

M SOLID CARBIDE SPIRAL FLUTE TAPS for NON-FERROUS METALS
有色金属用硬质合金螺旋槽丝锥

► Suitable for tapping Blind holes in Aluminum, Magnesium, Zinc, Copper as well as Non-Ferrous metal alloys.

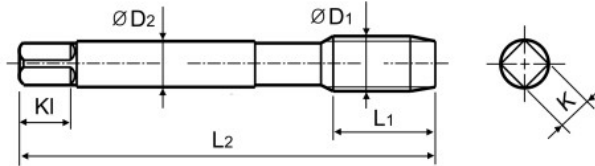
► 适用于铝, 镁, 锌, 铜及有色金属的盲孔加工.



1.5P

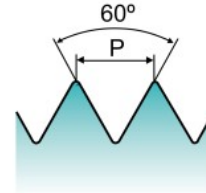
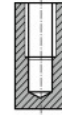
2.5P

up to M6 : Male Center



Hole type

孔类型
2.5×D



Material groups: **AI** CARBIDE I YH 60° 1.5P/2.5P R15 Bright p. B164

Plain Shank	Page
TAPPING ER CHUCK	D215-220
TAPPING CHUCK	D221-228
ONE STEP TAPPING CHUCK	D211-213

Tap Limits: p.B230

Unit(单位) : mm

SIZE	Pitch	EDP No.		Limit	Overall Length	Thread Length	Shank Diameter	Square Size	Square Length	No. of Flute
尺寸	牙距	型号		精度	全长	螺纹长	柄径	方块尺寸	方块长度	槽数
ØD1	P	1.5P	2.5P	精度	L2	L1	ØD2	K	KI	槽数
M3	× 0.5	T0202203	T0102203	YH3	46	11	4	3.2	6	3
M4	× 0.7	T0202243	T0102243	YH3	52	13	5	4	7	3
M5	× 0.8	T0202283	T0102283	YH3	60	16	5.5	4.5	7	3
M6	× 1	T0202313	T0102313	YH3	62	19	6	4.5	7	3
M8	× 1.25	T0202364	T0102364	YH4	70	22	6.2	5	8	3
M10	× 1.5	T0202424	T0102424	YH4	75	24	7	5.5	8	3
M12	× 1.75	T0202504	T0102504	YH4	82	29	8.5	6.5	9	3

► Refer to p.B233-B238 for recommended tap drill sizes. 参考p.B233-B238 底孔尺寸.

◎ : Excellent (优秀) ○ : Good (良好)

ISO	P										M				K								
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel				Stainless steel				Grey cast iron		Nodular cast iron		Malleable cast iron
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20			
HRc	13	25	28	32	30	29	32	38	15	35	15	23	10	10	26	3	25						
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230			
Recommended															○	○	○	○					

ISO	N										S						H				
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys						Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended	◎	◎	◎	○																	