

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

EDP No.	MODEL	Tool Material	Standard	Work Material	Dimensions	Tolerance	Chamfer	Surface Treatment	PAGE
TC612		HSS-E	M	GS	DIN 352	ISO 2/6H	C	Bright	384
TC211		HSS-E	M	GS	DIN 371/376	ISO 2/6H	C	Bright	385
TC517		HSS-E	M	GS	DIN 371/376	ISO 2/6H	C	Bright	386
TC711		HSS-E	M	GS	DIN 371/376	ISO 2/6H	C	Bright	387
TD711		HSS-E	M	GS	DIN 371/376	ISO 2/6H	C	TiN	388
TQ823		HSS-PM	M	VG	DIN 371/376	ISO 2/6H	C	vap	389
TR823		HSS-PM	M	VG	DIN 371/376	ISO 2/6H	C	Bright	390
TB312		HSS-E	M	VG	DIN 371/376	ISO 2/6H	C	vap	391
TB913		HSS-E	M	VG	DIN 371/376	ISO 2/6H	C	vap	392
TC312		HSS-E	M	VG	DIN 371/376	ISO 2/6H	C	Bright	393
TD312		HSS-E	M	VG	DIN 371/376	ISO 2/6H	C	TiN	394
TY312		HSS-E	M	VG	DIN 371/376	ISO 2/6H	C	TiAlN	395
TQ813		HSS-PM	M	VA	DIN 371/376	ISO 2/6H	C	vap	396
TR813		HSS-PM	M	VA	DIN 371/376	ISO 2/6H	C	Bright	397
TB313		HSS-E	M	HR	DIN 371/376	ISO 2/6H	C	vap	398
TC313		HSS-E	M	HR	DIN 371/376	ISO 2/6H	C	Bright	399
TY313		HSS-E	M	HR	DIN 371/376	ISO 2/6H	C	TiAlN	400
TB914		HSS-E	M	VA NW	DIN 371/376	ISO 2/6H	C	vap	401
TCH14		HSS-E	M	VA NW	DIN 371/376	ISO 2/6H	C	Hardslick	402
TB711		HSS-E	M	NW	DIN 371/376	ISO 2/6H	C	vap	403
TM903		HSS-PM	M	Ti	DIN 371/376	ISO 2/6H	C	Bright	404
TZ903		HSS-PM	M	Ti	DIN 371/376	ISO 2/6H	C	TiAlN	405

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	406
TR833		HSS-PM	M	Ti Ni	DIN 371/376	ISO 2/6H	C	Bright	407
TM933		HSS-PM	M	Ni	DIN 371/376	ISO 2/6H	C	Bright	408
TZ933		HSS-PM	M	Ni	DIN 371/376	ISO 2/6H	C	TiAlN	409
TC163		HSS-E	M	Al	DIN 371/376	ISO 2/6H	C	Bright	410
TE953		HSS-E	M	Al	DIN 371/376	ISO 2/6H	C	NI	411
TC411		HSS-E	MF	GS	DIN 374	ISO 2/6H	C	Bright	412
TD411		HSS-E	MF	GS	DIN 374	ISO 2/6H	C	TiN	414
TC413		HSS-E	MF	VG	DIN 374	ISO 2/6H	C	Bright	416
TD413		HSS-E	MF	VG	DIN 374	ISO 2/6H	C	TiN	417
TB183		HSS-E	MF	VA NW	DIN 374	ISO 2/6H	C	vap	418
TC963		HSS-E	MF	Al	DIN 374	ISO 2/6H	C	Bright	419
TC144		HSS-E	UNC	GS	DIN 371/376	2B	C	Bright	420
TC174		HSS-E	UNC	VG	DIN 371/376	2B	C	Bright	421
TD174		HSS-E	UNC	VG	DIN 371/376	2B	C	TiN	422
TB904		HSS-E	UNC	VA NW	DIN 371/376	2B	C	vap	423
TC169		HSS-E	UNC	Al	DIN 371/376	2B	C	Bright	424
TC124		HSS-E	UNF	GS	DIN 371/374	2B	C	Bright	425
TC184		HSS-E	UNF	VG	DIN 371/374	2B	C	Bright	426
TB924		HSS-E	UNF	VA NW	DIN 371/374	2B	C	vap	427
TC170		HSS-E	UNF	Al	DIN 371/374	2B	C	Bright	428
TC134		HSS-E	BSW	GS	DIN 2182/2183	-	C	Bright	429



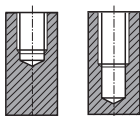
SPIRAL FLUTE TAPS

TC612 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 352



HSS-E

DIN 352

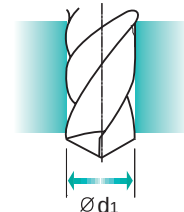
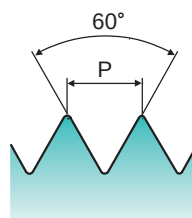
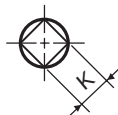
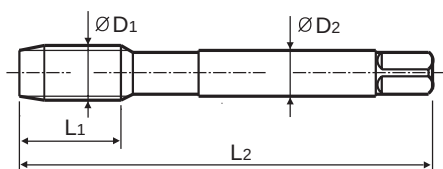
6H



Bright



Short machine taps
Maschinengewindebohrer
kurz



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	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

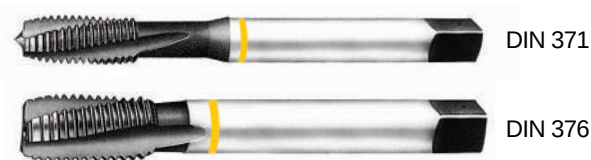
Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
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Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 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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M

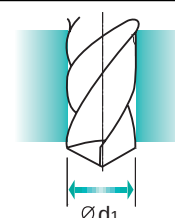
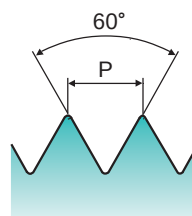
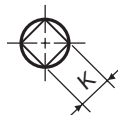
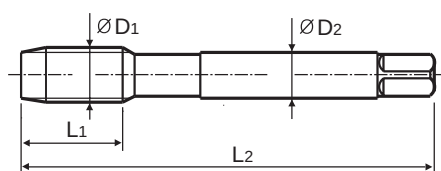
ISO metric coarse threads DIN 13
Metrisches ISO-Gewinde DIN 13

► Left spiral flute and right hand cut 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.


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	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	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
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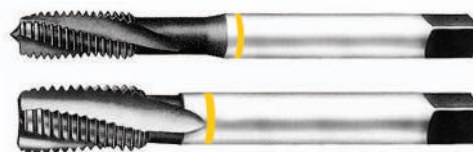
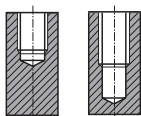
SPIRAL FLUTE TAPS

TC517 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

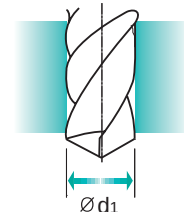
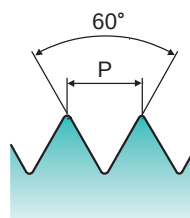
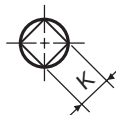
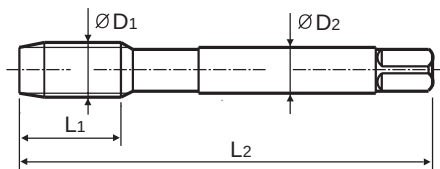
6H

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	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
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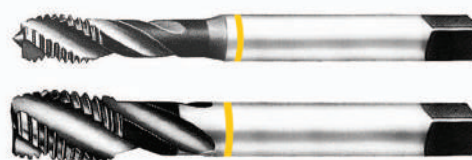
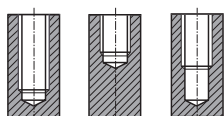
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ISO metric coarse threads DIN 13
Metrisches ISO-Gewinde DIN 13

► 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



DIN 371

DIN 376



HSS-E

DIN 371/376

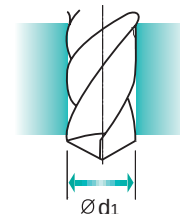
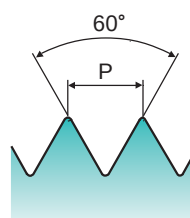
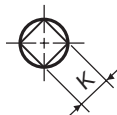
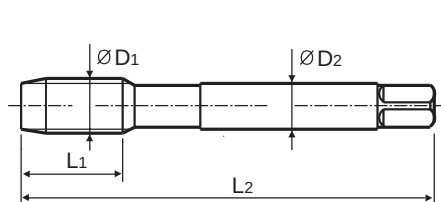
6H



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
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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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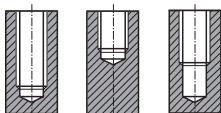
SPIRAL FLUTE TAPS

TD711 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



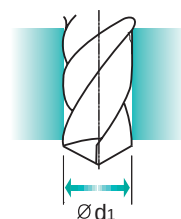
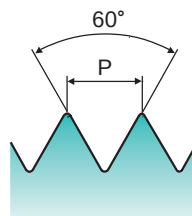
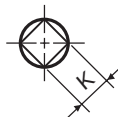
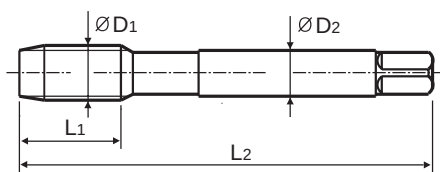
HSS-E

DIN
371/376

6H



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
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	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

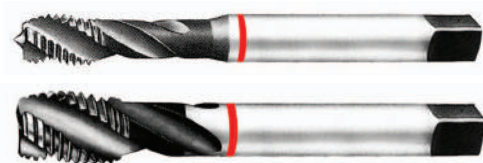
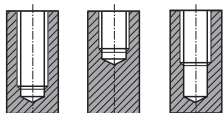
M ISO metric coarse threads DIN 13

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-PM

DIN 371/376

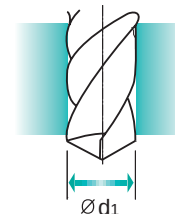
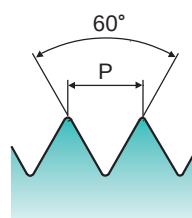
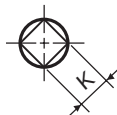
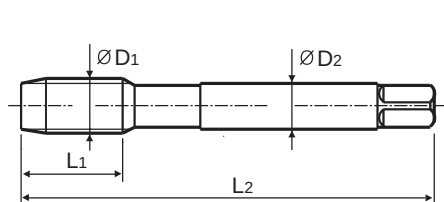
6H



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	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
		○												



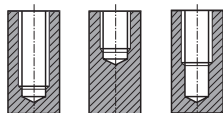
SPIRAL FLUTE TAPS

TR823 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.

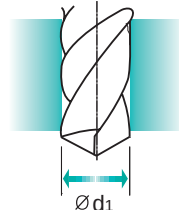
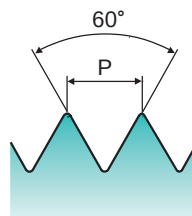
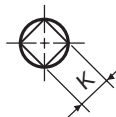
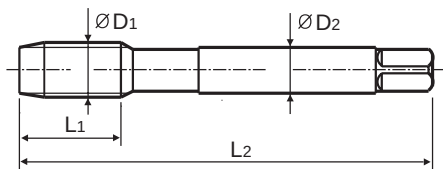
Hole type


DIN 371



DIN 376


HSS-PM
DIN 371/376
6H
60°
C
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	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	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
		○												

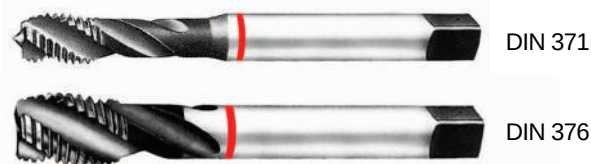
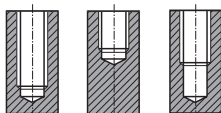
M

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

► Suitable for 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

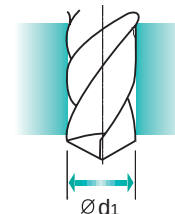
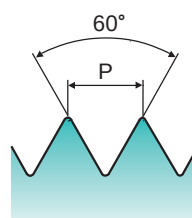
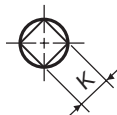
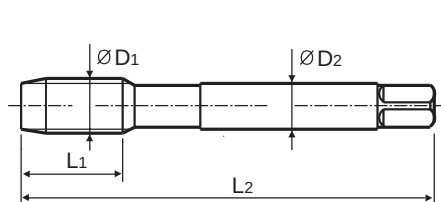
6H



Vap



Machine taps
Maschinengewindebohrer



Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping drill diameter 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

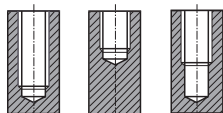
Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
			○	◎				○						○
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu 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

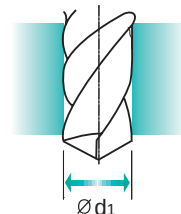
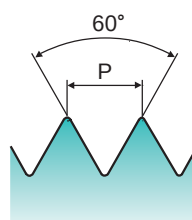
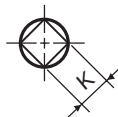
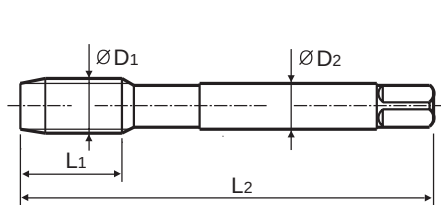
HSS-E

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	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
		○												

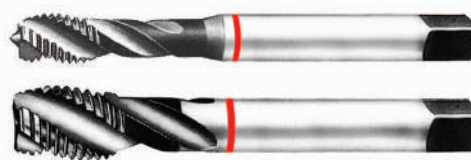
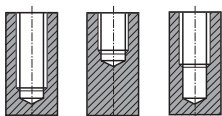
M

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

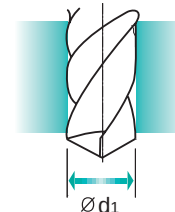
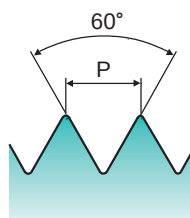
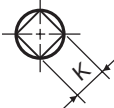
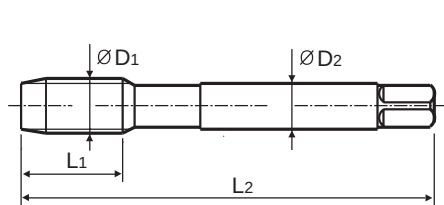
6H



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
		○												



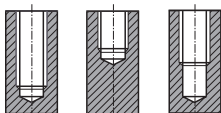
SPIRAL FLUTE TAPS

TD312 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



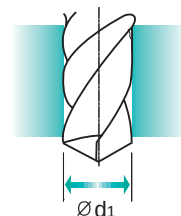
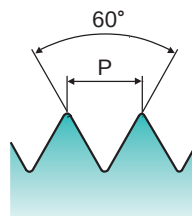
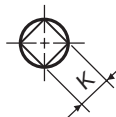
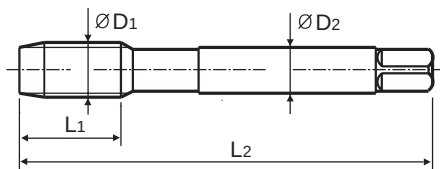
HSS-E

DIN
371/376

6H



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
		○												

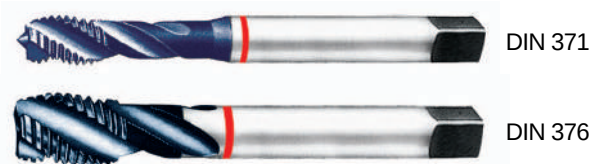
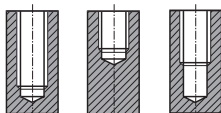
M

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

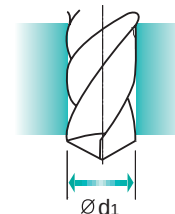
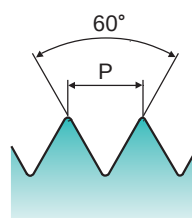
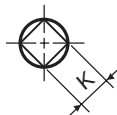
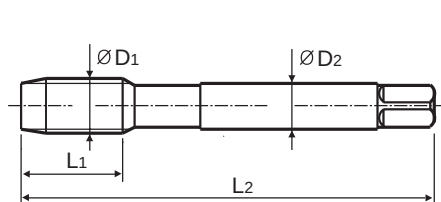
6H



TiAlN



Machine taps
Maschinengewindebohrer



Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping drill diameter
ØD1	P		L1	L2	ØD2	K	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
		○												

HSS

CARBIDE

COMBO
TAPSSPIRAL
POINT TAPSSPIRAL
FLUTE TAPSSTRAIGHT
FLUTE TAPSCOLD
FORMING
TAPS

NUT TAPS

STI TAPS

HAND TAPS

PIPE TAPS

CARBIDE
TAPSTHREAD
MILLSTECHNICAL
DATA

SPIRAL FLUTE TAPS

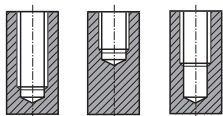
TQ813 SERIES

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

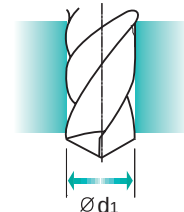
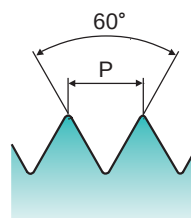
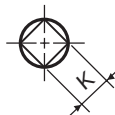
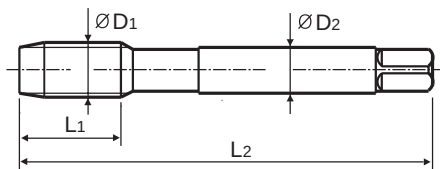
6H

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	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	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
		○												

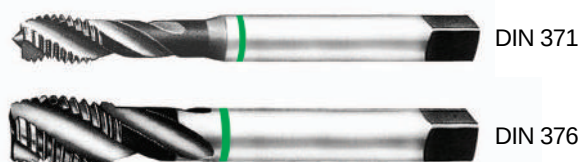
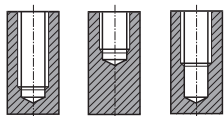
M ISO metric coarse threads DIN 13

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

Material groups

VA

HSS-PM

DIN 371/376

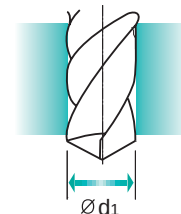
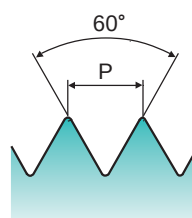
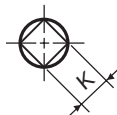
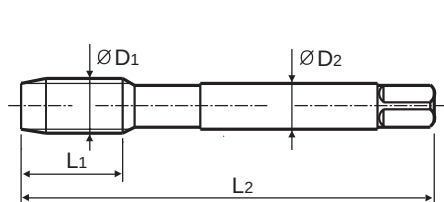
6H



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	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
		○												



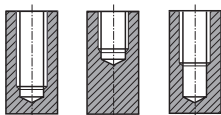
SPIRAL FLUTE TAPS

TB313 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



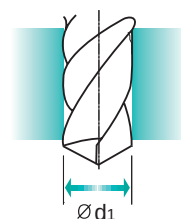
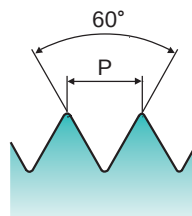
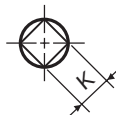
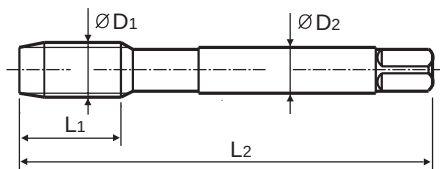
HSS-E

DIN
371/376

6H



Vap


Machine taps
Maschinengewindebohrer


Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping drill diameter
ØD1	P		L1	L2	ØD2	K	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
					○		◎						○	○

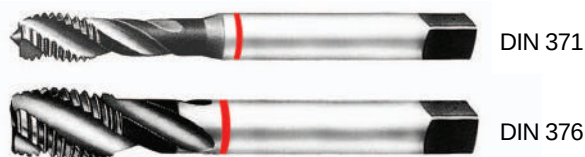
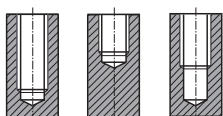
M

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
HR

HSS-E

DIN 371/376

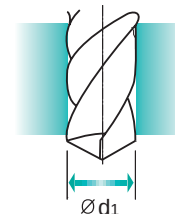
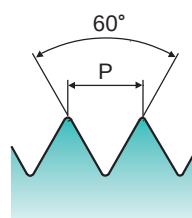
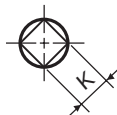
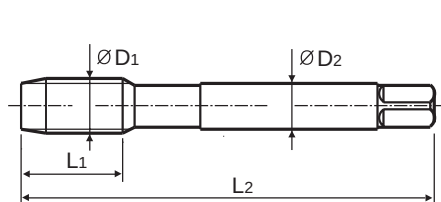
6H



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	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
					○		◎						○	○



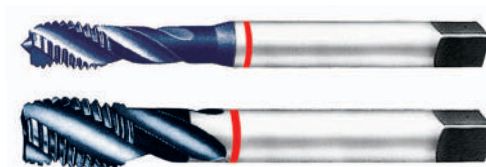
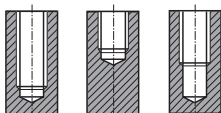
SPIRAL FLUTE TAPS

TY313 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



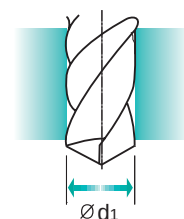
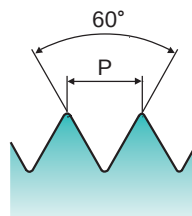
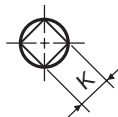
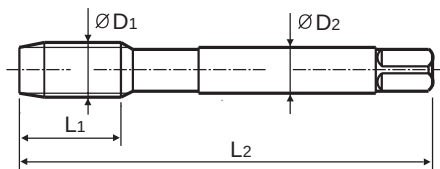
HSS-E

DIN
371/376

6H



TiAlN


Machine taps
Maschinengewindebohrer


Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping drill diameter
ØD1	P		L1	L2	ØD2	K	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
					○		◎						○	○



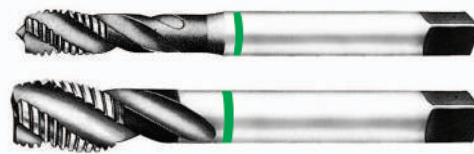
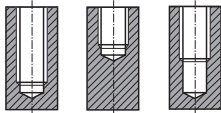
SPIRAL FLUTE TAPS

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



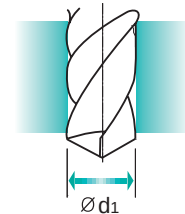
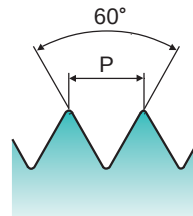
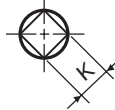
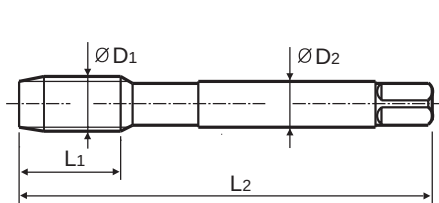
HSS-E

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
		○												

HSS

CARBIDE

COMBO
TAPS

SPIRAL
POINT TAPS

SPIRAL
FLUTE TAPS

STRAIGHT
FLUTE TAPS

COLD
FORMING
TAPS

NUT TAPS

STI TAPS

HAND TAPS

PIPE TAPS

CARBIDE
TAPS

THREAD
MILLS

TECHNICAL
DATA



SPIRAL FLUTE TAPS

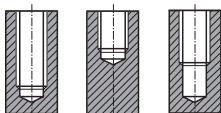
TCH14 SERIES

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



DIN 371



DIN 376



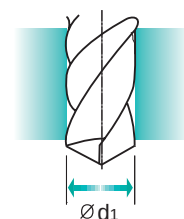
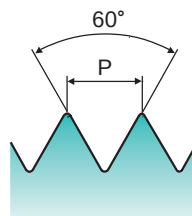
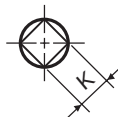
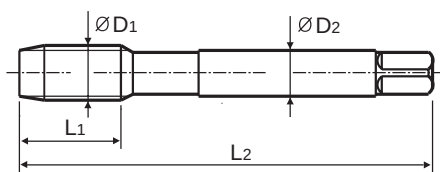
HSS-E

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
		○												

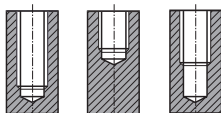
M

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
NW

HSS-E

DIN 371/376

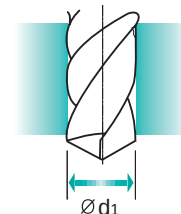
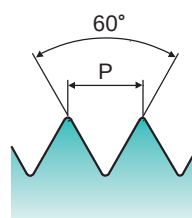
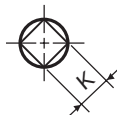
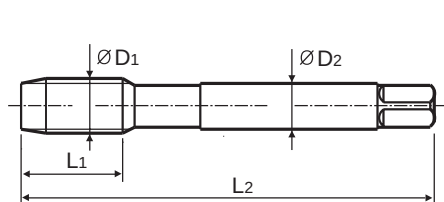
6H



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	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

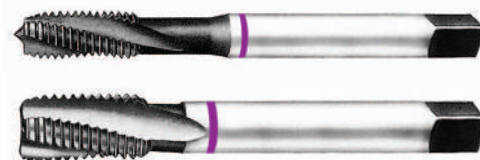
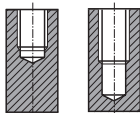
Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
◎	◎													
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy 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.

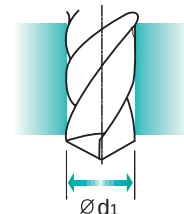
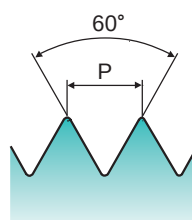
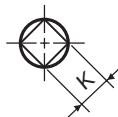
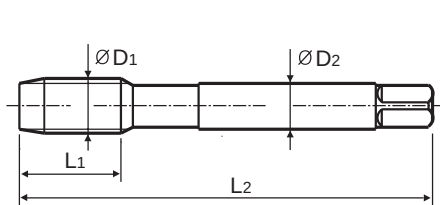
► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

Hole type

DIN 371

DIN 376

Material groups

Ti**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	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
◎														

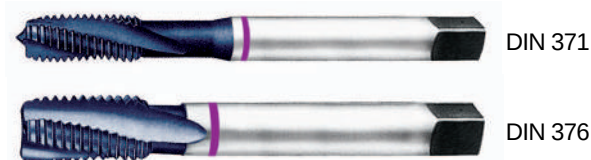
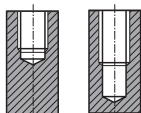
M ISO metric coarse threads DIN 13

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

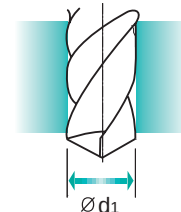
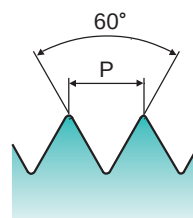
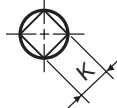
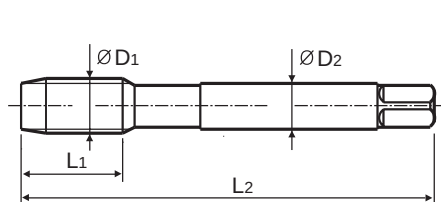
6H



TiAlN



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

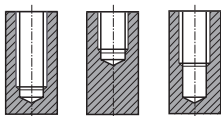
Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
				○									○	◎
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu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

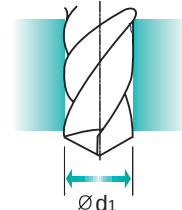
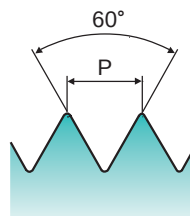
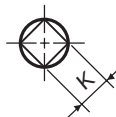
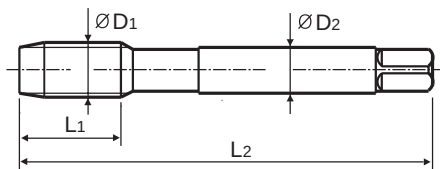
Hole type

DIN 371



DIN 376

Material groups

**Ti
Ni****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	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	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
◎		◎	◎				○							

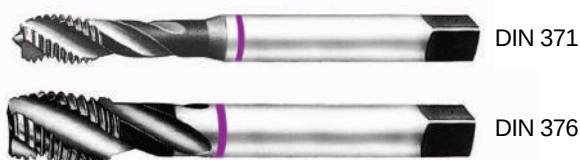
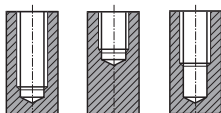
M

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

Material groups

**Ti
Ni**

HSS-PM

DIN
371/376

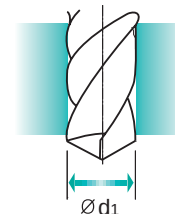
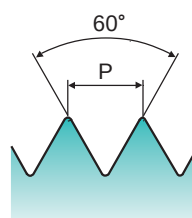
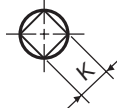
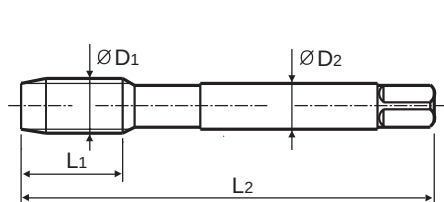
6H



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	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
◎		◎	◎				○							



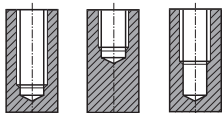
SPIRAL FLUTE TAPS

TM933 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

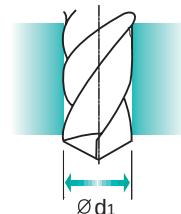
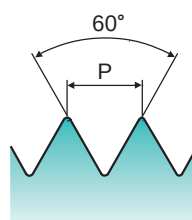
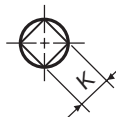
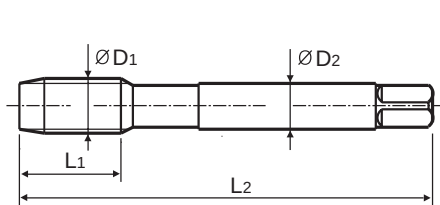
HSS-PM

DIN
371/376

6H



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
○		◎	◎				○							

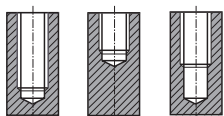
M

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

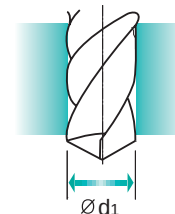
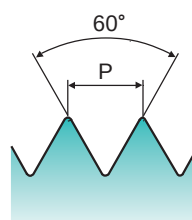
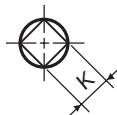
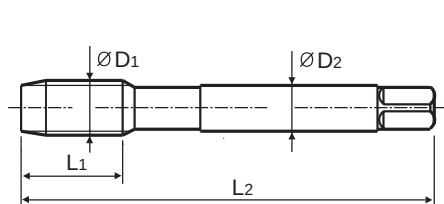
6H



TiAlN



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
○		◎	◎				○							



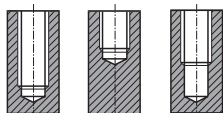
SPIRAL FLUTE TAPS

TC163 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

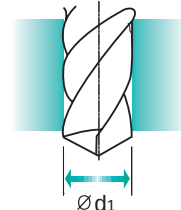
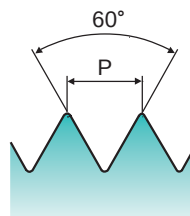
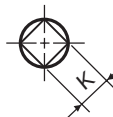
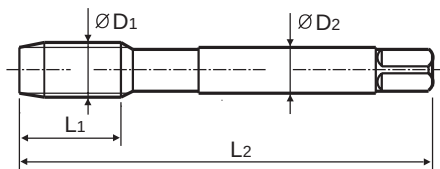
6H

60°

C

Bright

R45

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	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
				◎				◎	◎	◎				

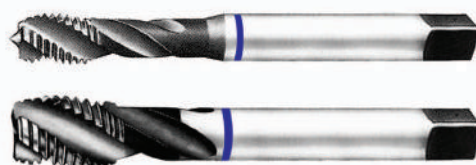
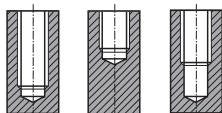
M

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

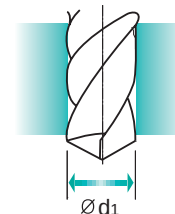
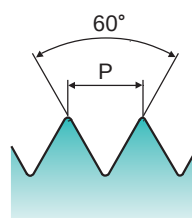
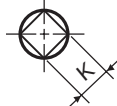
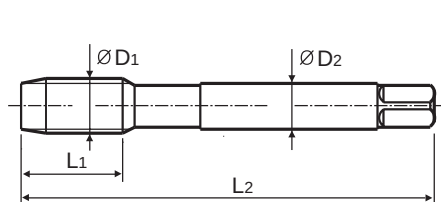
60°

C

NI

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	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

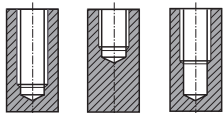
Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
		○												
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy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



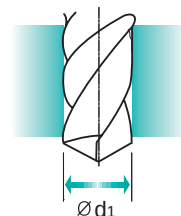
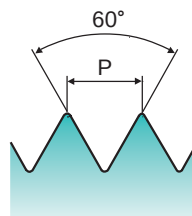
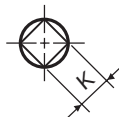
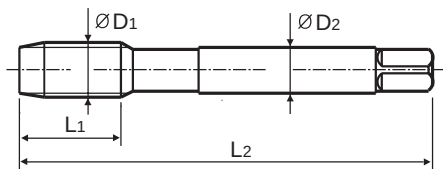
HSS-E

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	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	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
○				○		◎		○	○	○	◎	○		

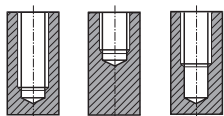
MF

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



Material groups
GS

HSS-E

DIN 374

6H

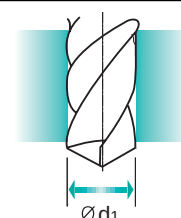
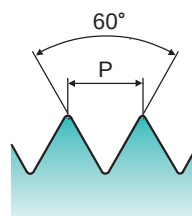
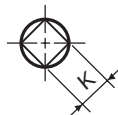
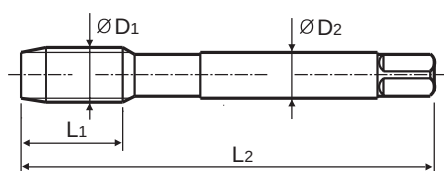
60°

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
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	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
○	○			○		○		○	○	○	○	○		



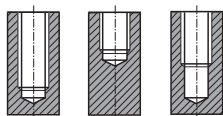
SPIRAL FLUTE TAPS

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



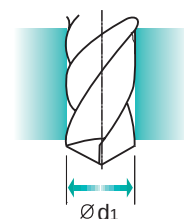
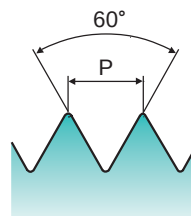
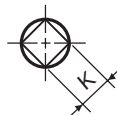
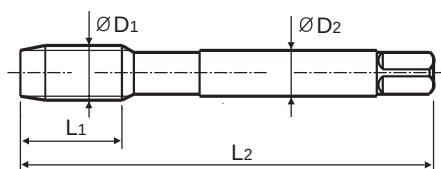
HSS-E

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
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	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
○				○		◎		○	○	○	◎	○		

MF

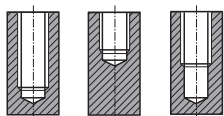
ISO metric fine threads DIN 13

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



HSS-E

DIN
374

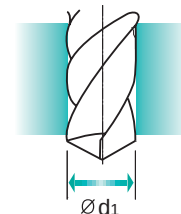
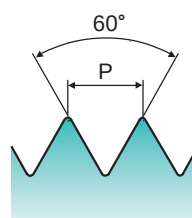
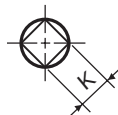
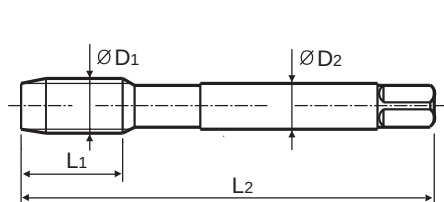
6H



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
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	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
○	○	○	○	○	○	○	○	○	○	○	○	○	○	○



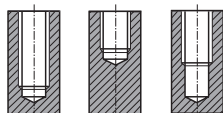
SPIRAL FLUTE TAPS

TC413 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.

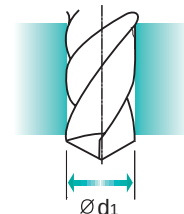
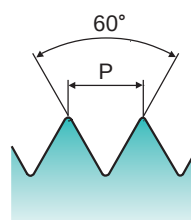
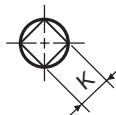
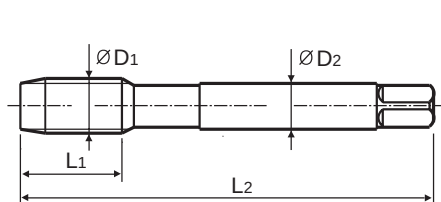
► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

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
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
		○												

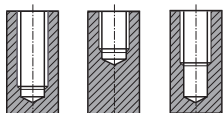
MF

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

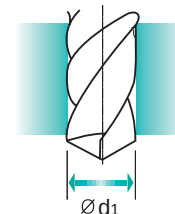
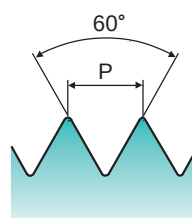
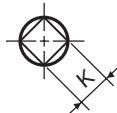
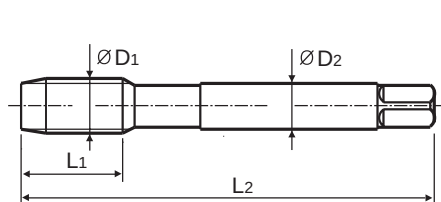
6H



TiN



Machine taps
Maschinengewindebohrer



Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping drill diameter 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

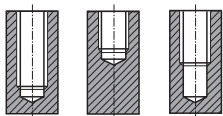
Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
			○	◎				○						○
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu 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

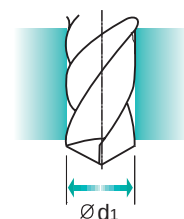
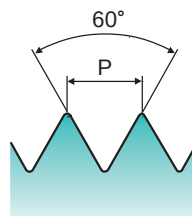
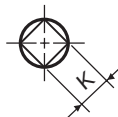
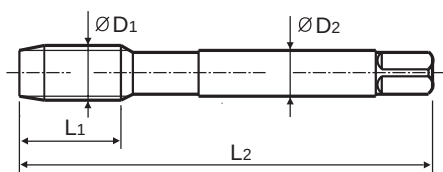
HSS-E

DIN
374

6H



Vap


Machine taps
Maschinengewindebohrer


Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping drill diameter
ØD1	P		L1	L2	ØD2	K	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	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
		○												

MF

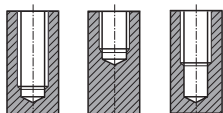
ISO metric fine threads DIN 13

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

AI

HSS-E

DIN 374

6H

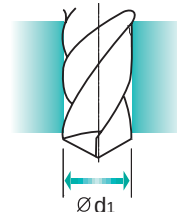
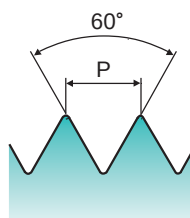
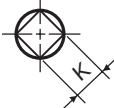
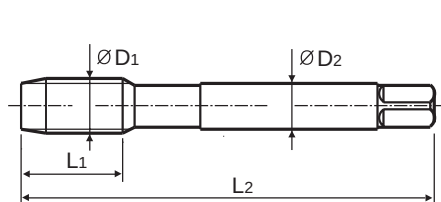
60°

C

Bright

R45

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	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
				◎				◎	◎	◎				

HSS

CARBIDE

COMBO
TAPSSPIRAL
POINT TAPSSPIRAL
FLUTE TAPSSTRAIGHT
FLUTE TAPSCOLD
FORMING
TAPS

NUT TAPS

STI TAPS

HAND TAPS

PIPE TAPS

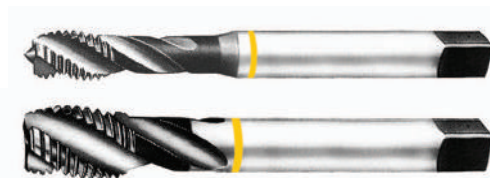
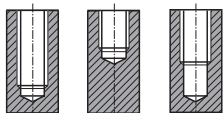
CARBIDE
TAPSTHREAD
MILLSTECHNICAL
DATA
**SPIRAL
FLUTE TAPS**
TC144 SERIES

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



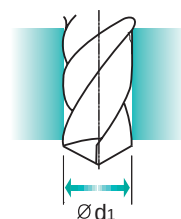
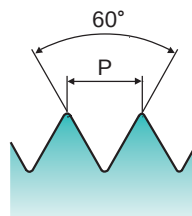
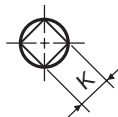
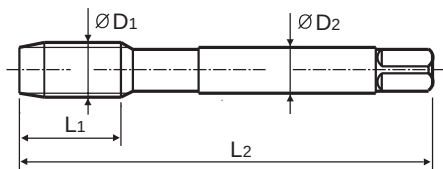
HSS-E

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	– 40UNC	TC144162	6	56	3.5	2.7	2.3
#5	– 40UNC	TC144202	7	56	3.5	2.7	2.6
#6	– 32UNC	TC144242	7	56	4	3	2.85
#8	– 32UNC	TC144282	8	63	4.5	3.4	3.5
#10	– 24UNC	TC144322	10	70	6	4.9	3.9
#12	– 24UNC	TC144362	10	80	6	4.9	4.5
1/4"	– 20UNC	TC144402	13	80	7	5.5	5.2
5/16"	– 18UNC	TC144442	14	90	8	6.2	6.6
3/8"	– 16UNC	TC144482	16	100	9	7	8
7/16"	– 14UNC	TC144522	17	100	8	6.2	9.4
1/2"	– 13UNC	TC144562	20	110	9	7	10.75
9/16"	– 12UNC	TC144602	20	110	11	9	12.25
5/8"	– 11UNC	TC144642	22	110	12	9	13.5
3/4"	– 10UNC	TC144702	25	125	14	11	16.5
7/8"	– 9UNC	TC144742	27	140	18	14.5	19.5
1"	– 8UNC	TC144782	30	160	20	16	22.25
1 1/8"	– 7UNC	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	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

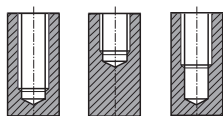
UNC

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



Material groups
VG

HSS-E

DIN 371/376

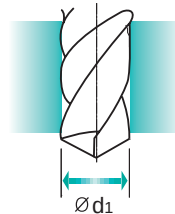
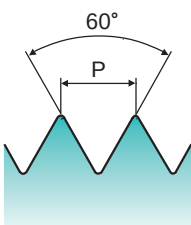
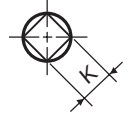
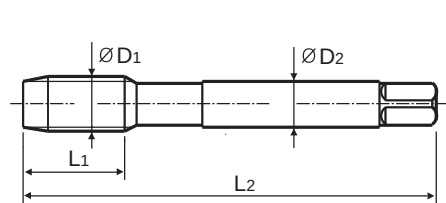
2B



Bright



Machine taps
Maschinengewindebohrer



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



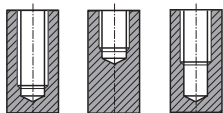
SPIRAL FLUTE TAPS

TD174 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



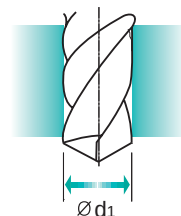
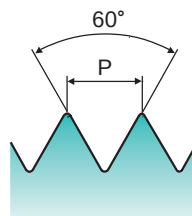
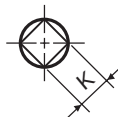
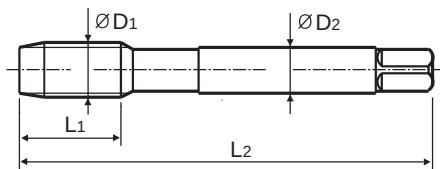
HSS-E

DIN
371/376

2B



TiN


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	– 40UNC	TD174162	6	56	3.5	2.7	2.3
#5	– 40UNC	TD174202	7	56	3.5	2.7	2.6
#6	– 32UNC	TD174242	7	56	4	3	2.85
#8	– 32UNC	TD174282	8	63	4.5	3.4	3.5
#10	– 24UNC	TD174322	10	70	6	4.9	3.9
#12	– 24UNC	TD174362	10	80	6	4.9	4.5
1/4"	– 20UNC	TD174402	13	80	7	5.5	5.2
5/16"	– 18UNC	TD174442	14	90	8	6.2	6.6
3/8"	– 16UNC	TD174482	16	100	9	7	8
7/16"	– 14UNC	TD174522	17	100	8	6.2	9.4
1/2"	– 13UNC	TD174562	20	110	9	7	10.75
9/16"	– 12UNC	TD174602	20	110	11	9	12.25
5/8"	– 11UNC	TD174642	22	110	12	9	13.5
3/4"	– 10UNC	TD174702	25	125	14	11	16.5
7/8"	– 9UNC	TD174742	27	140	18	14.5	19.5
1"	– 8UNC	TD174782	30	160	20	16	22.25
1 1/8"	– 7UNC	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	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
		○												

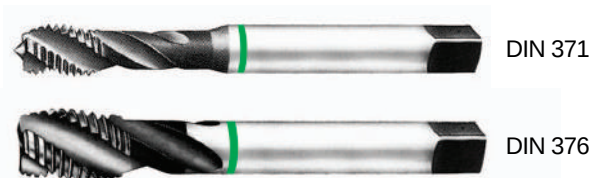
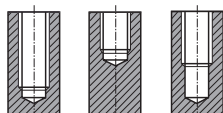
UNC

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



Material groups
VANW

HSS-E

DIN 371/376

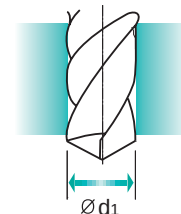
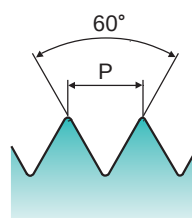
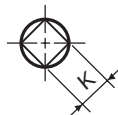
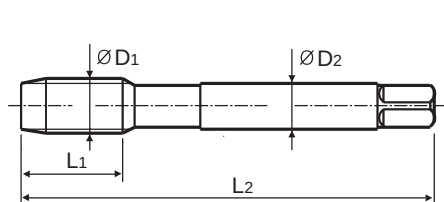
2B



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	40UNC	TB904162	6	56	3.5	2.7	2.3
#5	40UNC	TB904202	7	56	3.5	2.7	2.6
#6	32UNC	TB904242	7	56	4	3	2.85
#8	32UNC	TB904282	8	63	4.5	3.4	3.5
#10	24UNC	TB904322	10	70	6	4.9	3.9
#12	24UNC	TB904362	10	80	6	4.9	4.5
1/4"	20UNC	TB904402	13	80	7	5.5	5.2
5/16"	18UNC	TB904442	14	90	8	6.2	6.6
3/8"	16UNC	TB904482	16	100	9	7	8
7/16"	14UNC	TB904522	17	100	8	6.2	9.4
1/2"	13UNC	TB904562	20	110	9	7	10.75
9/16"	12UNC	TB904602	20	110	11	9	12.25
5/8"	11UNC	TB904642	22	110	12	9	13.5
3/4"	10UNC	TB904702	25	125	14	11	16.5
7/8"	9UNC	TB904742	27	140	18	14.5	19.5
1"	8UNC	TB904782	30	160	20	16	22.25
1 1/8"	7UNC	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
		○												

HSS

CARBIDE

COMBO
TAPSSPIRAL
POINT TAPSSPIRAL
FLUTE TAPSSTRAIGHT
FLUTE TAPSCOLD
FORMING
TAPS

NUT TAPS

STI TAPS

HAND TAPS

PIPE TAPS

CARBIDE
TAPSTHREAD
MILLSTECHNICAL
DATA

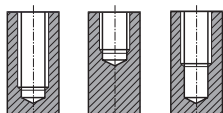
SPIRAL FLUTE TAPS

TC169 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

Material groups

AI

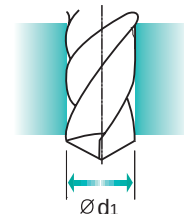
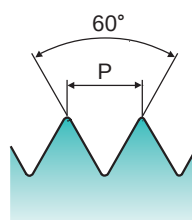
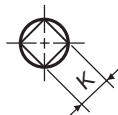
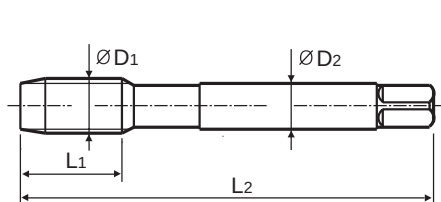
HSS-E

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	– 40UNC	TC169162	6	56	3.5	2.7	2.3
#5	– 40UNC	TC169202	7	56	3.5	2.7	2.6
#6	– 32UNC	TC169242	7	56	4	3	2.85
#8	– 32UNC	TC169282	8	63	4.5	3.4	3.5
#10	– 24UNC	TC169322	10	70	6	4.9	3.9
#12	– 24UNC	TC169362	10	80	6	4.9	4.5
1/4"	– 20UNC	TC169402	13	80	7	5.5	5.2
5/16"	– 18UNC	TC169442	14	90	8	6.2	6.6
3/8"	– 16UNC	TC169482	16	100	9	7	8
7/16"	– 14UNC	TC169522	17	100	8	6.2	9.4
1/2"	– 13UNC	TC169562	20	110	9	7	10.75
9/16"	– 12UNC	TC169602	20	110	11	9	12.25
5/8"	– 11UNC	TC169642	22	110	12	9	13.5
3/4"	– 10UNC	TC169702	25	125	14	11	16.5
7/8"	– 9UNC	TC169742	27	140	18	14.5	19.5
1"	– 8UNC	TC169782	30	160	20	16	22.25
1 1/8"	– 7UNC	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	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
				◎				◎	◎	◎				

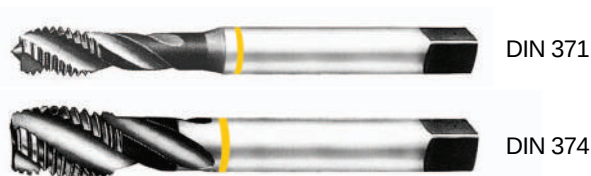
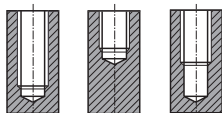
UNF

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



Material groups
GS

HSS-E

DIN 371/374

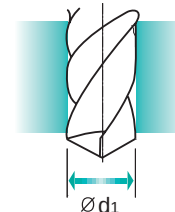
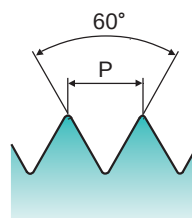
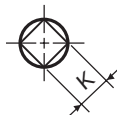
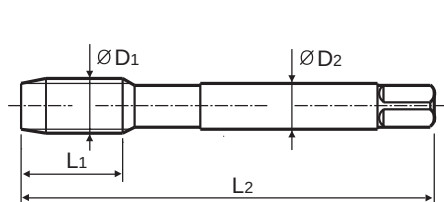
2B



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	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

HSS

CARBIDE

COMBO
TAPSSPIRAL
POINT TAPSSPIRAL
FLUTE TAPSSTRAIGHT
FLUTE TAPSCOLD
FORMING
TAPS

NUT TAPS

STI TAPS

HAND TAPS

PIPE TAPS

CARBIDE
TAPSTHREAD
MILLSTECHNICAL
DATA

SPIRAL FLUTE TAPS

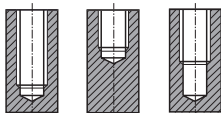
TC184 SERIES

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



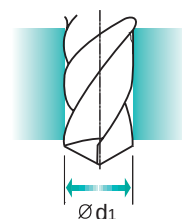
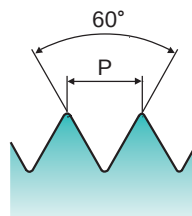
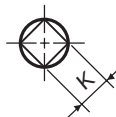
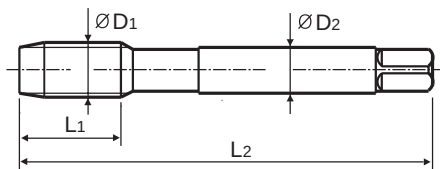
HSS-E

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	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	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
		○												

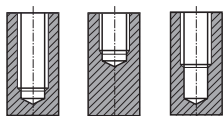
UNF

Unified fine threads
Unified Feingewinde

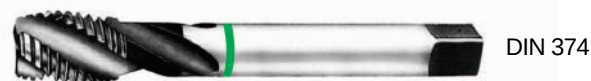
► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

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

Hole type



DIN 371



DIN 374

Material groups
VANW

HSS-E

DIN 371/374

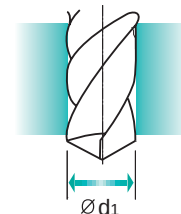
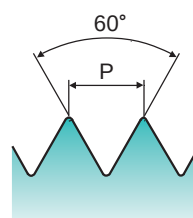
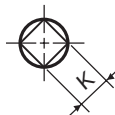
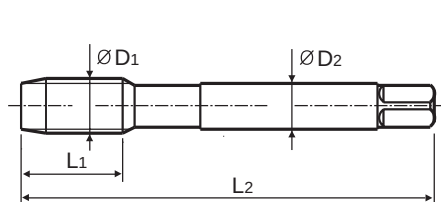
2B



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
		○												

HSS

CARBIDE

COMBO
TAPSSPIRAL
POINT TAPSSPIRAL
FLUTE TAPSSTRAIGHT
FLUTE TAPSCOLD
FORMING
TAPS

NUT TAPS

STI TAPS

HAND TAPS

PIPE TAPS

CARBIDE
TAPSTHREAD
MILLSTECHNICAL
DATA

SPIRAL FLUTE TAPS

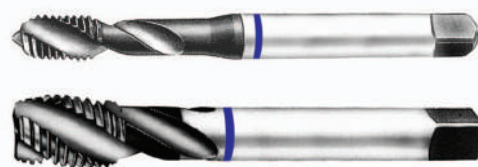
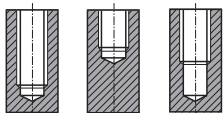
TC170 SERIES

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

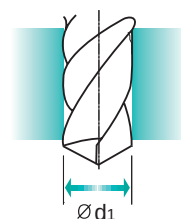
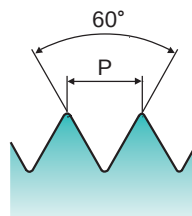
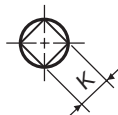
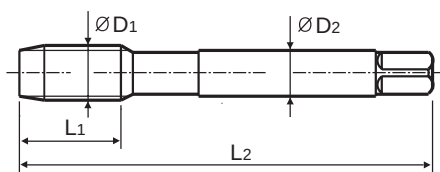
HSS-E

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	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
				◎				◎	◎	◎				

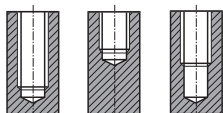
BSW

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

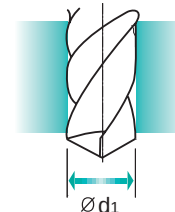
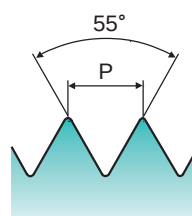
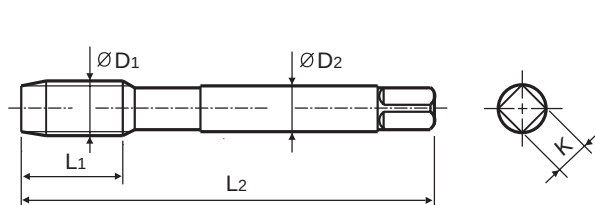
DIN
2182/2183



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	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
					○	○					○			