



suttontools

T394 -Spiral Point (Gun) Taps - M -Sutton Tools

Features:

- General purpose use
- Suitable for materials up to 1000N/mm²
- Through holes
- Depths up to approx. 3 x d1

Specifications:

Designation:	N
Material:	HSSE V3
Finish:	Blu
Max Cut Depth:	3xD
Shank Form:	A
Standard:	ISO529
Thread Form:	M
Nut Tolerance:	ISO 2 / 6H
Lead:	Form B / 4,5 x P

Range:

Item #	d1	Limit	Length l1 (mm)	Length l2 (mm)	Diameter d2 (mm)	sq	Length l4 (mm)	z	Pitch
T3940250	M2.5	ISO 2 / 6H	45	10	2.8	2.24	5	3	0.45
T3940300	M3	ISO 2 / 6H	48	11	3.15	2.5	5	3	0.50
T3940350	M3.5	ISO 2 / 6H	50	13	3.55	2.8	5	3	0.60
T3940400	M4	ISO 2 / 6H	53	13	4	3.15	6	3	0.70
T3940500	M5	ISO 2 / 6H	58	16	5	4	7	3	0.80
T3940600	M6	ISO 2 / 6H	66	19	6.3	5	8	3	1.00
T3940800	M8	ISO 2 / 6H	72	22	8	6.3	9	3	1.25
T3941000	M10	ISO 2 / 6H	80	24	10	8	11	3	1.50
T3941200	M12	ISO 2 / 6H	89	29	9	7.1	10	3	1.75
T3941400	M14	ISO 2 / 6H	95	30	11.2	9	12	3	2.00
T3941600	M16	ISO 2 / 6H	102	32	12.5	10	13	3	2.00
T3941800	M18	ISO 2 / 6H	112	37	14	11.2	14	4	2.50
T3942000	M20	ISO 2 / 6H	112	37	14	11.2	14	4	2.50
T3942200	M22	ISO 2 / 6H	118	38	16	12.5	16	4	2.50
T3942400	M24	ISO 2 / 6H	130	45	18	14	18	4	3.00
T3943000	M30	ISO 2 / 6H	138	48	20	16	20	4	3.50

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	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	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		250HB	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		160MPa	570MPa	○
K	18	Cast Iron, Nodular (GGG) - Pearlitic		250MPa	840MPa	○
K	19	Cast Iron, Malleable - Ferritic		130MPa	460MPa	○
K	20	Cast Iron, Malleable - Pearlitic		230HB	780MPa	
N	21	Aluminum & Magnesium, wrought alloy - Non Heat Treatable		60HB	210MPa	
N	22	Aluminum & Magnesium, wrought alloy - Heat Treatable	Age Hardened	100HB	360MPa	
N	23	Aluminum & Magnesium, cast alloy ≤12% Si - Non Heat Treatable		75HB	270MPa	
N	24	Aluminum & Magnesium, cast alloy ≤12% Si - Heat Treatable	Age Hardened	90HB	320MPa	
N	25	Aluminum & Magnesium, cast alloy >12% Si - Non Heat Treatable		130HB	460MPa	
N	26	Copper & Copper alloys (Brass/Bronze) - Free cutting, Pb > 1		110HB	390MPa	
N	27	Copper & Copper alloys (Brass/Bronze) - Brass (CuZn, CuSnZn)		90HB	320MPa	
N	28	Copper & Copper alloys (Brass/Bronze) - Bronze (CuSn)		100HB	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	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

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	400MPa	1350MPa	o
H	41	Cast Iron	Hardened & Tempered	55HRC		

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