





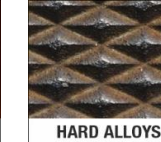



FAMILY CLASSIFICATION	01660
DESCRIPTION	HSS-CO. GROUND PROFILE MACHINE TAPS - METRIC ISO THREAD COARSE PITCH - STRAIGHT FLUTE - CHAMFER FORM "B" FOR THROUGH HOLES - REINFORCED SHANK
PRODUCT IMAGE	<p>from M3 to M6 </p> <p>from M8 to M10 </p>
KIND OF STEEL	HSS AISI M35
COMPOSITION %	C 0,88-0,93 - Si 0,30-0,43 - Mn 0,25-0,35 - P ≤ 0.028 - S ≤ 0,009 Cr 3,90-4,00 - Mo 4,75-4,90 - W 5,95-6,20 - V 1,75-1,90 - Co 4,55-4,70 C=Carbon - Si=Silicon - Mn=Manganese - P=Phosphorus - S=Sulfur - Cr=Chrome - Mo=Molybdenum Cr=Chrome - W=Tungsten - V=Vanadium - Co=Cobalt
HARDENING TEMP.	1100°
HARDNESS	65-66 HRC
DIN	371/B
KIND OF HOLES	THROUGH HOLES
FLUTE	STRAIGHT
SHANK	SQUARE
MANUFACTURING PROCESS	FULLY GROUND FROM THE SOLID, with CAO System, that grants quality control and product homogeneity.
TOLERANCES	H6 1/3=0/+0,014 - 3/6=0/+0,018 - 6/10=0/+0,022 - 10/18=0/+0,027 - 18/25=0/+0,033
SURFACE TREATMENT	Natural steel - ground from the solid - smooth bright finish
WORK PIECE MATERIALS	ALLOY STEEL - METALS - STAINLESS STEEL - CAST IRON HARD ALLOYS METALS WITH RESISTANCE $R \leq 900$ N/mm     
USE	machine use
RECOMANDATION	USE REFRIGERANT OIL during the cutting, if required
PACKING	Each tap in SINGLE PLASTIC BOX
CHIP FORWARD EJECTION	The CHIP is driven ahead of the cutting action of the tap with chamfer form B. Typical for the through hole tapping. It allows the immediate evacuation of the chips  CHIP FORWARD EJECTION

FAMILY CLASSIFICATION

01660

TAPPING DRILL SIZES CHART

∅ H
hole

POINTED HEAD TAP	
M3	2,50 mm
M4	3,30 mm
M5	4,20 mm
M6	5,00 mm
FLAT HEAD TAP	
M8	6,80 mm
M10	8,50 mm

Work piece materials	Cutting speed (m/min.)	Refriger.
Low alloyed steel	10 ÷ 20	
Heat resistant steel, tool steel	4 ÷ 8	
Steel with R>750 N/mm ²	2 ÷ 5	
Stainless steel	5 ÷ 10	
Special Alloys	2 ÷ 4	
Malleable Cast iron	6 ÷ 12	
Brass	10 ÷ 15	
Bronze	6 ÷ 15	
Aluminium	10 ÷ 20	
Titanium	3 ÷ 4	
Plastic - Thermoplastic materials	5 ÷ 15	

PERSONAL SECURITY WARNINGS



Always use safety glasses



In case of loud noise wear ear protection



Always wear protective gloves