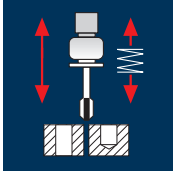


## Application



## Material

Unalloyed aluminium

M	ø [mm]	P [mm]	$v_c$			$v_c$			$v_c$		
			$1.5 \times d$	n [min <sup>-1</sup> ]	$v_f$ [100%]	$2.0 \times d$	n [min <sup>-1</sup> ]	$v_f$ [100%]	$3.0 \times d$	n [min <sup>-1</sup> ]	$v_f$ [100%]
M 2	2.0	0.40	25	3980	1592	20	3185	1274	15	2385	954
M 2.2	2.2	0.45	25	3615	1627	20	2895	1303	15	2170	977
M 2.5	2.5	0.45	25	3185	1433	20	2545	1145	15	1910	860
M 3	3.0	0.50	25	2655	1328	20	2120	1060	15	1590	795
M 4	4.0	0.70	25	1990	1393	20	1590	1113	15	1195	837
M 5	5.0	0.80	25	1590	1272	20	1275	1020	15	955	764
M 6	6.0	1.00	25	1325	1325	20	1060	1060	15	795	795
M 8	8.0	1.25	25	995	1244	20	795	994	15	595	744
M10	10.0	1.50	25	795	1193	20	635	953	15	475	713

Unalloyed aluminium

M12	12.0	1.75	25	665	1164	20	530	928	15	400	700
M14	14.0	2.00	25	570	1140	20	455	910	15	340	680
M16	16.0	2.00	25	495	990	20	400	800	15	300	600

Wrought aluminium alloys Si < 6% not hardened

M 2	2.0	0.40	30	4775	1910	25	3980	1592	20	3185	1274
M 2.2	2.2	0.45	30	4340	1953	25	3615	1627	20	2895	1303
M 2.5	2.5	0.45	30	3820	1719	25	3185	1433	20	2545	1145
M 3	3.0	0.50	30	3185	1593	25	2655	1328	20	2120	1060
M 4	4.0	0.70	30	2385	1670	25	1990	1393	20	1590	1113
M 5	5.0	0.80	30	1910	1528	25	1590	1272	20	1275	1020
M 6	6.0	1.00	30	1590	1590	25	1325	1325	20	1060	1060
M 8	8.0	1.25	30	1195	1494	25	995	1244	20	795	994
M10	10.0	1.50	30	955	1433	25	795	1193	20	635	953

Wrought aluminium alloys Si < 6% not hardened

M12	12.0	1.75	30	795	1391	25	665	1164	20	530	928
M14	14.0	2.00	30	680	1360	25	570	1140	20	455	910
M16	16.0	2.00	30	595	1190	25	495	990	20	400	800

## Material

Unalloyed copper



M	ø [mm]	P [mm]	$v_c$			$v_c$			$v_c$		
			$1.5 \times d$	n [min <sup>-1</sup> ]	$v_f$ [100%]	$2.0 \times d$	n [min <sup>-1</sup> ]	$v_f$ [100%]	$3.0 \times d$	n [min <sup>-1</sup> ]	$v_f$ [100%]
M 2	2.0	0.40	15	2385	954	10	1590	636	10	1590	636
M 2.2	2.2	0.45	15	2170	977	10	1445	650	10	1445	650
M 2.5	2.5	0.45	15	1910	860	10	1275	574	10	1275	574
M 3	3.0	0.50	15	1590	795	10	1060	530	10	1060	530
M 4	4.0	0.70	15	1195	837	10	795	557	10	795	557
M 5	5.0	0.80	15	955	764	10	635	508	10	635	508
M 6	6.0	1.00	15	795	795	10	530	530	10	530	530
M 8	8.0	1.25	15	595	744	10	400	500	10	400	500
M10	10.0	1.50	15	475	713	10	320	480	10	320	480

Unalloyed copper



M12	12.0	1.75	15	400	700	10	265	464	10	265	464
M14	14.0	2.00	15	340	680	10	225	450	10	225	450
M16	16.0	2.00	15	300	600	10	200	400	10	200	400

Non ferrous metal  $A_5 > 15\%$



M 2	2.0	0.40	15	2385	954	10	1590	636	10	1590	636
M 2.2	2.2	0.45	15	2170	977	10	1445	650	10	1445	650
M 2.5	2.5	0.45	15	1910	860	10	1275	574	10	1275	574
M 3	3.0	0.50	15	1590	795	10	1060	530	10	1060	530
M 4	4.0	0.70	15	1195	837	10	795	557	10	795	557
M 5	5.0	0.80	15	955	764	10	635	508	10	635	508
M 6	6.0	1.00	15	795	795	10	530	530	10	530	530
M 8	8.0	1.25	15	595	744	10	400	500	10	400	500
M10	10.0	1.50	15	475	713	10	320	480	10	320	480

Non ferrous metal  $A_5 > 15\%$



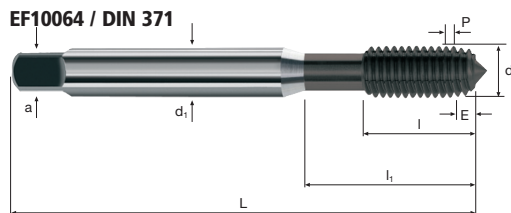
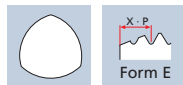
M12	12.0	1.75	15	400	700	10	265	464	10	265	464
M14	14.0	2.00	15	340	680	10	225	450	10	225	450
M16	16.0	2.00	15	300	600	10	200	400	10	200	400

# Cold forming taps



**M** ISO 3 (6G)

**HSS PM/F**



EF10065 / DIN 376



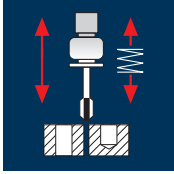
AI Aluminium > 99%    AI Aluminium Alloy    Cu Copper    CuZn Brass

Example: Order-N°: <b>EF10064</b> . <b>034</b>										F-DLC
∅ Code	d	P	L	l	l <sub>1</sub>	d <sub>1</sub>	a	⊘	⌘	EF10064
.034	M 2	0.40	45	8	—	2.8	2.1	3	1.80	●
.036	M 2.2	0.45	45	9	—	2.8	2.1	3	2.00	●
.040	M 2.5	0.45	50	9	—	2.8	2.1	3	2.30	●
.044	M 3	0.50	56	12	18.0	3.5	2.7	3	2.80	●
.058	M 4	0.70	63	13	21.0	4.5	3.4	3	3.70	●
.084	M 5	0.80	70	15	25.0	6.0	4.9	4	4.60	●
.088	M 6	1.00	80	17	30.0	6.0	4.9	4	5.50	●
.160	M 8	1.25	90	20	35.0	8.0	6.2	4	7.40	●
.174	M10	1.50	100	22	39.0	10.0	8.0	4	9.30	●

Example: Order-N°: <b>EF10065</b> . <b>240</b>										F-DLC
∅ Code	d	P	L	l	l <sub>1</sub>	d <sub>1</sub>	a	⊘	⌘	EF10065
.240	M12	1.75	110	24	40.0	9.0	7.0	5	11.20	●
.244	M14	2.00	110	26	40.0	11.0	9.0	5	13.10	●
.246	M16	2.00	110	27	40.0	12.0	9.0	5	15.10	●

CF

## Application



## Material

Steel  
< 850 N/mm<sup>2</sup>  
A<sub>5</sub> > 10%

Steel  
< 850 N/mm<sup>2</sup>  
A<sub>5</sub> > 10%

Steel  
850 - 1100 N/mm<sup>2</sup>  
A<sub>5</sub> > 10%



Steel  
850 - 1100 N/mm<sup>2</sup>  
A<sub>5</sub> > 10%



M	ø [mm]	P [mm]	V <sub>c</sub> 1.5 x d			V <sub>c</sub> 2.0 x d			V <sub>c</sub> 3.0 x d		
			n [min <sup>-1</sup> ]	v <sub>f</sub> [100%]		n [min <sup>-1</sup> ]	v <sub>f</sub> [100%]		n [min <sup>-1</sup> ]	v <sub>f</sub> [100%]	
M 2	2.0	0.40	20	3185	1274	15	2385	954	10	1590	636
M 2.2	2.2	0.45	20	2895	1303	15	2170	977	10	1445	650
M 2.5	2.5	0.45	20	2545	1145	15	1910	860	10	1275	574
M 3	3.0	0.50	20	2120	1060	15	1590	795	10	1060	530
M 4	4.0	0.70	20	1590	1113	15	1195	837	10	795	557
M 5	5.0	0.80	20	1275	1020	15	955	764	10	635	508
M 6	6.0	1.00	20	1060	1060	15	795	795	10	530	530
M 8	8.0	1.25	20	795	994	15	595	744	10	400	500
M10	10.0	1.50	20	635	953	15	475	713	10	320	480
M12	12.0	1.75	20	530	928	15	400	700	10	265	464
M14	14.0	2.00	20	455	910	15	340	680	10	225	450
M16	16.0	2.00	20	400	800	15	300	600	10	200	400
M 2	2.0	0.40	15	2385	954	10	1590	636			
M 2.2	2.2	0.45	15	2170	977	10	1445	650			
M 2.5	2.5	0.45	15	1910	860	10	1275	574			
M 3	3.0	0.50	15	1590	795	10	1060	530			
M 4	4.0	0.70	15	1195	837	10	795	557			
M 5	5.0	0.80	15	955	764	10	635	508			
M 6	6.0	1.00	15	795	795	10	530	530			
M 8	8.0	1.25	15	595	744	10	400	500			
M10	10.0	1.50	15	475	713	10	320	480			
M12	12.0	1.75	15	400	700	10	265	464			
M14	14.0	2.00	15	340	680	10	225	450			
M16	16.0	2.00	15	300	600	10	200	400			

## Material

Stainless steel  
ferritic/martensitic  
A<sub>5</sub> > 10%



Stainless steel  
ferritic/martensitic  
A<sub>5</sub> > 10%



Stainless steel  
[Cr-Ni/1.4301]



Stainless steel  
[Cr-Ni/1.4301]



M	ø [mm]	P [mm]	V <sub>c</sub> 1.5 x d			V <sub>c</sub> 2.0 x d					
			n [min <sup>-1</sup> ]	v <sub>f</sub> [100%]		n [min <sup>-1</sup> ]	v <sub>f</sub> [100%]		n [min <sup>-1</sup> ]	v <sub>f</sub> [100%]	
M 2	2.0	0.40	15	2385	954	10	1590	636			
M 2.2	2.2	0.45	15	2170	977	10	1445	650			
M 2.5	2.5	0.45	15	1910	860	10	1275	574			
M 3	3.0	0.50	15	1590	795	10	1060	530			
M 4	4.0	0.70	15	1195	837	10	795	557			
M 5	5.0	0.80	15	955	764	10	635	508			
M 6	6.0	1.00	15	795	795	10	530	530			
M 8	8.0	1.25	15	595	744	10	400	500			
M10	10.0	1.50	15	475	713	10	320	480			
M12	12.0	1.75	15	400	700	10	265	464			
M14	14.0	2.00	15	340	680	10	225	450			
M16	16.0	2.00	15	300	600	10	200	400			
M 2	2.0	0.40	15	2385	954	10	1590	636			
M 2.2	2.2	0.45	15	2170	977	10	1445	650			
M 2.5	2.5	0.45	15	1910	860	10	1275	574			
M 3	3.0	0.50	15	1590	795	10	1060	530			
M 4	4.0	0.70	15	1195	837	10	795	557			
M 5	5.0	0.80	15	955	764	10	635	508			
M 6	6.0	1.00	15	795	795	10	530	530			
M 8	8.0	1.25	15	595	744	10	400	500			
M10	10.0	1.50	15	475	713	10	320	480			
M12	12.0	1.75	15	400	700	10	265	464			
M14	14.0	2.00	15	340	680	10	225	450			
M16	16.0	2.00	15	300	600	10	200	400			

# Cold forming taps

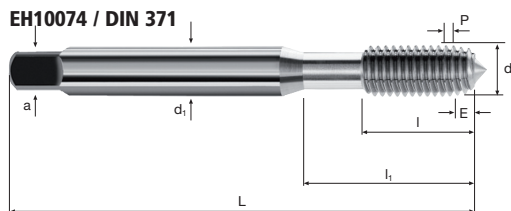


**M** **ISO 3 (6G)**

**60°** **HSS PM/F**

**DIN 371/376**

**Form E**



**EH10075 / DIN 376**



**Rm** < 850    **Rm** 850-1100    **Inox** Stainless

Example: Order-N°.										Article-N°.		α-Code		TiCN	
										<b>EH10074</b>		<b>.034</b>		<b>EH10074</b>	
∅ Code	d	P	L	l	l <sub>1</sub>	d <sub>1</sub>	a	○	⌘						
.034	M 2	0.40	45	8	—	2.8	2.1	3	1.80						●
.036	M 2.2	0.45	45	9	—	2.8	2.1	3	2.00						●
.040	M 2.5	0.45	50	9	—	2.8	2.1	3	2.30						●
.044	M 3	0.50	56	12	18.0	3.5	2.7	3	2.80						●
.058	M 4	0.70	63	13	21.0	4.5	3.4	3	3.70						●
.084	M 5	0.80	70	15	25.0	6.0	4.9	4	4.60						●
.088	M 6	1.00	80	17	30.0	6.0	4.9	4	5.50						●
.160	M 8	1.25	90	20	35.0	8.0	6.2	5	7.40						●
.174	M10	1.50	100	22	39.0	10.0	8.0	5	9.30						●

Example: Order-N°.										Article-N°.		α-Code		TiCN	
										<b>EH10075</b>		<b>.240</b>		<b>EH10075</b>	
∅ Code	d	P	L	l	l <sub>1</sub>	d <sub>1</sub>	a	○	⌘						
.240	M12	1.75	110	24	40	9.0	7.0	7	11.20						●
.244	M14	2.00	110	26	40	11.0	9.0	7	13.10						●
.246	M16	2.00	110	27	40	12.0	9.0	7	15.10						●

CF