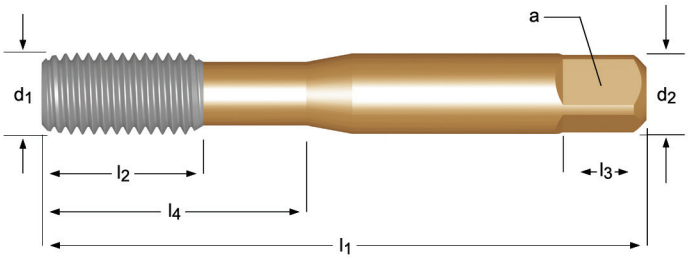
- M Strojní závitník Spectrum™ Tap bezdrážkový
- M Gépi Menetfúró Spectrum™ Tap Menetformázók
- M Gwintowygniatak bezrowkowy Spectrum™ Tap
- M Tarozi de masina Spectrum™ Tap Fara canale
- M Машинные метчики Spectrum™ Тар Без стружечной канавки
- M Machine Tap Spectrum™ Tap Fluteless

Spectrum™ Tap 400

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**32-66**	M 1	**12-22**	K 1		N 1.1	**32-48**	S 1	**16-24**	H 1		O 1	
P 2	**32-48**	M 2	**12-18**	K 2		N 1.2	**44-66**	S 2	**6-24**	H 2		O 2	
P 3	**32-48**	M 3		K 3		N 1.3	**20-48**	S 3		H 3		O 3	
P 4	**32-54**			K 4		N 1.4	**20-30**	S 4	**28-42**	H 4		O 4	
P 5	**12-48**			K 5		N 2	**20-48**	S 5				O 5	
						N 3.1	**20-30**	S 6				O 6	
						N 3.2	**32-48**					O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



M	P mm	l_1 mm	l_2 mm	d_2 Ø mm	a mm	l_3 mm	↔	l_4 mm	e-Code	
2	0.40	41	8	2.50	2.00	4	1.8	8	**E097M2**	1) 2)
2.5	0.45	44.5	9.5	2.80	2.24	5	2.3	9.5	**E097M2.5**	1) 2)
3	0.50	48	12.5	3.15	2.50	5	2.8	12.5	**E097M3**	1)
4	0.70	53	14	4.00	3.15	6	3.7	14	**E097M4**	1)
5	0.80	58	11	5.00	4.00	7	4.6	22	**E097M5**	1)
6	1.00	66	13	6.30	5.00	8	5.5	26	**E097M6**	1)
8	1.25	72.0	16	8.00	6.30	9	7.4	29	**E097M8**	
10	1.50	80.0	18	10.00	8.00	11	9.3	34	**E097M10**	
12	1.75	89.0	22	9.00	7.10	10	11.2		**E097M12**	
16	2.00	102.0	24	12.50	10.00	13	15		**E097M16**	

HSS-E

2)

1) S plochým koncem / Teljes pont / Nakiełek zewnętrzny / Punct de încheiere / Цилиндрические с плоским концом / Full point

M | ISO 529 | 6HX | 3XD | HSS-PM | C 2-3 | TiN

E099

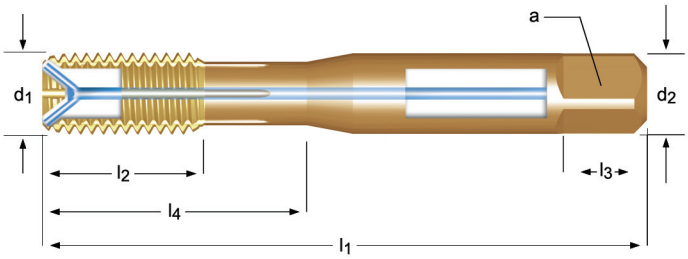
- M Strojní závitník Spectrum™ Tap bezdrážkový
- M Gépi Menetfúró Spectrum™ Tap Menetformázók
- M Gwintowygniatak bezrowkowy Spectrum™ Tap
- M Tarozi de masina Spectrum™ Tap Fara canale
- M Машинные метчики Spectrum™ Тар Без стружечной канавки
- M Machine Tap Spectrum™ Tap Fluteless

Spectrum™ Tap 400

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**32-66**	M 1	**8-22**	K 1		N 1.1	**32-48**	S 1	**16-24**	H 1		O 1	
P 2	**16-48**	M 2	**12-18**	K 2		N 1.2	**44-66**	S 2	**6-24**	H 2		O 2	
P 3	**16-48**	M 3	**8-12**	K 3		N 1.3	**20-48**	S 3		H 3		O 3	
P 4	**32-54**			K 4		N 1.4	**20-30**	S 4	**28-42**	H 4		O 4	
P 5	**8-48**			K 5		N 2	**20-48**	S 5				O 5	
						N 3.1	**20-30**	S 6				O 6	
						N 3.2	**32-48**					O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



M	P mm	l_1 mm	l_2 mm	d_2 Ø mm	⧄ a mm	l_3 mm	↔	l_4 mm	e-Code
4	0.70	53	14	4.00	3.15	6	3.7	14	**E099M4** [1]
5	0.80	58	11	5.00	4.00	7	4.6	22	**E099M5** [1]
6	1.00	66	13	6.30	5.00	8	5.5	26	**E099M6** [1]
8	1.25	72	16	8.00	6.30	9	7.4	29	**E099M8**
10	1.50	80	18	10.00	8.00	11	9.3	34	**E099M10**
12	1.75	89	22	9.00	7.10	10	11.2		**E099M12**
16	2.00	102	24	12.50	10.00	13	15		**E099M16**

[1] S plochým koncem / Teljes pont / Nakiełek zewnętrzny / Punct de încheiere / Цилиндрические с плоским концом / Full point

MF | DIN 2174 | 6HX | 3XD | HSS-E | C 2-3.5 | TiN

E317

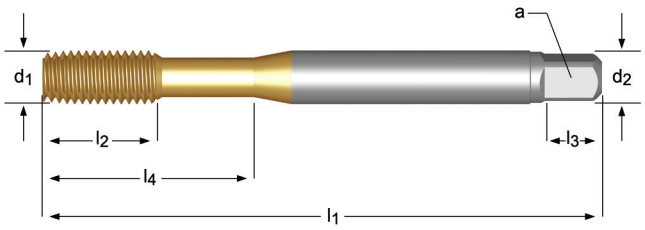
- MF Strojní závitník Spectrum™ Tap bezdrážkový
- MF Gépi Menetfúró Spectrum™ Tap Menetformázók
- MF Gwintowygniatak bezrowkowy Spectrum™ Tap
- MF Tarozi de masina Spectrum™ Tap Fara canale
- MF Машинные метчики Spectrum™ Tap Без стружечной канавки
- MF Machine Tap Spectrum™ Tap Fluteless

Spectrum™ Tap 400

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**32-66**	M 1	**8-22**	K 1		N 1.1	**32-48**	S 1	**16-24**	H 1		O 1	
P 2	**16-48**	M 2	**12-18**	K 2		N 1.2	**44-66**	S 2	**6-24**	H 2		O 2	
P 3	**16-48**	M 3	**8-12**	K 3		N 1.3	**20-48**	S 3		H 3		O 3	
P 4	**32-54**			K 4		N 1.4	**20-30**	S 4	**28-42**	H 4		O 4	
P 5	**8-48**			K 5		N 2	**20-48**	S 5				O 5	
						N 3.1	**20-30**	S 6				O 6	
						N 3.2	**32-48**					O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



MF	P mm	l_1 mm	l_2 mm	d_2 Ø mm	◪ a mm	l_3 mm	z	↔	l_4 mm	e-Code
5	0.50	70	13	6.0	4.9	8	5	4.80	25	**E317M5X0.5** [1]
6	0.75	80	15	6.0	4.9	8	5	5.70	30	**E317M6X0.75** [1]
7	0.75	80	15	7.0	5.5	8	5	6.70	30	**E317M7X0.75** [1]
8	0.75	80	15	6.0	4.9	8	5	7.70		**E317M8X.75** [1]
8	1.00	90	18	6.0	4.9	8	5	7.50		**E317M8X1** [1]
10	1.00	90	20	7.0	5.5	8	5	9.50		**E317M10X1** [1]
10	1.25	100	20	7.0	5.5	8	5	9.40		**E317M10X1.25** [1]
12	1.00	100	21	9.0	7.0	10	5	11.50		**E317M12X1**
12	1.25	100	21	9.0	7.0	10	5	11.40		**E317M12X1.25**
12	1.50	100	21	9.0	7.0	10	5	11.30		**E317M12X1.5**
14	1.00	100	21	11.0	9.0	12	6	13.50		**E317M14X1**
14	1.25	100	21	11.0	9.0	12	6	13.40		**E317M14X1.25**
14	1.50	100	21	11.0	9.0	12	6	13.30		**E317M14X1.5**
16	1.50	100	21	12.0	9.0	12	6	15.25		**E317M16X1.5**

[1] S plochým koncem / Teljes pont / Nakiełek zewnętrzny / Punct de încheiere / Цилиндрические с плоским концом / Full point

MF | DIN ANSI | 6H | 3XD | HSS-PM | C 2-3 | TiN

E891

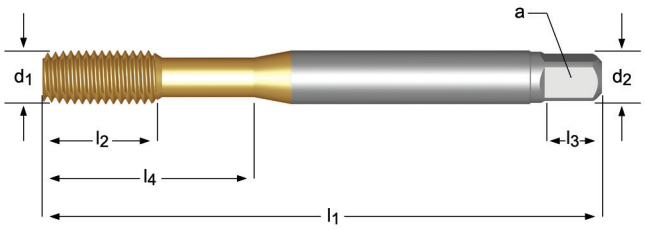
- MF Strojní závitník Spectrum™ Tap bezdrážkový
- MF Gépi Menetfúró Spectrum™ Tap Menetformázók
- MF Gwintowygniatak bezrowkowy Spectrum™ Tap
- MF Tarozi de masina Spectrum™ Tap Fara canale
- MF Машинные метчики Spectrum™ Tap Без стружечной канавки
- MF Machine Tap Spectrum™ Tap Fluteless

Spectrum™ Tap 400

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**32-66**	M 1	**8-22**	K 1		N 1.1	**32-48**	S 1	**16-24**	H 1		O 1	
P 2	**16-48**	M 2	**12-18**	K 2		N 1.2	**44-66**	S 2	**6-24**	H 2		O 2	
P 3	**16-48**	M 3	**8-12**	K 3		N 1.3	**20-48**	S 3		H 3		O 3	
P 4	**32-54**			K 4		N 1.4	**20-30**	S 4	**28-42**	H 4		O 4	
P 5	**8-48**			K 5		N 2	**20-48**	S 5				O 5	
						N 3.1	**20-30**	S 6				O 6	
						N 3.2	**32-48**					O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



MF	P mm	l_1 inch	l_2 inch	d_2 Ø inch	⧄ a inch	z	↔	l_4 inch	↔	EDP # or Stock No.	e-Code
10	1.25	100	0.7874	0.3810	0.2860	5	9.40	1.4871	U	0631638	**E891M10X1.25**
12	1.50	110	0.9060	0.3670	0.2750	5	11.20			0631645	**E891M12X1.5**

UNC ANSI 2B 2.5XD HSS-PM C 2-3

E064

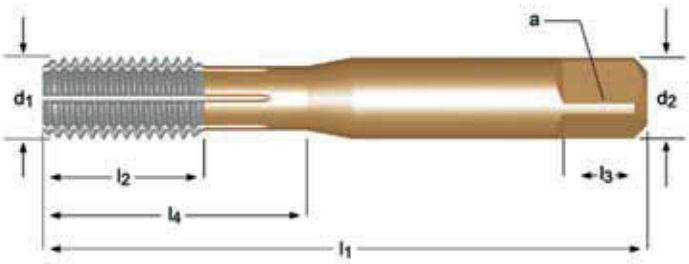
- MF Strojní závitník Spectrum™ Tap bezdrážkový
- MF Gépi Menetfúró Spectrum™ Tap Menetformázók
- MF Gwintowygniatak bezrowkowy Spectrum™ Tap
- MF Tarozi de masina Spectrum™ Tap Fara canale
- MF Машинные метчики Spectrum™ Tap Без стружечной канавки
- MF Machine Tap Spectrum™ Tap Fluteless

Spectrum™ Tap 400

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**16-36**	M 1		K 1		N 1.1	**18-26**	S 1		H 1		O 1	
P 2	**16-24**	M 2		K 2		N 1.2	**30-46**	S 2		H 2		O 2	
P 3	**16-24**	M 3		K 3		N 1.3	**18-26**	S 3		H 3		O 3	
P 4	**16-28**			K 4		N 1.4		S 4		H 4		O 4	
P 5	**16-24**			K 5		N 2	**18-26**	S 5				O 5	
						N 3.1		S 6				O 6	
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



UNC	TPI	l_1 inch	l_2 inch	d_2 Ø inch	⧄ a inch	z	↔	l_4 inch	↔	EDP # or Stock No.	e-Code
4	40	1.7/8	0.6091	0.1410	0.1100	3	N39	0.6091	2.60	0582633	**E0644-40**
6	32	2“	0.2610	0.1410	0.1100	3	1/8	0.5938	3.20	0582640	**E0646-32**
8	32	2.1/8	0.2484	0.1680	0.1310	3	N25	0.6526	3.80	0582657	**E0648-32**
10	24	2.3/8	0.4303	0.1940	0.1520	4	11/64	0.8434	4.40	0582664	**E06410-24**
12	24	2.3/8	0.4173	0.2200	0.1650	4	N9	0.8848	5.00	0582671	**E06412-24**
1/4	20	2.1/2	0.5075	0.2550	0.1910	4		1.0073	5.80	0582688	**E0641/4**
5/16	18	2.23/32	0.5939	0.3180	0.2380	5		1.1891	7.30	0582695	**E0645/16**
3/8	16	2.15/16	0.6020	0.3810	0.2860	6	11/32	1.2915	8.80	0582701	**E0643/8**

UNC | DIN ANSI | 2B | 3XD | HSS-PM | C 2-3 | TiN

E892

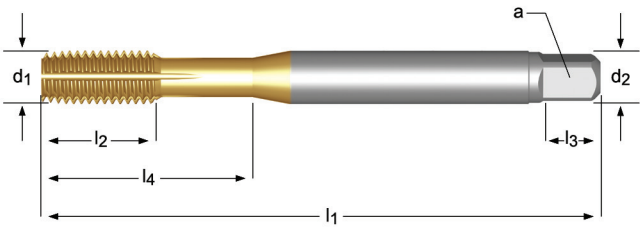
- UNC Strojní závitník Spectrum™ Tap bezdrážkový
- UNC Gépi Menetfúró Spectrum™ Tap Menetformázók
- UNC Gwintowygniatak bezrowkowy Spectrum™ Tap
- UNC Tarozi de masina Spectrum™ Tap Fara canale
- UNC Машинные метчики Spectrum™ Tap Без стружечной канавки
- UNC Machine Tap Spectrum™ Tap Fluteless

Spectrum™ Tap 400

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**32-66**	M 1	**8-22**	K 1		N 1.1	**32-48**	S 1	**16-24**	H 1		O 1	
P 2	**16-48**	M 2	**12-18**	K 2		N 1.2	**44-66**	S 2	**6-24**	H 2		O 2	
P 3	**16-48**	M 3	**8-12**	K 3		N 1.3	**20-48**	S 3		H 3		O 3	
P 4	**32-54**			K 4		N 1.4	**20-30**	S 4	**28-42**	H 4		O 4	
P 5	**8-48**			K 5		N 2	**20-48**	S 5				O 5	
						N 3.1	**20-30**	S 6				O 6	
						N 3.2	**32-48**					O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



UNC	TPI	l_1 mm	l_2 Inch	d_2 Ø Inch /	⧄ a Inch	z	↔	↔	l_4 Inch	e-Code
4	40	56	0.3543	0.1410	0.1100	4	N39	2.60	0.6681	**E8924-40**
6	32	56	0.4331	0.1410	0.1100	5	1/8	3.20	0.7954	**E8926-32**
8	32	63	0.5118	0.1680	0.1310	5	N25	3.80	0.8337	**E8928-32**
10	24	70	0.5512	0.1940	0.1520	5	11/64	4.40	1.0843	**E89210-24**
12	24	80	0.5910	0.2200	0.1650	5	N9	5.00	1.0059	**E89212-24**
1/4	20	80	0.5906	0.2550	0.1910	5		5.80	0.9681	**E8921/4**
5/16	18	90	0.7087	0.3180	0.2380	5		7.30	1.3060	**E8925/16**
3/8	16	100	0.7874	0.3810	0.2860	5	11/32	8.80	1.4871	**E8923/8**
7/16	14	100	0.7870	0.3230	0.2420	5	Y	10.30		**E8927/16**
1/2	13	110	0.9060	0.3670	0.2750	6	15/32	11.90		**E8921/2**
5/8	11	110	0.9060	0.4800	0.3600	6	37/64	14.80		**E8925/8**
3/4	10	125	1.1810	0.5900	0.4420	7	45/64	17.90		**E8923/4**
7/8	9	140	1.3386	0.6900	0.5230	8		21.00		**E8927/8-9**
1“	8	160	1.4961	0.8000	0.6000	8	61/64	24.00		**E8921**

UNC | ISO 529 | 2BX | 2.5XD | HSS | C 2-3

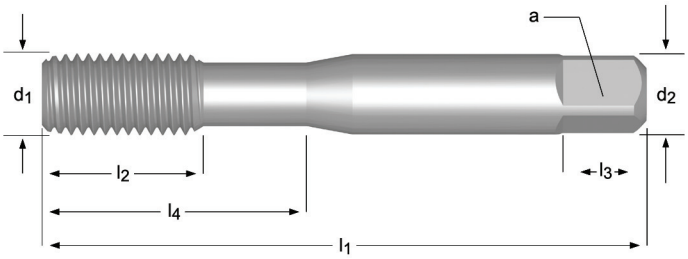
E523

- UNC Strojní závitník Spectrum™ Tap bezdrážkový
- UNC Gépi Menetfúró Spectrum™ Tap Menetformázók
- UNC Gwintowygniatak bezrowkowy Spectrum™ Tap
- UNC Tarozi de masina Spectrum™ Tap Fara canale
- UNC Машинные метчики Spectrum™ Tap Без стружечной канавки
- UNC Machine Tap Spectrum™ Tap Fluteless

Spectrum™ Tap 400

Vc[m/min]													
P		M		K		N		S		H		O	
P 1	**16-36**	M 1		K 1		N 1.1	**18-26**	S 1		H 1		O 1	
P 2	**16-24**	M 2		K 2		N 1.2	**30-46**	S 2		H 2		O 2	
P 3	**16-24**	M 3		K 3		N 1.3	**18-26**	S 3		H 3		O 3	
P 4	**16-28**			K 4		N 1.4		S 4		H 4		O 4	
P 5	**16-24**			K 5		N 2	**18-26**	S 5				O 5	
						N 3.1		S 6				O 6	
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



UNC	TPI	d_1 nom mm	l_1 mm	l_2 mm	d_2 Ø mm	⧄ a mm	l_3 mm	↔	l_4 mm	e-Code
4	40	2.845	48	12.5	3.15	2.50	5	2.6	12.5	**E5234-40BRIGHT** [1]
6	32	3.505	50	14	3.55	2.80	5	3.2	14	**E5236-32BRIGHT** [1]
8	32	4.166	53	9.5	4.50	3.55	6	3.8	18	**E5238-32BRIGHT** [1]
10	24	4.826	58	11	5.00	4.00	7	4.4	20	**E52310-24BRIGHT** [1]
1/4	20	6.350	66	13	6.30	5.00	8	5.8	26	**E5231/4BRIGHT** [1]
5/16	18	7.938	72	16	8.00	6.30	9	7.3	29	**E5235/16BRIGHT**
3/8	16	9.525	80	18	10.00	8.00	11	8.8	32	**E5233/8BRIGHT**

[1] S plochým koncem / Teljes pont / Nakiełek zewnętrzny / Punct de încheiere / Цилиндрические с плоским концом / Full point

UNC | ISO 529 | 2BX | 2.5XD | HSS | C 2-3 | CrN

E596

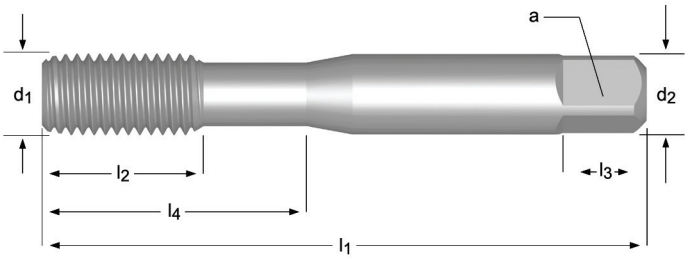
- UNC Strojní závitník Spectrum™ Tap bezdrážkový
- UNC Gépi Menetfúró Spectrum™ Tap Menetformázók
- UNC Gwintowygniatak bezrowkowy Spectrum™ Tap
- UNC Tarozi de masina Spectrum™ Tap Fara canale
- UNC Машинные метчики Spectrum™ Tap Без стружечной канавки
- UNC Machine Tap Spectrum™ Tap Fluteless

Spectrum™ Tap 400

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**32-66**	M 1	**12-22**	K 1		N 1.1	**32-48**	S 1	**16-24**	H 1		O 1	
P 2	**32-48**	M 2	**12-18**	K 2		N 1.2	**44-66**	S 2	**6-24**	H 2		O 2	
P 3	**32-48**	M 3		K 3		N 1.3	**20-48**	S 3		H 3		O 3	
P 4	**32-54**			K 4		N 1.4	**20-30**	S 4	**28-42**	H 4		O 4	
P 5	**12-48**			K 5		N 2	**20-48**	S 5				O 5	
						N 3.1	**20-30**	S 6				O 6	
						N 3.2	**32-48**					O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



UNC	TPI	d_1 nom mm	l_1 mm	l_2 mm	d_2 Ø mm	◪ a mm	l_3 mm	↔	l_4 mm	e-Code
4	40	2.845	48	12.5	3.15	2.50	5	2.6	12.5	**E5964-40** [1]
6	32	3.505	50	14	3.55	2.80	5	3.2	14	**E5966-32** [1]
8	32	4.166	53	9.5	4.50	3.55	6	3.8	18	**E5968-32** [1]
10	24	4.826	58	11	5.00	4.00	7	4.4	20	**E59610-24** [1]
1/4	20	6.350	66	13	6.30	5.00	8	5.8	26	**E5961/4** [1]
5/16	18	7.938	72	16	8.00	6.30	9	7.3	29	**E5965/16**
3/8	16	9.525	80	18	10.00	8.00	11	8.8	32	**E5963/8**

[1] S plochým koncem / Teljes pont / Nakiełek zewnętrzny / Punct de încheiere / Цилиндрические с плоским концом / Full point

UNC ANSI 2B 2.5XD HSS-PM C 2-3

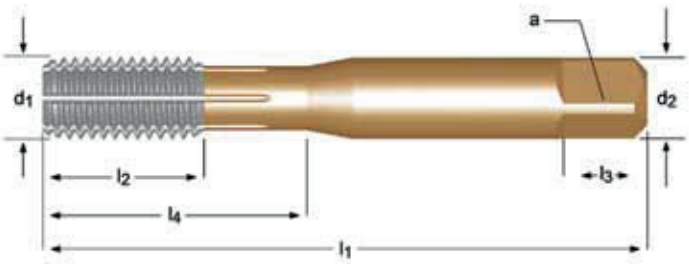
E074

- UNC Strojní závitník Spectrum™ Tap bezdrážkový
- UNC Gépi Menetfúró Spectrum™ Tap Menetformázók
- UNC Gwintowygniatak bezrowkowy Spectrum™ Tap
- UNC Tarozi de masina Spectrum™ Tap Fara canale
- UNC Машинные метчики Spectrum™ Tap Без стружечной канавки
- UNC Machine Tap Spectrum™ Tap Fluteless

Spectrum™ Tap 400

Vc[m/min]													
P		M		K		N		S		H		O	
P 1	**16-36**	M 1		K 1		N 1.1	**18-26**	S 1		H 1		O 1	
P 2	**16-24**	M 2		K 2		N 1.2	**30-46**	S 2		H 2		O 2	
P 3	**16-24**	M 3		K 3		N 1.3	**18-26**	S 3		H 3		O 3	
P 4	**16-28**			K 4		N 1.4		S 4		H 4		O 4	
P 5	**16-24**			K 5		N 2	**18-26**	S 5				O 5	
						N 3.1		S 6				O 6	
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



UNF	TPI	l_1 inch	l_2 inch	d_2 Ø inch	⧄ a inch	z		l_4 inch		EDP # or Stock No.	e-Code
10	32	2.3/8	0.4303	0.1940	0.1520	4	N16	0.8434	4.50	0582879	**E07410-32**
1/4	28	2.1/2	0.5075	0.2550	0.1910	4	A	1.0073	6.00	0582886	**E0741/4**
5/16	24	2.23/32	0.5939	0.3180	0.2380	5	M	1.1891	7.50	0582893	**E0745/16**
3/8	24	2.15/16	0.6020	0.3810	0.2860	6	T	1.2915	9.10	0582909	**E0743/8**

UNF | DIN ANSI | 2B | 3XD | HSS-PM | C 2-3 | TiN

E893

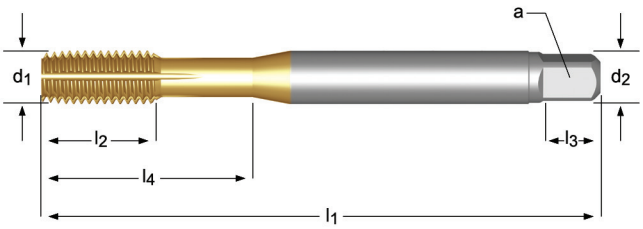
- UNF Strojní závitník Spectrum™ Tap bezdrážkový
- UNF Gépi Menetfúró Spectrum™ Tap Menetformázók
- UNF Gwintowygniatak bezrowkowy Spectrum™ Tap
- UNF Tarozi de masina Spectrum™ Tap Fara canale
- UNF Машинные метчики Spectrum™ Тар Без стружечной канавки
- UNF Machine Tap Spectrum™ Tap Fluteless

Spectrum™ Tap 400

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**32-66**	M 1	**8-22**	K 1		N 1.1	**32-48**	S 1	**16-24**	H 1		O 1	
P 2	**16-48**	M 2	**12-18**	K 2		N 1.2	**44-66**	S 2	**6-24**	H 2		O 2	
P 3	**16-48**	M 3	**8-12**	K 3		N 1.3	**20-48**	S 3		H 3		O 3	
P 4	**32-54**			K 4		N 1.4	**20-30**	S 4	**28-42**	H 4		O 4	
P 5	**8-48**			K 5		N 2	**20-48**	S 5				O 5	
						N 3.1	**20-30**	S 6				O 6	
						N 3.2	**32-48**					O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



UNF	TPI	l_1 mm	l_2 Inch	d_2 Ø Inch /	⧄ a Inch	z	↔	↔	l_4 Inch	e-Code
10	32	70	0.5512	0.1940	0.1520	5	4.50	N16	1.0843	**E89310-32**
1/4	28	80	0.5906	0.2550	0.1910	5	6.00	A	0.9681	**E8931/4**
5/16	24	90	0.7087	0.3180	0.2380	5	7.50	M	1.3060	**E8935/16**
3/8	24	100	0.7874	0.3810	0.2860	5	9.10	T	1.4871	**E8933/8**
7/16	20	100	0.7870	0.3230	0.2420	5	10.60	Z		**E8937/16**
1/2	20	110	0.9060	0.3670	0.2750	6	12.10			**E8931/2**
5/8	18	110	0.9060	0.4800	0.3600	6	15.30	39/64		**E8935/8**
3/4	16	125	1.1810	0.5900	0.4420	7	18.30	23/32		**E8933/4**
1“	12	160	1.4170	0.8000	0.6000	8	24.00	61/64		**E8931**

UNF | ISO 529 | 2BX | 2.5XD | HSS | C 2-3

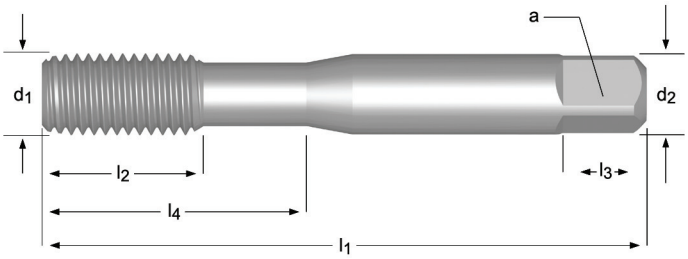
E530

- UNF Strojní závitník Spectrum™ Tap bezdrážkový
- UNF Gépi Menetfúró Spectrum™ Tap Menetformázók
- UNF Gwintowygniatak bezrowkowy Spectrum™ Tap
- UNF Tarozi de masina Spectrum™ Tap Fara canale
- UNF Машинные метчики Spectrum™ Tap Без стружечной канавки
- UNF Machine Tap Spectrum™ Tap Fluteless

Spectrum™ Tap 400

Vc[m/min]													
P		M		K		N		S		H		O	
P 1	**16-36**	M 1		K 1		N 1.1	**18-26**	S 1		H 1		O 1	
P 2	**16-24**	M 2		K 2		N 1.2	**30-46**	S 2		H 2		O 2	
P 3	**16-24**	M 3		K 3		N 1.3	**18-26**	S 3		H 3		O 3	
P 4	**16-28**			K 4		N 1.4		S 4		H 4		O 4	
P 5	**16-24**			K 5		N 2	**18-26**	S 5				O 5	
						N 3.1		S 6				O 6	
						N 3.2						O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



UNF	TPI	d_1 nom mm	l_1 mm	l_2 mm	d_2 Ø mm	⧄ a mm	l_3 mm	↔	l_4 mm	e-Code
10	32	4.826	58	11	5.00	4.00	7	4.5	20	**E53010-32BRIGHT** [1]
1/4	28	6.350	66	13	6.30	5.00	8	6	26	**E5301/4BRIGHT** [1]
5/16	24	7.938	72	16	8.00	8.00	9	7.5	29	**E5305/16BRIGHT**
3/8	24	9.525	80	18	10.00	10.00	11	9.1	32	**E5303/8BRIGHT**
7/16	20	11.112	85	19	8.00	8.00	9	10.6		**E5307/16BRIGHT**

[1] S plochým koncem / Teljes pont / Nakiełek zewnętrzny / Punct de încheiere / Цилиндрические с плоским концом / Full point

EGM Insert | DIN 40435 | 6H mod. | 3XD | HSS-E | C 2-3.5 | TiN

E323

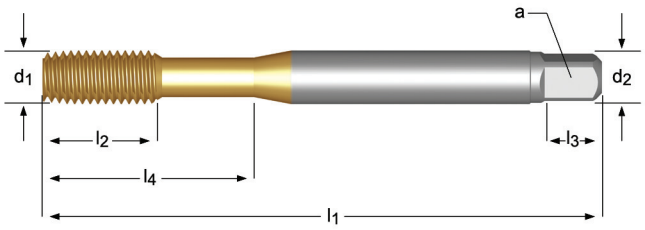
- EGM Maskingängtappar Spectrum™ Tap Pressgängtappar
- EGM Konekierretapit Spectrum™ Tap Manglaavat kierretapit
- EGM Machine Tap Spectrum™ Tap Fluteless
- EGM Spectrum™ Tap Maschi a macchina Rullare
- EGM Machinetappen Spectrum™ Tap Roltappen
- EGM Maskingevindtappe Spectrum™ Tap Rullegevindtappe

Spectrum™ Tap 400

Vc[m/min]

P		M		K		N		S		H		O	
P 1	**32-66**	M 1	**8-22**	K 1		N 1.1	**32-48**	S 1	**16-24**	H 1		O 1	
P 2	**16-48**	M 2	**12-18**	K 2		N 1.2	**44-66**	S 2	**6-24**	H 2		O 2	
P 3	**16-48**	M 3	**8-12**	K 3		N 1.3	**20-48**	S 3		H 3		O 3	
P 4	**32-54**			K 4		N 1.4	**20-30**	S 4	**28-42**	H 4		O 4	
P 5	**8-48**			K 5		N 2	**20-48**	S 5				O 5	
						N 3.1	**20-30**	S 6				O 6	
						N 3.2	**32-48**					O 7	
						N 3.3							
						N 3.4							
						N 4							

$$n = \frac{Vc \times 1000}{\pi \times D}$$



EGM	P mm	l_1 mm	l_2 mm	d_2 Ø mm	◪ a mm	l_3 mm	z	↔	l_4 mm	e-Code
3	0.50	63	12	4.5	3.4	6	4	3.40	21	**E323M3** [1]
4	0.70	70	13	6.0	4.9	8	4	4.60	25	**E323M4** [1]
5	0.80	80	15	6.0	4.9	8	4	5.70	30	**E323M5** [1]
6	1.00	90	18	8.0	6.2	9	5	6.80	35	**E323M6** [1]
8	1.25	100	20	10.0	8	11	5	9.10	39	**E323M8** [1]
10	1.50	100	21	9.0	7	10	5	11.30	-	**E323M10**
12	1.75	110	25	11.0	9	12	6	13.50	-	**E323M12**

[1] Full spets / Täysi kartio / Full point / Punto intero / Full Point / Full point

ŘEZÁNÍ ZÁVITŮ

VŠEOBECNÁ DOPORUČENÍ PRO ŘEZÁNÍ ZÁVITŮ

Úspěch každé závitořezné operace závisí na řadě různých faktorů, které společně ovlivňují výslednou kvalitu výrobku.

1. Podle materiálu obráběné součásti a typu díry, např. průchozí nebo slepé, zvolte s pomocí tabulky klasifikace materiálů vhodný typ závitníku.
2. Dbejte na to, aby součást byla řádně upnuta - při pohybu do stran se závitník může zlomit nebo kvalita závitů může být špatná.
3. Podle katalogu určete správnou velikost vrtáku. Mějte na paměti, že velikosti vrtáků pro tvářecí závitníky (bez drážky) jsou jiné. Dbejte na to, aby nežádoucí mechanické zpevnění materiálu součásti bylo minimální.
4. Pomocí katalogu nebo aplikace CoroGuide zvolte správnou řeznou rychlost.
5. Použijte vhodný typ řezné kapaliny odpovídající dané operaci.
6. Zajistěte plynulý vstup závitníku do díry, v důsledku nerovnoměrného posuvu může dojít k poškození okraje díry.

TŘÍDY ZÁVITNÍKŮ 2B & 3B: PALCOVÉ UN ZÁVITY

	TPI, počet závitů na palec		Limity závitníků	
Velikost	**UNC**	**UNF**	**Třída 2B**	**Třída 3B**
0		80	H2	H1
1	64		H2	H1
1		72	H2	H1
2	56		H2	H1
2		64	H2	H1
3	48		H2	H1
3		56	H2	H1
4	40		H2	H2
4		48	H2	H1
5	40		H2	H2
5		44	H2	H1
6	32		H3	H2
6		40	H2	H2
8	32		H3	H2
8		36	H2	H2
10	24		H3	H3
10		32	H3	H2
12	24		H3	H3
12		28	H3	H3
1/4	20		H5	H3
1/4		28	H4	H3
5/16	18		H5	H3
5/16		24	H4	H3
3/8	16		H5	H3

	TPI, počet závitů na palec		Limity závitníků	
Velikost	**UNC**	**UNF**	**Třída 2B**	**Třída 3B**
3/8		24	H4	H3
7/16	14		H5	H3
7/16		20	H5	H3
1/2	13		H5	H3
1/2		20	H5	H3
9/16	12		H5	H3
9/16		18	H5	H3
5/8	11		H5	H3
5/8		18	H5	H3
3/4	10		H5	H5
3/4		16	H5	H3
7/8	9		H6	H4
7/8		14	H6	H4
1”	8		H6	H4
1”		12	H6	H4
1.1/8	7		H8	H4
1.1/8		12	H6	H4
1.1/4	7		H8	H4
1.1/4		12	H6	H4
1.3/8	6		H8	H4
1.3/8		12	H6	H4
1.1/2	6		H8	H4
1.1/2		12	H6	H4

ZÁVITNÍKY PRO TVÁŘENÍ ZA STUDENA: GEOMETRIE A PROCESY

Závitníky pro tváření za studena se liší od běžných řezacích závitníků tím, že závit ve skutečnosti nevzniká klasickým řezáním, ale plastickou deformací materiálu součásti. To znamená, že v průběhu jejich činnosti nevznikají třísky. Oblast použití se omezuje na zpracování materiálů s dobrou tvářitelností. Pevnost v tahu (R_m) by neměla přesáhnout 1200 N/mm^2 a tažnost (A_5) by neměla být menší než 10%.

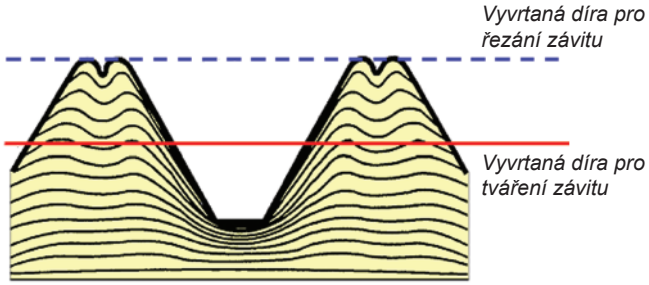
Tvářecí závitníky bez drážek jsou vhodné pro běžné obrábění, především pro vertikální tváření závitů v neprůchozích dírách. K dispozici jsou rovněž v provedení s vnitřním přívodem řezné kapaliny.

Výhody v porovnání s řezacími závitníky
- Tváření závitů za studena je rychlejší než běžné řezání závitů
- Tvářecí závitníky často dosahují delší životnosti
- Jeden typ nástroje lze použít pro různé materiály a pro tváření závitů jak v průchozích, tak i ve slepých dírách
- Konstrukce tvářecích závitníků je velmi stabilní, riziko zalomení je menší
- Zaručená požadovaná přesnost závitů
- Nevznikají třísky
- Pevnější závit (vyšší pevnost povrchové vrstvy), v porovnání s řezanými závity je pevnost vyrobeného závitu až o 100% vyšší
- Tvářením se získává lepší povrch závitu než řezáním

Předpoklady efektivního použití
- Dostatečná tažnost materiálu
  A_5>10 %
- Přesný průměr vyvrtané díry
- Důkladné mazání, které je naprosto zásadní

TOK MATERIÁLU PŘI TVÁŘENÍ ZÁVITŮ

Velikost díry pro tváření závitů závisí na obráběném materiálu, zvolených řezných podmínkách a stavu použitého stroje a nástroje. Jestliže závitník vytlačuje materiál na vstupu do díry (začátku závitu) a/nebo je trvanlivost nástroje příliš krátká, zvolte o něco větší průměr vrtáku. Na druhou stranu, pokud je profil vytvořeného závitu nedostatečný, zvolte poněkud menší průměr vrtáku.



MENETMEGMUNKÁLÁS

ÁLTALÁNOS TANÁCSOK A MENETFÚRÁSHOZ

A megfelelő menetfúrás számos tényező függvénye, melyek mind befolyásolják a végtermék minőségét.

1. Az anyag minőségéhez és a furat típusához (átmenő és zsákfurat) megfelelő menetfúró kiválasztása. Anyagtípus kiválasztásához használja az Anyagbesorolási táblázatot.
2. Bizonyosodjon meg a munkadarab stabil, merev megfogásáról. Az oldalirányú elmozdulás rossz minőségű menetet vagy a szerszám törését okozhatja.
3. Válasszon megfelelő méretű fúrót a katalógus vonatkozó oldaláról. A menetformázóknál eltérő méretű az előfúró. Mindig bizonyosodjon meg arról, hogy a munkadarabon a felkeményedés mértéke minimális.
4. Válassza a katalógus termékoldal és a TermékVálasztó által javasolt vágási sebességet.
5. A tökéletes megmunkálás érdekében mindig a megfelelő vágófolyadékot használja.
6. A menetfúrót mindig finoman indítsa a furatba. Az egyenlőtlen előtolás harangszáj kialakulásához vezethet.

2B & 3B MENETFÚRÓ OSZTÁLYOK: EGYSÉGES MÉRETŰ MENETEK

	TPI		Menetfúró tűrésértékek	
Méret	**UNC**	**UNF**	**2B osztály**	**3B osztály**
0		80	H2	H1
1	64		H2	H1
1		72	H2	H1
2	56		H2	H1
2		64	H2	H1
3	48		H2	H1
3		56	H2	H1
4	40		H2	H2
4		48	H2	H1
5	40		H2	H2
5		44	H2	H1
6	32		H3	H2
6		40	H2	H2
8	32		H3	H2
8		36	H2	H2
10	24		H3	H3
10		32	H3	H2
12	24		H3	H3
12		28	H3	H3
1/4	20		H5	H3
1/4		28	H4	H3
5/16	18		H5	H3
5/16		24	H4	H3
3/8	16		H5	H3

	TPI		Menetfúró tűrésértékek	
Méret	**UNC**	**UNF**	**2B osztály**	**3B osztály**
3/8		24	H4	H3
7/16	14		H5	H3
7/16		20	H5	H3
1/2	13		H5	H3
1/2		20	H5	H3
9/16	12		H5	H3
9/16		18	H5	H3
5/8	11		H5	H3
5/8		18	H5	H3
3/4	10		H5	H5
3/4		16	H5	H3
7/8	9		H6	H4
7/8		14	H6	H4
1”	8		H6	H4
1”		12	H6	H4
1.1/8	7		H8	H4
1.1/8		12	H6	H4
1.1/4	7		H8	H4
1.1/4		12	H6	H4
1.3/8	6		H8	H4
1.3/8		12	H6	H4
1.1/2	6		H8	H4
1.1/2		12	H6	H4

MENETFORMÁZÓK: GEOMETRIÁK ÉS ELJÁRÁSOK

A menetformázók abban különböznek a menetfúróktól, hogy a menet kialakítása – szemben a hagyományos forgácsolási művelettel – a munkadarab anyagának képlékeny alakításával történik. Ez azt is jelenti, hogy a folyamat alatt nem képződik forgács. Különösen jól alakítható anyagokhoz javasoljuk, ahol a szakítószilárdság 1200 N/mm^2 alatt, a nyúlási tényező (A_5) 10% fölött van.

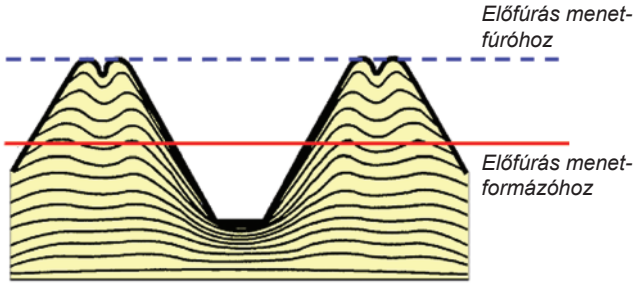
A horony nélküli menetformázók használata normál megmunkáláshoz, különösen függőleges irányú zsákfurat készítéshez javasolt. Belső hűtőcsatornás kivitelben is elérhető.

Előnyei a hagyományos menetvágókkal szemben
- A menetformázók gyorsabbak, mint a hagyományos menetvágók
- A menetformázók szerszáméltartama általában hosszabb
- Egyazon szerszám különböző anyagokhoz, mind átmenő, mind zsákfurat készítéshez alkalmazható
- A menetformázók stabilabb szerszámok, a szerszámtörés esélye kisebb
- A megfelelő tűrésű menet garantált
- Forgács nélkül
- A hagyományos menetvágóhoz képest akár 100%-kal erősebb (nagyobb felületi szilárdságú) menet készül
- A menetformálás esetén a menetvágásnál alacsonyabb felületi érdesség

A hatékony alkalmazás előfeltételei
- Megfelelő mechanikai tulajdonságok
  A_5>10 %
- Pontos furatátmérő
- A megfelelő kenés rendkívül fontos

ANYAGALAKÍTÁSI FOLYAMAT MENETFORMÁZÁSKOR

Az előfúrás mérete a megmunkált anyag minőségétől, a megválasztott forgácsolási paraméterektől és az alkalmazott szerszám minőségétől függ. Ha az anyag a menetbemenetnél tömörödik, és/vagy a menetfúró éltartama nagyon rövid, válasszon kissé nagyobb fúróátmérőt. Ha a menetprofil nem megfelelő, válasszon enyhén kisebb átmérőjű előfúrót.



GWINTOWANIE

OGÓLNE WSKAZÓWKI DOT. GWINTOWANIA OTWORÓW

Sukces każdej operacji gwintowania zależy od wielu czynników, przy czym mają one wszystkie wpływ na jakość gotowego produktu.

1. Wybrać z tabeli klasyfikacji materiałowej prawidłową geometrię gwintownika na podstawie obrabianego materiału i typu otworu (np. otwór ślepy lub przelotowy).
2. Narzędzie musi być dobrze zamocowane - luz poprzeczny może prowadzić do złej jakości gwintu, a nawet do złamania gwintownika.
3. Wybrać właściwy rozmiar wiertła z odpowiedniej strony w katalogu. Należy pamiętać, że średnica wiertła pod gwintowygniataki różni się od tej pod gwintowniki. Zawsze należy się upewnić, że utwardzenie powierzchniowe materiału jest utrzymywane na minimalnym poziomie.
4. Wybrać prawidłową prędkość skrawania z katalogu lub programu komputerowego wspomagającego dobór narzędzia (CoroGuide).
5. Zastosować odpowiednią ciecz chłodząco-smarującą do danej aplikacji.
6. Gwintownik powinien wchodzić w otwór z równomiernym posuwem, ponieważ nierównomierny posuw może prowadzić do rozszerzenia gwintu przy końcu obrabianego otworu.

GWINTOWNIKI KLAS 2B I 3B: GWINTY CALOWE ZUNIFIKOWANE

	TPI (zw/cal)		Ograniczenia gwintowników	
Rozmiar	**UNC**	**UNF**	**Klasa 2B**	**Klasa 3B**
0		80	H2	H1
1	64		H2	H1
1		72	H2	H1
2	56		H2	H1
2		64	H2	H1
3	48		H2	H1
3		56	H2	H1
4	40		H2	H2
4		48	H2	H1
5	40		H2	H2
5		44	H2	H1
6	32		H3	H2
6		40	H2	H2
8	32		H3	H2
8		36	H2	H2
10	24		H3	H3
10		32	H3	H2
12	24		H3	H3
12		28	H3	H3
1/4	20		H5	H3
1/4		28	H4	H3
5/16	18		H5	H3
5/16		24	H4	H3
3/8	16		H5	H3

	TPI (zw/cal)		Ograniczenia gwintowników	
Rozmiar	**UNC**	**UNF**	**Klasa 2B**	**Klasa 3B**
3/8		24	H4	H3
7/16	14		H5	H3
7/16		20	H5	H3
1/2	13		H5	H3
1/2		20	H5	H3
9/16	12		H5	H3
9/16		18	H5	H3
5/8	11		H5	H3
5/8		18	H5	H3
3/4	10		H5	H5
3/4		16	H5	H3
7/8	9		H6	H4
7/8		14	H6	H4
1”	8		H6	H4
1”		12	H6	H4
1.1/8	7		H8	H4
1.1/8		12	H6	H4
1.1/4	7		H8	H4
1.1/4		12	H6	H4
1.3/8	6		H8	H4
1.3/8		12	H6	H4
1.1/2	6		H8	H4
1.1/2		12	H6	H4

GWINTOWYGNIATAKI: GEOMETRIE I PROCES

Gwintowygniataki (gniotowniki) różnią się tym od konwencjonalnych gwintowników, że w ich przypadku gwinty powstają w wyniku plastycznego kształtowania obrabianego materiału. Oznacza to, że podczas obróbki nie powstają wióry. Zakres zastosowań,to materiały o dobrej zdolności do odkształceń plastycznych. Wytrzymałość na rozciąganie (R_m) nie powinna przekroczyć 1200 N/mm^2 a współczynnik wydłużenia (A_5) nie powinien być niższy niż 10%.

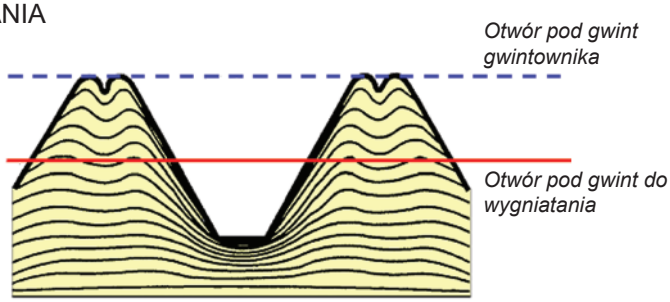
Gwintowygniataki bezrowkowe nadają się do normalnej obróbki, a szczególnie do kształtowania gwintu pionowych otworów nieprzelotowych. Gwintowygniataki te są również dostępne z wewnętrznym doprowadzeniem chłodziwa.

Zalety w porównaniu z gwintowaniem:
- Wygniatanie jest szybsze niż zwykłe gwintowanie
- Gwintowygniataki odznaczają się zwykle wyższą trwałością
- Jeden gniotownik stosuje się do różnych materiałów, zarówno do otworów przelotowych, jak i nieprzelotowych
- Gwintowygniataki wygniatające mają stabilną konstrukcje, co zmniejsza ryzyko złamania
- Gwarantują wykonywanie gwintów z prawidłową tolerancją
- Brak wiórów
- Gwinty mogą być poddawane większym obciążeniom (większa odporność na zerwanie gwintu) w porównaniu ze standardowo wykonywanymi gwintami (do 100 % wyższa)
- Mniejsza chropowatość powierzchni gwintu, osiągana w wyniku wygniatania niż przy skrawaniu

Warunek wstępny dla efektywnego wykorzystania:
- Wystarczające wydłużanie się materiału
  A_5>10 %
- Precyzyjnie wywiercona średnica otworu pod gwint
- Niezbędne jest dobre smarowanie

PRZEMIESZCZANIE SIĘ MATERIAŁU PODCZAS WYGNIATANIA

Rozmiar otworu pod gwint w przypadku wygniatania zależy od obrabianego materiału, wybranych parametrów skrawania i stanu stosowanego osprzętu. Jeśli materiał zostaje wypchnięty przy wejściu gwintowygniataka i/lub trwałość gwintowygniataka jest zbyt krótka, wybierz trochę większą średnicę wiertła. Jeśli z drugiej strony zarys utworzonego gwintu jest niewystarczający, wówczas wybierz trochę mniejszą średnicę wiertła.



FILETARE

RECOMANDĂRI GENERALE LA FILETARE

Succesul operației de filetare depinde de mai mulți factori, fiecare dintre ei având efect asupra calității produsului finit.

1. Alegeți tipul corect de tarod în funcție de material şi tipul găurii, de ex. pentru gaură străpunsă sau înfundată, conform indicațiilor din tabelul Clasificarea materialelor.
2. Verificați siguranța fixării tarodului. Existența unor jocuri poate provoca ruperea sculei şi o lipsă de calitate a filetului.
3. Alegeți dimensiunea corectă a burghiului de la pagina corespunzătoare a catalogului. Nu uitați: mărimea burghiului la filetarea cu tarozi fără canale este alta decât în mod uzual. Asigurați-vă că durificarea materialului în timpul filetării este minimă.
4. Alegeți viteza de aşchiere optimă conform indicațiilor din pagina de produs din catalog şi din CoroGuide.
5. Utilizați lichidul de răcire adecvat pentru aplicația corectă.
6. Asigurați o intrare uşoară a tarodului în alezaj, deoarece un avans neuniform poate cauza distrugerea filetului.

CLASE TAROZI AŞCHIERE 2B & 3B: FILETE STANDARDIZATE INCH

	TPI		Limite tarod	
Dim.	**UNC**	**UNF**	**Clasă 2B**	**Clasă 3B**
0		80	H2	H1
1	64		H2	H1
1		72	H2	H1
2	56		H2	H1
2		64	H2	H1
3	48		H2	H1
3		56	H2	H1
4	40		H2	H2
4		48	H2	H1
5	40		H2	H2
5		44	H2	H1
6	32		H3	H2
6		40	H2	H2
8	32		H3	H2
8		36	H2	H2
10	24		H3	H3
10		32	H3	H2
12	24		H3	H3
12		28	H3	H3
1/4	20		H5	H3
1/4		28	H4	H3
5/16	18		H5	H3
5/16		24	H4	H3
3/8	16		H5	H3

	TPI		Limite tarod	
Dim.	**UNC**	**UNF**	**Clasă 2B**	**Clasă 3B**
3/8		24	H4	H3
7/16	14		H5	H3
7/16		20	H5	H3
1/2	13		H5	H3
1/2		20	H5	H3
9/16	12		H5	H3
9/16		18	H5	H3
5/8	11		H5	H3
5/8		18	H5	H3
3/4	10		H5	H5
3/4		16	H5	H3
7/8	9		H6	H4
7/8		14	H6	H4
1”	8		H6	H4
1”		12	H6	H4
1.1/8	7		H8	H4
1.1/8		12	H6	H4
1.1/4	7		H8	H4
1.1/4		12	H6	H4
1.3/8	6		H8	H4
1.3/8		12	H6	H4
1.1/2	6		H8	H4
1.1/2		12	H6	H4

TAROZI PENTRU FILETARE PRIN DEFORMARE PLASTICĂ:GEOMETRII ŞI PROCES

Diferența dintre tarozii de deformare la rece şi tarozii de aşchiere este producerea filetului prin deformare plastică a materialului componentei, mai degrabă decât prin aşchierea tradițională. Aceasta înseamnă că nu se produce nicio aşchie prin acțiunea lor. Domeniul de aplicare se limitează la materialele cu o deformabilitate plastică ridicată. Rezistența la rupere (R_m) trebuie să fie sub 1200 N/mm^2, iar factorul de elongație (A_5) trebuie să fie de minim 10 %.

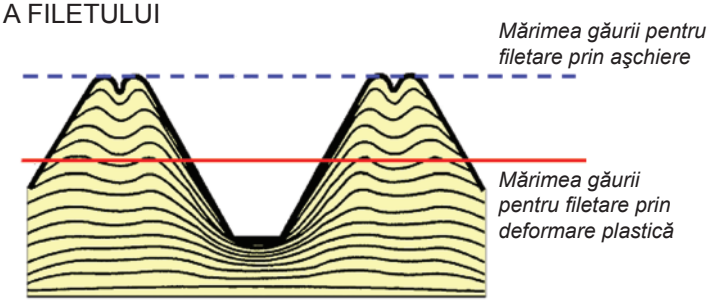
Tarozii pentru filetarea prin deformare plastica nu au canale. Se recomandă în special la găuri înfundate şi lucrul pe verticală. Mai sunt disponibili şi cu lichid de răcire prin interior.

Avantaje față de aşchiere
- Viteza de lucru mai mare
- Durabilitatea tarodului mai mare
- Un singur tarod poate fi utilizat în materiale diverse, la găuri străpunse şi înfundate
- Tarodul este mai robust, riscul de rupere mai redus
- Garantează realizarea filetului în toleranța prescrisă
- Fără aşchii
- Portanța filetului cu peste 100% mai mare decât la cel aşchiat
- Rugozitatea filetului este mai mică

Precondiții pentru utilizare:
- Coeficientul de elongație al materialului
  A_5>10 %
- Realizarea precisă a găurii
- O ungere bună este obligatorie

CURGEREA MATERIALULUI ÎN PROCESUL DE FORMARE A FILETULUI

Mărimea găurii în vederea filetării depinde de materialul de prelucrat, regimul de aşchiere şi starea echipamentelor utilizate. Dacă materialul este împins peste capacitatea de preluare a tarodului, viața sculei va fi scurtă. Ca urmare se impune folosirea unui burghiu mai mare. În sens contrar dacă profilul filetului va rezulta incomplet, va fi necesară folosirea unui burghiu mai mic.



НАРЕЗАНИЕ РЕЗЬБЫ

ОБЩИЕ УКАЗАНИЯ ПО НАРЕЗАНИЮ РЕЗЬБЫ МЕТЧИКАМИ

Результат любой операции по нарезанию резьбы зависит от ряда факторов, каждый из которых, в конечном счете, влияет на качество готовой детали.

1. Выберите правильную конструкцию метчика для данного обрабатываемого материала и типа отверстия, т. е. сквозного или глухого, из таблицы группы обрабатываемых материалов.

2. Убедитесь, что деталь надежно закреплена – перемещения в процессе обработки могут привести к поломке метчика или плохому качеству резьбы.

3. Выберите правильный размер сверла с соответствующей страницы каталога. Помните, что для метчиков-раскатников необходимы сверла других диаметров. Всегда контролируйте наклеп обрабатываемого материала.

4. Выберите правильное значение скорости резания, как показано в каталоге Coromant или программе CoroGuide.

5. Используйте СОЖ, соответствующую выполняемой операции.

6. Убедитесь в том, что метчик плавно входит в отверстие, прерывистая подача может привести к колоколообразной форме начальных витков резьбового отверстия.

МЕТЧИКИ КЛАССА ТОЧНОСТИ 2В и 3В: УНИФИЦИРОВАННАЯ ДЮЙМОВАЯ РЕЗЬБА

	Число витков резьбы на дюйм (TPI)		Предельные допуски метчика	
Размер	**UNC**	**UNF**	**Линейка 2В**	**Линейка 3В**
0		80	H2	H1
1	64		H2	H1
1		72	H2	H1
2	56		H2	H1
2		64	H2	H1
3	48		H2	H1
3		56	H2	H1
4	40		H2	H2
4		48	H2	H1
5	40		H2	H2
5		44	H2	H1
6	32		H3	H2
6		40	H2	H2
8	32		H3	H2
8		36	H2	H2
10	24		H3	H3
10		32	H3	H2
12	24		H3	H3
12		28	H3	H3
1/4	20		H5	H3
1/4		28	H4	H3
5/16	18		H5	H3
5/16		24	H4	H3
3/8	16		H5	H3

	Число витков резьбы на дюйм (TPI)		Предельные допуски метчика	
Размер	**UNC**	**UNF**	**Линейка 2В**	**Линейка 3В**
3/8		24	H4	H3
7/16	14		H5	H3
7/16		20	H5	H3
1/2	13		H5	H3
1/2		20	H5	H3
9/16	12		H5	H3
9/16		18	H5	H3
5/8	11		H5	H3
5/8		18	H5	H3
3/4	10		H5	H5
3/4		16	H5	H3
7/8	9		H6	H4
7/8		14	H6	H4
1”	8		H6	H4
1”		12	H6	H4
1.1/8	7		H8	H4
1.1/8		12	H6	H4
1.1/4	7		H8	H4
1.1/4		12	H6	H4
1.3/8	6		H8	H4
1.3/8		12	H6	H4
1.1/2	6		H8	H4
1.1/2		12	H6	H4

БЕССТРУЖЕЧНЫЕ МЕТЧИКИ (РАСКАТНИКИ): ГЕОМЕТРИЯ И ПРОЦЕСС РЕЗЬБОНАРЕЗАНИЯ

Бесстружечные метчики отличаются от обычных тем, что образуют профиль резьбы за счет пластической деформации, а не за счет снятия стружки. Рекомендуются для материалов с высокой пластичностью. Такие материалы имеют предел прочности не более 1200 Н/мм2, а относительное удлинение – не менее 10%.

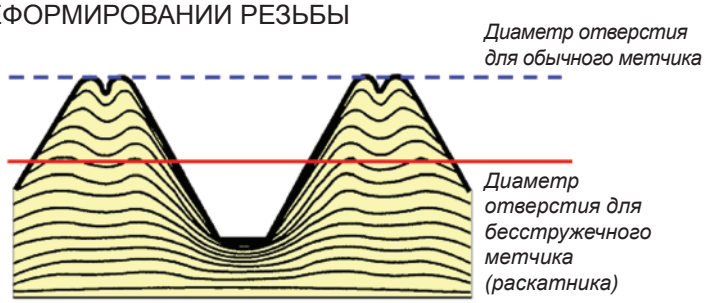
Бесстружечные метчики можно использовать в обычных условиях, но лучшие результаты они показывают при обработке вертикальных глухих отверстий. Выпускаются также с внутренним подводом СОЖ.

Преимущества по сравнению с обычными метчиками
- Метчики-раскатники работают быстрее, чем обычные
- Метчики-раскатники имеют большую стойкость
- Один бесстружечный метчик (раскатник) может быть использован для обработки резьбы в различных материалах, в глухих и сквозных отверстиях
- Метчики-раскатники имеет жесткую конструкцию, уменьшающую вероятность поломки
- Гарантированное получение резьбы в пределах поля допуска
- Отсутствует стружка
- Более прочная резьба (более высокая прочность на смятие), по сравнению с нарезанной резьбой (в 2 раза прочнее)
- Лучшее качество поверхности у резьб, полученных пластическим деформированием

Условия для эффективного использования
- Относительное удлинение обрабатываемого материала A_5>10 %
- Точный диаметр просверленного отверстия
- Необходимо хорошее смазывание

РАСПРЕДЕЛЕНИИ МАТЕРИАЛА ПРИ ПЛАСТИЧЕСКОМ ДЕФОРМИРОВАНИИ РЕЗЬБЫ

Диаметр просверленного отверстия зависит от обрабатываемого материала, режимов резания и состояния используемого оборудования. Если материал приподнят к началу резьбы и/или стойкость бесстружечного метчика (раскатника) мала, выберите сверло большего диаметра. С другой стороны, если не хватает материала для формирования полного профиля резьбы, следует использовать сверло немного меньшего диаметра.



THREADING

GENERAL HINTS ON TAPPING

The success of any tapping operation depends on a number of factors, all of which effect the quality of the finished product.

1. Select the correct design of tap for the component material and type of hole, i.e. through or blind, from the Materials Classification chart.
2. Ensure the component is securely clamped - lateral movement may cause tap breakage or poor quality threads.
3. Select the correct size of drill from the relevant catalogue page. Remember the drill sizes for fluteless taps are different. Always ensure that work hardening of the component material is kept to a minimum.
4. Select the correct cutting speed as shown on the catalogue product page and in the CoroGuide.
5. Use appropriate cutting fluid for correct application.
6. Ensure smooth entry of the tap into the hole, as an uneven feed may cause ‘bell mouthing’.

CUTTING TAPS CLASSES 2B & 3B: UNIFIED INCH SCREW THREADS

	TPI		Tap limits	
Size	UNC	UNF	Class 2B	Class 3B
0		80	H2	H1
1	64		H2	H1
1		72	H2	H1
2	56		H2	H1
2		64	H2	H1
3	48		H2	H1
3		56	H2	H1
4	40		H2	H2
4		48	H2	H1
5	40		H2	H2
5		44	H2	H1
6	32		H3	H2
6		40	H2	H2
8	32		H3	H2
8		36	H2	H2
10	24		H3	H3
10		32	H3	H2
12	24		H3	H3
12		28	H3	H3
1/4	20		H5	H3
1/4		28	H4	H3
5/16	18		H5	H3
5/16		24	H4	H3
3/8	16		H5	H3

	TPI		Tap limits	
Size	UNC	UNF	Class 2B	Class 3B
3/8		24	H4	H3
7/16	14		H5	H3
7/16		20	H5	H3
1/2	13		H5	H3
1/2		20	H5	H3
9/16	12		H5	H3
9/16		18	H5	H3
5/8	11		H5	H3
5/8		18	H5	H3
3/4	10		H5	H5
3/4		16	H5	H3
7/8	9		H6	H4
7/8		14	H6	H4
1”	8		H6	H4
1”		12	H6	H4
1.1/8	7		H8	H4
1.1/8		12	H6	H4
1.1/4	7		H8	H4
1.1/4		12	H6	H4
1.3/8	6		H8	H4
1.3/8		12	H6	H4
1.1/2	6		H8	H4
1.1/2		12	H6	H4

COLD FORMING TAPS: GEOMETRIES AND PROCESS

Cold forming taps differ from cutting taps in that the thread is produced by plastic deformation of the component material rather than by the traditional cutting action. This means that no swarf is produced by their action. The application range is materials with good formability. Tensile strength (R_m) should not exceed 1200 N/mm^2 and the elongation factor (A_5) should not be less than 10%.

Cold forming taps without flutes are suitable for normal machining and are especially suitable when vertically tapping blind holes. They are also available with through coolant.

Advantages compared with cutting taps

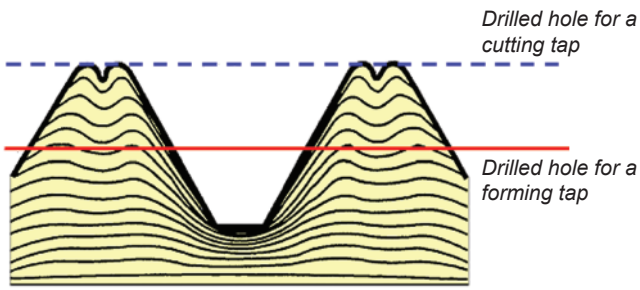
- Cold forming is faster than ordinary thread cutting
- Cold forming taps often give a longer tool life
- One type of tool can be used in different materials and for both through and blind holes
- Cold forming taps have a stable design which gives lower risk of breakage
- Threads to the correct tolerance are guaranteed
- No chips
- Stronger thread (higher stripping strength), compared to thread obtained by cutting (up to 100% more)
- Lower surface roughness on thread obtained by forming than by cutting

Pre-conditions for effective use

- Sufficent material elongation
  A_5>10 %
- Precise drilled hole diameter
- Good lubrication is imperative

FLOW OF MATERIAL WHEN FORMING A THREAD

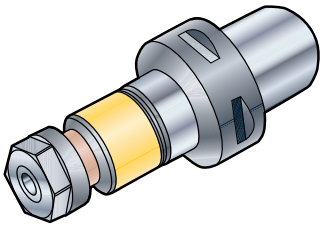
The tapping hole size depends upon the material being drilled, the cutting conditions selected and the condition of the equipment being used. If material is pushed up at the thread entry by the tap and/or the life of the tap is too short, select a slightly larger drill diameter. If on the other hand the profile of the thread formed is insufficient, then select a slightly smaller drill diameter.



Držáky závitníků

Pro všechny typy závitníků

KTERÝ DRŽÁK ZÁVITNÍKŮ SPLŇUJE VAŠE POŽADAVKY?

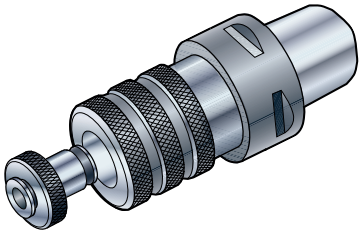


Závitníkové sklíčidlo SynchroFlex®* ER

• První volba pro CNC obráběcí stroje a synchronizované závitořezné operace
• Pro hromadnou výrobu a vysokou přesnost
• Tuhý plovoucí držák závitníků s axiální mikrokompenzací
• Použití společně se závitníkovými kleštinami ER se čtyřhranem
• Prodloužení životnosti závitníku, zlepšení kvality obrobené plochy a zajištění maximální bezpečnosti procesu

*SynchroFlex je registrovanou obchodní značkou firmy Tapmatic Corp., USA

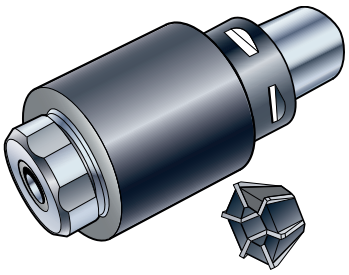
Použití společně se:
Závitníky CoroTap™
• Závitníky Spectrum™



Rychlovýměnné závitníkové sklíčidlo

• První volba pro závitořezné operace neuvedené výše
• Pro všeobecnou malosériovou výrobu
• Snadné upínání závitníků a jejich rychlá výměna
• Vyrovnání chyby posuvu rozpínáním nebo stlačením

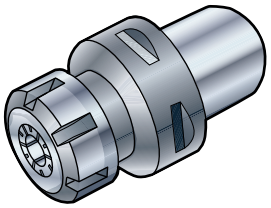
Použití společně se:
• Závitníky Spectrum™



Plovoucí sklíčidlo pro pryžové kleštiny

• Staré konstrukční provedení, často používané pro malá soustružnická centra
• Kleštiny se vyznačují širokým upínacím rozsahem

Použití společně se:
• Závitníky Spectrum™



Kleštinové sklíčidlo ER

• Malosériová výroba
• Použití společně se závitníkovými kleštinami ER se čtyřhranem
• Pevné, bez axiální kompenzace, omezená životnost závitníku

Použití společně se:
• Závitníky Spectrum™

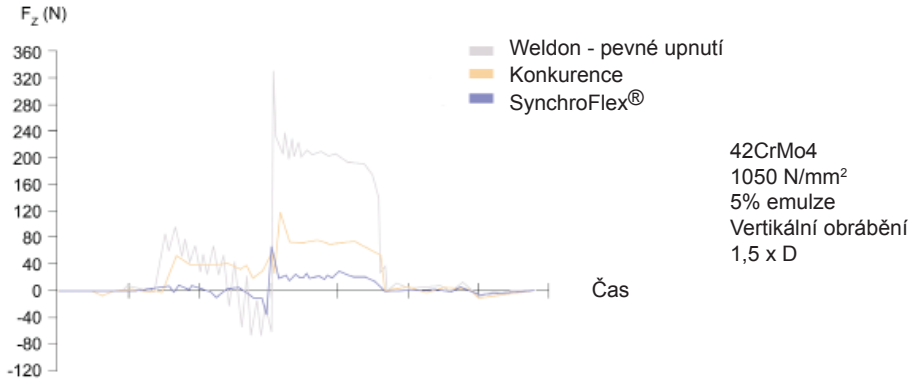
Sortiment a údaje pro objednání viz Dodatkový katalog 12.1 a 12.2 , kapitola Nástrojové systémy.

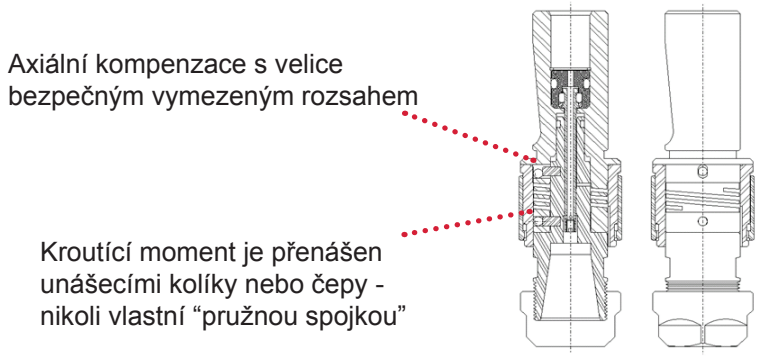
Příslušenství pro řezání závitů

Proces řezání závitů spočívá v dokonalé souhře axiálních a rotačních pohybů nástroje. Proto je někdy nutné omezit axiální pohyb nástroje.

I minimální rozdíly mezi vypočteným posuvem a skutečným stoupáním závitníku mohou vést ke vzniku extrémně vysokých osových sil působících na boky závitu a tudíž i ke zvýšení řezného tlaku, podstatnému snížení kvality závitu a trvanlivosti nástroje.

Závitníkové sklíčidlo SynchroFlex® využívá přesný mikrokompenzátor - či "pružnou spojku" - který umožňuje kompenzaci radiálních i axiálních polohových odchylek v řádu mikrometrů. Výsledkem je výrazné snížení tlaku působícího na bocích (hřbetu) závitníku.





Mezi další výhody patří:

- Snížení tření (a tedy menší opotřebení), které se projeví prodloužením životnosti nástroje
- Lepší kontrola hloubky závitu a přesnější výrobní proces
- Štíhlý tvar výrazně usnadňuje odvádění třísek
- Díky menšímu riziku zalomení závitníku se zvyšuje bezpečnost celého procesu
- Protože pohyb je s vysokou bezpečností omezen, nedochází k přetěžování pružné spojky, a proto držák neztrácí časem svou tuhost ani neopotřebovává
- Komplexní řešení pro řezání závitů: držák se přizpůsobuje geometrii příslušného závitníku, např. závitníkům CoroTap™ nebo Spectrum™

Všechna závitníková sklíčidla SynchroFlex® lze použít na CNC obráběcích strojích se synchronizovanými závitořeznými cykly, k dispozici jsou v provedení s vnitřním přívodem řezné kapaliny (až 80 barů). Díky tomu se zvyšuje bezpečnost procesu řezání závitů, zejména v případě řezání závitů v korozivzdorných ocelích (ISO M) a v materiálech na bázi niklu (ISO S).

K dispozici stroje s rozhraním DIN 1835 B/E, HSK A/C 63 a Capto, stejně jako adaptéry pro nejběžnější vedlejší systémy.

Výhody se ještě násobí, pokud se držáky závitníků SynchroFlex® použijí společně se závitníky s větším úhlem šroubovice a větším podbroušením.

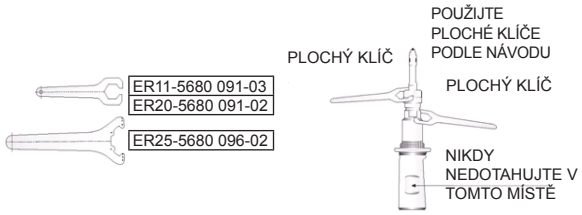
UPNUTÍ ZÁVITNÍKU

1. Vyberte vhodnou ER kleštinu pro stopku závitníku se čtyřhranem
2. Vložte kleštinu do matice a ujistěte se, že kleština dobře sedí ve svém lůžku

NESPRÁVNĚ

SPRÁVNĚ

3. Použijte dva ploché klíče a dobře dotáhněte matici kleštiny. Není vhodné využívat pro dotažení matice upínací stopku. Neutahujte matici příliš pevně, protože by mohlo dojít k poškození unašeče závitníku



Doporučené hodnoty kroutícího momentu pro utažení matic ER kleštin pro závitníky	
Všechny ER11	18 Nm/13 ft-lbs
Všechny ER20	40 Nm/29 ft-lbs
Všechny ER25	130 Nm/95 ft-lbs

RYCHLOVÝMĚNNÉ DRŽÁKY ZÁVITNÍKŮ

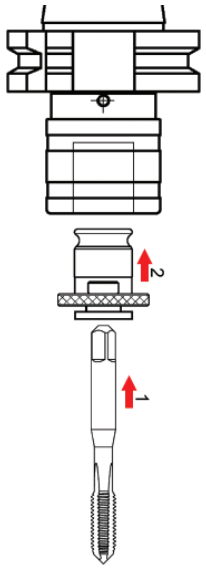
Jednoduchý upínač závitníků s možností rychlé výměny a s plnou kompenzací rozpínáním nebo stlačením. Tento druh závitníkového držáku je vhodný pro všeobecné použití (GP) / standardní / ruční závitníky.

V případě použití plovoucího upnutí závitníků pro operace na NC strojích se ujistěte, že naprogramovaná velikost posuvu je správná.
Doporučená hodnota je 95% až 97% stoupání závitu. Tím se zajistí, že závitník správně řeže a je tažen do řezu vlastním stoupáním.To je možné pouze u nepříliš výkonných závitníků se šroubovitou drážkou.

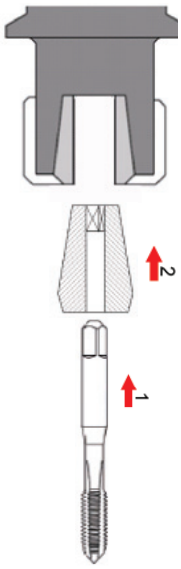
Používáte-li tuhé držáky závitníků, např. SynchroFlex® nebo sklíčidlo typu ER, ponechejte 100% posuv.

Vždy používejte vhodný typ řezné kapaliny odpovídající dané operaci.

RYCHLOVÝMĚNNÝ DRŽÁK ZÁVITNÍKŮ



KLEŠTINOVÉ SKLÍČIDLO (STANDARDNÍ) (ER)

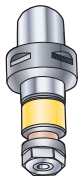


*SynchroFlex je registrovanou obchodní značkou firmy Tapmatic Corp.,USA

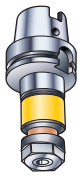
Sortiment držáků závitníků

Závitníkové sklíčidlo SynchroFlex® ER* - pro synchronizované závitořezné operace

Coromant Capto ®

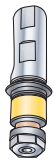


Celistvý držák HSK



Celistvý držák MAS-BT

Stopkový držák Weldon



Pro použití společně se
Závitníkovými kleštinami ER
Pro řezání závitů s vnitřním přívodem řezné kapaliny použijte:
Těsnící kroužky ER
Kleštinovou matici ER

Rychlovýměnné závitníkové sklíčidlo

Coromant Capto ®

Celistvý držák HSK

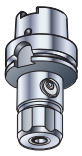
Stopkový držák Weldon

Pro použití společně s
Rychlovýměnnými závitníkovými adaptéry s třecí spojkou
Rychlovýměnnými závitníkovými adaptéry bez třecí spojky

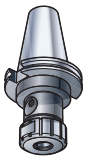
Plovoucí sklíčidlo pro pryžové kleštiny

Coromant Capto ®

Celistvý držák HSK



Celistvý držák CAT-V



Pro použití společně s
Pryžovými kleštinami

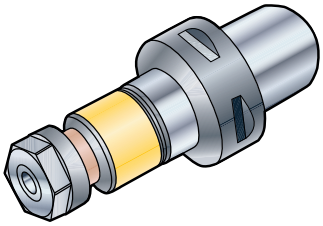
*SynchroFlex je registrovanou obchodní značkou firmy Tapmatic Corp.,USA

Sortiment a údaje pro objednání viz Dodatkový katalog 12.1 a 12.2 , kapitola Nástrojové systémy.

Menetfúró befogók

Minden menetfúró szerszámhoz

MELYIK MENETFÚRÓ BEFOGÓ FELEL MEG IGÉNYEINEK?



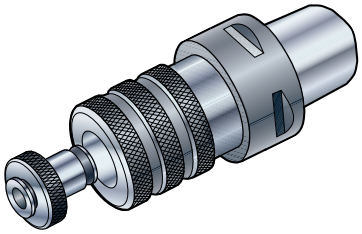
SynchroFlex®* ER menetfúró tokmány

- Első választás CNC szerszámgépekhez és szinkronizált menetfúrás műveletekhez
- Nagy volumenű gyártáshoz és a nagy pontosságért
- Merev menetfúró tartó mikrolebegő kompenzálással
- Használja ER menetfúró szögletes patronokkal
- Javítja a szerszám éltartamot, felületi minőséget és a legjobb folyamatbiztonság érhető el vele

* A SynchroFlex a Tapmatic Corp., USA bejegyzett védjegye

Használja a következőkkel:

- CoroTap™
- Spectrum™ menetfúró

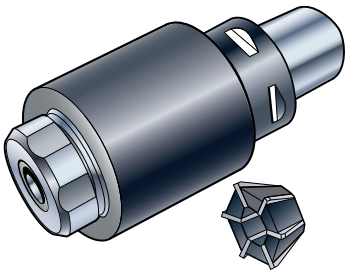


Gyors cseréjű menetfúró tokmány

- Első választás a felsorolásban nem szereplő menetfúró műveletekhez
- Általános, kisebb volumenű termeléshez
- Könnyű, gyors cseréjű menetfúró befogó
- Húzás és nyomás az előtolási hiba kiküszöbölésére

Használja a következőkkel:

- Spectrum™ menetfúró

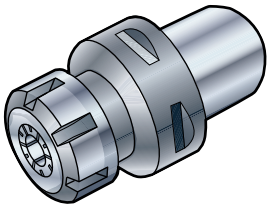


Lebegő gumipatronos tokmány

- Régi típusú, gyakran alkalmazott kisebb eszterga-gépekben
- A patronok széles befogási választékban kaphatók

Használja a következőkkel:

- Spectrum™ menetfúró



ER patronos tokmány

- Kis sorozatú gyártás
- Használja ER menetfúró szögletes patronokkal
- Merev, nincs kompenzáció, korlátozza a menetfúró éltartamát

Használja a következőkkel:

- Spectrum™ menetfúró

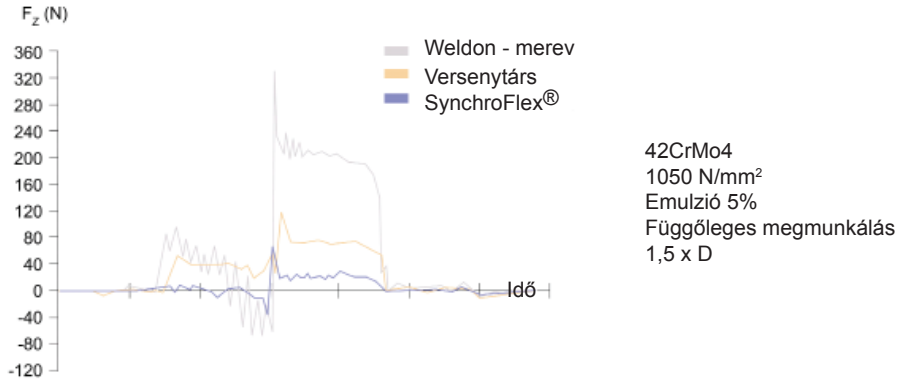
A választékhoz és a rendelési információkhoz lásd a 12.1 és 12.2 kiegészítő katalógusok Szerszámrendszerek fejezetét.

MENETFÚRÓ-BEFOGÓK

A menetfúrás a menetfúró körkörös és axiális mozgásának komplex egyensúlya. Néha szükséges a menetfúró axiális mozgását korlátozni.

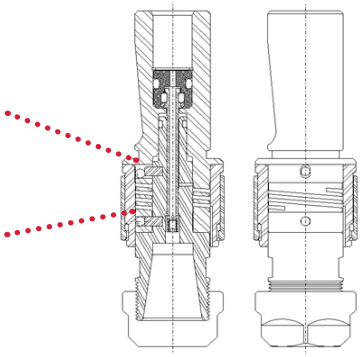
A kiszámított előtolás és a menetfúró tényleges menetemelkedése közötti mikroeltérések is extrém mértékű forgácsolóerőket eredményeznek az éleken és ennek megfelelően megnövelik a forgácsolási nyomást, amely jelentősen csökkenti a menet minőségét és a szerszáméltartamot.

A Coromant SynchroFlex® menetfúró befogójának működése egy precízen kialakított mikrokompenzátoron (“Flexure”) alapul, amely kompenzálja a sugár- és tengelyirányú mikroméretű pozicionálási eltéréseket. Ennek megfelelően a menetfúróra gyakorolt nyomás jelentős mértékben csökkenthető.



A tengelyirányú kompenzáció biztonságos tartományba van korlátozva

A nyomaték átadását a meghajtógörgők és csapok végzik, nem pedig a hajlítás



További előnyök:

- A kisebb súrlódás (és ezért kevesebb kopás) hosszabb szerszáméltartamhoz vezet
- A mélységvezérlés nagyobb pontossága pedig precízebb termelési folyamatokat eredményez
- A karcsú kialakítás jelentősen javítja a forgácselvezetést
- Nagyobb folyamatbiztonság a szerszámtörés kisebb veszélyének köszönhetően
- Mivel a mozgás biztonságos tartományba van korlátozva, a hajlítás nincs túlzott igénybevételnek kitéve, ennek megfelelően a szerszámbefogó soha nem fárad ki vagy kopik el
- Komplett menetmegmunkálási megoldás: a szerszámbefogó a menetfúró geometriájának megfelelően van koordinálva, pl. CoroTap™ és Spectrum™ menetfúrók

A szinkronizált menetfúró ciklusú CNC-gépeken történő használatra alkalmas SynchroFlex® menetfúró befogók belső hűtőcsatornával (max. 80 bar) rendelkeznek, amely tovább növeli a menetfúró folyamatbiztonságát, különösen rozsdamentes acél (ISO M) és nikkel (ISO S) anyagokon végzett menetmegmunkálás során.

DIN 1835 B/E, HSK A/C 63 és Capto megmunkáló befogó interfészek, és a legtöbb elterjedt rendszerhez való adapterek kaphatók.

SynchroFlex® szerszámtartóval az előnyök különösen erősen hátraköszörült spirálfúrók alkalmazása esetén érvényesülnek.

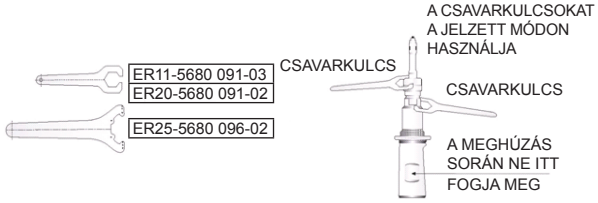
A MENETFÚRÓ FELSZERELÉSE

1. Válassza ki a megfelelő méretű ER patront, száras és négyszög befogású menetfúrók esetén
2. Illessze be a patront az anyába úgy, hogy a patron rögzítő csavarjának a lába felütközzön a patron felfekvőfelületére

HELYTELEN

HELYES

3. Két csavarkulcs használatával húzza meg erőteljesen a patront rögzítő csavart. Nem ajánlott a meghúzás során fogóval megfogni a befogás szárát. Ügyeljen, hogy ne húzza túl az anyát, mivel ez a menetfúró meghajtás sérüléséhez vezethet.



Az anya ajánlott meghúzási nyomaték értékei az ER menetfúró patron rögzítőcsavarjai esetén	
Bármely ER11	18 Nm/13 ft-lbs
Bármely ER20	40 Nm/29 ft-lbs
Bármely ER25	130 Nm/95 ft-lbs

GYORSCSERÉLŐ MENETFÚRÓ BEFOGÁS

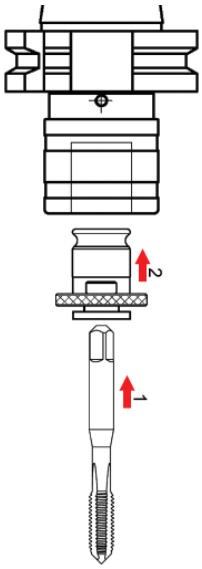
Egyszerű menetfúró befogás gyorscserélő funkcióval, valamint teljes feszítő és összenyomó mozgatással. Ez a menetfúró befogó típus általános célú (GP) / standard / kézi használatú menetfúrók esetén ajánlott.

Lengő szerszámtartó NC alkalmazásokban történő használata esetén a programhoz megfelelő vágósebességet válasszon: 95-97%-os menetemelkedés javasolt, amely lehetővé teszi a menetfúró a saját menetemelkedésének generálását. Ez kizárólag nem nagy teljesítményű spirál menetfúró esetén lehetséges.

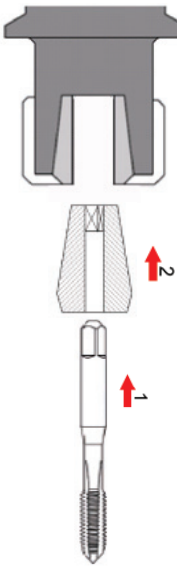
A merev menetfúrótartók használata esetén, mint a SynchroFlex®* vagy az ER tokmányok, alkalmazzon 100%-os előtolást.

Mindig az adott alkalmazásnak megfelelő vágó-folyadékot használjon.

GYORSCSERÉLŐ MENETFÚRÓ BEFOGÓ



PATRON TOKMÁNY (STANDARD) (ER)

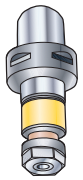


*A SynchroFlex a Tapmatic Corp., USA bejegyzett védjegye

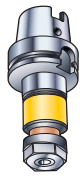
Menetfúró befogó választék

SynchroFlex® ER menetfúró tokmány* - szinkronizált menetfúrás műveletekhez

Coromant Capto ®

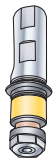


HSK tömör befogó



MAS-BT tömör befogó

Weldon szártartó



A következőkkel használható:
ER menetfúró patron
Átmenő hűtőközeges menetfúróhoz:
ER tömítő tárcsa
ER patron anya

Gyors cseréjű menetfúró tokmány

Coromant Capto ®

HSK tömör befogó

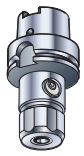
Weldon szártartó

A következőkkel használható:
Gyors cseréjű menetfúró adapter súrlódó tengelykapcsolóval
Gyors cseréjű menetfúró adapter súrlódó tengelykapcsoló nélkül

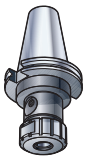
Lebegő gumipatronos tokmány

Coromant Capto ®

HSK tömör befogó



CAT-V tömör tartó



A következőkkel használható:
Gumipatronok

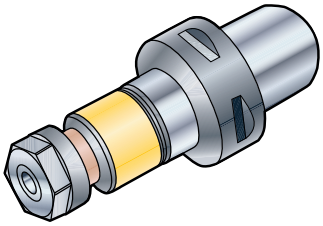
*A SynchroFlex a Tapmatic Corp., USA bejegyzett védjegye

A választékhoz és a rendelési információkhoz lásd a 12.1 és 12.2 kiegészítő katalógusok Szerszámrendszerek fejezetét.

Oprawki do gwintowników

Do wszystkich gwintowników

JAKICH OPRAWEK DO GWINTOWNIKÓW POTRZEBUJESZ?



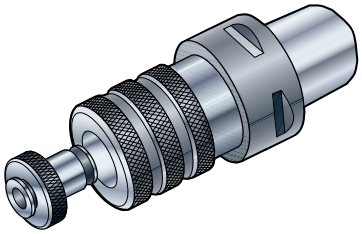
Oprawka SynchroFlex®* na tuleje zaciskowe ER

- Rekomendowany w pierwszej kolejności do obrabiarek CNC i gwintowania zsynchronizowanego
- Do dużych partii i produkcji precyzyjnej
- Sztywna oprawka z kompensacją mikrowahań
- Stosować z prostokątnymi tulejami zaciskowymi ER
- Większa trwałość gwintownika, lepsza jakość wykończenia powierzchni i duże bezpieczeństwo obróbki

* SynchroFlex jest zastrzeżonym znakiem towarowym Tapmatic Corp., USA

Stosować z modelami:

- CoroTap™
- Spectrum™ Tap

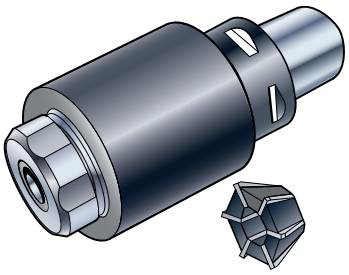


Oprawka do gwintowników z funkcją szybkiej wymiany

- Pierwszy wybór do operacji wytaczania niewymienionych powyżej
- Do produkcji zróżnicowanej i mniejszych partii
- Łatwe mocowanie gwintownika za pomocą systemu szybkowymiennego
- Kompensuje nierównomierność posuwuu

Stosować z modelami:

- Spectrum™ Tap

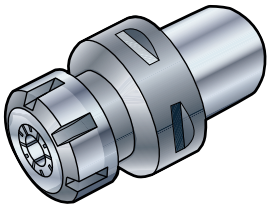


Oprawka „pływająca“ z gumową tulejką zaciskową

- Uchwyt starego typu, często stosowany w małych tokarkach
- Tuleje zaciskowe można stosować do mocowań różnego typu

Stosować z modelami:

- Spectrum™ Tap



Oprawka na tuleje zaciskowe ER

- Do produkcji małych partii
- Stosować z przeznaczonymi do gwintowania tulejkami zaciskowymi ER
- Sztywne, bez kompensacji, mniejsza trwałość gwintownika

Stosować z modelami:

- Spectrum™ Tap

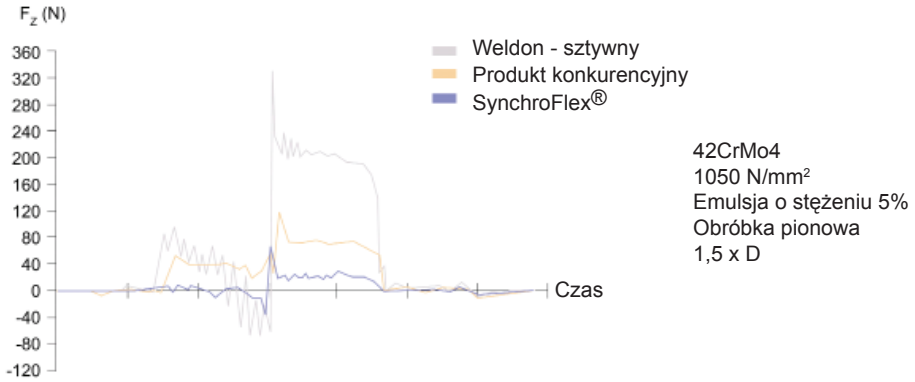
Asortyment i informacje o zasadach składania zamówienia - patrz Suplement 12.1 i 12.2, rozdział Systemy narzędziowe.

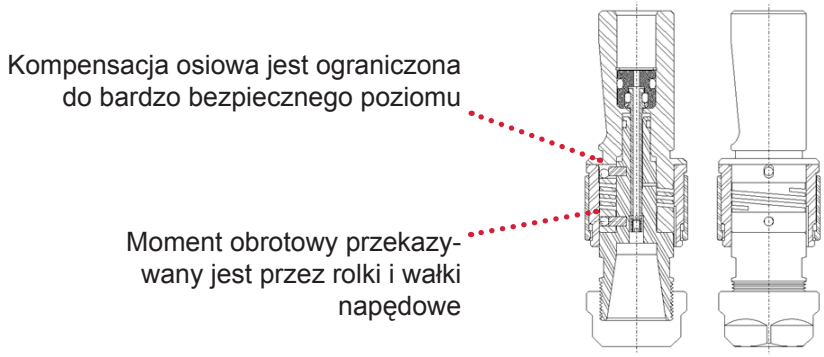
UCHWYTY SZYBKOZMIENNE DO GWINTOWNIKÓW

Proces gwintowania otworów jest kombinacją ruchów obrotowego i postępowego. Czasem konieczne jest ograniczenie ruchu postępowego (w kierunku osi) narzędzia.

Nawet mikro różnice pomiędzy obliczonym posuwem, a rzeczywistym skokiem mogą spowodować wyjątkowo duże siły odporu na krawędziach gwintownika, tym samym tworzy się większy nacisk podczas obróbki, co znacznie obniża jakość gwintu i trwałość narzędzia.

Oprawki/adaptery do gwintowników serii SynchroFlex® firmy Coromant powstał w oparciu o precyzyjny mikro kompensator gwintownika koryguje odchyłki położenia w mikro skali promieniowo oraz osiowo. Tym samym, nacisk nałożony na krawędzie gwintu można znacznie ograniczyć.





Dodatkowe korzyści to:

- Mniejsze tarcie (a tym samym mniejsze zużycie), zapewnia dłuższą trwałość narzędzia
- Większa dokładność kontroli głębokości sprawia, że proces obróbki jest bardziej precyzyjny
- Smukły kształt radykalnie poprawia odprowadzenie wiórów
- Bezpieczniejszy przebieg procesu dzięki ograniczonej możliwości wykruszenia się gwintownika
- Ponieważ ruch ograniczony jest do bardzo bezpiecznego zakresu, nigdy nie następuje zbyt duży nacisk na mechanizm kompensacji, zatem oprawka nigdy nie ulegnie zniszczeniu ani zużyciu
- Pełne rozwiązanie dla procesu gwintowania: mocowanie jest dopasowane do geometrii gwintownika np. typu CoroTap™ i Spectrum™

Odpowiednie do zastosowania w obrabiarkach CNC ze stałym cyklem gwintowania, wszystkie oprawki gwintowników SynchroFlex® dostępne są z opcją wewnętrznego doprowadzania chłodziwa (do 80 bar) lub bez niej, co jeszcze bardziej poprawia bezpieczeństwo mocowania, szczególnie podczas gwintowania materiałów ze stali nierdzewnej (ISO M) i stopów niklu(ISO S).

Dostępne są przyłącza do obrabiarek DIN 1835 B/E, HSK A/C 63 i Capto, jak również adaptery do większości powszechnie stosowanych systemów.

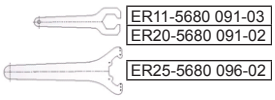
Maksymalne korzyści osiąga się przy zastosowaniu oprawek gwintowników SynchroFlex® wraz z gwintownikami z dużym kątem pochylenia linii śrubowej i dużym kątem przyłożenia.

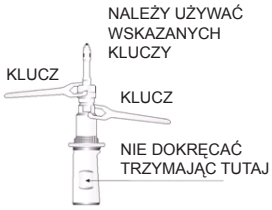
MOCOWANIE GWINTOWNIKA

1. Wybrać tuleję ER do gwintowników pasującą do oprawki i przekroju zabieraka gwintownika
2. Umieścić tuleję w nakrętce pamiętając, aby weszła do samego końca

NIEPRAWIDŁOWO PRAWIDŁOWO

3. Za pomocą dwóch kluczy mocno dokręcić nakrętkę do oprawki. Nie zaleca się dokręcania trzymając za trzonek oprawki. Należy uważać, aby nie dokręcić nakrętki zbyt mocno; może to spowodować uszkodzenie gwintownika.





Zalecane wartości momentu obrotowego przy dokręcaniu nakrętek oprawek do gwintowników na tuleje ER	
Wszystkie ER11	18 Nm/13 ft-lbs
Wszystkie ER20	40 Nm/29 ft-lbs
Wszystkie ER25	130 Nm/95 ft-lbs

SZYBKIE MOCOWANIE GWINTOWNIKA

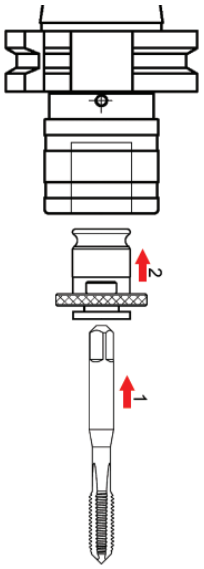
Łatwe mocowanie gwintownika z funkcją szybkiej wymiany przy pełnym naprężeniu i ruchu sprężającym. Tego typu oprawka jest zalecana do gwintowników standardowych / uniwersalnych (GP) / ręcznych.

W przypadku zastosowania oprawek “pływających” w obrabiarkach ze sterowaniem numerycznym wartości posuwu powinny być prawidłowe dla wybranego programu: zaleca się posuw na poziomie 95% do 97% skoku, żeby gwintownik bez nacisku wchodził w materiał. Jest to możliwe jedynie w przypadku niewysokowydajnych gwintowników ze skośną powierzchnią natarcia.

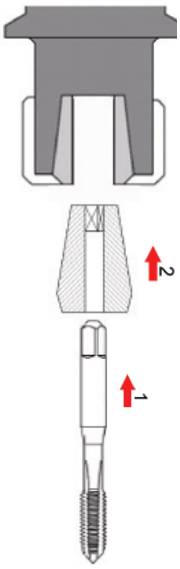
W przypadku stosowania sztywnych mocowań gwintowników, takich jak SynchroFlex®* czy oprawek na tuleje ER, należy zastosować 100% wartość posuwu.

Należy zawsze stosować odpowiednią do zastosowania ciecz chłodząco-smarującą.

OPRAWKA DO GWINTOWNIKÓW Z FUNKCJĄ SZYBKIEJ WYMIANY



TULEJKA ZACISKOWA (STANDARDOWA) (ER)

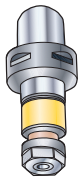


*SynchroFlex jest zastrzeżonym znakiem towarowym Tapmatic Corp., USA

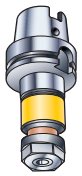
Asortyment oprawek do gwintowników

Oprawka do gwintowników na tuleje ER serii SynchroFlex® * - do wytaczania synchronicznego

Coromant Capto ®

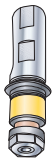


Uchwyt jednolity HSK



Uchwyt jednolity MAS-BT

Chwyt Weldon



Stosować z
Tuleją zaciskową ER
Dla doprowadzenia chłodziwa przez środek:
Pierścień uszczelniający do tulei ER
Nakrętka do tulei zaciskowej

Oprawki do gwintowników z funkcją szybkiej wymiany

Coromant Capto ®

Uchwyt jednolity HSK

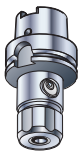
Chwyt Weldon

Stosować z:
Adapterami szybkowymiennymi ze sprzęgłem ciernym
Adapterami szybkowymiennymi bez sprzęgła ciernego

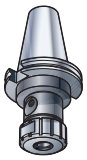
Oprawki “pływające” z gumową tuleją zaciskową

Coromant Capto ®

Uchwyt jednolity HSK



Uchwyt jednolity CAT-V



Stosować z:
Gumowymi tulejami zaciskowymi

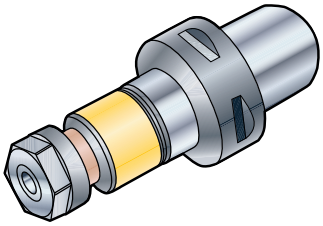
*SynchroFlex jest zastrzeżonym znakiem towarowym Tapmatic Corp., USA

Asortyment i informacje o zasadach składania zamówienia - patrz Suplement 12.1 i 12.2, rozdział Systemy narzędziowe.

Portsculă de tarodare

Pentru fiecare sculă de filetare

CE PORTSCULE DE FILETARE SE POTRIVESC NEVOILOR DVS.??



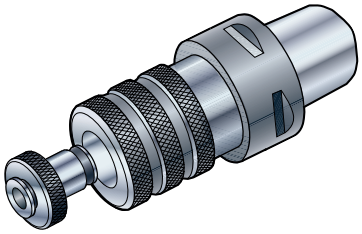
Mandrină specială pentru prinderea tarozilor cu ER SynchroFlex®*

- Prima alegere pentru maşini-unelte CNC şi operații de filetare sincronizate
- Pentru producție în masă şi înaltă precizie
- Portsculă rigidă de filetare cu micro compensare a jocurilor
- Utilizare cu bucşe elastice ER cu echer
- Îmbunătățeşte durata de viață a tarodului, calitatea suprafeței şi oferă securitate la cel mai înalt nivel

* SynchroFlex este marca inregistrata a Tapmatic Corp., USA

Utilizare cu:

- CoroTap™
- Tarod Spectrum™

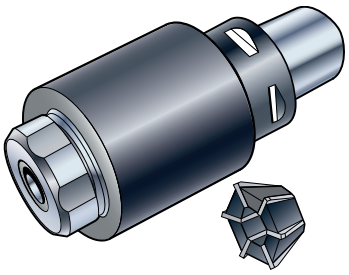


Mandrină pentru prinderea tarozilor cu schimbare rapidă

- Prima alegere pentru operațiile de filetare neprezentată mai sus
- Pentru producție universală mai redusă
- Fixare uşoară a tarodului cu schimbare rapidă
- Tensiune şi comprimare pentru eliminarea erorilor de avans

Utilizare cu:

- Tarod Spectrum™

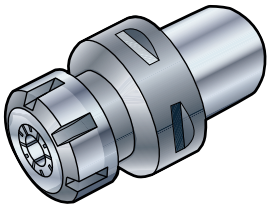


Mandrină cu bucşă elastică din cauciuc

- Model vechi, utilizat adesea la maşinile de strunjit
- Bucşele elastice acoperă o gamă largă de prindere

Utilizare cu:

- Tarod Spectrum™



Mandrină cu bucşă elastică ER

- Producție de serie mică
- Utilizare cu bucşe elastice ER
- Rigid, fără compensare, limitează durata de viață a tarodului

Utilizare cu:

- Tarod Spectrum™

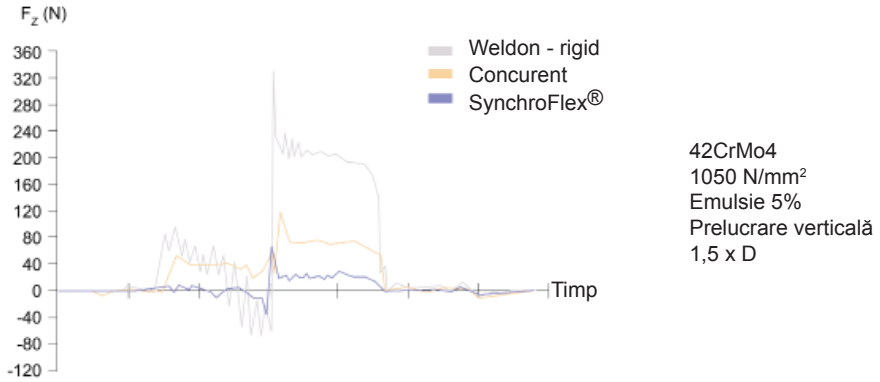
Pentru informații privind sortimentele şi modul de comandă, consultați Suplimentele 12.1 şi 12.2, capitolul Sisteme de prelucrare.

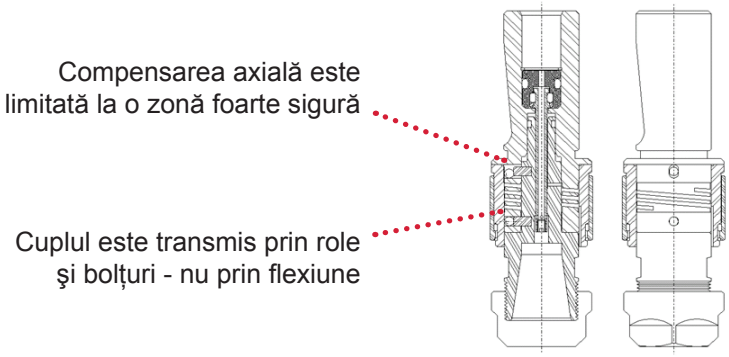
PORT-SCULE PENTRU FILETARE

Procesul de filetare presupune o concordanță complexă între mişcarea de rotație şi cea de avans. Uneori este necesară limitarea mişcării de avans a sculei.

Chiar şi diferențele mici dintre avansul calculat şi pasul efectiv al tarodului pot genera o presiune axială excesivă pe fl ancurile fi letului şi, prin urmare, o creştere a fortei de aşchiere, ceea ce reduce considerabil calitatea fi letului şi durata de viață a sculei.

Portscula de filetare Coromant SynchroFlex® se bazează pe un micro compensator fabricat cu precizie - sau „Flexure“ - care compensează deviațiile de poziție în gama micro atât radial, cât şi axial. Prin urmare, presiunea exercitată pe fl ancurile fi letului poate fi redusă considerabil.





Printre avantajele suplimentare se numără:

- Mai puțină frecare (şi prin urmare mai puțină uzură) oferă o durată de viață mai lungă a sculei
- Precizie mai mare a controlului adâncimii pentru un proces de producție mai precis
- Forma zveltă îmbunătățeşte în mod impresionant evacuarea aşchiilor
- Siguranță mai mare a procesului datorită riscului redus de rupere a tarodului
- Întrucât jocul este limitat la o zonă foarte sigură, flexiunea nu este suprasolicitată şi, prin urmare, portscula nu va obosi şi nu va ceda prin uzură accelerată
- Soluție de filetare completă: portscula este utilizabilă indiferent de geometria tarodului, de ex. tarozi CoroTap™ şi Spectrum™

Utilizabile la maşini CNC cu cicluri de filetare sincronizate, toate bucşele SynchroFlex® sunt disponibile cu alimentare cu lichid de răcire prin interior (până la 80 bari) pentru a îmbunătăți siguranța procesului pe tarod, îndeosebi când se filetează în materiale din oțel inoxidabil (ISO M) şi nichel (ISO S).

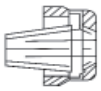
Sunt disponibile interfețe de maşină DIN 1835 B/E, HSK A/C 63 şi Capto, precum şi adaptoare pentru cele mai obişnuite forme de cozi.

Beneficiile sunt maxime când bucşele SynchroFlex® sunt utilizate cu tarozi cu spirală lungă şi detalonare mare.

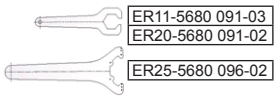
INSTALAREA TARODULUI

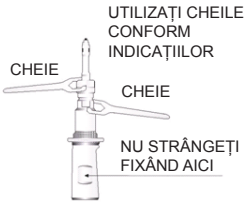
1. Selectați bucşa ER corespunzătoare cu pătrat de antrenare pentru coada tarozilor şi unghi drept
2. Introduceți bucşa în piuliță având grijă să montați gheara piuliței bucşei cu locaşul bucşei

INCORECT

CORECT 

3. Utilizați două chei pentru a strânge bine piulița bucşei. Nu se recomandă să strângeți prinzând coada dispozitivului. Fiți atenți să nu strângeți prea tare piulița, deoarece s-ar putea deteriora elementul de acționare al tarodului.





Valori recomandate de cuplu de strângere a piuliței pentru piulițele bucşei elastice de filetare ER	
Toate ER11	18 Nm/13 ft-lbs
Toate ER20	40 Nm/29 ft-lbs
Toate ER25	130 Nm/95 ft-lbs

MANDRINĂ DE GĂURIT SCHIMBARE RAPIDĂ

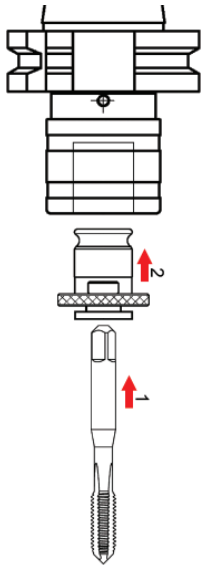
Mandrină de găurit, uşor de utilizat, cu funcție de schimbare rapidă şi functie de compensare la tractiune şi compresiune. Acest tip de portsculă de tarodare este recomandat pentru uz general (GP) / standard / filetare manuală.

Când utilizați un port-tarod flotant la filetarea NC, asigurați-vă că valoarea avansului programat este cea corectă: se recomandă ca mărimea avansului sa fie 95 – 97% din valoarea pasului tarodului. Acest lucru este posibil numai pe tarozi cu spirală care nu sunt de înaltă performanță.

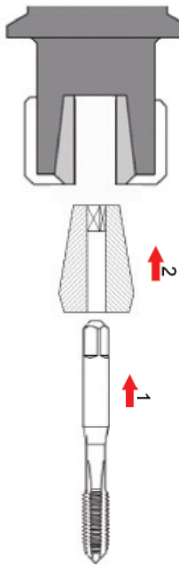
Când utilizați port-scule de tarodare rigidă precum SynchroFlex®* sau mandrine ER, utilizați avans de 100%.

Utilizați cel mai indicat lichid de răcire ungere pentru fiecare aplicație.

PORT-SCULĂ DE TARODARE SCHIMBARE RAPIDĂ



MANDRINĂ BUCŞĂ (STANDARD) (ER)



*SynchroFlex este o marcă înregistrată Tapmatic Corp.,USA

Sortimente de portscule de tarodare

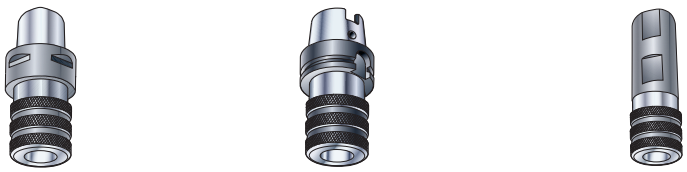
Mandrină specială pentru prinderea pieselor filetate cu tarod ER SynchroFlex®* - pentru operații de filetare sincronizate

Coromant Capto ® Suport monobloc HSK Suport monobloc MAS-BT Coadă prismatică Weldon

A se utiliza cu
Bucşă elastică pentru filetare ER
Pentru filetare cu lichid de răcire prin interior:
disc de etanşare ER
piuliță bucşă elastică ER

Mandrină pentru prinderea pieselor filetate cu tarod cu schimbare rapidă

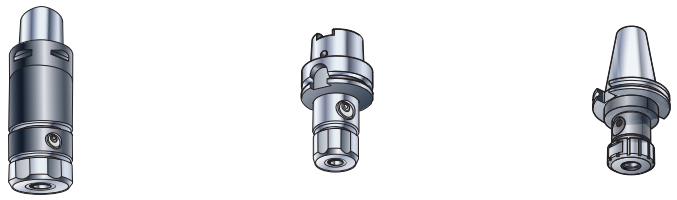
Coromant Capto ® Suport monobloc HSK Coadă prismatică Weldon



A se utiliza cu
Adaptoare de filetare cu schimbare rapidă cu cuplaj cu fricțiune
Adaptoare de filetare cu schimbare rapidă fără cuplaj cu fricțiune

Mandrină cu bucşă elastică din cauciuc plutitor

Coromant Capto ® Suport monobloc HSK Suport monobloc CAT-V



A se utiliza cu
Bucşe elastice din cauciuc

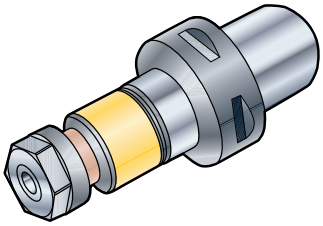
*SynchroFlex este o marcă înregistrată Tapmatic Corp.,USA

Pentru informații privind sortimentele şi modul de comandă, consultați Suplimentele 12.1 şi 12.2, capitolul Sisteme de prelucrare.

Резьбовые патроны

Для любых метчиков

Какие резьбовые патроны удовлетворяют вашим потребностям?



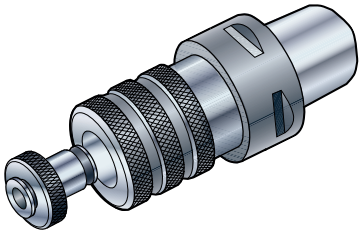
Патрон для метчиков SynchroFlex®* ER

- Первый выбор для станков с ЧПУ с синхронизацией операций резьбонарезания
- Для больших объемов производства и высокой точности
- Жесткий резьбовой патрон с микрокомпенсацией
- Используйте с цангами ER для метчиков с четырехгранником
- Увеличивает срок службы метчиков, улучшает качество поверхности и обеспечивает высочайшую безопасность процесса

* SynchroFlex является зарегистрированной торговой маркой компании Tapmatic Corp., США

Используйте с:

- CoroTap™
- Spectrum™ Tap

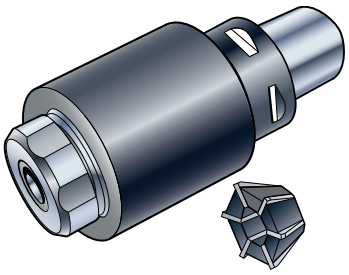


Быстросменный патрон для метчиков

- Первый выбор для операций резьбонарезания, не перечисленных выше
- Для единичных и мелкосерийных производств
- Легкое закрепление метчиков и быстрая замена
- Компенсация ошибок подачи

Используйте с:

- Spectrum™ Tap

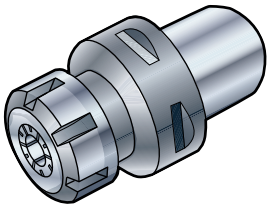


Подвижный патрон для обрезиненных цанг

- Старый тип конструкции, часто используется в небольших токарных станках
- Цанги допускают широкий диапазон закрепляемых диаметров

Используйте с:

- Spectrum™ Tap



Цанговый патрон ER

- Мелкосерийное производство
- Используйте с цангами ER для метчиков с четырехгранником
- Жесткие, без компенсации, ограничивают срок службы метчика

Используйте с:

- Spectrum™ Tap

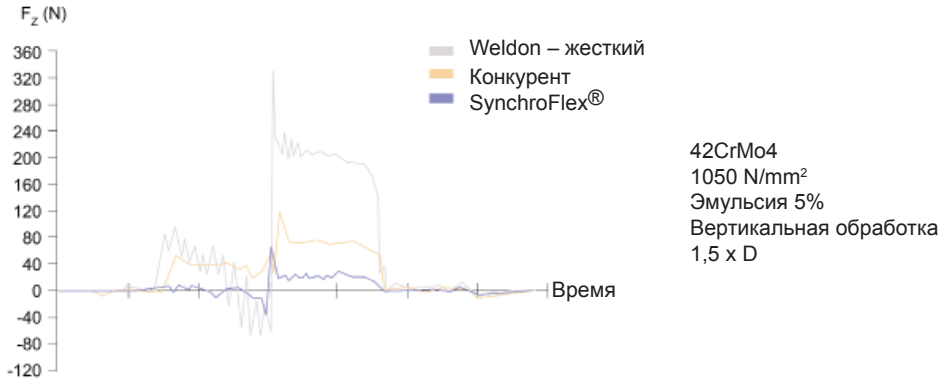
Информация об ассортименте и возможности заказа, см. каталоги „Новые инструменты от Sandvik Coromant“ 12.1 и 12.2.

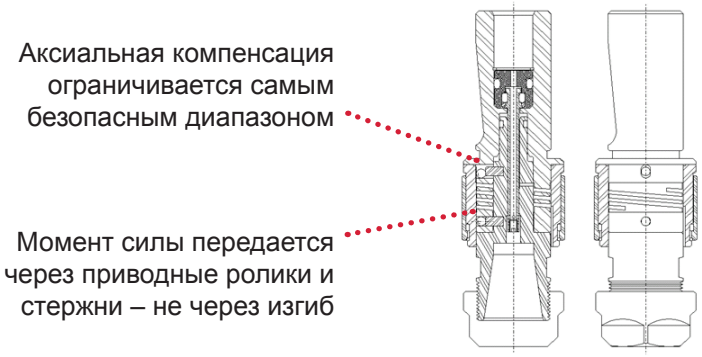
РЕЗЬБОНАРЕЗНЫЕ ПАТРОНЫ

Процесс резьбонарезания – это сложный баланс между вращением и осевым перемещением инструмента. Иногда необходимо ограничивать осевое перемещение инструмента.

Даже мельчайшие различия между расчетной скоростью подачи и действительным шагом метчика может привести к крайне высокому усилию осевой подачи на боковые стороны профиля резьбы и, таким образом, к увеличению давления резания, которое значительно снижает качество резьбы и срок службы инструмента.

Патрон для закрепления метчика компанииCoromantSynchroFlex® базируется на точно изготовленном микрокомпенсаторе, или “изгибе”, который компенсирует радиальные и аксиальные отклонения от заданного положения в микродиапазоне. Таким образом давление, действующее на боковые поверхности метчика, может быть значительно снижено.





Дополнительные преимущества:

- Меньшее трение (и, соответственно, меньший износ) обеспечивает более продолжительный срок службы
- Большая точность при регулировании глубины обработки и более точный процесс производства
- Тонкая конструкция заметно улучшает процесс удаления стружки
- Большая безопасность работы благодаря снижению риска повреждения метчика
- Так как движение ограничено самым безопасным диапазоном, изгиб никогда не подвергается чрезмерному напряжению, поэтому патрон никогда не испытывает усталости материала или износа
- Полное решение нарезания резьбы: держатель скоординирован с геометрией метчика, например метчиков CoroTap™ и Spectrum™

Подходит для использования на станках с ЧПУ с синхронизацией цикла нарезания резьбы. Все патроны SynchroFlex® имеют внутреннюю подачу СОЖ (до 80 бар), повышающую надежность обработки, особенно при нарезании резьбы в деталях из нержавеющей стали (ISO M) и никеля (ISO S).

Доступны соединения DIN 1835 B/E, HSK A/C 63 и Capto, а также адаптеры для других распространенных систем.

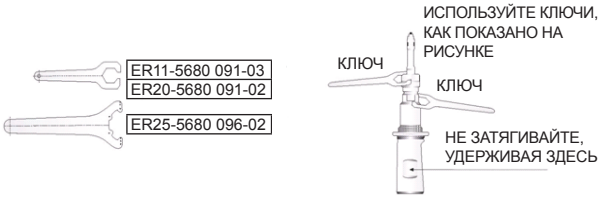
Эффективность повышается при использовании патронов SynchroFlex® с метчиками с большим углом подъема витка спирали.

УСТАНОВКА МЕТЧИКА

1. Выберите требуемую цангу ER по хвостовику метчика
2. Вставьте цангу в гайку и, убедившись, что лепестки цанги охвачены гайкой, накрутите гайку на патрон

НЕПРАВИЛЬНО ПРАВИЛЬНО

3. Вставьте метчик и при помощи двух гаечных ключей затяните гайку до упора. Будьте осторожны и не затягивайте гайку чрезмерно, так как это может привести к повреждению патрона.



Рекомендованные значения момента затяжки гайки патрона ER для нарезания резьбы	
Всеl ER11	18 Нм/13 фунтов силы-фут
Все ER20	40 Нм/29 фунтов силы-фут
Все ER25	130 Нм/95 фунтов силы-фут

БЫСТРОСМЕННЫЙ ПАТРОН ДЛЯ МЕТЧИКА

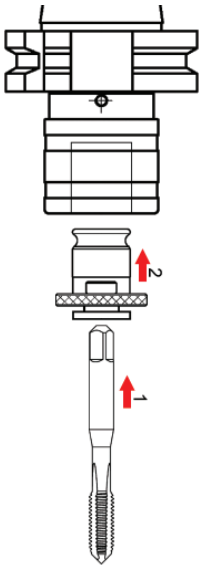
Удобный патрон для метчика с функцией быстрой замены и механизмом полной затяжки и сжатия. Этот тип патронов рекомендуется для метчиков общего назначения (GP) / стандартных/ручных.

При использовании плавающих приспособлений для нарезания резьбы метчиком в станках с ЧПУ убедитесь в правильности выбранного для программы значения подачи: При шаге от 95% до 97% рекомендуется позволить метчику выработать собственный шаг. Это возможно только при применении невысокопроизводительных метчиков с винтовыми канавками.

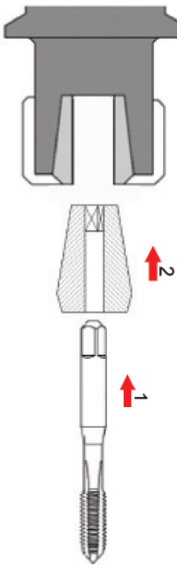
При использовании жестких патронов для метчика, таких, как SynchroFlex®* или зажимных патронов ER используйте 100% подачу.

Всегда используйте СОЖ, соответствующую выполняемой операции.

БЫСТРОСМЕННЫЙ ПАТРОН ДЛЯ МЕТЧИКА



ЦАНГОВЫЙ ЗАЖИМНЫЙ ПАТРОН (СТАНДАРТНЫЙ) (ER)

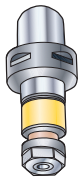


*SynchroFlex – это зарегистрированный товарный знак фирмы Tapmatic Corp., USA.

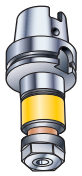
Ассортимент резьбовых патронов

Патрон SynchroFlex® ER* для резьбонарезания с синхронизацией

Coromant Capto ®

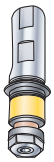


Адаптер HSK



Адаптер MAS-BT

Адаптер для хвостовика Weldon



Для использования с
Цанга ER для метчиков
Для использования при резьбонарезании с внутренним подводом СОЖ:
Уплотнительный диск ER
Гайка для цанг ER

Быстросменный патрон для метчиков

Coromant Capto ®

Адаптер HSK

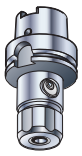
Адаптер для хвостовика Weldon

Для использования с
Быстросменные адаптеры для резьбонарезания с фрикционной муфтой
Быстросменные адаптеры для резьбонарезания без фрикционной муфты

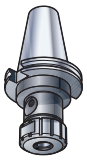
Floating rubber collet chuck

Coromant Capto ®

Адаптер HSK



Адаптер CAT-V



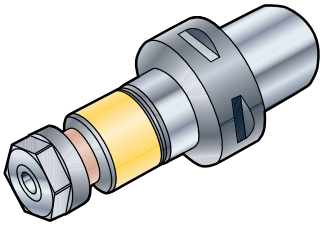
Для использования с
Обрезиненные цанги

*SynchroFlex – это зарегистрированный товарный знак фирмы Tapmatic Corp., USA.

Информация об ассортименте и возможности заказа, см. каталоги „Новые инструменты от Sandvik Coromant“ 12.1 и 12.2.

For every tapping tool

WHICH TAP HOLDERS FIT YOUR NEED?



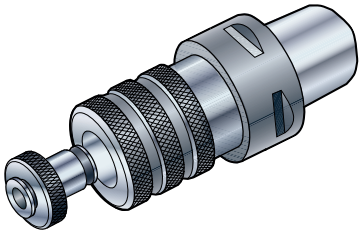
SynchroFlex®* ER tapping chuck

- First-choice for CNC machine tools and synchronized tapping operations
- For high volume production and high precision
- Rigid tap holder with micro-float compensation
- Use with ER tapping collets with square
- Improves tap tool life, surface quality and provides highest process security

* SynchroFlex is a registered tradmark of Tapmatic Corp., USA

Use with:

- CoroTap™
- Spectrum™ Tap

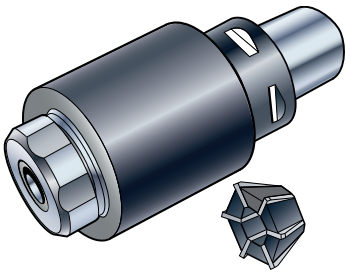


Quick change tapping chuck

- First-choice for tapping operations not included above
- For all-round, lower volume production
- Easy tap holding with quick change
- Tension and compression to eliminate feed error

Use with:

- Spectrum™ Tap

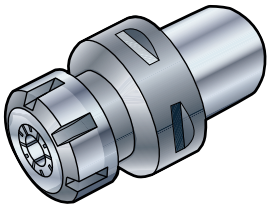


Floating rubber collet chuck

- Old style, often used in small turning machines
- The collets cover a wide clamping range

Use with:

- Spectrum™ Tap



ER collet chuck

- Low batch production
- Use with ER tapping collets with square
- Stiff, no compensation, limits tap tool life

Use with:

- Spectrum™ Tap

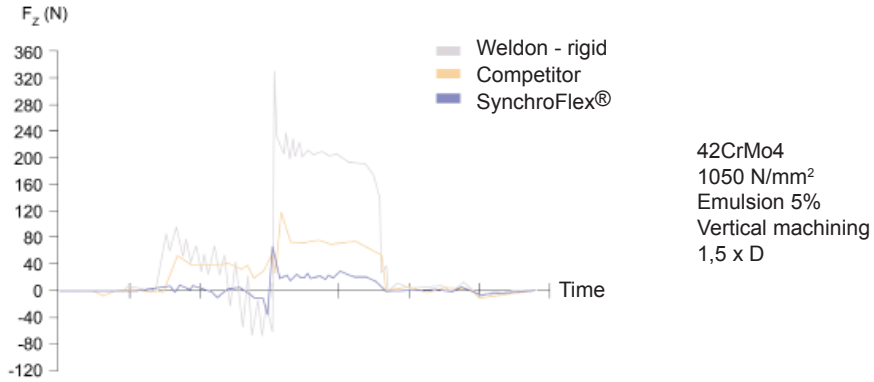
For ordering information, see separate Tap catalogue, C-2900:139, available for order or download at www.sandvik.coromant.com

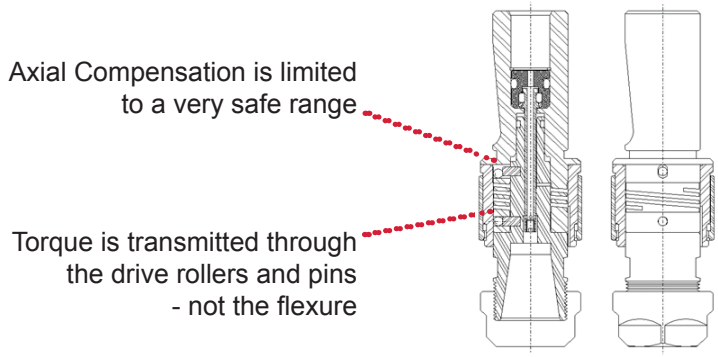
TAPPING ATTACHMENTS

The process of tapping is a complex balance of rotational and axial movements of the tool. It is sometimes necessary to restrict the axial movements of the tool.

Even micro differences between the calculated feed and the actual pitch of the tap can lead to extremely high thrust forces on the thread flanks and therefore an increase in cutting pressure, which considerably reduces thread quality and tool life.

Coromant's SynchroFlex® tap holder is based on a precisely manufactured micro compensator - or "Flexure" - which compensates for positional deviations in the micro range radially as well as axially. Consequently, pressure exerted on the tap flanks can be reduced considerably.





Additional benefits include:

- Less friction (and therefore less wear) gives longer tool life
- Greater accuracy of depth control for a more precise production process
- Slim design dramatically improves chip evacuation
- Greater process security due to the reduced risk of tap breakage
- As movement is limited to a very safe range the flexure is never overstressed and, therefore, the holder will never fatigue or wear out
- Complete threading solution: holder is coordinated to the geometry of the tap e.g. CoroTap™ and Spectrum™ taps

Suitable for use on CNC machines with synchronised tapping cycles, all SynchroFlex® tap holders are available with internal coolant supply (up to 80 bar) to further improve process security on the tap, especially when threading in stainless steel (ISO M) and nickel (ISO S) materials.

DIN 1835 B/E, HSK A/C 63 and Capto machine interfaces are available, as well as adapters for most common back-end systems.

Benefits are maximised when SynchroFlex® tap holders are used with taps with high spiral and high relief.

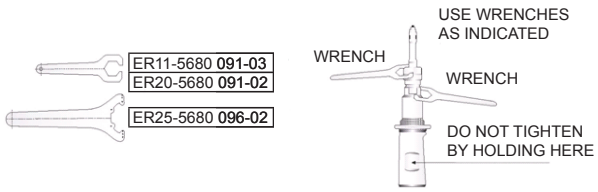
INSTALLING THE TAP

1. Select the proper square drive ER collet for the taps' shank and square
2. Insert the collet into the nut being sure to fix paw of collet nut with the seat of the collet

INCORRECT

CORRECT

3. Use two wrenches to tighten the collet nut firmly. It is not recommended to tighten by gripping the shank of the attachment. Use caution not to over tighten the nut, as this can cause damage to the tap driver.



Recommended Nut tightening Torque Values for ER tapping Collet Nuts	
All ER11	18 Nm/13 ft-lbs
All ER20	40 Nm/29 ft-lbs
All ER25	130 Nm/95 ft-lbs

QUICK CHANGE TAP HOLDING

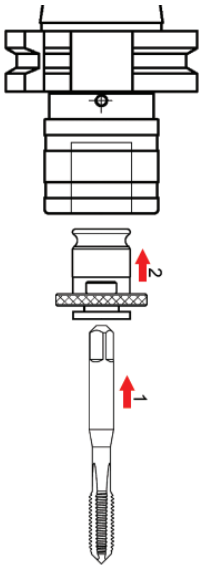
Easy tap holding with quick change function and full tension and compression movement. This type of tap holder is recommended for General Purpose (GP) / standard / hand taps.

When using a floating tapping attachment in NC applications ensure that the feed value chosen for the program is correct: 95% to 97% of the pitch is recommended to allow the tap to generate its own pitch. This is only possible on non-high-performance spiral taps.

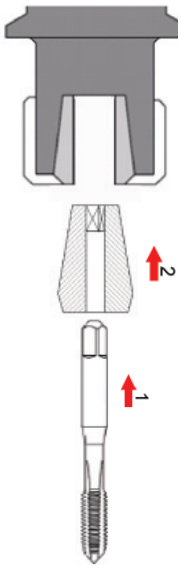
When using Rigid tap holders like SynchroFlex® or ER chucks, use 100% feed.

Always use appropriate cutting fluid for each application.

QUICK CHANGE TAP HOLDER



COLLET CHUCK (STANDARD) (ER)

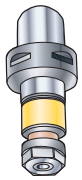


SynchroFlex® is a registered trademark of Tapmatic Corp., USA

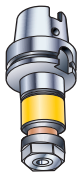
Tapping holder assortment

SynchroFlex ® * ER tapping chuck - for synchronized tapping

Coromant Capto ®

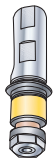


HSK Solid holder



MAS BT solid holder

Weldon shank holder



To be used with
ER sealing disc, page
For through coolant tapping use:
ER collet nut, page
ER tapping collet page

Quick change tapping chuck

Coromant Capto ®

HSK Solid holder

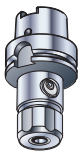
Weldon shank holder

To be used with
Quick change tapping adaptors with friction clutch, page
Quick change tapping adaptors without friction clutch, page

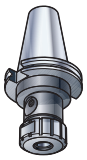
Floating rubber collet chuck

Coromant Capto ®

HSK Solid holder



CAT-V solid holder



To be used with
Rubber collets, page

*SynchroFlex® is a registered trademark of Tapmatic Corp., USA

For ordering information, see separate Tap catalogue, C-2900:139, available for order or download at www.sandvik.coromant.com

Všeobecné symboly / Alkalmazott szimbólumok / Ikony / Icoane comune / Общие обозначения / Common icons

Materiál
Anyag
Materiał
Material
Материал
Material

HM

Slinutý karbid
Keményfém
Węglik spiekany
Carbura
Твердый сплав
Carbide

HSS

Rychlořezná ocel
Gyorsacél
Stal szybkotnąca
Otel rapid
Быстрорежущая сталь
High Speed Steel

HSS-E

Kobaltová rychlořezná ocel
Kobalttal ötvözött gyorsacél
Szybkotnąca stal kobaltowa
Otel rapid cu Co
Быстрорежущая сталь с кобальтом
High Speed Cobalt

HSS-PM

Prášková rychlořezná ocel
Porkohászati gyorsacél
Szybkotnąca stal proszkowa
Otel rapid sinterizat
Порошковая быстрорежущая сталь
High Speed Powder Steel

HSS-E-PM

Prášková kobaltová rychlořezná ocel
Kobalttal ötvözött porkohászati gyorsacél
Szybkotnąca proszkowa stal kobaltowa
Otel rapid cu Co sinterizat
Порошковая быстрорежущая сталь с кобальтом
HSS-E powder metallurgy steel

Povlak
Bevonatok
Pokrycie
Acoperire
Покрытие
Coating

Cool TOP

Optimální kombinace vysoké tvrdosti a odolnosti proti otěru
Optimális kombinációja a keménységnek és kopásállóságnak
Optymalna kombinacja wysokiej twardości i odporności na ścieranie
Combinatia optima intre duritatea taisului si uzura de abraziune
Оптимальная комбинация высокой прочности и стойкости к абразивному износу
Optimal combination of high hardness and abrasive wear

Smooth TOP

Nízký koeficient tření snižující adhezi materiálu k břitu nástroje na minimum
Az alacsony súrlódási tényező minimálisra csökkenti az anyag feltapadását a forgácsoló élre
Niski współczynnik tarcia minimalizuje zużycie adhezyjne krawędzi skrawających
Acoperire cu coeficient de frecare redus micsorind depunerile de material pe tais.
Низкий коэффициент трения минимизирует налипание обрабатываемого материала на режущую кромку
Low friction coefficient minimise material adhesion to the cutting edge

Lesklý bez povlaku
Fényes
Polerowany
Lucios
Полирование
Bright

ST

Parní oxidace
Gőzzel kezelt
Oksydowany
Brunare
Оксидирование
Steam tempered

TiCN

Karbonitrid titanu
Titán-karbonitrid
Węgloazotek tytanu
Carbonitrura de titan
Карбонитрид титана
Titanium Carbo Nitride

CrN

Nitrid chromu
Kromnitrid
Azotek chromu
Nitrura de crom
Нитрид хрома
Chromium Nitride

TiN

Nitrid titanu
Titánnitrid
Azotek tytanu
Nitrura de titan
Нитрид титана
Titanium Nitride

Význam ostatních použitých symbolů/ Szimbólumok menetmegmunkáláshoz / Ikony-Gwintowanie / Icoane filetare / Описание обозначений для резьбового инструмента / Threading icons

Typ závitu
Menet tipusok
Rodzaj gwintu
Forma filetului
Тип резьбы
Metric Coarse

Metrický
Normál menet
Metryczny
Metric
Метрическая
Metric Coarse

Metrický jemný
Finommenet
Metryczny drobnozwojny
Metric fin
Метрическая с мелким шагом
Metric Fine

UNC

UNF

NPT

NPTF

G

Typ díry
Furat tipus
Rodzaj otworu
Tip gaura
Тип отверстия
Hole type

Průchozí díra
Átmenő furat
Otwór przelotowy
Gaura strapunsa
Сквозное отверстие
Through hole

Slepá díra
Zsákfurat
Otwór nieprzelotowy
Gaura infundata
Глухое отверстие
Blind hole

Průchozí nebo slepá díra
Átmenő vagy zsákfurat
Otwór przelotowy lub nieprzelotowy
Gaura strapunsa sau infundata
Сквозное или глухое отверстие
Through or blind hole

Řezná kapalina
Hűtés
Chłodziwo
Racire
СОЖ
Coolant

Vnitřní přívod
Belső hűtés
Chłodzenie wewnętrzne
Racire interna
подача СОЖ через инструмент
Internal Coolant

Vnitřní přívod
Belső hűtés
Chłodzenie wewnętrzne
Racire interna
подача СОЖ через инструмент
Internal Coolant

Náběh
Bekezdőkúp
Nakrój
Conul de atac
Заборный конус
Chamfer

Náběh B 3.5 - 5
B tipusú 3.5 - 5
Nakrój B 3.5 - 5
Con B 3.5 - 5
Заборный конус типа B 3.5 - 5
Chamfer No. B 3.5 - 5

Náběh C 2 - 3
C tipusú 2 - 3
Nakrój C 2 - 3
Con C 2 - 3
Заборный конус типа C 2 - 3
Chamfer No. C 2 - 3

Náběh C 2 - 3.5
C tipusú 2 - 3.5
Nakrój C 2 - 3.5
Con C 2 - 3.5
Заборный конус типа C 2 - 3.5
Chamfer No. C 2 - 3.5

Náběh E 1 - 2
E tipusú 1 - 2
Nakrój E 1 - 2
Con E 1 - 2
Заборный конус типа E 1 - 2
Chamfer No. E 1 - 2

SANDVIK Coromant

Význam ostatních použitých symbolů / Szimbólumok menetmegmunkáláshoz / Ikony-Gwintowanie / Icoane filetare / Описание обозначений для резьбового инструмента / Threading icons

Hloubka
Fúrási mélység
Głębokość
Adancimea
Глубина
Depth

Geometrie drážky
Horony geometria
Rowek wiórowy
Geometria canalului
Геометрия канавки метчика
Flute Geometry

Přímá drážka
Egyenes horony
Prosty rowek wiórowy
Canale drepte
Прямая канавка
Straight flute

Přímá s lamačem
Terelőél
Ze skośną powierzchnią natarcia
Varf spiral
Спиральная подточка
Spiral point

Šroubovitá drážka 10°
10°-os csavarthorony
Śrubowy rowek wiórowy 10°
Canal elicoidal 10°
Спиральная канавка 10°
Spiral flute 10°

Šroubovitá drážka 15°
15°-os csavarthorony
Śrubowy rowek wiórowy 15°
Canal elicoidal 15°
Спиральная канавка 15°
Spiral flute 15°

Šroubovitá drážka 27°
27°-os csavarthorony
Śrubowy rowek wiórowy 27°
Canal elicoidal 27°
Спиральная канавка 27°
Spiral flute 27°

Šroubovitá drážka 30°
30°-os csavarthorony
Śrubowy rowek wiórowy 30°
Canal elicoidal 30°
Спиральная канавка 30°
Spiral flute 30°

Šroubovitá drážka 35°
35°-os csavarthorony
Śrubowy rowek wiórowy 35°
Canal elicoidal 35°
Спиральная канавка 35°
Spiral flute 35°

Šroubovitá drážka 40°
40°-os csavarthorony
Śrubowy rowek wiórowy 40°
Canal elicoidal 40°
Спиральная канавка 40°
Spiral flute 40°

Šroubovitá drážka 45°
45°-os csavarthorony
Śrubowy rowek wiórowy 45°
Canal elicoidal 45°
Спиральная канавка 45°
Spiral flute 45°

Šroubovitá drážka 48°
48°-os csavarthorony
Śrubowy rowek wiórowy 48°
Canal elicoidal 48°
Спиральная канавка 48°
Spiral flute 48°

Bez drážek
Menetformázó
Gwintowygniatak bezrowkowy
Fara canale
Безканавочный
Fluteless

Význam ostatních použitých symbolů / Szimbólumok menetmegmunkáláshoz / Ikony-Gwintowanie / Icoane filetare / Описание обозначений для резьбового инструмента / Threading icons

Norma
Szabvány
Norma wymiarowa
Standard
Стандарт
Standard

DIN 371≤10 376≥12	DIN 371	DIN 374
DIN 376	DIN 2174	DIN 2184-1
DIN 40435	DIN 5156	DIN ANSI
ISO 529	~DIN 371	

Tolerance
Tűrés
Kl. tolerancji
Toleranta
Допуск
Tolerance

2B	2BX	2B 3B	Normal	
6H	6HX	6H mod.	6G	6GX

SANDVIK Coromant

Srovnávací rejstřík materiálů/Anyagok kereszthivatkozási táblázatai/ Tabele odnośników materiałów/Tabel cu referinţe privind materialele/ Таблицы перекрестных ссылок на материалы/Material Cross Reference Tables

Norma a stát/region//Standard és Ország/Régió//Standard i kraj/region//Standard şi Ţară/Regiune//Стандарт и страна/регион//Standard & Country/Region

ISO	MC-code	Dormer AMG	Europe DIN EN	Germany W.-nr	UK BS	EN	Sweden SS	USA AISI/SAE/ASTM	France AFNOR	Italy UNI	Spain UNE	Japan JIS
P	**Nelegované oceli/Ötvözetlen acél/Stale niestopowe/Oţeluri nealiate/Нелегированная сталь/ Unalloyed steels**											
	P1.1.Z.AN	1.2	S235JR G2	1.0038	4360 40 C		1311	A570.36	E 24-2 Ne			STKM 12A;C
	P1.1.Z.AN	1.2	S235J2 G3	1.0116	4360 40 B		1312	A573-81 65	E 24-U	Fe37-3		
	P1.1.Z.AN	1.2	C15	1.0401	080M15	-	1350	1015	CC12	C15C16	F.111	-
	P1.1.Z.AN	1.2	C22	1.0402	050A20	2C/2D	1450	1020	CC20	C20C21	F.112	-
	P1.1.Z.AN	1.2	C15E	1.1141	080M15	32C	1370	1015	XC12	C16	C15K	S15C
	P1.1.Z.AN	1.2	C25E	1.1158	-	-	–	1025	-	-	-	S25C
	P1.1.Z.AN	1.2	S380N	1.8900	4360 55 E		2145	A572-60	-	FeE390KG		
	P1.1.Z.AN	1.3	17MnV7	1.0870	4360 55 E		2142	A572-60	NFA 35-501 E 36	-	-	
	P1.1.Z.AN	1.3	55Si7	1.0904	250A53	45	2085	9255	55S7	55Si8	56Si7	-
	P1.1.Z.HT	1.3	-	-	-	-	2090	9255	55S7	-	-	-
	P1.2.Z.AN	1.2	S275J2G3	1.0144	4360 43C		1412	A573-81	E 28-3	-	-	SM 400A;B;C
	P1.2.Z.AN	1.2	S355J2G3+C2	1.0570	4360 50B		2132	-	E36-3	Fe52BFN/ Fe52CFN	-	SM490A;B;C; YA;YB
	P1.2.Z.AN	1.2	S355J2G3	1.0841	150 M 19		2172	5120	20 MC 5	Fe52	F-431	
	P1.2.Z.AN	1.3	C35	1.0501	060A35	-	1550	1035	CC35	C35	F.113	-
	P1.2.Z.AN	1.3	C45	1.0503	080M46	-	1650	1045	CC45	C45	F.114	-
	P1.2.Z.AN	1.3	40Mn4	1.1157	150M36	15	-	1039	35M5	-	-	-
	P1.2.Z.AN	1.3	36Mn5	1.1167	–	–	2120	1335	40M5	-	36Mn5	SMn438(H)
	P1.2.Z.AN	1.3	28Mn6	1.1170	150M28	14A	-	1330	20M5	C28Mn	-	SCMn1
	P1.2.Z.AN	1.3	C35G	1.1183	060A35	-	1572	1035	XC38TS	C36	-	S35C
	P1.2.Z.AN	1.3	C45E	1.1191	080M46	-	1672	1045	XC42	C45	C45K	S45C
	P1.2.Z.AN	1.3	C53G	1.1213	060A52	-	1674	1050	XC48TS	C53	-	S50C
	P1.2.Z.AN	1.3	C55	1.0535	070M55	-	1655	1055	-	C55	-	-
	P1.2.Z.AN	1.3	C55E	1.1203	070M55	-	-	1055	XC55	C50	C55K	S55C
	P1.3.Z.AN	1.3	C60E	1.0601	080A62	43D	-	1060	CC55	C60	-	-
	P1.3.Z.AN	1.3	C60E	1.1221	080A62	43D	1678	1060	XC60	C60	-	S58C
	P1.3.Z.AN	1.3	C101E	1.1274	060 A 96		1870	1095	XC 100	-	F-5117	
	P1.3.Z.AN	1.3	S340 MGC	1.0961	-	-	-	9262	60SC7	60SiCr8	60SiCr8	-
	P1.3.Z.AN	1.4	C101u	1.1545	BW 1A		1880	W 1	Y105	C36KU	F-5118	SK 3
	P1.3.Z.AN	1.4	C105W1	-	BW2	-	2900	W210	Y120	C120KU	F.515	SUP4
	P1.4.Z.AN	1.2	11SMn30	1.0715	230M07	-	1912	1213	S250	CF9SMn28	11SMn28	SUM22
	P1.4.Z.AN	1.2	11SMnPb30	1.0718	-	-	1914	12L13	S250Pb	CF9SMnPb28	11SMnPb28	SUM22L
	P1.4.Z.AN	1.2	10SPb20	1.0722	-	-	-	-	10PbF2	CF10SPb20	10SPb20	-
	P1.4.Z.AN	1.2	11SMn37	1.0736	240M07	1B	-	1215	S 300	CF9SMn36	12SMn35	-
	P1.4.Z.AN	1.2	11SMnPb37	1.0737	-	-	1926	12L14	S300Pb	CF9SMnPb36	12SMnP35	-
	P1.4.Z.AN	1.2	35S20	1.0726	212M36	8M	1957	1140	35MF4	-	F210G	-
	P1.5.C.UT	1.2	GC16E	1.1142	030A04W	1A	1325	1115	-	-	-	-
	Nízkolegované oceli/Gyengén ötvözött acél/Stale niskostopowe/Oţeluri slab aliate/ Низколегированная сталь/Low-alloyed steels											
	P2.1.Z.AN	1.3	16MnCr5	1.7139	-	-	2127	-	-	-	-	-
	P2.1.Z.AN	1.4-1.6	16Mo3	1.5415	1501-240	-	2912	A204Gr.A	15D3	16Mo3KW	16Mo3	-
	P2.1.Z.AN	1.4-1.6	14Ni6	1.5622	-	-	-	A350LF5	16N6	14Ni6	15Ni6	-
	P2.1.Z.AN	1.4-1.6	21NiCrMo2	1.6523	805M20	362	2506	8620	20NCD2	20NiCrMo2	20NiCrMo2	SNCM220(H)
	P2.1.Z.AN	1.4-1.6	17CrNiMo6	1.6587	820A16	-	-	-	18NCD6	-	14NiCrMo13	-
	P2.1.Z.AN	1.4-1.6	15Cr3	1.7015	523M15	-	-	5015	12C3	-	-	SCr415(H)
	P2.1.Z.AN	1.4-1.6	55Cr3	1.7176	527A60	48	-	5155	55C3	-	-	SUP9(A)
	P2.1.Z.AN	1.4-1.6	15CrMo5	1.7262	2127	-	2216	-	12CD4	-	12CrMo4	SCM415(H)
	P2.1.Z.AN	1.4-1.6	13CrMo4-5	1.7335	1501-620Gr27	-	-	A182 F11;F12	15CD3.5	14CrMo45	14CrMo45	-
	P2.1.Z.AN	1.4-1.6	10CrMo9 10	1.7380	1501-622Gr. 31;45	-	2218	A182 F.22	12CD9, 10	12CrMo9, 10	TU.H	-
	P2.1.Z.AN	1.4-1.6	14MoV6 3	1.7715	1503-660-440	-	-	-	-	-	13MoCrV6	-
	P2.1.Z.AN	1.4-1.6	50CoMo4	1.7228	823M30	33	2512	-	-	653M31	-	-
	P2.1.Z.AN	1.4-1.6	14NiCrMo134	1.6657	832M13	36C	-	-	-	15NiCrMo13	14NiCrMo131	-
	P2.1.Z.AN	1.4-1.6	16Mo5	1.5423	1503-245-420	-	-	4520	-	16Mo5	16Mo5	-
	P2.1.Z.AN	1.4-1.6	22Mo4	1.5419	605A32	-	2108	8620	25CD4	-	F520.S	-
	P2.1.Z.AN/P2.5.Z.HT	1.4-1.6	25CrMo4	1.7218	1717CDS110	-	2225	4130	16MC5	25CrMo4(KB)	AM26CrMo4	SCM420; SCM430
	P2.1.Z.AN/P2.5.Z.HT	1.4-1.6	16MnCr5	1.7131	(527M20)	-	2511	5115	35CD4	16MnCr5	16MnCr5	-
	P2.1.Z.AN/P2.5.Z.HT	1.4-1.6	34CrMo4	1.7220	708A37	19B	2234	4137;4135	42CD4TS	35CrMo4	34CrMo4	SCM432; SCCRM3
	P2.1.Z.AN/P2.5.Z.HT	1.4-1.6	41CrMo4	1.7223	708M40	19A	2244	4140;4142	42CD4	41CrMo4	42CrMo4	SCM 440
	P2.1.Z.AN/P2.5.Z.HT	1.4-1.6	42CrMo4	1.7225	708M40	19A	2244	4140	30 CD 12	42CrMo4	42CrMo4	SCM440(H)
	P2.2.Z.AN	1.4-1.6	31CrMo12	1.8515	722 M 24		2240	-	-	30CrMo12	F-1712	
	P2.2.Z.AN	1.4-1.6	39CrMoV13 9	1.8523	897M39	40C	-	-	-	36CrMoV12	-	
	P2.2.Z.AN	1.4-1.6	41CrS4	1.7039	524A14	-	2092	L1	-	105WCR 5	-	-
	P2.2.Z.AN	1.4-1.6	45WCrV7	1.2542	BS1	-	2710	S1	-	45WCrV8KU	45WCrSi8	-
	P2.2.Z.AN	1.4-1.6	40NiCrMo8-4	1.6562	311-Type 7	-	-	8740	-	40NiCrMo2(KB)	40NiCrMo2	SNCM240
	P2.2.Z.AN	1.4-1.6	42Cr4	1.7045	-	-	2245	5140	-	-	42Cr4	SCr440
	P2.2.Z.AN	1.4-1.6	31NiCrMo14	1.5755	830 M 31		2534	-	55NCV6	-	F-1270	
	P2.2.Z.AN	1.6	50NiCr13	1.2721	-		2550	L6	40NCD3	-	F-528	

Ocel/Acél/Stal/Oţel/Сталь/Steel

Norma a stát/region//Standard és Ország/Régió//Standard i kraj/region//Standard şi Ţară/Regiune//Стандарт и страна/регион//Standard & Country/Region

ISO	MC-code	Dormer AMG	Europe DIN EN	Germany W.-nr	UK BS	EN	Sweden SS	USA AISI/SAE/ASTM	France AFNOR	Italy UNI	Spain UNE	Japan JIS
P	P2.2.Z.AN/P2.5.Z.HT	1.4-1.6	36CrNiMo4	1.6511	816M40	110	-	9840	35NCD6	38NiCrMo4(KB)	35NiCrMo4	-
	P2.2.Z.AN/P2.5.Z.HT	1.4-1.6	34CrNiMo6	1.6582	817M40	24	2541	4340	32C4	35NiCrMo6(KB)	-	-
	P2.2.Z.AN/P2.5.Z.HT	1.4-1.6	34Cr4	1.7033	530A32	18B	-	5132	42C4	34Cr4(KB)	35Cr4	SCr430(H)
	P2.2.Z.AN/P2.5.Z.HT	1.4-1.6	41Cr4	1.7035	530A40	18	-	5140	30CD12	41Cr4	42Cr4	SCr440(H)
	P2.2.Z.AN/P2.5.Z.HT	1.4-1.6	32CrMo12	1.7361	722M24	40B	2240	-	50CV4	32CrMo12	F.124.A	-
	P2.2.Z.AN/P2.5.Z.HT	1.4-1.6	51CrV4	1.8159	735A50	47	2230	6150	40CAD6, 12	50CrV4	51CrV4	SUP10
	P2.2.Z.AN/P2.5.Z.HT	1.4-1.6	41CrAlMo7	1.8509	905M39	41B	2940	-	100C6	41CrAlMo7	41CrAlMo7	-
	P2.3.Z.AN	1.4-1.6	100Cr6	1.3505	534A99	31	2258	52100	105WC13	100Cr6	F.131	SUJ2
	P2.3.Z.AN/H1.2.Z.HA	1.4-1.6	105WCr6	1.2419	-	-	2140	-	105WC13	10WCr6	105WCr5	SKS31
	P2.3.Z.AN/H1.2.Z.HA	1.4-1.6	-	1.2714	-	-	-	L6	55NCDV7	-	F.520.S	SKT4
	P2.3.Z.AN/H1.3.Z.HA	1.4-1.6	100Cr6	1.2067	BL3	-	-	L3	Y100C6	-	100Cr6	-
	P2.5.Z.HT	1.4-1.6	36NiCr6	1.5710	640A35	111A	-	3135	35NC6	-	-	SNC236
	P2.5.Z.HT	1.4-1.6	14NiCr10	1.5732	-	-	-	3415	14NC11	16NiCr11	15NiCr11	SNC415(H)
	P2.5.Z.HT	1.4-1.6	14NiCr14	1.5752	655M13; A12	36A	-	3415;3310	12NC15	-	-	SNC815(H)
	P2.6.C.UT	1.3	14NiCr14	-	-	-	2223	-	-			
Ocel/Acél/Stal/Oţel/Сталь/Steel	**Vysokolegované oceli/Erősen ötvözött acél/Stale wysokostopowe/Oţeluri înalt aliate/ Высоколегированная сталь/High-alloyed steels**											
	P3.0.Z.AN	1.4-1.6 (1.8)	X210Cr12	1.2080	BD3	-	-	D3	Z200C12	X210Cr13KU	X210Cr12	SKD1
	P3.0.Z.AN	1.4-1.6 (1.8)	X43Cr13	1.2083			2314					
	P3.0.Z.AN	1.4-1.6 (1.8)	X40CrMoV5 1	1.2344	BH13	-	2242	H13	Z40CDV5	X35CrMoV05KU	X40CrMoV5	SKD61
	P3.0.Z.AN	1.4-1.6 (1.8)	X100CrMoV5 1	1.2363	BA2	-	2260	A2	Z100CDV5	X100CrMoV51KU	X100CrMoV5	SKD12
	P3.0.Z.AN	1.4-1.6 (1.8)	X210CrW12	1.2436	-	-	2312	-	-	X215CrW12 1KU	X210CrW12	SKD2
	P3.0.Z.AN	1.4-1.6 (1.8)	X30WCrV9 3	1.2581	BH21	-	-	H21	Z30WCV9	X28W09KU	X30WCrV9	SKD5
	P3.0.Z.AN	1.4-1.6 (1.8)	X165CrMoV 12	1.2601	-	-	2310	-	-	X165CrMoW12KU	X160CrMoV12	-
	P3.0.Z.AN	1.4-1.6 (1.8)	X8Ni9	1.5662	1501-509;510	-	-	ASTM A353	-	X10Ni9	XBNi09	-
	P3.0.Z.AN	1.4-1.6 (1.8)	12Ni19	1.5680	-		-	2515	Z18N5	-	-	-
	P3.0.Z.HT	1.4-1.6 (1.8)	X155CrMoV12-1	1.2379	-	-	2736	HNV3	-	-	-	-
	P3.1.Z.AN	1.4-1.6 (1.8)	S6-5-2	1.3343	4959BA2	-	2715	D3	Z40CSD10	15NiCrMo13	-	SUH3
	P3.1.Z.AN	1.4-1.6 (1.8)	-	1.3343	BM 2		2722	M 2	Z85WDCV	HS 6-5-2-2	F-5603.	SKH 51
	P3.1.Z.AN	1.4-1.6 (1.8)	HS 6-5-2-5	1.3243	BM 35		2723	M 35	6-5-2-5	HS 6-5-2-5	F-5613	SKH 55
	P3.1.Z.AN	1.4-1.6 (1.8)	HS 2-9-2	1.3348	-		2782	M 7	-	HS 2-9-2	F-5607	-
	P3.2.C.AQ	1.4-1.6 (1.8)	G-X120Mn12	1.3401	Z120M12	-	2183	L3	Z120M12	XG120Mn12	X120Mn12	SCMnH/1
	Feritické/Martenzitické korozivzdorné oceli//Ferrites és martenzites rozsdamentes acél//Stale nierdzewne ferrytyczne/martenzytyczne// Oţeluri inoxidabile feritice/martensitice//Ферритная и мартенситная нержавеющая сталь//Ferritic/Martensitic stainless steels											
	P5.0.Z.AN/P5.0.C.UT	2.2	X10CrAL13	1.4724	403S17	-	-	405	Z10C13	X10CrAl12	F.311	SUS405
	P5.0.Z.AN/P5.0.C.UT	2.2	X10CrAL18	1.4742	430S15	60	-	430	Z10CAS18	X8Cr17	F.3113	SUS430
	P5.0.Z.AN/P5.0.C.UT	2.2	X10CrAL2-4	1.4762	-	-	2322	446	Z10CAS24	X16Cr26	-	SUH446
	P5.0.Z.AN/P5.0.C.UT	2.3	X1CrMoTi18-2	1.4521	-		2326	S44400		-	-	-
	P5.0.Z.AN/P5.0.C.UT	2.3	X6Cr13	1.4000	403S17		2301	403	Z6C13	X6Cr13	F.3110	SUS403
	P5.0.Z.AN/P5.0.C.UT	2.3	X10Cr13	1.4006	410S21	56A	2302	410	Z10C14	X12Cr13	F.3401	SUS410
	P5.0.Z.AN/P5.0.C.UT	2.3	X6Cr17	1.4016	430S15	960	2320	430	Z8C17	X8Cr17	F3113	SUS430
	P5.0.Z.AN/P5.0.C.UT	2.3	X6CrAL13	1.4002	405S17	-	-	405	Z8CA12	X6CrAl13	-	-
	P5.0.Z.AN/P5.0.C.UT	2.3	X20Cr13	1.4021	420S37	-	2303	420	Z20C13	X20Cr13	-	-
	P5.0.Z.AN/P5.0.C.UT	2.3	X6CrMo17-1	1.4113	434S17	-	2325	434	Z8CD17.01	X8CrMo17	-	SUS434
	P5.0.Z.AN/P5.0.C.UT	2.3	X85CrMoV18-2	1.4748	443S65	59	-	HNV6	Z80CSN20.02	X80CrSiNi20	F.320B	SUH4
	P5.0.Z.AN/P5.0.C.UT	2.3	X12CrS13	1.4005	416 S 21		2380	416	Z11CF13	X12 CrS 13	F-3411	SUS 416
	P5.0.Z.AN/P5.0.C.UT	2.3	X46Cr13	1.4034	420S45	56D	2304	-	Z40CM	X40Cr14	F.3427	SUS420J2
	P5.0.Z.AN/P5.0.C.UT	2.3	X19CrNi17-2	1.4057	431S29	57	2321	431	Z15CNi6.02	X16CrNi16	F.3405	SUS431
	P5.0.Z.AN/P5.0.C.UT	2.4	X20CrMoV12-1	1.4922	-		2317	-	-	X20CrMoNi 12 01	-	-
	P5.0.Z.AN/P5.0.Z.HT	2.3	X7Cr14	1.4001					-	-	F.8401	-
	P5.0.Z.HT	2.2	X45CrS9-3-1	1.4718	401S45	52	-	HW3	Z45CS9	X45GrSi8	F322	SUH1
	P5.0.Z.PH	2.3	X4 CrNiMo16-5	1.4418	-		2387	-	Z6CND16-04-01			
	P5.0.Z.PH/P5.0.C.HT	2.2+2.4	X5CrNiCu-Nb16-4	1.4542 1.4548	-		-	630	Z7CNU17-04	-	-	-
	P5.1.Z.AN/P5.0.Z.HT	2.1	X14CrMoS17	1.4104	-	-	2383	430F	Z10CF17	X10CrS17	F.3117	SUS430F
	P1.2.Z.AN	1.2		1.0045	OVAKO 520M (Ovako Steel)							
	P1.2.Z.AN	1.2			S355J2G3(XM)							
	P1.2.Z.AN	1.3			FORMAX (Uddeholm Tooling)							
	P1.2.Z.AN	1.3			C45(XM)							
	P2.5.Z.HT	1.6			HARDOX 400 (SSAB – Swedish Steel Corp.)							
	P3.0.Z.AN	1.5			Orvar Supreme (Uddeholm Tooling)							

SANDVIK Coromant

Norma a stát/region//Standard és Ország/Régió//Standard i kraj/region//Standard şi Ţară/Regiune//Стандарт и страна/регион//Standard & Country/Region

ISO	MC-code	Dormer AMG	Europe DIN EN	Germany W.-nr	UK BS	EN	Sweden SS	USA AISI/SAE/ASTM	France AFNOR	Italy UNI	Spain UNE	Japan JIS
M Korozivzdorné oceli/Rozsdamentes acél/ Stal nierdzewna/Oţel inoxidabil/Нержавеющая сталь/ Stainless Steel	**Austenitické korozivzdorné oceli/Ausztenites rozsdamentes acél/Stale nierdzewne austenityczneq/Oţeluri inoxidabile austenitice/ Аустенитная нержавеющая сталь/Austenitic stainless steels**											
	M1.0.Z.AQ	2.2	X5CrNi18-10	1.4301	304S15	58E	2332, 2333	304	Z6CN18.09	X5CrNi18 10	F.3551	SUS304
	M1.0.Z.AQ	2.2	X5CrNiMo17-2-2	1.4401	316S16	58J	2347	316	Z6CND17.11	X5CrNiMo17 12	F.3543	SUS316
	M1.0.Z.AQ	2.2	X6CrNiTi18-10	1.4541	321S12	58B	2337	321	Z6CNT18.10	X6CrNiTi18 11	F.3553 F.3523	SUS321
	M1.0.Z.AQ	2.3	X3CrNiMo13-4	1.4313	425C11	-	2385	CA6-NM	Z4CND13.4MZ38C13M	(G)X6CrNi304	-	SCS5
	M1.0.Z.AQ	2.4	X1CrNiMo-CuN20-18-7	1.4547	-	-	2378	S31254	Z1CNDU20-18-06AZ	-	-	-
	M1.0.Z.AQ/M1.0.C.UT	2.2	X53CrMnNiN21-9	1.4871	349S54	-	-	EV8	Z52CMN21.09	X53CrMnNiN21 9	-	SUH35, SUH36
	M1.0.Z.AQ/M1.0.C.UT	2.2	X2CrNiN18-10	1.4311	304S62	-	2371	304LN	Z2CN18.10	-	-	SUS304LN
	M1.0.Z.AQ/M1.0.C.UT	2.2	X2CrNiMoN17-13-3	1.4429	-	-	2375	316LN	Z2CND17.13	-	-	SUS316LN
	M1.0.Z.AQ/M1.0.C.UT	2.2	X2CrNiMo17-12-2	1.4404	316S13		2348	316L	Z2CND17-12	X2CrNiMo1712	-	-
	M1.0.Z.AQ/M1.0.C.UT	2.2	X2CrNiMo18-14-3	1.4435	316S13	-	2353	316L	Z2CND17.12	X2CrNiMo17 12	-	SCS16, SUS316L
	M1.0.Z.AQ/M1.0.C.UT	2.2	X3CrNiMo17-3-3	1.4436	316S33	-	2343, 2347	316	Z6CND18-12-03	X8CrNiMo1713	-	-
	M1.0.Z.AQ/M1.0.C.UT	2.2	X2CrNiMo18-15-4	1.4438	317S12	-	2367	317L	Z2CND19.15	X2CrNiMo18 16	-	SUS317L
	M1.0.Z.AQ/M1.0.C.UT	2.2	X6CrNiNb18-10	1.4550	347S17	58F	2338	347	Z6CNNb18.10	X6CrNiNb18 11	F.3552 F.3524	SUS347
	M1.0.Z.AQ/M1.0.C.UT	2.2	X6CrNiMoTi17-12-2	1.4571	320S17	58J	2350	316Ti	Z6NDT17.12	X6CrNiMoTi17 12	F.3535	-
	M1.0.Z.AQ/M1.0.C.UT	2.2	X10CrNiMoNb 18-12	1.4583	-	-	-	318	Z6CNDNb17 13B	X6CrNiMoNb17 13	-	-
	M1.0.Z.AQ/M1.0.C.UT	2.2	X15CrNiSi20-12	1.4828	309S24	-	-	309	Z15CNS20.12	-	-	SUH309
	M1.0.Z.AQ/M1.0.C.UT	2.2	X2CrNiMoN17-11-2	1.4406	301S21	58C	2370	308	Z1NCDU25.20	-	F.8414	SCS17
	M1.0.Z.AQ/M1.0.C.UT	2.2	X9CrNi18-8	1.4310	-	-	2331	301	Z12CN17.07	X12CrNi17 07	F.3517	SUS301
	M1.0.Z.AQ/M1.0.C.UT	2.2	X2CrNi19-11	1.4306	304S11	-	2352	304L	Z2CN18-10	X2CrNi18 11	-	-
	M1.0.Z.PH	2.4	X7CrNiAL17-7	1.4568 1.4504	316S111	-	-	17-7PH	Z8CNA17-07	X2CrNiMo1712	-	-
	M1.2.Z.AQ	2.1	X8CrNiS18-9	1.4305	303S21	58M	2346	303	Z10CNF 18.09	X10CrNiS 18.09	F.3508	SUS303
	(Ni > 20 %) - Superaustenitické korozivzdorné oceli/Szuper-ausztenites rozsdamentes acél/Stale nierdzewne superaustenityczne/ Oţeluri inoxidabile superaustenitice/супераустенитная нержавеющая сталь/Super-austenitic stainless steels											
	M2.0.C.AQ	2.2	G-X40NiCrSi36-18	1.4865	330C11	-	-	-	-	XG50NiCr39 19	-	SCH15
	M2.0.Z.AQ	2.2	X8CrNi25-21	1.4845	310S24	-	2361	310S	Z12CN25 20	X6CrNi25 20	F.331	SUH310
	M2.0.Z.AQ	2.2	X12NiCrSi36 16	1.4864	-	-	-	330	Z12NCS35.16	F-3313	-	SUH330
	M2.0.Z.AQ	2.4	X1NiCrMo-Cu31-27-4	1.4563	-	-	2584	NO8028	Z1NCDU31-27-03	-	-	-
	M2.0.Z.AQ	2.4	X1NiCrMo-Cu25-20-5	1.4539	-		2562	UNS V 0890A	Z2 NCDU25-20	-	-	-
	Duplexní (austeniticko/feritické) korozivzdorné oceli/Duplex rozsdamentes acél/Stale nierdzewne Duplex/Oţeluri inoxidabile Duplex/Дуплексная нержавеющая сталь/Duplex stainless steels											
	M3.1.Z.AQ/M3.1.C.AQ	2.3	X2CrNiN23-4	1.4362	-		2376	S31500	-	-	-	-
	M3.1.Z.AQ/M3.1.C.AQ	2.3	X8CrNiMo27-5	-	-		2324	S32900	-	-	-	-
	M3.2.Z.AQ/M3.2.C.AQ	2.3	X2CrNiMoN22-53	-	-		2327	S32304	Z2CN23-04AZ	-	-	-
	M3.2.Z.AQ/M3.2.C.AQ	2.3	-	-	-		2328	-	-	-	-	-
	M3.2.Z.AQ/M3.2.C.AQ	2.3	X2CrNiMoN22-53	-	-		2377	S31803	Z2CND22-05-03	-	-	-
	M1.0.Z.AQ	2.4	254 SMO									
	M1.1.Z.AQ	2.2	SANMAC 304 (Sandvik Steel)									
	M1.1.Z.AQ	2.2	SANMAC 304L (Sandvik Steel)									
	M1.1.Z.AQ	2.2	SANMAC 316 (Sandvik Steel)									
	M1.1.Z.AQ	2.2	SANMAC 316L (Sandvik Steel)									
	M3.2.Z.AQ	2.3	SANMAC SAF 2205 (Sandvik Steel)									
	M3.2.Z.AQ	2.3	SANMAC SAF 2507 (Sandvik Steel)									
K Litiny/Öntöttvas/Żeliwo/Fontă/ Чугун/Cast Iron	**Temperovaná litina/Temperöntvény/Żeliwo ciągliwe/Fontă maleabilă/Ковкий чугун/ Malleable cast iron**											
	K1.1.C.NS	3.3	EN-GJMB350-10	0.8135	B 340/12		0815	32510	MN 35-10			FCMW330
	K1.1.C.NS	3.3	EN-GJMB450-6	0.8145	P 440/7		0852	40010	Mn 450	GMN 45		FCMW370
	K1.1.C.NS	3.3	EN-GJMB550-4	0.8155	P 510/4		0854	50005	MP 50-5	GMN 55		FCMP490
	K1.1.C.NS	3.3	EN-GJMB650-2	0.8165	P570/3		0856	A220-70003	Mn 650-3	GMN 65		FCMP590
	K1.1.C.NS	3.3	EN-GJMB700-2	0.8170	P690/2		0862	A220-80002	Mn700-2	GMN 70		FCMP690
	Šedá litina/Szürke öntöttvas/Żeliwo szare/Fontă cenuşie/Серый чугун/Grey cast iron											
	K2.1.C.UT	3.1	EN-GJL-100	0.6010			0110	No 20 B	Ft 10 D			FC100
	K2.1.C.UT	3.1	EN-GJL-150	0.6015	Grade 150		0115	No 25 B	Ft 15 D	G 15	FG 15	FC150
	K2.1.C.UT	3.1-3.2	EN-GJL-200	0.6020	Grade 220		0120	No 30 B	Ft 20 D	G 20		FC200
	K2.1.C.UT	3.1-3.2	EN-GJL-200	0.6025	Grade 260		0125	No 35 B	Ft 25 D	G 25	FG 25	FC250
	K2.1.C.UT	3.1-3.2	EN-JLZ	0.6040	Grade 400		0140	No 55 B	Ft 40 D			
	K2.2.C.UT	3.1-3.2	EN-GJL-300	0.6030	Grade 300		0130	No 45 B	Ft 30 D	G 30	FG 30	FC300
	K2.2.C.UT	3.1-3.2	EN-GJL-350	0.6035	Grade 350		0135	No 50 B	Ft 35 D	G 35	FG 35	FC350
	K2.3.C.UT	3.3	GGL-NiCr20-2	0.6660	L-NiCuCr202		0523	A436 Type 2	L-NC 202			
	Nodulární litina/Gömbgrafitos öntöttvas/Żeliwo sferoidalne/Fontă cu grafit nodular/ Чугун с шаровидным графитом/Nodular cast iron											
	K3.1.C.UT	3.3	EN-GJS-350-22-LT	0.7033	-		0717-15	-	-			
	K3.1.C.UT	3.3-3.4	EN-GJS-400-15	0.7040	SNG 420/12		0717-02	60-40-18	FCS 400-12	GS 370-17	FGE 38-17	FCD400
	K3.1.C.UT	3.3-3.4	EN-GJS-400-18-LT	0.7043	SNG 370/17		0717-12	-	FGS 370-17			FCD500
	K3.1.C.UT	3.3-3.4	EN-GJS-800-7	0.7050	SNG 500/7		0727	80-55-06	FGS 500-7	GS 500	FGE 50-7	
	K3.2.C.UT	3.3-3.4	EN-GJS-600-3	0.7060	SNG 600/3		0732-03	-	FGS 600-3			FCD600
	K3.3.C.UT	3.3-3.4	EN-GJS-700-2	0.7070	SNG 700/2		0737-01	100-70-03	FGS 700-2	GS 700-2	FGS 70-2	FCD700
	K3.5.C.UT	3.3-3.4	EN-GJSA-XNiCr20-2	0.7660	Grade S6		0776	A43D2	S-NC 202			

Norma a stát/region//Standard és Ország/Régió//Standard i kraj/region//Standard şi Ţară/Regiune//Стандарт и страна/регион//Standard & Country/Region

ISO	MC-code	Dormer AMG	Europe DIN EN	Germany W.-nr	UK BS EN	Sweden SS	USA AISI/SAE/ASTM	France AFNOR	Italy UNI	Spain UNE	Japan JIS
K	**Litina s červíkovitým grafitem/Grafitos öntöttvas/Stop żelazowo-grafitowy/Fontă grafitată compactată/ Чугун с вермикулярным графитом/Compacted graphite iron**										
	K4.1.C.UT	-	EN-GJV-300								
	K4.1.C.UT	-	EN-GJV-350								
	K4.2.C.UT	-	EN-GJV-400								
	K4.2.C.UT	-	EN-GJV-450								
	K4.2.C.UT	-	EN-GJV-500								
	Izotermicky kalená tvárná litina/Ausztemperált gömbgrafitos öntöttvas/Żeliwo sferoidalne hartowane (ADI)/Fontă cu grafit nodular bainitică/Отпущенный ковкий чугун/Austempered ductile iron										
	K5.1.C.NS	-	EN-GJS-800-8				ASTM A897 No. 1				
	K5.1.C.NS	-	EN-GJS-1000-5				ASTM A897 No. 2				
	K5.2.C.NS	-	EN-GJS-1200-2				ASTM A897 No. 3				
	K5.2.C.NS	-	EN-GJS-1400-1				ASTM A897 No. 4				
	K2.1.C.UT	3.2	GG25								
	K3.1.C.UT	3.3	GGG-40								
N Neželezné kovy/Nem vas alapú anyagok/ Materiały nieżelazne/Materiale neferoase/ Цветные металлы/ Non-ferrous materials	**Slitiny na bázi hliníku/Alumínium alapú ötvözetek/Stopy aluminiowe/Aliaje pe bază de aluminiu/ Сплавы на основе алюминия/Aluminium based alloys**										
	N1.1.Z.UT	7.1	AW-1070A	3.0275		4005		A7	4508	L-3071	A1070
	N1.2.Z.AG	7.2	AW-6082	3.2315	H30	4212	6082	A-SGM0,7	3571		
	N1.3.C.AG	7.3	G-AISI9MGWA	3.2373		4253	SC64D	A-S7G			C4BS
	N1.3.C.AG	7.3	GD-AlSi8Cu3		LM24	4250	A380.1				A7075
	N1.3.C.AG	7.3	G-AlSi10Mg(Cu)		LM9	4253	A360.2				
	N1.3.C.UT	7.3	G-ALMG5		LM5	4252	GD-AISI12	A-SU12			AC4A
	N1.3.C.UT	7.4	GD-AlSi12			4247	A413.0				A6061
	N1.3.C.UT	7.4	G-AlSi12(Cu)		LM20	4260	A413.1				ADC12
	N1.3.C.UT	7.4	G-AlSi12		LM6	4261	A413.2				
	N1.3.C.UT/N1.3.C.AG	7.3			LM25	4244	356.1				A5052
	Slitiny mědi/Réz alapú ötvözetek/Stopy miedziane/Aliaje pe bază de cupru/ Сплавы на основе меди/Copper based alloys										
	N3.1.U.UT	6.1	E-Cu57	2.0060	C101	5010		Cu-a1		C11020	
	N3.3.U.UT	6.3	CW612N	2.0380	Cz 120			CuZn39Pb2		C37700	C3771
	N3.1.U.UT	6.4	Ampco 18								
	N3.4.C.UT	6.4	Ampco 25								
S Žáruvzdorné slitiny/Hőálló szuperötvözetek/Superstopy odporne na wysokie temperatury/ Superalliaje termorezistente/ Heat Resistant Super Alloys/Heat Resistant Super Alloys	**Slitiny na bázi niklu/Nikkel alapú ötvözetek/Stopy niklowe/Aliaje pe bază de nichel/ Сплавы на основе никеля/Nickel based alloys**										
	S2.0.C.UT	5.2-5.3	NiCo15Cr10MoAlTi	LW2 4674	- -	-	AMS 5397	-	-	-	
	S2.0.Z.AG	5.2-5.3	NiFe35Cr14MoTi	LW2.4662	- -	-	5660	ZSNCDT42	-	-	
	S2.0.Z.AG	5.2-5.3	NiCr20TiAk	2.4631	Hr401.601 -	-	-	NC20TA	-	-	
	S2.0.Z.AG	5.2-5.3	NiCu30AL3Ti	2.4375	3072-76 -	-	4676	-	-	-	
	S2.0.Z.AG	5.2-5.3	S-NiCr13A16MoNb	LW2 4670	3072-76 -	-	5391	NC12AD	-	-	
	S2.0.Z.AG	5.3	NiCr19Fe19NbMo	LW2.4668	HR8 -	-	5383	NC19eNB	-	-	
	S2.0.Z.AN	5.2-5.3	NiCr22Mo9Nb	2.4856	- -	-	5666	NC22FeDNB	-	-	
	S2.0.Z.AN	5.2-5.3	NiCr20Ti	2.4630	HR5.203-4 -	-	-	NC20T	-	-	
	Slitiny na bázi kobaltu/Kobalt alapú ötvözetek/Stopy kobaltowe/Aliaje pe bază de cobalt/ Сплавы на основе кобальта/Cobolt based alloys										
	S3.0.Z.AG	-	CoCr20W15Ni		- -	-	5537C, AMS	KC20WN	-	-	
	S3.0.Z.AG	-	CoCr22W14Ni	LW2.4964			5772	KC22WN			
	Titanové slitiny/Titán alapú ötvözetek/Stopy tytanu/Aliaje de titan/Сплавы на основе титана/ Titanium alloys										
	S4.2.Z.AN	4.2-4.3	TiAl5Sn2.5	3.7115.1	TA14/17 -	-	UNS R54520	T-A5E	-	-	
	S4.2.Z.AN	4.2-4.3	TiAl6V4	3.7165.1	TA10-13/TA28 -	-	UNS R56401	T-A6V			
	S2.0.Z.AG	5.2-5.3	Nimonic PE 13, Inconel 700, Nimonic 901, Waspaloy								
	S2.0.Z.AG	5.3	Rene 95, Inconel 718								
	S2.0.Z.AN	5.2-5.3	Hastelloy C, Incoloy 825, Inconel 600, Monel 400								
	S2.0.Z.AN	5.3	Haynes 600, Nimocast PD16								
	S2.0.Z.UT/S2.0.Z.AN	5.2-5.3	Incoloy 800								
H	**Tvrzené materiály/Edzett anyagok/Materiały hartowane/Materiale călite/Материалы высокой твёрдости/ Hardened materials**										
	H1.2.Z.HA	1.8	X65CrMo14	-	-	2541-06	0-2	-	-		AC4A
	H1.3.Z.HA	1.8	X110CrMoV15	1.4111	- -	2534-05	610	-	-		AC4A
	H1.2.Z.HA	1.8	Hardox 600								
O	**Neobsažené v ISO/Non ISO/Bez oznaczenia ISO/Non ISO/Другие материалы/Non ISO**										
	O1.0.U.NS	8.1	PS		Styrene			Polystyrene			
	O1.0.U.NS	8.1	Polyvinyl chloride		PVC			Chlorure de polyvinyle			
	O2.0.U.NS	8.2	Bakelite								