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Email: cservice@sutton.com.au
https://suttontools.com

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T386 -Straight Flute Taps - M - Bottoming -Sutton Tools

HSS Taps ISO Metric Straight Flute Bottoming

Features:

- General purpose use
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d1
- Suitable for materials up to 1000N/mm2

Specifications:

Designation:	N
Material:	HSS
Finish:	Brt
Max Cut Depth:	1xD
Shank Form:	A
Standard:	ISO529
Thread Form:	M
Nut Tolerance:	ISO 2 / 6H
Lead:	Bottoming

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Range:

Item #	d1	Limit	Length l1 (mm)	Length l2 (mm)	Diameter d2 (mm)	sq	Length l4 (mm)	z	Pitch
T3860200	M2	ISO 2 / 6H	41	8	2.5	2	4	3	0.40
T3860250	M2.5	ISO 2 / 6H	45	10	2.8	2.24	5	3	0.45
T3860300	M3	ISO 2 / 6H	48	11	3.15	2.5	5	3	0.50
T3860350	M3.5	ISO 2 / 6H	50	13	3.55	2.8	5	3	0.60
T3860400	M4	ISO 2 / 6H	53	13	4	3.15	6	3	0.70
T3860450	M4.5	ISO 2 / 6H	53	13	4.5	3.55	6	3	0.75
T3860500	M5	ISO 2 / 6H	58	16	5	4	7	3	0.80
T3860600	M6	ISO 2 / 6H	66	19	6.3	5	8	3	1.00
T3860700	M7	ISO 2 / 6H	66	19	7.1	5.6	8	4	1.00
T3860800	M8	ISO 2 / 6H	72	22	8	6.3	9	4	1.25
T3860900	M9	ISO 2 / 6H	72	22	9	7.1	10	4	1.25
T3861000	M10	ISO 2 / 6H	80	24	10	8	11	4	1.50
T3861100	M11	ISO 2 / 6H	85	25	8	6.3	9	4	1.50
T3861200	M12	ISO 2 / 6H	89	29	9	7.1	10	4	1.75
T3861400	M14	ISO 2 / 6H	95	30	11.2	9	12	4	2.00
T3861600	M16	ISO 2 / 6H	102	32	12.5	10	13	4	2.00
T3861800	M18	ISO 2 / 6H	112	37	14	11.2	14	4	2.50
T3862000	M20	ISO 2 / 6H	112	37	14	11.2	14	4	2.50
T3862200	M22	ISO 2 / 6H	118	38	16	12.5	16	4	2.50
T3862400	M24	ISO 2 / 6H	130	45	18	14	18	4	3.00
T3862700	M27	ISO 2 / 6H	135	45	20	16	20	4	3.00
T3863000	M30	ISO 2 / 6H	138	48	20	16	20	4	3.50
T3863300	M33	ISO 2 / 6H	151	51	22.4	18	22	4	3.50
T3863600	M36	ISO 2 / 6H	162	57	25	20	24	4	4.00
T3863900	M39	ISO 2 / 6H	170	60	28	22.4	26	4	4.00
T3864200	M42	ISO 2 / 6H	170	60	28	22.4	26	4	4.50
T3864500	M45	ISO 2 / 6H	187	67	31.5	25	28	4	4.50
T3864800	M48	ISO 2 / 6H	187	67	31.5	25	28	4	5.00
T3865200	M52	ISO 2 / 6H	200	70	35.5	28	31	4	5.00

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Applications:

ISO	VDI	Description	Condition	Hardness	Strength	Optimal
P	1	Steel - Non-alloy, cast & free cutting (~ 0.15 %C)	Annealed	125MPa	440MPa	●
P	2	Steel - Non-alloy, cast & free cutting (~ 0.45 %C)	Annealed	190MPa	640MPa	●
P	3	Steel - Non-alloy, cast & free cutting (~ 0.45 %C)	Quenched & Tempered	250MPa	840MPa	●
P	4	Steel - Non-alloy, cast & free cutting (~ 0.75 %C)	Annealed	270MPa	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	180MPa	610MPa	●
P	7	Steel - Low alloy & cast < 5% of alloying elements	Quenched & Tempered	275MPa	930MPa	o
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		180MPa	610MPa	o
K	16	Cast Iron, Grey (GG) - Pearlitic		260HB	880MPa	
K	17	Cast Iron, Nodular (GGG) - Ferritic		160MPa	570MPa	o
K	18	Cast Iron, Nodular (GGG) - Pearlitic		250HB	840MPa	
K	19	Cast Iron, Malleable - Ferritic		130MPa	460MPa	o
K	20	Cast Iron, Malleable - Pearlitic		230HB	780MPa	
N	21	Aluminum & Magnesium, wrought alloy - Non Heat Treatable		60MPa	210MPa	o
N	22	Aluminum & Magnesium, wrought alloy - Heat Treatable	Age Hardened	100MPa	360MPa	o
N	23	Aluminum & Magnesium, cast alloy ?12% Si - Non Heat Treatable		75MPa	270MPa	o
N	24	Aluminum & Magnesium, cast alloy ?12% Si - Heat Treatable	Age Hardened	90MPa	320MPa	o
N	25	Aluminum & Magnesium, cast alloy >12% Si - Non Heat Treatabl		130HB	460MPa	
N	26	Copper & Copper alloys (Brass/Bronze) - Free cutting, Pb > 1%		110MPa	390MPa	o
N	27	Copper & Copper alloys (Brass/Bronze) - Brass (CuZn, CuSnZn)		90HB	320MPa	
N	28	Copper & Copper alloys (Brass/Bronze) - Bronze (CuSn)		100MPa	360MPa	o
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

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Applications:

ISO	VDI	Description	Condition	Hardness	Strength	Optimal
H	39.1	Hardened steel	Hardened & Tempered	58HRC		
H	39.2	Hardened steel	Hardened & Tempered	62HRC		
H	40	Cast Iron - Chilled	Cast	400HB	1350MPa	
H	41	Cast Iron	Hardened & Tempered	55HRC		

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