

HSS



Being the best through innovation



HAND TAPS

HANDGEWINDEBOHRER

- General Tapping, HSS & HSS-E
- Für normales Gewindeschneiden. HSS und HSS-E

SELECTION GUIDE

HAND TAPS

General Tapping, HSS & HSS-E

HSS HAND TAPS

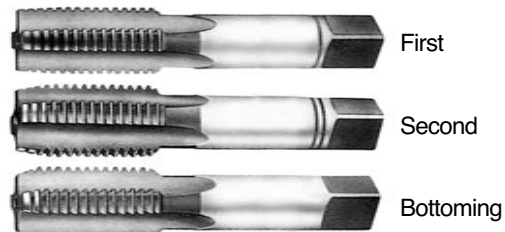
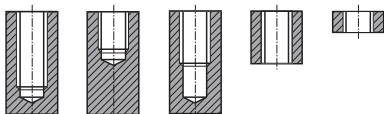
EDP No.	MODEL	Tool Material	Standard	Work Material	Dimensions	Tolerance	Chamfer	Surface Treatment	PAGE
T7109		HSS	M	GS	DIN 352	ISO 2/6H	I / II / III	Bright	535
T7343		HSS	M-LH	GS	DIN 352	ISO 2/6H	I / II / III	Bright	536
TC353		HSS-E	M	VG	DIN 352	ISO 2/6H	I / II / III	Bright	537
TB373		HSS-E	M	VA	DIN 352	ISO 2X/6HX	I / II / III	Vap	538
T7309		HSS	MF	GS	DIN 2181	ISO 2/6H	I / III	Bright	539
T7363		HSS	UNC	GS	DIN 351	2B	I / II / III	Bright	541
T7509		HSS	UNF	GS	DIN 2181	2B	I / III	Bright	542
T7609		HSS	BSW	GS	DIN 351	-	I / II / III	Bright	543

**HAND TAPS****T7109** SERIES

M ISO metric coarse threads DIN 13

Metrisches ISO-Gewinde DIN 13

- ▶ This tap is a serial hand tap in set, First, Second and Bottoming.
- ▶ Bottoming tap of set has final internal thread dimensions only.
- ▶ Dies ist ein Handgewindebohrer im Satz mit Vor-, Mittel- und Fertigschneider.
- ▶ Nur der Fertigschneider kann das gewünschte Gewinde schneiden.

Hole type

First

Second

Bottoming



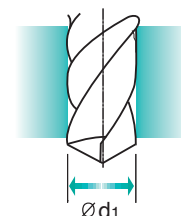
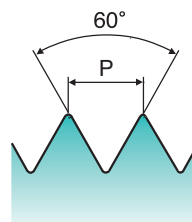
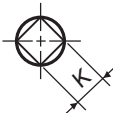
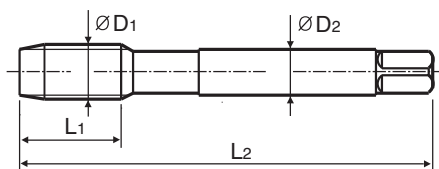
HSS

DIN
352

6H



Bright

Sets of taps
Gewindebohrer - Satz

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	T7109139	8	36	2.8	2.1	1.6
M2.2	× 0.45	T7109159	9	36	2.8	2.1	1.75
* M2.3	× 0.4	T7109199	9	36	2.8	2.1	1.9
M2.5	× 0.45	T7109179	9	40	2.8	2.1	2.05
* M2.6	× 0.45	T7109499	9	40	2.8	2.1	2.1
M3	× 0.5	T7109209	11	40	3.5	2.7	2.5
M3.5	× 0.6	T7109229	13	45	4	3	2.9
M4	× 0.7	T7109249	13	45	4.5	3.4	3.3
M4.5	× 0.75	T7109269	16	50	6	4.9	3.7
M5	× 0.8	T7109289	16	52	6	4.9	4.2
* M5.5	× 0.9	T7109N69	18	56	6	4.9	4.6
M6	× 1	T7109319	18	56	6	4.9	5
M7	× 1	T7109349	18	56	6	4.9	6
M8	× 1.25	T7109369	20	63	6	4.9	6.8
M9	× 1.25	T7109399	20	63	7	5.5	7.8
M10	× 1.5	T7109429	22	70	7	5.5	8.5
M11	× 1.5	T7109469	22	70	8	6.2	9.5
M12	× 1.75	T7109509	24	80	9	7	10.2
M14	× 2	T7109549	26	80	11	9	12
M16	× 2	T7109609	27	80	12	9	14
M18	× 2.5	T7109659	30	95	14	11	15.5
M20	× 2.5	T7109709	32	95	16	12	17.5
M22	× 2.5	T7109749	32	100	18	14.5	19.5
M24	× 3	T7109789	34	110	18	14.5	21
M27	× 3	T7109869	36	110	20	16	24
M30	× 3.5	T7109949	40	125	22	18	26.5
M33	× 3.5	T7109A49	40	125	25	20	29.5
M36	× 4	T7109B39	50	150	28	22	32
M39	× 4	T7109C09	50	150	32	24	35
M42	× 4.5	T7109C89	56	150	32	24	37.5
M45	× 4.5	T7109D59	58	160	36	29	40.5
M48	× 5	T7109E29	65	180	36	29	43
M52	× 5	T7109F39	65	180	40	32	47

▶ * DIN profile not ISO

HSS

CARBIDE

COMBO
TAPSSPIRAL
FLUTE TAPSSPIRAL
POINT TAPSSTRAIGHT
FLUTE TAPSCOLD
FORMING
TAPS

NUT TAPS

STI TAPS

HAND TAPS

PIPE TAPS

CARBIDE
TAPSTHREAD
MILLSTECHNICAL
DATA



HAND TAPS

T7343 SERIES

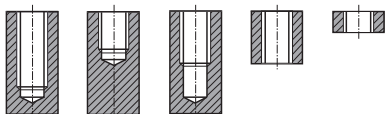
M-LH

ISO metric coarse threads DIN 13

Metrisches ISO-Gewinde DIN 13

- This tap is a serial hand tap in set, First, Second and Bottoming.
- Bottoming tap of set has final internal thread dimensions only.
- Dies ist ein Handgewindebohrer im Satz mit Vor-, Mittel- und Fertigschneider.
- Nur der Fertigschneider kann das gewünschte Gewinde schneiden.

Hole type



First



Second



Bottoming



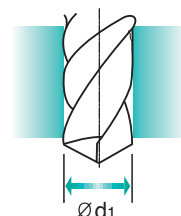
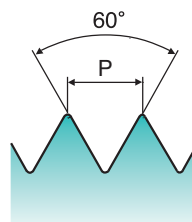
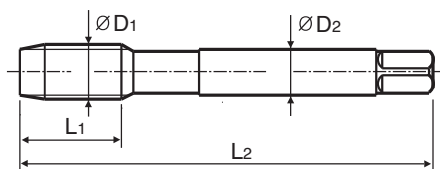
HSS

DIN
352

6H



Bright

Sets of taps
Gewindebohrer - Satz

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	T7343209	11	40	3.5	2.7	2.5
M3.5	× 0.6	T7343229	13	45	4	3	2.9
M4	× 0.7	T7343249	13	45	4.5	3.4	3.3
M4.5	× 0.75	T7343269	16	50	6	4.9	3.7
M5	× 0.8	T7343289	16	52	6	4.9	4.2
M6	× 1	T7343319	18	56	6	4.9	5
M8	× 1.25	T7343369	20	63	6	4.9	6.8
M10	× 1.5	T7343429	22	70	7	5.5	8.5
M12	× 1.75	T7343509	24	80	9	7	10.2
M14	× 2	T7343549	26	80	11	9	12
M16	× 2	T7343609	27	80	12	9	14
M18	× 2.5	T7343659	30	95	14	11	15.5
M20	× 2.5	T7343709	32	95	16	12	17.5
M22	× 2.5	T7343749	32	100	18	14.5	19.5
M24	× 3	T7343789	34	110	18	14.5	21
M27	× 3	T7343869	36	110	20	16	24
M30	× 3.5	T7343949	40	125	22	18	26.5

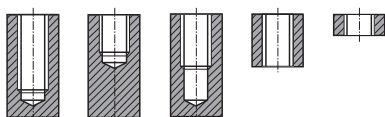
► LH=Left hand thread

**HAND TAPS****TC353** SERIES

M ISO metric coarse threads DIN 13

Metrisches ISO-Gewinde DIN 13

- This tap is a serial hand tap in set, First, Second and Bottoming.
- Bottoming tap of set has final internal thread dimensions only.
- Dies ist ein Handgewindebohrer im Satz mit Vor-, Mittel- und Fertigschneider.
- Nur der Fertigschneider kann das gewünschte Gewinde schneiden.

Hole type

Material groups

VG

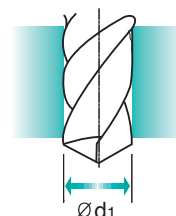
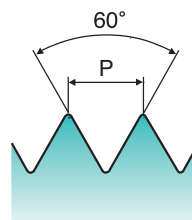
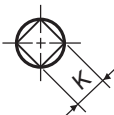
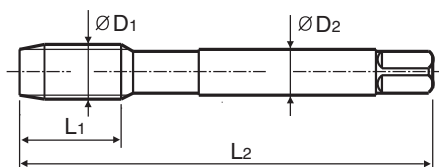
HSS-E

DIN
352

6H



Bright

Sets of taps
Gewindebohrer - Satz

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	TC353209	11	40	3.5	2.7	2.5
M3.5	× 0.6	TC353229	13	45	4	3	2.9
M4	× 0.7	TC353249	13	45	4.5	3.4	3.3
M4.5	× 0.75	TC353269	16	50	6	4.9	3.7
M5	× 0.8	TC353289	16	52	6	4.9	4.2
M6	× 1	TC353319	18	56	6	4.9	5
M8	× 1.25	TC353369	20	63	6	4.9	6.8
M10	× 1.5	TC353429	22	70	7	5.5	8.5
M12	× 1.75	TC353509	24	80	9	7	10.2
M14	× 2	TC353549	26	80	11	9	12
M16	× 2	TC353609	27	80	12	9	14
M18	× 2.5	TC353659	30	95	14	11	15.5
M20	× 2.5	TC353709	32	95	16	12	17.5

- First with pilot guide

HSS**CARBIDE**COMBO
TAPSSPIRAL
FLUTE TAPSSPIRAL
POINT TAPSSTRAIGHT
FLUTE TAPSCOLD
FORMING
TAPS

NUT TAPS

STI TAPS

HAND TAPS

PIPE TAPS

CARBIDE
TAPSTHREAD
MILLSTECHNICAL
DATA

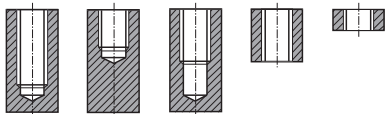


M ISO metric coarse threads DIN 13

Metrisches ISO-Gewinde DIN 13

- This tap is a serial hand tap in set, First, Second and Bottoming.
- Bottoming tap of set has final internal thread dimensions only.
- Dies ist ein Handgewindebohrer im Satz mit Vor-, Mittel- und Fertigschneider.
- Nur der Fertigschneider kann das gewünschte Gewinde schneiden.

Hole type



Material groups

VA

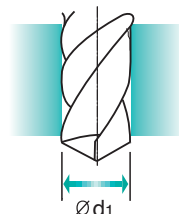
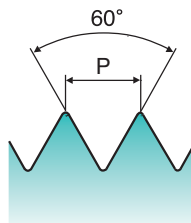
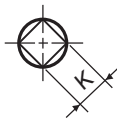
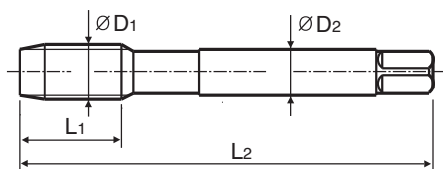
HSS-E

DIN 352

6HX



Vap

Sets of taps
Gewindebohrer - Satz

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping Drill Diameter
ØD1	P		L1	L2	ØD2	K	Ød1
M3	× 0.5	TB373209	11	40	3.5	2.7	2.5
M3.5	× 0.6	TB373229	13	45	4	3	2.9
M4	× 0.7	TB373249	13	45	4.5	3.4	3.3
M4.5	× 0.75	TB373269	16	50	6	4.9	3.7
M5	× 0.8	TB373289	16	52	6	4.9	4.2
M6	× 1	TB373319	18	56	6	4.9	5
M8	× 1.25	TB373369	20	63	6	4.9	6.8
M10	× 1.5	TB373429	22	70	7	5.5	8.5
M12	× 1.75	TB373509	24	80	9	7	10.2
M14	× 2	TB373549	26	80	11	9	12
M16	× 2	TB373609	27	80	12	9	14
M18	× 2.5	TB373659	30	95	14	11	15.5
M20	× 2.5	TB373709	32	95	16	12	17.5

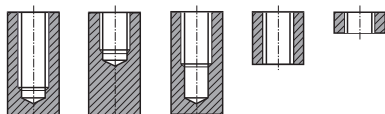
- First with pilot guide

**HAND TAPS****T7309** SERIES

MF ISO metric fine threads DIN 13

Metrisches ISO-Feingewinde DIN 13

- ▶ Serial hand tap set in First and Bottoming.
- ▶ Bottoming tap of set has final internal thread dimensions only.
- ▶ Handgewindebohrersatz mit Vor- und Fertigschneider.
- ▶ Nur der Fertigschneider kann das gewünschte Gewinde schneiden.

Hole type

First



Bottoming

Material groups

GS

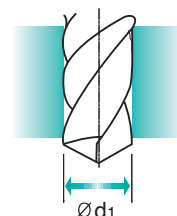
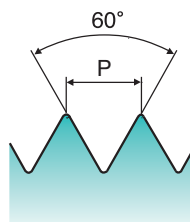
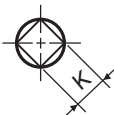
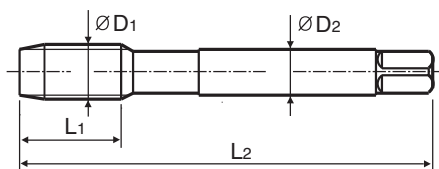
HSS

DIN
2181

6H



Bright

Sets of taps
Gewindebohrer-Satz

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	× 0.35	T7309219	8	42	3.5	2.7	2.65
M4	× 0.5	T7309259	9	48	4.5	3.4	3.5
M5	× 0.5	T7309299	11	52	6	4.9	4.5
M6	× 0.75	T7309329	12	56	6	4.9	5.2
M6	× 0.5	T7309339	12	56	6	4.9	5.5
M7	× 0.75	T7309359	14	56	6	4.9	6.2
M8	× 1	T7309379	17	63	6	4.9	7
M8	× 0.75	T7309389	14	63	6	4.9	7.2
M8	× 0.5	T7309939	14	63	6	4.9	7.5
M9	× 1	T7309409	17	63	7	5.5	8
M10	× 1.25	T7309439	22	70	7	5.5	8.8
M10	× 1	T7309449	18	63	7	5.5	9
M10	× 0.75	T7309459	18	63	7	5.5	9.2
M11	× 1	T7309479	18	63	8	6.2	10
M12	× 1.5	T7309519	20	70	9	7	10.5
M12	× 1.25	T7309529	20	70	9	7	10.8
M12	× 1	T7309539	18	70	9	7	11
M13	× 1.5	T7309N19	20	70	11	9	11.5
M13	× 1	T7309N29	18	70	11	9	12
M14	× 1.5	T7309559	20	70	11	9	12.5
M14	× 1.25	T7309569	20	70	11	9	12.8
M14	× 1	T7309579	18	70	11	9	13
M15	× 1.5	T7309589	20	70	12	9	13.5
M15	× 1	T7309599	18	70	12	9	14
M16	× 1.5	T7309619	20	70	12	9	14.5
M16	× 1	T7309629	18	70	12	9	15

HSS

CARBIDE

COMBO
TAPSSPIRAL
FLUTE TAPSSPIRAL
POINT TAPSSTRAIGHT
FLUTE TAPSCOLD
FORMING
TAPS

NUT TAPS

STI TAPS

HAND TAPS

PIPE TAPS

CARBIDE
TAPSTHREAD
MILLSTECHNICAL
DATA



HAND TAPS

T7309 SERIES

MF

ISO metric fine threads DIN 13

Metrisches ISO-Feingewinde DIN 13

- Serial hand tap set in First and Bottoming.
- Bottoming tap of set has final internal thread dimensions only.
- Handgewindebohrersatz mit Vor- und Fertigschneider.
- Nur der Fertigschneider kann das gewünschte Gewinde schneiden.

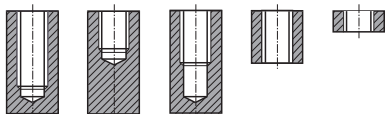


First



Bottoming

Hole type



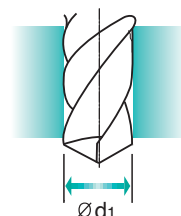
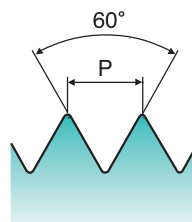
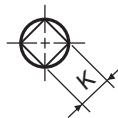
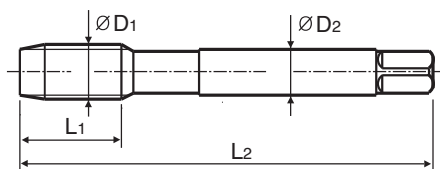
HSS

DIN
2181

6H



Bright

Sets of taps
Gewindebohrer-Satz

Unit : mm

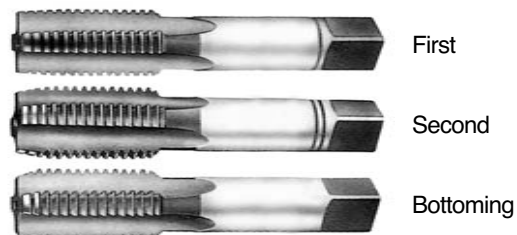
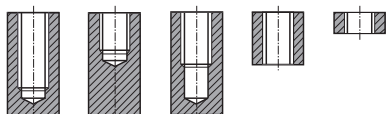
SIZE	Pitch	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping Drill Diameter
ØD1	P		L1	L2	ØD2	K	Ød1
M18 × 2		T7309669	22	80	14	11	16
M18 × 1.5		T7309679	22	80	14	11	16.5
M18 × 1		T7309689	18	80	14	11	17
M20 × 2		T7309719	22	80	16	12	18
M20 × 1.5		T7309729	22	80	16	12	18.5
M20 × 1		T7309739	18	80	16	12	19
M22 × 2		T7309759	22	80	18	14.5	20
M22 × 1.5		T7309769	22	80	18	14.5	20.5
M22 × 1		T7309779	18	80	18	14.5	21
M24 × 2		T7309799	22	90	18	14.5	22
M24 × 1.5		T7309809	22	90	18	14.5	22.5
M24 × 1		T7309819	18	90	18	14.5	23
M25 × 1.5		T7309839	22	90	18	14.5	23.5
M25 × 1		T7309849	18	90	18	14.5	24
M26 × 1.5		T7309859	22	90	18	14.5	24.5
M26 × 1		T7309N59	18	90	18	14.5	25
M27 × 2		T7309879	22	90	20	16	25
M27 × 1.5		T7309889	22	90	20	16	25.5
M27 × 1		T7309899	18	90	20	16	26
M28 × 2		T7309909	22	90	20	16	26
M28 × 1.5		T7309919	22	90	20	16	26.5
M30 × 2		T7309969	22	90	22	18	28
M30 × 1.5		T7309979	22	90	22	18	28.5
M30 × 1		T7309989	18	90	22	18	29

UNC Unified coarse threads

Unified Grobgewinde

- ▶ This tap is a serial hand tap in set, First, Second and Bottoming.
- ▶ Bottoming tap of set has final internal thread dimensions only.
- ▶ Dies ist ein Handgewindebohrer im Satz mit Vor-, Mittel- und Fertigschneider.
- ▶ Nur der Fertigschneider kann das gewünschte Gewinde schneiden.

Hole type



Material groups

GS

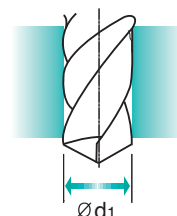
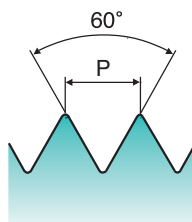
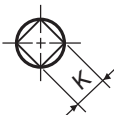
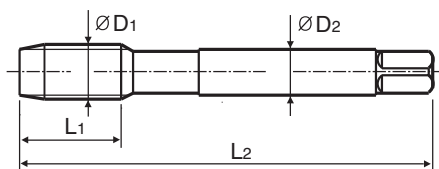
HSS

DIN
351

2B



Bright

Sets of taps
Gewindebohrer-Satz

Unit : mm

SIZE	TPI	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping Drill Diameter	
ØD1			L1	L2	ØD2	K	Ød1	
#2	—	56 UNC	T7363089	9	36	2.8	2.1	1.8
#3	—	48 UNC	T7363129	10	40	2.8	2.1	2.1
#4	—	40 UNC	T7363169	10	42	3.5	2.7	2.3
#5	—	40 UNC	T7363209	10	42	3.5	2.7	2.6
#6	—	32 UNC	T7363249	11	45	4	3	2.85
#8	—	32 UNC	T7363289	12	48	4.5	3.4	3.5
#10	—	24 UNC	T7363329	14	52	6	4.9	3.9
#12	—	24 UNC	T7363369	16	56	6	4.9	4.5
1/4"	—	20 UNC	T7363409	16	56	6	4.9	5.2
5/16"	—	18 UNC	T7363449	20	63	6	4.9	6.6
3/8"	—	16 UNC	T7363489	22	70	7	5.5	8
7/16"	—	14 UNC	T7363529	22	70	8	6.2	9.4
1/2"	—	13 UNC	T7363569	25	80	9	7	10.75
9/16"	—	12 UNC	T7363609	26	80	11	9	12.25
5/8"	—	11 UNC	T7363649	27	90	12	9	13.5
3/4"	—	10 UNC	T7363709	32	105	14	11	16.5
7/8"	—	9 UNC	T7363749	32	110	18	14.5	19.5
1"	—	8 UNC	T7363789	36	110	20	16	22.25
1*1/8"	—	7 UNC	T7363829	40	125	22	18	25
1*1/4"	—	7 UNC	T7363869	40	125	25	20	28.25
1*3/8"	—	6 UNC	T7363909	50	150	28	22	30.75
1*1/2"	—	6 UNC	T7363949	50	150	32	24	34
1*3/4"	—	5 UNC	T7363B89	58	160	36	29	39.5
2"	—	4 1/2 UNC	T7363D29	65	180	40	32	45.25



HAND TAPS

T7509 SERIES

UNF

Unified fine threads

Unified Feingewinde

- Serial hand tap set in First and Bottoming.
- Bottoming tap of set has final internal thread dimensions only.
- Handgewindebohrersatz mit Vor- und Fertigschneider.
- Nur der Fertigschneider kann das gewünschte Gewinde schneiden.

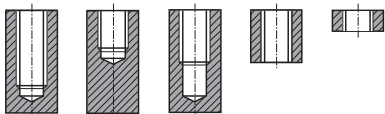


First



Bottoming

Hole type



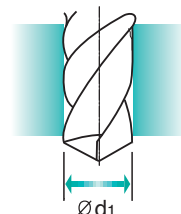
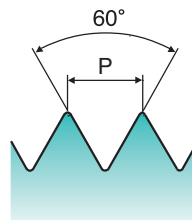
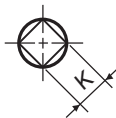
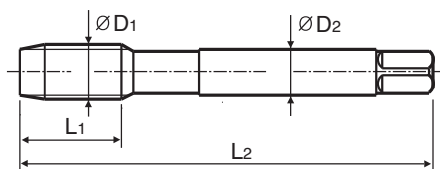
HSS

DIN
2181

2B



Bright

Sets of taps
Gewindebohrer-Satz

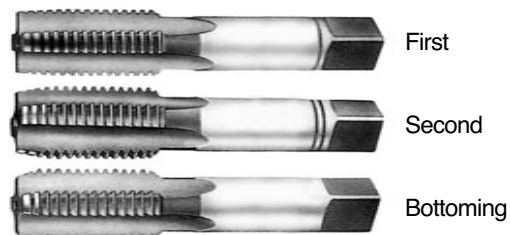
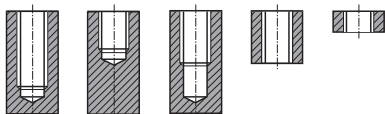
Unit : mm

SIZE ØD1	TPI	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping Drill Diameter Ød1
#4	– 48 UNF	T7509189	10	42	3.5	2.7	2.4
#5	– 44 UNF	T7509229	10	42	3.5	2.7	2.7
#6	– 40 UNF	T7509269	11	45	4	3	3
#8	– 36 UNF	T7509309	12	48	4.5	3.4	3.5
#10	– 32 UNF	T7509349	14	52	6	4.9	4.1
#12	– 28 UNF	T7509389	16	56	6	4.9	4.7
1/4"	– 28 UNF	T7509429	16	56	6	4.9	5.5
5/16"	– 24 UNF	T7509469	17	63	6	4.9	6.9
3/8"	– 24 UNF	T7509509	18	63	7	5.5	8.5
7/16"	– 20 UNF	T7509549	20	70	8	6.2	9.9
1/2"	– 20 UNF	T7509589	20	70	9	7	11.5
9/16"	– 18 UNF	T7509629	20	70	11	9	12.9
5/8"	– 18 UNF	T7509669	20	70	12	9	14.5
3/4"	– 16 UNF	T7509729	22	80	14	11	17.5
7/8"	– 14 UNF	T7509769	22	80	18	14.5	20.5
1"	– 12 UNF	T7509809	22	90	18	14.5	23.25
1 1/8"	– 12 UNF	T7509849	22	90	22	18	26.5

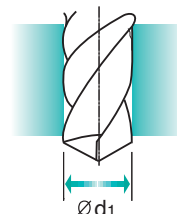
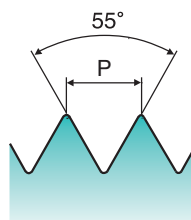
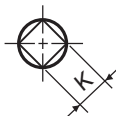
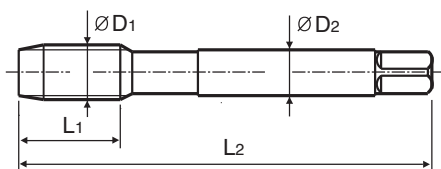
**HAND TAPS****T7609** SERIES

BSW Whitworth threads Whitworth Gewinde

- ▶ This tap is a serial hand tap in set, First, Second and Bottoming.
- ▶ Bottoming tap of set has final internal thread dimensions only.
- ▶ Dies ist ein Handgewindebohrer im Satz mit Vor-, Mittel- und Fertigschneider.
- ▶ Nur der Fertigschneider kann das gewünschte Gewinde schneiden.

Hole type

Material groups

GS**HSS****DIN 351****Bright**Sets of taps
Gewindebohrer-Satz

Unit : mm

SIZE ØD1	TPI	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping Drill Diameter Ød1
W3/32"	48	T7609129	10	40	2.8	2.1	1.8
W1/8"	40	T7609209	10	42	3.5	2.7	2.5
W5/32"	32	T7609289	12	48	4.5	3.4	3.1
W3/16"	24	T7609329	14	52	6	4.9	3.6
W7/32"	24	T7609369	16	56	6	4.9	4.4
W1/4"	20	T7609409	16	56	6	4.9	5.1
W5/16"	18	T7609449	20	63	6	4.9	6.5
W3/8"	16	T7609489	22	70	7	5.5	7.9
W7/16"	14	T7609529	22	70	8	6.2	9.3
W1/2"	12	T7609569	25	80	9	7	10.5
W9/16"	12	T7609609	26	80	11	9	12
W5/8"	11	T7609649	27	90	12	9	13.5
W3/4"	10	T7609709	32	105	14	11	16.5
W7/8"	9	T7609749	32	110	18	14.5	19.25
W1"	8	T7609789	36	110	20	16	22
W1*1/8"	7	T7609829	40	125	22	18	24.75
W1*1/4"	7	T7609869	40	125	25	20	27.75
W1*3/8"	6	T7609909	50	150	28	22	30.5
W1*1/2"	6	T7609949	50	150	32	24	33.5
W1*5/8"	5	T7609989	56	150	32	24	35.5
W1*3/4"	5	T7609989	58	160	36	29	39
W1*7/8"	4 1/2	T7609989	65	180	36	29	41.5
W2"	4 1/2	T7609989	65	180	40	32	44.5

HSS**CARBIDE**COMBO
TAPSSPIRAL
FLUTE TAPSSPIRAL
POINT TAPSSTRAIGHT
FLUTE TAPSCOLD
FORMING
TAPS

NUT TAPS

STI TAPS

HAND TAPS

PIPE TAPS

CARBIDE
TAPSTHREAD
MILLSTECHNICAL
DATA