



suttontools

T313 -Thread Forming Taps - N -Sutton Tools

Suitable for materials with >10% elongation Through or blind holes Depths up to 3 x d1

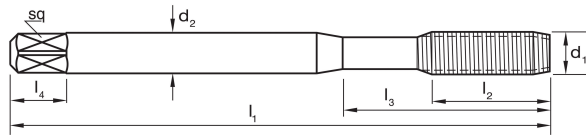
Features:

- Suitable for materials with >10% elongation
- Through or blind holes
- Depths up to 3 x d1

Specifications:

Designation:	N
Material:	HSSE V3
Finish:	TiN
Max Cut Depth:	3xD
Shank Form:	A
Type:	Fluteless - No Groove
Standard:	DIN2174
Nut Tolerance:	6HX
Lead:	Form C / 3 x P

Range:



Item #	d1	Limit	Length l1 (mm)	Length l2 (mm)	Length l3 (mm)	Diameter d2 (mm)	sq	Length l4 (mm)	z
T3130100	M1	6HX	40	6	-	2.5	2.1	3	-
T3130120	M1.2	6HX	40	6	-	2.5	2.1	3	-
T3130140	M1.4	6HX	40	6	-	2.5	2.1	3	-
T3130160	M1.6	6HX	40	7	-	2.5	2.1	3	-
T3130170	M1.7	6HX	40	8	-	2.5	2.1	3	-
T3130180	M1.8	6HX	40	8	-	2.5	2.1	3	-
T3130200	M2	6HX	45	8	-	2.8	2.1	5	-
T3130220	M2.2	6HX	45	8	-	2.8	2.1	5	-
T3130230	M2.3	6HX	45	9	-	2.8	2.1	5	-
T3130250	M2.5	6HX	50	9	-	2.8	2.1	5	-
T3130260	M2.6	6HX	50	9	-	2.8	2.1	5	-
T3130300	M3	6HX	56	11	18	3.5	2.7	6	-
T3130350	M3.5	6HX	56	13	20	4	3	6	-
T3130400	M4	6HX	63	13	21	4.5	3.4	6	-
T3130500	M5	6HX	70	16	25	6	4.9	8	-
T3130600	M6	6HX	80	19	30	6	4.9	8	-
T3130800	M8	6HX	90	22	35	8	6.2	9	-
T3131000	M10	6HX	100	24	39	10	8	11	-

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	275HB	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	200HB	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		250HB	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		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 Treatabl		130HB	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	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	400HB	1350MPa	
H	41	Cast Iron	Hardened & Tempered	55HRC		

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