



E255

DORMER

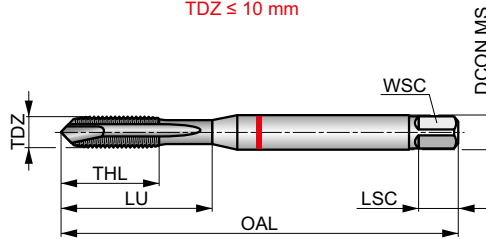


Red SHARK, Spiral Point Metric Machine Tap, DIN Standard

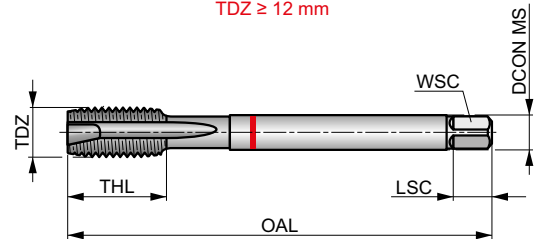
Through hole tap with reinforced or reduced shank for medium to high strength steels. Unique HSS-E-PM steel with bright surface finish provide consistency and process security.

SHARK

TDZ ≤ 10 mm



TDZ ≥ 12 mm



| | | |
|-------------------|----------------|---------------------|
| M | DIN 371/376 | 6HX |
| | 2.5xD | HSS-E PM |
| B 3.5-5 | | R |
| Bright | | |

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

| | | | | | | | | | |
|---------------------|---------------------|--------------------|--------------------|--------------------|--------------------|---------------------|--------------------|--------------------|--------------------|
| P2.3 ■ 11 | P3.1 ■ 10 | P3.2 ■ 8 | P3.3 ■ 7 | P4.1 ■ 6 | P4.2 ■ 5 | S1.2 ▣ 12 | S2.1 ▣ 3 | S3.1 ▣ 2 | S4.1 ▣ 2 |
|---------------------|---------------------|--------------------|--------------------|--------------------|--------------------|---------------------|--------------------|--------------------|--------------------|

| Product | TDZ | TP | OAL | THL | DCON MS | WSC | LSC | NOF | PHD | LU |
|----------------|-----|------|-------|-----|---------|-------|-----|-----|-------|-------|
| | | | | | | | | | | |
| E255M3 | 3 | 0.50 | 56.0 | 9 | 3.50 | 2.70 | 6 | 3 | 2.50 | 18.00 |
| E255M4 | 4 | 0.70 | 63.0 | 12 | 4.50 | 3.40 | 6 | 3 | 3.30 | 21.00 |
| E255M5 | 5 | 0.80 | 70.0 | 13 | 6.00 | 4.90 | 8 | 3 | 4.20 | 25.00 |
| E255M6 | 6 | 1.00 | 80.0 | 15 | 6.00 | 4.90 | 8 | 3 | 5.00 | 30.00 |
| E255M8 | 8 | 1.25 | 90.0 | 18 | 8.00 | 6.20 | 9 | 3 | 6.80 | 35.00 |
| E255M10 | 10 | 1.50 | 100.0 | 20 | 10.00 | 8.00 | 11 | 3 | 8.50 | 39.00 |
| E255M12 | 12 | 1.75 | 110.0 | 23 | 9.00 | 7.00 | 10 | 3 | 10.30 | – |
| E255M14 | 14 | 2.00 | 110.0 | 25 | 11.00 | 9.00 | 12 | 3 | 12.00 | – |
| E255M16 | 16 | 2.00 | 110.0 | 25 | 12.00 | 9.00 | 12 | 3 | 14.00 | – |
| E255M20 | 20 | 2.50 | 140.0 | 30 | 16.00 | 12.00 | 15 | 4 | 17.50 | – |



E256



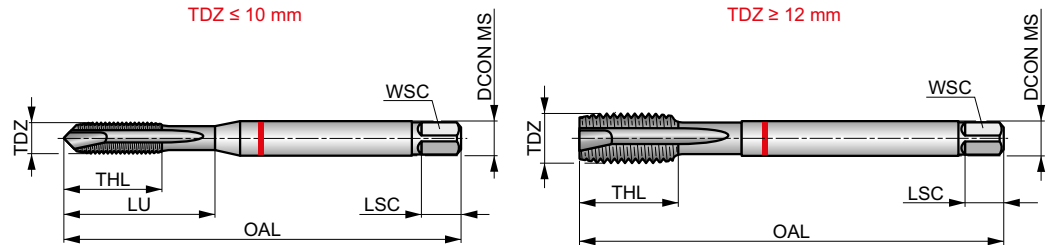
Red SHARK Spiral Point Metric Machine Tap, DIN Standard

High performance through hole tap with reinforced or reduced shank for medium to high strength steel. Unique HSS-E-PM substrate along with TiAlN-Top coating and edge treatment provide superior performance, consistency, extended tool life and higher process security.

SHARK



| | | |
|--|----------------|----------|
| | DIN 371/376 | 6HX |
| | 2.5xD | HSS-E-PM |
| | B 3.5-5 | |
| | | |



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

| | | | | | | | | | | |
|---------------------|---------------------|---------------------|---------------------|---------------------|---------------------|---------------------|--------------------|--------------------|--------------------|--------------------|
| P2.3 ■ 27 | P3.1 ■ 25 | P3.2 ■ 20 | P3.3 ■ 17 | P4.1 ■ 15 | P4.2 ■ 13 | P4.3 ■ 10 | S1.2 ■ 3 | S2.1 ■ 4 | S3.1 ■ 3 | S4.1 ■ 3 |
|---------------------|---------------------|---------------------|---------------------|---------------------|---------------------|---------------------|--------------------|--------------------|--------------------|--------------------|

| Product | TDZ | TP | OAL | THL | DCON MS | WSC | LSC | NOF | PHD | LU |
|---------|-----|------|-------|-----|---------|-------|-----|-----|-------|-------|
| | | | | | | | | | | |
| E256M3 | 3 | 0.50 | 56.0 | 9 | 3.50 | 2.70 | 6 | 3 | 2.50 | 18.00 |
| E256M4 | 4 | 0.70 | 63.0 | 12 | 4.50 | 3.40 | 6 | 3 | 3.30 | 21.00 |
| E256M5 | 5 | 0.80 | 70.0 | 13 | 6.00 | 4.90 | 8 | 3 | 4.20 | 25.00 |
| E256M6 | 6 | 1.00 | 80.0 | 15 | 6.00 | 4.90 | 8 | 3 | 5.00 | 30.00 |
| E256M8 | 8 | 1.25 | 90.0 | 18 | 8.00 | 6.20 | 9 | 3 | 6.80 | 35.00 |
| E256M10 | 10 | 1.50 | 100.0 | 20 | 10.00 | 8.00 | 11 | 3 | 8.50 | 39.00 |
| E256M12 | 12 | 1.75 | 110.0 | 23 | 9.00 | 7.00 | 10 | 3 | 10.30 | – |
| E256M16 | 16 | 2.00 | 110.0 | 25 | 12.00 | 9.00 | 12 | 3 | 14.00 | – |
| E256M20 | 20 | 2.50 | 140.0 | 30 | 16.00 | 12.00 | 15 | 4 | 17.50 | – |



E260

DORMER

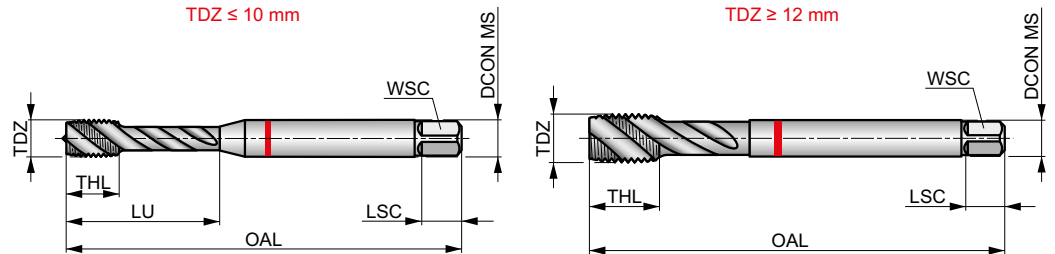


Red SHARK 45° Spiral Flute Metric Machine Tap, DIN Standard

Through hole tap with reinforced or reduced shank for medium to high strength steels. Unique HSS-E-PM substrate with bright surface finish. Extra back taper to further facilitate chip evacuation, preventing chipping on the last threads of the tap and also reduces torque when the tap reverses.

SHARK

| | | |
|--|-------------|---------------|
| | DIN 371/376 | 6HX |
| | 2.5xD | HSS-E PM |
| | C 2-3 | λ 45° |
| | Bright | |



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

| Product | TDZ | TP | OAL | THL | DCON MS | WSC | LSC | NOF | PHD | LU |
|---------------------|-----|------|-------|-----|---------|-------|-----|-----|-------|-------|
| | | | | | | | | | | |
| P2.3 ■ 10 | | | | | | | | | | |
| P3.1 ■ 9 | | | | | | | | | | |
| P3.2 ■ 7 | | | | | | | | | | |
| P3.3 ■ 6 | | | | | | | | | | |
| P4.1 ■ 5 | | | | | | | | | | |
| P4.2 ■ 4 | | | | | | | | | | |
| S1.2 ■ 2 | | | | | | | | | | |
| S2.1 ■ 3 | | | | | | | | | | |
| S3.1 ■ 2 | | | | | | | | | | |
| S4.1 ■ 2 | | | | | | | | | | |
| E260M3 | 3 | 0.50 | 56.0 | 6 | 3.50 | 2.70 | 6 | 3 | 2.50 | 18.00 |
| E260M4 | 4 | 0.70 | 63.0 | 7 | 4.50 | 3.40 | 6 | 3 | 3.30 | 21.00 |
| E260M5 | 5 | 0.80 | 70.0 | 8 | 6.00 | 4.90 | 8 | 3 | 4.20 | 25.00 |
| E260M6 | 6 | 1.00 | 80.0 | 10 | 6.00 | 4.90 | 8 | 3 | 5.00 | 30.00 |
| E260M8 | 8 | 1.25 | 90.0 | 12 | 8.00 | 6.20 | 9 | 3 | 6.80 | 35.00 |
| E260M10 | 10 | 1.50 | 100.0 | 15 | 10.00 | 8.00 | 11 | 3 | 8.50 | 39.00 |
| E260M12 | 12 | 1.75 | 110.0 | 16 | 9.00 | 7.00 | 10 | 3 | 10.30 | – |
| E260M14 | 14 | 2.00 | 110.0 | 20 | 11.00 | 9.00 | 12 | 3 | 12.00 | – |
| E260M16 | 16 | 2.00 | 110.0 | 20 | 12.00 | 9.00 | 12 | 4 | 14.00 | – |
| E260M20 | 20 | 2.50 | 140.0 | 25 | 16.00 | 12.00 | 15 | 4 | 17.50 | – |



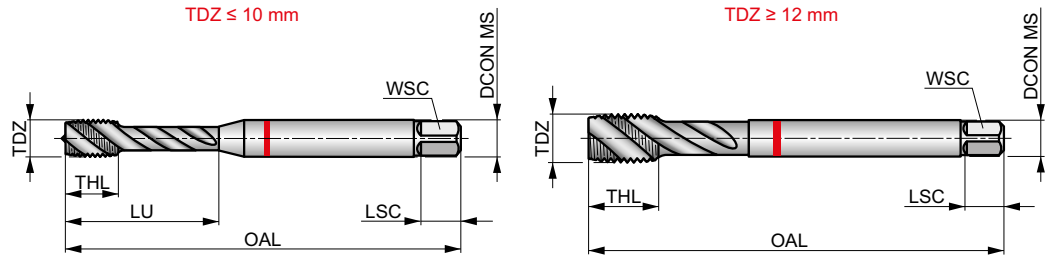
E261



Red SHARK 45° Spiral Flute Metric Machine Tap, DIN Standard

High performance blind hole tap for medium to high strength steels. Unique HSS-E-PM substrate with TiAIN-Top coating and additional edge treatment provide superior performance, consistency and extended tool life. Extra back taper further facilitates chip evacuation and reduces torque on tap reversal.

SHARK



| | | |
|-----------------|----------------|-------------|
| M | DIN 371/376 | 6HX |
| | 2.5xD | HSS-E PM |
| C 2-3 | | λ 45° |
| R | | |

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

| Product | TDZ | TP | OAL | THL | DCON MS | WSC | LSC | NOF | PHD | LU | Workpiece material group suitability and starting values for cutting speed (m/min) | | | | | | | | | | | |
|---------|-----|------|-------|-----|---------|-------|-----|-----|-------|-------|--|------|------|------|------|------|------|------|------|------|------|--|
| | | | | | | | | | | | P2.3 | P3.1 | P3.2 | P3.3 | P4.1 | P4.2 | P4.3 | S1.2 | S2.1 | S3.1 | S4.1 | |
| E261M3 | 3 | 0.50 | 56.0 | 6 | 3.50 | 2.70 | 6 | 3 | 2.50 | 18.00 | ■ 26 | ■ 24 | ■ 19 | ■ 16 | ■ 14 | ■ 12 | ▣ 9 | ▣ 2 | ▣ 3 | ▣ 2 | ▣ 2 | |
| E261M4 | 4 | 0.70 | 63.0 | 7 | 4.50 | 3.40 | 6 | 3 | 3.30 | 21.00 | | | | | | | | | | | | |
| E261M5 | 5 | 0.80 | 70.0 | 8 | 6.00 | 4.90 | 8 | 3 | 4.20 | 25.00 | | | | | | | | | | | | |
| E261M6 | 6 | 1.00 | 80.0 | 10 | 6.00 | 4.90 | 8 | 3 | 5.00 | 30.00 | | | | | | | | | | | | |
| E261M8 | 8 | 1.25 | 90.0 | 12 | 8.00 | 6.20 | 9 | 3 | 6.80 | 35.00 | | | | | | | | | | | | |
| E261M10 | 10 | 1.50 | 100.0 | 15 | 10.00 | 8.00 | 11 | 3 | 8.50 | 39.00 | | | | | | | | | | | | |
| E261M12 | 12 | 1.75 | 110.0 | 16 | 9.00 | 7.00 | 10 | 3 | 10.30 | – | | | | | | | | | | | | |
| E261M16 | 16 | 2.00 | 110.0 | 20 | 12.00 | 9.00 | 12 | 4 | 14.00 | – | | | | | | | | | | | | |
| E261M20 | 20 | 2.50 | 140.0 | 25 | 16.00 | 12.00 | 15 | 4 | 17.50 | – | | | | | | | | | | | | |