
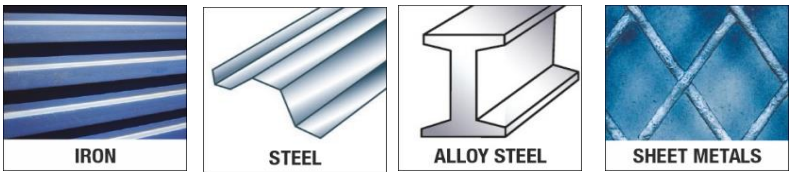


ECEF TECHNICAL SPECIFICATIONS

THREADING TOOLS

FAMILY CLASSIFICATION	05390
DESCRIPTION	HSS-GROUND LEFT HAND MACHINE TAPS - METRIC ISO THREAD COARSE PITCH - CHAMFER FORM "C" - 35° LEFT HAND SPIRAL FLUTE - FOR BLIND HOLES - REINFORCED SHANK
PRODUCT IMAGE	<p>from M3 to M6 </p> <p>from M8 to M10</p>
KIND OF STEEL	HSS AISI M2 plus
COMPOSITION %	C 0,84-0,88 - Si 0,30-0,43 - Mn 0,25-0,35 - P ≤ 0.028 - S ≤ 0,009 Cr 3,90-4,00 - Mo 4,80-5,00 - W 6,00-6,20 - V 1,80-2,00 - Nb 0,04-0,06 C=Carbon - Si=Silicon - Mn=Manganese - P=Phosphorus - S=Sulfur Cr=Chrome - Mo=Molybdenum - W=Tungsten - V=Vanadium - Nb=Niobium
HARDENING TEMP.	1100°
HARDNESS	64-65 HRC
DIN	371/C 35°
KIND OF HOLES	BLIND HOLES
FLUTE	35° SPIRAL LEFT HAND
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	IRON - LIGHT STEEL - LIGHT METALS - LIGHT ALLOY STEEL METALS WITH RESISTANCE $R \leq 800 \text{ N/mm}^2$
	
USE	machine use
RECOMANDATION	USE REFRIGERANT OIL during the cutting, if required
PACKING	Each tap in SINGLE PLASTIC BOX
CHIP MASSIVE BACKWARD EJECTION	<p>The CHIP is massive pushed backward the cutting action. Typical ejection for blind hole tapping at 35°.</p> 

FAMILY CLASSIFICATION

05390

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