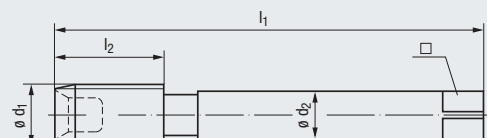


- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8
- M
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

DIN Length • DIN Shank

With internal chip collector



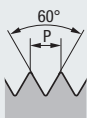
Reduced Shank

VA
Stainless Steel
Materials



M

ISO Metric Coarse Thread
DIN 13

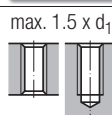


Class of Fit
Coating
Cutting Material
Technical Characteristics



Thread Depth
and Hole Shape

6HX
NE2
HSS Extra
C / 2-3
P / O 1)



Applications – Material

P 1.1-4.1
M 1.1-2.1
K 1.1-4.2

Reduced Shank

Tool Identification

C0803001

Nominal Size ϕd_1	P	l_1	mm l_2	ϕd_2	$\square$		Dimens. ID	Robust 2X-VA NE2	Flutes
M 20	2.5	140	32	16	12	17.5	.0120	★	5
M 22	2.5	140	32	18	14.5	19.5	.0122	★	5
M 24	3	160	34	18	14.5	21	.0124	★	5
M 27	3	160	36	20	16	24	.0127	★	5
M 30	3.5	180	40	22	18	26.5	.0130	★	6
M 33	3.5	180	40	25	20	29.5	.0133	★	6
M 36	4	200	50	28	22	32	.0136	★	6
M 42	4.5	200	56	32	24	37.5	.0142	★	6
M 45	4.5	220	58	36	29	40.5	.0145	★	6
M 48	5	250	65	36	29	43	.0148	★	6
M 52	5	250	65	40	32	47	.0152	★	6
M 56	5.5	250	70	40	32	50.5	.0156	★	7
M 60	5.5	280	70	45	35	54.5	.0160	★	7
M 64	6	315	75	50	39	58	.0164	★	7
M 68	6	315	75	50	39	62	.0168	★	7

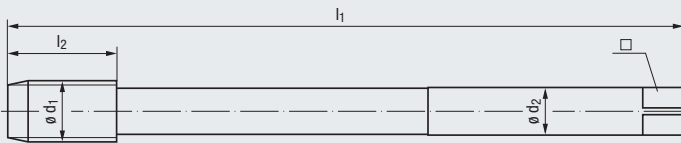
≥ M56 Shank with grooves for better handling!

1) If possible, use paste lubrication, coating both the tool and the walls of the drilled hole.
Lubrication with oil is possible only in the vertical machining of blind holes, if the hole is entirely filled with oil.

Larger sizes priced upon request.

The Complete Tool System

Robust 2X-VA Taps when used with a KSN Type tapping attachment creates the optimal tapping unit!

Extra Length • DIN ShankWith long flutes and long shank for thread depths up to max. $4 \times d_1$ 

M

**ISO Metric Coarse Thread
DIN 13**



Class of Fit
Coating
Cutting Material
Technical Characteristics



Thread Depth
and Hole Shape

Applications – Material

Z
CNC-Controlled
Machines



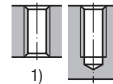
6HX

TiCN

HSS Extra

C / 2-3

E / 0

max. $4 \times d_1$ 

1)

P 1.1-4.1
K 1.1-4.2
N 1.4-6, 2.4-7
N 4.1

6HX

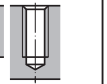
TiN

HSS Extra

R15

C / 2-3

E / 0

max. $4 \times d_1$ 

P 2.1-5.1
K 2.1-2
N 1.4-6, 2.4-5

6HX

TiN

HSS Extra

R15

C / 2-3

E / 0

max. $4 \times d_1$ 

P 2.1-5.1
K 2.1-2
N 1.4-6, 2.4-5

Reduced Shank**Tool Identification**

Dimens.
ID

C0539401

Rekord
2A-Z-1KZ-LF4
TiCN

Flutes

C4283701

Rekord
2D-Z-1KZ-LF4
TiN

Flutes

C4063701

Rekord
2D-Z-BF-1KZ-LF4
TiN

Flutes

Nominal Size $\varnothing d_1$	P	l_1	mm l_2	$\varnothing d_2$	$\square$								
M 20	2.5	190	25	16	12	17.5	.0120	★	4	★	3	★	3
M 22	2.5	230	27	18	14.5	19.5	.0122	★	4	★	3	★	3
M 24	3	240	30	18	14.5	21	.0124	★	4	★	3	★	3
M 27	3	250	30	20	16	24	.0127	★	4	★	3	★	3
M 30	3.5	270	35	22	18	26.5	.0130	★	4	★	4	★	4
M 33	3.5	290	35	25	20	29.5	.0133	★	4	★	4	★	4
M 36	4	310	40	28	22	32	.0136	★	4	★	4	★	4
M 42	4.5	340	45	32	24	37.5	.0142	★	4	★	4	★	4
M 45	4.5	360	45	36	29	40.5	.0145	★	4	★	4	★	4

1) Threading in through holes is possible only with external cooling/lubrication

