suttontools
world class cutting tools

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Customer Service: 1800 335 350
Email: cservice@sutton.com.au
http://www.suttontools.com

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T409 - HSS TAPS - MACHINE - SPIRAL FLUTE TAPS - Sutton Tools

Features:

- General purpose use
- Suitable for materials up to 1000N/mm2
- Blind holes
- Depths up to approx. 2.5 x d1

Specifications:

Designation:	N
Material:	HSSE V3
Finish:	Brt
Max Cut Depth:	2.5xD
Shank Form:	A
Helix Angle:	R40
Type:	Spiral Flute
Standard:	ISO529
Thread Form:	MF
Nut Tolerance:	ISO 2 / 6H
Lead:	Form C / 3 x P

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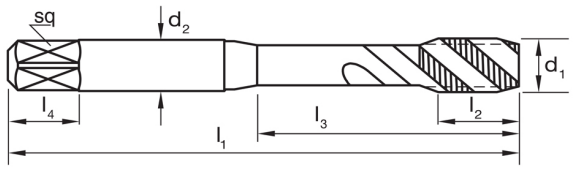
Range:



Item #	d1	Pitch	Limit	l1	l2	l3	d2	sq	l4	z	Drill Ø
T4090503	MF5	0.5	ISO 2 / 6H	58	16	22	5	4	7	3	4.5
T4090604	MF6	0.75	ISO 2 / 6H	66	19	26	6.3	5	8	3	5.3
T4090805	MF8	1	ISO 2 / 6H	72	22	30	8	6.3	9	3	7
T4091005	MF10	1	ISO 2 / 6H	80	24	34	10	8	11	3	9
T4091006	MF10	1.25	ISO 2 / 6H	80	24	34	10	8	11	3	8.8
T4091206	MF12	1.25	ISO 2 / 6H	89	29	-	9	7.1	10	3	10.8
T4091207	MF12	1.5	ISO 2 / 6H	89	29	-	9	7.1	10	3	10.5
T4091406	MF14	1.25	ISO 2 / 6H	95	30	-	11.2	9	12	3	12.8
T4091407	MF14	1.5	ISO 2 / 6H	95	30	-	11.2	9	12	3	12.5
T4091607	MF16	1.5	ISO 2 / 6H	102	32	-	12.5	10	13	3	14.5
T4091807	MF18	1.5	ISO 2 / 6H	112	37	-	14	11.2	14	4	16.5
T4092007	MF20	1.5	ISO 2 / 6H	112	37	-	14	11.2	14	4	18.5
T4092207	MF22	1.5	ISO 2 / 6H	118	38	-	16	12.5	16	4	20.5

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Applications:

ISO	VDI	Description	Condition	Hardness	Strength	Optimal
P	1	Steel - Non-alloy, cast & free cutting (~ 0.15 %C)	Annealed	125HB	440MPa	●
P	2	Steel - Non-alloy, cast & free cutting (~ 0.45 %C)	Annealed	190HB	640MPa	●
P	3	Steel - Non-alloy, cast & free cutting (~ 0.45 %C)	Quenched & Tempered	250HB	840MPa	○
P	4	Steel - Non-alloy, cast & free cutting (~ 0.75 %C)	Annealed	270HB	910MPa	○
P	5	Steel - Non-alloy, cast & free cutting (~ 0.75 %C)	Quenched & Tempered	300HB	1010MPa	
P	6	Steel - Low alloy & cast < 5% of alloying elements	Annealed	180HB	610MPa	●
P	7	Steel - Low alloy & cast < 5% of alloying elements	Quenched & Tempered	275HB	930MPa	
P	8	Steel - Low alloy & cast < 5% of alloying elements	Quenched & Tempered	300HB	1010MPa	
P	9	Steel - Low alloy & cast < 5% of alloying elements	Quenched & Tempered	350HB	1180MPa	
P	10	Steel - High alloy, cast & tool	Annealed	200HB	680MPa	
P	11	Steel - High alloy, cast & tool	Hardened & Tempered	325HB	1100MPa	
P	12	Steel - Corrosion resistant & cast - Ferritic / Martensitic	Annealed	200HB	680MPa	
P	13	Steel - Corrosion resistant & cast - Martensitic	Quenched & Tempered	240HB	810MPa	
M	14.1	Stainless Steel - Austenitic	Age Hardened	180HB	610MPa	○
M	14.2	Stainless Steel - Duplex		250HB	840MPa	○
M	14.3	Stainless Steel - Precipitation Hardening		250HB	840MPa	
K	15	Cast Iron, Grey (GG) - Ferritic / Pearlitic		180HB	610MPa	
K	16	Cast Iron, Grey (GG) - Pearlitic		260HB	880MPa	
K	17	Cast Iron, Nodular (GGG) - Ferritic		160HB	570MPa	○
K	18	Cast Iron, Nodular (GGG) - Pearlitic		250HB	840MPa	○
K	19	Cast Iron, Malleable - Ferritic		130HB	460MPa	
K	20	Cast Iron, Malleable - Pearlitic		230HB	780MPa	
N	21	Aluminum & Magnesium, wrought alloy - Non Heat Treatable		60HB	210MPa	○
N	22	Aluminum & Magnesium, wrought alloy - Heat Treatable	Age Hardened	100HB	360MPa	○
N	23	Aluminum & Magnesium, cast alloy ≤12% Si - Non Heat Treatabl		75HB	270MPa	○
N	24	Aluminum & Magnesium, cast alloy ≤12% Si - Heat Treatable	Age Hardened	90HB	320MPa	○
N	25	Aluminum & Magnesium, cast alloy >12% Si - Non Heat Treatabl		130HB	460MPa	
N	26	Copper & Copper alloys (Brass/Bronze) - Free cutting, Pb > 1		110HB	390MPa	●
N	27	Copper & Copper alloys (Brass/Bronze) - Brass (CuZn, CuSnZn)		90HB	320MPa	○
N	28	Copper & Copper alloys (Brass/Bronze) - Bronze (CuSn)		100HB	360MPa	○
N	29	Non-metallic - Thermosetting & fiber-reinforced plastics				
N	30	Non-metallic - Hard rubber, wood etc.				
S	31	High temperature alloys - Fe based	Annealed	200HB	680MPa	
S	32	High temperature alloys - Fe based	Age Hardened	280HB	950MPa	
S	33	High temperature alloys - Ni / Co based	Annealed	250HB	840MPa	
S	34	High temperature alloys - Ni / Co based	Age Hardened	350HB	1180MPa	
S	35	High temperature alloys - Ni / Co based	Cast	320HB	1080MPa	
S	36	Titanium & Titanium alloys - CP Titanium			400MPa	
S	37.1	Titanium & Titanium alloys - Alpha alloys			860MPa	
S	37.2	Titanium & Titanium alloys - Alpha / Beta alloys	Annealed		960MPa	
S	37.3	Titanium & Titanium alloys - Alpha / Beta alloys	Age Hardened		1170MPa	
S	37.4	Titanium & Titanium alloys - Beta alloys	Annealed		830MPa	
S	37.5	Titanium & Titanium alloys - Beta alloys	Age Hardened		1400MPa	
H	38.1	Hardened steel	Hardened & Tempered	45HRC		
H	38.2	Hardened steel	Hardened & Tempered	55HRC		

KEY

● Optimal ○ Effective | P Steel | M Stainless | K Cast Iron | N Non-Ferous Metals | S Titanium & Super Alloys | H Hard Materials