



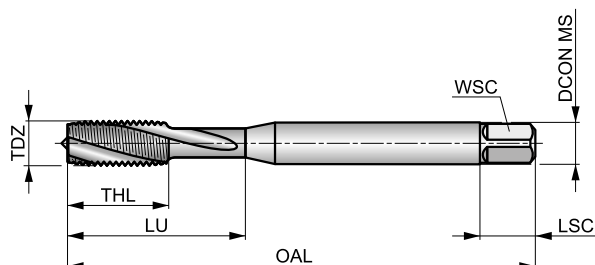
E212

DORMER



HSS-E-PM 15° Spiral Flute Machine Tap, Metric, DIN Standard

High performance slow spiral flute tap for up to 1.5xD deep holes. With 15° helix for more stability threading of harder and higher strength steels. The reinforced shank increases strength against torsional twist. TiN coated to allow higher cutting speeds, improve performance and extend tool life.



M	DIN 371	6H
1.5xD	HSS-E PM	
C 2-3	λ 15°	
R	TiN	

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

	P2.2 ■ 28	P2.3 ▣ 25	P3.1 ■ 15	P3.2 ■ 12	P4.1 ■ 9	N1.3 ▣ 8	N2.1 ▣ 31	N2.2 ▣ 28	N2.3 ▣ 20			
Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU		
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]		
E212M3	3	0.50	56.0	9	3.50	2.70	6	3	2.50	18.00		
E212M4	4	0.70	63.0	12	4.50	3.40	6	3	3.30	21.00		
E212M5	5	0.80	70.0	13	6.00	4.90	8	3	4.20	25.00		
E212M6	6	1.00	80.0	15	6.00	4.90	8	3	5.00	30.00		
E212M8	8	1.25	90.0	18	8.00	6.20	9	3	6.80	35.00		
E212M10	10	1.50	100.0	20	10.00	8.00	11	3	8.50	39.00		