



E397(M)

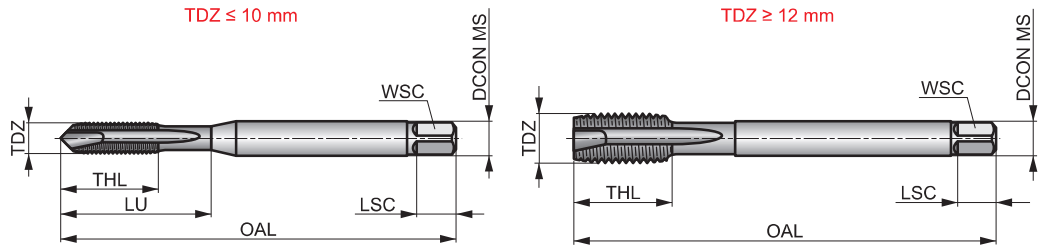
DORMER



HSS-E-PM Spiral Point Tap, Metric, DIN Standard, TiCN Coated

Machine tap for highly productive applications with spiral point for 2.5xD through holes only. Suited for machining a variety of work-materials. Unique TiCN coated HSS-E-PM substrate to offer superior abrasion resistance, higher cutting speeds, improve thread quality, reduced cycle times and longer tool-life.

M	DIN 371/376	6HX
2.5xD	HSS-E PM	
B 3.5-5		R
TiCN		



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1 ■ 37	P1.2 ■ 42	P1.3 ■ 44	P2.1 ■ 33	P2.2 ■ 28	P2.3 ■ 25	P3.1 ■ 20	P3.2 ■ 16	P3.3 ▣ 13	P4.1 ■ 12	P4.2 ▣ 9	M1.1 ■ 15	M1.2 ■ 12	M2.1 ■ 13
M2.2 ■ 11	M3.1 ■ 9	M3.2 ■ 7	M3.3 ▣ 6	M4.1 ▣ 4	K1.1 ▣ 20	K1.2 ▣ 15	K1.3 ▣ 11	K2.1 ▣ 29	K2.2 ▣ 23	K3.1 ▣ 25	K3.2 ▣ 19	K4.1 ▣ 23	K4.2 ▣ 17
N1.3 ▣ 12	N2.1 ▣ 37	N2.2 ▣ 34	N2.3 ▣ 24	N3.1 ▣ 60	N3.2 ▣ 36	N4.1 ▣ 26							

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)		(mm)	(mm)
E397M3	3	0.50	56.0	9	3.50	2.70	6	3	2.50	18.00
E397M4	4	0.70	63.0	12	4.50	3.40	6	3	3.30	21.00
E397M5	5	0.80	70.0	13	6.00	4.90	8	3	4.20	25.00
E397M6	6	1.00	80.0	15	6.00	4.90	8	3	5.00	30.00
E397M8	8	1.25	90.0	18	8.00	6.20	9	3	6.80	35.00
E397M10	10	1.50	100.0	20	10.00	8.00	11	3	8.50	39.00
E397M12	12	1.75	110.0	23	9.00	7.00	10	4	10.30	—
E397M14	14	2.00	110.0	25	11.00	9.00	12	4	12.00	—
E397M16	16	2.00	110.0	25	12.00	9.00	12	4	14.00	—
E397M18	18	2.50	125.0	30	14.00	11.00	14	4	15.50	—
E397M20	20	2.50	140.0	30	16.00	12.00	15	4	17.50	—
E397M22	22	2.50	140.0	34	18.00	14.50	17	4	19.50	—
E397M24	24	3.00	160.0	38	18.00	14.50	17	4	21.00	—
E397M27	27	3.00	160.0	38	20.00	16.00	19	4	24.00	—
E397M30	30	3.50	180.0	45	22.00	18.00	21	4	26.50	—