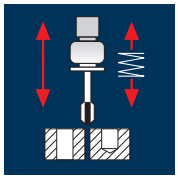
Application



Material	MF	ø [mm]	P [mm]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]	v_c 3.0 x d	n [min⁻¹]	v_f [100%]
Unalloyed aluminium	M 4	4.0	0.50	25	1990	995	20	1590	795	15	1195	598
	M 5	5.0	0.50	25	1590	795	20	1275	638	15	955	478
	M 6	6.0	0.50	25	1325	663	20	1060	530	15	795	398
	M 6	6.0	0.75	25	1325	994	20	1060	795	15	795	596
	M 8	8.0	0.75	25	995	746	20	795	596	15	595	446
	M10	10.0	0.75	25	795	596	20	635	476	15	475	356
	M 8	8.0	1.00	25	995	995	20	795	795	15	595	595
	M10	10.0	1.00	25	795	795	20	635	635	15	475	475
	M10	10.0	1.25	25	795	994	20	635	794	15	475	594
Unalloyed aluminium	M12	12.0	1.00	25	665	665	20	530	530	15	400	400
	M14	14.0	1.00	25	570	570	20	455	455	15	340	340
	M16	16.0	1.00	25	495	495	20	400	400	15	300	300
	M12	12.0	1.25	25	665	831	20	530	663	15	400	500
	M12	12.0	1.50	25	665	998	20	530	795	15	400	600
	M14	14.0	1.50	25	570	855	20	455	683	15	340	510
	M16	16.0	1.50	25	495	743	20	400	600	15	300	450
	M20	20.0	1.50	25	400	600	20	320	480	15	240	360
Wrought aluminium alloys Si < 6% not hardened	M 4	4.0	0.50	30	2385	1193	25	1990	995	20	1590	795
	M 5	5.0	0.50	30	1910	955	25	1590	795	20	1275	638
	M 6	6.0	0.50	30	1590	795	25	1325	663	20	1060	530
	M 6	6.0	0.75	30	1590	1193	25	1325	994	20	1060	795
	M 8	8.0	0.75	30	1195	896	25	995	746	20	795	596
	M10	10.0	0.75	30	955	716	25	795	596	20	635	476
	M 8	8.0	1.00	30	1195	1195	25	995	995	20	795	795
	M10	10.0	1.00	30	955	955	25	795	795	20	635	635
	M10	10.0	1.25	30	955	1194	25	795	994	20	635	794
Wrought aluminium alloys Si < 6% not hardened	M12	12.0	1.00	30	795	795	25	665	665	20	530	530
	M14	14.0	1.00	30	680	680	25	570	570	20	455	455
	M16	16.0	1.00	30	595	595	25	495	495	20	400	400
	M12	12.0	1.25	30	795	994	25	665	831	20	530	663
	M12	12.0	1.50	30	795	1193	25	665	998	20	530	795
	M14	14.0	1.50	30	680	1020	25	570	855	20	455	683
	M16	16.0	1.50	30	595	893	25	495	743	20	400	600
	M20	20.0	1.50	30	475	713	25	400	600	20	320	480

Material	MF	ø [mm]	P [mm]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]	v_c 3.0 x d	n [min⁻¹]	v_f [100%]
Unalloyed copper	M 4	4.0	0.50	15	1195	598	10	795	398	10	795	398
	M 5	5.0	0.50	15	955	478	10	635	318	10	635	318
	M 6	6.0	0.50	15	795	398	10	530	265	10	530	265
	M 6	6.0	0.75	15	795	596	10	530	398	10	530	398
	M 8	8.0	0.75	15	595	446	10	400	300	10	400	300
	M10	10.0	0.75	15	475	356	10	320	240	10	320	240
	M 8	8.0	1.00	15	595	595	10	400	400	10	400	400
	M10	10.0	1.00	15	475	475	10	320	320	10	320	320
	M10	10.0	1.25	15	475	594	10	320	400	10	320	400
Unalloyed copper	M12	12.0	1.00	15	400	400	10	265	265	10	265	265
	M14	14.0	1.00	15	340	340	10	225	225	10	225	225
	M16	16.0	1.00	15	300	300	10	200	200	10	200	200
	M12	12.0	1.25	15	400	500	10	265	331	10	265	331
	M12	12.0	1.50	15	400	600	10	265	398	10	265	398
	M14	14.0	1.50	15	340	510	10	225	338	10	225	338
	M16	16.0	1.50	15	300	450	10	200	300	10	200	300
	M20	20.0	1.50	15	240	360	10	160	240	10	160	240
Non ferrous metal A_5 > 15%	M 4	4.0	0.50	15	1195	598	10	795	398	10	795	398
	M 5	5.0	0.50	15	955	478	10	635	318	10	635	318
	M 6	6.0	0.50	15	795	398	10	530	265	10	530	265
	M 6	6.0	0.75	15	795	596	10	530	398	10	530	398
	M 8	8.0	0.75	15	595	446	10	400	300	10	400	300
	M10	10.0	0.75	15	475	356	10	320	240	10	320	240
	M 8	8.0	1.00	15	595	595	10	400	400	10	400	400
	M10	10.0	1.00	15	475	475	10	320	320	10	320	320
	M10	10.0	1.25	15	475	594	10	320	400	10	320	400
Non ferrous metal A_5 > 15%	M12	12.0	1.00	15	400	400	10	265	265	10	265	265
	M14	14.0	1.00	15	340	340	10	225	225	10	225	225
	M16	16.0	1.00	15	300	300	10	200	200	10	200	200
	M12	12.0	1.25	15	400	500	10	265	331	10	265	331
	M12	12.0	1.50	15	400	600	10	265	398	10	265	398
	M14	14.0	1.50	15	340	510	10	225	338	10	225	338
	M16	16.0	1.50	15	300	450	10	200	300	10	200	300
	M20	20.0	1.50	15	240	360	10	160	240	10	160	240

Cold forming taps

Al

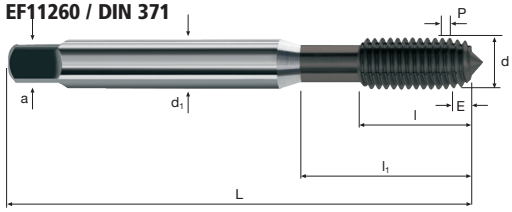
MF | ISO 2 (6H)

60° | HSS PM/F

DIN 371/374

X · P Form E

EF11260 / DIN 371



EF11261 / DIN 374

Al Aluminium > 99% | **Al** Aluminium Alloy | **Cu** Copper | CuZn Brass

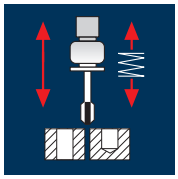
Example: Order-N°. Article-N°. **EF11260** ø-Code **.046**

Ø Code	d	P	L	l	l1	d1	a			F-DLC
										EF11260
.046	M 4	0.50	63	13	21	4.5	3.4	3	3.80	●
.048	M 5	0.50	70	15	25	6.0	4.9	4	4.80	●
.050	M 6	0.50	80	17	30	6.0	4.9	4	5.80	●
.064	M 6	0.75	80	17	30	6.0	4.9	4	5.65	●
.066	M 8	0.75	90	20	35	8.0	6.2	4	7.65	●
.068	M10	0.75	100	22	39	10.0	8.0	4	9.65	●
.090	M 8	1.00	90	20	35	8.0	6.2	4	7.55	●
.092	M10	1.00	100	22	39	10.0	8.0	4	9.55	●
.162	M10	1.25	100	22	39	10.0	8.0	4	9.40	●

Example: Order-N°. Article-N°. **EF11261** ø-Code **.094**

Ø Code	d	P	L	l	l1	d1	a			F-DLC
										EF11261
.094	M12	1.00	100	18	39	9.0	7.0	5	11.50	●
.096	M14	1.00	100	18	39	11.0	9.0	5	13.50	●
.098	M16	1.00	100	18	39	12.0	9.0	5	15.50	●
.164	M12	1.25	100	22	39	9.0	7.0	5	11.40	●
.176	M12	1.50	100	22	39	9.0	7.0	5	11.30	●
.178	M14	1.50	100	22	39	11.0	9.0	5	13.30	●
.180	M16	1.50	100	22	39	12.0	9.0	5	15.30	●
.184	M20	1.50	125	26	50	16.0	12.0	6	19.30	●

Application



Material	MF	ø [mm]	P [mm]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]	v_c 3.0 x d	n [min⁻¹]	v_f [100%]
Steel < 850 N/mm² A_5 > 10%	M 4	4.0	0.50	20	1590	795	15	1195	598	10	795	398
	M 5	5.0	0.50	20	1275	638	15	955	478	10	635	318
	M 6	6.0	0.50	20	1060	530	15	795	398	10	530	265
	M 6	6.0	0.75	20	1060	795	15	795	596	10	530	398
	M 8	8.0	0.75	20	795	596	15	595	446	10	400	300
	M10	10.0	0.75	20	635	476	15	475	356	10	320	240
	M 8	8.0	1.00	20	795	795	15	595	595	10	400	400
	M10	10.0	1.00	20	635	635	15	475	475	10	320	320
	M10	10.0	1.25	20	635	794	15	475	594	10	320	400
Steel < 850 N/mm² A_5 > 10%	M12	12.0	1.00	20	530	530	15	400	400	10	265	265
	M14	14.0	1.00	20	455	455	15	340	340	10	225	225
	M16	16.0	1.00	20	400	400	15	300	300	10	200	200
	M12	12.0	1.25	20	530	663	15	400	500	10	265	331
	M12	12.0	1.50	20	530	795	15	400	600	10	265	398
	M14	14.0	1.50	20	455	683	15	340	510	10	225	338
	M16	16.0	1.50	20	400	600	15	300	450	10	200	300
	M20	20.0	1.50	20	320	480	15	240	360	10	160	240
Steel 850 - 1100 N/mm² A_5 > 10%	M 4	4.0	0.50	15	1195	598	10	795	398			
	M 5	5.0	0.50	15	955	478	10	635	318			
	M 6	6.0	0.50	15	795	398	10	530	265			
	M 6	6.0	0.75	15	795	596	10	530	398			
	M 8	8.0	0.75	15	595	446	10	400	300			
	M10	10.0	0.75	15	475	356	10	320	240			
	M 8	8.0	1.00	15	595	595	10	400	400			
	M10	10.0	1.00	15	475	475	10	320	320			
	M10	10.0	1.25	15	475	594	10	320	400			
Steel 850 - 1100 N/mm² A_5 > 10%	M12	12.0	1.00	15	400	400	10	265	265			
	M14	14.0	1.00	15	340	340	10	225	225			
	M16	16.0	1.00	15	300	300	10	200	200			
	M12	12.0	1.25	15	400	500	10	265	331			
	M12	12.0	1.50	15	400	600	10	265	398			
	M14	14.0	1.50	15	340	510	10	225	338			
	M16	16.0	1.50	15	300	450	10	200	300			
	M20	20.0	1.50	15	240	360	10	160	240			

Material	MF	ø [mm]	P [mm]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]
Stainless steel ferritc/martensitic A_5 > 10%	M 4	4.0	0.50	15	1195	598	10	795	398
	M 5	5.0	0.50	15	955	478	10	635	318
	M 6	6.0	0.50	15	795	398	10	530	265
	M 6	6.0	0.75	15	795	596	10	530	398
	M 8	8.0	0.75	15	595	446	10	400	300
	M10	10.0	0.75	15	475	356	10	320	240
	M 8	8.0	1.00	15	595	595	10	400	400
	M10	10.0	1.00	15	475	475	10	320	320
	M10	10.0	1.25	15	475	594	10	320	400
Stainless steel ferritc/martensitic A_5 > 10%	M12	12.0	1.00	15	400	400	10	265	265
	M14	14.0	1.00	15	340	340	10	225	225
	M16	16.0	1.00	15	300	300	10	200	200
	M12	12.0	1.25	15	400	500	10	265	331
	M12	12.0	1.50	15	400	600	10	265	398
	M14	14.0	1.50	15	340	510	10	225	338
	M16	16.0	1.50	15	300	450	10	200	300
	M20	20.0	1.50	15	240	360	10	160	240
Stainless steel [Cr-Ni/1.4301]	M 4	4.0	0.50	15	1195	598	10	795	398
	M 5	5.0	0.50	15	955	478	10	635	318
	M 6	6.0	0.50	15	795	398	10	530	265
	M 6	6.0	0.75	15	795	596	10	530	398
	M 8	8.0	0.75	15	595	446	10	400	300
	M10	10.0	0.75	15	475	356	10	320	240
	M 8	8.0	1.00	15	595	595	10	400	400
	M10	10.0	1.00	15	475	475	10	320	320
	M10	10.0	1.25	15	475	594	10	320	400
Stainless steel [Cr-Ni/1.4301]	M12	12.0	1.00	15	400	400	10	265	265
	M14	14.0	1.00	15	340	340	10	225	225
	M16	16.0	1.00	15	300	300	10	200	200
	M12	12.0	1.25	15	400	500	10	265	331
	M12	12.0	1.50	15	400	600	10	265	398
	M14	14.0	1.50	15	340	510	10	225	338
	M16	16.0	1.50	15	300	450	10	200	300
	M20	20.0	1.50	15	240	360	10	160	240

Cold forming taps

St

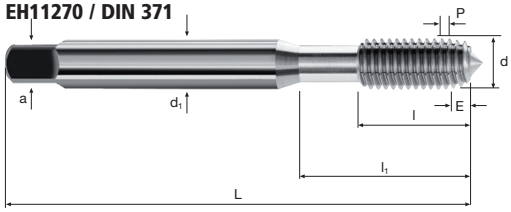
MF | ISO 2 (6H)

60° | HSS PM/F

DIN 371/374

X · P Form E

EH11270 / DIN 371



EH11271 / DIN 374

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

Example: Order-N°. Article-N°. **EH11270** ø-Code **.046**

Ø Code	d	P	L	l	l_1	d_1	a			TiCN
										EH11270
.046	M 4	0.50	63	13	21	4.5	2.1	4	3.80	●
.048	M 5	0.50	70	15	25	6.0	2.7	4	4.80	●
.050	M 6	0.50	80	17	30	6.0	3.4	4	5.80	●
.064	M 6	0.75	80	17	30	6.0	3.4	4	5.65	●
.066	M 8	0.75	90	20	35	8.0	4.9	5	7.65	●
.068	M10	0.75	100	22	39	10.0	5.5	5	9.65	●
.090	M 8	1.00	90	20	35	8.0	4.9	5	7.55	●
.092	M10	1.00	100	22	39	10.0	5.5	5	9.55	●
.162	M10	1.25	100	22	39	10.0	5.5	5	9.40	●

Example: Order-N°. Article-N°. **EH11271** ø-Code **.094**

Ø Code	d	P	L	l	l_1	d_1	a			TiCN
										EH11271
.094	M12	1.00	100	18	39	9.0	7.0	7	11.50	●
.096	M14	1.00	100	18	39	11.0	9.0	7	13.50	●
.098	M16	1.00	100	18	39	12.0	9.0	7	15.50	●
.164	M12	1.25	100	22	39	9.0	7.0	7	11.40	●
.176	M12	1.50	100	22	39	9.0	7.0	7	11.30	●
.178	M14	1.50	100	22	39	11.0	9.0	7	13.30	●
.180	M16	1.50	100	22	39	12.0	9.0	7	15.30	●
.184	M20	1.50	125	26	50	16.0	12.0	7	19.30	●