



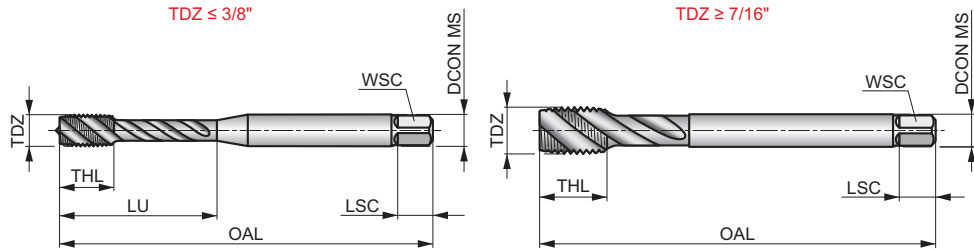
EX31



HSS-E-PM Spiral Flute Machine Tap, UNF, DIN Standard

Machine tap with spiral flute suited for blind holes. Steam tempered surface acts to retain cutting fluid and prevent chip to tool welding.

	DIN 2184-1	2B
	2.5xD	HSS-E PM
C 2-3		λ 45°



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

P1.1 ▣21	P2.2 ▣15	P2.3 ▣13	P3.2 ▣9	P3.3 ▣8	P4.1 ▣7	P4.2 ▣5	M1.1 ▣8	M1.2 ▣6	M2.1 ▣7	M2.2 ▣5	M3.1 ▣5	M3.2 ▣4	M3.3 ▣3
M4.1 ▣3													

Product	TDZ	TPI	TD	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
			[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			
EX318-36	8	36	4.166	63.0	7	4.50	3.40	8	3	3.50	21.00
EX3110-32	10	32	4.826	70.0	8	6.00	4.90	8	3	4.10	25.00
EX311/4	1/4	28	6.350	80.0	10	7.00	5.50	8	3	5.50	30.00
EX315/16	5/16	24	7.938	90.0	12	8.00	6.20	9	3	6.90	35.00
EX313/8	3/8	24	9.525	100.0	15	10.00	8.00	11	3	8.50	39.00
EX317/16	7/16	20	11.112	100.0	15	8.00	6.20	9	3	9.90	-
EX311/2	1/2	20	12.700	110.0	18	9.00	7.00	10	3	11.50	-
EX315/8	5/8	18	15.875	110.0	20	12.00	9.00	12	4	14.50	-
EX313/4	3/4	16	19.050	125.0	25	14.00	11.00	14	4	17.50	-
EX317/8	7/8	14	22.225	140.0	25	18.00	14.50	17	4	20.40	-
EX311	1"	12	25.400	160.0	30	18.00	14.50	17	4	23.25	-