



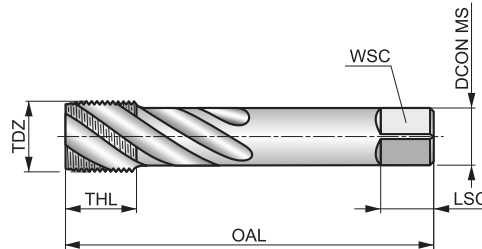
EX40



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

Machine tap with spiral flute suited for blind holes. Bright finish to produce more accurate and cleaner threads preventing the workpiece material from sticking to the cutting edges.

	DIN 5156	Normal
	2.5xD	HSS-E PM
C 2-3		λ 45°
	Bright	



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

P1.1 ■ 21	P1.2 ■ 23	P1.3 ■ 24	P2.1 ■ 17	P2.2 ■ 15	P2.3 ■ 13	P3.1 ■ 12	P3.2 ■ 9	P4.1 ■ 7	N1.1 ■ 13	N1.2 ■ 9	N1.3 ■ 6	N2.1 ■ 27	N2.2 ■ 24
N2.3 ■ 17													

Product	TDZ	TPI	TD	OAL	THL	DCON MS	WSC	LSC	NOF	PHD
			[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]
EX401/8	1/8	28	9.728	90.0	13	7.00	5.50	8	3	8.80
EX401/4	1/4	19	13.157	100.0	15	11.00	9.00	12	3	11.80
EX403/8	3/8	19	16.662	100.0	15	12.00	9.00	12	4	15.25
EX401/2	1/2	14	20.955	125.0	18	16.00	12.00	15	4	19.00
EX405/8	5/8	14	22.911	125.0	18	18.00	14.50	17	4	21.00
EX403/4	3/4	14	26.441	140.0	20	20.00	16.00	19	4	24.50
EX407/8	7/8	14	30.201	150.0	20	22.00	18.00	21	4	28.25
EX401	1"	11	33.249	160.0	22	25.00	20.00	23	4	30.75
EX401.1/8	1.1/8	11	37.897	170.0	22	28.00	22.00	25	4	35.00
EX401.1/4 ¹⁾	1.1/4	11	41.910	170.0	22	32.00	24.00	27	4	39.50
EX401.1/2 ¹⁾	1.1/2	11	47.803	190.0	23	36.00	29.00	32	4	45.00

¹⁾ HSS-E.