



# E414

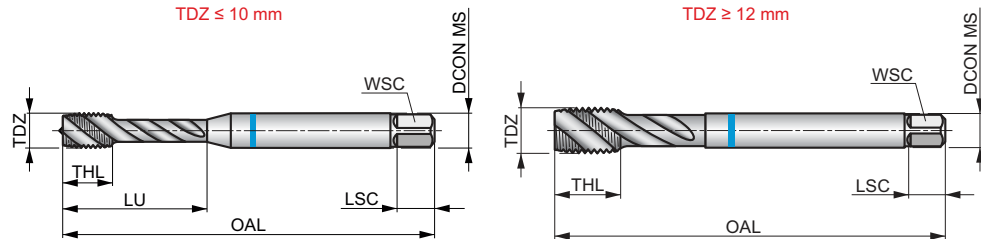


## Blue SHARK 48° Spiral Flute Metric Machine Tap, DIN Standard

High performance quick spiral tap for deep blind holes in stainless steels. Unique HSS-E-PM substrate with Super-B coating and additional edge treatment provide superior performance. Extra back taper facilitates chip evacuation and reduces torque on reversal. Recommended to be used with synchronous feed tap holders.

### SHARK

	DIN 371/376	6H
	3xD	HSS-E PM
C 2-3		$\lambda$ 48°



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

<b>P2.2</b> ■ 32	<b>P2.3</b> ■ 28	<b>P3.2</b> ■ 15	<b>P3.3</b> ■ 13	<b>P4.1</b> ■ 11	<b>P4.2</b> ■ 10	<b>M1.1</b> ■ 22	<b>M1.2</b> ■ 19	<b>M2.1</b> ■ 20	<b>M2.2</b> ■ 16	<b>M2.3</b> ■ 13	<b>M3.1</b> ■ 14	<b>M3.2</b> ■ 12	<b>M3.3</b> ■ 11
<b>M4.1</b> ■ 8	<b>M4.2</b> ■ 7												

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
E414M3	3	0.50	56.0	6	3.50	2.70	6	3	2.50	18.00
E414M4	4	0.70	63.0	7	4.50	3.40	6	3	3.30	21.00
E414M5	5	0.80	70.0	8	6.00	4.90	8	3	4.20	25.00
E414M6	6	1.00	80.0	10	6.00	4.90	8	3	5.00	30.00
E414M8	8	1.25	90.0	13	8.00	6.20	9	3	6.80	35.00
E414M10	10	1.50	100.0	15	10.00	8.00	11	3	8.50	39.00
E414M12	12	1.75	110.0	18	9.00	7.00	10	3	10.30	–
E414M14	14	2.00	110.0	20	11.00	9.00	12	3	12.00	–
E414M16	16	2.00	110.0	20	12.00	9.00	12	4	14.00	–
E414M20	20	2.50	140.0	25	16.00	12.00	15	4	17.50	–