



suttontools

T791 -Spiral Flute Taps - R15 Ti -Sutton Tools

For Titanium based alloys For duplex and super duplex stainless steels For Nickel based alloys >850N/mm² <1150N/mm² Tight tolerances and optimised micro finish for optimal process reliability and excellent thread quality Blind holes up to approximately 1.5 x d1

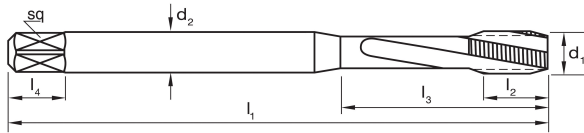
Features:

- For Titanium based alloys Unique cutting geometry for highly efficient swarf ejection
- Optimised microfinish for optimal process reliability and
- excellent thread quality
- Blind holes up to approx. 1.5 x d1

Specifications:

Designation:	Ti
Material:	PM-HSS Co
Finish:	TiCN
Max Cut Depth:	1.5xD
Shank Form:	A
Helix Angle:	R15
Standard:	DIN2184-1
Thread Form:	UNJF
Nut Tolerance:	3BX
Lead:	Form C / 3 x P

Range:



Item #	d1	TPI	Length l1 (mm)	Length l2 (mm)	Length l3 (mm)	Diameter d2 (mm)	sq	Length l4 (mm)	z
T7910635	1/4	28	80	10	30	7	5.5	8	3
T7910794	5/16	24	90	13	34	8	6.2	9	3
T7910953	3/8	24	100	15	35	10	7	10	3

Applications:

ISO	VDI	Description	Condition	Hardness	Strength	Optimal
P	1	Steel - Non-alloy, cast & free cutting (~ 0.15 %C)	Annealed	125HB	440MPa	
P	2	Steel - Non-alloy, cast & free cutting (~ 0.45 %C)	Annealed	190HB	640MPa	
P	3	Steel - Non-alloy, cast & free cutting (~ 0.45 %C)	Quenched & Tempered	250HB	840MPa	
P	4	Steel - Non-alloy, cast & free cutting (~ 0.75 %C)	Annealed	270HB	910MPa	
P	5	Steel - Non-alloy, cast & free cutting (~ 0.75 %C)	Quenched & Tempered	300MPa	1010MPa	o
P	6	Steel - Low alloy & cast < 5% of alloying elements	Annealed	180HB	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	300MPa	1010MPa	o
P	9	Steel - Low alloy & cast < 5% of alloying elements	Quenched & Tempered	350MPa	1180MPa	o
P	10	Steel - High alloy, cast & tool	Annealed	200MPa	680MPa	o
P	11	Steel - High alloy, cast & tool	Hardened & Tempered	325MPa	1100MPa	o
P	12	Steel - Corrosion resistant & cast - Ferritic / Martensitic	Annealed	200HB	680MPa	
P	13	Steel - Corrosion resistant & cast - Martensitic	Quenched & Tempered	240MPa	810MPa	o
M	14.1	Stainless Steel - Austenitic	Age Hardened	180HB	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		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	280MPa	950MPa	o
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	320MPa	1080MPa	o
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	o
S	37.4	Titanium & Titanium alloys - Beta alloys	Annealed		830MPa	●
S	37.5	Titanium & Titanium alloys - Beta alloys	Age Hardened		1400MPa	o
H	38.1	Hardened steel	Hardened & Tempered	45HRC		
H	38.2	Hardened steel	Hardened & Tempered	55HRC		

KEY

● Optimal o 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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