

HSS



Being the best through innovation



SPIRAL FLUTE TAPS

GEWINDEBOHRER MIT DRALL

- Tapping Blind Holes, HSS-E & HSS-PM
- Für Sacklöcher. HSS-E und HSS-PM

SELECTION GUIDE

SPIRAL FLUTE TAPS

Tapping Blind Holes, HSS-E & HSS-PM

SPIRAL FLUTE TAPS

◆ SYNCHRO TYPE

EDP No.	MODEL	Tool Material	Standard	Work Material	Dimensions	Tolerance	Chamfer	Surface Treatment	PAGE
◆ TTS31		HSS-PM	M	GS	DIN 371/376	ISO 2/6H	C	TiN	400
TC612		HSS-E	M	GS	DIN 352	ISO 2/6H	C	Bright	401
TC211		HSS-E	M	GS	DIN 371/376	ISO 2/6H	C	Bright	402
TC517		HSS-E	M	GS	DIN 371/376	ISO 2/6H	C	Bright	403
TC711		HSS-E	M	GS	DIN 371/376	ISO 2/6H	C	Bright	404
TD711		HSS-E	M	GS	DIN 371/376	ISO 2/6H	C	TiN	405
TQ823		HSS-PM	M	VG	DIN 371/376	ISO 2/6H	C	Vap	406
TR823		HSS-PM	M	VG	DIN 371/376	ISO 2/6H	C	Bright	407
TB312		HSS-E	M	VG	DIN 371/376	ISO 2/6H	C	Vap	408
TB913		HSS-E	M	VG	DIN 371/376	ISO 2/6H	C	Vap	409
TC312		HSS-E	M	VG	DIN 371/376	ISO 2/6H	C	Bright	410
TD312		HSS-E	M	VG	DIN 371/376	ISO 2/6H	C	TiN	411
TY312		HSS-E	M	VG	DIN 371/376	ISO 2/6H	C	TiAlN	412
TQ813		HSS-PM	M	VA	DIN 371/376	ISO 2/6H	C	Vap	413
TR813		HSS-PM	M	VA	DIN 371/376	ISO 2/6H	C	Bright	414
TB313		HSS-E	M	HR	DIN 371/376	ISO 2/6H	C	Vap	415
TC313		HSS-E	M	HR	DIN 371/376	ISO 2/6H	C	Bright	416
TY313		HSS-E	M	HR	DIN 371/376	ISO 2/6H	C	TiAlN	417
TB914		HSS-E	M	VA NW	DIN 371/376	ISO 2/6H	C	Vap	418
TCH14		HSS-E	M	VA NW	DIN 371/376	ISO 2/6H	C	Hardslick	419
TB711		HSS-E	M	NW	DIN 371/376	ISO 2/6H	C	Vap	420
TM903		HSS-PM	M	Ti	DIN 371/376	ISO 2/6H	C	Bright	421
TZ903		HSS-PM	M	Ti	DIN 371/376	ISO 2/6H	C	TiAlN	422

SPIRAL FLUTE TAPS

EDP No.	MODEL	Tool Material	Standard	Work Material	Dimensions	Tolerance	Chamfer	Surface Treatment	PAGE
TQ833		HSS-PM	M	Ti Ni	DIN 371/376	ISO 2/6H	C	Vap	423
TR833		HSS-PM	M	Ti Ni	DIN 371/376	ISO 2/6H	C	Bright	424
TM933		HSS-PM	M	Ni	DIN 371/376	ISO 2/6H	C	Bright	425
TZ933		HSS-PM	M	Ni	DIN 371/376	ISO 2/6H	C	TiAlN	426
TC163		HSS-E	M	Al	DIN 371/376	ISO 2/6H	C	Bright	427
TE953		HSS-E	M	Al	DIN 371/376	ISO 2/6H	C	NI	428
TC411		HSS-E	MF	GS	DIN 374	ISO 2/6H	C	Bright	429
TD411		HSS-E	MF	GS	DIN 374	ISO 2/6H	C	TiN	431
TC413		HSS-E	MF	VG	DIN 374	ISO 2/6H	C	Bright	433
TD413		HSS-E	MF	VG	DIN 374	ISO 2/6H	C	TiN	434
TB183		HSS-E	MF	VA NW	DIN 374	ISO 2/6H	C	Vap	435
TC963		HSS-E	MF	Al	DIN 374	ISO 2/6H	C	Bright	436
TC144		HSS-E	UNC	GS	DIN 371/376	2B	C	Bright	437
TC174		HSS-E	UNC	VG	DIN 371/376	2B	C	Bright	438
TD174		HSS-E	UNC	VG	DIN 371/376	2B	C	TiN	439
TB904		HSS-E	UNC	VA NW	DIN 371/376	2B	C	Vap	440
TC169		HSS-E	UNC	Al	DIN 371/376	2B	C	Bright	441
TC124		HSS-E	UNF	GS	DIN 371/374	2B	C	Bright	442
TC184		HSS-E	UNF	VG	DIN 371/374	2B	C	Bright	443
TB924		HSS-E	UNF	VA NW	DIN 371/374	2B	C	Vap	444
TC170		HSS-E	UNF	Al	DIN 371/374	2B	C	Bright	445
TC134		HSS-E	BSW	GS	DIN 2182/2183	-	C	Bright	446



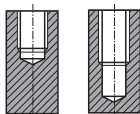
SPIRAL FLUTE TAPS

TTS31 SERIES

M ISO metric coarse threads DIN 13 Metrisches ISO-Gewinde DIN 13

► Suitable for high speed machining and high precision threads

► Geeignet für die High-Speed-Bearbeitung (HSC) und hoher Gewinde-Präzision

Hole type


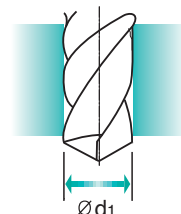
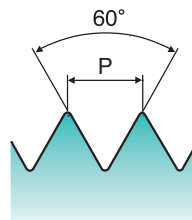
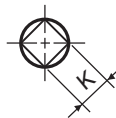
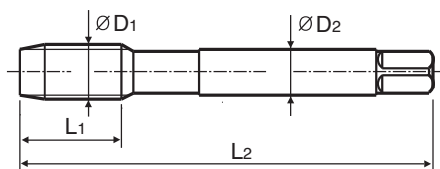
DIN 371/376

**Synchro
Type**

Applicable to 2-3 times faster cutting speed than minimum general GS Taps cutting speeds


HSS-PM
DIN 371/376
6H
60°
C
TiN
R45

Machine taps
Maschinengewindebohrer



Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping Drill Diameter Ød1
M3	× 0.5	TTS31206	6	56	3.5	2.7	2.5
M4	× 0.7	TTS31246	7	63	4.5	3.4	3.3
M5	× 0.8	TTS31286	8	70	6	4.9	4.2
M6	× 1	TTS31316	10	80	6	4.9	5
M8	× 1.25	TTS31366	13	90	8	6.2	6.8
M10	× 1.5	TTS31426	15	100	10	8	8.5
M12	× 1.75	TTS31506	18	110	9	7	10.2
M14	× 2	TTS31546	20	110	11	9	12
M16	× 2	TTS31606	20	110	12	9	14
M18	× 2.5	TTS31656	25	125	14	11	15.5
M20	× 2.5	TTS31706	25	140	16	12	17.5

► DIN371 (M3~M10) and DIN376 (M11~M20)

► Coating(TiAlN) is available on your request.

Unit : N/mm²

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
◎	◎	◎									◎	◎	○	
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
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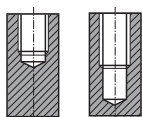
M ISO metric coarse threads DIN 13

Metrisches ISO-Gewinde DIN 13

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

Hole type



DIN 352



HSS-E

DIN
352

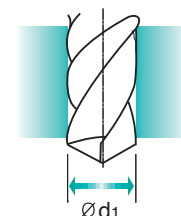
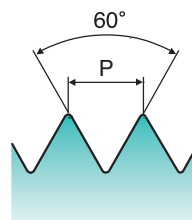
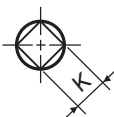
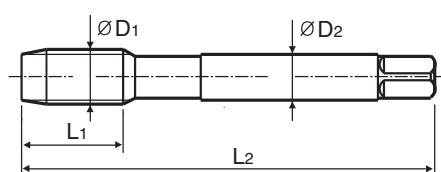
6H



Bright



Short machine taps
Maschinengewindebohrer
kurz



Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping Drill Diameter Ød1
M3	× 0.5	TC612206	11	40	3.5	2.7	2.5
M4	× 0.7	TC612246	13	45	4.5	3.4	3.3
M5	× 0.8	TC612286	16	52	6	4.9	4.2
M6	× 1	TC612316	18	56	6	4.9	5
M8	× 1.25	TC612366	20	63	6	4.9	6.8
M10	× 1.5	TC612426	22	70	7	5.5	8.5
M12	× 1.75	TC612506	24	80	9	7	10.2
M14	× 2	TC612546	26	80	11	9	12
M16	× 2	TC612606	27	80	12	9	14
M18	× 2.5	TC612656	30	95	14	11	15.5
M20	× 2.5	TC612706	32	95	16	12	17.5

Unit : N/mm²

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy < 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
◎	◎	◎									◎	◎	○	
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
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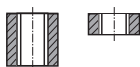
SPIRAL FLUTE TAPS

TC211 SERIES

M ISO metric coarse threads DIN 13 Metrisches ISO-Gewinde DIN 13

► Left spiral flute and right hand thread tap to push chips ahead in powerful than spiral point taps.

► Rechtsschneidender Gewindebohrer mit Linksdrall um kraftvoller nach vorne zu entspannen als mit Gewindebohrern mit Rechtsdrall.

Hole type


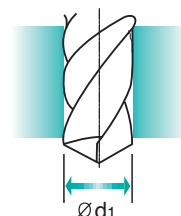
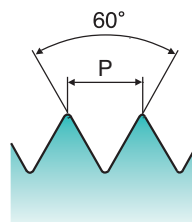
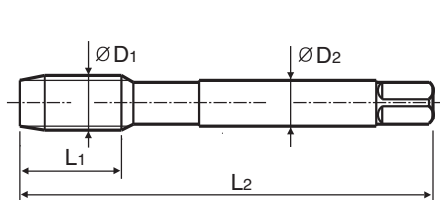
DIN 371



DIN 376


HSS-E
**DIN
371/376**
6H

Bright

Machine taps
Maschinengewindebohrer


Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping Drill Diameter Ød1
M2	× 0.4	TC211136	8	45	2.8	2.1	1.6
M2.2	× 0.45	TC211156	8	45	2.8	2.1	1.75
* M2.3	× 0.4	TC211196	8	45	2.8	2.1	1.9
M2.5	× 0.45	TC211176	9	50	2.8	2.1	2.05
* M2.6	× 0.45	TC211496	9	50	2.8	2.1	2.1
M3	× 0.5	TC211206	11	56	3.5	2.7	2.5
M3.5	× 0.6	TC211226	12	56	4	3	2.9
M4	× 0.7	TC211246	13	63	4.5	3.4	3.3
M4.5	× 0.75	TC211266	14	70	6	4.9	3.7
M5	× 0.8	TC211286	15	70	6	4.9	4.2
M6	× 1	TC211316	17	80	6	4.9	5
M7	× 1	TC211346	17	80	7	5.5	6
M8	× 1.25	TC211366	20	90	8	6.2	6.8
M9	× 1.25	TC211396	20	90	9	7	7.8
M10	× 1.5	TC211426	22	100	10	8	8.5
M11	× 1.5	TC211466	22	100	8	6.2	9.5
M12	× 1.75	TC211506	24	110	9	7	10.2
M14	× 2	TC211546	26	110	11	9	12
M16	× 2	TC211606	27	110	12	9	14
M18	× 2.5	TC211656	30	125	14	11	15.5
M20	× 2.5	TC211706	32	140	16	12	17.5
M22	× 2.5	TC211746	32	140	18	14.5	19.5
M24	× 3	TC211786	34	160	18	14.5	21
M27	× 3	TC211866	36	160	20	16	24
M30	× 3.5	TC211946	40	180	22	18	26.5

► DIN 371(M2~M10) and DIN 376(M11~M30)

► * DIN profile not ISO

Unit : N/mm²

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy < 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎
Ti Alloy ≤ 1300	Ni ≤ 500	Ni Alloy ≤ 900	Ni Alloy ≤ 1400	Cu ≤ 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe ≤ 1500	Al / Mg ≤ 350	Al Wrought	Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
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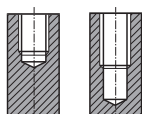
M ISO metric coarse threads DIN 13

Metrisches ISO-Gewinde DIN 13

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

Hole type



HSS-E

DIN 371/376

6H

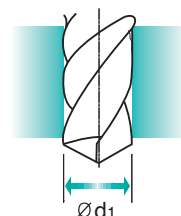
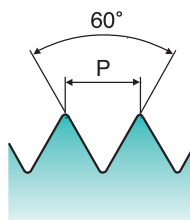
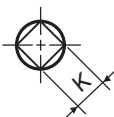
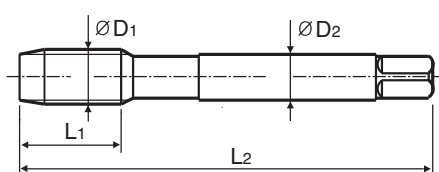
60°

C

Bright

R20

Machine taps
Maschinengewindebohrer



Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping Drill Diameter Ød1
M2	× 0.4	TC517136	8	45	2.8	2.1	1.6
M2.2	× 0.45	TC517156	8	45	2.8	2.1	1.75
* M2.3	× 0.4	TC517196	8	45	2.8	2.1	1.9
M2.5	× 0.45	TC517176	9	50	2.8	2.1	2.05
* M2.6	× 0.45	TC517496	9	50	2.8	2.1	2.1
M3	× 0.5	TC517206	6	56	3.5	2.7	2.5
M3.5	× 0.6	TC517226	7	56	4	3	2.9
M4	× 0.7	TC517246	7	63	4.5	3.4	3.3
M4.5	× 0.75	TC517266	8	70	6	4.9	3.7
M5	× 0.8	TC517286	8	70	6	4.9	4.2
M6	× 1	TC517316	10	80	6	4.9	5
M7	× 1	TC517346	10	80	7	5.5	6
M8	× 1.25	TC517366	13	90	8	6.2	6.8
M9	× 1.25	TC517396	13	90	9	7	7.8
M10	× 1.5	TC517426	15	100	10	8	8.5
M11	× 1.5	TC517466	17	100	8	6.2	9.5
M12	× 1.75	TC517506	18	110	9	7	10.2
M14	× 2	TC517546	20	110	11	9	12
M16	× 2	TC517606	20	110	12	9	14
M18	× 2.5	TC517656	25	125	14	11	15.5
M20	× 2.5	TC517706	25	140	16	12	17.5
M22	× 2.5	TC517746	25	140	18	14.5	19.5
M24	× 3	TC517786	30	160	18	14.5	21
M27	× 3	TC517866	30	160	20	16	24
M30	× 3.5	TC517946	35	180	22	18	26.5

► DIN 371(M2~M10) and DIN 376(M11~M30)

► * DIN profile not ISO

Unit : N/mm²

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy < 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎
Ti Alloy < 1300	Ni < 500	Ni Alloy < 900	Ni Alloy < 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Si < 10%	Al > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
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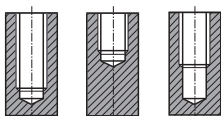
SPIRAL FLUTE TAPS

TC711 SERIES

M ISO metric coarse threads DIN 13 Metrisches ISO-Gewinde DIN 13

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

Hole type


DIN 371



DIN 376



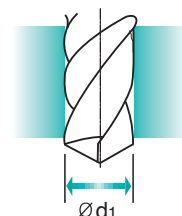
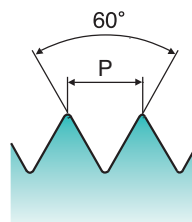
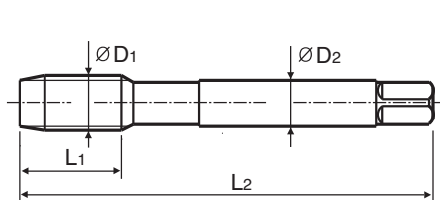
HSS-E

DIN
371/376

6H



Bright


Machine taps
Maschinengewindebohrer


Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping Drill Diameter Ød1
M2	× 0.4	TC711136	8	45	2.8	2.1	1.6
M2.2	× 0.45	TC711156	8	45	2.8	2.1	1.75
* M2.3	× 0.4	TC711196	8	45	2.8	2.1	1.9
M2.5	× 0.45	TC711176	9	50	2.8	2.1	2.05
* M2.6	× 0.45	TC711496	9	50	2.8	2.1	2.1
M3	× 0.5	TC711206	6	56	3.5	2.7	2.5
M3.5	× 0.6	TC711226	7	56	4	3	2.9
M4	× 0.7	TC711246	7	63	4.5	3.4	3.3
M4.5	× 0.75	TC711266	8	70	6	4.9	3.7
M5	× 0.8	TC711286	8	70	6	4.9	4.2
M6	× 1	TC711316	10	80	6	4.9	5
M7	× 1	TC711346	10	80	7	5.5	6
M8	× 1.25	TC711366	13	90	8	6.2	6.8
M9	× 1.25	TC711396	13	90	9	7	7.8
M10	× 1.5	TC711426	15	100	10	8	8.5
M11	× 1.5	TC711466	17	100	8	6.2	9.5
M12	× 1.75	TC711506	18	110	9	7	10.2
M14	× 2	TC711546	20	110	11	9	12
M16	× 2	TC711606	20	110	12	9	14
M18	× 2.5	TC711656	25	125	14	11	15.5
M20	× 2.5	TC711706	25	140	16	12	17.5
M22	× 2.5	TC711746	25	140	18	14.5	19.5
M24	× 3	TC711786	30	160	18	14.5	21
M27	× 3	TC711866	30	160	20	16	24
M30	× 3.5	TC711946	35	180	22	18	26.5

► DIN 371(M2~M10) and DIN 376(M11~M30)

► * DIN profile not ISO

Unit : N/mm²

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy < 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎
Ti Alloy ≤ 1300	Ni ≤ 500	Ni Alloy ≤ 900	Ni Alloy ≤ 1400	Cu ≤ 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe ≤ 1500	Al / Mg ≤ 350	Al Wrought	Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

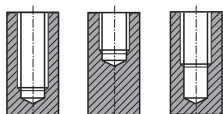
M

ISO metric coarse threads DIN 13
Metrisches ISO-Gewinde DIN 13

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

Hole type



DIN 371



DIN 376

Material groups
GS

HSS-E

DIN 371/376

6H

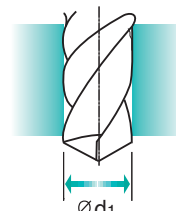
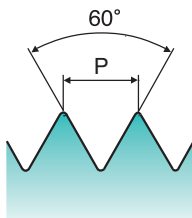
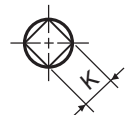
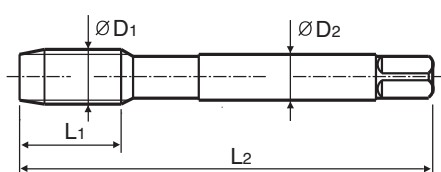
60°

C

TiN

R40

Machine taps
Maschinengewindebohrer



Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping Drill Diameter Ød1
M2	× 0.4	TD711136	8	45	2.8	2.1	1.6
M2.2	× 0.45	TD711156	8	45	2.8	2.1	1.75
* M2.3	× 0.4	TD711196	8	45	2.8	2.1	1.9
M2.5	× 0.45	TD711176	9	50	2.8	2.1	2.05
* M2.6	× 0.45	TD711496	9	50	2.8	2.1	2.1
M3	× 0.5	TD711206	6	56	3.5	2.7	2.5
M3.5	× 0.6	TD711226	7	56	4	3	2.9
M4	× 0.7	TD711246	7	63	4.5	3.4	3.3
M4.5	× 0.75	TD711266	8	70	6	4.9	3.7
M5	× 0.8	TD711286	8	70	6	4.9	4.2
M6	× 1	TD711316	10	80	6	4.9	5
M7	× 1	TD711346	10	80	7	5.5	6
M8	× 1.25	TD711366	13	90	8	6.2	6.8
M9	× 1.25	TD711396	13	90	9	7	7.8
M10	× 1.5	TD711426	15	100	10	8	8.5
M11	× 1.5	TD711466	17	100	8	6.2	9.5
M12	× 1.75	TD711506	18	110	9	7	10.2
M14	× 2	TD711546	20	110	11	9	12
M16	× 2	TD711606	20	110	12	9	14
M18	× 2.5	TD711656	25	125	14	11	15.5
M20	× 2.5	TD711706	25	140	16	12	17.5
M22	× 2.5	TD711746	25	140	18	14.5	19.5
M24	× 3	TD711786	30	160	18	14.5	21
M27	× 3	TD711866	30	160	20	16	24
M30	× 3.5	TD711946	35	180	22	18	26.5

► DIN 371(M2~M10) and DIN 376(M11~M30)

► * DIN profile not ISO

Unit : N/mm²

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy < 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎
Ti Alloy < 1300	Ni < 500	Ni Alloy < 900	Ni Alloy < 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Si < 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎



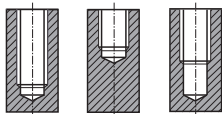
SPIRAL FLUTE TAPS

TQ823 SERIES

M ISO metric coarse threads DIN 13 Metrisches ISO-Gewinde DIN 13

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

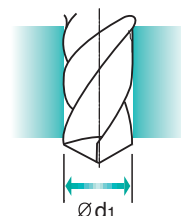
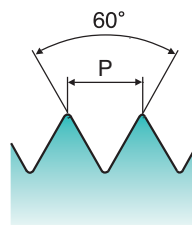
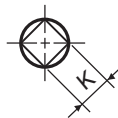
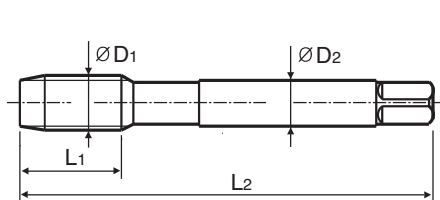
Hole type


DIN 371



DIN 376


HSS-PM
DIN 371/376
6H
60°
C
Vap
R40

Machine taps
Maschinengewindebohrer


Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping Drill Diameter
ØD1	P		L1	L2	ØD2	K	Ød1
M2	× 0.4	TQ823136	8	45	2.8	2.1	1.6
M2.2	× 0.45	TQ823156	8	45	2.8	2.1	1.75
M2.5	× 0.45	TQ823176	9	50	2.8	2.1	2.05
M3	× 0.5	TQ823206	6	56	3.5	2.7	2.5
M3.5	× 0.6	TQ823226	7	56	4	3	2.9
M4	× 0.7	TQ823246	7	63	4.5	3.4	3.3
M4.5	× 0.75	TQ823266	8	70	6	4.9	3.7
M5	× 0.8	TQ823286	8	70	6	4.9	4.2
M6	× 1	TQ823316	10	80	6	4.9	5
M7	× 1	TQ823346	10	80	7	5.5	6
M8	× 1.25	TQ823366	13	90	8	6.2	6.8
M10	× 1.5	TQ823426	15	100	10	8	8.5
M12	× 1.75	TQ823506	18	110	9	7	10.2

► DIN (M2~M10) and DIN 376(M12)

Unit : N/mm²

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
			○	◎				○						○
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
		○												

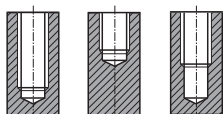
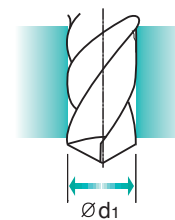
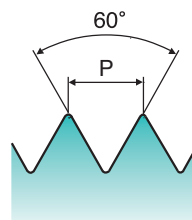
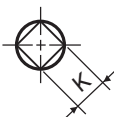
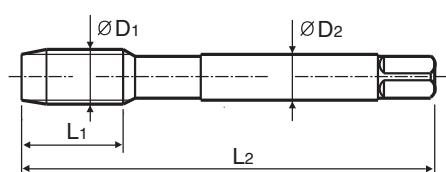
M ISO metric coarse threads DIN 13

Metrisches ISO-Gewinde DIN 13

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

Hole type


HSS-PM
DIN 371/376
6H
60°
C
Bright
R40
**Machine taps
Maschinengewindebohrer**


Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping Drill Diameter Ød1
M2	× 0.4	TR823136	8	45	2.8	2.1	1.6
M2.2	× 0.45	TR823156	8	45	2.8	2.1	1.75
M2.5	× 0.45	TR823176	9	50	2.8	2.1	2.05
M3	× 0.5	TR823206	6	56	3.5	2.7	2.5
M3.5	× 0.6	TR823226	7	56	4	3	2.9
M4	× 0.7	TR823246	7	63	4.5	3.4	3.3
M4.5	× 0.75	TR823266	8	70	6	4.9	3.7
M5	× 0.8	TR823286	8	70	6	4.9	4.2
M6	× 1	TR823316	10	80	6	4.9	5
M7	× 1	TR823346	10	80	7	5.5	6
M8	× 1.25	TR823366	13	90	8	6.2	6.8
M10	× 1.5	TR823426	15	100	10	8	8.5
M12	× 1.75	TR823506	18	110	9	7	10.2

► DIN (M2~M10) and DIN 376(M12)

Unit : N/mm²

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
			○	◎				○						○
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
		○												



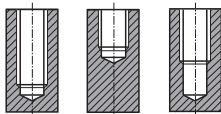
SPIRAL FLUTE TAPS

TB312 SERIES

M ISO metric coarse threads DIN 13 Metrisches ISO-Gewinde DIN 13

► Suitable for threading blind holes due to excellent chip evacuation of tempered steels or similar work materials.

► Geeignet zum Gewinden von Sacklöchern dank ausgezeichneter Spanabfuhr von angelassenen Stählen oder ähnlichen Werkstoffen.

Hole type


DIN 371



DIN 376



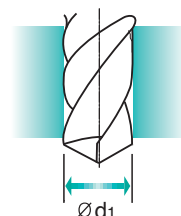
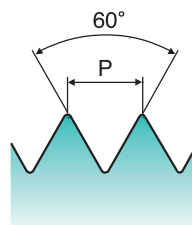
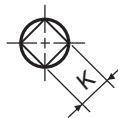
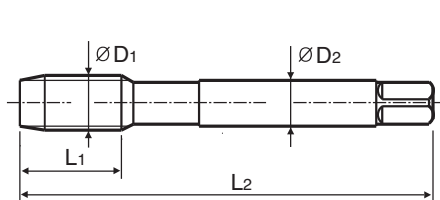
HSS-E

DIN
371/376

6H



Vap


Machine taps
Maschinengewindebohrer


Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping Drill Diameter
ØD1	P		L1	L2	ØD2	K	Ød1
M2	× 0.4	TB312136	8	45	2.8	2.1	1.6
M2.2	× 0.45	TB312156	8	45	2.8	2.1	1.75
* M2.3	× 0.4	TB312196	8	45	2.8	2.1	1.9
M2.5	× 0.45	TB312176	9	50	2.8	2.1	2.05
* M2.6	× 0.45	TB312496	9	50	2.8	2.1	2.1
M3	× 0.5	TB312206	6	56	3.5	2.7	2.5
M3.5	× 0.6	TB312226	7	56	4	3	2.9
M4	× 0.7	TB312246	7	63	4.5	3.4	3.3
M4.5	× 0.75	TB312266	8	70	6	4.9	3.7
M5	× 0.8	TB312286	8	70	6	4.9	4.2
M6	× 1	TB312316	10	80	6	4.9	5
M7	× 1	TB312346	10	80	7	5.5	6
M8	× 1.25	TB312366	13	90	8	6.2	6.8
M9	× 1.25	TB312396	13	90	9	7	7.8
M10	× 1.5	TB312426	15	100	10	8	8.5
M11	× 1.5	TB312466	17	100	8	6.2	9.5
M12	× 1.75	TB312506	18	110	9	7	10.2
M14	× 2	TB312546	20	110	11	9	12
M16	× 2	TB312606	20	110	12	9	14
M18	× 2.5	TB312656	25	125	14	11	15.5
M20	× 2.5	TB312706	25	140	16	12	17.5
M22	× 2.5	TB312746	25	140	18	14.5	19.5
M24	× 3	TB312786	30	160	18	14.5	21
M27	× 3	TB312866	30	160	20	16	24
M30	× 3.5	TB312946	35	180	22	18	26.5

► DIN 371(M2~M10) and DIN 376(M11~M30)

► * DIN profile not ISO

Unit : N/mm²

◎ : Excellent ○ : Good

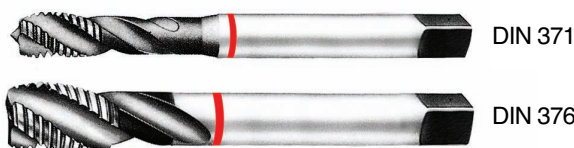
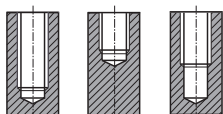
Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
			○	◎				○						○
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
		○												

M ISO metric coarse threads DIN 13

Metrisches ISO-Gewinde DIN 13

- ▶ With recessed threads for machine tapping of deep blind holes.
- ▶ Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

- ▶ Mit abgesetztem Gewinde zum Schneiden von tiefen Sacklochgewinden.
- ▶ Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

Hole type


DIN 371

DIN 376



HSS-E

DIN
371/376

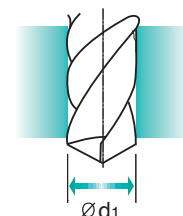
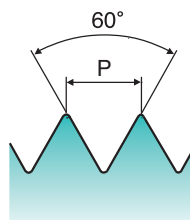
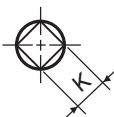
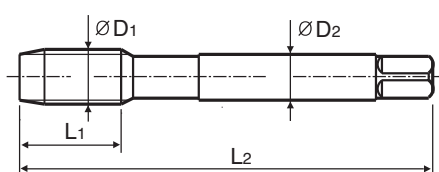
6H

60°

C

Vap

R40

Machine taps
Maschinengewindebohrer


Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping Drill Diameter Ød1
M2	× 0.4	TB913136	8	45	2.8	2.1	1.6
M2.2	× 0.45	TB913156	8	45	2.8	2.1	1.75
* M2.3	× 0.4	TB913196	8	45	2.8	2.1	1.9
M2.5	× 0.45	TB913176	9	50	2.8	2.1	2.05
* M2.6	× 0.45	TB913496	9	50	2.8	2.1	2.1
M3	× 0.5	TB913206	6	56	3.5	2.7	2.5
M3.5	× 0.6	TB913226	7	56	4	3	2.9
M4	× 0.7	TB913246	7	63	4.5	3.4	3.3
M4.5	× 0.75	TB913266	8	70	6	4.9	3.7
M5	× 0.8	TB913286	8	70	6	4.9	4.2
M6	× 1	TB913316	10	80	6	4.9	5
M7	× 1	TB913346	10	80	7	5.5	6
M8	× 1.25	TB913366	13	90	8	6.2	6.8
M9	× 1.25	TB913396	13	90	9	7	7.8
M10	× 1.5	TB913426	15	100	10	8	8.5
M11	× 1.5	TB913466	17	100	8	6.2	9.5
M12	× 1.75	TB913506	18	110	9	7	10.2
M14	× 2	TB913546	20	110	11	9	12
M16	× 2	TB913606	20	110	12	9	14
M18	× 2.5	TB913656	25	125	14	11	15.5
M20	× 2.5	TB913706	25	140	16	12	17.5
M22	× 2.5	TB913746	25	140	18	14.5	19.5
M24	× 3	TB913786	30	160	18	14.5	21
M27	× 3	TB913866	30	160	20	16	24
M30	× 3.5	TB913946	35	180	22	18	26.5

▶ DIN 371(M2~M10) and DIN 376(M11~M30)

▶ * DIN profile not ISO

Unit : N/mm²

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy < 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
			○	◎				○						○
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
		○												



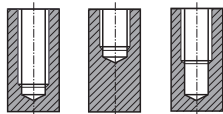
SPIRAL FLUTE TAPS

TC312 SERIES

M ISO metric coarse threads DIN 13 Metrisches ISO-Gewinde DIN 13

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

Hole type


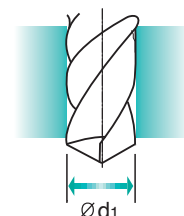
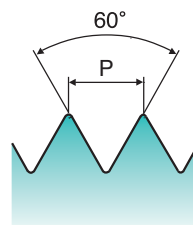
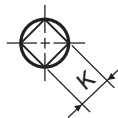
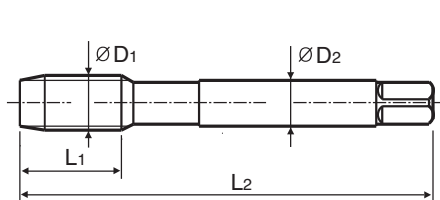
DIN 371



DIN 376


HSS-E
DIN 371/376
6H

Bright

Machine taps
Maschinengewindebohrer


Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping Drill Diameter
ØD1	P		L1	L2	ØD2	K	Ød1
M2	× 0.4	TC312136	8	45	2.8	2.1	1.6
M2.2	× 0.45	TC312156	8	45	2.8	2.1	1.75
* M2.3	× 0.4	TC312196	8	45	2.8	2.1	1.9
M2.5	× 0.45	TC312176	9	50	2.8	2.1	2.05
* M2.6	× 0.45	TC312496	9	50	2.8	2.1	2.1
M3	× 0.5	TC312206	6	56	3.5	2.7	2.5
M3.5	× 0.6	TC312226	7	56	4	3	2.9
M4	× 0.7	TC312246	7	63	4.5	3.4	3.3
M4.5	× 0.75	TC312266	8	70	6	4.9	3.7
M5	× 0.8	TC312286	8	70	6	4.9	4.2
M6	× 1	TC312316	10	80	6	4.9	5
M7	× 1	TC312346	10	80	7	5.5	6
M8	× 1.25	TC312366	13	90	8	6.2	6.8
M9	× 1.25	TC312396	13	90	9	7	7.8
M10	× 1.5	TC312426	15	100	10	8	8.5
M11	× 1.5	TC312466	17	100	8	6.2	9.5
M12	× 1.75	TC312506	18	110	9	7	10.2
M14	× 2	TC312546	20	110	11	9	12
M16	× 2	TC312606	20	110	12	9	14
M18	× 2.5	TC312656	25	125	14	11	15.5
M20	× 2.5	TC312706	25	140	16	12	17.5
M22	× 2.5	TC312746	25	140	18	14.5	19.5
M24	× 3	TC312786	30	160	18	14.5	21
M27	× 3	TC312866	30	160	20	16	24
M30	× 3.5	TC312946	35	180	22	18	26.5

► DIN 371(M2~M10) and DIN 376(M11~M30)

► * DIN profile not ISO

Unit : N/mm²

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
			○	◎				○						○
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
		○												

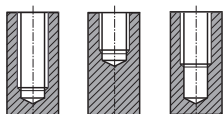
M

ISO metric coarse threads DIN 13
Metrisches ISO-Gewinde DIN 13

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

Hole type



DIN 371



DIN 376



HSS-E

DIN 371/376

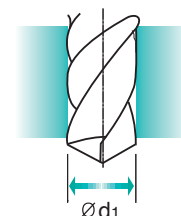
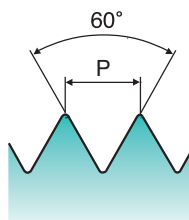
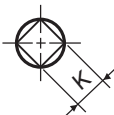
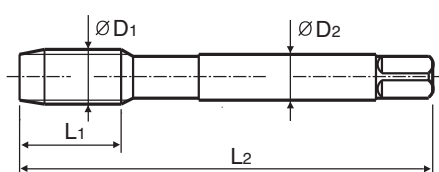
6H



TiN



Machine taps
Maschinengewindebohrer



Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping Drill Diameter Ød1
M2	× 0.4	TD312136	8	45	2.8	2.1	1.6
M2.2	× 0.45	TD312156	8	45	2.8	2.1	1.75
* M2.3	× 0.4	TD312196	8	45	2.8	2.1	1.9
M2.5	× 0.45	TD312176	9	50	2.8	2.1	2.05
* M2.6	× 0.45	TD312496	9	50	2.8	2.1	2.1
M3	× 0.5	TD312206	6	56	3.5	2.7	2.5
M3.5	× 0.6	TD312226	7	56	4	3	2.9
M4	× 0.7	TD312246	7	63	4.5	3.4	3.3
M4.5	× 0.75	TD312266	8	70	6	4.9	3.7
M5	× 0.8	TD312286	8	70	6	4.9	4.2
M6	× 1	TD312316	10	80	6	4.9	5
M7	× 1	TD312346	10	80	7	5.5	6
M8	× 1.25	TD312366	13	90	8	6.2	6.8
M9	× 1.25	TD312396	13	90	9	7	7.8
M10	× 1.5	TD312426	15	100	10	8	8.5
M11	× 1.5	TD312466	17	100	8	6.2	9.5
M12	× 1.75	TD312506	18	110	9	7	10.2
M14	× 2	TD312546	20	110	11	9	12
M16	× 2	TD312606	20	110	12	9	14
M18	× 2.5	TD312656	25	125	14	11	15.5
M20	× 2.5	TD312706	25	140	16	12	17.5
M22	× 2.5	TD312746	25	140	18	14.5	19.5
M24	× 3	TD312786	30	160	18	14.5	21
M27	× 3	TD312866	30	160	20	16	24
M30	× 3.5	TD312946	35	180	22	18	26.5

► DIN 371(M2~M10) and DIN 376(M11~M30)

► * DIN profile not ISO

Unit : N/mm²

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
			○	◎				○						○
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
		○												



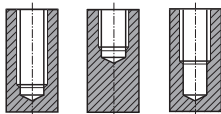
SPIRAL FLUTE TAPS

TY312 SERIES

M ISO metric coarse threads DIN 13 Metrisches ISO-Gewinde DIN 13

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

Hole type


DIN 371



DIN 376



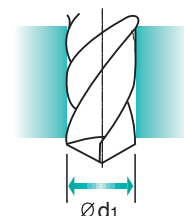
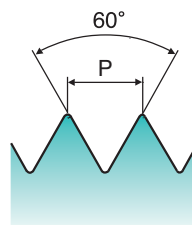
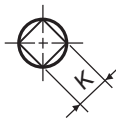
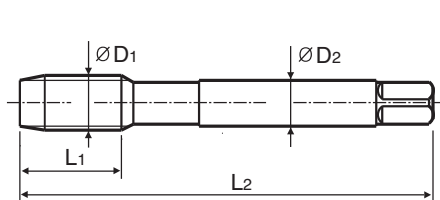
HSS-E

DIN
371/376

6H



TiAlN


Machine taps
Maschinengewindebohrer


Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping Drill Diameter Ød1
M2	× 0.4	TY312136	8	45	2.8	2.1	1.6
M2.2	× 0.45	TY312156	8	45	2.8	2.1	1.75
* M2.3	× 0.4	TY312196	8	45	2.8	2.1	1.9
M2.5	× 0.45	TY312176	9	50	2.8	2.1	2.05
* M2.6	× 0.45	TY312496	9	50	2.8	2.1	2.1
M3	× 0.5	TY312206	6	56	3.5	2.7	2.5
M3.5	× 0.6	TY312226	7	56	4	3	2.9
M4	× 0.7	TY312246	7	63	4.5	3.4	3.3
M4.5	× 0.75	TY312266	8	70	6	4.9	3.7
M5	× 0.8	TY312286	8	70	6	4.9	4.2
M6	× 1	TY312316	10	80	6	4.9	5
M7	× 1	TY312346	10	80	7	5.5	6
M8	× 1.25	TY312366	13	90	8	6.2	6.8
M9	× 1.25	TY312396	13	90	9	7	7.8
M10	× 1.5	TY312426	15	100	10	8	8.5
M11	× 1.5	TY312466	17	100	8	6.2	9.5
M12	× 1.75	TY312506	18	110	9	7	10.2
M14	× 2	TY312546	20	110	11	9	12
M16	× 2	TY312606	20	110	12	9	14
M18	× 2.5	TY312656	25	125	14	11	15.5
M20	× 2.5	TY312706	25	140	16	12	17.5
M22	× 2.5	TY312746	25	140	18	14.5	19.5
M24	× 3	TY312786	30	160	18	14.5	21
M27	× 3	TY312866	30	160	20	16	24
M30	× 3.5	TY312946	35	180	22	18	26.5

► DIN 371(M2~M10) and DIN 376(M11~M30)

► * DIN profile not ISO

Unit : N/mm²

◎ : Excellent ○ : Good

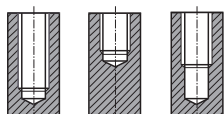
Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
			○	◎				○						○
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
		○												

M

ISO metric coarse threads DIN 13
Metrisches ISO-Gewinde DIN 13

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

Hole type


Material groups

VA

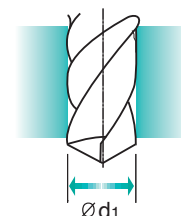
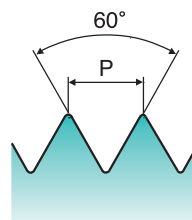
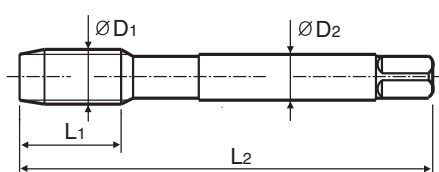
HSS-PM

DIN
371/376

6H



Vap


Machine taps
Maschinengewindebohrer


Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping Drill Diameter Ød1
M2	× 0.4	TQ813136	8	45	2.8	2.1	1.6
M2.2	× 0.45	TQ813156	8	45	2.8	2.1	1.75
M2.5	× 0.45	TQ813176	9	50	2.8	2.1	2.05
M3	× 0.5	TQ813206	6	56	3.5	2.7	2.5
M3.5	× 0.6	TQ813226	7	56	4	3	2.9
M4	× 0.7	TQ813246	7	63	4.5	3.4	3.3
M4.5	× 0.75	TQ813266	8	70	6	4.9	3.7
M5	× 0.8	TQ813286	8	70	6	4.9	4.2
M6	× 1	TQ813316	10	80	6	4.9	5
M7	× 1	TQ813346	10	80	7	5.5	6
M8	× 1.25	TQ813366	13	90	8	6.2	6.8
M10	× 1.5	TQ813426	15	100	10	8	8.5
M12	× 1.75	TQ813506	18	110	9	7	10.2

► DIN 371(M2-M10) and DIN 376(M12)

Unit : N/mm²

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy < 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
○	◎					◎	◎	◎						○
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
		○												



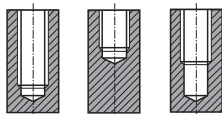
SPIRAL FLUTE TAPS

TR813 SERIES

M ISO metric coarse threads DIN 13 Metrisches ISO-Gewinde DIN 13

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

Hole type


DIN 371



DIN 376

Material groups

VA

HSS-PM

DIN 371/376

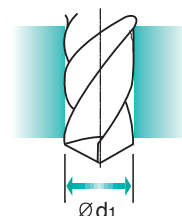
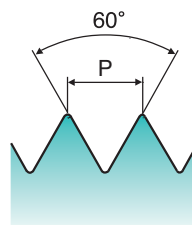
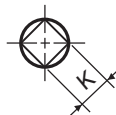
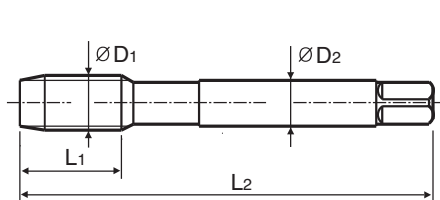
6H

60°

C

Bright

R40

Machine taps
Maschinengewindebohrer


Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping Drill Diameter
ØD1	P		L1	L2	ØD2	K	Ød1
M2	× 0.4	TR813136	8	45	2.8	2.1	1.6
M2.2	× 0.45	TR813156	8	45	2.8	2.1	1.75
M2.5	× 0.45	TR813176	9	50	2.8	2.1	2.05
M3	× 0.5	TR813206	6	56	3.5	2.7	2.5
M3.5	× 0.6	TR813226	7	56	4	3	2.9
M4	× 0.7	TR813246	7	63	4.5	3.4	3.3
M4.5	× 0.75	TR813266	8	70	6	4.9	3.7
M5	× 0.8	TR813286	8	70	6	4.9	4.2
M6	× 1	TR813316	10	80	6	4.9	5
M7	× 1	TR813346	10	80	7	5.5	6
M8	× 1.25	TR813366	13	90	8	6.2	6.8
M10	× 1.5	TR813426	15	100	10	8	8.5
M12	× 1.75	TR813506	18	110	9	7	10.2

► DIN 371(M2~M10) and DIN 376(M12)

Unit : N/mm²

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
○	◎					◎	◎	◎						○
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
		○												

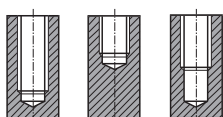
M

ISO metric coarse threads DIN 13
Metrisches ISO-Gewinde DIN 13

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

Hole type



Material groups
HR

HSS-E

DIN 371/376

6H

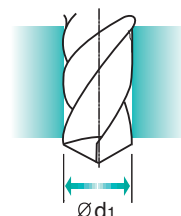
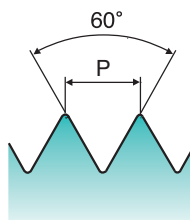
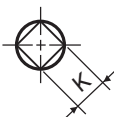
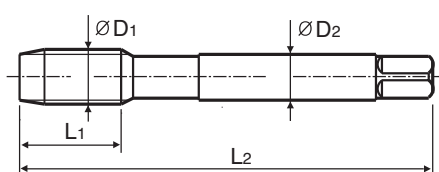
60°

C

Vap

R40

Machine taps
Maschinengewindebohrer



Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping Drill Diameter Ød1
M2	× 0.4	TB313136	8	45	2.8	2.1	1.6
M2.2	× 0.45	TB313156	8	45	2.8	2.1	1.75
* M2.3	× 0.4	TB313196	8	45	2.8	2.1	1.9
M2.5	× 0.45	TB313176	9	50	2.8	2.1	2.05
* M2.6	× 0.45	TB313496	9	50	2.8	2.1	2.1
M3	× 0.5	TB313206	6	56	3.5	2.7	2.5
M3.5	× 0.6	TB313226	7	56	4	3	2.9
M4	× 0.7	TB313246	7	63	4.5	3.4	3.3
M4.5	× 0.75	TB313266	8	70	6	4.9	3.7
M5	× 0.8	TB313286	8	70	6	4.9	4.2
M6	× 1	TB313316	10	80	6	4.9	5
M7	× 1	TB313346	10	80	7	5.5	6
M8	× 1.25	TB313366	13	90	8	6.2	6.8
M9	× 1.25	TB313396	13	90	9	7	7.8
M10	× 1.5	TB313426	15	100	10	8	8.5
M11	× 1.5	TB313466	17	100	8	6.2	9.5
M12	× 1.75	TB313506	18	110	9	7	10.2
M14	× 2	TB313546	20	110	11	9	12
M16	× 2	TB313606	20	110	12	9	14
M18	× 2.5	TB313656	25	125	14	11	15.5
M20	× 2.5	TB313706	25	140	16	12	17.5
M22	× 2.5	TB313746	25	140	18	14.5	19.5
M24	× 3	TB313786	30	160	18	14.5	21
M27	× 3	TB313866	30	160	20	16	24
M30	× 3.5	TB313946	35	180	22	18	26.5

► DIN 371(M2~M10) and DIN 376(M11~M30)

► * DIN profile not ISO

Unit : N/mm²

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
				○	◎			○						
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
					○		◎						○	○



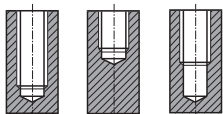
SPIRAL FLUTE TAPS

TC313 SERIES

M ISO metric coarse threads DIN 13 Metrisches ISO-Gewinde DIN 13

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

Hole type


DIN 371



DIN 376



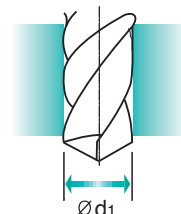
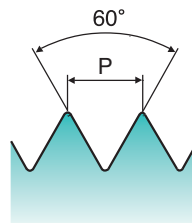
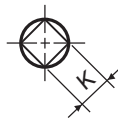
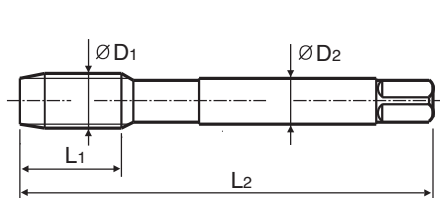
HSS-E

DIN
371/376

6H



Bright


Machine taps
Maschinengewindebohrer


Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping Drill Diameter
ØD1	P		L1	L2	ØD2	K	Ød1
M2	× 0.4	TC313136	8	45	2.8	2.1	1.6
M2.2	× 0.45	TC313156	8	45	2.8	2.1	1.75
* M2.3	× 0.4	TC313196	8	45	2.8	2.1	1.9
M2.5	× 0.45	TC313176	9	50	2.8	2.1	2.05
* M2.6	× 0.45	TC313496	9	50	2.8	2.1	2.1
M3	× 0.5	TC313206	6	56	3.5	2.7	2.5
M3.5	× 0.6	TC313226	7	56	4	3	2.9
M4	× 0.7	TC313246	7	63	4.5	3.4	3.3
M4.5	× 0.75	TC313266	8	70	6	4.9	3.7
M5	× 0.8	TC313286	8	70	6	4.9	4.2
M6	× 1	TC313316	10	80	6	4.9	5
M7	× 1	TC313346	10	80	7	5.5	6
M8	× 1.25	TC313366	13	90	8	6.2	6.8
M9	× 1.25	TC313396	13	90	9	7	7.8
M10	× 1.5	TC313426	15	100	10	8	8.5
M11	× 1.5	TC313466	17	100	8	6.2	9.5
M12	× 1.75	TC313506	18	110	9	7	10.2
M14	× 2	TC313546	20	110	11	9	12
M16	× 2	TC313606	20	110	12	9	14
M18	× 2.5	TC313656	25	125	14	11	15.5
M20	× 2.5	TC313706	25	140	16	12	17.5
M22	× 2.5	TC313746	25	140	18	14.5	19.5
M24	× 3	TC313786	30	160	18	14.5	21
M27	× 3	TC313866	30	160	20	16	24
M30	× 3.5	TC313946	35	180	22	18	26.5

► DIN 371(M2~M10) and DIN 376(M11~M30)

► * DIN profile not ISO

Unit : N/mm²

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
				○	◎			○						
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
					○		◎						○	○

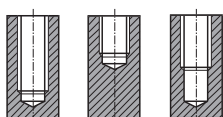
M

ISO metric coarse threads DIN 13
Metrisches ISO-Gewinde DIN 13

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

Hole type



Material groups
HR

HSS-E

DIN 371/376

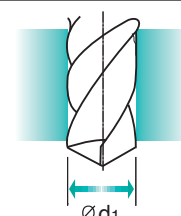
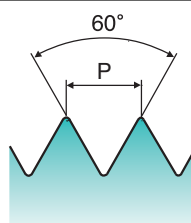
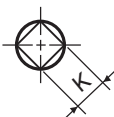
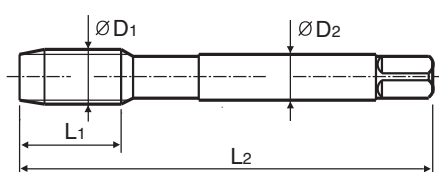
6H



TiAlN



Machine taps
Maschinengewindebohrer



Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping Drill Diameter Ød1
M2	× 0.4	TY313136	8	45	2.8	2.1	1.6
M2.2	× 0.45	TY313156	8	45	2.8	2.1	1.75
* M2.3	× 0.4	TY313196	8	45	2.8	2.1	1.9
M2.5	× 0.45	TY313176	9	50	2.8	2.1	2.05
* M2.6	× 0.45	TY313496	9	50	2.8	2.1	2.1
M3	× 0.5	TY313206	6	56	3.5	2.7	2.5
M3.5	× 0.6	TY313226	7	56	4	3	2.9
M4	× 0.7	TY313246	7	63	4.5	3.4	3.3
M4.5	× 0.75	TY313266	8	70	6	4.9	3.7
M5	× 0.8	TY313286	8	70	6	4.9	4.2
M6	× 1	TY313316	10	80	6	4.9	5
M7	× 1	TY313346	10	80	7	5.5	6
M8	× 1.25	TY313366	13	90	8	6.2	6.8
M9	× 1.25	TY313396	13	90	9	7	7.8
M10	× 1.5	TY313426	15	100	10	8	8.5
M11	× 1.5	TY313466	17	100	8	6.2	9.5
M12	× 1.75	TY313506	18	110	9	7	10.2
M14	× 2	TY313546	20	110	11	9	12
M16	× 2	TY313606	20	110	12	9	14
M18	× 2.5	TY313656	25	125	14	11	15.5
M20	× 2.5	TY313706	25	140	16	12	17.5
M22	× 2.5	TY313746	25	140	18	14.5	19.5
M24	× 3	TY313786	30	160	18	14.5	21
M27	× 3	TY313866	30	160	20	16	24
M30	× 3.5	TY313946	35	180	22	18	26.5

► DIN 371(M2~M10) and DIN 376(M11~M30)

► * DIN profile not ISO

Unit : N/mm²

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
				○	◎			○						
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
					○		◎						○	○



SPIRAL FLUTE TAPS

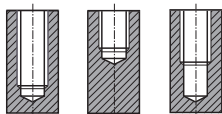
TB914 SERIES

M ISO metric coarse threads DIN 13 Metrisches ISO-Gewinde DIN 13

- ▶ With recessed threads for machine tapping of deep blind holes.
- ▶ Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

- ▶ Mit abgesetztem Gewinde zum Schneiden von tiefen Sacklochgewinden.
- ▶ Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

Hole type



DIN 371



DIN 376



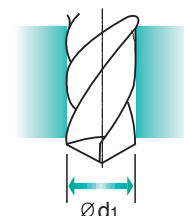
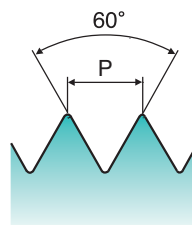
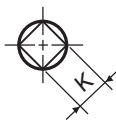
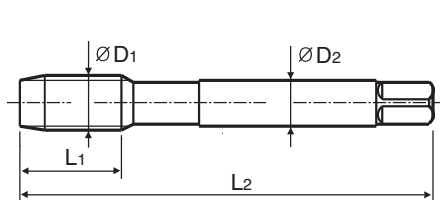
HSS-E

DIN
371/376

6H



Vap


Machine taps
Maschinengewindebohrer


Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping Drill Diameter Ød1
M2	× 0.4	TB914136	8	45	2.8	2.1	1.6
M2.2	× 0.45	TB914156	8	45	2.8	2.1	1.75
* M2.3	× 0.4	TB914196	8	45	2.8	2.1	1.9
M2.5	× 0.45	TB914176	9	50	2.8	2.1	2.05
* M2.6	× 0.45	TB914496	9	50	2.8	2.1	2.1
M3	× 0.5	TB914206	6	56	3.5	2.7	2.5
M3.5	× 0.6	TB914226	7	56	4	3	2.9
M4	× 0.7	TB914246	7	63	4.5	3.4	3.3
M4.5	× 0.75	TB914266	8	70	6	4.9	3.7
M5	× 0.8	TB914286	8	70	6	4.9	4.2
M6	× 1	TB914316	10	80	6	4.9	5
M7	× 1	TB914346	10	80	7	5.5	6
M8	× 1.25	TB914366	13	90	8	6.2	6.8
M9	× 1.25	TB914396	13	90	9	7	7.8
M10	× 1.5	TB914426	15	100	10	8	8.5
M11	× 1.5	TB914466	17	100	8	6.2	9.5
M12	× 1.75	TB914506	18	110	9	7	10.2
M14	× 2	TB914546	20	110	11	9	12
M16	× 2	TB914606	20	110	12	9	14
M18	× 2.5	TB914656	25	125	14	11	15.5
M20	× 2.5	TB914706	25	140	16	12	17.5
M22	× 2.5	TB914746	25	140	18	14.5	19.5
M24	× 3	TB914786	30	160	18	14.5	21
M27	× 3	TB914866	30	160	20	16	24
M30	× 3.5	TB914946	35	180	22	18	26.5

▶ DIN 371(M2~M10) and DIN 376(M11~M30)

▶ * DIN profile not ISO

Unit : N/mm²

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy < 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
◎	◎					◎	◎	◎						○
Ti Alloy ≤ 1300	Ni ≤ 500	Ni Alloy ≤ 900	Ni Alloy ≤ 1400	Cu ≤ 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe ≤ 1500	Al / Mg ≤ 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
		○												



SPIRAL FLUTE TAPS

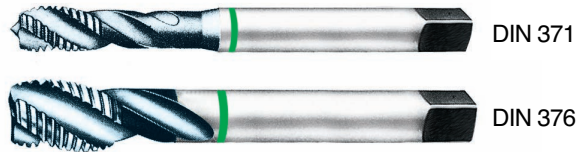
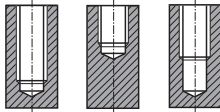
TCH14 SERIES

M ISO metric coarse threads DIN 13 Metrisches ISO-Gewinde DIN 13

- ▶ With recessed threads for machine tapping of deep blind holes.
- ▶ Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

- ▶ Mit abgesetztem Gewinde zum Schneiden von tiefen Sacklochgewinden.
- ▶ Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

Hole type



HSS-E

DIN 371/376

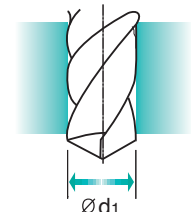
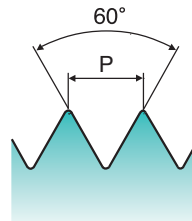
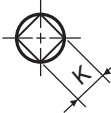
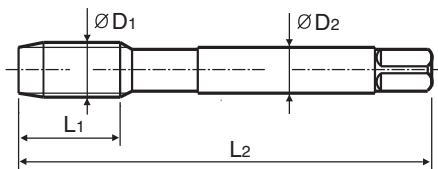
6H



Hardslick



Machine taps
Maschinengewindebohrer



Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping Drill Diameter Ød1
M2	× 0.4	TCH14136	8	45	2.8	2.1	1.6
M2.2	× 0.45	TCH14156	8	45	2.8	2.1	1.75
* M2.3	× 0.4	TCH14196	8	45	2.8	2.1	1.9
M2.5	× 0.45	TCH14176	9	50	2.8	2.1	2.05
* M2.6	× 0.45	TCH14496	9	50	2.8	2.1	2.1
M3	× 0.5	TCH14206	6	56	3.5	2.7	2.5
M3.5	× 0.6	TCH14226	7	56	4	3	2.9
M4	× 0.7	TCH14246	7	63	4.5	3.4	3.3
M4.5	× 0.75	TCH14266	8	70	6	4.9	3.7
M5	× 0.8	TCH14286	8	70	6	4.9	4.2
M6	× 1	TCH14316	10	80	6	4.9	5
M7	× 1	TCH14346	10	80	7	5.5	6
M8	× 1.25	TCH14366	13	90	8	6.2	6.8
M9	× 1.25	TCH14396	13	90	9	7	7.8
M10	× 1.5	TCH14426	15	100	10	8	8.5
M11	× 1.5	TCH14466	17	100	8	6.2	9.5
M12	× 1.75	TCH14506	18	110	9	7	10.2
M14	× 2	TCH14546	20	110	11	9	12
M16	× 2	TCH14606	20	110	12	9	14
M18	× 2.5	TCH14656	25	125	14	11	15.5
M20	× 2.5	TCH14706	25	140	16	12	17.5
M22	× 2.5	TCH14746	25	140	18	14.5	19.5
M24	× 3	TCH14786	30	160	18	14.5	21
M27	× 3	TCH14866	30	160	20	16	24
M30	× 3.5	TCH14946	35	180	22	18	26.5

▶ DIN 371(M2~M10) and DIN 376(M11~M30)

▶ * DIN profile not ISO

Unit : N/mm²

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy < 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
◎	◎					◎	◎	◎						○
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
		○												

HSS

CARBIDE

COMBO TAPS

SPIRAL FLUTE TAPS

SPIRAL POINT TAPS

STRAIGHT FLUTE TAPS

COLD FORMING TAPS

NUT TAPS

STI TAPS

HAND TAPS

PIPE TAPS

CARBIDE TAPS

THREAD MILLS

TECHNICAL DATA



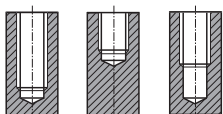
SPIRAL FLUTE TAPS

TB711 SERIES

M ISO metric coarse threads DIN 13 Metrisches ISO-Gewinde DIN 13

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

Hole type


DIN 371



DIN 376



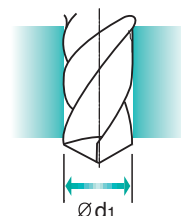
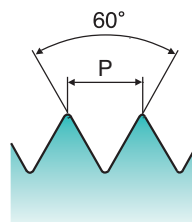
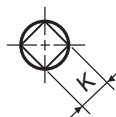
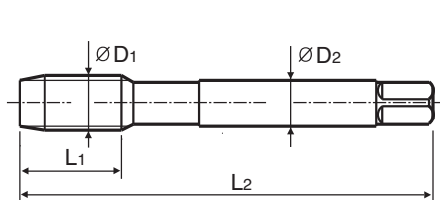
HSS-E

DIN
371/376

6H



Vap


Machine taps
Maschinengewindebohrer


Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping Drill Diameter Ød1
M2	× 0.4	TB711136	8	45	2.8	2.1	1.6
M2.2	× 0.45	TB711156	8	45	2.8	2.1	1.75
* M2.3	× 0.4	TB711196	8	45	2.8	2.1	1.9
M2.5	× 0.45	TB711176	9	50	2.8	2.1	2.05
* M2.6	× 0.45	TB711496	9	50	2.8	2.1	2.1
M3	× 0.5	TB711206	6	56	3.5	2.7	2.5
M3.5	× 0.6	TB711226	7	56	4	3	2.9
M4	× 0.7	TB711246	7	63	4.5	3.4	3.3
M4.5	× 0.75	TB711266	8	70	6	4.9	3.7
M5	× 0.8	TB711286	8	70	6	4.9	4.2
M6	× 1	TB711316	10	80	6	4.9	5
M7	× 1	TB711346	10	80	7	5.5	6
M8	× 1.25	TB711366	13	90	8	6.2	6.8
M9	× 1.25	TB711396	13	90	9	7	7.8
M10	× 1.5	TB711426	15	100	10	8	8.5
M11	× 1.5	TB711466	17	100	8	6.2	9.5
M12	× 1.75	TB711506	18	110	9	7	10.2
M14	× 2	TB711546	20	110	11	9	12
M16	× 2	TB711606	20	110	12	9	14
M18	× 2.5	TB711656	25	125	14	11	15.5
M20	× 2.5	TB711706	25	140	16	12	17.5
M22	× 2.5	TB711746	25	140	18	14.5	19.5
M24	× 3	TB711786	30	160	18	14.5	21
M27	× 3	TB711866	30	160	20	16	24
M30	× 3.5	TB711946	35	180	22	18	26.5

► DIN 371(M2~M10) and DIN 376(M11~M30)

► * DIN profile not ISO

Unit : N/mm²

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy < 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
◎	◎													
Ti Alloy ≤ 1300	Ni ≤ 500	Ni Alloy ≤ 900	Ni Alloy ≤ 1400	Cu ≤ 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe ≤ 1500	Al / Mg ≤ 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
				○				○						

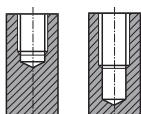
M ISO metric coarse threads DIN 13

Metrisches ISO-Gewinde DIN 13

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

Hole type



Material groups

Ti

HSS-PM

DIN 371/376

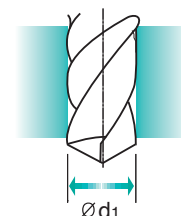
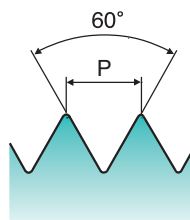
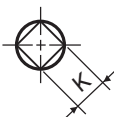
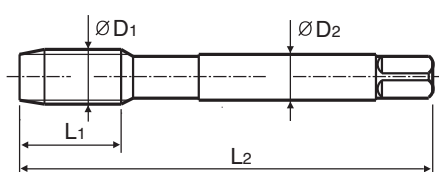
6H



Bright



Machine taps
Maschinengewindebohrer



Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping Drill Diameter Ød1
M2	× 0.4	TM903136	8	45	2.8	2.1	1.6
M2.2	× 0.45	TM903156	8	45	2.8	2.1	1.75
* M2.3	× 0.4	TM903196	8	45	2.8	2.1	1.9
M2.5	× 0.45	TM903176	9	50	2.8	2.1	2.05
* M2.6	× 0.45	TM903496	9	50	2.8	2.1	2.1
M3	× 0.5	TM903206	6	56	3.5	2.7	2.5
M3.5	× 0.6	TM903226	7	56	4	3	2.9
M4	× 0.7	TM903246	7	63	4.5	3.4	3.3
M4.5	× 0.75	TM903266	8	70	6	4.9	3.7
M5	× 0.8	TM903286	8	70	6	4.9	4.2
M6	× 1	TM903316	10	80	6	4.9	5
M7	× 1	TM903346	10	80	7	5.5	6
M8	× 1.25	TM903366	13	90	8	6.2	6.8
M9	× 1.25	TM903396	13	90	9	7	7.8
M10	× 1.5	TM903426	15	100	10	8	8.5
M11	× 1.5	TM903466	17	100	8	6.2	9.5
M12	× 1.75	TM903506	18	110	9	7	10.2
M14	× 2	TM903546	20	110	11	9	12
M16	× 2	TM903606	20	110	12	9	14
M18	× 2.5	TM903656	25	125	14	11	15.5
M20	× 2.5	TM903706	25	140	16	12	17.5
M22	× 2.5	TM903746	25	140	18	14.5	19.5
M24	× 3	TM903786	30	160	18	14.5	21
M27	× 3	TM903866	30	160	20	16	24
M30	× 3.5	TM903946	35	180	22	18	26.5

► DIN 371(M2~M10) and DIN 376(M11~M30)

► * DIN profile not ISO

Unit : N/mm²

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
				○									○	◎
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
◎														



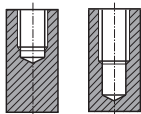
SPIRAL FLUTE TAPS

TZ903 SERIES

M ISO metric coarse threads DIN 13 Metrisches ISO-Gewinde DIN 13

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

Hole type


DIN 371



DIN 376

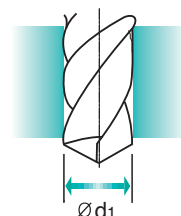
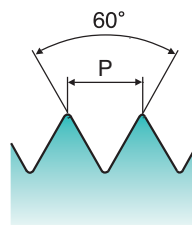
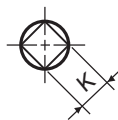
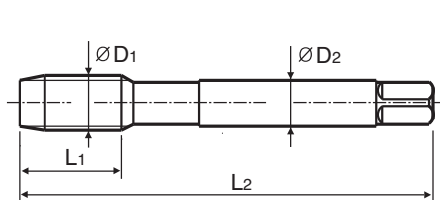
Material groups

Ti

HSS-PM

DIN 371/376

6H


Machine taps
Maschinengewindebohrer


Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping Drill Diameter
ØD1	P		L1	L2	ØD2	K	Ød1
M2	× 0.4	TZ903136	8	45	2.8	2.1	1.6
M2.2	× 0.45	TZ903156	8	45	2.8	2.1	1.75
* M2.3	× 0.4	TZ903196	8	45	2.8	2.1	1.9
M2.5	× 0.45	TZ903176	9	50	2.8	2.1	2.05
* M2.6	× 0.45	TZ903496	9	50	2.8	2.1	2.1
M3	× 0.5	TZ903206	6	56	3.5	2.7	2.5
M3.5	× 0.6	TZ903226	7	56	4	3	2.9
M4	× 0.7	TZ903246	7	63	4.5	3.4	3.3
M4.5	× 0.75	TZ903266	8	70	6	4.9	3.7
M5	× 0.8	TZ903286	8	70	6	4.9	4.2
M6	× 1	TZ903316	10	80	6	4.9	5
M7	× 1	TZ903346	10	80	7	5.5	6
M8	× 1.25	TZ903366	13	90	8	6.2	6.8
M9	× 1.25	TZ903396	13	90	9	7	7.8
M10	× 1.5	TZ903426	15	100	10	8	8.5
M11	× 1.5	TZ903466	17	100	8	6.2	9.5
M12	× 1.75	TZ903506	18	110	9	7	10.2
M14	× 2	TZ903546	20	110	11	9	12
M16	× 2	TZ903606	20	110	12	9	14
M18	× 2.5	TZ903656	25	125	14	11	15.5
M20	× 2.5	TZ903706	25	140	16	12	17.5
M22	× 2.5	TZ903746	25	140	18	14.5	19.5
M24	× 3	TZ903786	30	160	18	14.5	21
M27	× 3	TZ903866	30	160	20	16	24
M30	× 3.5	TZ903946	35	180	22	18	26.5

► DIN 371(M2~M10) and DIN 376(M11~M30)

► * DIN profile not ISO

Unit : N/mm²

◎ : Excellent ○ : Good

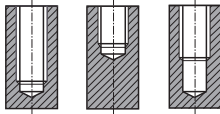
Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
				○									○	◎
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
◎														

M

ISO metric coarse threads DIN 13
Metrisches ISO-Gewinde DIN 13

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

Hole type

DIN 371



DIN 376

Material groups

**Ti
Ni**

HSS-PM

DIN
371/376

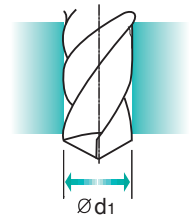
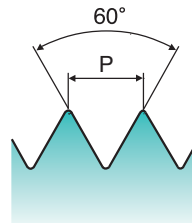
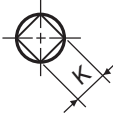
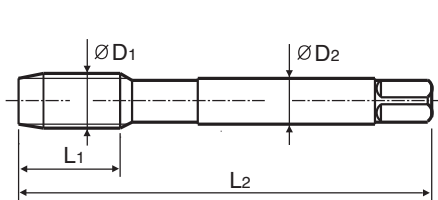
6H

60°

C

Vap

R40

Machine taps
Maschinengewindebohrer

Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping Drill Diameter Ød1
M2	× 0.4	TQ833136	8	45	2.8	2.1	1.6
M2.2	× 0.45	TQ833156	8	45	2.8	2.1	1.75
M2.5	× 0.45	TQ833176	9	50	2.8	2.1	2.05
M3	× 0.5	TQ833206	6	56	3.5	2.7	2.5
M3.5	× 0.6	TQ833226	7	56	4	3	2.9
M4	× 0.7	TQ833246	7	63	4.5	3.4	3.3
M4.5	× 0.75	TQ833266	8	70	6	4.9	3.7
M5	× 0.8	TQ833286	8	70	6	4.9	4.2
M6	× 1	TQ833316	10	80	6	4.9	5
M7	× 1	TQ833346	10	80	7	5.5	6
M8	× 1.25	TQ833366	13	90	8	6.2	6.8
M10	× 1.5	TQ833426	15	100	10	8	8.5
M12	× 1.75	TQ833506	18	110	9	7	10.2

► DIN 371(M2~M10) and DIN 376(M12)

Unit : N/mm²

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy < 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
				◎	◎								○	◎
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
◎		◎	◎				○							



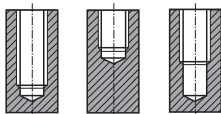
SPIRAL FLUTE TAPS

TR833 SERIES

M ISO metric coarse threads DIN 13 Metrisches ISO-Gewinde DIN 13

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

Hole type


DIN 371



DIN 376

Material groups

**Ti
Ni**

HSS-PM

DIN
371/376

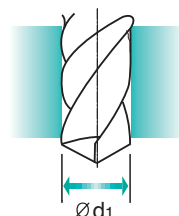
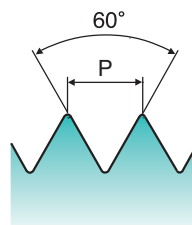
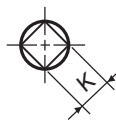
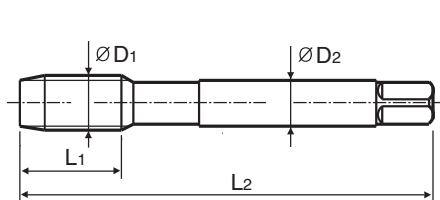
6H

60°

C

Bright

R40

Machine taps
Maschinengewindebohrer


Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping Drill Diameter
ØD1	P		L1	L2	ØD2	K	Ød1
M2	× 0.4	TR833136	8	45	2.8	2.1	1.6
M2.2	× 0.45	TR833156	8	45	2.8	2.1	1.75
M2.5	× 0.45	TR833176	9	50	2.8	2.1	2.05
M3	× 0.5	TR833206	6	56	3.5	2.7	2.5
M3.5	× 0.6	TR833226	7	56	4	3	2.9
M4	× 0.7	TR833246	7	63	4.5	3.4	3.3
M4.5	× 0.75	TR833266	8	70	6	4.9	3.7
M5	× 0.8	TR833286	8	70	6	4.9	4.2
M6	× 1	TR833316	10	80	6	4.9	5
M7	× 1	TR833346	10	80	7	5.5	6
M8	× 1.25	TR833366	13	90	8	6.2	6.8
M10	× 1.5	TR833426	15	100	10	8	8.5
M12	× 1.75	TR833506	18	110	9	7	10.2

► DIN 371(M2~M10) and DIN 376(M12)

Unit : N/mm²

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
				◎	◎								○	◎
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
◎		◎	◎				○							

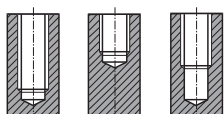
M ISO metric coarse threads DIN 13

Metrisches ISO-Gewinde DIN 13

► For tapping Nickel alloys and heat resistant alloy steels which are used in aerospace and chemical industries.

► Zum Gewindeschneiden von Nickellegierungen und hitzefesten Legierungsstählen, die in der Luftfahrtindustrie und chemischen Industrie verwendet werden.

Hole type



Material groups

Ni

HSS-PM

DIN 371/376

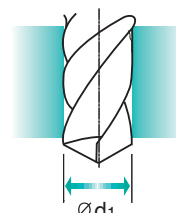
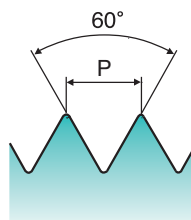
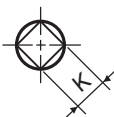
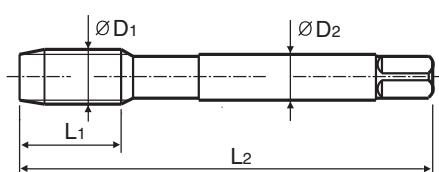
6H



Bright



Machine taps
Maschinengewindebohrer



Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping Drill Diameter
ØD1	P		L1	L2	ØD2	K	Ød1
M2	× 0.4	TM933136	8	45	2.8	2.1	1.6
M2.2	× 0.45	TM933156	8	45	2.8	2.1	1.75
* M2.3	× 0.4	TM933196	8	45	2.8	2.1	1.9
M2.5	× 0.45	TM933176	9	50	2.8	2.1	2.05
* M2.6	× 0.45	TM933496	9	50	2.8	2.1	2.1
M3	× 0.5	TM933206	6	56	3.5	2.7	2.5
M3.5	× 0.6	TM933226	7	56	4	3	2.9
M4	× 0.7	TM933246	7	63	4.5	3.4	3.3
M4.5	× 0.75	TM933266	8	70	6	4.9	3.7
M5	× 0.8	TM933286	8	70	6	4.9	4.2
M6	× 1	TM933316	10	80	6	4.9	5
M7	× 1	TM933346	10	80	7	5.5	6
M8	× 1.25	TM933366	13	90	8	6.2	6.8
M9	× 1.25	TM933396	13	90	9	7	7.8
M10	× 1.5	TM933426	15	100	10	8	8.5
M11	× 1.5	TM933466	17	100	8	6.2	9.5
M12	× 1.75	TM933506	18	110	9	7	10.2
M14	× 2	TM933546	20	110	11	9	12
M16	× 2	TM933606	20	110	12	9	14
M18	× 2.5	TM933656	25	125	14	11	15.5
M20	× 2.5	TM933706	25	140	16	12	17.5
M22	× 2.5	TM933746	25	140	18	14.5	19.5
M24	× 3	TM933786	30	160	18	14.5	21
M27	× 3	TM933866	30	160	20	16	24
M30	× 3.5	TM933946	35	180	22	18	26.5

► DIN 371(M2~M10) and DIN 376(M11~M30)

► * DIN profile not ISO

Unit : N/mm²

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
				◎	◎									
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
○		◎	◎				○							



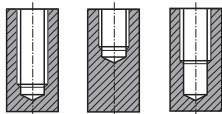
SPIRAL FLUTE TAPS

TZ933 SERIES

M ISO metric coarse threads DIN 13 Metrisches ISO-Gewinde DIN 13

► For tapping Nickel alloys and heat resistant alloy steels which are used in aerospace and chemical industries.

► Zum Gewindeschneiden von Nickellegierungen und hitzefesten Legierungsstählen, die in der Luftfahrtindustrie und chemischen Industrie verwendet werden.

Hole type


DIN 371



DIN 376

Material groups

Ni

HSS-PM

DIN 371/376

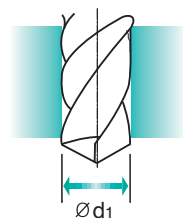
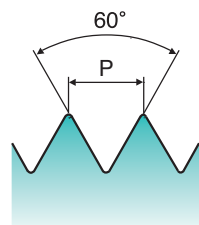
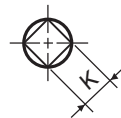
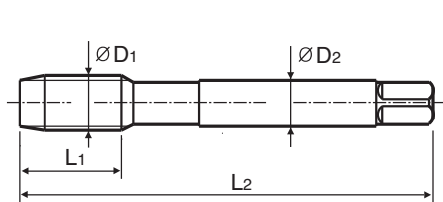
6H

60°

C

TiAlN

R40

Machine taps
Maschinengewindebohrer


Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping Drill Diameter
ØD1	P		L1	L2	ØD2	K	Ød1
M2	× 0.4	TZ933136	8	45	2.8	2.1	1.6
M2.2	× 0.45	TZ933156	8	45	2.8	2.1	1.75
* M2.3	× 0.4	TZ933196	8	45	2.8	2.1	1.9
M2.5	× 0.45	TZ933176	9	50	2.8	2.1	2.05
* M2.6	× 0.45	TZ933496	9	50	2.8	2.1	2.1
M3	× 0.5	TZ933206	6	56	3.5	2.7	2.5
M3.5	× 0.6	TZ933226	7	56	4	3	2.9
M4	× 0.7	TZ933246	7	63	4.5	3.4	3.3
M4.5	× 0.75	TZ933266	8	70	6	4.9	3.7
M5	× 0.8	TZ933286	8	70	6	4.9	4.2
M6	× 1	TZ933316	10	80	6	4.9	5
M7	× 1	TZ933346	10	80	7	5.5	6
M8	× 1.25	TZ933366	13	90	8	6.2	6.8
M9	× 1.25	TZ933396	13	90	9	7	7.8
M10	× 1.5	TZ933426	15	100	10	8	8.5
M11	× 1.5	TZ933466	17	100	8	6.2	9.5
M12	× 1.75	TZ933506	18	110	9	7	10.2
M14	× 2	TZ933546	20	110	11	9	12
M16	× 2	TZ933606	20	110	12	9	14
M18	× 2.5	TZ933656	25	125	14	11	15.5
M20	× 2.5	TZ933706	25	140	16	12	17.5
M22	× 2.5	TZ933746	25	140	18	14.5	19.5
M24	× 3	TZ933786	30	160	18	14.5	21
M27	× 3	TZ933866	30	160	20	16	24
M30	× 3.5	TZ933946	35	180	22	18	26.5

► DIN 371(M2~M10) and DIN 376(M11~M30)

► * DIN profile not ISO

Unit : N/mm²

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
				◎	◎									
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
○		◎	◎				○							

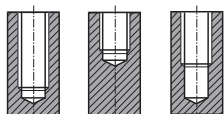
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ISO metric coarse threads DIN 13
Metrisches ISO-Gewinde DIN 13

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

Hole type



Material groups

AI

HSS-E

DIN 371/376

6H

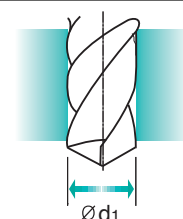
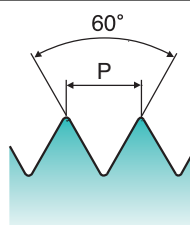
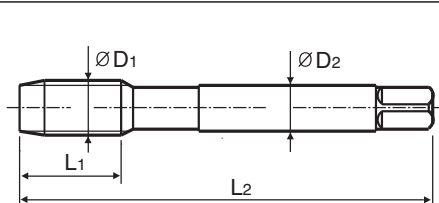
60°

C

Bright

R45

Machine taps
Maschinengewindebohrer



Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping Drill Diameter Ød1
M2	× 0.4	TC163136	8	45	2.8	2.1	1.6
M2.2	× 0.45	TC163156	8	45	2.8	2.1	1.75
* M2.3	× 0.4	TC163196	8	45	2.8	2.1	1.9
M2.5	× 0.45	TC163176	9	50	2.8	2.1	2.05
* M2.6	× 0.45	TC163496	9	50	2.8	2.1	2.1
M3	× 0.5	TC163206	6	56	3.5	2.7	2.5
M3.5	× 0.6	TC163226	7	56	4	3	2.9
M4	× 0.7	TC163246	7	63	4.5	3.4	3.3
M4.5	× 0.75	TC163266	8	70	6	4.9	3.7
M5	× 0.8	TC163286	8	70	6	4.9	4.2
M6	× 1	TC163316	10	80	6	4.9	5
M7	× 1	TC163346	10	80	7	5.5	6
M8	× 1.25	TC163366	13	90	8	6.2	6.8
M9	× 1.25	TC163396	13	90	9	7	7.8
M10	× 1.5	TC163426	15	100	10	8	8.5
M11	× 1.5	TC163466	17	100	8	6.2	9.5
M12	× 1.75	TC163506	18	110	9	7	10.2
M14	× 2	TC163546	20	110	11	9	12
M16	× 2	TC163606	20	110	12	9	14
M18	× 2.5	TC163656	25	125	14	11	15.5
M20	× 2.5	TC163706	25	140	16	12	17.5
M22	× 2.5	TC163746	25	140	18	14.5	19.5
M24	× 3	TC163786	30	160	18	14.5	21
M27	× 3	TC163866	30	160	20	16	24
M30	× 3.5	TC163946	35	180	22	18	26.5

► DIN 371(M2~M10) and DIN 376(M11~M30)

► * DIN profile not ISO

Unit : N/mm²

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy < 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
○	○	○											○	
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
				◎				◎	◎	◎				



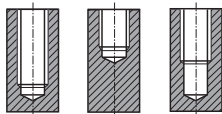
SPIRAL FLUTE TAPS

TE953 SERIES

M ISO metric coarse threads DIN 13 Metrisches ISO-Gewinde DIN 13

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

Hole type


DIN 371



DIN 376

Material groups

AI

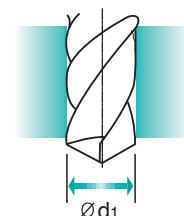
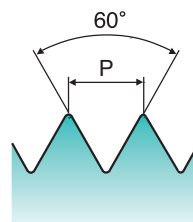
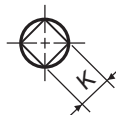
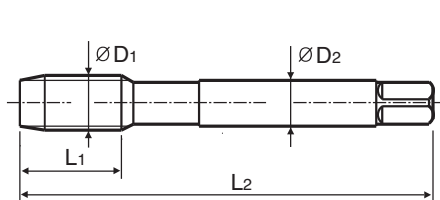
HSS-E

DIN 371/376

6H



NI


Machine taps
Maschinengewindebohrer


Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping Drill Diameter
ØD1	P		L1	L2	ØD2	K	Ød1
M2	× 0.4	TE953136	8	45	2.8	2.1	1.6
M2.2	× 0.45	TE953156	8	45	2.8	2.1	1.75
* M2.3	× 0.4	TE953196	8	45	2.8	2.1	1.9
M2.5	× 0.45	TE953176	9	50	2.8	2.1	2.05
* M2.6	× 0.45	TE953496	9	50	2.8	2.1	2.1
M3	× 0.5	TE953206	6	56	3.5	2.7	2.5
M3.5	× 0.6	TE953226	7	56	4	3	2.9
M4	× 0.7	TE953246	7	63	4.5	3.4	3.3
M4.5	× 0.75	TE953266	8	70	6	4.9	3.7
M5	× 0.8	TE953286	8	70	6	4.9	4.2
M6	× 1	TE953316	10	80	6	4.9	5
M7	× 1	TE953346	10	80	7	5.5	6
M8	× 1.25	TE953366	13	90	8	6.2	6.8
M9	× 1.25	TE953396	13	90	9	7	7.8
M10	× 1.5	TE953426	15	100	10	8	8.5
M11	× 1.5	TE953466	17	100	8	6.2	9.5
M12	× 1.75	TE953506	18	110	9	7	10.2
M14	× 2	TE953546	20	110	11	9	12
M16	× 2	TE953606	20	110	12	9	14
M18	× 2.5	TE953656	25	125	14	11	15.5
M20	× 2.5	TE953706	25	140	16	12	17.5
M22	× 2.5	TE953746	25	140	18	14.5	19.5
M24	× 3	TE953786	30	160	18	14.5	21
M27	× 3	TE953866	30	160	20	16	24
M30	× 3.5	TE953946	35	180	22	18	26.5

► DIN 371(M2~M10) and DIN 376(M11~M30)

► * DIN profile not ISO

Unit : N/mm²

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
											◎			

MF

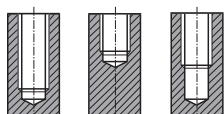
ISO metric fine threads DIN 13

Metrisches ISO-Feingewinde DIN 13

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

Hole type



DIN 374

Material groups
GS

HSS-E

DIN
374

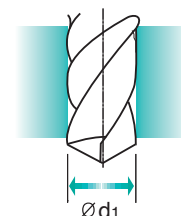
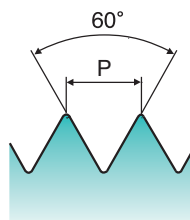
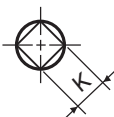
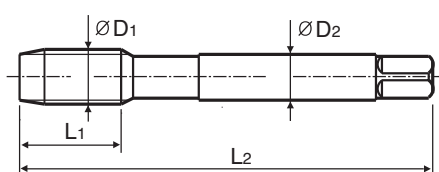
6H



Bright



Machine taps
Maschinengewindebohrer



Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping Drill Diameter Ød1
M4	× 0.5	TC411256	5	63	2.8	2.1	3.5
M5	× 0.5	TC411296	5	70	3.5	2.7	4.5
M6	× 0.75	TC411326	8	80	4.5	3.4	5.2
M6	× 0.5	TC411336	5	80	4.5	3.4	5.5
M7	× 0.75	TC411356	10	80	5.5	4.3	6.2
M8	× 1	TC411376	10	90	6	4.9	7
M8	× 0.75	TC411386	8	80	6	4.9	7.2
M8	× 0.5	TC411936	5	80	6	4.9	7.5
M10	× 1.25	TC411436	16	100	7	5.5	8.8
M10	× 1	TC411446	10	90	7	5.5	9
M10	× 0.75	TC411456	10	90	7	5.5	9.2
M12	× 1.5	TC411516	15	100	9	7	10.5
M12	× 1.25	TC411526	15	100	9	7	10.8
M12	× 1	TC411536	11	100	9	7	11
M14	× 1.5	TC411556	15	100	11	9	12.5
M14	× 1.25	TC411566	15	100	11	9	12.8
M14	× 1	TC411576	11	100	11	9	13

Unit : N/mm²

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy < 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
◎	◎	◎									◎	◎	○	
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
	○			○		◎		○	○	○	◎	○		



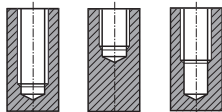
SPIRAL FLUTE TAPS

TC411 SERIES

MF
ISO metric fine threads DIN 13
Metrisches ISO-Feingewinde DIN 13

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

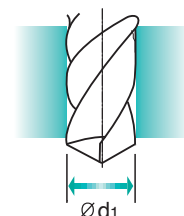
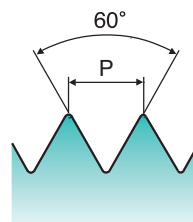
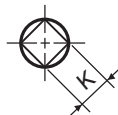
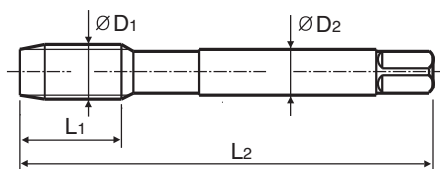
► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

Hole type


DIN 374


HSS-E
**DIN
374**
6H

Bright

Machine taps
Maschinengewindebohrer


Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping Drill Diameter
ØD1	P		L1	L2	ØD2	K	Ød1
M16	× 1.5	TC411616	15	100	12	9	14.5
M16	× 1	TC411626	12	100	12	9	15
M18	× 1.5	TC411676	17	110	14	11	16.5
M18	× 1	TC411686	13	110	14	11	17
M20	× 1.5	TC411726	17	125	16	12	18.5
M20	× 1	TC411736	14	125	16	12	19
M22	× 1.5	TC411766	17	125	18	14.5	20.5
M22	× 1	TC411776	14	125	18	14.5	21
M24	× 2	TC411796	20	140	18	14.5	22
M24	× 1.5	TC411806	20	140	18	14.5	22.5
M26	× 1.5	TC411856	20	140	18	14.5	24.5
M27	× 2	TC411876	20	140	20	16	25
M27	× 1.5	TC411886	20	140	20	16	25.5
M28	× 1.5	TC411916	20	140	20	16	26.5
M30	× 2	TC411966	22	150	22	18	28
M30	× 1.5	TC411976	22	150	22	18	28.5

Unit : N/mm²

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
◎	◎	◎	◎								◎	◎	○	
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
○				○		◎		○	○	○	◎	○		

MF

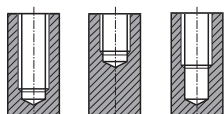
ISO metric fine threads DIN 13

Metrisches ISO-Feingewinde DIN 13

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

Hole type



DIN 374

Material groups
GS

HSS-E

DIN
374

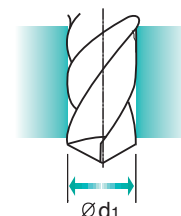
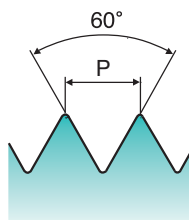
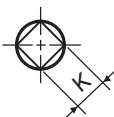
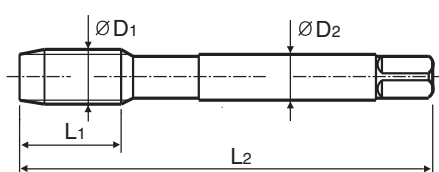
6H



TiN



Machine taps
Maschinengewindebohrer



Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping Drill Diameter Ød1
M4	× 0.5	TD411256	5	63	2.8	2.1	3.5
M5	× 0.5	TD411296	5	70	3.5	2.7	4.5
M6	× 0.75	TD411326	8	80	4.5	3.4	5.2
M6	× 0.5	TD411336	5	80	4.5	3.4	5.5
M7	× 0.75	TD411356	10	80	5.5	4.3	6.2
M8	× 1	TD411376	10	90	6	4.9	7
M8	× 0.75	TD411386	8	80	6	4.9	7.2
M8	× 0.5	TD411936	5	80	6	4.9	7.5
M10	× 1.25	TD411436	16	100	7	5.5	8.8
M10	× 1	TD411446	10	90	7	5.5	9
M10	× 0.75	TD411456	10	90	7	5.5	9.2
M12	× 1.5	TD411516	15	100	9	7	10.5
M12	× 1.25	TD411526	15	100	9	7	10.8
M12	× 1	TD411536	11	100	9	7	11
M14	× 1.5	TD411556	15	100	11	9	12.5
M14	× 1.25	TD411566	15	100	11	9	12.8
M14	× 1	TD411576	11	100	11	9	13

Unit : N/mm²

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy < 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
◎	◎	◎									◎	◎	○	
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
	○			○		◎		○	○	○	◎	○		



SPIRAL FLUTE TAPS

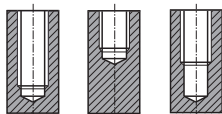
TD411 SERIES

MF

ISO metric fine threads DIN 13 Metrisches ISO-Feingewinde DIN 13

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

Hole type


DIN 374



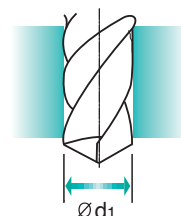
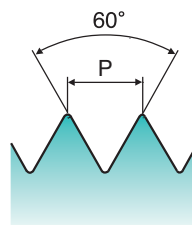
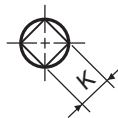
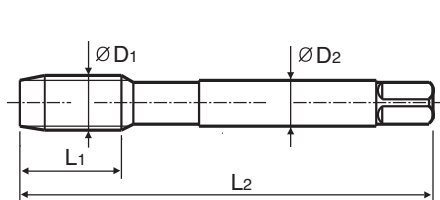
HSS-E

DIN
374

6H



TiN


Machine taps
Maschinengewindebohrer


Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping Drill Diameter
ØD1	P		L1	L2	ØD2	K	Ød1
M16	× 1.5	TD411616	15	100	12	9	14.5
M16	× 1	TD411626	12	100	12	9	15
M18	× 1.5	TD411676	17	110	14	11	16.5
M18	× 1	TD411686	13	110	14	11	17
M20	× 1.5	TD411726	17	125	16	12	18.5
M20	× 1	TD411736	14	125	16	12	19
M22	× 1.5	TD411766	17	125	18	14.5	20.5
M22	× 1	TD411776	14	125	18	14.5	21
M24	× 2	TD411796	20	140	18	14.5	22
M24	× 1.5	TD411806	20	140	18	14.5	22.5
M26	× 1.5	TD411856	20	140	18	14.5	24.5
M27	× 2	TD411876	20	140	20	16	25
M27	× 1.5	TD411886	20	140	20	16	25.5
M28	× 1.5	TD411916	20	140	20	16	26.5
M30	× 2	TD411966	22	150	22	18	28
M30	× 1.5	TD411976	22	150	22	18	28.5

Unit : N/mm²

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
◎	◎	◎									◎	◎	○	
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
○				○		◎		○	○	○	◎	○		

MF

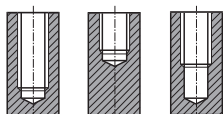
ISO metric fine threads DIN 13

Metrisches ISO-Feingewinde DIN 13

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

Hole type



DIN 374

Material groups
VG

HSS-E

DIN
374

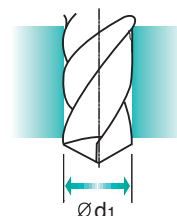
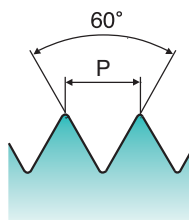
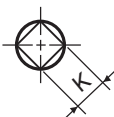
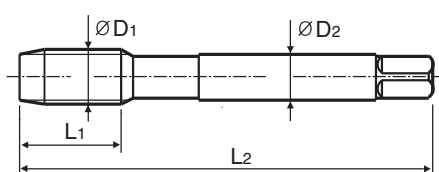
6H



Bright



Machine taps
Maschinengewindebohrer



Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping Drill Diameter Ød1
M4	× 0.5	TC413256	5	63	2.8	2.1	3.5
M5	× 0.5	TC413296	5	70	3.5	2.7	4.5
M6	× 0.75	TC413326	8	80	4.5	3.4	5.2
M6	× 0.5	TC413336	5	80	4.5	3.4	5.5
M7	× 0.75	TC413356	10	80	5.5	4.3	6.2
M8	× 1	TC413376	10	90	6	4.9	7
M8	× 0.75	TC413386	8	80	6	4.9	7.2
M10	× 1.25	TC413436	16	100	7	5.5	8.8
M10	× 1	TC413446	10	90	7	5.5	9
M10	× 0.75	TC413456	10	90	7	5.5	9.2
M12	× 1.5	TC413516	15	100	9	7	10.5
M12	× 1.25	TC413526	15	100	9	7	10.8
M12	× 1	TC413536	11	100	9	7	11
M14	× 1.5	TC413556	15	100	11	9	12.5
M14	× 1.25	TC413566	15	100	11	9	12.8
M16	× 1.5	TC413616	15	100	12	9	14.5
M18	× 1.5	TC413676	17	110	14	11	16.5
M20	× 1.5	TC413726	17	125	16	12	18.5
M22	× 1.5	TC413766	17	125	18	14.5	20.5
M24	× 1.5	TC413806	20	140	18	14.5	22.5

Unit : N/mm²

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy < 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
			○	◎				○						○
Ti Alloy < 1300	Ni < 500	Ni Alloy < 900	Ni Alloy < 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si < 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
		○												



SPIRAL FLUTE TAPS

TD413 SERIES

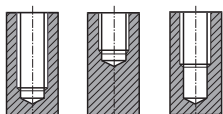
MF

ISO metric fine threads DIN 13

Metrisches ISO-Feingewinde DIN 13

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

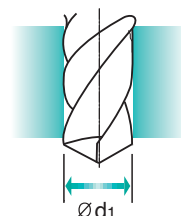
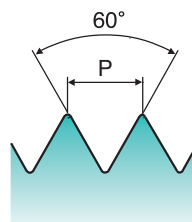
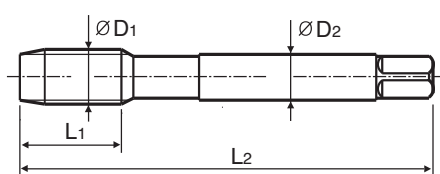
► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

Hole type


DIN 374


HSS-E
DIN 374
6H

TiN

Machine taps
Maschinengewindebohrer


Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping Drill Diameter
ØD1	P		L1	L2	ØD2	K	Ød1
M4	× 0.5	TD413256	5	63	2.8	2.1	3.5
M5	× 0.5	TD413296	5	70	3.5	2.7	4.5
M6	× 0.75	TD413326	8	80	4.5	3.4	5.2
M6	× 0.5	TD413336	5	80	4.5	3.4	5.5
M7	× 0.75	TD413356	10	80	5.5	4.3	6.2
M8	× 1	TD413376	10	90	6	4.9	7
M8	× 0.75	TD413386	8	80	6	4.9	7.2
M10	× 1.25	TD413436	16	100	7	5.5	8.8
M10	× 1	TD413446	10	90	7	5.5	9
M10	× 0.75	TD413456	10	90	7	5.5	9.2
M12	× 1.5	TD413516	15	100	9	7	10.5
M12	× 1.25	TD413526	15	100	9	7	10.8
M12	× 1	TD413536	11	100	9	7	11
M14	× 1.5	TD413556	15	100	11	9	12.5
M14	× 1.25	TD413566	15	100	11	9	12.8
M16	× 1.5	TD413616	15	100	12	9	14.5
M18	× 1.5	TD413676	17	110	14	11	16.5
M20	× 1.5	TD413726	17	125	16	12	18.5
M22	× 1.5	TD413766	17	125	18	14.5	20.5
M24	× 1.5	TD413806	20	140	18	14.5	22.5

Unit : N/mm²

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
			○	◎				○						○
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
		○												

MF

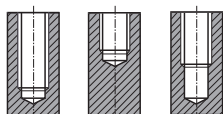
ISO metric fine threads DIN 13

Metrisches ISO-Feingewinde DIN 13

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

Hole type



DIN 374

Material groups
VANW

HSS-E

DIN
374

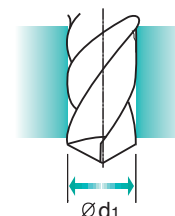
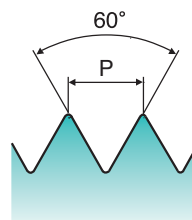
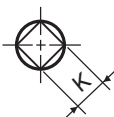
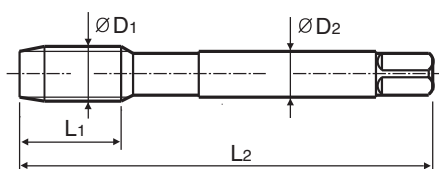
6H



Vap



Machine taps
Maschinengewindebohrer



Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping Drill Diameter Ød1
M4	× 0.5	TB183256	5	63	2.8	2.1	3.5
M5	× 0.5	TB183296	5	70	3.5	2.7	4.5
M6	× 0.75	TB183326	8	80	4.5	3.4	5.2
M6	× 0.5	TB183336	5	80	4.5	3.4	5.5
M7	× 0.75	TB183356	10	80	5.5	4.3	6.2
M8	× 1	TB183376	10	90	6	4.9	7
M8	× 0.75	TB183386	8	80	6	4.9	7.2
M10	× 1.25	TB183436	16	100	7	5.5	8.8
M10	× 1	TB183446	10	90	7	5.5	9
M10	× 0.75	TB183456	10	90	7	5.5	9.2
M12	× 1.5	TB183516	15	100	9	7	10.5
M12	× 1.25	TB183526	15	100	9	7	10.8
M12	× 1	TB183536	11	100	9	7	11
M14	× 1.5	TB183556	15	100	11	9	12.5
M14	× 1.25	TB183566	15	100	11	9	12.8
M16	× 1.5	TB183616	15	100	12	9	14.5
M18	× 1.5	TB183676	17	110	14	11	16.5
M20	× 1.5	TB183726	17	125	16	12	18.5
M22	× 1.5	TB183766	17	125	18	14.5	20.5
M24	× 1.5	TB183806	20	140	18	14.5	22.5

Unit : N/mm²

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy < 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
◎	◎					◎	◎	◎						○
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
		○												



SPIRAL FLUTE TAPS

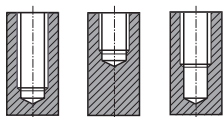
TC963 SERIES

MF

ISO metric fine threads DIN 13 Metrisches ISO-Feingewinde DIN 13

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

Hole type


DIN 374

Material groups

AI

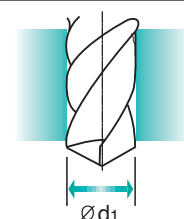
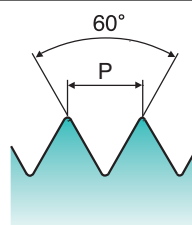
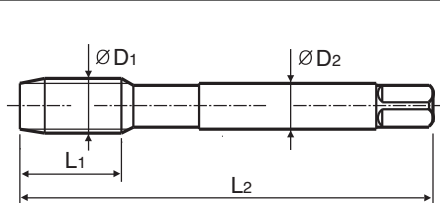
HSS-E

DIN
374

6H



Bright


Machine taps
Maschinengewindebohrer


Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping Drill Diameter
ØD1	P		L1	L2	ØD2	K	Ød1
M4	× 0.5	TC963256	5	63	2.8	2.1	3.5
M5	× 0.5	TC963296	5	70	3.5	2.7	4.5
M6	× 0.75	TC963326	8	80	4.5	3.4	5.2
M6	× 0.5	TC963336	5	80	4.5	3.4	5.5
M7	× 0.75	TC963356	10	80	5.5	4.3	6.2
M8	× 1	TC963376	10	90	6	4.9	7
M8	× 0.75	TC963386	8	80	6	4.9	7.2
M10	× 1.25	TC963436	16	100	7	5.5	8.8
M10	× 1	TC963446	10	90	7	5.5	9
M10	× 0.75	TC963456	10	90	7	5.5	9.2
M12	× 1.5	TC963516	15	100	9	7	10.5
M12	× 1.25	TC963526	15	100	9	7	10.8
M12	× 1	TC963536	11	100	9	7	11
M14	× 1.5	TC963556	15	100	11	9	12.5
M14	× 1.25	TC963566	15	100	11	9	12.8
M16	× 1.5	TC963616	15	100	12	9	14.5
M18	× 1.5	TC963676	17	110	14	11	16.5
M20	× 1.5	TC963726	17	125	16	12	18.5
M22	× 1.5	TC963766	17	125	18	14.5	20.5
M24	× 1.5	TC963806	20	140	18	14.5	22.5

Unit : N/mm²

◎ : Excellent ○ : Good

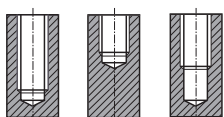
Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
○	○	○											○	
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
				◎				◎	◎	◎				

UNC

Unified coarse threads
Unified Grobgewinde

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

Hole type


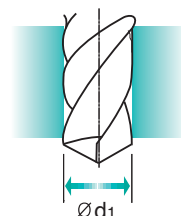
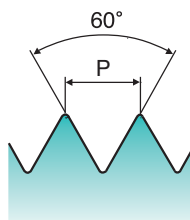
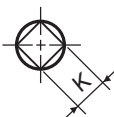
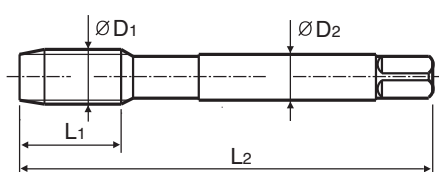
HSS-E

DIN
371/376

2B



Bright


Machine taps
Maschinengewindebohrer


Unit : mm

SIZE ØD1	TPI	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping Drill Diameter Ød1
#4	– 40 UNC	TC144162	6	56	3.5	2.7	2.3
#5	– 40 UNC	TC144202	7	56	3.5	2.7	2.6
#6	– 32 UNC	TC144242	7	56	4	3	2.85
#8	– 32 UNC	TC144282	8	63	4.5	3.4	3.5
#10	– 24 UNC	TC144322	10	70	6	4.9	3.9
#12	– 24 UNC	TC144362	10	80	6	4.9	4.5
1/4"	– 20 UNC	TC144402	13	80	7	5.5	5.2
5/16"	– 18 UNC	TC144442	14	90	8	6.2	6.6
3/8"	– 16 UNC	TC144482	16	100	9	7	8
7/16"	– 14 UNC	TC144522	17	100	8	6.2	9.4
1/2"	– 13 UNC	TC144562	20	110	9	7	10.75
9/16"	– 12 UNC	TC144602	20	110	11	9	12.25
5/8"	– 11 UNC	TC144642	22	110	12	9	13.5
3/4"	– 10 UNC	TC144702	25	125	14	11	16.5
7/8"	– 9 UNC	TC144742	27	140	18	14.5	19.5
1"	– 8 UNC	TC144782	30	160	20	16	22.25
1 1/8"	– 7 UNC	TC144822	35	180	22	18	25

► DIN 371(#4~3/8") and DIN 376(7/16"~1 1/8")

Unit : N/mm²

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy < 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
◎	◎	◎									◎	◎	○	
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
	○			○		◎		○	○	○	◎	○		



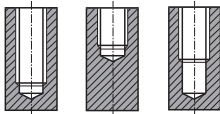
SPIRAL FLUTE TAPS

TC174 SERIES

UNC Unified coarse threads Unified Grobgewinde

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

Hole type


DIN 371



DIN 376



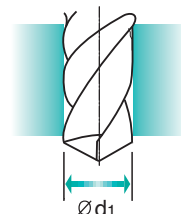
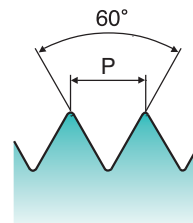
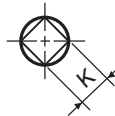
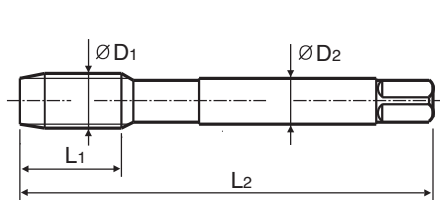
HSS-E

DIN
371/376

2B



Bright


Machine taps
Maschinengewindebohrer


Unit : mm

SIZE ØD1	TPI	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping Drill Diameter Ød1
#4	40 UNC	TC174162	6	56	3.5	2.7	2.3
#5	40 UNC	TC174202	7	56	3.5	2.7	2.6
#6	32 UNC	TC174242	7	56	4	3	2.85
#8	32 UNC	TC174282	8	63	4.5	3.4	3.5
#10	24 UNC	TC174322	10	70	6	4.9	3.9
#12	24 UNC	TC174362	10	80	6	4.9	4.5
1/4"	20 UNC	TC174402	13	80	7	5.5	5.2
5/16"	18 UNC	TC174442	14	90	8	6.2	6.6
3/8"	16 UNC	TC174482	16	100	9	7	8
7/16"	14 UNC	TC174522	17	100	8	6.2	9.4
1/2"	13 UNC	TC174562	20	110	9	7	10.75
9/16"	12 UNC	TC174602	20	110	11	9	12.25
5/8"	11 UNC	TC174642	22	110	12	9	13.5
3/4"	10 UNC	TC174702	25	125	14	11	16.5
7/8"	9 UNC	TC174742	27	140	18	14.5	19.5
1"	8 UNC	TC174782	30	160	20	16	22.25
1 1/8"	7 UNC	TC174822	35	180	22	18	25

► DIN 371(#4~3/8") and DIN 376(7/16"~1 1/8")

Unit : N/mm²

◎ : Excellent ○ : Good

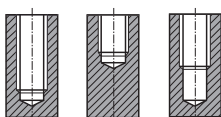
Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
			○	◎				○						○
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
		○												

UNC

Unified coarse threads
Unified Grobgewinde

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

Hole type


DIN 371



DIN 376



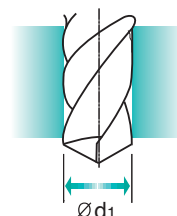
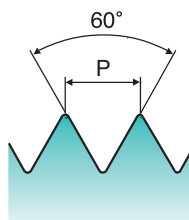
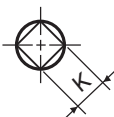
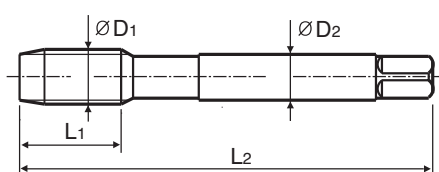
HSS-E

DIN
371/376

2B



TiN


Machine taps
Maschinengewindebohrer


Unit : mm

SIZE Ø D ₁	TPI	EDP No.	Thread Length L ₁	Overall Length L ₂	Shank Diameter Ø D ₂	Square Size K	Tapping Drill Diameter Ø d ₁
#4	– 40 UNC	TD174162	6	56	3.5	2.7	2.3
#5	– 40 UNC	TD174202	7	56	3.5	2.7	2.6
#6	– 32 UNC	TD174242	7	56	4	3	2.85
#8	– 32 UNC	TD174282	8	63	4.5	3.4	3.5
#10	– 24 UNC	TD174322	10	70	6	4.9	3.9
#12	– 24 UNC	TD174362	10	80	6	4.9	4.5
1/4"	– 20 UNC	TD174402	13	80	7	5.5	5.2
5/16"	– 18 UNC	TD174442	14	90	8	6.2	6.6
3/8"	– 16 UNC	TD174482	16	100	9	7	8
7/16"	– 14 UNC	TD174522	17	100	8	6.2	9.4
1/2"	– 13 UNC	TD174562	20	110	9	7	10.75
9/16"	– 12 UNC	TD174602	20	110	11	9	12.25
5/8"	– 11 UNC	TD174642	22	110	12	9	13.5
3/4"	– 10 UNC	TD174702	25	125	14	11	16.5
7/8"	– 9 UNC	TD174742	27	140	18	14.5	19.5
1"	– 8 UNC	TD174782	30	160	20	16	22.25
1 1/8"	– 7 UNC	TD174822	35	180	22	18	25

► DIN 371(#4~3/8") and DIN 376(7/16"~1 1/8")

Unit : N/mm²

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy < 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
			○	◎				○						○
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
		○												



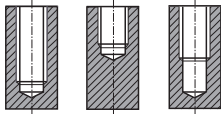
SPIRAL FLUTE TAPS

TB904 SERIES

UNC Unified coarse threads Unified Grobgewinde

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

Hole type


DIN 371



DIN 376



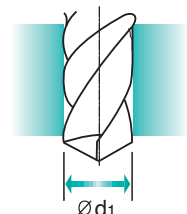
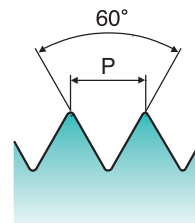
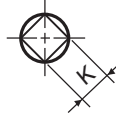
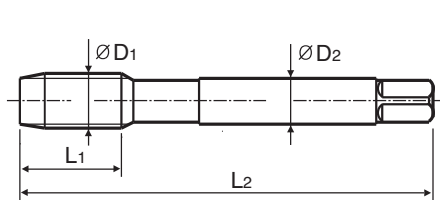
HSS-E

DIN
371/376

2B



Vap


Machine taps
Maschinengewindebohrer


Unit : mm

SIZE ØD1	TPI	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping Drill Diameter Ød1
#4	40 UNC	TB904162	6	56	3.5	2.7	2.3
#5	40 UNC	TB904202	7	56	3.5	2.7	2.6
#6	32 UNC	TB904242	7	56	4	3	2.85
#8	32 UNC	TB904282	8	63	4.5	3.4	3.5
#10	24 UNC	TB904322	10	70	6	4.9	3.9
#12	24 UNC	TB904362	10	80	6	4.9	4.5
1/4"	20 UNC	TB904402	13	80	7	5.5	5.2
5/16"	18 UNC	TB904442	14	90	8	6.2	6.6
3/8"	16 UNC	TB904482	16	100	9	7	8
7/16"	14 UNC	TB904522	17	100	8	6.2	9.4
1/2"	13 UNC	TB904562	20	110	9	7	10.75
9/16"	12 UNC	TB904602	20	110	11	9	12.25
5/8"	11 UNC	TB904642	22	110	12	9	13.5
3/4"	10 UNC	TB904702	25	125	14	11	16.5
7/8"	9 UNC	TB904742	27	140	18	14.5	19.5
1"	8 UNC	TB904782	30	160	20	16	22.25
1 1/8"	7 UNC	TB904822	35	180	22	18	25

► DIN 371(#4~3/8") and DIN 376(7/16"~1 1/8")

Unit : N/mm²

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
◎	◎					◎	◎	◎						○
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
		○												

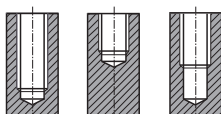
UNC

Unified coarse threads
Unified Grobgewinde

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

Hole type



DIN 371



DIN 376

Material groups

AI

HSS-E

DIN 371/376

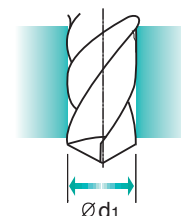
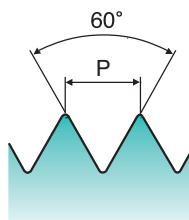
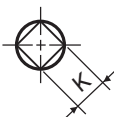
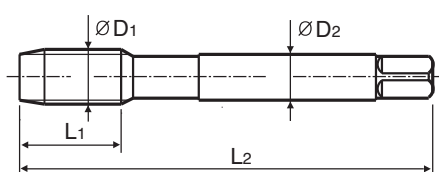
2B



Bright



Machine taps
Maschinengewindebohrer



Unit : mm

SIZE ØD1	TPI	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping Drill Diameter Ød1
#4	– 40 UNC	TC169162	6	56	3.5	2.7	2.3
#5	– 40 UNC	TC169202	7	56	3.5	2.7	2.6
#6	– 32 UNC	TC169242	7	56	4	3	2.85
#8	– 32 UNC	TC169282	8	63	4.5	3.4	3.5
#10	– 24 UNC	TC169322	10	70	6	4.9	3.9
#12	– 24 UNC	TC169362	10	80	6	4.9	4.5
1/4"	– 20 UNC	TC169402	13	80	7	5.5	5.2
5/16"	– 18 UNC	TC169442	14	90	8	6.2	6.6
3/8"	– 16 UNC	TC169482	16	100	9	7	8
7/16"	– 14 UNC	TC169522	17	100	8	6.2	9.4
1/2"	– 13 UNC	TC169562	20	110	9	7	10.75
9/16"	– 12 UNC	TC169602	20	110	11	9	12.25
5/8"	– 11 UNC	TC169642	22	110	12	9	13.5
3/4"	– 10 UNC	TC169702	25	125	14	11	16.5
7/8"	– 9 UNC	TC169742	27	140	18	14.5	19.5
1"	– 8 UNC	TC169782	30	160	20	16	22.25
1 1/8"	– 7 UNC	TC169822	35	180	22	18	25

► DIN 371(#4~3/8") and DIN 376(7/16"~1 1/8")

Unit : N/mm²

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
○	○	○											○	
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Si ≤ 10%	Al > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
				◎				◎	◎	◎				



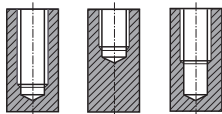
SPIRAL FLUTE TAPS

TC124 SERIES

UNF Unified fine threads Unified Feingewinde

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

Hole type


DIN 371



DIN 374



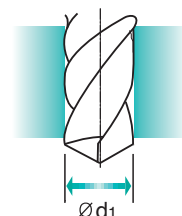
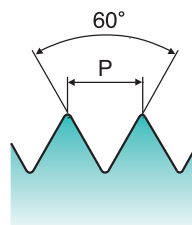
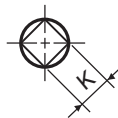
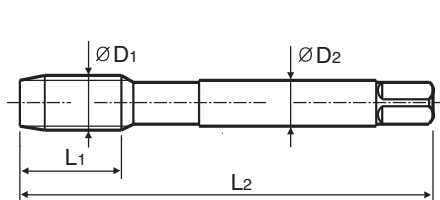
HSS-E

DIN
371/374

2B



Bright


Machine taps
Maschinengewindebohrer


Unit : mm

SIZE ØD1	TPI	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping Drill Diameter Ød1
#4	48 UNF	TC124182	6	56	3.5	2.7	2.4
#5	44 UNF	TC124222	7	56	3.5	2.7	2.7
#6	40 UNF	TC124262	7	56	4	3	3
#8	36 UNF	TC124302	8	63	4.5	3.4	3.5
#10	32 UNF	TC124342	10	70	6	4.9	4.1
#12	28 UNF	TC124382	10	80	6	4.9	4.7
1/4"	28 UNF	TC124422	10	80	7	5.5	5.5
5/16"	24 UNF	TC124462	10	90	8	6.2	6.9
3/8"	24 UNF	TC124502	10	100	9	7	8.5
7/16"	20 UNF	TC124542	13	100	8	6.2	9.9
1/2"	20 UNF	TC124582	13	100	9	7	11.5
9/16"	18 UNF	TC124622	15	100	11	9	12.9
5/8"	18 UNF	TC124662	15	100	12	9	14.5
3/4"	16 UNF	TC124722	17	110	14	11	17.5
7/8"	14 UNF	TC124762	17	125	18	14.5	20.5
1"	12 UNF	TC124802	20	140	20	16	23.25
1 1/8"	12 UNF	TC124842	22	150	22	18	26.5

► DIN 371(#4~3/8") and DIN 374(7/16"~1 1/8")

Unit : N/mm²

◎ : Excellent ○ : Good

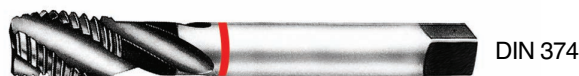
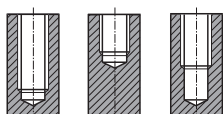
Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
◎	◎	◎									◎	◎	○	
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
○				○		◎		○	○	○	◎	○		

UNF

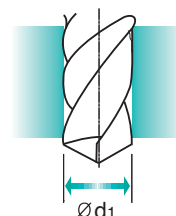
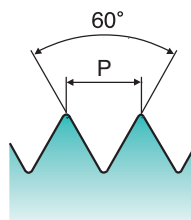
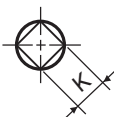
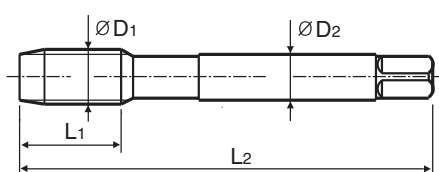
Unified fine threads
Unified Feingewinde

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

Hole type

HSS-E
DIN 371/374
2B

Bright

Machine taps
Maschinengewindebohrer


Unit : mm

SIZE ØD1	TPI	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping Drill Diameter Ød1
#4	– 48 UNF	TC184182	6	56	3.5	2.7	2.4
#5	– 44 UNF	TC184222	7	56	3.5	2.7	2.7
#6	– 40 UNF	TC184262	7	56	4	3	3
#8	– 36 UNF	TC184302	8	63	4.5	3.4	3.5
#10	– 32 UNF	TC184342	10	70	6	4.9	4.1
#12	– 28 UNF	TC184382	10	80	6	4.9	4.7
1/4"	– 28 UNF	TC184422	10	80	7	5.5	5.5
5/16"	– 24 UNF	TC184462	10	90	8	6.2	6.9
3/8"	– 24 UNF	TC184502	10	100	9	7	8.5
7/16"	– 20 UNF	TC184542	13	100	8	6.2	9.9
1/2"	– 20 UNF	TC184582	13	100	9	7	11.5
9/16"	– 18 UNF	TC184622	15	100	11	9	12.9
5/8"	– 18 UNF	TC184662	15	100	12	9	14.5
3/4"	– 16 UNF	TC184722	17	110	14	11	17.5
7/8"	– 14 UNF	TC184762	17	125	18	14.5	20.5
1"	– 12 UNF	TC184802	20	140	20	16	23.25
1 1/8"	– 12 UNF	TC184842	22	150	22	18	26.5

► DIN 371(#4~3/8") and DIN 374(7/16"~1 1/8")

Unit : N/mm²

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy < 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
			○	◎				○						○
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
		○												



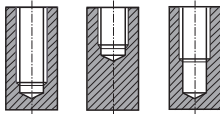
SPIRAL FLUTE TAPS

TB924 SERIES

UNF Unified fine threads Unified Feingewinde

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

Hole type


DIN 371



DIN 374



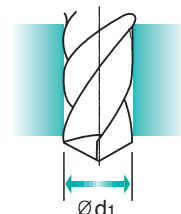
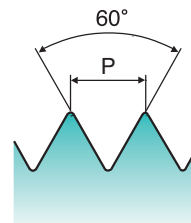
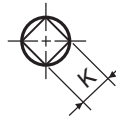
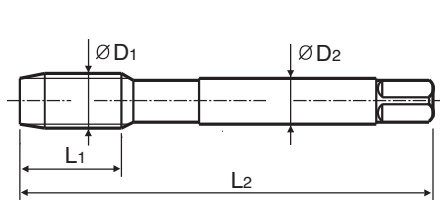
HSS-E

DIN
371/374

2B



Vap


Machine taps
Maschinengewindebohrer


Unit : mm

SIZE ØD1	TPI	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping Drill Diameter Ød1
#4	48 UNF	TB924182	6	56	3.5	2.7	2.4
#5	44 UNF	TB924222	7	56	3.5	2.7	2.7
#6	40 UNF	TB924262	7	56	4	3	3
#8	36 UNF	TB924302	8	63	4.5	3.4	3.5
#10	32 UNF	TB924342	10	70	6	4.9	4.1
#12	28 UNF	TB924382	10	80	6	4.9	4.7
1/4"	28 UNF	TB924422	10	80	7	5.5	5.5
5/16"	24 UNF	TB924462	10	90	8	6.2	6.9
3/8"	24 UNF	TB924502	10	100	9	7	8.5
7/16"	20 UNF	TB924542	13	100	8	6.2	9.9
1/2"	20 UNF	TB924582	13	100	9	7	11.5
9/16"	18 UNF	TB924622	15	100	11	9	12.9
5/8"	18 UNF	TB924662	15	100	12	9	14.5
3/4"	16 UNF	TB924722	17	110	14	11	17.5
7/8"	14 UNF	TB924762	17	125	18	14.5	20.5
1"	12 UNF	TB924802	20	140	20	16	23.25
1 1/8"	12 UNF	TB924842	22	150	22	18	26.5

► DIN 371(#4~3/8") and DIN 374(7/16"~1 1/8")

Unit : N/mm²

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
◎	◎					◎	◎	◎						○
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
		○												



TC170 SERIES

UNF

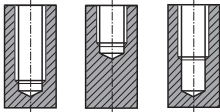
Unified fine threads

Unified Feingewinde

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

Hole type



DIN 371



DIN 374

Material groups

AI

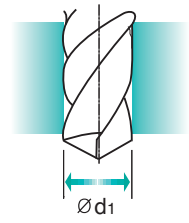
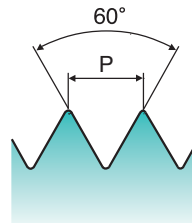
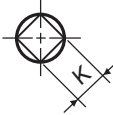
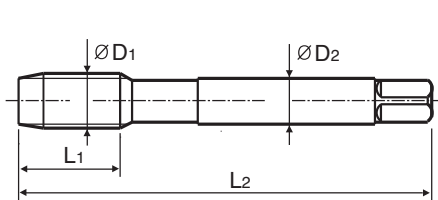
HSS-E

DIN
371/374

2B



Bright

Machine taps
Maschinengewindebohrer

Unit : mm

SIZE ØD1	TPI	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping Drill Diameter Ød1
#4	– 48 UNF	TC170182	6	56	3.5	2.7	2.4
#5	– 44 UNF	TC170222	7	56	3.5	2.7	2.7
#6	– 40 UNF	TC170262	7	56	4	3	3
#8	– 36 UNF	TC170302	8	63	4.5	3.4	3.5
#10	– 32 UNF	TC170342	10	70	6	4.9	4.1
#12	– 28 UNF	TC170382	10	80	6	4.9	4.7
1/4"	– 28 UNF	TC170422	10	80	7	5.5	5.5
5/16"	– 24 UNF	TC170462	10	90	8	6.2	6.9
3/8"	– 24 UNF	TC170502	10	100	9	7	8.5
7/16"	– 20 UNF	TC170542	13	100	8	6.2	9.9
1/2"	– 20 UNF	TC170582	13	100	9	7	11.5
9/16"	– 18 UNF	TC170622	15	100	11	9	12.9
5/8"	– 18 UNF	TC170662	15	100	12	9	14.5
3/4"	– 16 UNF	TC170722	17	110	14	11	17.5
7/8"	– 14 UNF	TC170762	17	125	18	14.5	20.5
1"	– 12 UNF	TC170802	20	140	20	16	23.25
1 1/8"	– 12 UNF	TC170842	22	150	22	18	26.5

► DIN 371(#4~3/8") and DIN 374(7/16"~1 1/8")

Unit : N/mm²

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy < 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
○	○	○											○	
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
				◎				◎	◎	◎				



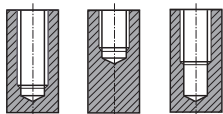
SPIRAL FLUTE TAPS

TC134 SERIES

BSW Whitworth threads Whitworth Gewinde

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

Hole type


DIN 2182



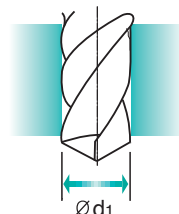
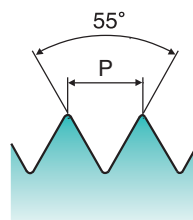
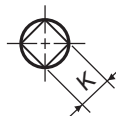
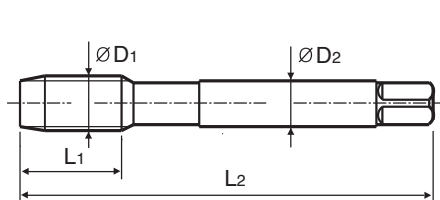
DIN 2183



HSS-E

DIN
2182/2183


Bright


Machine taps
Maschinengewindebohrer


Unit : mm

SIZE ØD1	TPI	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping Drill Diameter Ød1
W1/8"	40	TC134200	7	56	3.5	2.7	2.5
W5/32"	32	TC134280	7	63	4.5	3.4	3.1
W3/16"	24	TC134320	10	70	6	4.9	3.6
W7/32"	24	TC134360	10	80	6	4.9	4.4
W1/4"	20	TC134400	13	80	7	5.5	5.1
W5/16"	18	TC134440	14	90	8	6.2	6.5
W3/8"	16	TC134480	16	100	9	7	7.9
W7/16"	14	TC134520	17	100	8	6.2	9.3
W1/2"	12	TC134560	20	110	9	7	10.5
W9/16"	12	TC134600	20	110	11	9	12
W5/8"	11	TC134640	22	110	12	9	13.5
W3/4"	10	TC134700	25	125	14	11	16.5
W7/8"	9	TC134740	27	140	18	14.5	19.25
W1"	8	TC134780	30	160	20	16	22
W1*1/8"	7	TC134820	35	180	22	18	24.75

► DIN 2182(W1/8"~W3/8") and DIN 2183(W7/16"~W1*1/8")

Unit : N/mm²

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
○	○	○	○								○	○		
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
					○	○					○			