



E049

- M 机用丝锥 CoroTap™ P 螺尖
- M Tarauts machine CoroTap™ P Coupe gun
- M Maschinen-Gewindebohrer CoroTap™ P Geradegenutet mit Schälanschnitt
- M Macho Máquina CoroTap™ P Ponta Helicoidal
- M Machos de máquina CoroTap™ P Entrada corregida
- M Machine CoroTap™ P Spiral Point



CoroTap™ 200



| P | |
|-----------|-------|
| P 1 | 24-48 |
| P 2 | 9-36 |
| P 3 | 9-36 |
| P 4 | 24-38 |
| P 5 | 9-36 |
| Vc[m/min] | |

↓ 1.5xD

| M | TP | Vc [m/min] | | |
|-----|------|------------|---------|-------------|
| | | Vc | N [rpm] | Vf [mm/min] |
| M3 | 0.5 | 39 | 4153 | 2076.5 |
| M4 | 0.7 | 39 | 3115 | 2180.5 |
| M5 | 0.8 | 39 | 2492 | 1993.6 |
| M6 | 1 | 39 | 2076 | 2076.0 |
| M8 | 1.25 | 39 | 1557 | 1946.3 |
| M10 | 1.5 | 39 | 1246 | 1869.0 |
| M12 | 1.75 | 39 | 1038 | 1816.5 |
| M16 | 2 | 34 | 684 | 1368.0 |
| M20 | 2.5 | 31 | 495 | 1237.5 |

Din EN C45/ 1.0503/ AISI 1045/ SS1650
MC-code: P1.2.Z.AN 220 HB

↓ 2xD

| M | TP | Vc [m/min] | | |
|-----|------|------------|---------|-------------|
| | | Vc | N [rpm] | Vf [mm/min] |
| M3 | 0.5 | 32 | 3395 | 1697.5 |
| M4 | 0.7 | 32 | 2546 | 1782.2 |
| M5 | 0.8 | 32 | 2037 | 1629.6 |
| M6 | 1 | 32 | 1698 | 1698.0 |
| M8 | 1.25 | 32 | 1273 | 1591.3 |
| M10 | 1.5 | 32 | 1019 | 1528.5 |
| M12 | 1.75 | 32 | 849 | 1485.8 |
| M16 | 2 | 28 | 559 | 1118.0 |
| M20 | 2.5 | 25 | 405 | 1012.5 |

P1

↓ 2.5xD

| M | TP | Vc [m/min] | | |
|-----|------|------------|---------|-------------|
| | | Vc | N [rpm] | Vf [mm/min] |
| M3 | 0.5 | 27 | 2904 | 1452.0 |
| M4 | 0.7 | 27 | 2178 | 1524.6 |
| M5 | 0.8 | 27 | 1743 | 1394.4 |
| M6 | 1 | 27 | 1452 | 1452.0 |
| M8 | 1.25 | 27 | 1089 | 1361.3 |
| M10 | 1.5 | 27 | 871 | 1306.5 |
| M12 | 1.75 | 27 | 726 | 1270.5 |
| M16 | 2 | 24 | 478 | 956.0 |
| M20 | 2.5 | 22 | 346 | 865.0 |

P1

↓ 1.5xD

| M | TP | Vc [m/min] | | |
|-----|------|------------|---------|-------------|
| | | Vc | N [rpm] | Vf [mm/min] |
| M3 | 0.5 | 27 | 2855 | 1427.5 |
| M4 | 0.7 | 27 | 2141 | 1498.7 |
| M5 | 0.8 | 27 | 1713 | 1370.4 |
| M6 | 1 | 27 | 1428 | 1428.0 |
| M8 | 1.25 | 27 | 1071 | 1338.8 |
| M10 | 1.5 | 27 | 857 | 1285.5 |
| M12 | 1.75 | 27 | 714 | 1249.5 |
| M16 | 2 | 24 | 470 | 940.0 |
| M20 | 2.5 | 21 | 340 | 850.0 |

Din EN 42CrMo4/ 1.7225/ SS2244
MC-code: P2.2.Z.AN 241 HB

↓ 2xD

| M | TP | Vc [m/min] | | |
|-----|------|------------|---------|-------------|
| | | Vc | N [rpm] | Vf [mm/min] |
| M3 | 0.5 | 22 | 2334 | 1167.0 |
| M4 | 0.7 | 22 | 1751 | 1225.7 |
| M5 | 0.8 | 22 | 1401 | 1120.8 |
| M6 | 1 | 22 | 1167 | 1167.0 |
| M8 | 1.25 | 22 | 875 | 1093.8 |
| M10 | 1.5 | 22 | 700 | 1050.0 |
| M12 | 1.75 | 22 | 584 | 1022.0 |
| M16 | 2 | 19 | 385 | 770.0 |
| M20 | 2.5 | 17 | 278 | 695.0 |

P2

↓ 2.5xD

| M | TP | Vc [m/min] | | |
|-----|------|------------|---------|-------------|
| | | Vc | N [rpm] | Vf [mm/min] |
| M3 | 0.5 | 19 | 1997 | 998.5 |
| M4 | 0.7 | 19 | 1498 | 1048.6 |
| M5 | 0.8 | 19 | 1198 | 958.4 |
| M6 | 1 | 19 | 998 | 998.0 |
| M8 | 1.25 | 19 | 749 | 936.3 |
| M10 | 1.5 | 19 | 599 | 898.5 |
| M12 | 1.75 | 19 | 499 | 873.3 |
| M16 | 2 | 17 | 329 | 658.0 |
| M20 | 2.5 | 15 | 238 | 595.0 |

P2

↓ 1.5xD

| M | TP | Vc [m/min] | | |
|-----|------|------------|---------|-------------|
| | | Vc | N [rpm] | Vf [mm/min] |
| M3 | 0.5 | 27 | 2855 | 1427.5 |
| M4 | 0.7 | 27 | 2141 | 1498.7 |
| M5 | 0.8 | 27 | 1713 | 1370.4 |
| M6 | 1 | 27 | 1428 | 1428.0 |
| M8 | 1.25 | 27 | 1071 | 1338.8 |
| M10 | 1.5 | 27 | 857 | 1285.5 |
| M12 | 1.75 | 27 | 714 | 1249.5 |
| M16 | 2 | 24 | 470 | 940.0 |
| M20 | 2.5 | 21 | 340 | 850.0 |

1.2344/ AISI H13/ SS2242
MC-code: P3.0.Z.AN 235 HB

↓ 2xD

| M | TP | Vc [m/min] | | |
|-----|------|------------|---------|-------------|
| | | Vc | N [rpm] | Vf [mm/min] |
| M3 | 0.5 | 22 | 2334 | 1167.0 |
| M4 | 0.7 | 22 | 1751 | 1225.7 |
| M5 | 0.8 | 22 | 1401 | 1120.8 |
| M6 | 1 | 22 | 1167 | 1167.0 |
| M8 | 1.25 | 22 | 875 | 1093.8 |
| M10 | 1.5 | 22 | 700 | 1050.0 |
| M12 | 1.75 | 22 | 584 | 1022.0 |
| M16 | 2 | 19 | 385 | 770.0 |
| M20 | 2.5 | 17 | 278 | 695.0 |

P3

↓ 2.5xD

| M | TP | Vc [m/min] | | |
|-----|------|------------|---------|-------------|
| | | Vc | N [rpm] | Vf [mm/min] |
| M3 | 0.5 | 19 | 1997 | 998.5 |
| M4 | 0.7 | 19 | 1498 | 1048.6 |
| M5 | 0.8 | 19 | 1198 | 958.4 |
| M6 | 1 | 19 | 998 | 998.0 |
| M8 | 1.25 | 19 | 749 | 936.3 |
| M10 | 1.5 | 19 | 599 | 898.5 |
| M12 | 1.75 | 19 | 499 | 873.3 |
| M16 | 2 | 17 | 329 | 658.0 |
| M20 | 2.5 | 15 | 238 | 595.0 |

P3

材料对照表/Tableaux de correspondance matériau/ Quererverweistabellen (Material)/Tabelas de Referência Cruzada de Materiais/Tablas de referencias cruzadas de materiales/Material Cross Reference Tables

| //Norme et Pays/région//Standard & Land/Region//Padrão & País/Região//Estándar y país/región//Standard & Country/Region | | | | | | | | | | | | |
|---|--|---------------|------------------|------------------|------------------|-------|--------------|----------------------|-----------------|---------------------|--------------|----------------------|
| ISO | MC-code | Dormer AMG | Europe DIN EN | Germany W.-nr | UK BS | EN | Sweden SS | USA AISI/SAE/ASTM | France AFNOR | Italy UNI | Spain UNE | Japan JIS |
| P | 非合金钢/Aciers non alliés/Unlegierter Stahl/Aços sem liga/Acero no aleado/ Unalloyed steels | | | | | | | | | | | |
| | P1.1.Z.AN | 1.2 | S235JR G2 | 1.0038 | 4360 40 C | | 1311 | A570.36 | E 24-2 Ne | | | STKM 12A;C |
| | P1.1.Z.AN | 1.2 | S235J2 G3 | 1.0116 | 4360 40 B | | 1312 | A573-81 65 | E 24-U | Fe37-3 | | |
| | P1.1.Z.AN | 1.2 | C15 | 1.0401 | 080M15 | - | 1350 | 1015 | CC12 | C15C16 | F.111 | - |
| | P1.1.Z.AN | 1.2 | C22 | 1.0402 | 050A20 | 2C/2D | 1450 | 1020 | CC20 | C20C21 | F.112 | - |
| | P1.1.Z.AN | 1.2 | C15E | 1.1141 | 080M15 | 32C | 1370 | 1015 | XC12 | C16 | C15K | S15C |
| | P1.1.Z.AN | 1.2 | C25E | 1.1158 | - | - | - | 1025 | - | - | - | S25C |
| | P1.1.Z.AN | 1.2 | S380N | 1.8900 | 4360 55 E | | 2145 | A572-60 | - | FeE390KG | | |
| | P1.1.Z.AN | 1.3 | 17MnV7 | 1.0870 | 4360 55 E | | 2142 | A572-60 | NFA 35-501 E 36 | - | - | |
| | P1.1.Z.AN | 1.3 | 55Si7 | 1.0904 | 250A53 | 45 | 2085 | 9255 | 55S7 | 55Si8 | 56Si7 | - |
| | P1.1.Z.HT | 1.3 | - | - | - | - | 2090 | 9255 | 55S7 | - | - | - |
| | P1.2.Z.AN | 1.2 | S275J2G3 | 1.0144 | 4360 43C | | 1412 | A573-81 | E 28-3 | - | - | SM 400A;B;C |
| | P1.2.Z.AN | 1.2 | S355J2G3+C2 | 1.0570 | 4360 50B | | 2132 | - | E36-3 | Fe52BFN/ Fe52CFN | - | SM490A;B;C; YA;YB |
| | P1.2.Z.AN | 1.2 | S355J2G3 | 1.0841 | 150 M 19 | | 2172 | 5120 | 20 MC 5 | Fe52 | F-431 | - |
| | P1.2.Z.AN | 1.3 | C35 | 1.0501 | 060A35 | - | 1550 | 1035 | CC35 | C35 | F.113 | - |
| | P1.2.Z.AN | 1.3 | C45 | 1.0503 | 080M46 | - | 1650 | 1045 | CC45 | C45 | F.114 | - |
| | P1.2.Z.AN | 1.3 | 40Mn4 | 1.1157 | 150M36 | 15 | - | 1039 | 35M5 | - | - | - |
| | P1.2.Z.AN | 1.3 | 36Mn5 | 1.1167 | - | - | 2120 | 1335 | 40M5 | - | 36Mn5 | SMn438(H) |
| | P1.2.Z.AN | 1.3 | 28Mn6 | 1.1170 | 150M28 | 14A | - | 1330 | 20M5 | C28Mn | - | SCMn1 |
| | P1.2.Z.AN | 1.3 | C35G | 1.1183 | 060A35 | - | 1572 | 1035 | XC38TS | C36 | - | S35C |
| | P1.2.Z.AN | 1.3 | C45E | 1.1191 | 080M46 | - | 1672 | 1045 | XC42 | C45 | C45K | S45C |
| | P1.2.Z.AN | 1.3 | C53G | 1.1213 | 060A52 | - | 1674 | 1050 | XC48TS | C53 | - | S50C |
| | P1.2.Z.AN | 1.3 | C55 | 1.0535 | 070M55 | - | 1655 | 1055 | - | C55 | - | - |
| | P1.2.Z.AN | 1.3 | C55E | 1.1203 | 070M55 | - | - | 1055 | XC55 | C50 | C55K | S55C |
| | P1.3.Z.AN | 1.3 | C60E | 1.0601 | 080A62 | 43D | - | 1060 | CC55 | C60 | - | - |
| | P1.3.Z.AN | 1.3 | C60E | 1.1221 | 080A62 | 43D | 1678 | 1060 | XC60 | C60 | - | S58C |
| | P1.3.Z.AN | 1.3 | C101E | 1.1274 | 060 A 96 | | 1870 | 1095 | XC 100 | - | F-5117 | - |
| | P1.3.Z.AN | 1.3 | S340 MGC | 1.0961 | - | - | - | 9262 | 60SC7 | 60SiCr8 | 60SiCr8 | - |
| | P1.3.Z.AN | 1.4 | C101u | 1.1545 | BW 1A | | 1880 | W 1 | Y105 | C36KU | F-5118 | SK 3 |
| | P1.3.Z.AN | 1.4 | C105W1 | - | BW2 | - | 2900 | W210 | Y120 | C120KU | F.515 | SUP4 |
| | P1.4.Z.AN | 1.2 | 11SMn30 | 1.0715 | 230M07 | - | 1912 | 1213 | S250 | CF9SMn28 | 11SMn28 | SUM22 |
| | P1.4.Z.AN | 1.2 | 11SMnPb30 | 1.0718 | - | - | 1914 | 12L13 | S250Pb | CF9SMnPb28 | 11SMnPb28 | SUM22L |
| | P1.4.Z.AN | 1.2 | 10SPb20 | 1.0722 | - | - | - | - | 10PbF2 | CF10SPb20 | 10SPb20 | - |
| | P1.4.Z.AN | 1.2 | 11SMn37 | 1.0736 | 240M07 | 1B | - | 1215 | S 300 | CF9SMn36 | 12SMn35 | - |
| | P1.4.Z.AN | 1.2 | 11SMnPb37 | 1.0737 | - | - | 1926 | 12L14 | S300Pb | CF9SMnPb36 | 12SMnP35 | - |
| P1.4.Z.AN | 1.2 | 35S20 | 1.0726 | 212M36 | 8M | 1957 | 1140 | 35MF4 | - | F210G | - | |
| P1.5.C.UT | 1.2 | GC16E | 1.1142 | 030A04W | 1A | 1325 | 1115 | - | - | - | - | |
| 钢/Acier/Stahl/Aços/Acero/Steel | 低合金钢/Aciers faiblement alliés/Niedriglegierter Stahl/Aços baixa-liga/ Acero de aleación baja/Low-alloyed steels | | | | | | | | | | | |
| | P2.1.Z.AN | 1.3 | 16MnCr5 | 1.7139 | - | - | 2127 | - | - | - | - | - |
| | P2.1.Z.AN | 1.4-1.6 | 16Mo3 | 1.5415 | 1501-240 | - | 2912 | A204Gr.A | 15D3 | 16Mo3KW | 16Mo3 | - |
| | P2.1.Z.AN | 1.4-1.6 | 14Ni6 | 1.5622 | - | - | - | A350LF5 | 16N6 | 14Ni6 | 15Ni6 | - |
| | P2.1.Z.AN | 1.4-1.6 | 21NiCrMo2 | 1.6523 | 805M20 | 362 | 2506 | 8620 | 20NCD2 | 20NiCrMo2 | 20NiCrMo2 | SNCM220(H) |
| | P2.1.Z.AN | 1.4-1.6 | 17CrNiMo6 | 1.6587 | 820A16 | - | - | - | 18NCD6 | - | 14NiCrMo13 | - |
| | P2.1.Z.AN | 1.4-1.6 | 15Cr3 | 1.7015 | 523M15 | - | - | 5015 | 12C3 | - | - | SCr415(H) |
| | P2.1.Z.AN | 1.4-1.6 | 55Cr3 | 1.7176 | 527A60 | 48 | - | 5155 | 55C3 | - | - | SUP9(A) |
| | P2.1.Z.AN | 1.4-1.6 | 15CrMo5 | 1.7262 | 2127 | - | 2216 | - | 12CD4 | - | 12CrMo4 | SCM415(H) |
| | P2.1.Z.AN | 1.4-1.6 | 13CrMo4-5 | 1.7335 | 1501-620Gr27 | - | - | A182 F11;F12 | 15CD3.5 | 14CrMo45 | 14CrMo45 | - |
| | P2.1.Z.AN | 1.4-1.6 | 10CrMo9 10 | 1.7380 | 1501-622Gr.31;45 | - | 2218 | A182 F.22 | 12CD9, 10 | 12CrMo9, 10 | TU.H | - |
| | P2.1.Z.AN | 1.4-1.6 | 14MoV6 3 | 1.7715 | 1503-660-440 | - | - | - | - | - | 13MoCrV6 | - |
| | P2.1.Z.AN | 1.4-1.6 | 50CoMo4 | 1.7228 | 823M30 | 33 | 2512 | - | - | 653M31 | - | - |
| | P2.1.Z.AN | 1.4-1.6 | 14NiCrMo134 | 1.6657 | 832M13 | 36C | - | - | - | 15NiCrMo13 | 14NiCrMo131 | - |
| | P2.1.Z.AN | 1.4-1.6 | 16Mo5 | 1.5423 | 1503-245-420 | - | - | 4520 | - | 16Mo5 | 16Mo5 | - |
| | P2.1.Z.AN | 1.4-1.6 | 22Mo4 | 1.5419 | 605A32 | - | 2108 | 8620 | 25CD4 | - | F520.S | - |
| | P2.1.Z.AN/P2.5.Z.HT | 1.4-1.6 | 25CrMo4 | 1.7218 | 1717CDS110 | - | 2225 | 4130 | 16MC5 | 25CrMo4(KB) | AM26CrMo4 | SCM420; SCM430 |
| | P2.1.Z.AN/P2.5.Z.HT | 1.4-1.6 | 16MnCr5 | 1.7131 | (527M20) | - | 2511 | 5115 | 35CD4 | 16MnCr5 | 16MnCr5 | - |
| | P2.1.Z.AN/P2.5.Z.HT | 1.4-1.6 | 34CrMo4 | 1.7220 | 708A37 | 19B | 2234 | 4137;4135 | 42CD4TS | 35CrMo4 | 34CrMo4 | SCM432; SCCRM3 |
| | P2.1.Z.AN/P2.5.Z.HT | 1.4-1.6 | 41CrMo4 | 1.7223 | 708M40 | 19A | 2244 | 4140;4142 | 42CD4 | 41CrMo4 | 42CrMo4 | SCM 440 |
| | P2.1.Z.AN/P2.5.Z.HT | 1.4-1.6 | 42CrMo4 | 1.7225 | 708M40 | 19A | 2244 | 4140 | 30 CD 12 | 42CrMo4 | 42CrMo4 | SCM440(H) |
| | P2.2.Z.AN | 1.4-1.6 | 31CrMo12 | 1.8515 | 722 M 24 | | 2240 | - | - | 30CrMo12 | F-1712 | - |
| | P2.2.Z.AN | 1.4-1.6 | 39CrMoV13 9 | 1.8523 | 897M39 | 40C | - | - | - | 36CrMoV12 | - | - |
| | P2.2.Z.AN | 1.4-1.6 | 41CrS4 | 1.7039 | 524A14 | - | 2092 | L1 | - | 105WCR 5 | - | - |
| | P2.2.Z.AN | 1.4-1.6 | 45WCrV7 | 1.2542 | BS1 | - | 2710 | S1 | - | 45WCrV8KU | 45WCrSi8 | - |
| | P2.2.Z.AN | 1.4-1.6 | 40NiCrMo8-4 | 1.6562 | 311-Type 7 | - | - | 8740 | - | 40NiCrMo2(KB) | 40NiCrMo2 | SNCM240 |
| | P2.2.Z.AN | 1.4-1.6 | 42Cr4 | 1.7045 | - | - | 2245 | 5140 | - | - | 42Cr4 | SCR440 |
| | P2.2.Z.AN | 1.4-1.6 | 31NiCrMo14 | 1.5755 | 830 M 31 | | 2534 | - | 55NCV6 | - | F-1270 | - |
| | P2.2.Z.AN | 1.6 | 50NiCr13 | 1.2721 | - | | 2550 | L6 | 40NCD3 | - | F-528 | - |

