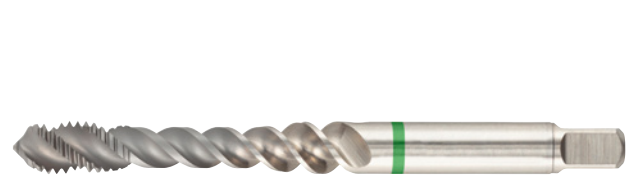


Machine tap HSCo VaryTap green blind hole DIN 371/376

The innovative specialist drill bit for processing alloyed and high-alloyed steels (stainless steels), as well as rust-resistant and acid-resistant steels. Also suitable for processing conventional steel materials up to a strength of 1,200 N/mm².



Newly developed Vario geometry

Optimised chip removal, prevents chip accumulation

Optimised cutting edge preparation thanks to multi-stage finishing process

Excellent chip removal and perfectly true to the gauge

Extra-long groove

Optimised coolant supply and chip removal for deep threads

Angled threaded part

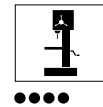
Reduced risk of chipping on the tool during return

Rake precisely tailored to stainless steel

Up to 50 % longer service life than conventional plain machine taps

Available exclusively from Würth

Sustainable product packaging made of 100 % PCR (plastic recycled from household waste), 100 % recyclable and Cradle to Cradle Certified® Bronze



Thread type	Metric thread
Material to be processed	Stainless steel, Steel
Hole type	Blind hole ≤ 2.5xD
Suitable for machine type	Milling/drill center, Pedestal drilling machine
Quality	ZEBRA-Premium
Cutting material	HSCo
Surface	Plain
Form	C
Twist angle	45° Vario
Shank style	Cylindrical with square drive
Tolerance of screw taps	ISO 2X (6HX)
Suitable for tensile strength up to	1200 N/mm ²
Service life	●●●○
Trueness to gauge	●●●●
Versatility	●●●○
Cutting behaviour	●●●○
Chip formation	●●●○

Material of sub-group	Stainless steels, sulphurated, Stainless steels, austenitic, Stainless steels, martensitic, General structural steels, Non-alloyed tempering steels, Alloyed tempering steels, Nitriding steels, Tool steels, High-speed steels
Color Coding System	■ Stainless steel ■ Steel

Art. no.	0655 800 300	0655 800 400	0655 800 500	0655 800 600	0655 800 800	0655 801 000
P. Qty.	1	1	1	1	1	1
Thread type x nominal diameter	M3	M4	M5	M6	M8	M10
Pitch	0.5 mm	0.7 mm	0.8 mm	1 mm	1.25 mm	1.5 mm
Length	56 mm	63 mm	70 mm	80 mm	90 mm	100 mm
Shaft diameter	3.5 mm	4.5 mm	6 mm	6 mm	8 mm	10 mm
Size of square	2.7 mm	3.4 mm	4.9 mm	4.9 mm	6.2 mm	8 mm
DIN	371	371	371	371	371	371
Core hole diameter	2.5 mm	3.3 mm	4.2 mm	5 mm	6.8 mm	8.5 mm

Art. no.	0655 801 200
P. Qty.	1
Thread type x nominal diameter	M12
Pitch	1.75 mm
Length	110 mm
Shaft diameter	9 mm
Size of square	7 mm
DIN	376
Core hole diameter	10.2 mm

Cutting values

For M3-M5												
Material designation	Tensile strength	v _c		M3			M4			M5		
				n		f	n		f	n		f
		from	to	from	to		from	to		from	to	
Steels												
Steels	< 850 N/mm ²	8	10	849	1061	0.5	637	796	0.7	509	637	0.8
Steels	< 1,000 N/mm ²	6	8	637	849	0.5	477	637	0.7	382	509	0.8
Steels	< 1,200 N/mm ²	4	6	424	637	0.5	318	477	0.7	255	382	0.8
Stainless steels												
Stainless steels	< 850 N/mm ²	6	8	637	849	0.5	477	637	0.7	382	509	0.8
Stainless steels	> 850 N/mm ²	4	6	424	637	0.5	318	477	0.7	255	382	0.8

Cutting values

For M6-M10												
Material designation	Tensile strength	v _c		M6			M8			M10		
				n		f	n		f	n		f
		from	to	from	to		from	to		from	to	
Steels												
Steels	< 850 N/mm ²	8	10	424	531	1	318	398	1.25	255	318	1.5
Steels	< 1,000 N/mm ²	6	8	318	424	1	239	318	1.25	191	255	1.5

Cutting values

For M6-M10												
Material designation	Tensile strength	v_c		M6			M8			M10		
				n		f	n		f	n		f
		from	to	from	to		from	to		from	to	
Steels	< 1,200 N/mm ²	4	6	212	318	1	159	239	1.25	127	191	1.5
Stainless steels												
Stainless steels	< 850 N/mm ²	6	8	382	424	1	239	318	1.25	191	255	1.5
Stainless steels	> 850 N/mm ²	4	6	212	382	1	159	239	1.25	127	191	1.5

Cutting values

For M12-M16												
Material designation	Tensile strength	v_c		M12			M14			M16		
				n		f	n		f	n		f
		from	to	from	to		from	to		from	to	
Steels												
Steels	< 850 N/mm ²	8	10	212	265	1.75	182	227	2	159	199	2
Steels	< 1,000 N/mm ²	6	8	159	212	1.75	136	182	2	119	159	2
Steels	< 1,200 N/mm ²	4	6	106	159	1.75	91	136	2	80	119	2
Stainless steels												
Stainless steels	< 850 N/mm ²	6	8	159	212	1.75	136	182	2	119	159	2
Stainless steels	> 850 N/mm ²	4	6	106	159	1.75	91	136	2	80	119	2

Cutting values

For M20						
Material designation	Tensile strength	v_c		M20		
				n		f
		from	to	from	to	
Steels						
Steels	< 850 N/mm ²	8	10	127	159	2.5
Steels	< 1,000 N/mm ²	6	8	95	127	2.5
Steels	< 1,200 N/mm ²	4	6	64	95	2.5
Stainless steels						
Stainless steels	< 850 N/mm ²	6	8	95	127	2.5
Stainless steels	> 850 N/mm ²	4	6	64	95	2.5

Legend

v_c = cutting speed [m/min]

f = feed [mm/r]

n = rotation speed [rpm]

The suggested cutting values are reference values only and must be adapted to the respective conditions.

Details/Application



Notice

Sufficient coolant and lubricant must be added when cutting threads.

Related products	Art. no.
CUT+COOL drilling and cutting oil	0893 050 004
Drilling and cutting foam CUT+COOL	0893 050 007
CUT+COOL Perfect drilling and cutting oil	0893 050 008
Cut and Cool Perfect drilling/cutting paste	0893 050 010
Cordless drill driver ABS 18 POWER M-CUBE	5701 404 005
Cordless drill driver ABS 18 COMPACT M-CUBE	5701 800 3