



E398(M)

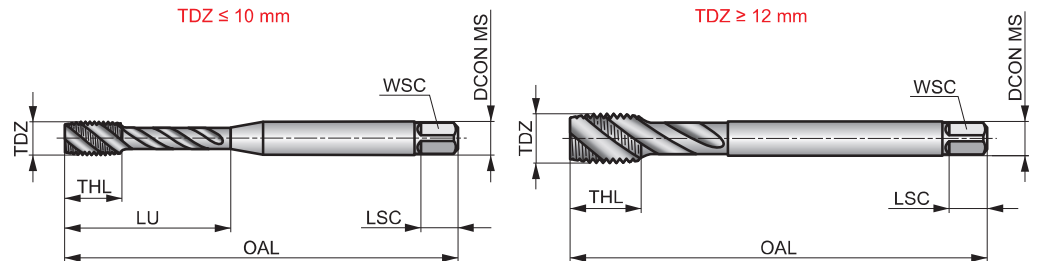
DORMER



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

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

M	DIN 371/376	6HX
	2.5xD	HSS-E PM
C 2-3		λ 48°
R		



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

P1.1 ■ 35	P1.2 ■ 40	P1.3 ■ 42	P2.1 ■ 31	P2.2 ■ 27	P2.3 ■ 24	P3.1 ■ 19	P3.2 ■ 15	P3.3 ■ 12	P4.1 ■ 11	P4.2 ■ 9	M1.1 ■ 14	M1.2 ■ 11	M2.1 ■ 12
M2.2 ■ 10	M3.1 ■ 9	M3.2 ■ 7	M3.3 ■ 6	M4.1 ■ 4	N1.3 ■ 11	N2.1 ■ 35	N2.2 ■ 32	N2.3 ■ 23	N3.1 ■ 60				

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)		(mm)	(mm)
E398M3	3	0.50	56.0	6	3.50	2.70	6	3	2.50	18.00
E398M4	4	0.70	63.0	7	4.50	3.40	6	3	3.30	21.00
E398M5	5	0.80	70.0	8	6.00	4.90	8	3	4.20	25.00
E398M6	6	1.00	80.0	10	6.00	4.90	8	3	5.00	31.00
E398M8	8	1.25	90.0	12	8.00	6.20	9	3	6.80	35.00
E398M10	10	1.50	100.0	15	10.00	8.00	11	3	8.50	39.00
E398M12	12	1.75	110.0	16	9.00	7.00	10	3	10.30	—
E398M14	14	2.00	110.0	20	11.00	9.00	12	3	12.00	—
E398M16	16	2.00	110.0	20	12.00	9.00	12	4	14.00	—
E398M18	18	2.50	125.0	25	14.00	11.00	14	4	15.50	—
E398M20	20	2.50	140.0	25	16.00	12.00	15	4	17.50	—
E398M22	22	2.50	140.0	25	18.00	14.50	17	4	19.50	—
E398M24	24	3.00	160.0	30	18.00	14.50	17	4	21.00	—
E398M27	27	3.00	160.0	30	20.00	16.00	19	4	24.00	—
E398M30	30	3.50	180.0	36	22.00	18.00	21	4	26.50	—