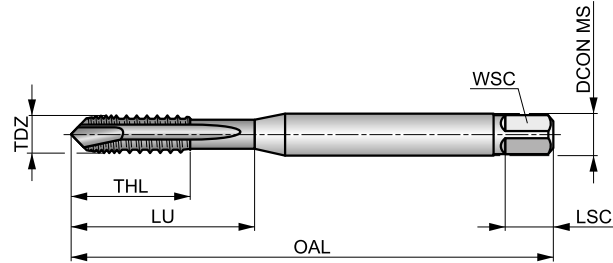


**E422****DORMER****HSS-E-PM Spiral Point Interrupted Thread Machine Tap, Metric, DIN Standard**

High performance spiral point tap for through holes only. Interrupted threads to lessen the damaging effects of chip wedging, reduce friction, permit better lubrication and allow more space for the passage of chips. The reinforced shank increases the strength and TiN coating enables higher cutting speeds and performance.



|                   |                   |                     |
|-------------------|-------------------|---------------------|
|                   | DIN<br><b>371</b> | <b>6H</b>           |
|                   | <b>3xD</b>        | <b>HSS-E<br/>PM</b> |
| <b>B</b><br>3.5-5 |                   |                     |
|                   |                   |                     |

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

|                     |                     |                     |                     |                     |                     |                     |                     |                    |                     |                     |                     |                     |                     |
|---------------------|---------------------|---------------------|---------------------|---------------------|---------------------|---------------------|---------------------|--------------------|---------------------|---------------------|---------------------|---------------------|---------------------|
| <b>P1.1</b><br>■ 37 | <b>P1.2</b><br>■ 42 | <b>P1.3</b><br>■ 43 | <b>P2.1</b><br>■ 32 | <b>P2.2</b><br>■ 28 | <b>P2.3</b><br>■ 25 | <b>P3.1</b><br>■ 15 | <b>P3.2</b><br>■ 12 | <b>P4.1</b><br>■ 9 | <b>N1.1</b><br>■ 25 | <b>N1.2</b><br>■ 19 | <b>N1.3</b><br>■ 13 | <b>N2.1</b><br>■ 46 | <b>N2.2</b><br>■ 42 |
| <b>N2.3</b><br>■ 30 | <b>N3.1</b><br>■ 76 | <b>N3.2</b><br>■ 45 | <b>N3.3</b><br>■ 23 | <b>N4.1</b><br>■ 30 |                     |                     |                     |                    |                     |                     |                     |                     |                     |

| Product        | TDZ | TP   | OAL   | THL  | DCON MS | WSC  | LSC  | NOF | PHD  | LU    |
|----------------|-----|------|-------|------|---------|------|------|-----|------|-------|
|                |     | [mm] | [mm]  | [mm] | [mm]    | [mm] | [mm] |     | [mm] | [mm]  |
| <b>E422M3</b>  | 3   | 0.50 | 56.0  | 9    | 3.50    | 2.70 | 6    | 3   | 2.50 | 18.00 |
| <b>E422M4</b>  | 4   | 0.70 | 63.0  | 12   | 4.50    | 3.40 | 6    | 3   | 3.30 | 21.00 |
| <b>E422M5</b>  | 5   | 0.80 | 70.0  | 13   | 6.00    | 4.90 | 8    | 3   | 4.20 | 25.00 |
| <b>E422M6</b>  | 6   | 1.00 | 80.0  | 15   | 6.00    | 4.90 | 8    | 3   | 5.00 | 30.00 |
| <b>E422M8</b>  | 8   | 1.25 | 90.0  | 18   | 8.00    | 6.20 | 9    | 3   | 6.80 | 35.00 |
| <b>E422M10</b> | 10  | 1.50 | 100.0 | 20   | 10.00   | 8.00 | 11   | 3   | 8.50 | 39.00 |