



suttontools

T679 -Spiral Flute Taps - R50 VAPM -Sutton Tools

Universal high performance tapping PM-HSSE V3 offers superior tool life Use in stainless steels and high strength steels up to 850N/mm² Deep blind holes Depths up to 3 x d1

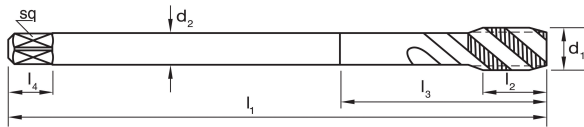
Features:

- Universal high performance tapping
- PM-HSSE V3 offers superior tool life
- Use in stainless steels and high strength steels up to 850N/mm²
- Deep blind holes
- Depths up to 3 x d1

Specifications:

Designation:	VA
Material:	HSS-PM
Finish:	TiCN
Max Cut Depth:	3xD
Shank Form:	A
Helix Angle:	R50
Standard:	DIN376
Thread Form:	Metric
Thread Tolerance Class:	6GX
Lead:	Form C

Range:



Item #	Length l1 (mm)	Length l2 (mm)	Diameter d2 (mm)	sq	Length l4 (mm)	z	Pitch	Drill ϕ	d1
T6791200	110	17.5	9	7	10	3	1.75	10.2	M12
T6791400	110	20	11	9	12	3	2.00	12	M14
T6791600	110	20	12	9	12	4	2.00	14	M16
T6791800	125	25	14	11	14	4	2.50	15.5	M18
T6792000	140	25	16	12	15	4	2.50	17.5	M20
T6792200	140	25	18	14.5	17	4	2.50	19.5	M22
T6792400	160	30	18	14.5	17	4	3.00	21	M24

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	○
P	8	Steel - Low alloy & cast < 5% of alloying elements	Quenched & Tempered	300MPa	1010MPa	○
P	9	Steel - Low alloy & cast < 5% of alloying elements	Quenched & Tempered	350HB	1180MPa	
P	10	Steel - High alloy, cast & tool	Annealed	200MPa	680MPa	○
P	11	Steel - High alloy, cast & tool	Hardened & Tempered	325HB	1100MPa	
P	12	Steel - Corrosion resistant & cast - Ferritic / Martensitic	Annealed	200MPa	680MPa	●
P	13	Steel - Corrosion resistant & cast - Martensitic	Quenched & Tempered	240HB	810MPa	
M	14.1	Stainless Steel - Austenitic	Age Hardened	180MPa	610MPa	●
M	14.2	Stainless Steel - Duplex		250MPa	840MPa	●
M	14.3	Stainless Steel - Precipitation Hardening		250MPa	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		60MPa	210MPa	○
N	22	Aluminum & Magnesium, wrought alloy - Heat Treatable	Age Hardened	100MPa	360MPa	○
N	23	Aluminum & Magnesium, cast alloy ?12% Si - Non Heat Treatable		75MPa	270MPa	○
N	24	Aluminum & Magnesium, cast alloy ?12% Si - Heat Treatable	Age Hardened	90MPa	320MPa	○
N	25	Aluminum & Magnesium, cast alloy >12% Si - Non Heat Treatable		130MPa	460MPa	○
N	26	Copper & Copper alloys (Brass/Bronze) - Free cutting, Pb > 1%		110MPa	390MPa	○
N	27	Copper & Copper alloys (Brass/Bronze) - Brass (CuZn, CuSnZn)		90HB	320MPa	
N	28	Copper & Copper alloys (Brass/Bronze) - Bronze (CuSn)		100MPa	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	200MPa	680MPa	●
S	32	High temperature alloys - Fe based	Age Hardened	280HB	950MPa	
S	33	High temperature alloys - Ni / Co based	Annealed	250MPa	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

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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