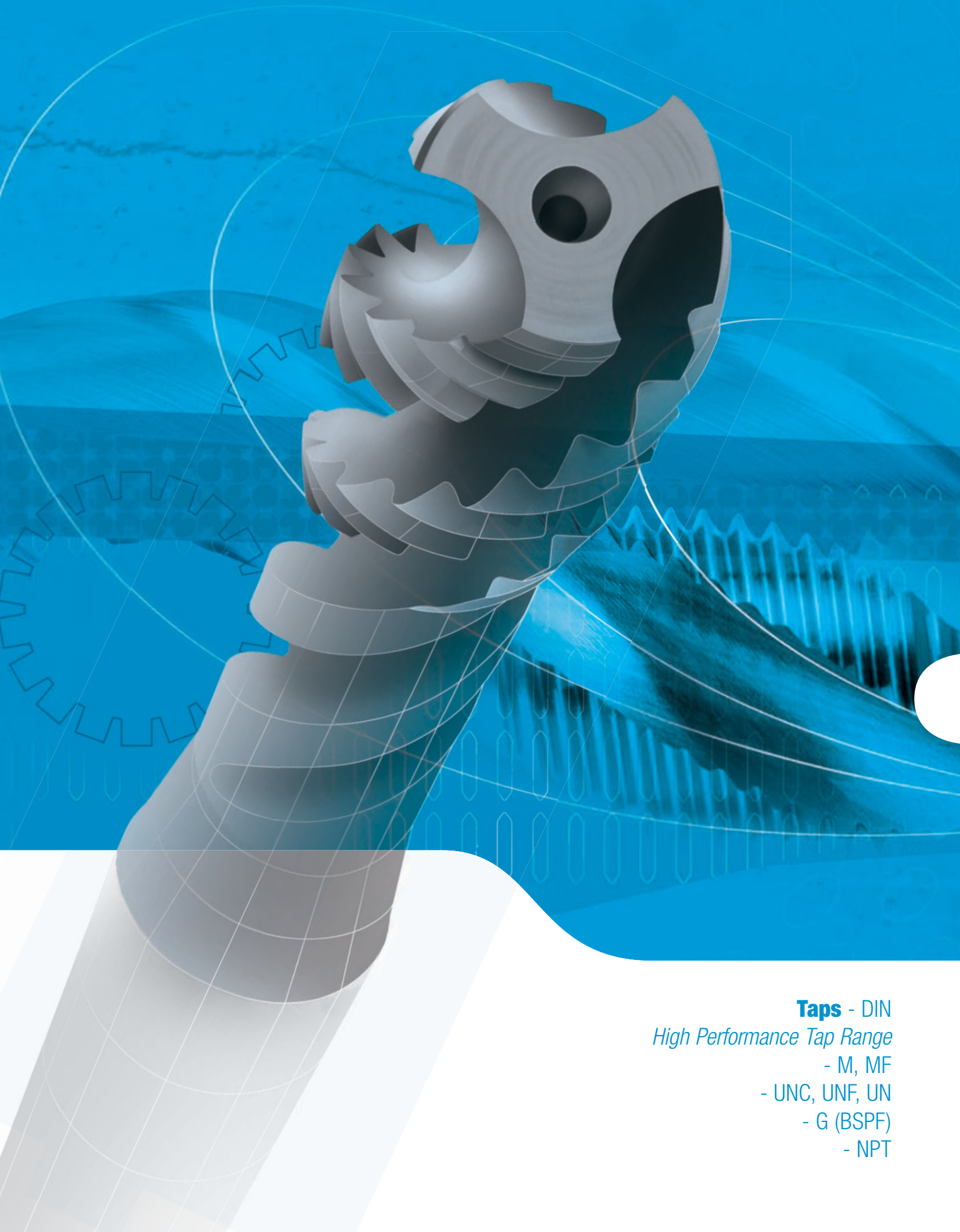


DIN TAPS



Taps - DIN

High Performance Tap Range

- M, MF

- UNC, UNF, UN

- G (BSPF)

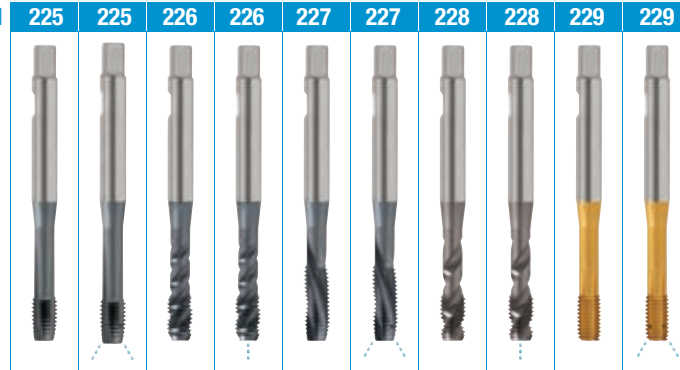
- NPT



For Synchro Tapping



Page M



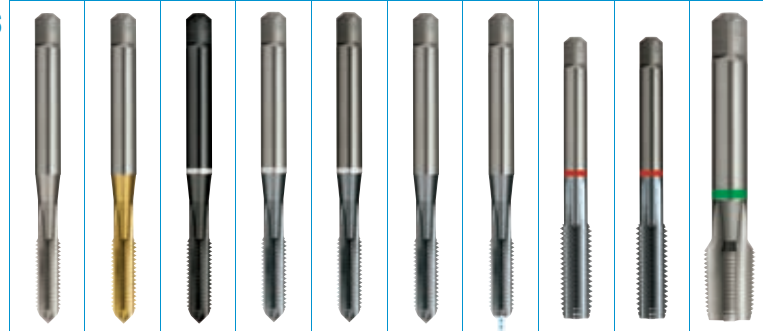
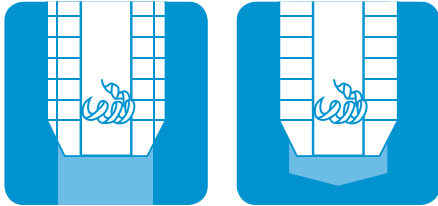
Catalogue Code	T377	T379	T373	T375	T365	T367	T369	T371	T381	T383
Material	PM-HSSE V3									
Surface Finish	TiCN					CrN			TiN	
Application	High Speed Cutting									
Tapping Depth	3 x Ø									
Material Limit & Nut Tolerance	6HX									

Material	HB	N/mm ²	% Elong.	T377	T379	T373	T375	T365	T367	T369	T371	T381	T383
1.0 Steels													
1.1 Mild steels, magnetic soft steel	<200	>200 <400	10	●	●	●	●	●	●			●	●
1.2 Free cutting, structural, unalloyed	<200	>350 <700	30	●	●	●	●	●	●			●	●
1.3 Plain carbon, low alloyed	<300	>350 <850	20	●	●	●	●	●	●			○	○
1.4 Alloy steels harden. / tempered	<250	>500 <850	30	●	●	●	●	●	●				
1.5 Alloy steels harden. / tempered	<350	>850 <1200	30	○	○	○	○	○	○				
1.6 Hardened, heat treated, high tensile alloy	<420	>1500	12	○	○	○	○	○	○				
1.7 Hardened Steel 45-50 Rc	<550		<12										
1.8 Hardened Steel 50-62 Rc	<700		<12										
2.0 Stainless Steels													
2.1 Free machining	<250	<850	25	●	●	●	●	●	●			●	●
2.2 Austenitic	<250	<850	20	●	●	●	●	●	●			●	●
2.3 Ferritic + martensitic	<250	<850	20	●	●	●	●	●	●				
3.0 Cast Irons													
3.1 Lamellar graphite (Grey soft)	<150	<500	10	●	●	○	○	●	●				
3.2 Lamellar graphite (Grey hard)	<300	<1000	10	○	○	○	○	○	○				
3.3 Nodular (spheroidal) graphite & malleable	<200	<700	10	○	○	○	○	○	○				
4.0 Titaniums													
4.1 Pure Titanium	<250	<850	20	●	●	●	●	●	●				
4.2 Titanium alloys	>250	>850	20	●	●	●	●	●	●				
5.0 Nickels													
5.1 Nickel alloys	<250	<850	25	●	●	●	●	●	●				
5.2 Nickel alloys	>250	>850	25										
6.0 Coppers													
6.1 Pure Copper (electrolytic copper)	<120	<400	12	●	●	○	○	●	●	●	●	●	●
6.2 Short chip Brass, Phosphor Bronze, gun metal	<200	<700	12	○	○	○	○	○	○	●	●		
6.3 Long chip Brass, Bronze	<200	<700	12	●	●	○	○	●	●	●	●		
7.0 Aluminiums													
7.1 Aluminium unalloyed	<100	<350	15	●	●	●	○	●	●	●	●	●	●
7.2 Magnesium unalloyed	<150	<350	15	●	●	○	○	●	●	●	●	●	●
7.3 Al Alloyed Si < 1.5 %	<120	<500	15	●	●	○	○	●	●	●	●	●	●
7.4 Al Alloyed 1.5 % < Si < 10%	<120	<400	10	●	●	○	○	●	●	●	●	●	●
7.5 Al Alloyed > 10% Si	-	<400	N	○	○	●	●	○	○				
7.6 Magnesium alloys	-	<400	N	○	○	●	●	○	○				
8.0 Plastics													
8.1 Plastics, Thermoplastics, Polyethylene	<340	<50	N	●	●	○	○	●	●	●	●		

● Optimal ○ Effective

		<i>Tap Straight Flute, N</i>	<i>Tap Straight Flute, N</i>	<i>Tap Straight Flute, GG</i>	<i>Tap Straight Flute, GG</i>	<i>Tap Straight Flute, GG</i>	<i>Tap Straight Flute, DC</i>	<i>Tap Straight Flute, DC, IK</i>	<i>Tap Straight Flute, VH</i>	<i>Tap Straight Flute, UNI</i>
Page	M	230	230	232	232	232	234	234	236	237
	MF	294	294	295	295		296	296		
	UNC			308						
	UNF									
	G (BSPF)	335	335		336					
	NPT									345

For Tapping Through & Blind Holes



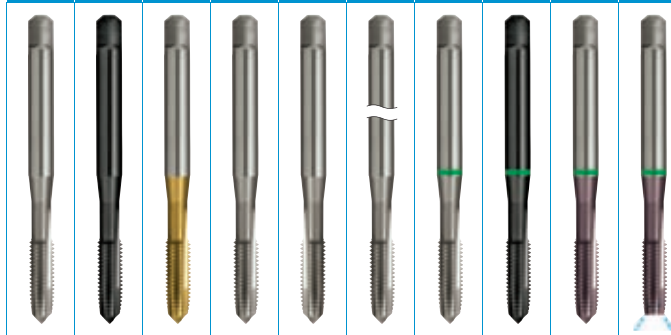
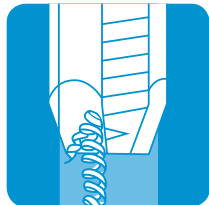
Material	HSSE V3			VHM	PM-HSS Co	SPM	VHM	HSSE V3
Surface Finish	Brt	TiN	Ni+Blu	TiCN			Brt	
Colour Ring & Application	N		GG		DC	XH	VH	UNI
Tapping Depth	≤ 1.5xØ		≤ 3xØ		≤ 1.5xØ			
Material Limit & Nut Tolerance	ISO 2 / 6H		6HX	6H	6HX			ANSI B1.20.1

Material	HB	N/mm²	% Elong.									
1.0 Steels												
1.1 Mild steels, magnetic soft steel	<200	>200 <400	10	●	●							●
1.2 Free cutting, structural, unalloyed	<200	>350 <700	30	●	●							●
1.3 Plain carbon, low alloyed	<300	>350 <850	20	●	●							●
1.4 Alloy steels harden. / tempered	<250	>500 <850	30	○	○							●
1.5 Alloy steels harden. / tempered	<350	>850 <1200	30	○	○					○		○
1.6 Hardened, heat treated, high tensile alloy	<420	>1500	12							●	○	○
1.7 Hardened Steel 45-50 Rc	<550		<12							●	●	
1.8 Hardened Steel 50-62 Rc	<700		<12								●	
2.0 Stainless Steels												
2.1 Free machining	<250	<850	25									○
2.2 Austenitic	<250	<850	20									○
2.3 Ferritic + martensitic	<250	<850	20									○
3.0 Cast Irons												
3.1 Lamellar graphite (Grey soft)	<150	<500	10	○	○	●	●	●	○	○		○
3.2 Lamellar graphite (Grey hard)	<300	<1000	10	○	○	●	●	●	○	○		○
3.3 Nodular (spheroidal) graphite & malleable	<200	<700	10	○	○	○	○	●	○	○		○
4.0 Titaniums												
4.1 Pure Titanium	<250	<850	20									
4.2 Titanium alloys	>250	>850	20									
5.0 Nickels												
5.1 Nickel alloys	<250	<850	25									
5.2 Nickel alloys	>250	>850	25									
6.0 Coppers												
6.1 Pure Copper (electrolytic copper)	<120	<400	12	○	○							○
6.2 Short chip Brass, Phosphor Bronze, gun metal	<200	<700	12	○	○			●	○	○	○	○
6.3 Long chip Brass, Bronze	<200	<700	12	○	○							●
7.0 Aluminiums												
7.1 Aluminium unalloyed	<100	<350	15	○	○							●
7.2 Magnesium unalloyed	<150	<350	15	○	○							●
7.3 Al Alloyed Si < 1.5 %	<120	<500	15	○	○				○	○		○
7.4 Al Alloyed 1.5 % < Si < 10%	<120	<400	10	○	○				●	●		○
7.5 Al Alloyed > 10% Si	-	<400	N				○	●	●	●		
7.6 Magnesium alloys	-	<400	N				○	●	●	●		
8.0 Plastics												
8.1 Plastics, Thermoplastics, Polyethylene	<340	<50	N	●	●			●	●	●		○



	Tap Gun, N	Tap Gun, N	Tap Gun, N	Tap Gun, N	Tap Gun, N, Left Hand	Tap Gun, N, Extra Length	Tap Gun, UNI	Tap Gun, UNI	Tap Gun, UNI	Tap Gun, UNI, IK
Page	238	238	238	240	240	242	244	244	244	244
M	297	297	297	297			299		299	
MF										
UNC	310	310	310					312	312	
UNF	327		327							
G (BSPF)	337	337	337							

For Tapping Through Holes



Material	HSSE V3						PM-HSSE V3			
Surface Finish	Brt	Blu	TIN	Brt			Blu	TiAIN		
Colour Ring & Application	N						UNI			
Tapping Depth	≤ 3xØ									

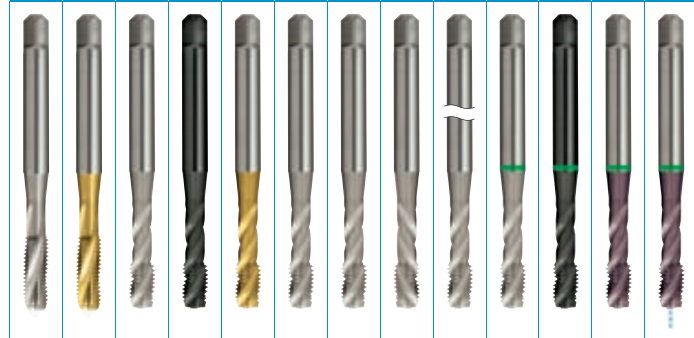
Material	Limit & Nut Tolerance			ISO 2 / 6H									
	HB	N/mm ²	% Elong.	ISO 2 / 6H		ISO 3 / 6G		ISO 2 / 6H					
1.0 Steels													
1.1 Mild steels, magnetic soft steel	<200	>200 <400	10	●	●	●	●	●	●	●	●	●	●
1.2 Free cutting, structural, unalloyed	<200	>350 <700	30	●	●	●	●	●	●	●	●	●	●
1.3 Plain carbon, low alloyed	<300	>350 <850	20	○	●	●	○	○	○	●	●	●	●
1.4 Alloy steels harden. / tempered	<250	>500 <850	30	○	○	●	○	○	○	●	●	●	●
1.5 Alloy steels harden. / tempered	<350	>850 <1200	30						○	○	●	●	
1.6 Hardened, heat treated, high tensile alloy	<420	>1500	12						○	○	○	○	
1.7 Hardened Steel 45-50 Rc	<550		<12										
1.8 Hardened Steel 50-62 Rc	<700		<12										
2.0 Stainless Steels													
2.1 Free machining	<250	<850	25		○	○				○	○	●	●
2.2 Austenitic	<250	<850	20		○	○				○	○	○	●
2.3 Ferritic + martensitic	<250	<850	20		○	○				○	○	○	○
3.0 Cast Irons													
3.1 Lamellar graphite (Grey soft)	<150	<500	10	○	○	○	○	○	○	○	○	○	○
3.2 Lamellar graphite (Grey hard)	<300	<1000	10	○	○	○	○	○	○	○	○	○	○
3.3 Nodular (spheroidal) graphite & malleable	<200	<700	10	○	○	○	○	○	○	○	○	○	○
4.0 Titaniums													
4.1 Pure Titanium	<250	<850	20										
4.2 Titanium alloys	>250	>850	20										
5.0 Nickels													
5.1 Nickel alloys	<250	<850	25										
5.2 Nickel alloys	>250	>850	25										
6.0 Coppers													
6.1 Pure Copper (electrolytic copper)	<120	<400	12							○		○	○
6.2 Short chip Brass, Phosphor Bronze, gun metal	<200	<700	12	○		○	○	○	○	○		○	○
6.3 Long chip Brass, Bronze	<200	<700	12	○		●	○	○	○	●		●	●
7.0 Aluminiums													
7.1 Aluminium unalloyed	<100	<350	15	○		○	○	○	○	○		○	○
7.2 Magnesium unalloyed	<150	<350	15	○		○	○	○	○	○		○	○
7.3 Al Alloyed Si < 1.5 %	<120	<500	15	○		○	○	○	○	○		○	○
7.4 Al Alloyed 1.5 % < Si < 10%	<120	<400	10	○		○	○	○	○	○		○	○
7.5 Al Alloyed > 10% Si	-	<400	N									○	○
7.6 Magnesium alloys	-	<400	N									○	○
8.0 Plastics													
8.1 Plastics, Thermoplastics, Polyethylene	<340	<50	N	●		●	●	●	●	●	●	●	●

● Optimal ○ Effective



Page	M	262	264	264	266	266	266	268	270	270	270	270
	MF	302	303	303	303				304		304	
	UNC		318	318	318					320	320	
	UNF		331									
	G (BSPF)	340	340	341	341	341						

For Tapping Blind Holes



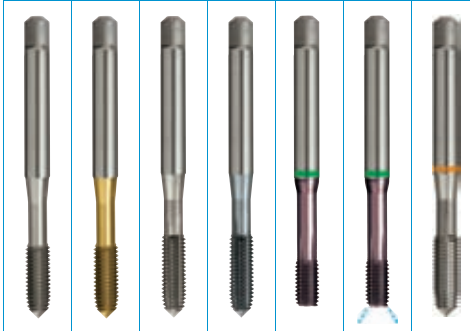
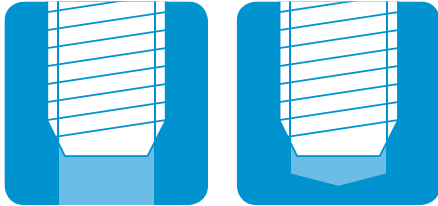
Material	HSSE V3								PM-HSSE V3				
Surface Finish	BrT	TiN	BrT	Blu	TiN	BrT				Blu	TiAIN		
Colour Ring & Application	N								UNI				
Tapping Depth	≤ 1.5xØ				≤ 3xØ								
Material	Limit & Nut Tolerance			ISO 2 / 6H			ISO 2 / 6H			ISO 3 / 6G / ISO 1 / 4H		ISO 2 / 6H	

Material	HB	N/mm ²	% Elong.	1	2	3	4	5	6	7	8	9	10	11	12	13	
1.0 Steels																	
1.1 Mild steels, magnetic soft steel	<200	>200 <400	10	●	●	●	●	●	●	●	●	●	●	●	●	●	
1.2 Free cutting, structural, unalloyed	<200	>350 <700	30	●	●	●	●	●	●	●	●	●	●	●	●	●	
1.3 Plain carbon, low alloyed	<300	>350 <850	20	○	●	○	●	○	○	○	○	○	○	○	○	○	
1.4 Alloy steels harden. / tempered	<250	>500 <850	30	○	○	○	○	○	○	○	○	○	○	○	○	○	
1.5 Alloy steels harden. / tempered	<350	>850 <1200	30	○	○		○					○	○	○	○	○	
1.6 Hardened, heat treated, high tensile alloy	<420	>1500	12											○	○	○	
1.7 Hardened Steel 45-50 Rc	<550		<12														
1.8 Hardened Steel 50-62 Rc	<700		<12														
2.0 Stainless Steels																	
2.1 Free machining	<250	<850	25		○		○	○	○	○	○	○	○	○	○	○	○
2.2 Austenitic	<250	<850	20		○		○	○	○	○	○	○	○	○	○	○	○
2.3 Ferritic + martensitic	<250	<850	20				○	○	○	○	○	○	○	○	○	○	○
3.0 Cast Irons																	
3.1 Lamellar graphite (Grey soft)	<150	<500	10	○	○	○	○	○	○	○	○	○	○	○	○	○	○
3.2 Lamellar graphite (Grey hard)	<300	<1000	10	○	○	○	○	○	○	○	○	○	○	○	○	○	○
3.3 Nodular (spheroidal) graphite & malleable	<200	<700	10	○	○	○	○	○	○	○	○	○	○	○	○	○	○
4.0 Titaniums																	
4.1 Pure Titanium	<250	<850	20		○												
4.2 Titanium alloys	>250	>850	20		○												
5.0 Nickels																	
5.1 Nickel alloys	<250	<850	25		○												
5.2 Nickel alloys	>250	>850	25														
6.0 Coppers																	
6.1 Pure Copper (electrolytic copper)	<120	<400	12													○	○
6.2 Short chip Brass, Phosphor Bronze, gun metal	<200	<700	12	○	○	○	○	○	○	○	○	○	○	○	○	○	○
6.3 Long chip Brass, Bronze	<200	<700	12	○	○	○	○	○	○	○	○	○	○	○	○	○	○
7.0 Aluminiums																	
7.1 Aluminium unalloyed	<100	<350	15	○	○	○	○	○	○	○	○	○	○	○	○	○	○
7.2 Magnesium unalloyed	<150	<350	15	○	○	○	○	○	○	○	○	○	○	○	○	○	○
7.3 Al Alloyed Si < 1.5 %	<120	<500	15	○	○	○	○	○	○	○	○	○	○	○	○	○	○
7.4 Al Alloyed 1.5 % < Si < 10%	<120	<400	10	○	○	○	○	○	○	○	○	○	○	○	○	○	○
7.5 Al Alloyed > 10% Si	-	<400	N												○	○	
7.6 Magnesium alloys	-	<400	N												○	○	
8.0 Plastics																	
8.1 Plastics, Thermoplastics, Polyethylene	<340	<50	N	●	●	●	●	●	●	●	●	●	●	●	●	●	●



Page	M	289	289		290	292	292	292	290
	MF								
	UNC								
	UNF								
	G (BSPF)			344	344				

For Thread Forming

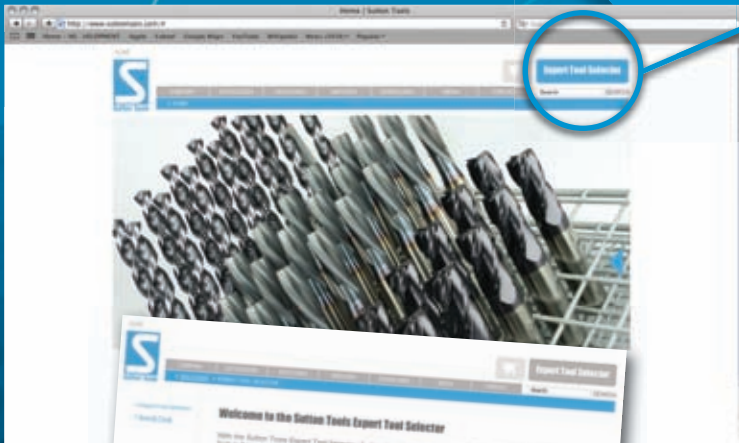


Material	HSSE V3				SPM		HSSE V3	
Surface Finish	Brt	TiN	Brt	TiCN	TiAlN		CrN	
Colour Ring & Application	N				UNI		Cu	
Tapping Depth	≤ 1.5xØ			≤ 3xØ				
Material Limit & Nut Tolerance	6HX		ISO 228 X	6HX				

Material	HB	N/mm²	% Elong.	6HX	ISO 228 X	6HX	6HX	6HX	6HX	6HX
1.0 Steels										
1.1 Mild steels, magnetic soft steel	<200	>200 <400	10	○	●	●	●	●	●	
1.2 Free cutting, structural, unalloyed	<200	>350 <700	30	○	●	○	●	●	●	
1.3 Plain carbon, low alloyed	<300	>350 <850	20		○	○	○	●	●	
1.4 Alloy steels harden. / tempered	<250	>500 <850	30					○	○	
1.5 Alloy steels harden. / tempered	<350	>850 <1200	30							
1.6 Hardened, heat treated, high tensile alloy	<420	>1500	12							
1.7 Hardened Steel 45-50 Rc	<550		<12							
1.8 Hardened Steel 50-62 Rc	<700		<12							
2.0 Stainless Steels										
2.1 Free machining	<250	<850	25		●		●	●	●	
2.2 Austenitic	<250	<850	20		●		●	●	●	
2.3 Ferritic + martensitic	<250	<850	20							
3.0 Cast Irons										
3.1 Lamellar graphite (Grey soft)	<150	<500	10							
3.2 Lamellar graphite (Grey hard)	<300	<1000	10							
3.3 Nodular (spheroidal) graphite & malleable	<200	<700	10							
4.0 Titaniums										
4.1 Pure Titanium	<250	<850	20							
4.2 Titanium alloys	>250	>850	20							
5.0 Nickels										
5.1 Nickel alloys	<250	<850	25							
5.2 Nickel alloys	>250	>850	25							
6.0 Coppers										
6.1 Pure Copper (electrolytic copper)	<120	<400	12	○	○	○	○	○	○	●
6.2 Short chip Brass, Phosphor Bronze, gun metal	<200	<700	12							
6.3 Long chip Brass, Bronze	<200	<700	12	●	●	○	●	●	●	●
7.0 Aluminiums										
7.1 Aluminium unalloyed	<100	<350	15	●	●	●	●	●	●	●
7.2 Magnesium unalloyed	<150	<350	15	●	○	●	○	●	●	●
7.3 Al Alloyed Si < 1.5 %	<120	<500	15	●	○	●	○	●	●	●
7.4 Al Alloyed 1.5 % < Si < 10%	<120	<400	10	○	○	○	○	●	●	●
7.5 Al Alloyed > 10% Si	-	<400	N							
7.6 Magnesium alloys	-	<400	N							
8.0 Plastics										
8.1 Plastics, Thermoplastics, Polyethylene	<340	<50	N							

online material based product selection...

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SynchroFlex Tapping Attachment with unique Double Flexure



Unlike other “synchronous” tap drivers that use soft plastic components or Belleville washers similar as above, to cushion the taps’ entry into the hole, SynchroFlex utilizes a patented (computer generated, precisely machined, special steel alloy) Double Flexure between the mount and the chuck.

It compensates both axially and radially for the unavoidable discrepancies between the machine’s programmed RPM, feed and traverse and the exact thread pitch and precise hole location.

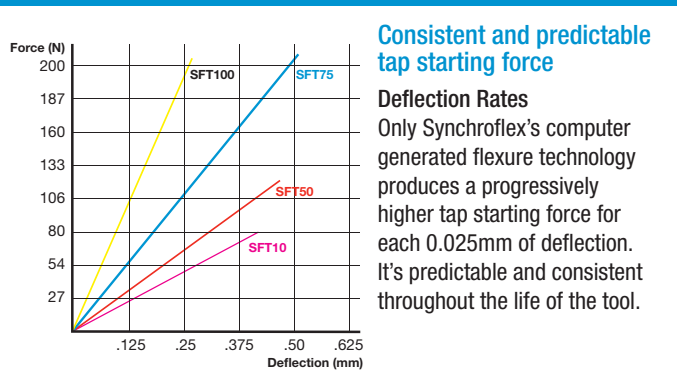
The SynchroFlex is dependable and predictable. You can expect long life performance under all working conditions. What’s more, you’ll make significant savings when it comes to tap costs.

Synchroflex Proven Results

Independent tests in real world applications confirm Synchroflex is unmatched in performance

- Tap life increased by 100% or more
- Thread quality improved
- Increased production due to less tap breakage
- Less down time
- Reduced costs. The most economical rigid tapping

Synchroflex exerts lower thrust and torque forces than any other tap holder on the market. In any given material the lower the thrust and torque forces on the tap, the longer the tap life.

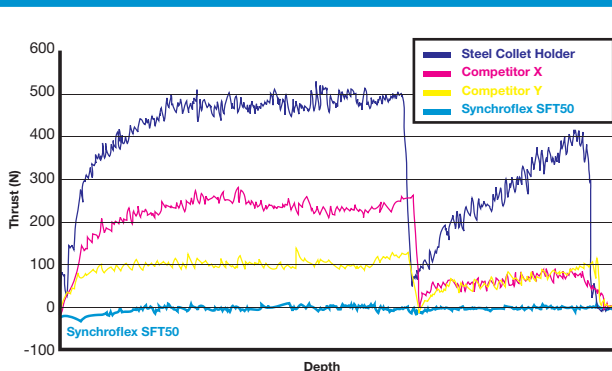


Test One (Thrust): 10 holes, M6 R45Al, 2 flute tap, 3x Dia deep in AL7075 at 1000 RPM

Holder Type	Average Thrust (N)	Average Down Cut Thrust (N) Entering Hole	Average Reverse Thrust (N) Exiting Hole
Steel Collet Holder (Rigid)	1008	1379	930
Competitor X	681	879	445
Competitor Y	320	425	266
Synchroflex	-12	-29	-31

Test Two (Torque): 10 holes, M6 R45Al, 2 flute tap, 3x Dia deep in AL7075 at 2000 RPM

Holder Type	Average Torque (Ncm)	Average Down Cut Torque (Ncm) Entering Hole	Average Reverse Torque (Ncm) Exiting Hole
Steel Collet Holder (Rigid)	481	631	-387
Competitor X	593	639	-354
Competitor Y	542	730	-392
Synchroflex	268	371	-190

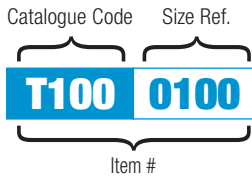


Graph illustrates the final hole tapped by each tap driver.

Tool Holding CNC - Rigid Tapping



- For the best rigid tapping results
- Holder designed for machines with rigid tapping
- Machine reversal required
- Increases tap life by 100% or more
- Improve thread quality
- Flexure design, acts like shock absorber



BT-40 Arbor



ER25 Collet
(Sq. Drive)



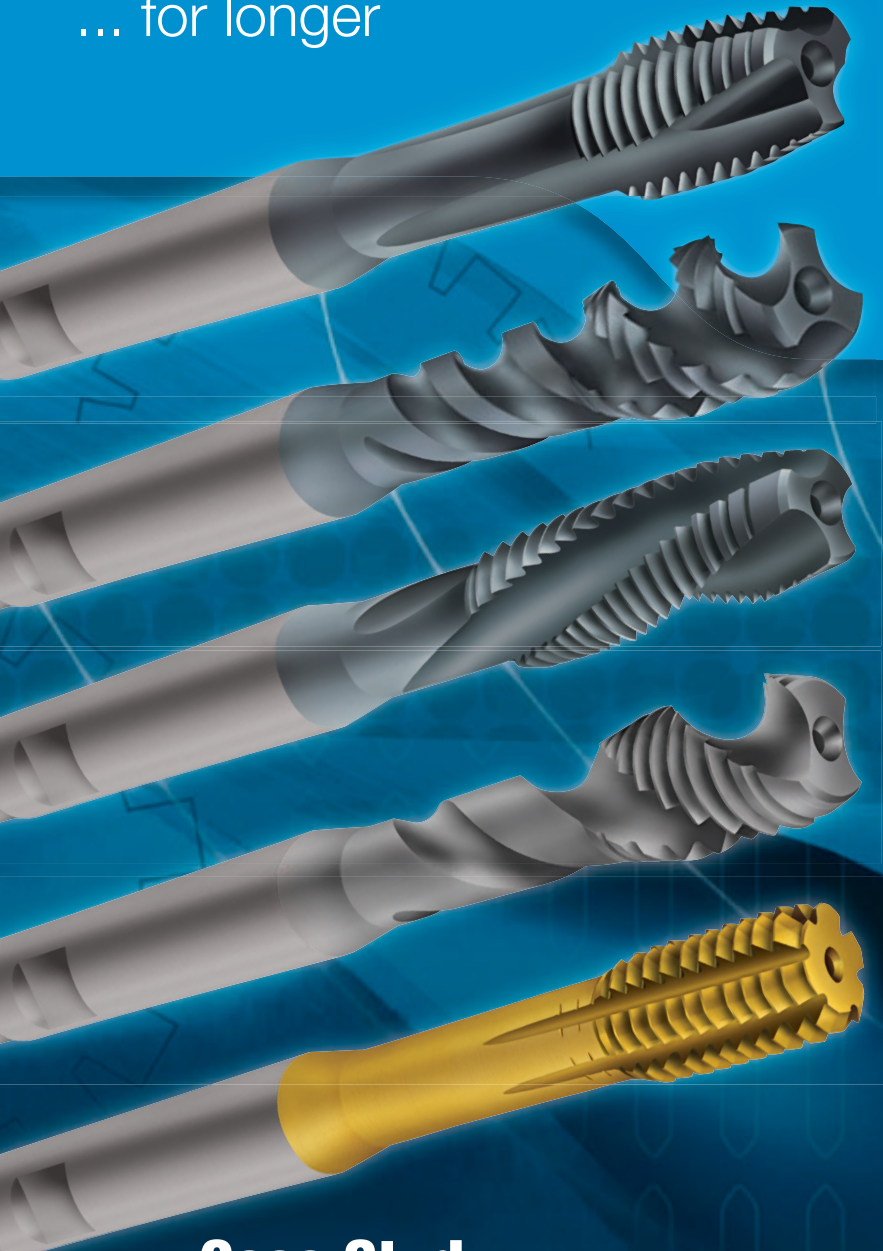
Size Ref.	Description	Size Capacity	Mount	Collet Series	Item #
Tapping Attachments (Discount Group Z1104)					
SFT10	Synchroflex SFT10	M1-M6 #2-#10	25mm SS	ER11	Z101 SFT10
SFT50	Synchroflex SFT50	M4-M12 #8-1/2	25mm SS	ER20	Z101 SFT50
SFT75	Synchroflex SFT75	M4-M16 3/8 - 3/4	25mm SS	ER25	Z101 SFT75
SFT100	Synchroflex SFT100	M8-M30	25mm SS	ER40	Z101 SFT100
Collets - SFT10 (Round Drive) (Discount Group Z1110)					
0025	2-2.5mm	M1-1,8	-	ER11	Z110 0025
0030	2.5-3mm	M2-2,6	-	ER11	Z110 0030
0035	3-3.5mm	M3	-	ER11	Z110 0035
0040	3.5-4mm	M3,5	-	ER11	Z110 0040
0045	4-4.5mm	M4	-	ER11	Z110 0045
0050	4.5-5mm	M4 JIS	-	ER11	Z110 0050
0055	5-5.5mm	M5 JIS	-	ER11	Z110 0055
0060	5.5-6mm	M5/M6 or M2-M6 Synchro	-	-	Z110 0060
Collets - SFT50 (Square Drive) (Discount Group Z1110)					
0045	Ø 4.5mm	M4 DIN371	-	ER20	Z111 0045
0050	Ø 5mm	ISO	-	ER20	Z111 0050
0060	Ø 6mm	M5/M6 DIN371 or M2-M6 Synchro	-	ER20	Z111 0060
0070	Ø 7mm	M10 DIN376	-	ER20	Z111 0070
0080	Ø 8mm	M8 DIN371 or M8 Synchro	-	ER20	Z111 0080
0090	Ø 9mm	M12 DIN376	-	ER20	Z111 0090
0100	Ø 10mm	M10 DIN371 or M10 Synchro	-	ER20	Z111 0100
Collets - SFT75 (Square Drive) (Discount Group Z1110)					
0045	Ø 4.5mm	M4 DIN371	-	ER25	Z112 0045
0060	Ø 6mm	M5/M6 DIN371 or M2-M6 Synchro	-	ER25	Z112 0060
0070	Ø 7mm	M10 DIN371	-	ER25	Z112 0070
0080	Ø 8mm	M8 DIN371 or M8 Synchro	-	ER25	Z112 0080
0090	Ø 9mm	M12 DIN376	-	ER25	Z112 0090
0100	Ø 10mm	M10 DIN371 or M10 Synchro	-	ER25	Z112 0100
0110	Ø 11mm	M14 DIN376	-	ER25	Z112 0110
0120	Ø 12mm	M16 DIN376 or M12 Synchro	-	ER25	Z112 0120
Collets - SFT100 (Square Drive) (Discount Group Z1110)					
0080	Ø 8mm	M8 DIN371 or M8 Synchro	-	ER40	Z112 0045
0010	Ø 10mm	M10 DIN371 or M10 Synchro	-	ER40	Z112 0060
0012	Ø 12mm	M16 DIN376 or M12 Synchro	-	ER40	Z112 0070
0014	Ø 14mm	M18 DIN376 or M14 Synchro	-	ER40	Z112 0080
0016	Ø 16mm	M20 DIN376 or M16 Synchro	-	ER40	Z112 0090
Accessories (Discount Group Z1108)					
3943	BT-40 Arbor W/25mm Bore	-	-	-	Z130 3943
3945	BT-50 Arbor W/25mm Bore	-	-	-	Z130 3945
Z135					
BT40	Pull stud BT40	-	-	-	Z135 BT40
BT50	Pull stud BT50	-	-	-	Z135 BT50



Patented Flexure Design

Tapping Just Got Faster...

... for longer



Gun Synchro

Through holes in general, heat treatable & stainless steels, aluminium, and copper alloys

R50 Synchro

Blind holes in general, heat treatable & stainless steels,

L20 Synchro

Through holes with interruptions or angular exit in general, heat treatable & stainless steels, aluminium, and copper alloys

R45 Synchro

Blind holes in wrought and low silicon aluminium, and copper alloys

RLC Synchro

Forming blind or through holes in general, heat treatable & stainless steels, aluminium, and copper alloys

Case Study

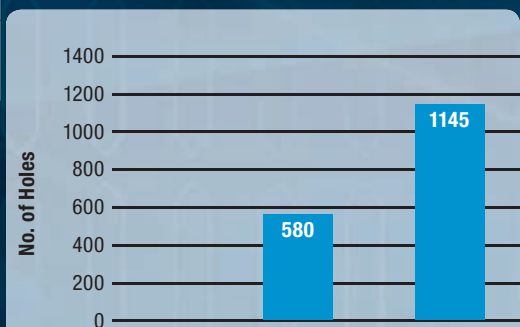
Material: AISI 4140/ 1.7223 / 41CrMo4/ SCM440
Tap size: M6
Drill size: 5.1
Depth: 12mm (blind hole)
Machine: Haas VF2-SS
Lubrication: Emulsion 7%

Comments:

- Synchro taps reduce costs & cycle time
- With the additional use of Synchroflex holder, approx 100% longer tap life was achieved.

Inputs:

Vc (m/min)	12	25
Pitch	1	1
Size	M6	M6
RPM	636	1325
Feed (mm/min)	636	1325
Depth	12	12

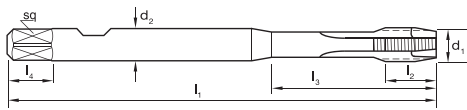


Tap type	R40-N TiN	R50 Sync TiCN
Material:	HSSE-V	PM-HSSE
Vc:	12m/min	25m/min
Tapping process:	Floating holder	Rigid holder
Holder type:	with length compensation	Tapmatic Synchroflex
Machine hourly rate:	\$150.00	\$150.00
Tool Cost:	\$36.34	\$54.50
Time/hole(secs):	5.7	2.7
Cost per hole:	\$0.30	\$0.16

DIN Taps Metric, Synchro, Gun



- For high speed and precision tapping
- For rigid tapping in CNC machines with synchronised feed
- Suitable for materials up to 850N/mm²
- Through holes up to 3 x d₁
- h6 endmill shank



Catalogue Code Size Ref.



Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
0200	M 2 x 0.40		70	4	13	6.0	4.9	8.0	3	1.6
0250	M 2.5 x 0.45		70	4.5	14	6.0	4.9	8.0	3	2.1
0300	M 3 x 0.50		70	5	18	6.0	4.9	8.0	3	2.5
0400	M 4 x 0.70		70	7	21	6.0	4.9	8.0	3	3.3
0500	M 5 x 0.80		70	8	25	6.0	4.9	8.0	3	4.2
0600	M 6 x 1.00		80	10	30	6.0	4.9	8.0	3	5.0
0805	MF 8 x 1.00		90	13	30	8.0	6.2	9.0	3	7.0
0800	M 8 x 1.25		90	13	35	8.0	6.2	9.0	3	6.8
1005	MF 10 x 1.00		100	15	39	10.0	8.0	11.0	3	9.0
1006	MF 10 x 1.25		100	15	39	10.0	8.0	11.0	3	8.8
1000	M 10 x 1.50		100	15	39	10.0	8.0	11.0	3	8.5
1205	MF 12 x 1.00		110	18	45	12.0	9.0	12.0	3	11.0
1206	MF 12 x 1.25		110	18	45	12.0	9.0	12.0	3	10.8
1207	MF 12 x 1.50		110	18	45	12.0	9.0	12.0	3	10.5
1200	M 12 x 1.75		110	18	44	12.0	9.0	12.0	3	10.3
1400	M 14 x 2.00		110	20	44	14.0	11.0	14.0	3	12.0
1600	M 16 x 2.00		110	20	44	16.0	12.0	15.0	4	14.0
1800	M 18 x 2.50		125	25	-	16.0	12.0	15.0	4	15.5
2000	M 20 x 2.50		140	25	-	16.0	12.0	15.0	4	17.5



Catalogue Code	T377	T379
Discount Group	D0412	D0412
Material	PM-HSSE V3	PM-HSSE V3
Surface Finish	TICN	TICN
Geometry		Internal Coolant
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P
Shank Form (~DIN 1835)	B	B
Limit & Nut Tolerance	6HX	6HX

Item #	Item #
T377 0200	
T377 0250	
T377 0300	
T377 0400	
T377 0500	T379 0500
T377 0600	T379 0600
•	•
T377 0800	T379 0800
•	•
•	•
T377 1000	T379 1000
•	•
•	•
•	•
T377 1200	T379 1200
T377 1400	T379 1400
T377 1600	T379 1600
T377 1800	T379 1800
T377 2000	T379 2000

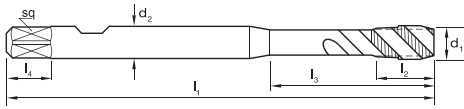
• Available on request as special manufacture. Subject to lead time.



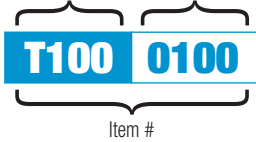
DIN Taps Metric, Synchro, Spiral Flute, R50



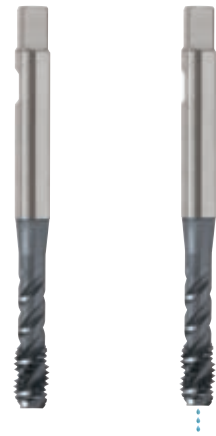
- For high speed and precision tapping
- For rigid tapping in CNC machines with synchronised feed
- Suitable for materials up to 850N/mm²
- Blind holes up to 3 x d₁
- h6 endmill shank



Catalogue Code Size Ref.



Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
0200	M 2	x 0.40	70	4	13	6.0	4.9	8.0	3	1.6
0250	M 2.5	x 0.45	70	4.5	14	6.0	4.9	8.0	3	2.1
0300	M 3	x 0.50	70	5	18	6.0	4.9	8.0	3	2.5
0400	M 4	x 0.70	70	7	21	6.0	4.9	8.0	3	3.3
0500	M 5	x 0.80	70	8	25	6.0	4.9	8.0	3	4.2
0600	M 6	x 1.00	80	10	30	6.0	4.9	8.0	3	5.0
0805	MF 8	x 1.00	90	13	30	8.0	6.2	9.0	3	7.0
0800	M 8	x 1.25	90	13	35	8.0	6.2	9.0	3	6.8
1005	MF 10	x 1.00	100	15	39	10.0	8.0	11.0	3	9.0
1006	MF 10	x 1.25	100	15	39	10.0	8.0	11.0	3	8.8
1000	M 10	x 1.50	100	15	39	10.0	8.0	11.0	3	8.5
1205	MF 12	x 1.00	110	18	45	12.0	9.0	12.0	3	11.0
1206	MF 12	x 1.25	110	18	45	12.0	9.0	12.0	3	10.8
1207	MF 12	x 1.50	110	18	45	12.0	9.0	12.0	3	10.5
1200	M 12	x 1.75	110	18	44	12.0	9.0	12.0	4	10.3
1400	M 14	x 2.00	110	20	44	14.0	11.0	14.0	4	12.0
1600	M 16	x 2.00	110	20	44	16.0	12.0	15.0	4	14.0
1800	M 18	x 2.50	125	25	-	16.0	12.0	15.0	4	15.5
2000	M 20	x 2.50	140	25	-	16.0	12.0	15.0	4	17.5



Catalogue Code	T373	T375
Discount Group	D0412	D0412
Material	PM-HSSE V3	PM-HSSE V3
Surface Finish	TICN	TICN
Geometry	R50°	R50° Internal Coolant
Chamfer	Form C / 2.5 x P	Form C / 2.5 x P
Shank Form (~DIN 1835)	B	B
Limit & Nut Tolerance	6HX	6HX

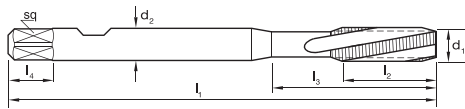
Item #	Item #
T373 0200	
T373 0250	
T373 0300	
T373 0400	
T373 0500	T375 0500
T373 0600	T375 0600
•	•
T373 0800	T375 0800
•	•
•	•
T373 1000	T375 1000
•	•
•	•
•	•
T373 1200	T375 1200
T373 1400	T375 1400
T373 1600	T375 1600
T373 1800	T375 1800
T373 2000	T375 2000

• Available on request as special manufacture. Subject to lead time.

DIN Taps Metric, Synchro, Spiral Flute, L20



- Right hand cutting / Left hand helix
- For high speed and precision tapping
- For rigid tapping in CNC machines with synchronised feed
- Suitable for materials up to 850N/mm²
- Ideal for through holes with angular exit or interrupted hole



Catalogue Code Size Ref.



Catalogue Code	T365	T367
Discount Group	D0412	D0412
Material	PM-HSSE V3	PM-HSSE V3
Surface Finish	TICN	TICN
Geometry	L20°	L20° Internal Coolant
Chamfer	Form D / 4 x P	Form D / 4 x P
Shank Form (~DIN 1835)	B	B
Limit & Nut Tolerance	6HX	6HX

Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #
0200	M 2 x 0.40		70	8	13	6.0	4.9	8.0	3	1.6	T365 0200	
0250	M 2.5 x 0.45		70	9	14	6.0	4.9	8.0	3	2.1	T365 0250	
0300	M 3 x 0.50		70	11	18	6.0	4.9	8.0	3	2.5	T365 0300	
0400	M 4 x 0.70		70	13	21	6.0	4.9	8.0	3	3.3	T365 0400	
0500	M 5 x 0.80		70	16	25	6.0	4.9	8.0	3	4.2	T365 0500	T367 0500
0600	M 6 x 1.00		80	19	30	6.0	4.9	8.0	3	5.0	T365 0600	T367 0600
0805	MF 8 x 1.00		90	13	30	8.0	6.2	9.0	3	7.0	•	•
0800	M 8 x 1.25		90	22	35	8.0	6.2	9.0	3	6.8	T365 0800	T367 0800
1005	MF 10 x 1.00		100	15	39	10.0	8.0	11.0	3	9.0	•	•
1006	MF 10 x 1.25		100	15	39	10.0	8.0	11.0	3	8.8	•	•
1000	M 10 x 1.50		100	24	39	10.0	8.0	11.0	3	8.5	T365 1000	T367 1000
1205	MF 12 x 1.00		110	18	45	12.0	9.0	12.0	3	11.0	•	•
1206	MF 12 x 1.25		110	18	45	12.0	9.0	12.0	3	10.8	•	•
1207	MF 12 x 1.50		110	18	45	12.0	9.0	12.0	3	10.5	•	•
1200	M 12 x 1.75		110	29	44	12.0	9.0	12.0	3	10.3	T365 1200	T367 1200
1400	M 14 x 2.00		110	30	44	14.0	11.0	14.0	4	12.0	T365 1400	T367 1400
1600	M 16 x 2.00		110	32	44	16.0	12.0	15.0	4	14.0	T365 1600	T367 1600
1800	M 18 x 2.50		125	34	-	16.0	12.0	15.0	4	15.5	T365 1800	T367 1800
2000	M 20 x 2.50		140	34	-	16.0	12.0	15.0	4	17.5	T365 2000	T367 2000

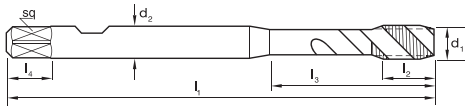
• Available on request as special manufacture. Subject to lead time.



DIN Taps Metric, Synchro, Spiral Flute, R45 Al



- For high speed and precision tapping
- For rigid tapping in CNC machines with synchronised feed
- For aluminium & aluminium alloys
- Blind holes up to $3 \times d_1$
- h6 endmill shank



Catalogue Code Size Ref.



Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
0200	M 2	x 0.40	70	4	13	6.0	4.9	8.0	2	1.6
0250	M 2.5	x 0.45	70	4.5	14	6.0	4.9	8.0	2	2.1
0300	M 3	x 0.50	70	5	18	6.0	4.9	8.0	2	2.5
0400	M 4	x 0.70	70	7	21	6.0	4.9	8.0	2	3.3
0500	M 5	x 0.80	70	8	25	6.0	4.9	8.0	2	4.2
0600	M 6	x 1.00	80	10	30	6.0	4.9	8.0	2	5.0
0805	MF 8	x 1.00	90	13	30	8.0	6.2	9.0	3	7.0
0800	M 8	x 1.25	90	13	35	8.0	6.2	9.0	2	6.8
1005	MF 10	x 1.00	100	15	39	10.0	8.0	11.0	3	9.0
1006	MF 10	x 1.25	100	15	39	10.0	8.0	11.0	3	8.8
1000	M 10	x 1.50	100	15	39	10.0	8.0	11.0	2	8.5
1205	MF 12	x 1.00	110	18	45	12.0	9.0	12.0	3	11.0
1206	MF 12	x 1.25	110	18	45	12.0	9.0	12.0	3	10.8
1207	MF 12	x 1.50	110	18	45	12.0	9.0	12.0	3	10.5
1200	M 12	x 1.75	110	18	44	12.0	9.0	12.0	2	10.3
1400	M 14	x 2.00	110	20	44	14.0	11.0	14.0	2	12.0
1600	M 16	x 2.00	110	20	44	16.0	12.0	15.0	2	14.0
1800	M 18	x 2.50	125	25	-	16.0	12.0	15.0	2	15.5
2000	M 20	x 2.50	140	25	-	16.0	12.0	15.0	2	17.5



Catalogue Code	T369	T371
Discount Group	D0412	D0412
Material	PM-HSSE V3	PM-HSSE V3
Surface Finish	CrN	CrN
Geometry	R45°	R45° Internal Coolant
Chamfer	Form C / 2.5 x P	Form C / 2.5 x P
Shank Form (~DIN 1835)	B	B
Limit & Nut Tolerance	6HX	6HX

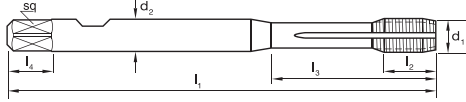
Item #	Item #
T369 0200	
T369 0250	
T369 0300	
T369 0400	
T369 0500	T371 0500
T369 0600	T371 0600
•	•
T369 0800	T371 0800
•	•
•	•
T369 1000	T371 1000
•	•
•	•
•	•
T369 1200	T371 1200
T369 1400	T371 1400
T369 1600	T371 1600
T369 1800	T371 1800
T369 2000	T371 2000

• Available on request as special manufacture. Subject to lead time.

DIN Taps Metric, Synchro, Forming



- For high speed and precision tapping
- For rigid tapping in CNC machines with synchronised feed
- For aluminium and aluminium alloys
- Process of plastic deformation to imprint thread on material
- Blind and through holes up to 3 x d₁
- h6 endmill shank



Catalogue Code Size Ref.



Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #
0200	M 2 x 0.40		70	4	13	6.0	4.9	8.0	1.8		T381 0200	
0250	M 2.5 x 0.45		70	4.5	14	6.0	4.9	8.0	2.3		T381 0250	
0300	M 3 x 0.50		70	5	18	6.0	4.9	8.0	2.8		T381 0300	
0400	M 4 x 0.70		70	7	21	6.0	4.9	8.0	3.7		T381 0400	
0500	M 5 x 0.80		70	8	25	6.0	4.9	8.0	4.6		T381 0500	T383 0500
0600	M 6 x 1.00		80	10	30	6.0	4.9	8.0	5.5		T381 0600	T383 0600
0805	MF 8 x 1.00		90	13	30	8.0	6.2	9.0	7.5		•	•
0800	M 8 x 1.25		90	13	35	8.0	6.2	9.0	7.4		T381 0800	T383 0800
1005	MF 10 x 1.00		100	15	39	10.0	8.0	11.0	9.5		•	•
1006	MF 10 x 1.25		100	15	39	10.0	8.0	11.0	9.4		•	•
1000	M 10 x 1.50		100	15	39	10.0	8.0	11.0	9.3		T381 1000	T383 1000
1205	MF 12 x 1.00		110	18	45	12.0	9.0	12.0	11.5		•	•
1206	MF 12 x 1.25		110	18	45	12.0	9.0	12.0	11.4		•	•
1207	MF 12 x 1.50		110	18	45	12.0	9.0	12.0	11.3		•	•
1200	M 12 x 1.75		110	18	44	12.0	9.0	12.0	11.2		T381 1200	T383 1200
1400	M 14 x 2.00		110	20	44	14.0	11.0	14.0	13.1		T381 1400	T383 1400
1600	M 16 x 2.00		110	20	44	16.0	12.0	15.0	15.1		T381 1600	T383 1600
1800	M 18 x 2.50		125	25	-	16.0	12.0	15.0	16.9		T381 1800	T383 1800
2000	M 20 x 2.50		140	25	-	16.0	12.0	15.0	18.9		T381 2000	T383 2000



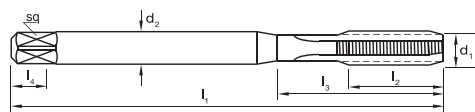
Catalogue Code	T381	T383
Discount Group	D0412	D0412
Material	PM-HSSE V3	PM-HSSE V3
Surface Finish	TiN	TiN
Geometry	Multi-Coolant Groove	Multi-Coolant Groove IK
Chamfer	Form C / 2.5 x P	Form C / 2.5 x P
Shank Form (~DIN 1835)	B	B
Limit & Nut Tolerance	6HX	6HX

• Available on request as special manufacture. Subject to lead time.

DIN Taps Metric, Straight Flute, N



- General purpose use
- Suitable for materials up to 1000N/mm²
- Through & blind holes
- Depths up to 1.5 x d₁



Catalogue Code Size Ref.



Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #
0200	M 2	x 0.40	45	8	-	2.8	2.1	5	3	1.6	T286 0200	T288 0200
0220	M 2.2	x 0.45	45	9	-	2.8	2.1	5	3	1.75	T286 0220	T288 0220
0230	M 2.3	x 0.4	45	9	-	2.8	2.1	5	3	1.9	T286 0230	T288 0230
0250	M 2.5	x 0.45	50	9	-	2.8	2.1	5	3	2.05	T286 0250	T288 0250
0260	M 2.6	x 0.45	50	9	-	2.8	2.1	5	3	2.15	T286 0260	T288 0260
0300	M 3	x 0.50	56	11	18	3.5	2.7	6	3	2.5	T286 0300	T288 0300
0350	M 3.5	x 0.60	56	13	20	4.0	3.0	6	3	2.9	T286 0350	T288 0350
0400	M 4	x 0.70	63	13	21	4.5	3.4	6	3	3.3	T286 0400	T288 0400
0500	M 5	x 0.80	70	16	25	6.0	4.9	8	3	4.2	T286 0500	T288 0500
0600	M 6	x 1.00	80	19	30	6.0	4.9	8	3	5.0	T286 0600	T288 0600
0700	M 7	x 1.00	80	19	30	7.0	5.5	8	3	6.0	•	•
0800	M 8	x 1.25	90	22	35	8.0	6.2	9	3	6.8	T286 0800	T288 0800
1000	M 10	x 1.50	100	24	39	10.0	8.0	11	3	8.5	T286 1000	T288 1000



Catalogue Code	T286	T288
Discount Group	D0402	D0406
Material	HSSE V3	HSSE V3
Surface Finish	BrT	TiN
Colour Ring & Application	N	N
Geometry		
Chamfer	Form C / 2.5 x P	Form C / 2.5 x P
Limit & Nut Tolerance	ISO 2 / 6H	ISO 2 / 6H

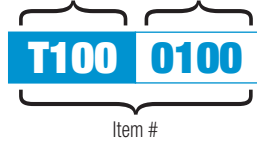
DIN Taps Metric, Straight Flute, N



- General purpose use
- Suitable for materials up to 1000N/mm²
- Through & blind holes
- Depths up to 1.5 x d₁



Catalogue Code Size Ref.



Catalogue Code	T287	T289
Discount Group	D0402	D0406
Material	HSSE V3	HSSE V3
Surface Finish	Brt	TIN
Colour Ring & Application	N	N
Geometry		
Chamfer	Form C / 2.5 x P	Form C / 2.5 x P
Limit & Nut Tolerance	ISO 2 / 6H	ISO 2 / 6H

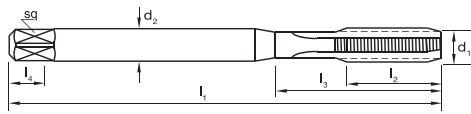
Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #
0300	M 3	x 0.50	56	11	-	2.2	-	-	3	2.5	•	•
0350	M 3.5	x 0.60	56	13	-	2.5	2.1	5	3	2.9	•	•
0400	M 4	x 0.70	63	13	-	2.8	2.1	5	3	3.3	•	•
0500	M 5	x 0.80	70	16	-	3.5	2.7	6	3	4.2	•	•
0600	M 6	x 1.00	80	19	-	4.5	3.4	6	3	5.0	T287 0600	T289 0600
0800	M 8	x 1.25	90	22	-	6.0	4.9	8	3	6.8	T287 0800	T289 0800
1000	M 10	x 1.50	100	24	-	7.0	5.5	8	3	8.5	T287 1000	T289 1000
1200	M 12	x 1.75	110	28	-	9.0	7.0	10	3	10.2	T287 1200	T289 1200
1400	M 14	x 2.00	110	30	-	11.0	9.0	12	3	12.0	T287 1400	T289 1400
1600	M 16	x 2.00	110	32	-	12.0	9.0	12	4	14.0	T287 1600	T289 1600
1800	M 18	x 2.50	125	34	-	14.0	11.0	14	4	15.5	T287 1800	T289 1800
2000	M 20	x 2.50	140	34	-	16.0	12.0	15	4	17.5	T287 2000	T289 2000
2200	M 22	x 2.50	140	34	-	18.0	14.5	17	4	19.5	T287 2200	T289 2200
2400	M 24	x 3.00	160	38	-	18.0	14.5	17	4	21.0	T287 2400	T289 2400
2700	M 27	x 3.00	160	38	-	20.0	16.0	19	4	24.0	T287 2700	T289 2700
3000	M 30	x 3.50	180	45	-	22.0	18.0	21	4	26.5	T287 3000	T289 3000

• Available on request as special manufacture. Subject to lead time.

DIN Taps Metric, Straight Flute, GG



- HSSE V3, for use in grey cast iron (GG)
- VHM, for use in Al >10% Si & cast iron (GGG)
- Through & blind holes
- Depths up to 3 x d₁



Catalogue Code Size Ref.
T100 0100
 Item #

Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
0200	M 2	x 0.40	45	8	-	2.8	2.1	5	2	1.6
0220	M 2.2	x 0.45	45	9	-	2.8	2.1	5	2	1.75
0230	M 2.3	x 0.40	45	9	-	2.8	2.1	5	2	1.9
0250	M 2.5	x 0.45	50	9	-	2.8	2.1	5	2	2.05
0260	M 2.6	x 0.45	50	9	-	2.8	2.1	5	2	2.15
0300	M 3	x 0.50	56	11	18	3.5	2.7	6	4	2.5
0350	M 3.5	x 0.60	56	13	20	4.0	3.0	6	4	2.9
0400	M 4	x 0.70	63	13	21	4.5	3.4	6	4	3.3
0500	M 5	x 0.80	70	16	25	6.0	4.9	8	4	4.2
0600	M 6	x 1.00	80	19	30	6.0	4.9	8	4	5.0
0700	M 7	x 1.00	80	19	30	7.0	5.5	8	4	6.0
0800	M 8	x 1.25	90	22	35	8.0	6.2	9	4	6.8
1000	M 10	x 1.50	100	24	39	10.0	8.0	11	4	8.5



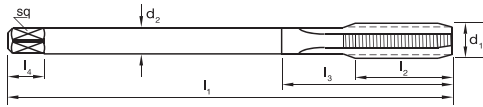
Catalogue Code	T290	T292	T670
Discount Group	D0402	D0408	D0414
Material	HSSE V3	HSSE V3	VHM
Surface Finish	Ni + Blu	TICN	TICN
Colour Ring & Application	GG	GG	GG
Geometry	Low Relief	Low Relief	Low Relief
Chamfer	Form C / 2.5 x P	Form C / 2.5 x P	Form C / 2.5 x P
Limit & Nut Tolerance	6HX	6HX	6H
	Item #	Item #	Item #
•	•	•	
•	•	•	
•	•	•	
•	•	•	
•	•	•	
T290 0300	T292 0300		
•	•		
T290 0400	T292 0400		
T290 0500	T292 0500		
T290 0600	T292 0600	T670 0600	
•	•	•	
T290 0800	T292 0800	T670 0800	
T290 1000	T292 1000	T670 1000	

• Available on request as special manufacture. Subject to lead time.

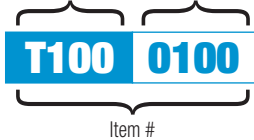
DIN Taps Metric, Straight Flute, GG



- HSSE V3, for use in grey cast iron (GG)
- VHM, for use in Al >10% Si & cast iron (GGG)
- Through & blind holes
- Depths up to 3 x d₁



Catalogue Code Size Ref.



Catalogue Code	T291	T293	T671
Discount Group	D0402	D0408	D0414
Material	HSSE V3	HSSE V3	VHM
Surface Finish	Ni + Blu	TICN	TICN
Colour Ring & Application	GG	GG	GG
Geometry	Low Relief	Low Relief	Low Relief
Chamfer	Form C / 2.5 x P	Form C / 2.5 x P	Form C / 2.5 x P
Limit & Nut Tolerance	6HX	6HX	6H

Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #	Item #
0300	M 3	x 0.50	56	11	-	2.2	-	-	4	2.5	•	•	•
0350	M 3.5	x 0.60	56	13	-	2.5	2.1	5	4	2.9	•	•	•
0400	M 4	x 0.70	63	13	-	2.8	2.1	5	4	3.3	•	•	•
0500	M 5	x 0.80	70	16	-	3.5	2.7	6	4	4.2	•	•	•
0600	M 6	x 1.00	80	19	-	4.5	3.4	6	4	5.0	T291 0600	T293 0600	•
0800	M 8	x 1.25	90	22	-	6.0	4.9	8	4	6.8	T291 0800	T293 0800	•
1000	M 10	x 1.50	100	24	-	7.0	5.5	8	4	8.5	T291 1000	T293 1000	•
1200	M 12	x 1.75	110	28	-	9.0	7.0	10	4	10.2	T291 1200	T293 1200	T671 1200
1400	M 14	x 2.00	110	30	-	11.0	9.0	12	4	12.0	T291 1400	T293 1400	•
1600	M 16	x 2.00	110	32	-	12.0	9.0	12	4	14.0	T291 1600	T293 1600	T671 1600
1800	M 18	x 2.50	125	34	-	14.0	11.0	14	4	15.5	•	•	•
2000	M 20	x 2.50	140	34	-	16.0	12.0	15	4	17.5	T291 2000	T293 2000	•

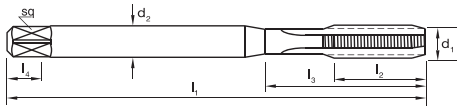
• Available on request as special manufacture. Subject to lead time.



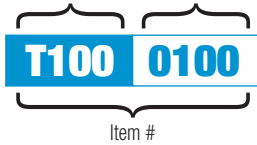
DIN Taps Metric, Straight Flute, DC



- For production tapping in die cast materials
- PM-HSS Co for superior tool life
- Form E for maximum thread depth in blind holes
- Depths up to 1.5 x d₁



Catalogue Code Size Ref.



Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
0600	M 6	x 1.00	80	19	30	6.0	4.9	8	4	5.0
0800	M 8	x 1.25	90	22	35	8.0	6.2	9	4	6.8
1000	M 10	x 1.50	100	24	39	10.0	8.0	11	4	8.5

Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #
0600	M 6	x 1.00	80	19	30	6.0	4.9	8	4	5.0	T335 0600	•
0800	M 8	x 1.25	90	22	35	8.0	6.2	9	4	6.8	T335 0800	•
1000	M 10	x 1.50	100	24	39	10.0	8.0	11	4	8.5	T335 1000	•



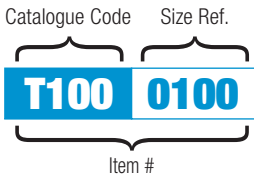
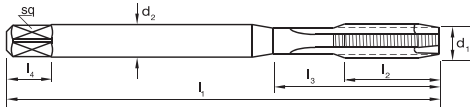
Catalogue Code	T335	T357
Discount Group	D0408	D0408
Material	PM-HSS Co	PM-HSS Co
Surface Finish	TICN	TICN
Colour Ring & Application	Die Cast	Die Cast
Geometry		Internal Coolant
Chamfer	Form E / 1.5 x P	Form E / 1.5 x P
Limit & Nut Tolerance	6HX	6HX

• Available on request as special manufacture. Subject to lead time.

DIN Taps Metric, Gun, N



- General purpose use
- Suitable for materials up to 1000N/mm²
- Through holes
- Depths up to 3 x d₁



Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
0100	M 1	x 0.25	40	6	-	2.5	2.1	5	2	0.75
0110	M 1.1	x 0.25	40	6	-	2.5	2.1	5	2	0.85
0120	M 1.2	x 0.25	40	6	-	2.5	2.1	5	2	0.95
0140	M 1.4	x 0.30	40	7	-	2.5	2.1	5	2	1.1
0160	M 1.6	x 0.35	40	8	-	2.5	2.1	5	2	1.25
0170	M 1.7	x 0.35	40	8	-	2.5	2.1	5	2	1.35
0180	M 1.8	x 0.35	40	8	-	2.5	2.1	5	2	1.45
0200	M 2	x 0.40	45	8	-	2.8	2.1	5	2	1.75
0220	M 2.2	x 0.45	45	9	-	2.8	2.1	5	2	1.9
0230	M 2.3	x 0.40	45	9	-	2.8	2.1	5	2	2.1
0250	M 2.5	x 0.45	50	9	-	2.8	2.1	5	2	2.05
0260	M 2.6	x 0.45	50	9	-	2.8	2.1	5	2	2.15
0300	M 3	x 0.50	56	11	18	3.5	2.7	6	3	2.5
0350	M 3.5	x 0.60	56	13	20	4.0	3.0	6	3	2.9
0400	M 4	x 0.70	63	13	21	4.5	3.4	6	3	3.3
0500	M 5	x 0.80	70	16	25	6.0	4.9	8	3	4.2
0600	M 6	x 1.00	80	19	30	6.0	4.9	8	3	5.0
0700	M 7	x 1.00	80	19	30	7.0	5.5	8	3	6.0
0800	M 8	x 1.25	90	22	35	8.0	6.2	9	3	6.8
1000	M 10	x 1.50	100	24	39	10.0	8.0	11	3	8.5



Catalogue Code	T100	T102	T104
Discount Group	D0402	D0402	D0406
Material	HSSE V3	HSSE V3	HSSE V3
Surface Finish	Brt	Blu	TiN
Colour Ring & Application	N	N	N
Geometry			
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P
Limit & Nut Tolerance	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H

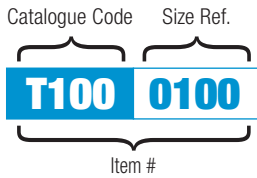
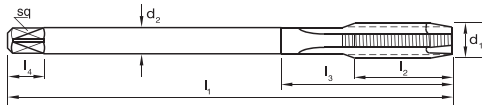
Item #	Item #	Item #
T100 0100	•	•
•	•	•
T100 0120	•	•
T100 0140	•	•
T100 0160	•	•
•	•	•
T100 0180	•	•
T100 0200	T102 0200	•
T100 0220	T102 0220	•
T100 0230	T102 0230	•
T100 0250	T102 0250	•
T100 0260	T102 0260	•
T100 0300	T102 0300	T104 0300
T100 0350	T102 0350	T104 0350
T100 0400	T102 0400	T104 0400
T100 0500	T102 0500	T104 0500
T100 0600	T102 0600	T104 0600
T100 0700	T102 0700	•
T100 0800	T102 0800	T104 0800
T100 1000	T102 1000	T104 1000

• Available on request as special manufacture. Subject to lead time.

DIN Taps Metric, Gun, N



- General purpose use
- Suitable for materials up to 1000N/mm²
- Through holes
- Depths up to 3 x d₁



Catalogue Code	T101	T103	T105
Discount Group	D0402	D0402	D0406
Material	HSSE V3	HSSE V3	HSSE V3
Surface Finish	Brt	Blu	TIN
Colour Ring & Application	N	N	N
Geometry			
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P
Limit & Nut Tolerance	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H

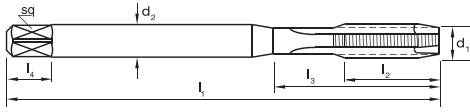
Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #	Item #
0300	M 3	x 0.50	56	11	-	2.2	-	-	3	2.5	•	•	•
0350	M 3.5	x 0.60	56	13	-	2.5	2.1	5	3	2.9	•	•	•
0400	M 4	x 0.70	63	13	-	2.8	2.1	5	3	3.3	•	•	•
0500	M 5	x 0.80	70	16	-	3.5	2.7	6	3	4.2	•	•	•
0600	M 6	x 1.00	80	19	-	4.5	3.4	6	3	5.0	T101 0600	T103 0600	T105 0600
0800	M 8	x 1.25	90	22	-	6.0	4.9	8	3	6.8	T101 0800	T103 0800	T105 0800
1000	M 10	x 1.50	100	24	-	7.0	5.5	8	3	8.5	T101 1000	T103 1000	T105 1000
1200	M 12	x 1.75	110	28	-	9.0	7.0	10	3	10.2	T101 1200	T103 1200	T105 1200
1400	M 14	x 2.00	110	30	-	11.0	9.0	12	3	12.0	T101 1400	T103 1400	T105 1400
1600	M 16	x 2.00	110	32	-	12.0	9.0	12	3	14.0	T101 1600	T103 1600	T105 1600
1800	M 18	x 2.50	125	34	-	14.0	11.0	14	4	15.5	T101 1800	T103 1800	T105 1800
2000	M 20	x 2.50	140	34	-	16.0	12.0	15	4	17.5	T101 2000	T103 2000	T105 2000
2200	M 22	x 2.50	140	34	-	18.0	14.5	17	4	19.5	T101 2200	•	T105 2200
2400	M 24	x 3.00	160	38	-	18.0	14.5	17	4	21.0	T101 2400	•	T105 2400
2700	M 27	x 3.00	160	38	-	20.0	16.0	19	4	24.0	T101 2700	•	T105 2700
3000	M 30	x 3.50	180	45	-	22.0	18.0	21	4	26.5	T101 3000	•	T105 3000
3300	M 33	x 3.50	180	50	-	25.0	20.0	23	4	29.5	T101 3300	•	•
3600	M 36	x 4.00	200	56	-	28.0	22.0	25	4	32.0	T101 3600	•	•
3900	M 39	x 4.00	200	60	-	32.0	24.0	27	4	35.0	T101 3900	•	•
4200	M 42	x 4.50	200	60	-	32.0	24.0	27	4	37.5	T101 4200	•	•
4500	M 45	x 4.50	220	65	-	36.0	29.0	32	4	40.5	T101 4500	•	•
4800	M 48	x 5.00	250	70	-	36.0	29.0	32	4	43.0	T101 4800	•	•
5200	M 52	x 5.00	250	70	-	40.0	32.0	35	4	47.0	T101 5200	•	•

• Available on request as special manufacture. Subject to lead time.

DIN Taps Metric, Gun, N - 6G, 4H, LH



- General purpose use
- Suitable for materials up to 1000N/mm²
- Through holes
- Depths up to 3 x d₁



Catalogue Code Size Ref.

T100 **0100**

Item #

Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
0200	M 2	x 0.40	45	8	-	2.8	2.1	5	2	1.6
0220	M 2.2	x 0.45	45	9	-	2.8	2.1	5	2	1.75
0230	M 2.3	x 0.40	45	9	-	2.8	2.1	5	2	1.9
0250	M 2.5	x 0.45	50	9	-	2.8	2.1	5	2	2.05
0260	M 2.6	x 0.45	50	9	-	2.8	2.1	5	2	2.15
0300	M 3	x 0.50	56	11	18	3.5	2.7	6	3	2.5
0350	M 3.5	x 0.60	56	13	20	4.0	3.0	6	3	2.9
0400	M 4	x 0.70	63	13	21	4.5	3.4	6	3	3.3
0500	M 5	x 0.80	70	16	25	6.0	4.9	8	3	4.2
0600	M 6	x 1.00	80	19	30	6.0	4.9	8	3	5.0
0700	M 7	x 1.00	80	19	30	7.0	5.5	8	3	6.0
0800	M 8	x 1.25	90	22	35	8.0	6.2	9	3	6.8
1000	M 10	x 1.50	100	24	39	10.0	8.0	11	3	8.5



Catalogue Code	T106	T648
Discount Group	D0402	D0402
Material	HSSE V3	HSSE V3
Surface Finish	Brt	Brt
Colour Ring & Application	N	N
Geometry	6G	Left Hand
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P
Limit & Nut Tolerance	ISO 3 / 6G	ISO 2 / 6H LH

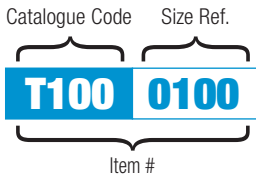
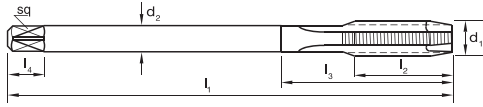
Item #	Item #
•	•
•	•
•	•
•	•
•	•
T106 0300	T648 0300
T106 0350	•
T106 0400	T648 0400
T106 0500	T648 0500
T106 0600	T648 0600
•	•
T106 0800	T648 0800
T106 1000	T648 1000

• Available on request as special manufacture. Subject to lead time.

DIN Taps Metric, Gun, N - 6G, 4H, LH



- General purpose use
- Suitable for materials up to 1000N/mm²
- Through holes
- Depths up to 3 x d₁



Catalogue Code	T107	T649
Discount Group	D0402	D0402
Material	HSSE V3	HSSE V3
Surface Finish	Brt	Brt
Colour Ring & Application	N	N
Geometry	6G	Left Hand
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P
Limit & Nut Tolerance	ISO 3 / 6G	ISO 2 / 6H LH

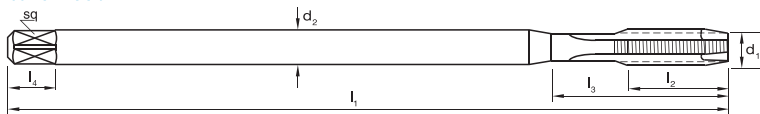
Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #
0300	M 3	x 0.50	56	11	-	2.2	-	-	3	2.5	•	•
0350	M 3.5	x 0.60	56	13	-	2.5	2.1	5	3	2.9	•	•
0400	M 4	x 0.70	63	13	-	2.8	2.1	5	3	3.3	•	•
0500	M 5	x 0.80	70	16	-	3.5	2.7	6	3	4.2	•	•
0600	M 6	x 1.00	80	19	-	4.5	3.4	6	3	5.0	•	•
0800	M 8	x 1.25	90	22	-	6.0	4.9	8	3	6.8	•	•
1000	M 10	x 1.50	100	24	-	7.0	5.5	8	3	8.5	•	•
1200	M 12	x 1.75	110	28	-	9.0	7.0	10	3	10.2	T107 1200	T649 1200
1400	M 14	x 2.00	110	30	-	11.0	9.0	12	3	12.0	T107 1400	T649 1400
1600	M 16	x 2.00	110	32	-	12.0	9.0	12	3	14.0	T107 1600	T649 1600
1800	M 18	x 2.50	125	34	-	14.0	11.0	14	4	15.5	T107 1800	T649 1800
2000	M 20	x 2.50	140	34	-	16.0	12.0	15	4	17.5	T107 2000	T649 2000

• Available on request as special manufacture. Subject to lead time.

DIN Taps Metric, Gun, N, Extra Length



- For long reach applications
- Suitable for materials up to 1000N/mm²
- Depths up to 3 x d₁
- d₂ and sq in accordance to DIN371



Catalogue Code Size Ref.



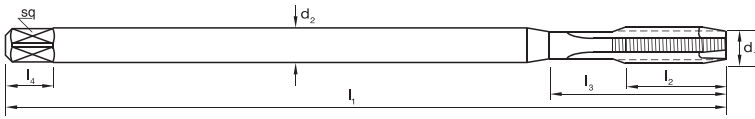
Catalogue Code	T337
Discount Group	D0402
Material	HSSE V3
Surface Finish	Brt
Colour Ring & Application	N
Geometry	Extra Length
Chamfer	Form B / 4.5 x P
Limit & Nut Tolerance	ISO 2 / 6H

Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #
0300	M 3	x 0.50	112	11		3.5	2.7	6	3	2.5	T337 0300
0400	M 4	x 0.70	126	13		4.5	3.4	6	3	3.3	T337 0400
0500	M 5	x 0.80	140	15		6.0	4.9	8	3	4.2	T337 0500
0600	M 6	x 1.00	160	17		6.0	4.9	8	3	5.0	T337 0600
0800	M 8	x 1.25	180	20		8.0	6.2	10	3	6.8	T337 0800

DIN Taps Metric, Gun, N, Extra Length



- For long reach applications
- Suitable for materials up to 1000N/mm²
- Depths up to 3 x d₁
- d₂ and sq in accordance to DIN376



Catalogue Code Size Ref.



Catalogue Code **T338**

Discount Group D0402

Material **HSSE V3**

Surface Finish **Brt**

Colour Ring & Application **N**

Geometry Extra Length

Chamfer Form B / 4.5 x P

Limit & Nut Tolerance ISO 2 / 6H

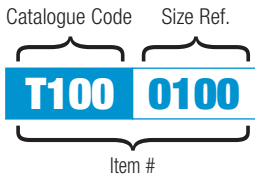
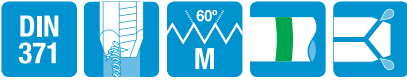
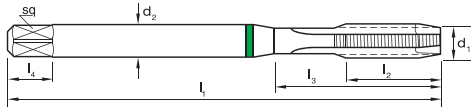
Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #
1000	M 10 x 1.50	200	24	100	7.0	5.5	8	3	8.5		T338 1000
1200	M 12 x 1.75	220	28	110	9.0	7.0	10	3	10.2		T338 1200
1400	M 14 x 2.00	220	30	110	11.0	9.0	12	3	12.0		T338 1400
1600	M 16 x 2.00	220	32	110	12.0	9.0	12	3	14.0		T338 1600
2000	M 20 x 2.50	280	34	110	16.0	12.0	15	4	17.5		•
2400	M 24 x 3.00	320	38	120	18.0	14.5	17	4	21.0		•

• Available on request as special manufacture. Subject to lead time.

DIN Taps Metric, Gun, UNI



- Universal use
- Suitable for materials up to 1200N/mm²
- Through holes
- Depths up to 3 x d₁



Catalogue Code
Discount Group
Material
Surface Finish
Colour Ring & Application
Geometry
Chamfer
Limit & Nut Tolerance

T132	T134	T140	T142
D0402	D0402	D0410	D0410
PM-HSSE V3	PM-HSSE V3	PM-HSSE V3	PM-HSSE V3
Br	Blu	TiAIN	TiAIN
UNI	UNI	UNI	UNI
			Internal Coolant
Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P
ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H



Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
0200	M 2	x 0.40	45	8	-	2.8	2.1	5	3	1.6
0220	M 2.2	x 0.45	45	9	-	2.8	2.1	5	3	1.75
0230	M 2.3	x 0.40	45	9	-	2.8	2.1	5	3	1.9
0250	M 2.5	x 0.45	50	9	-	2.8	2.1	5	3	2.05
0260	M 2.6	x 0.45	50	9	-	2.8	2.1	5	3	2.15
0300	M 3	x 0.50	56	11	18	3.5	2.7	6	3	2.5
0350	M 3.5	x 0.60	56	13	20	4.0	3.0	6	3	2.9
0400	M 4	x 0.70	63	13	21	4.5	3.4	6	3	3.3
0500	M 5	x 0.80	70	16	25	6.0	4.9	8	3	4.2
0600	M 6	x 1.00	80	19	30	6.0	4.9	8	3	5.0
0700	M 7	x 1.00	80	19	30	7.0	5.5	8	3	6.0
0800	M 8	x 1.25	90	22	35	8.0	6.2	9	3	6.8
1000	M 10	x 1.50	100	24	39	10.0	8.0	11	3	8.5

Item #	Item #	Item #	Item #
•	•	•	•
•	•	•	•
•	•	•	•
•	•	•	•
•	•	•	•
•	•	•	•
T132 0300	T134 0300	T140 0300	•
T132 0350	•	•	•
T132 0400	T134 0400	T140 0400	•
T132 0500	T134 0500	T140 0500	•
T132 0600	T134 0600	T140 0600	T142 0600
•	•	•	•
T132 0800	T134 0800	T140 0800	T142 0800
T132 1000	T134 1000	T140 1000	T142 1000

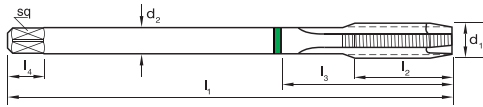
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• Available on request as special manufacture. Subject to lead time.

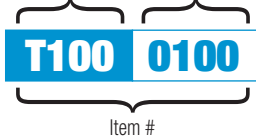
DIN Taps Metric, Gun, UNI



- Universal use
- Suitable for materials up to 1200N/mm²
- Through holes
- Depths up to 3 x d₁



Catalogue Code Size Ref.



Catalogue Code
Discount Group
Material
Surface Finish
Colour Ring & Application
Geometry
Chamfer
Limit & Nut Tolerance

T133	T135	T141	T143
D0402	D0402	D0410	D0410
PM-HSSE V3	PM-HSSE V3	PM-HSSE V3	PM-HSSE V3
Br	Blu	TAIN	TAIN
UNI	UNI	UNI	UNI
			Internal Coolant
Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P
ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H

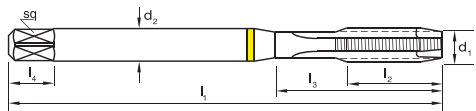
Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #	Item #	Item #
0300	M 3 x 0.50		56	11	-	2.2	-	-	3	2.5	•	•	•	•
0350	M 3.5 x 0.60		56	13	-	2.5	2.1	5	3	2.9	•	•	•	•
0400	M 4 x 0.70		63	13	-	2.8	2.1	5	3	3.3	•	•	•	•
0500	M 5 x 0.80		70	16	-	3.5	2.7	6	3	4.2	•	•	•	•
0600	M 6 x 1.00		80	19	-	4.5	3.4	6	3	5.0	•	•	•	•
0800	M 8 x 1.25		90	22	-	6.0	4.9	8	3	6.8	•	•	•	•
1000	M 10 x 1.50		100	24	-	7.0	5.5	8	3	8.5	•	•	•	•
1200	M 12 x 1.75		110	28	-	9.0	7.0	10	3	10.2	T133 1200	T135 1200	T141 1200	T143 1200
1400	M 14 x 2.00		110	30	-	11.0	9.0	12	3	12.0	T133 1400	T135 1400	T141 1400	T143 1400
1600	M 16 x 2.00		110	32	-	12.0	9.0	12	4	14.0	T133 1600	T135 1600	T141 1600	T143 1600
1800	M 18 x 2.50		125	34	-	14.0	11.0	14	4	15.5	T133 1800	T135 1800	T141 1800	T143 1800
2000	M 20 x 2.50		140	34	-	16.0	12.0	15	4	17.5	T133 2000	T135 2000	T141 2000	T143 2000
2200	M 22 x 2.50		140	34	-	18.0	14.5	17	4	19.5	•	•	•	•
2400	M 24 x 3.00		160	38	-	18.0	14.5	17	4	21.0	•	•	•	•
2700	M 27 x 3.00		160	38	-	20.0	16.0	19	4	24.0	•	•	•	•
3000	M 30 x 3.50		180	45	-	22.0	18.0	21	4	26.5	•	•	•	•

• Available on request as special manufacture. Subject to lead time.

DIN Taps Metric, Gun, W & Cu



- Suitable for use in soft materials
- CrN for copper and non-ferrous materials
- Through holes
- Depths up to 3 x d₁



Catalogue Code Size Ref.
T100 0100
 Item #

- Catalogue Code
- Discount Group
- Material
- Surface Finish
- Colour Ring & Application
- Geometry
- Chamfer
- Limit & Nut Tolerance

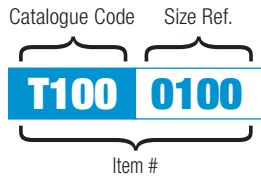
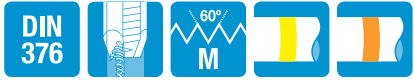
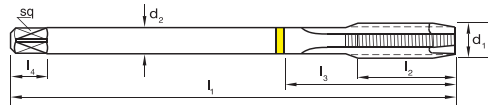
	T122	T124	T126
Catalogue Code	D0402	D0402	D0404
Discount Group	D0402	D0402	D0404
Material	HSSE V3	HSSE V3	HSSE V3
Surface Finish	Ni	Blu	CrN
Colour Ring & Application	W	W	Cu
Geometry			
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P
Limit & Nut Tolerance	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H
Item #	Item #	Item #	Item #
•	•	•	
•	•	•	
•	•	•	
•	•	•	
•	•	•	
•	•	•	
T122 0300	T124 0300	T126 0300	
•	•	•	
T122 0400	T124 0400	T126 0400	
T122 0500	T124 0500	T126 0500	
T122 0600	T124 0600	T126 0600	
•	•	•	
T122 0800	T124 0800	T126 0800	
T122 1000	T124 1000	T126 1000	

Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
0200	M 2	x 0.40	45	8	-	2.8	2.1	5	2	1.6
0220	M 2.2	x 0.45	45	9	-	2.8	2.1	5	2	1.75
0230	M 2.3	x 0.40	45	9	-	2.8	2.1	5	2	1.9
0250	M 2.5	x 0.45	50	9	-	2.8	2.1	5	2	2.05
0260	M 2.6	x 0.45	50	9	-	2.8	2.1	5	2	2.15
0300	M 3	x 0.50	56	11	18	3.5	2.7	6	3	2.5
0350	M 3.5	x 0.60	56	13	20	4.0	3.0	6	3	2.9
0400	M 4	x 0.70	63	13	21	4.5	3.4	6	3	3.3
0500	M 5	x 0.80	70	16	25	6.0	4.9	8	3	4.2
0600	M 6	x 1.00	80	19	30	6.0	4.9	8	3	5.0
0700	M 7	x 1.00	80	19	30	7.0	5.5	8	3	6.0
0800	M 8	x 1.25	90	22	35	8.0	6.2	9	3	6.8
1000	M 10	x 1.50	100	24	39	10.0	8.0	11	3	8.5

DIN Taps Metric, Gun, W & Cu



- Suitable for use in soft materials
- CrN for copper and non-ferrous materials
- Through holes
- Depths up to $3 \times d_1$



Catalogue Code	T123	T125	T127
Discount Group	D0402	D0402	D0404
Material	HSSE V3	HSSE V3	HSSE V3
Surface Finish	Ni	Blu	CrN
Colour Ring & Application	W	W	Cu
Geometry			
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P
Limit & Nut Tolerance	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H

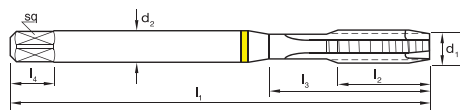
Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #	Item #
0300	M 3	x 0.50	56	11	-	2.2	-	-	3	2.5	•	•	•
0350	M 3.5	x 0.60	56	13	-	2.5	2.1	5	3	2.9	•	•	•
0400	M 4	x 0.70	63	13	-	2.8	2.1	5	3	3.3	•	•	•
0500	M 5	x 0.80	70	16	-	3.5	2.7	6	3	4.2	•	•	•
0600	M 6	x 1.00	80	19	-	4.5	3.4	6	3	5.0	•	•	•
0800	M 8	x 1.25	90	22	-	6.0	4.9	8	3	6.8	•	•	•
1000	M 10	x 1.50	100	24	-	7.0	5.5	8	3	8.5	•	•	•
1200	M 12	x 1.75	110	28	-	9.0	7.0	10	3	10.2	T123 1200	T125 1200	T127 1200
1400	M 14	x 2.00	110	30	-	11.0	9.0	12	3	12.0	•	•	•
1600	M 16	x 2.00	110	32	-	12.0	9.0	12	4	14.0	T123 1600	T125 1600	T127 1600
1800	M 18	x 2.50	125	34	-	14.0	11.0	14	4	15.5	•	•	•
2000	M 20	x 2.50	140	34	-	16.0	12.0	15	4	17.5	T123 2000	T125 2000	T127 2000

• Available on request as special manufacture. Subject to lead time.

DIN Taps Metric, Gun, W-AZ



- Use in soft elastic materials
- Through holes
- Depths up to $3 \times d_1$



Catalogue Code Size Ref.

T100 **0100**
Item #

Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #
0200	M 2	x 0.40	45	8	-	2.8	2.1	5	3	1.6	•	•
0220	M 2.2	x 0.45	45	9	-	2.8	2.1	5	3	1.75	•	•
0230	M 2.3	x 0.40	45	9	-	2.8	2.1	5	3	1.9	•	•
0250	M 2.5	x 0.45	50	9	-	2.8	2.1	5	3	2.05	•	•
0260	M 2.6	x 0.45	50	9	-	2.8	2.1	5	3	2.15	•	•
0300	M 3	x 0.50	56	11	18	3.5	2.7	6	3	2.5	T128 0300	T130 0300
0350	M 3.5	x 0.60	56	13	20	4.0	3.0	6	3	2.9	•	•
0400	M 4	x 0.70	63	13	21	4.5	3.4	6	3	3.3	T128 0400	T130 0400
0500	M 5	x 0.80	70	16	25	6.0	4.9	8	3	4.2	T128 0500	T130 0500
0600	M 6	x 1.00	80	19	30	6.0	4.9	8	3	5.0	T128 0600	T130 0600
0700	M 7	x 1.00	80	19	30	7.0	5.5	8	3	6.0	•	•
0800	M 8	x 1.25	90	22	35	8.0	6.2	9	3	6.8	T128 0800	T130 0800
1000	M 10	x 1.50	100	24	39	10.0	8.0	11	3	8.5	T128 1000	T130 1000

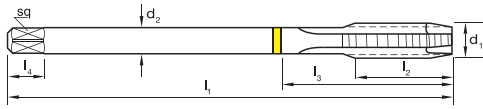


Catalogue Code	T128	T130
Discount Group	D0402	D0406
Material	HSSE V3	HSSE V3
Surface Finish	Brt	TiN
Colour Ring & Application	Sticky Material	Sticky Material
Geometry	Interrupted Threads	Interrupted Threads
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P
Limit & Nut Tolerance	ISO 2 / 6H	ISO 2 / 6H

DIN Taps Metric, Gun, W-AZ



- Use in soft elastic materials
- Through holes
- Depths up to $3 \times d_1$



Catalogue Code Size Ref.



Catalogue Code	T129	T131
Discount Group	D0402	D0406
Material	HSSE V3	HSSE V3
Surface Finish	Brt	TIN
Colour Ring & Application	Sticky Material	Sticky Material
Geometry	Interrupted Threads	Interrupted Threads
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P
Limit & Nut Tolerance	ISO 2 / 6H	ISO 2 / 6H

Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #
0300	M 3	x 0.50	56	11	-	2.2	-	-	3	2.5	•	•
0350	M 3.5	x 0.60	56	13	-	2.5	2.1	5	3	2.9	•	•
0400	M 4	x 0.70	63	13	-	2.8	2.1	5	3	3.3	•	•
0500	M 5	x 0.80	70	16	-	3.5	2.7	6	3	4.2	•	•
0600	M 6	x 1.00	80	19	-	4.5	3.4	6	3	5.0	•	•
0800	M 8	x 1.25	90	22	-	6.0	4.9	8	3	6.8	•	•
1000	M 10	x 1.50	100	24	-	7.0	5.5	8	3	8.5	•	•
1200	M 12	x 1.75	110	28	-	9.0	7.0	10	3	10.2	T129 1200	T131 1200
1400	M 14	x 2.00	110	30	-	11.0	9.0	12	3	12.0	T129 1400	T131 1400
1600	M 16	x 2.00	110	32	-	12.0	9.0	12	3	14.0	T129 1600	T131 1600

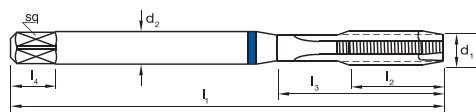
• Available on request as special manufacture. Subject to lead time.



DIN Taps Metric, Gun, VA



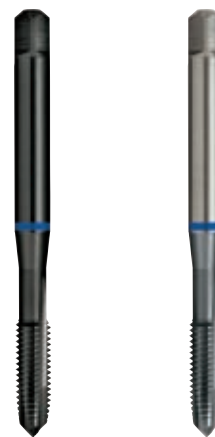
- Use in stainless steels and high strength steels
- Suitable for materials up to 850N/mm²
- Through holes
- Depths up to 3 x d₁



Catalogue Code Size Ref.



Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
0200	M 2	x 0.40	45	8	-	2.8	2.1	5	3	1.6
0220	M 2.2	x 0.45	45	9	-	2.8	2.1	5	3	1.75
0230	M 2.3	x 0.40	45	9	-	2.8	2.1	5	3	1.9
0250	M 2.5	x 0.45	50	9	-	2.8	2.1	5	3	2.05
0260	M 2.6	x 0.45	50	9	-	2.8	2.1	5	3	2.15
0300	M 3	x 0.50	56	11	18	3.5	2.7	6	3	2.5
0350	M 3.5	x 0.60	56	13	20	4.0	3.0	6	3	2.9
0400	M 4	x 0.70	63	13	21	4.5	3.4	6	3	3.3
0500	M 5	x 0.80	70	16	25	6.0	4.9	8	3	4.2
0600	M 6	x 1.00	80	19	30	6.0	4.9	8	3	5.0
0700	M 7	x 1.00	80	19	30	7.0	5.5	8	3	6.0
0800	M 8	x 1.25	90	22	35	8.0	6.2	9	3	6.8
1000	M 10	x 1.50	100	24	39	10.0	8.0	11	3	8.5



Catalogue Code	T110	T112
Discount Group	D0402	D0408
Material	HSSE V3	HSSE V3
Surface Finish	Blu	TICN
Colour Ring & Application	VA	VA
Geometry	Special Relief	Special Relief
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P
Limit & Nut Tolerance	ISO 2 / 6H	ISO 2 / 6H

Item #	Item #
•	•
•	•
•	•
•	•
•	•
T110 0300	T112 0300
T110 0350	T112 0350
T110 0400	T112 0400
T110 0500	T112 0500
T110 0600	T112 0600
•	•
T110 0800	T112 0800
T110 1000	T112 1000

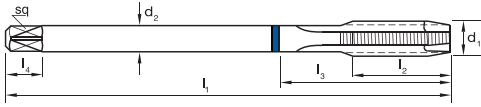
M

• Available on request as special manufacture. Subject to lead time.

DIN Taps Metric, Gun, VA



- Use in stainless steels and high strength steels
- Suitable for materials up to 850N/mm²
- Through holes
- Depths up to 3 x d₁



Catalogue Code Size Ref.
T100 **0100**
 Item #

Catalogue Code	T111	T113
Discount Group	D0402	D0408
Material	HSSE V3	HSSE V3
Surface Finish	Blu	TCN
Colour Ring & Application	VA	VA
Geometry	Special Relief	Special Relief
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P
Limit & Nut Tolerance	ISO 2 / 6H	ISO 2 / 6H

Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #
0300	M 3 x 0.50		56	11	-	2.2	-	-	3	2.5	•	•
0350	M 3.5 x 0.60		56	13	-	2.5	2.1	5	3	2.9	•	•
0400	M 4 x 0.70		63	13	-	2.8	2.1	5	3	3.3	•	•
0500	M 5 x 0.80		70	16	-	3.5	2.7	6	3	4.2	•	•
0600	M 6 x 1.00		80	19	-	4.5	3.4	6	3	5.0	T111 0600	T113 0600
0800	M 8 x 1.25		90	22	-	6.0	4.9	8	3	6.8	T111 0800	T113 0800
1000	M 10 x 1.50		100	24	-	7.0	5.5	8	3	8.5	T111 1000	T113 1000
1200	M 12 x 1.75		110	28	-	9.0	7.0	10	3	10.2	T111 1200	T113 1200
1400	M 14 x 2.00		110	30	-	11.0	9.0	12	3	12.0	T111 1400	T113 1400
1600	M 16 x 2.00		110	32	-	12.0	9.0	12	4	14.0	T111 1600	T113 1600
1800	M 18 x 2.50		125	34	-	14.0	11.0	14	4	15.5	T111 1800	T113 1800
2000	M 20 x 2.50		140	34	-	16.0	12.0	15	4	17.5	T111 2000	T113 2000
2200	M 22 x 2.50		140	34	-	18.0	14.5	17	4	19.5	T111 2200	T113 2200
2400	M 24 x 3.00		160	38	-	18.0	14.5	17	4	21.0	T111 2400	T113 2400
2700	M 27 x 3.00		160	38	-	20.0	16.0	19	4	24.0	T111 2700	T113 2700
3000	M 30 x 3.50		180	45	-	22.0	18.0	21	4	26.5	T111 3000	T113 3000

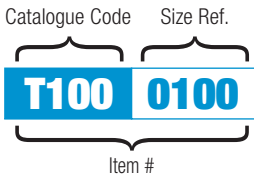
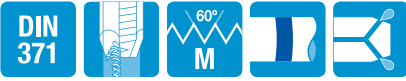
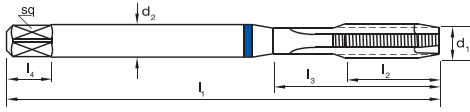
• Available on request as special manufacture. Subject to lead time.



DIN Taps Metric, Gun, VA PM



- PM-HSSE V3 offers superior performance
- Use in stainless steels and high strength steels
- Suitable for materials up to 850N/mm²
- Through holes
- Depths up to 3 x d₁



Catalogue Code
Discount Group
Material
Surface Finish
Colour Ring & Application
Geometry
Chamfer
Limit & Nut Tolerance

	T114	T116	T680	T118
Discount Group	D0402	D0408	D0408	D0408
Material	PM-HSSE V3	PM-HSSE V3	PM-HSSE V3	PM-HSSE V3
Surface Finish	Blu	TICN	TICN	TICN
Colour Ring & Application	VA PM	VA PM	VA PM	VA PM
Geometry	Special Relief	Special Relief	Special Relief	Internal Coolant
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P
Limit & Nut Tolerance	6HX	6HX	6GX	6HX
	Item #	Item #	Item #	Item #



Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
0160	M 1.6	x 0.35	40	8	-	2.5	2.1	5	3	1.25
0200	M 2	x 0.40	45	8	-	2.8	2.1	5	3	1.6
0220	M 2.2	x 0.45	45	9	-	2.8	2.1	5	3	1.75
0230	M 2.3	x 0.40	45	9	-	2.8	2.1	5	3	1.9
0250	M 2.5	x 0.45	50	9	-	2.8	2.1	5	3	2.05
0260	M 2.6	x 0.45	50	9	-	2.8	2.1	5	3	2.15
0300	M 3	x 0.50	56	11	18	3.5	2.7	6	3	2.5
0350	M 3.5	x 0.60	56	13	20	4.0	3.0	6	3	2.9
0400	M 4	x 0.70	63	13	21	4.5	3.4	6	3	3.3
0500	M 5	x 0.80	70	16	25	6.0	4.9	8	3	4.2
0600	M 6	x 1.00	80	19	30	6.0	4.9	8	3	5.0
0700	M 7	x 1.00	80	19	30	7.0	5.5	8	3	6.0
0800	M 8	x 1.25	90	22	35	8.0	6.2	9	3	6.8
1000	M 10	x 1.50	100	24	39	10.0	8.0	11	3	8.5

•	T116 0160	•	•
•	T116 0200	T680 0200	•
•	•	•	•
•	•	•	•
•	T116 0250	T680 0250	•
•	•	•	•
T114 0300	T116 0300	T680 0300	•
•	T116 0350	T680 0350	•
T114 0400	T116 0400	T680 0400	•
T114 0500	T116 0500	T680 0500	T118 0500
T114 0600	T116 0600	T680 0600	T118 0600
•	•	•	•
T114 0800	T116 0800	T680 0800	T118 0800
T114 1000	T116 1000	T680 1000	T118 1000

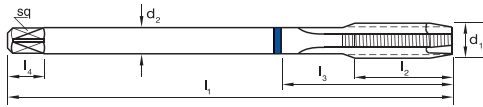
M

• Available on request as special manufacture. Subject to lead time.

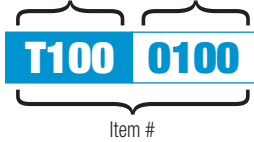
DIN Taps Metric, Gun, VA PM



- PM-HSSE V3 offers superior performance
- Use in stainless steels and high strength steels
- Suitable for materials up to 850N/mm²
- Through holes
- Depths up to 3 x d₁



Catalogue Code Size Ref.



Catalogue Code

Discount Group

Material

Surface Finish

Colour Ring & Application

Geometry

Chamfer

Limit & Nut Tolerance



T115	T117	T681	T119
D0402	D0408	D0408	D0408
PM-HSSE V3	PM-HSSE V3	PM-HSSE V3	PM-HSSE V3
Blu	TICN	TICN	TICN
VA PM	VA PM	VA PM	VA PM
Special Relief	Special Relief	Special Relief	Internal Coolant
Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P
6HX	6HX	6GX	6HX

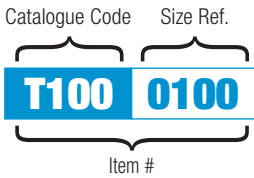
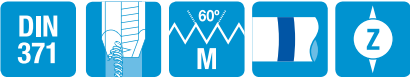
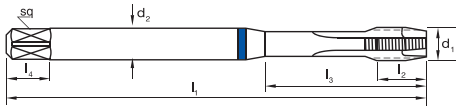
Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #	Item #	Item #
0300	M 3	x 0.50	56	11	-	2.2	-	-	3	2.5	•	•	•	•
0350	M 3.5	x 0.60	56	13	-	2.5	2.1	5	3	2.9	•	•	•	•
0400	M 4	x 0.70	63	13	-	2.8	2.1	5	3	3.3	•	•	•	•
0500	M 5	x 0.80	70	16	-	3.5	2.7	6	3	4.2	•	•	•	•
0600	M 6	x 1.00	80	19	-	4.5	3.4	6	3	5.0	•	•	•	•
0800	M 8	x 1.25	90	22	-	6.0	4.9	8	3	6.8	•	•	•	•
1000	M 10	x 1.50	100	24	-	7.0	5.5	8	3	8.5	•	•	•	•
1200	M 12	x 1.75	110	28	-	9.0	7.0	10	3	10.2	T115 1200	T117 1200	T681 1200	T119 1200
1400	M 14	x 2.00	110	30	-	11.0	9.0	12	3	12.0	T115 1400	T117 1400	T681 1400	T119 1400
1600	M 16	x 2.00	110	32	-	12.0	9.0	12	4	14.0	T115 1600	T117 1600	T681 1600	T119 1600
1800	M 18	x 2.50	125	34	-	14.0	11.0	14	4	15.5	T115 1800	T117 1800	T681 1800	T119 1800
2000	M 20	x 2.50	140	34	-	16.0	12.0	15	4	17.5	T115 2000	T117 2000	T681 2000	T119 2000
2200	M 22*	x 2.50	140	34	-	18.0	14.5	17	4	19.5	•	•	T681 2200	•
2400	M 24*	x 3.00	160	38	-	18.0	14.5	17	4	21.0	•	•	T681 2400	•
2700	M 27*	x 3.00	160	38	-	20.0	16.0	19	4	24.0	•	•	•	•
3000	M 30*	x 3.50	180	45	-	22.0	18.0	21	4	26.5	•	•	•	•

* HSSE V3 >20mm • Available on request as special manufacture. Subject to lead time.

DIN Taps Metric, Gun, VADH



- Suitable for synchronous tapping in deep holes
- PM-HSSE V3 offers superior performance
- Use in stainless steels and high strength steels up to 850N/mm²
- Through holes
- Depths up to 3.5 x d₁



Catalogue Code	T120
Discount Group	D0408
Material	PM-HSSE V3
Surface Finish	TICN
Colour Ring & Application	VA-DH
Geometry	Thread Length = 10 x P
Chamfer	Form B / 4.5 x P
Limit & Nut Tolerance	6HX

Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #
0200	M 2	x 0.40	45	8	-	2.8	2.1	5	3	1.6	•
0220	M 2.2	x 0.45	45	9	-	2.8	2.1	5	3	1.75	•
0230	M 2.3	x 0.40	45	9	-	2.8	2.1	5	3	1.9	•
0250	M 2.5	x 0.45	50	9	-	2.8	2.1	5	3	2.05	•
0260	M 2.6	x 0.45	50	9	-	2.8	2.1	5	3	2.15	•
0300	M 3	x 0.50	56	11	18	3.5	2.7	6	3	2.5	T120 0300
0350	M 3.5	x 0.60	56	13	20	4.0	3.0	6	3	2.9	•
0400	M 4	x 0.70	63	13	21	4.5	3.4	6	3	3.3	T120 0400
0500	M 5	x 0.80	70	16	25	6.0	4.9	8	3	4.2	T120 0500
0600	M 6	x 1.00	80	19	30	6.0	4.9	8	3	5.0	T120 0600
0700	M 7	x 1.00	80	19	30	7.0	5.5	8	3	6.0	•
0800	M 8	x 1.25	90	22	35	8.0	6.2	9	3	6.8	T120 0800
1000	M 10	x 1.50	100	24	39	10.0	8.0	11	3	8.5	T120 1000

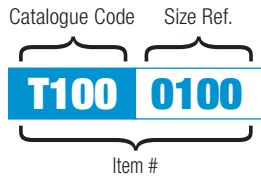
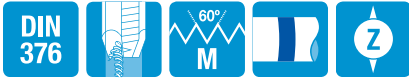
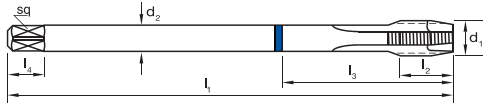
M

• Available on request as special manufacture. Subject to lead time.

DIN Taps Metric, Gun, VADH



- Use in stainless steels and high strength steels up to 1000N/mm²
- PM-HSSE V3 offers higher edge hardness than standard VA series
- Through holes
- Suitable for synchronous tapping in machine operations
- Depths up to approx. 3 x d₁



Catalogue Code	T121
Discount Group	D0408
Material	PM-HSSE V3
Surface Finish	TICN
Colour Ring & Application	VA-DH
Geometry	Thread Length = 10 x P
Chamfer	Form B / 4.5 x P
Limit & Nut Tolerance	6HX

Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #
0300	M 3	x 0.50	56	11	-	2.2	-	-	3	2.5	•
0350	M 3.5	x 0.60	56	13	-	2.5	2.1	5	3	2.9	•
0400	M 4	x 0.70	63	13	-	2.8	2.1	5	3	3.3	•
0500	M 5	x 0.80	70	16	-	3.5	2.7	6	3	4.2	•
0600	M 6	x 1.00	80	19	-	4.5	3.4	6	3	5.0	•
0800	M 8	x 1.25	90	22	-	6.0	4.9	8	3	6.8	•
1000	M 10	x 1.50	100	24	-	7.0	5.5	8	3	8.5	•
1200	M 12	x 1.75	110	28	-	9.0	7.0	10	3	10.2	T121 1200
1400	M 14	x 2.00	110	30	-	11.0	9.0	12	3	12.0	T121 1400
1600	M 16	x 2.00	110	32	-	12.0	9.0	12	3	14.0	T121 1600
1800	M 18	x 2.50	125	34	-	14.0	11.0	14	4	15.5	T121 1800
2000	M 20	x 2.50	140	34	-	16.0	12.0	15	4	17.5	T121 2000

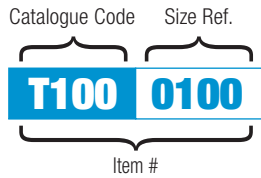
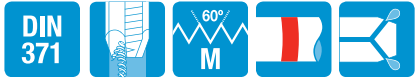
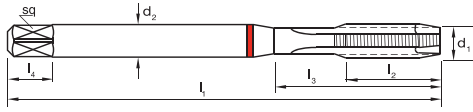
• Available on request as special manufacture. Subject to lead time.



DIN Taps Metric, Gun, H



- Suitable for harder short chipping materials up to 45 HR_c
- Through holes
- Depths up to 3 x d₁



Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
0200	M 2	x 0.40	45	8	-	2.8	2.1	5	3	1.6
0220	M 2.2	x 0.45	45	9	-	2.8	2.1	5	3	1.75
0230	M 2.3	x 0.40	45	9	-	2.8	2.1	5	3	1.9
0250	M 2.5	x 0.45	50	9	-	2.8	2.1	5	3	2.05
0260	M 2.6	x 0.45	50	9	-	2.8	2.1	5	3	2.15
0300	M 3	x 0.50	56	11	18	3.5	2.7	6	3	2.5
0350	M 3.5	x 0.60	56	13	20	4.0	3.0	6	3	2.9
0400	M 4	x 0.70	63	13	21	4.5	3.4	6	3	3.3
0500	M 5	x 0.80	70	16	25	6.0	4.9	8	3	4.2
0600	M 6	x 1.00	80	19	30	6.0	4.9	8	3	5.0
0700	M 7	x 1.00	80	19	30	7.0	5.5	8	3	6.0
0800	M 8	x 1.25	90	22	35	8.0	6.2	9	3	6.8
1000	M 10	x 1.50	100	24	39	10.0	8.0	11	3	8.5



- Catalogue Code
- Discount Group
- Material
- Surface Finish
- Colour Ring & Application
- Geometry
- Chamfer
- Limit & Nut Tolerance

	T144	T146	T148
D0402	D0402	D0408	D0408
PM-HSS Co	PM-HSS Co	PM-HSS Co	PM-HSS Co
Blu	TICN	TICN	TICN
H	H	H	H
Low Relief	Low Relief	Low Relief	Low Relief - IK
Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P
6HX	6HX	6HX	6HX
Item #	Item #	Item #	Item #
•	•	•	•
•	•	•	•
•	•	•	•
•	•	•	•
•	•	•	•
•	•	•	•
T144 0300	T146 0300	•	•
•	•	•	•
T144 0400	T146 0400	•	•
T144 0500	T146 0500	•	•
T144 0600	T146 0600	T148 0600	•
•	•	•	•
T144 0800	T146 0800	T148 0800	•
T144 1000	T146 1000	T148 1000	•

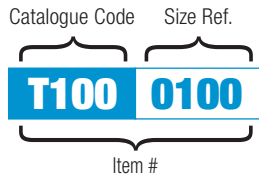
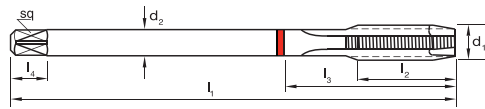
M

• Available on request as special manufacture. Subject to lead time.

DIN Taps Metric, Gun, H



- Suitable for harder short chipping materials up to 45 HRc
- Through holes
- Depths up to 3 x d₁



Catalogue Code	T145	T147	T149
Discount Group	D0402	D0408	D0408
Material	PM-HSS Co	PM-HSS Co	PM-HSS Co
Surface Finish	Blu	TICN	TICN
Colour Ring & Application	H	H	H
Geometry	Low Relief	Low Relief	Low Relief - IK
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P
Limit & Nut Tolerance	6HX	6HX	6HX

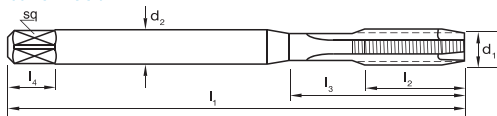
Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #	Item #
0300	M 3	x 0.50	56	11	-	2.2	-	-	3	2.5	•	•	•
0350	M 3.5	x 0.60	56	13	-	2.5	2.1	5	3	2.9	•	•	•
0400	M 4	x 0.70	63	13	-	2.8	2.1	5	3	3.3	•	•	•
0500	M 5	x 0.80	70	16	-	3.5	2.7	6	3	4.2	•	•	•
0600	M 6	x 1.00	80	19	-	4.5	3.4	6	3	5.0	•	•	•
0800	M 8	x 1.25	90	22	-	6.0	4.9	8	3	6.8	•	•	•
1000	M 10	x 1.50	100	24	-	7.0	5.5	8	3	8.5	•	•	•
1200	M 12	x 1.75	110	28	-	9.0	7.0	10	3	10.2	T145 1200	T147 1200	T149 1200
1400	M 14	x 2.00	110	30	-	11.0	9.0	12	3	12.0	T145 1400	T147 1400	T149 1400
1600	M 16	x 2.00	110	32	-	12.0	9.0	12	4	14.0	T145 1600	T147 1600	T149 1600
1800	M 18	x 2.50	125	34	-	14.0	11.0	14	4	15.5	T145 1800	T147 1800	T149 1800
2000	M 20	x 2.50	140	34	-	16.0	12.0	15	4	17.5	T145 2000	T147 2000	T149 2000
2200	M 22	x 2.50	140	34	-	18.0	14.5	17	4	19.5	•	•	•
2400	M 24	x 3.00	160	38	-	18.0	14.5	17	4	21.0	•	•	•
2700	M 27	x 3.00	160	38	-	20.0	16.0	19	4	24.0	•	•	•
3000	M 30	x 3.50	180	45	-	22.0	18.0	21	4	26.5	•	•	•

• Available on request as special manufacture. Subject to lead time.

DIN Taps Metric, Gun, Ti



- For Titanium based alloys
- Through holes
- Depths up to 1.5 x d₁



Catalogue Code Size Ref.

T100 **0100**

Item #



Catalogue Code	T152
Discount Group	D0408
Material	PM-HSS Co
Surface Finish	TICN
Colour Ring & Application	Ti
Geometry	
Chamfer	Form B / 4.5 x P
Limit & Nut Tolerance	ISO 2 / 6H

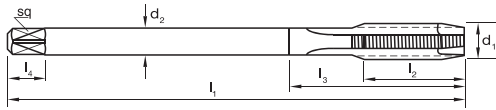
Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #
0200	M 2	x 0.40	45	8	-	2.8	2.1	5	3	1.6	•
0220	M 2.2	x 0.45	45	9	-	2.8	2.1	5	3	1.75	•
0230	M 2.3	x 0.40	45	9	-	2.8	2.1	5	3	1.9	•
0250	M 2.5	x 0.45	50	9	-	2.8	2.1	5	3	2.05	•
0260	M 2.6	x 0.45	50	9	-	2.8	2.1	5	3	2.15	•
0300	M 3	x 0.50	56	11	18	3.5	2.7	6	3	2.5	T152 0300
0350	M 3.5	x 0.60	56	13	20	4.0	3.0	6	3	2.9	•
0400	M 4	x 0.70	63	13	21	4.5	3.4	6	3	3.3	T152 0400
0500	M 5	x 0.80	70	16	25	6.0	4.9	8	3	4.2	T152 0500
0600	M 6	x 1.00	80	19	30	6.0	4.9	8	3	5.0	T152 0600
0700	M 7	x 1.00	80	19	30	7.0	5.5	8	3	6.0	•
0800	M 8	x 1.25	90	22	35	8.0	6.2	9	3	6.8	T152 0800
1000	M 10	x 1.50	100	24	39	10.0	8.0	11	3	8.5	T152 1000

• Available on request as special manufacture. Subject to lead time.

DIN Taps Metric, Gun, Ti



- For Titanium based alloys
- Through holes
- Depths up to 1.5 x d₁



DIN 376



60° M

Catalogue Code Size Ref.



Catalogue Code

T153

Discount Group

D0408

Material

PM-HSS Co

Surface Finish

TICN

Colour Ring & Application

Ti

Geometry

Form B / 4.5 x P

Chamfer

Limit & Nut Tolerance

ISO 2 / 6H

Size Ref/	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #
0300	M 3	x 0.50	56	11	-	2.2	-	-	3	2.5	•
0350	M 3.5	x 0.60	56	13	-	2.5	2.1	5	3	2.9	•
0400	M 4	x 0.70	63	13	-	2.8	2.1	5	3	3.3	•
0500	M 5	x 0.80	70	16	-	3.5	2.7	6	3	4.2	•
0600	M 6	x 1.00	80	19	-	4.5	3.4	6	3	5.0	•
0800	M 8	x 1.25	90	22	-	6.0	4.9	8	3	6.8	•
1000	M 10	x 1.50	100	24	-	7.0	5.5	8	3	8.5	•
1200	M 12	x 1.75	110	28	-	9.0	7.0	10	3	10.2	T153 1200
1400	M 14	x 2.00	110	30	-	11.0	9.0	12	3	12.0	T153 1400
1600	M 16	x 2.00	110	32	-	12.0	9.0	12	4	14.0	T153 1600
1800	M 18	x 2.50	125	34	-	14.0	11.0	14	4	15.5	T153 1800
2000	M 20	x 2.50	140	34	-	16.0	12.0	15	4	17.5	T153 2000
2200	M 22	x 2.50	140	34	-	18.0	14.5	17	4	19.5	•
2400	M 24	x 3.00	160	38	-	18.0	14.5	17	4	21.0	•
2700	M 27	x 3.00	160	38	-	20.0	16.0	19	4	24.0	•
3000	M 30	x 3.50	180	45	-	22.0	18.0	21	4	26.5	•

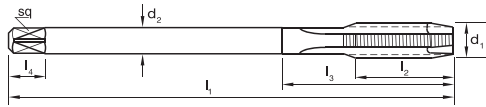
• Available on request as special manufacture. Subject to lead time.



DIN Taps Metric, Gun, Ni



- For Nickel based alloys
- Through holes
- Depths up to 1.5 x d₁

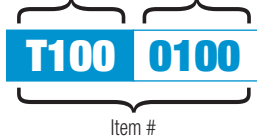


DIN 376



60° M

Catalogue Code Size Ref.



Catalogue Code	T151
Discount Group	D0402
Material	PM-HSS Co
Surface Finish	Br
Colour Ring & Application	Ni
Geometry	
Chamfer	Form B / 4.5 x P
Limit & Nut Tolerance	6HX

Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #
0300	M 3 x 0.50		56	11	-	2.2	-	-	3	2.5	•
0350	M 3.5 x 0.60		56	13	-	2.5	2.1	5	3	2.9	•
0400	M 4 x 0.70		63	13	-	2.8	2.1	5	3	3.3	•
0500	M 5 x 0.80		70	16	-	3.5	2.7	6	3	4.2	•
0600	M 6 x 1.00		80	19	-	4.5	3.4	6	3	5.0	•
0800	M 8 x 1.25		90	22	-	6.0	4.9	8	3	6.8	•
1000	M 10 x 1.50		100	24	-	7.0	5.5	8	3	8.5	•
1200	M 12 x 1.75		110	28	-	9.0	7.0	10	3	10.2	•
1400	M 14 x 2.00		110	30	-	11.0	9.0	12	3	12.0	•
1600	M 16 x 2.00		110	32	-	12.0	9.0	12	4	14.0	•
1800	M 18 x 2.50		125	34	-	14.0	11.0	14	4	15.5	•
2000	M 20 x 2.50		140	34	-	16.0	12.0	15	4	17.5	•
2200	M 22 x 2.50		140	34	-	18.0	14.5	17	4	19.5	•
2400	M 24 x 3.00		160	38	-	18.0	14.5	17	4	21.0	•
2700	M 27 x 3.00		160	38	-	20.0	16.0	19	4	24.0	•
3000	M 30 x 3.50		180	45	-	22.0	18.0	21	4	26.5	•

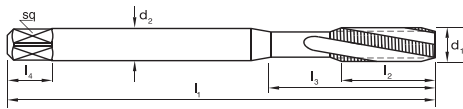
• Available on request as special manufacture. Subject to lead time.



DIN Taps Metric, Spiral Flute, R15 N



- General purpose use
- Suitable for materials up to 1000N/mm²
- Blind holes
- Depths up to 1.5 x d₁



Catalogue Code Size Ref.



Catalogue Code

T183

Discount Group

D0402

Material

HSSE V3

Surface Finish

Brt

Colour Ring & Application

N

Geometry

R15°

Chamfer

Form C / 2.5 x P

Limit & Nut Tolerance

ISO 2 / 6H

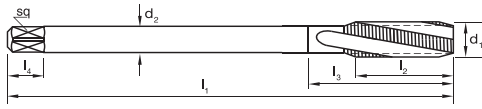
Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #
0200	M 2	x 0.40	45	8	-	2.8	2.1	5	3	1.6	T183 0200
0220	M 2.2	x 0.45	45	9	-	2.8	2.1	5	3	1.75	•
0230	M 2.3	x 0.40	45	9	-	2.8	2.1	5	3	1.9	•
0250	M 2.5	x 0.45	50	9	-	2.8	2.1	5	3	2.05	T183 0250
0260	M 2.6	x 0.45	50	9	-	2.8	2.1	5	3	2.15	•
0300	M 3	x 0.50	56	11	18	3.5	2.7	6	3	2.5	T183 0300
0350	M 3.5	x 0.60	56	13	20	4.0	3.0	6	3	2.9	T183 0350
0400	M 4	x 0.70	63	13	21	4.5	3.4	6	3	3.3	T183 0400
0500	M 5	x 0.80	70	16	25	6.0	4.9	8	3	4.2	T183 0500
0600	M 6	x 1.00	80	19	30	6.0	4.9	8	3	5.0	T183 0600
0700	M 7	x 1.00	80	19	30	7.0	5.5	8	3	6.0	•
0800	M 8	x 1.25	90	22	35	8.0	6.2	9	3	6.8	T183 0800
1000	M 10	x 1.50	100	24	39	10.0	8.0	11	3	8.5	T183 1000

• Available on request as special manufacture. Subject to lead time.

DIN Taps Metric, Spiral Flute, R15 N



- General purpose use
- Suitable for materials up to 1000N/mm²
- Blind holes
- Depths up to 1.5 x d₁



Catalogue Code Size Ref.



Catalogue Code	T184
Discount Group	D0402
Material	HSSE V3
Surface Finish	BrT
Colour Ring & Application	N
Geometry	R15°
Chamfer	Form C / 2.5 x P
Limit & Nut Tolerance	ISO 2 / 6H

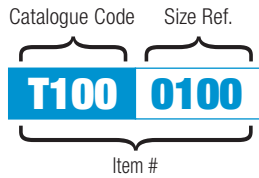
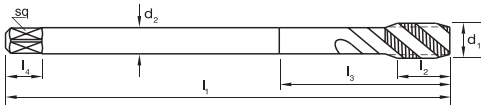
Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #
0300	M 3 x 0.50		56	11	-	2.2	-	-	3	2.5	•
0350	M 3.5 x 0.60		56	13	-	2.5	2.1	5	3	2.9	•
0400	M 4 x 0.70		63	13	-	2.8	2.1	5	3	3.3	•
0500	M 5 x 0.80		70	16	-	3.5	2.7	6	3	4.2	•
0600	M 6 x 1.00		80	19	-	4.5	3.4	6	3	5.0	•
0800	M 8 x 1.25		90	22	-	6.0	4.9	8	3	6.8	•
1000	M 10 x 1.50		100	24	-	7.0	5.5	8	3	8.5	•
1200	M 12 x 1.75		110	28	-	9.0	7.0	10	3	10.2	T184 1200
1400	M 14 x 2.00		110	30	-	11.0	9.0	12	3	12.0	T184 1400
1600	M 16 x 2.00		110	32	-	12.0	9.0	12	4	14.0	T184 1600
1800	M 18 x 2.50		125	34	-	14.0	11.0	14	4	15.5	T184 1800
2000	M 20 x 2.50		140	34	-	16.0	12.0	15	4	17.5	T184 2000
2200	M 22 x 2.50		140	34	-	18.0	14.5	17	4	19.5	•
2400	M 24 x 3.00		160	38	-	18.0	14.5	17	4	21.0	•
2700	M 27 x 3.00		160	38	-	20.0	16.0	19	4	24.0	•
3000	M 30 x 3.50		180	45	-	22.0	18.0	21	4	26.5	•

• Available on request as special manufacture. Subject to lead time.

DIN Taps Metric, Spiral Flute, R40 N



- General purpose use
- Suitable for materials up to 1000N/mm²
- Blind holes
- Depths up to 2.5 x d₁



Catalogue Code	T188	T190
Discount Group	D0402	D0402
Material	HSSE V3	HSSE V3
Surface Finish	Br	Blu
Colour Ring & Application	N	N
Geometry	R40°	R40°
Chamfer	Form C / 2.5 x P	Form C / 2.5 x P
Limit & Nut Tolerance	ISO 2 / 6H	ISO 2 / 6H

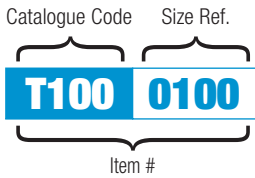
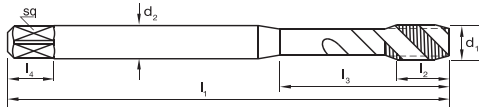
Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #
0300	M 3	x 0.50	56	5	-	2.2	-	-	3	2.5	•	•
0350	M 3.5	x 0.60	56	6	-	2.5	2.1	5	3	2.9	•	•
0400	M 4	x 0.70	63	7	-	2.8	2.1	5	3	3.3	•	•
0500	M 5	x 0.80	70	8	-	3.5	2.7	6	3	4.2	T188 0500	T190 0500
0600	M 6	x 1.00	80	10	-	4.5	3.4	6	3	5.0	T188 0600	T190 0600
0800	M 8	x 1.25	90	13	-	6.0	4.9	8	3	6.8	T188 0800	T190 0800
0900	M 9	x 1.25	90	13	-	9.0	7.0	10	3	7.8	•	•
1000	M 10	x 1.50	100	15	-	7.0	5.5	8	3	8.5	T188 1000	T190 1000
1200	M 12	x 1.75	110	18	-	9.0	7.0	10	3	10.2	T188 1200	T190 1200
1400	M 14	x 2.00	110	20	-	11.0	9.0	12	3	12.0	T188 1400	T190 1400
1600	M 16	x 2.00	110	20	-	12.0	9.0	12	3	14.0	T188 1600	T190 1600
1800	M 18	x 2.50	125	25	-	14.0	11.0	14	4	15.5	T188 1800	T190 1800
2000	M 20	x 2.50	140	25	-	16.0	12.0	15	4	17.5	T188 2000	T190 2000
2200	M 22	x 2.50	140	25	-	18.0	14.5	17	4	19.5	T188 2200	T190 2200
2400	M 24	x 3.00	160	30	-	18.0	14.5	17	4	21.0	T188 2400	T190 2400
2700	M 27	x 3.00	160	30	-	20.0	16.0	19	4	24.0	T188 2700	T190 2700
3000	M 30	x 3.50	180	45	-	22.0	18.0	21	4	26.5	T188 3000	T190 3000
3300	M 33	x 3.50	180	35	-	25.0	20.0	23	4	29.5	T188 3300	T190 3300
3600	M 36	x 4.00	200	40	-	28.0	22.0	25	4	32.0	T188 3600	T190 3600
3900	M 39	x 4.00	200	40	-	32.0	24.0	27	4	35.0	T188 3900	T190 3900
4200	M 42	x 4.50	200	45	-	32.0	24.0	27	4	37.5	T188 4200	T190 4200
4500	M 45	x 4.50	220	45	-	36.0	29.0	32	4	40.5	T188 4500	T190 4500
4800	M 48	x 5.00	250	50	-	36.0	29.0	32	4	43.0	T188 4800	T190 4800
5200	M 52	x 5.00	250	50	-	40.0	32.0	35	4	47.0	T188 5200	T190 5200

• Available on request as special manufacture. Subject to lead time.

DIN Taps Metric, Spiral Flute, R40 N - 6G, 4H, LH



- General purpose use
- Suitable for materials up to 1000N/mm²
- Blind holes
- Depths up to 2.5 x d₁



Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
0160	M 1.6	x 0.35	40	8	-	2.5	2.1	5	2	1.25
0200	M 2	x 0.40	45	8	-	2.8	2.1	5	2	1.6
0220	M 2.2	x 0.45	45	9	-	2.8	2.1	5	2	1.75
0230	M 2.3	x 0.40	45	9	-	2.8	2.1	5	2	1.9
0250	M 2.5	x 0.45	50	9	-	2.8	2.1	5	2	2.05
0260	M 2.6	x 0.45	50	9	-	2.8	2.1	5	2	2.15
0300	M 3	x 0.50	56	5	18	3.5	2.7	6	3	2.5
0350	M 3.5	x 0.60	56	6	20	4.0	3.0	6	3	2.9
0400	M 4	x 0.70	63	7	21	4.5	3.4	6	3	3.3
0500	M 5	x 0.80	70	8	25	6.0	4.9	8	3	4.2
0600	M 6	x 1.00	80	10	30	6.0	4.9	8	3	5.0
0700	M 7	x 1.00	80	10	30	7.0	5.5	8	3	6.0
0800	M 8	x 1.25	90	13	35	8.0	6.2	9	3	6.8
1000	M 10	x 1.50	100	15	39	10.0	8.0	11	3	8.5



- Catalogue Code
- Discount Group
- Material
- Surface Finish
- Colour Ring & Application
- Geometry
- Chamfer
- Limit & Nut Tolerance

	T191	T193	T195
Catalogue Code	D0402	D0402	D0402
Discount Group	D0402	D0402	D0402
Material	HSSE V3	HSSE V3	HSSE V3
Surface Finish	Brt	Brt	Brt
Colour Ring & Application	N	N	N
Geometry	R40° - 6G	R40° - 4H	L40°
Chamfer	Form C / 2.5 x P	Form C / 2.5 x P	Form C / 2.5 x P
Limit & Nut Tolerance	ISO 3 / 6G	ISO 1 / 4H	ISO 2 / 6H
	Item #	Item #	Item #
	•	•	•
	T191 0200	T193 0200	•
	•	•	•
	•	•	•
	T191 0250	T193 0250	•
	•	•	•
	T191 0300	T193 0300	T195 0300
	•	•	•
	T191 0400	T193 0400	T195 0400
	T191 0500	T193 0500	T195 0500
	T191 0600	T193 0600	T195 0600
	•	•	•
	T191 0800	T193 0800	T195 0800
	T191 1000	T193 1000	T195 1000

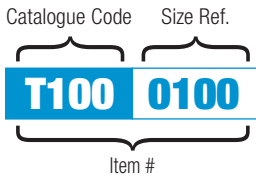
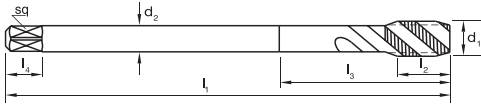
M

• Available on request as special manufacture. Subject to lead time.

DIN Taps Metric, Spiral Flute, R40 N - 6G, 4H, LH



- General purpose use
- Suitable for materials up to 1000N/mm²
- Blind holes
- Depths up to 2.5 x d₁



Catalogue Code	T192	T194	T196
Discount Group	D0402	D0402	D0402
Material	HSSE V3	HSSE V3	HSSE V3
Surface Finish	Brt	Brt	Brt
Colour Ring & Application	N	N	N
Geometry	R40° - 6G	R40° - 4H	L40°
Chamfer	Form C / 2.5 x P	Form C / 2.5 x P	Form C / 2.5 x P
Limit & Nut Tolerance	ISO 3 / 6G	ISO 1 / 4H	ISO 2 / 6H

Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #	Item #
0300	M 3	x 0.50	56	5	-	2.2	-	-	3	2.5	•	•	•
0350	M 3.5	x 0.60	56	6	-	2.5	2.1	5	3	2.9	•	•	•
0400	M 4	x 0.70	63	7	-	2.8	2.1	5	3	3.3	•	•	•
0500	M 5	x 0.80	70	8	-	3.5	2.7	6	3	4.2	•	•	•
0600	M 6	x 1.00	80	10	-	4.5	3.4	6	3	5.0	•	•	•
0800	M 8	x 1.25	90	13	-	6.0	4.9	8	3	6.8	•	•	•
1000	M 10	x 1.50	100	15	-	7.0	5.5	8	3	8.5	•	•	•
1200	M 12	x 1.75	110	18	-	9.0	7.0	10	3	10.2	T192 1200	•	T196 1200
1400	M 14	x 2.00	110	20	-	11.0	9.0	12	3	12.0	T192 1400	•	T196 1400
1600	M 16	x 2.00	110	20	-	12.0	9.0	12	3	14.0	T192 1600	•	T196 1600
1800	M 18	x 2.50	125	25	-	14.0	11.0	14	4	15.5	T192 1800	•	T196 1800
2000	M 20	x 2.50	140	25	-	16.0	12.0	15	4	17.5	T192 2000	•	T196 2000

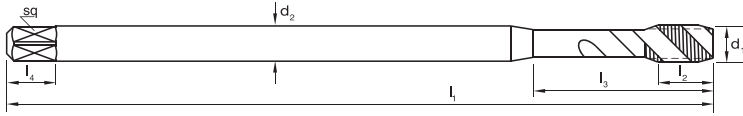
• Available on request as special manufacture. Subject to lead time.



DIN Taps Metric, Spiral Flute, R40 N, Extra Length



- For long reach applications
- Suitable for materials up to 1000N/mm²
- Depths up to 2.5 x d₁
- d₂ and sq in accordance to DIN376



Catalogue Code Size Ref.
T100 **0100**
 Item #

Catalogue Code	T339
Discount Group	D0402
Material	HSSE V3
Surface Finish	Brt
Colour Ring & Application	N
Geometry	R40° - Extra Length
Chamfer	Form C / 2.5 x P
Limit & Nut Tolerance	ISO 2 / 6H

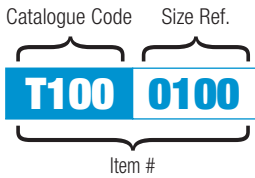
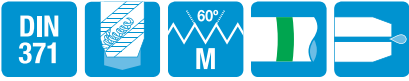
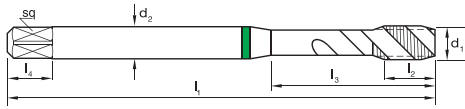
Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #
0300	M 3	x 0.50	112	5		3.5	2.7	6	3	2.5	T339 0300
0400	M 4	x 0.70	126	7		4.5	3.4	6	3	3.3	T339 0400
0500	M 5	x 0.80	140	8		6.0	4.9	8	3	4.2	T339 0500
0600	M 6	x 1.00	160	10		6.0	4.9	8	3	5.0	T339 0600
0800	M 8	x 1.25	180	13		8.0	6.2	10	3	6.8	T339 0800

M

DIN Taps Metric, Spiral Flute, R40 UNI



- Universal use
- Suitable for materials up to 1200N/mm²
- Blind holes
- Depths up to 2.5 x d₁



Catalogue Code
Discount Group
Material
Surface Finish
Colour Ring & Application
Geometry
Chamfer
Limit & Nut Tolerance

	T219	T221	T227	T229
Discount Group	D0402	D0402	D0410	D0410
Material	PM-HSSE V3	PM-HSSE V3	PM-HSSE V3	PM-HSSE V3
Surface Finish	Br t	Bl u	Ti AIN	Ti AIN
Colour Ring & Application	UNI	UNI	UNI	UNI
Geometry	R40°	R40°	R40°	R40° Internal Coolant
Chamfer	Form C / 2.5 x P	Form C / 2.5 x P	Form C / 2.5 x P	Form C / 2.5 x P
Limit & Nut Tolerance	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H



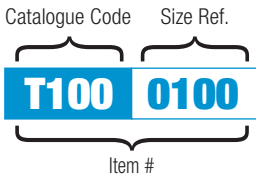
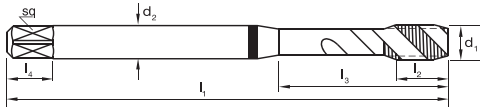
Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
0200	M 2	x 0.40	45	8	-	2.8	2.1	5	3	1.6
0220	M 2.2	x 0.45	45	9	-	2.8	2.1	5	3	1.75
0230	M 2.3	x 0.40	45	9	-	2.8	2.1	5	3	1.9
0250	M 2.5	x 0.45	50	9	-	2.8	2.1	5	3	2.05
0260	M 2.6	x 0.45	50	9	-	2.8	2.1	5	3	2.15
0300	M 3	x 0.50	56	5	18	3.5	2.7	6	3	2.5
0350	M 3.5	x 0.60	56	6	20	4.0	3.0	6	3	2.9
0400	M 4	x 0.70	63	7	21	4.5	3.4	6	3	3.3
0500	M 5	x 0.80	70	8	25	6.0	4.9	8	3	4.2
0600	M 6	x 1.00	80	10	30	6.0	4.9	8	3	5.0
0700	M 7	x 1.00	80	10	30	7.0	5.5	8	3	6.0
0800	M 8	x 1.25	90	12.5	35	8.0	6.2	9	3	6.8
1000	M 10	x 1.50	100	15	39	10.0	8.0	11	3	8.5

Item #	Item #	Item #	Item #
•	•	•	•
•	•	•	•
•	•	•	•
•	•	•	•
•	•	•	•
•	•	•	•
T219 0300	T221 0300	T227 0300	•
•	•	•	•
T219 0400	T221 0400	T227 0400	•
T219 0500	T221 0500	T227 0500	T229 0500
T219 0600	T221 0600	T227 0600	T229 0600
•	•	•	•
T219 0800	T221 0800	T227 0800	T229 0800
T219 1000	T221 1000	T227 1000	T229 1000

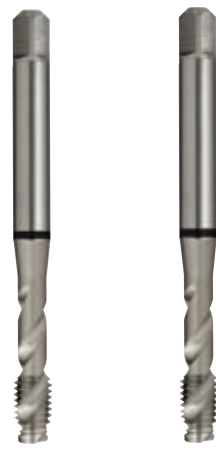
DIN Taps Metric, Spiral Flute, R45 Al



- Suitable for use in wrought aluminium and low silicon aluminium
- Blind holes
- Depths up to $3 \times d_1$
- CrN for longer tool life



Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
0200	M 2	x 0.40	45	8	-	2.8	2.1	5	2	1.6
0220	M 2.2	x 0.45	45	9	-	2.8	2.1	5	2	1.75
0230	M 2.3	x 0.40	45	9	-	2.8	2.1	5	2	1.9
0250	M 2.5	x 0.45	50	9	-	2.8	2.1	5	2	2.05
0260	M 2.6	x 0.45	50	9	-	2.8	2.1	5	2	2.15
0300	M 3	x 0.50	56	5	18	3.5	2.7	6	2	2.5
0350	M 3.5	x 0.60	56	6	20	4.0	3.0	6	2	2.9
0400	M 4	x 0.70	63	7	21	4.5	3.4	6	2	3.3
0500	M 5	x 0.80	70	8	25	6.0	4.9	8	2	4.2
0600	M 6	x 1.00	80	10	30	6.0	4.9	8	2	5.0
0700	M 7	x 1.00	80	10	30	7.0	5.5	8	2	6.0
0800	M 8	x 1.25	90	12.5	35	8.0	6.2	9	2	6.8
1000	M 10	x 1.50	100	15	39	10.0	8.0	11	2	8.5



Catalogue Code	T231	T233
Discount Group	D0402	D0404
Material	HSSE V3	HSSE V3
Surface Finish	BrT	CrN
Colour Ring & Application	Al	Al
Geometry	R45° 2 Flute	R45° 2 Flute
Chamfer	Form C / 2.5 x P	Form C / 2.5 x P
Limit & Nut Tolerance	ISO 2 / 6H	ISO 2 / 6H

Item #	Item #
T231 0200	•
•	•
•	•
T231 0250	•
•	•
T231 0300	T233 0300
T231 0350	•
T231 0400	T233 0400
T231 0500	T233 0500
T231 0600	T233 0600
•	•
T231 0800	T233 0800
T231 1000	T233 1000

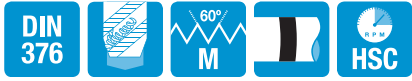
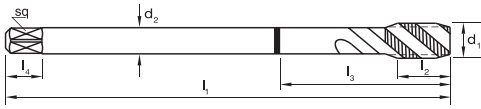
M

• Available on request as special manufacture. Subject to lead time.

DIN Taps Metric, Spiral Flute, R45 Al



- Suitable for use in wrought aluminium and low silicon aluminium
- Blind holes
- Depths up to $3 \times d_1$
- CrN for longer tool life



Catalogue Code Size Ref.



Catalogue Code	T232	T234
Discount Group	D0402	D0404
Material	HSSE V3	HSSE V3
Surface Finish	Brt	CrN
Colour Ring & Application	Al	Al
Geometry	R45° 2 Flute	R45° 2 Flute
Chamfer	Form C / 2.5 x P	Form C / 2.5 x P
Limit & Nut Tolerance	ISO 2 / 6H	ISO 2 / 6H

Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #
0300	M 3	x 0.50	56	6	-	2.2	-	-	2	2.5	•	•
0350	M 3.5	x 0.60	56	6	-	2.5	2.1	5	2	2.9	•	•
0400	M 4	x 0.70	63	7	-	2.8	2.1	5	2	3.3	•	•
0500	M 5	x 0.80	70	8	-	3.5	2.7	6	2	4.2	•	•
0600	M 6	x 1.00	80	10	-	4.5	3.4	6	2	5.0	•	•
0800	M 8	x 1.25	90	12.5	-	6.0	4.9	8	2	6.8	•	•
1000	M 10	x 1.50	100	15	-	7.0	5.5	8	2	8.5	•	•
1200	M 12	x 1.75	110	17.5	-	9.0	7.0	10	2	10.2	T232 1200	T234 1200
1400	M 14	x 2.00	110	20	-	11.0	9.0	12	2	12.0	T232 1400	T234 1400
1600	M 16	x 2.00	110	20	-	12.0	9.0	12	2	14.0	T232 1600	T234 1600
1800	M 18	x 2.50	125	25	-	14.0	11.0	14	2	15.5	T232 1800	T234 1800
2000	M 20	x 2.50	140	25	-	16.0	12.0	15	2	17.5	T232 2000	T234 2000

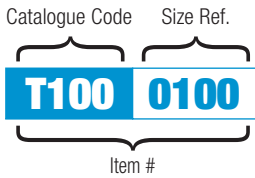
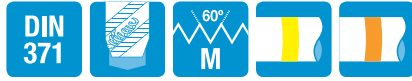
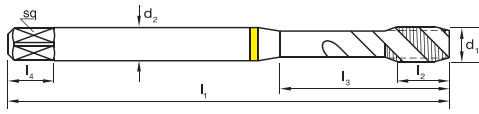
• Available on request as special manufacture. Subject to lead time.



DIN Taps Metric, Spiral Flute, R45 W & Cu



- Suitable for use in soft materials
- CrN for copper and non-ferrous materials
- Blind holes
- Depths up to 3 x d₁



Catalogue Code
Discount Group
Material
Surface Finish
Colour Ring & Application
Geometry
Chamfer
Limit & Nut Tolerance

T235	T237	T241	T239
D0402	D0402	D0406	D0404
HSSE V3	HSSE V3	HSSE V3	HSSE V3
Ni	Blu	TiN	CrN
W	W	W	Cu
R45°	R45°	R45°	R45°
Form C / 2.5 x P	Form C / 2.5 x P	Form C / 2.5 x P	Form C / 2.5 x P
ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H



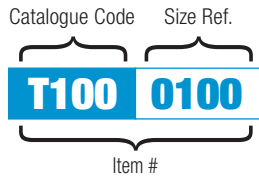
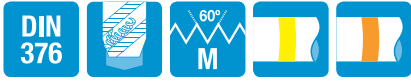
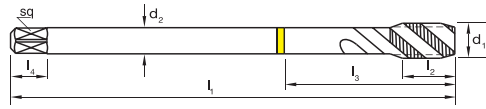
Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
0200	M 2	x 0.40	45	8	-	2.8	2.1	5	2	1.6
0220	M 2.2	x 0.45	45	9	-	2.8	2.1	5	2	1.75
0230	M 2.3	x 0.40	45	9	-	2.8	2.1	5	2	1.9
0250	M 2.5	x 0.45	50	9	-	2.8	2.1	5	2	2.05
0260	M 2.6	x 0.45	50	9	-	2.8	2.1	5	2	2.15
0300	M 3	x 0.50	56	5	18	3.5	2.7	6	3	2.5
0350	M 3.5	x 0.60	56	6	20	4.0	3.0	6	3	2.9
0400	M 4	x 0.70	63	7	21	4.5	3.4	6	3	3.3
0500	M 5	x 0.80	70	8	25	6.0	4.9	8	3	4.2
0600	M 6	x 1.00	80	10	30	6.0	4.9	8	3	5.0
0700	M 7	x 1.00	80	10	30	7.0	5.5	8	3	6.0
0800	M 8	x 1.25	90	12.5	35	8.0	6.2	9	3	6.8
1000	M 10	x 1.50	100	15	39	10.0	8.0	11	3	8.5

Item #	Item #	Item #	Item #
T235 0200	•	•	•
•	•	•	•
•	•	•	•
•	•	•	•
T235 0250	•	•	•
•	•	•	•
T235 0300	T237 0300	T241 0300	T239 0300
T235 0350	•	T241 0350	•
T235 0400	T237 0400	T241 0400	T239 0400
T235 0500	T237 0500	T241 0500	T239 0500
T235 0600	T237 0600	T241 0600	T239 0600
•	•	•	•
T235 0800	T237 0800	T241 0800	T239 0800
T235 1000	T237 1000	T241 1000	T239 1000

DIN Taps Metric, Spiral Flute, R45 W & Cu



- Suitable for use in soft materials
- CrN for copper and non-ferrous materials
- Blind holes
- Depths up to 3 x d₁



Catalogue Code	T236	T238	T242	T240
Discount Group	D0402	D0402	D0406	D0404
Material	HSSE V3	HSSE V3	HSSE V3	HSSE V3
Surface Finish	Ni	Blu	TiN	CrN
Colour Ring & Application	W	W	W	Cu
Geometry	R45°	R45°	R45°	R45°
Chamfer	Form C / 2.5 x P	Form C / 2.5 x P	Form C / 2.5 x P	Form C / 2.5 x P
Limit & Nut Tolerance	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H

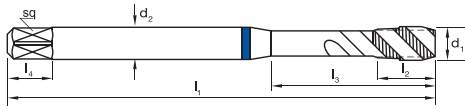
Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #	Item #	Item #
0300	M 3	x 0.50	56	6	-	2.2	-	-	3	2.5	•	•	•	•
0350	M 3.5	x 0.60	56	6	-	2.5	2.1	5	3	2.9	•	•	•	•
0400	M 4	x 0.70	63	7	-	2.8	2.1	5	3	3.3	•	•	•	•
0500	M 5	x 0.80	70	8	-	3.5	2.7	6	3	4.2	•	•	•	•
0600	M 6	x 1.00	80	10	-	4.5	3.4	6	3	5.0	T236 0600	•	T242 0600	T240 0600
0800	M 8	x 1.25	90	12.5	-	6.0	4.9	8	3	6.8	T236 0800	•	T242 0800	•
1000	M 10	x 1.50	100	15	-	7.0	5.5	8	3	8.5	T236 1000	•	T242 1000	•
1200	M 12	x 1.75	110	17.5	-	9.0	7.0	10	3	10.2	T236 1200	T238 1200	T242 1200	T240 1200
1400	M 14	x 2.00	110	20	-	11.0	9.0	12	3	12.0	T236 1400	T238 1400	T242 1400	T240 1400
1600	M 16	x 2.00	110	20	-	12.0	9.0	12	4	14.0	T236 1600	T238 1600	T242 1600	T240 1600
1800	M 18	x 2.50	125	25	-	14.0	11.0	14	4	15.5	T236 1800	T238 1800	T242 1800	T240 1800
2000	M 20	x 2.50	140	25	-	16.0	12.0	15	4	17.5	T236 2000	T238 2000	T242 2000	T240 2000

• Available on request as special manufacture. Subject to lead time.

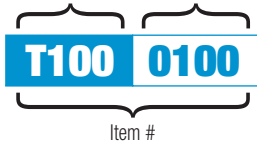
DIN Taps Metric, Spiral Flute, R45 VADH



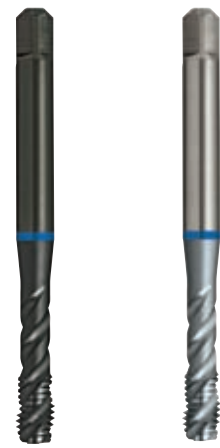
- Suitable for controlled tapping in deep holes
- Use in stainless steels and high strength steels up to 850N/mm²
- Blind holes
- Depths up to 3 x d₁



Catalogue Code Size Ref.



Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #
0200	M 2	x 0.40	45	8	-	2.8	2.1	5	3	1.6	•	•
0220	M 2.2	x 0.45	45	9	-	2.8	2.1	5	3	1.75	•	•
0230	M 2.3	x 0.40	45	9	-	2.8	2.1	5	3	1.9	•	•
0250	M 2.5	x 0.45	50	9	-	2.8	2.1	5	3	2.05	•	•
0260	M 2.6	x 0.45	50	9	-	2.8	2.1	5	3	2.15	•	•
0300	M 3	x 0.50	56	5	18	3.5	2.7	6	3	2.5	T197 0300	T201 0300
0350	M 3.5	x 0.60	56	6	20	4.0	3.0	6	3	2.9	•	•
0400	M 4	x 0.70	63	7	21	4.5	3.4	6	3	3.3	T197 0400	T201 0400
0500	M 5	x 0.80	70	8	25	6.0	4.9	8	3	4.2	T197 0500	T201 0500
0600	M 6	x 1.00	80	10	30	6.0	4.9	8	3	5.0	T197 0600	T201 0600
0700	M 7	x 1.00	80	10	30	7.0	5.5	8	3	6.0	•	•
0800	M 8	x 1.25	90	12.5	35	8.0	6.2	9	3	6.8	T197 0800	T201 0800
1000	M 10	x 1.50	100	15	39	10.0	8.0	11	3	8.5	T197 1000	T201 1000

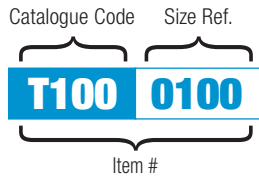
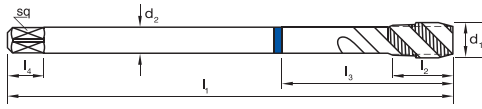


Catalogue Code	T197	T201
Discount Group	D0402	D0408
Material	HSSE V3	HSSE V3
Surface Finish	Blu	TICN
Colour Ring & Application	VA	VA
Geometry	R45° Back Chamf.	R45° Back Chamf.
Chamfer	Form C / 2.5 x P	Form C / 2.5 x P
Limit & Nut Tolerance	ISO 2 / 6H	ISO 2 / 6H

DIN Taps Metric, Spiral Flute, R45 VADH



- Suitable for controlled tapping in deep holes
- Use in stainless steels and high strength steels up to 850N/mm²
- Blind holes
- Depths up to 3 x d₁



Catalogue Code	T199	T202
Discount Group	D0402	D0408
Material	HSSE V3	HSSE V3
Surface Finish	Blu	TICN
Colour Ring & Application	VA	VA
Geometry	R45° Back Chamf.	R45° Back Chamf.
Chamfer	Form C / 2.5 x P	Form C / 2.5 x P
Limit & Nut Tolerance	ISO 2 / 6H	ISO 2 / 6H

Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #
0300	M 3 x 0.50	56	6	-	2.2	-	-	3	2.5		•	•
0350	M 3.5 x 0.60	56	6	-	2.5	2.1	5	3	2.9		•	•
0400	M 4 x 0.70	63	7	-	2.8	2.1	5	3	3.3		•	•
0500	M 5 x 0.80	70	8	-	3.5	2.7	6	3	4.2		•	•
0600	M 6 x 1.00	80	10	-	4.5	3.4	6	3	5.0		T199 0600	T202 0600
0800	M 8 x 1.25	90	12.5	-	6.0	4.9	8	3	6.8		T199 0800	T202 0800
1000	M 10 x 1.50	100	15	-	7.0	5.5	8	3	8.5		T199 1000	T202 1000
1200	M 12 x 1.75	110	17.5	-	9.0	7.0	10	3	10.2		T199 1200	T202 1200
1400	M 14 x 2.00	110	20	-	11.0	9.0	12	3	12.0		T199 1400	T202 1400
1600	M 16 x 2.00	110	20	-	12.0	9.0	12	4	14.0		T199 1600	T202 1600
1800	M 18 x 2.50	125	25	-	14.0	11.0	14	4	15.5		T199 1800	T202 1800
2000	M 20 x 2.50	140	25	-	16.0	12.0	15	4	17.5		T199 2000	T202 2000
2200	M 22 x 2.50	140	25	-	18.0	14.5	17	4	19.5		T199 2200	T202 2200
2400	M 24 x 3.00	160	30	-	18.0	14.5	17	4	21.0		T199 2400	T202 2400
2700	M 27 x 3.00	160	30	-	20.0	16.0	19	4	24.0		T199 2700	T202 2700
3000	M 30 x 3.50	180	35	-	22.0	18.0	21	4	26.5		T199 3000	T202 3000

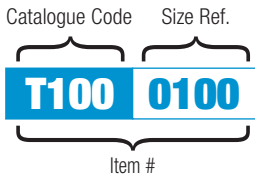
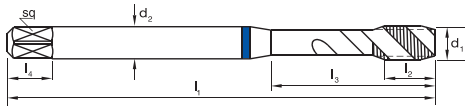
• Available on request as special manufacture. Subject to lead time.



DIN Taps Metric, Spiral Flute, R50 VA PM



- Universal high performance tapping
- PM-HSSE V3 offers superior tool life
- Use in stainless steels and high strength steels up to 850N/mm²
- Deep blind holes
- Depths up to 3 x d₁



Catalogue Code
Discount Group
Material
Surface Finish
Colour Ring & Application
Geometry
Chamfer
Limit & Nut Tolerance

	T203	T205	T678	T676
Discount Group	D0402	D0408	D0408	D0408
Material	PM-HSSE V3	PM-HSSE V3	PM-HSSE V3	PM-HSSE V3
Surface Finish	Blu	TICN	TICN	TICN
Colour Ring & Application	VA PM	VA PM	VA PM	VA PM
Geometry	R50°	R50°	R50°	R50°
Chamfer	Form C / 2.5 x P	Form C / 2.5 x P	Form C / 2.5 x P	Form E / 1.5 x P
Limit & Nut Tolerance	6HX	6HX	6GX	6HX
Item #	Item #	Item #	Item #	Item #
•	T205 0160	•	•	
•	T205 0200	T678 0200	T676 0200	
•	•	•	•	
•	•	•	•	
•	T205 0250	T678 0250	T676 0250	
•	•	•	•	
T203 0300	T205 0300	T678 0300	T676 0300	
•	T205 0350	T678 0350	T676 0350	
T203 0400	T205 0400	T678 0400	T676 0400	
T203 0500	T205 0500	T678 0500	T676 0500	
T203 0600	T205 0600	T678 0600	T676 0600	
•	•	•	•	
T203 0800	T205 0800	T678 0800	T676 0800	
T203 1000	T205 1000	T678 1000	T676 1000	

Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
0160	M 1.6	x 0.35	40	8	-	2.5	2.1	5	3	1.25
0200	M 2	x 0.40	45	8	-	2.8	2.1	5	3	1.6
0220	M 2.2	x 0.45	45	9	-	2.8	2.1	5	3	1.75
0230	M 2.3	x 0.40	45	9	-	2.8	2.1	5	3	1.9
0250	M 2.5	x 0.45	50	9	-	2.8	2.1	5	3	2.05
0260	M 2.6	x 0.45	50	9	-	2.8	2.1	5	3	2.15
0300	M 3	x 0.50	56	5	18	3.5	2.7	6	3	2.5
0350	M 3.5	x 0.60	56	6	20	4.0	3.0	6	3	2.9
0400	M 4	x 0.70	63	7	21	4.5	3.4	6	3	3.3
0500	M 5	x 0.80	70	8	25	6.0	4.9	8	3	4.2
0600	M 6	x 1.00	80	10	30	6.0	4.9	8	3	5.0
0700	M 7	x 1.00	80	10	30	7.0	5.5	8	3	6.0
0800	M 8	x 1.25	90	12.5	35	8.0	6.2	9	3	6.8
1000	M 10	x 1.50	100	15	39	10.0	8.0	11	3	8.5

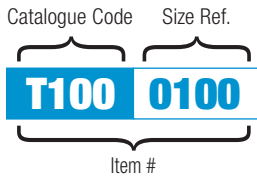
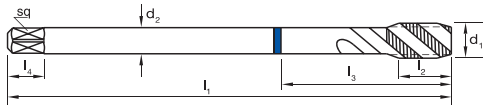
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• Available on request as special manufacture. Subject to lead time.

DIN Taps Metric, Spiral Flute, R50 VA PM



- Universal high performance tapping
- PM-HSSE V3 offers superior tool life
- Use in stainless steels and high strength steels up to 850N/mm²
- Deep blind holes
- Depths up to 3 x d₁



Catalogue Code
Discount Group
Material
Surface Finish
Colour Ring & Application
Geometry
Chamfer
Limit & Nut Tolerance

T204	T206	T679	T677
D0402	D0408	D0408	D0408
PM-HSSE V3	PM-HSSE V3	PM-HSSE V3	PM-HSSE V3
Blu	TICN	TICN	TICN
VA PM	VA PM	VA PM	VA PM
R50°	R50°	R50°	R50°
Form C / 2.5 x P	Form C / 2.5 x P	Form C / 2.5 x P	Form E / 1.5 x P
6HX	6HX	6GX	6HX

Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #	Item #	Item #
0300	M 3	x 0.50	56	6	-	2.2	-	-	3	2.5	•	•	•	•
0350	M 3.5	x 0.60	56	6	-	2.5	2.1	5	3	2.9	•	•	•	•
0400	M 4	x 0.70	63	7	-	2.8	2.1	5	3	3.3	•	•	•	•
0500	M 5	x 0.80	70	8	-	3.5	2.7	6	3	4.2	•	•	•	•
0600	M 6	x 1.00	80	10	-	4.5	3.4	6	3	5.0	•	•	•	•
0800	M 8	x 1.25	90	12.5	-	6.0	4.9	8	3	6.8	•	•	•	•
1000	M 10	x 1.50	100	15	-	7.0	5.5	8	3	8.5	•	•	•	•
1200	M 12	x 1.75	110	17.5	-	9.0	7.0	10	3	10.2	T204 1200	T206 1200	T679 1200	T677 1200
1400	M 14	x 2.00	110	20	-	11.0	9.0	12	3	12.0	T204 1400	T206 1400	T679 1400	T677 1400
1600	M 16	x 2.00	110	20	-	12.0	9.0	12	4	14.0	T204 1600	T206 1600	T679 1600	T677 1600
1800	M 18	x 2.50	125	25	-	14.0	11.0	14	4	15.5	T204 1800	T206 1800	T679 1800	T677 1800
2000	M 20	x 2.50	140	25	-	16.0	12.0	15	4	17.5	T204 2000	T206 2000	T679 2000	T677 2000
2200	M 22*	x 2.50	140	25	-	18.0	14.5	17	4	19.5	T204 2200	T206 2200	T679 2200	T677 2200
2400	M 24*	x 3.00	160	30	-	18.0	14.5	17	4	21.0	T204 2400	T206 2400	T679 2400	T677 2400
2700	M 27*	x 3.00	160	30	-	20.0	16.0	19	4	24.0	T204 2700	T206 2700	•	•
3000	M 30*	x 3.50	180	35	-	22.0	18.0	21	4	26.5	T204 3000	T206 3000	•	•

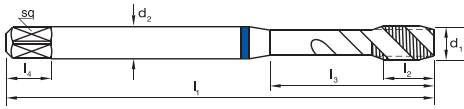
* HSSE V3 >20mm • Available on request as special manufacture. Subject to lead time.



DIN Taps Metric, Spiral Flute, R50 VA PM, IK



- Universal high performance tapping
- PM-HSSE V3 offers superior tool life
- Use in stainless steels and high strength steels up to 850N/mm²
- Deep blind holes
- Depths up to 3 x d₁



Catalogue Code Size Ref.



Catalogue Code	T207
Discount Group	D0408
Material	PM-HSSE V3
Surface Finish	TICN
Colour Ring & Application	VA PM
Geometry	R50° Internal Coolant
Chamfer	Form C / 2.5 x P
Limit & Nut Tolerance	6HX

Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #
0160	M 1.6	x 0.35	40	8	-	2.5	2.1	5	4	1.25	•
0220	M 2	x 0.40	45	8	-	2.8	2.1	5	4	1.6	•
0220	M 2.2	x 0.45	45	9	-	2.8	2.1	5	4	1.75	•
0230	M 2.3	x 0.40	45	9	-	2.8	2.1	5	4	1.9	•
0250	M 2.5	x 0.45	50	9	-	2.8	2.1	5	4	2.05	•
0260	M 2.6	x 0.45	50	9	-	2.8	2.1	5	4	2.15	•
0300	M 3	x 0.50	56	5	18	3.5	2.7	6	4	2.5	•
0350	M 3.5	x 0.60	56	6	20	4.0	3.0	6	4	2.9	•
0400	M 4	x 0.70	63	7	21	4.5	3.4	6	4	3.3	•
0500	M 5	x 0.80	70	8	25	6.0	4.9	8	4	4.2	T207 0500
0600	M 6	x 1.00	80	10	30	6.0	4.9	8	4	5.0	T207 0600
0700	M 7	x 1.00	80	10	30	7.0	5.5	8	4	6.0	•
0800	M 8	x 1.25	90	12.5	35	8.0	6.2	9	4	6.8	T207 0800
1000	M 10	x 1.50	100	15	39	10.0	8.0	11	4	8.5	T207 1000

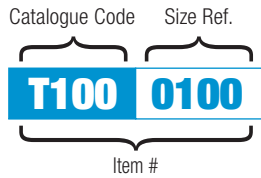
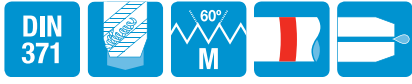
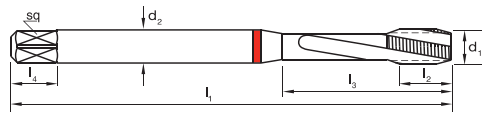
M

• Available on request as special manufacture. Subject to lead time.

DIN Taps Metric, Spiral Flute, R15 H



- Suitable for harder short chipping materials up to 45 HR_c
- Blind holes
- Depths up to 1.5 x d₁



Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
0200	M 2	x 0.40	45	4	-	2.8	2.1	5	3	1.6
0220	M 2.2	x 0.45	45	4.5	-	2.8	2.1	5	3	1.75
0230	M 2.3	x 0.40	45	4	-	2.8	2.1	5	3	1.9
0250	M 2.5	x 0.45	50	4	-	2.8	2.1	5	3	2.05
0260	M 2.6	x 0.45	50	4	-	2.8	2.1	5	3	2.15
0300	M 3	x 0.50	56	6	18	3.5	2.7	6	3	2.5
0350	M 3.5	x 0.60	56	6	20	4.0	3.0	6	3	2.9
0400	M 4	x 0.70	63	7	21	4.5	3.4	6	3	3.3
0500	M 5	x 0.80	70	8	25	6.0	4.9	8	3	4.2
0600	M 6	x 1.00	80	10	30	6.0	4.9	8	3	5.0
0700	M 7	x 1.00	80	10	30	7.0	5.5	8	3	6.0
0800	M 8	x 1.25	90	12.5	35	8.0	6.2	9	3	6.8
1000	M 10	x 1.50	100	15	39	10.0	8.0	11	3	8.5



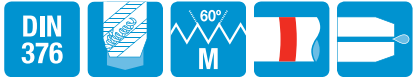
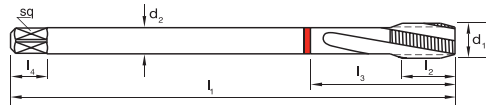
Catalogue Code	T209	T211	T213
Discount Group	D0402	D0408	D0408
Material	PM-HSS Co	PM-HSS Co	PM-HSS Co
Surface Finish	Blu	TICN	TICN
Colour Ring & Application	H	H	H
Geometry	R15°	R15°	R15° Internal Coolant
Chamfer	Form C / 3 x P	Form C / 3 x P	Form C / 3 x P
Limit & Nut Tolerance	ISO 2 / 6HX	ISO 2 / 6HX	ISO 2 / 6HX

Item #	Item #	Item #
•	•	•
•	•	•
•	•	•
•	•	•
•	•	•
T209 0300	T211 0300	•
•	•	•
T209 0400	T211 0400	•
T209 0500	T211 0500	T213 0500
T209 0600	T211 0600	T213 0600
•	•	•
T209 0800	T211 0800	T213 0800
T209 1000	T211 1000	T213 1000

DIN Taps Metric, Spiral Flute, R15 H



- Suitable for harder short chipping materials up to 45 HRc
- Blind holes
- Depths up to 1.5 x d₁



Catalogue Code Size Ref.

T100 **0100**

Item #



Catalogue Code	T210	T212	T214
Discount Group	D0402	D0408	D0408
Material	PM-HSS Co	PM-HSS Co	PM-HSS Co
Surface Finish	Blu	TICN	TICN
Colour Ring & Application	H	H	H
Geometry	R15°	R15°	R15° Internal Coolant
Chamfer	Form C / 3 x P	Form C / 3 x P	Form C / 3 x P
Limit & Nut Tolerance	ISO 2 / 6HX	ISO 2 / 6HX	ISO 2 / 6HX

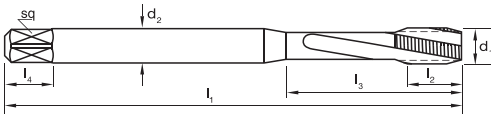
Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #	Item #
0300	M 3 x 0.50	56	6	-	2.2	-	-	3	2.5		•	•	•
0350	M 3.5 x 0.60	56	6	-	2.5	2.1	5	3	2.9		•	•	•
0400	M 4 x 0.70	63	7	-	2.8	2.1	5	3	3.3		•	•	•
0500	M 5 x 0.80	70	8	-	3.5	2.7	6	3	4.2		•	•	•
0600	M 6 x 1.00	80	10	-	4.5	3.4	6	3	5.0		•	•	•
0800	M 8 x 1.25	90	12.5	-	6.0	4.9	8	3	6.8		•	•	•
1000	M 10 x 1.50	100	15	-	7.0	5.5	8	3	8.5		•	•	•
1200	M 12 x 1.75	110	17.5	-	9.0	7.0	10	4	10.2		T210 1200	T212 1200	T214 1200
1400	M 14 x 2.00	110	20	-	11.0	9.0	12	4	12.0		T210 1400	T212 1400	T214 1400
1600	M 16 x 2.00	110	20	-	12.0	9.0	12	4	14.0		T210 1600	T212 1600	T214 1600
1800	M 18 x 2.50	125	25	-	14.0	11.0	14	4	15.5		T210 1800	T212 1800	T214 1800
2000	M 20 x 2.50	140	25	-	16.0	12.0	15	4	17.5		T210 2000	T212 2000	T214 2000
2200	M 22 x 2.50	140	25	-	18.0	14.5	17	4	19.5		•	•	•
2400	M 24 x 3.00	160	30	-	18.0	14.5	17	4	21.0		•	•	•
2700	M 27 x 3.00	160	30	-	20.0	16.0	19	4	24.0		•	•	•
3000	M 30 x 3.50	180	35	-	22.0	18.0	21	4	26.5		•	•	•

• Available on request as special manufacture. Subject to lead time.

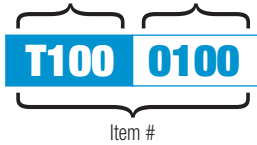
DIN Taps Metric, Spiral Flute, R15 Ti



- For Titanium based alloys
- Blind holes
- Depths up to approx. 1.5 x d₁



Catalogue Code Size Ref.



Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #
0200	M 2	x 0.40	45	4	-	2.8	2.1	5	3	1.6	•
0220	M 2.2	x 0.45	45	4.5	-	2.8	2.1	5	3	1.75	•
0230	M 2.3	x 0.40	45	4	-	2.8	2.1	5	3	1.9	•
0250	M 2.5	x 0.45	50	4	-	2.8	2.1	5	3	2.05	•
0260	M 2.6	x 0.45	50	4	-	2.8	2.1	5	3	2.15	•
0300	M 3	x 0.50	56	6	18	3.5	2.7	6	3	2.5	T215 0300
0350	M 3.5	x 0.60	56	6	20	4.0	3.0	6	3	2.9	•
0400	M 4	x 0.70	63	7	21	4.5	3.4	6	3	3.3	T215 0400
0500	M 5	x 0.80	70	8	25	6.0	4.9	8	3	4.2	T215 0500
0600	M 6	x 1.00	80	10	30	6.0	4.9	8	3	5.0	T215 0600
0700	M 7	x 1.00	80	10	30	7.0	5.5	8	3	6.0	•
0800	M 8	x 1.25	90	12.5	35	8.0	6.2	9	3	6.8	T215 0800
1000	M 10	x 1.50	100	15	39	10.0	8.0	11	3	8.5	T215 1000



Catalogue Code	T215
Discount Group	D0408
Material	PM-HSS Co
Surface Finish	TICN
Colour Ring & Application	Ti
Geometry	
Chamfer	Form C / 3 x P
Limit & Nut Tolerance	ISO 2 / 6H

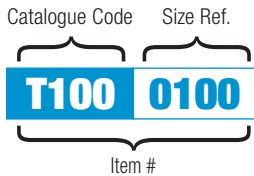
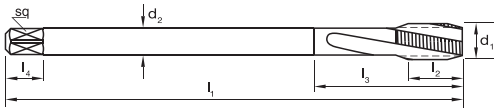


• Available on request as special manufacture. Subject to lead time.

DIN Taps Metric, Spiral Flute, R15 Ti



- For Titanium based alloys
- Blind holes
- Depths up to approx. 1.5 x d₁



Catalogue Code	T216
Discount Group	D0408
Material	PM-HSS Co
Surface Finish	TICN
Colour Ring & Application	Ti
Geometry	
Chamfer	Form C / 3 x P
Limit & Nut Tolerance	ISO 2 / 6H

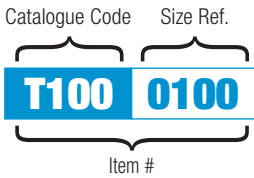
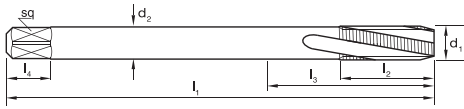
Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #
0300	M 3 x 0.50		56	6	-	2.2	-	-	3	2.5	•
0350	M 3.5 x 0.60		56	6	-	2.5	2.1	5	3	2.9	•
0400	M 4 x 0.70		63	7	-	2.8	2.1	5	3	3.3	•
0500	M 5 x 0.80		70	8	-	3.5	2.7	6	3	4.2	•
0600	M 6 x 1.00		80	10	-	4.5	3.4	6	3	5.0	•
0800	M 8 x 1.25		90	12.5	-	6.0	4.9	8	3	6.8	•
1000	M 10 x 1.50		100	15	-	7.0	5.5	8	3	8.5	•
1200	M 12 x 1.75		110	17.5	-	9.0	7.0	10	3	10.2	T216 1200
1400	M 14 x 2.00		110	20	-	11.0	9.0	12	3	12.0	T216 1400
1600	M 16 x 2.00		110	20	-	12.0	9.0	12	4	14.0	T216 1600
1800	M 18 x 2.50		125	25	-	14.0	11.0	14	4	15.5	T216 1800
2000	M 20 x 2.50		140	25	-	16.0	12.0	15	4	17.5	T216 2000
2200	M 22 x 2.50		140	25	-	18.0	14.5	17	4	19.5	•
2400	M 24 x 3.00		160	30	-	18.0	14.5	17	4	21.0	•
2700	M 27 x 3.00		160	30	-	20.0	16.0	19	4	24.0	•
3000	M 30 x 3.50		180	35	-	22.0	18.0	21	4	26.5	•

• Available on request as special manufacture. Subject to lead time.

DIN Taps Metric, Spiral Flute, R10 Ni



- For Nickel based alloys
- Blind holes
- Depths up to approx. $1.5 \times d_1$



Catalogue Code	T217
Discount Group	D0402
Material	PM-HSS Co
Surface Finish	Brt
Colour Ring & Application	Ni
Geometry	R10°
Chamfer	Form C / 3 x P
Limit & Nut Tolerance	6HX

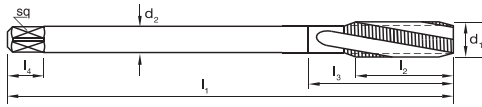
Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #
0200	M 2	x 0.40	45	4	-	2.8	2.1	5	3	1.6	•
0220	M 2.2	x 0.45	45	4.5	-	2.8	2.1	5	3	1.75	•
0230	M 2.3	x 0.40	45	4	-	2.8	2.1	5	3	1.9	•
0250	M 2.5	x 0.45	50	4	-	2.8	2.1	5	3	2.05	•
0260	M 2.6	x 0.45	50	4	-	2.8	2.1	5	3	2.15	•
0300	M 3	x 0.50	56	6	18	3.5	2.7	6	3	2.5	•
0350	M 3.5	x 0.60	56	6	20	4.0	3.0	6	3	2.9	•
0400	M 4	x 0.70	63	7	21	4.5	3.4	6	3	3.3	•
0500	M 5	x 0.80	70	8	25	6.0	4.9	8	3	4.2	•
0600	M 6	x 1.00	80	10	30	6.0	4.9	8	3	5.0	•
0700	M 7	x 1.00	80	10	30	7.0	5.5	8	3	6.0	•
0800	M 8	x 1.25	90	12.5	35	8.0	6.2	9	3	6.8	•
1000	M 10	x 1.50	100	15	39	10.0	8.0	11	3	8.5	•

• Available on request as special manufacture. Subject to lead time.

DIN Taps Metric, Spiral Flute, R10 Ni



- For Nickel based alloys
- Blind holes
- Depths up to approx. $1.5 \times d_1$



Catalogue Code Size Ref.

T100 **0100**

Item #



Catalogue Code	T218
Discount Group	D0402
Material	PM-HSS Co
Surface Finish	Brt
Colour Ring & Application	Ni
Geometry	R10°
Chamfer	Form C / 3 x P
Limit & Nut Tolerance	6HX

Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #
0300	M 3	x 0.50	56	6	-	2.2	-	-	3	2.5	•
0350	M 3.5	x 0.60	56	6	-	2.5	2.1	5	3	2.9	•
0400	M 4	x 0.70	63	7	-	2.8	2.1	5	3	3.3	•
0500	M 5	x 0.80	70	8	-	3.5	2.7	6	3	4.2	•
0600	M 6	x 1.00	80	10	-	4.5	3.4	6	3	5.0	•
0800	M 8	x 1.25	90	12.5	-	6.0	4.9	8	3	6.8	•
1000	M 10	x 1.50	100	15	-	7.0	5.5	8	3	8.5	•
1200	M 12	x 1.75	110	17.5	-	9.0	7.0	10	3	10.2	•
1400	M 14	x 2.00	110	20	-	11.0	9.0	12	3	12.0	•
1600	M 16	x 2.00	110	20	-	12.0	9.0	12	4	14.0	•
1800	M 18	x 2.50	125	25	-	14.0	11.0	14	4	15.5	•
2000	M 20	x 2.50	140	25	-	16.0	12.0	15	4	17.5	•
2200	M 22	x 2.50	140	25	-	18.0	14.5	17	4	19.5	•
2400	M 24	x 3.00	160	30	-	18.0	14.5	17	4	21.0	•
2700	M 27	x 3.00	160	30	-	20.0	16.0	19	4	24.0	•
3000	M 30	x 3.50	180	35	-	22.0	18.0	21	4	26.5	•

• Available on request as special manufacture. Subject to lead time.

the ultimate reference book is here...

BLACK BOOK

The ultimate reference book:

- Matt laminated grease proof pages
- Wire bound to stay flat on workbench when reading
- Ideal for engineers, trades people, apprentices, machine shops, tool rooms, technical colleges

Engineers Black Book

- Tables • Standards • Illustrations
- Grinding wheels • Conversion factors
- Tapers • Lubricants-coolants • G Codes
- Spur gear calculations • Tolerances
- Hardening & tempering • Weights of metal
- Geometrical construction • Formulae
- Engineering drawing standards • Plastics
- Bolts & nuts • Tungsten carbide
- Keys & keyways • Tapping drill sizes
- Speeds & feeds • Equivalent charts
- Sharpening information

Fastener Black Book

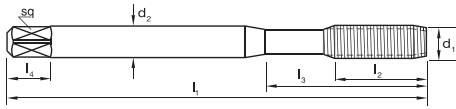
- Screw thread fundamentals • Standards
- Thread classes • Thread terminology
- Grades • Heat treatment • Material selection
- Materials & coatings • Failures & corrosion
- Fastener strengths & markings • Platings
- Tolerances • Hydrogen embrittlement
- Screw thread profiles • Torque control
- Galling • Elevated temperature effects
- Dimensional Specifications DIN / ISO / ANSI



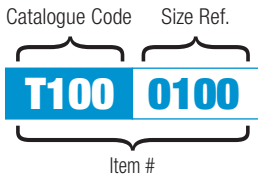
DIN Taps Metric, Forming



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



DIN 2174



Catalogue Code
Discount Group
Material
Surface Finish
Colour Ring & Application
Geometry
Chamfer
Limit & Nut Tolerance

T309	T313	T311	T315
D0402	D0406	D0402	D0406
HSSE V3	HSSE V3	HSSE V3	HSSE V3
BrT	TiN	BrT	TiN
N	N	N	N
No Groove	No Groove	No Groove	No Groove
Form C / 2.5 x P	Form C / 2.5 x P	Form D / 4 x P	Form D / 4 x P
6HX	6HX	6HX	6HX



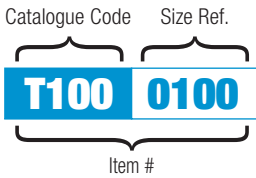
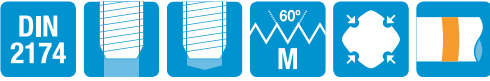
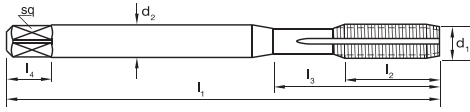
Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #	Item #	Item #
0100	M 1	x 0.25	40	6	-	2.5	2.1	3	0.9		T309 0100	T313 0100	T311 0100	T315 0100
0120	M 1.2	x 0.25	40	6	-	2.5	2.1	3	1.1		T309 0120	T313 0120	T311 0120	T315 0120
0140	M 1.4	x 0.30	40	6	-	2.5	2.1	3	1.28		T309 0140	T313 0140	T311 0140	T315 0140
0160	M 1.6	x 0.35	40	7	-	2.5	2.1	3	1.45		T309 0160	T313 0160	T311 0160	T315 0160
0170	M 1.7	x 0.35	40	8	-	2.5	2.1	3	1.55		T309 0170	T313 0170	T311 0170	T315 0170
0180	M 1.8	x 0.35	40	8	-	2.5	2.1	3	1.65		T309 0180	T313 0180	T311 0180	T315 0180
0200	M 2	x 0.40	45	8	-	2.8	2.1	5	1.8		T309 0200	T313 0200	T311 0200	T315 0200
0220	M 2.2	x 0.45	45	8	-	2.8	2.1	5	2.0		T309 0220	T313 0220	T311 0220	T315 0220
0230	M 2.3	x 0.40	45	9	-	2.8	2.1	5	2.1		T309 0230	T313 0230	T311 0230	T315 0230
0250	M 2.5	x 0.45	50	9	-	2.8	2.1	5	2.3		T309 0250	T313 0250	T311 0250	T315 0250
0260	M 2.6	x 0.45	50	9	-	2.8	2.1	5	2.4		T309 0260	T313 0260	T311 0260	T315 0260
0300	M 3	x 0.50	56	11	18	3.5	2.7	6	2.8		T309 0300	T313 0300	T311 0300	T315 0300
0350	M 3.5	x 0.60	56	13	20	4.0	3.0	6	3.2		T309 0350	T313 0350	T311 0350	T315 0350
0400	M 4	x 0.70	63	13	21	4.5	3.4	6	3.7		T309 0400	T313 0400	T311 0400	T315 0400
0500	M 5	x 0.80	70	16	25	6.0	4.9	8	4.6		T309 0500	T313 0500	T311 0500	T315 0500
0600	M 6	x 1.00	80	19	30	6.0	4.9	8	5.5		T309 0600	T313 0600	T311 0600	T315 0600
0800	M 8	x 1.25	90	22	35	8.0	6.2	9	7.4		T309 0800	T313 0800	T311 0800	T315 0800
1000	M 10	x 1.50	100	24	39	10.0	8.0	11	9.3		T309 1000	T313 1000	T311 1000	T315 1000



DIN Taps Metric, Forming, Multi Coolant Groove



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



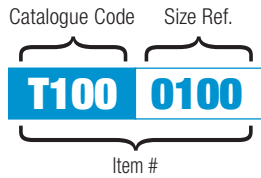
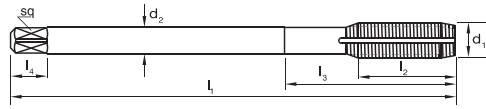
Catalogue Code	T319	T321	T329
Discount Group	D0408	D0408	D0404
Material	HSSE V3	HSSE V3	HSSE V3
Surface Finish	TICN	TICN	CrN
Colour Ring & Application	N	N	Cu
Geometry	Multi Coolant Groove	Multi Coolant Groove	Single-Coolant Groove
Chamfer	Form C / 2.5 x P	Form D / 4 x P	Form C / 2.5 x P
Limit & Nut Tolerance	6HX	6HX	6HX

Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #	Item #
0300	M 3	x 0.50	56	11	18	3.5	2.7	6	2.8		T319 0300	T321 0300	T329 0300
0350	M 3.5	x 0.60	56	13	20	4.0	3.0	6	3.2		T319 0350	T321 0350	T329 0350
0400	M 4	x 0.70	63	13	21	4.5	3.4	6	3.7		T319 0400	T321 0400	T329 0400
0500	M 5	x 0.80	70	16	25	6.0	4.9	8	4.6		T319 0500	T321 0500	T329 0500
0600	M 6	x 1.00	80	19	30	6.0	4.9	8	5.5		T319 0600	T321 0600	T329 0600
0800	M 8	x 1.25	90	22	35	8.0	6.2	9	7.4		T319 0800	T321 0800	T329 0800
1000	M 10	x 1.50	100	24	39	10.0	8.0	11	9.3		T319 1000	T321 1000	T329 1000

DIN Taps Metric, Forming, Multi Coolant Groove



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



Catalogue Code	T320	T322	T330
Discount Group	D0408	D0408	D0404
Material	HSSE V3	HSSE V3	HSSE V3
Surface Finish	TiCN	TiCN	CrN
Colour Ring & Application	N	N	Cu
Geometry	Multi Coolant Groove	Multi Coolant Groove	Single-Coolant Groove
Chamfer	Form C / 2.5 x P	Form D / 4 x P	Form C / 2.5 x P
Limit & Nut Tolerance	6HX	6HX	6HX

Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #	Item #
0600	M 6 [†]	x 1	80	19	-	4.5	3.4	6	5.5		T320 0600	•	•
0800	M 8 [†]	x 1.25	90	22	-	6.0	4.9	8	7.4		T320 0800	•	•
1000	M 10 [†]	x 1.5	100	24	-	7.0	5.5	8	9.3		T320 1000	•	•
1200	M 12	x 1.75	110	29	-	9.0	7.0	10	11.2		T320 1200	T322 1200	T330 1200
1400	M 14	x 2	110	30	-	11.0	9.0	12	13.1		T320 1400	T322 1400	•
1600	M 16	x 2	110	32	-	12.0	9.0	12	15.1		T320 1600	T322 1600	•
1800	M 18	x 2.5	125	34	-	14.0	11.0	14	16.9		•	•	•
2000	M 20	x 2.5	140	34	-	16.0	12.0	15	18.9		•	•	•

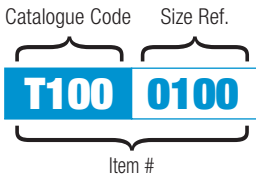
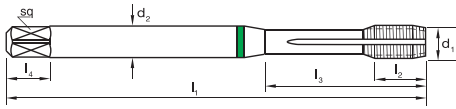
• Available on request as special manufacture. Subject to lead time.
 † Made to -DIN 376 standard.



DIN Taps Metric, Forming, UNI



- SPM for superior performance
- Application specific geometry
- Suitable for materials with >10% elongation
- Through or blind holes
- Depths up to 3 x d₁



Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #
0200	M 2	x 0.4	45	6	-	2.8	2.1	5	1.8		T325 0200	
0220	M 2.2	x 0.45	45	7	-	2.8	2.1	5	2.0		•	
0230	M 2.3	x 0.4	45	7	-	2.8	2.1	5	2.1		•	
0250	M 2.5	x 0.45	50	8	-	2.8	2.1	5	2.3		T325 0250	
0260	M 2.6	x 0.45	50	8	-	2.8	2.1	5	2.4		•	
0300	M 3	x 0.5	56	9	18	3.5	2.7	6	2.8		T325 0300	
0350	M 3.5	x 0.6	56	11	20	4.0	3.0	6	3.2		•	
0400	M 4	x 0.7	63	12	21	4.5	3.4	6	3.7		T325 0400	
0500	M 5	x 0.8	70	13	25	6.0	4.9	8	4.6		T325 0500	T327 0500
0600	M 6	x 1	80	15	30	6.0	4.9	8	5.5		T325 0600	T327 0600
0700	M 7	x 1	80	15	30	7.0	5.5	8	6.5		•	•
0800	M 8	x 1.25	90	18	35	8.0	6.2	9	7.4		T325 0800	T327 0800
1000	M 10	x 1.5	100	20	39	10.0	8.0	11	9.3		T325 1000	T327 1000

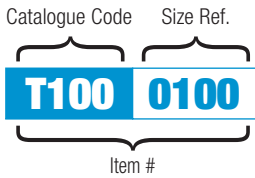
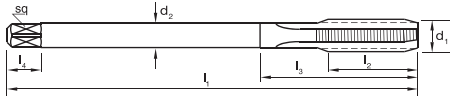


Catalogue Code	T325	T327
Discount Group	D0410	D0410
Material	SPM	SPM
Surface Finish	TIAIN	TIAIN
Colour Ring & Application	UNI	UNI
Geometry	Multi-Coolant Groove	Internal Coolant
Chamfer	Form C / 2.5 x P	Form C / 2.5 x P
Limit & Nut Tolerance	6HX	6HX

DIN Taps Metric Fine, Straight Flute, N



- General purpose use, materials up to approx. 1000 N/mm²
- Through & blind holes
- Suitable for machine operations
- Depths up to approx. 1 x d₁



Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
0302	MF 3 x 0.35	56	8	-	2.2	-	-	3	2.65	
0403	MF 4 x 0.50	63	10	-	2.8	2.1	5	3	3.5	
0503	MF 5 x 0.50	70	12	-	3.5	2.7	6	3	4.5	
0603	MF 6 x 0.50	80	14	-	4.5	3.4	6	3	5.5	
0604	MF 6 x 0.75	80	14	-	4.5	3.4	6	3	5.3	
0803	MF 8 x 0.50	80	18	-	6.0	4.9	8	3	7.5	
0804	MF 8 x 0.75	80	18	-	6.0	4.9	8	3	7.3	
0805	MF 8 x 1.00	90	22	-	6.0	4.9	8	3	7.0	
1004	MF 10 x 0.75	90	20	-	7.0	5.5	8	3	9.3	
1005	MF 10 x 1.00	90	20	-	7.0	5.5	8	3	9.0	
1006	MF 10 x 1.25	100	24	-	7.0	5.5	8	3	8.8	
1205	MF 12 x 1.00	100	22	-	9.0	7.0	10	3	11.0	
1206	MF 12 x 1.25	100	22	-	9.0	7.0	10	3	10.8	
1207	MF 12 x 1.50	100	22	-	9.0	7.0	10	3	10.5	
1405	MF 14 x 1.00	100	22	-	11.0	9.0	12	3	13.0	
1406	MF 14 x 1.25	100	22	-	11.0	9.0	12	3	12.8	
1407	MF 14 x 1.50	100	22	-	11.0	9.0	12	3	12.5	
1605	MF 16 x 1.00	100	22	-	12.0	9.0	12	3	15.0	
1607	MF 16 x 1.50	100	22	-	12.0	9.0	12	3	14.5	
1805	MF 18 x 1.00	110	25	-	14.0	11.0	14	4	17.0	
1807	MF 18 x 1.50	110	25	-	14.0	11.0	14	4	16.5	
1808	MF 18 x 2.00	125	34	-	14.0	11.0	14	4	16.0	
2005	MF 20 x 1.00	125	25	-	16.0	12.0	15	4	19.0	
2007	MF 20 x 1.50	125	25	-	16.0	12.0	15	4	18.5	
2008	MF 20 x 2.00	140	34	-	16.0	12.0	15	4	18.0	



Catalogue Code	T298	T299
Discount Group	D0402	D0406
Material	HSSE V3	HSSE V3
Surface Finish	BrT	TIN
Colour Ring & Application	N	N
Geometry		
Chamfer	Form C / 2.5 x P	Form C / 2.5 x P
Limit & Nut Tolerance	ISO 2 / 6H	ISO 2 / 6H

Item #	Item #
T298 0302	•
T298 0403	•
T298 0503	•
T298 0603	T299 0603
T298 0604	•
T298 0803	•
T298 0804	•
T298 0805	T299 0805
T298 1004	•
T298 1005	T299 1005
T298 1006	T299 1006
T298 1205	T299 1205
T298 1206	T299 1206
T298 1207	T299 1207
T298 1405	T299 1405
T298 1406	T299 1406
T298 1407	T299 1407
T298 1605	T299 1605
T298 1607	T299 1607
T298 1805	•
T298 1807	T299 1807
T298 1808	•
T298 2005	T299 2005
T298 2007	•
T298 2008	•

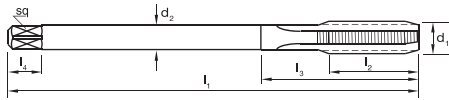
MF

• Available on request as special manufacture. Subject to lead time.

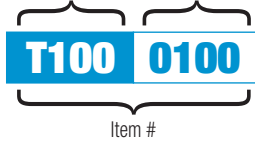
DIN Taps Metric Fine, Straight Flute, GG



- Use in grey cast iron (GG), brittle plastics, hard bronzes to a hardness of 850 N/mm²
- Through & blind holes
- Suitable for machine operations
- Depths up to approx. 3 x d₁



Catalogue Code Size Ref.



Catalogue Code	T300	T301
Discount Group	D0402	D0408
Material	HSSE V3	HSSE V3
Surface Finish	Ni + Blu	TICN
Colour Ring & Application	GG	GG
Geometry	Low Relief	Low Relief
Chamfer	Form C / 2.5 x P	Form C / 2.5 x P
Limit & Nut Tolerance	ISO 2 / 6HX	ISO 2 / 6HX

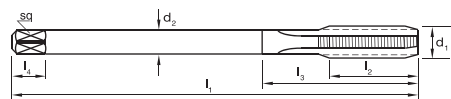
Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #
0302	MF 3 x 0.35	56	8	-	2.2	-	-	4	2.65		•	•
0403	MF 4 x 0.50	63	10	-	2.8	2.1	5	4	3.5		T300 0403	T301 0403
0503	MF 5 x 0.50	70	12	-	3.5	2.7	6	4	4.5		T300 0503	T301 0503
0604	MF 6 x 0.75	80	14	-	4.5	3.4	6	4	5.3		T300 0604	T301 0604
0803	MF 8 x 0.50	80	18	-	6.0	4.9	8	4	7.5		•	•
0804	MF 8 x 0.75	80	18	-	6.0	4.9	8	4	7.3		•	•
0805	MF 8 x 1.00	90	22	-	6.0	4.9	8	4	7.0		T300 0805	T301 0805
1004	MF 10 x 0.75	90	20	-	7.0	5.5	8	4	9.3		•	•
1005	MF 10 x 1.00	90	20	-	7.0	5.5	8	4	9.0		T300 1005	T301 1005
1006	MF 10 x 1.25	100	24	-	7.0	5.5	8	4	8.8		T300 1006	T301 1006
1205	MF 12 x 1.00	100	22	-	9.0	7.0	10	4	11.0		•	•
1206	MF 12 x 1.25	100	22	-	9.0	7.0	10	4	10.8		T300 1206	T301 1206
1207	MF 12 x 1.50	100	22	-	9.0	7.0	10	4	10.5		T300 1207	T301 1207
1405	MF 14 x 1.00	100	22	-	11.0	9.0	12	4	13.0		•	•
1406	MF 14 x 1.25	100	22	-	11.0	9.0	12	4	12.8		T300 1406	T301 1406
1407	MF 14 x 1.50	100	22	-	11.0	9.0	12	4	12.5		T300 1407	T301 1407
1605	MF 16 x 1.00	100	22	-	12.0	9.0	12	4	15.0		•	•
1607	MF 16 x 1.50	100	22	-	12.0	9.0	12	4	14.5		T300 1607	T301 1607
1805	MF 18 x 1.00	110	25	-	14.0	11.0	14	4	17.0		•	•
1807	MF 18 x 1.50	110	25	-	14.0	11.0	14	4	16.5		T300 1807	T301 1807
1808	MF 18 x 2.00	125	34	-	14.0	11.0	14	4	16.0		•	•
2005	MF 20 x 1.00	125	25	-	16.0	12.0	15	4	19.0		•	•
2007	MF 20 x 1.50	125	25	-	16.0	12.0	15	4	18.5		T300 2007	T301 2007
2008	MF 20 x 2.00	140	34	-	16.0	12.0	15	4	18.0		•	•

• Available on request as special manufacture. Subject to lead time.

DIN Taps Metric Fine, Straight Flute, DC



- Premium design for cast aluminium and cast iron (Short Chipping)
- Through & blind holes
- Depths up to approx. 1.5 x d_1
- Axial coolant duct available



Catalogue Code Size Ref.

T100 **0100**
Item #

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø
1006	MF 10 x 1.25	100	24	-	7.0	5.5	8	4	8.8	
1207	MF 12 x 1.50	100	22	-	9.0	7.0	10	4	10.5	
1407	MF 14 x 1.50	100	22	-	11.0	9.0	12	4	12.5	
1607	MF 16 x 1.50	100	22	-	12.0	9.0	12	4	14.5	



Catalogue Code	T668	T669
Discount Group	D0408	D0408
Material	PM-HSS Co	PM-HSS Co
Surface Finish	TICN	TICN
Colour Ring & Application	Die Cast	Die Cast
Geometry		Internal Coolant
Chamfer	Form E / 1.5 x P	Form E / 1.5 x P
Limit & Nut Tolerance	6HX	6HX

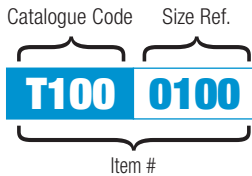
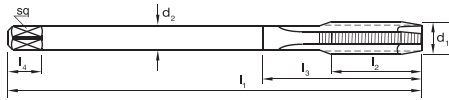
Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
											T668 1006	T669 1006
											T668 1207	T669 1207
											T668 1407	T669 1407
											T668 1607	T669 1607

MF

DIN Taps Metric Fine, Gun, N



- General purpose use, materials up to approx. 1000 N/mm²
- Through holes
- Suitable for machine operations
- Depths up to approx. 3 x d₁



Catalogue Code
Discount Group
Material
Surface Finish
Colour Ring & Application
Geometry
Chamfer
Limit & Nut Tolerance

T154	T155	T156	T157
D0402	D0402	D0402	D0406
HSSE V3	HSSE V3	HSSE V3	HSSE V3
Brt	Brt	Blu	TiN
N	N	N	N
	6G		
Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P
ISO 2 / 6H	ISO 3 / 6G	ISO 2 / 6H	ISO 2 / 6H

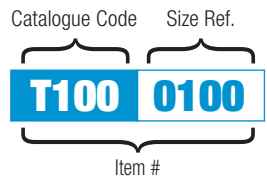
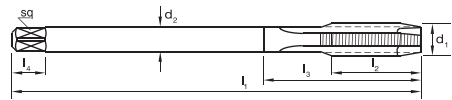
Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #	Item #	Item #
0302	MF 3 x 0.35	56	8	-	2.2	-	-	3	2.65		T154 0302	•	•	•
0403	MF 4 x 0.50	63	10	-	2.8	2.1	5	3	3.5		T154 0403	•	T156 0403	•
0503	MF 5 x 0.50	70	12	-	3.5	2.7	6	3	4.5		T154 0503	•	T156 0503	•
0604	MF 6 x 0.75	80	14	-	4.5	3.4	6	3	5.3		T154 0604	T155 0604	T156 0604	T157 0604
0803	MF 8 x 0.50	80	18	-	6.0	4.9	8	3	7.5		T154 0803	•	•	T157 0803
0804	MF 8 x 0.75	80	18	-	6.0	4.9	8	3	7.3		T154 0804	•	T156 0804	T157 0804
0805	MF 8 x 1.00	90	22	-	6.0	4.9	8	3	7.0		T154 0805	T155 0805	T156 0805	T157 0805
1004	MF 10 x 0.75	90	20	-	7.0	5.5	8	3	9.3		T154 1004	•	T156 1004	•
1005	MF 10 x 1.00	90	20	-	7.0	5.5	8	3	9.0		T154 1005	T155 1005	T156 1005	T157 1005
1006	MF 10 x 1.25	100	24	-	7.0	5.5	8	3	8.8		T154 1006	T155 1006	T156 1006	T157 1006
1205	MF 12 x 1.00	100	22	-	9.0	7.0	10	3	11.0		T154 1205	•	T156 1205	T157 1205
1206	MF 12 x 1.25	100	22	-	9.0	7.0	10	3	10.8		T154 1206	•	T156 1206	T157 1206
1207	MF 12 x 1.50	100	22	-	9.0	7.0	10	3	10.5		T154 1207	T155 1207	T156 1207	T157 1207
1405	MF 14 x 1.00	100	22	-	11.0	9.0	12	3	13.0		T154 1405	•	•	•
1406	MF 14 x 1.25	100	22	-	11.0	9.0	12	3	12.8		T154 1406	•	T156 1406	T157 1406
1407	MF 14 x 1.50	100	22	-	11.0	9.0	12	3	12.5		T154 1407	T155 1407	T156 1407	T157 1407
1605	MF 16 x 1.00	100	22	-	12.0	9.0	12	3	14.5		T154 1605	•	•	•
1607	MF 16 x 1.50	100	22	-	12.0	9.0	12	3	16.5		T154 1607	•	T156 1607	T157 1607
1805	MF 18 x 1.00	110	25	-	14.0	11.0	14	4	17.0		T154 1805	•	•	•
1807	MF 18 x 1.50	110	25	-	14.0	11.0	14	4	16.5		T154 1807	•	T156 1807	T157 1807
1808	MF 18 x 2.00	125	34	-	14.0	11.0	14	4	16.0		T154 1808	•	•	•
2005	MF 20 x 1.00	125	25	-	16.0	12.0	15	4	19.0		T154 2005	•	•	•
2007	MF 20 x 1.50	125	25	-	16.0	12.0	15	4	18.5		T154 2007	•	T156 2007	T157 2007
2008	MF 20 x 2.00	140	34	-	16.0	12.0	15	4	18.0		T154 2008	•	•	•
2205	MF 22 x 1.00	125	25	-	18.0	14.5	17	4	18.5		T154 2205	•	•	•
2207	MF 22 x 1.50	125	25	-	18.0	14.5	17	4	20.5		T154 2207	•	•	•
2208	MF 22 x 2.00	140	28	-	18.0	14.5	17	4	20.0		T154 2208	•	•	•
2405	MF 24 x 1.00	140	28	-	18.0	14.5	17	4	23.0		T154 2405	•	•	•
2407	MF 24 x 1.50	140	28	-	18.0	14.5	17	4	22.5		T154 2407	•	•	•
2408	MF 24 x 2.00	140	28	-	18.0	14.5	17	4	22.0		T154 2408	•	•	•
2505	MF 25 x 1.00	140	28	-	18.0	14.5	17	4	24.0		•	•	•	•
2507	MF 25 x 1.50	140	28	-	18.0	14.5	17	4	23.5		T154 2507	•	•	•
2508	MF 25 x 2.00	140	28	-	18.0	14.5	17	4	23.0		•	•	•	•
2605	MF 26 x 1.00	140	28	-	18.0	14.5	17	4	25.0		•	•	•	•
2607	MF 26 x 1.50	140	28	-	18.0	14.5	17	4	24.5		T154 2607	•	•	•
2608	MF 26 x 2.00	140	28	-	18.0	14.5	17	4	24.0		•	•	•	•
2707	MF 27 x 1.50	140	28	-	20.0	16.0	19	4	25.5		T154 2707	•	•	•
2708	MF 27 x 2.00	140	28	-	20.0	16.0	19	4	25.0		T154 2708	•	•	•
2807	MF 28 x 1.50	140	28	-	20.0	16.0	19	4	26.5		T154 2807	•	•	•
2808	MF 28 x 2.00	140	28	-	20.0	16.0	19	4	26.0		•	•	•	•
3005	MF 30 x 1.00	150	28	-	22.0	18.0	21	4	29.0		T154 3005	•	•	•
3007	MF 30 x 1.50	150	28	-	22.0	18.0	21	4	28.5		T154 3007	•	•	•
3008	MF 30 x 2.00	150	28	-	22.0	18.0	21	4	28.0		T154 3008	•	•	•
3207	MF 32 x 1.50	150	28	-	22	18	21	4	30.5		T154 3207	•	•	•

• Available on request as special manufacture. Subject to lead time.

DIN Taps Metric Fine, Gun, N



- General purpose use, materials up to approx. 1000 N/mm²
- Through holes
- Suitable for machine operations
- Depths up to approx. 3 x d₁



Catalogue Code
Discount Group
Material
Surface Finish
Colour Ring & Application
Geometry
Chamfer
Limit & Nut Tolerance



	T154	T155	T156	T157
Catalogue Code	D0402	D0402	D0402	D0406
Discount Group	D0402	D0402	D0402	D0406
Material	HSSE V3	HSSE V3	HSSE V3	HSSE V3
Surface Finish	Brt	Brt	Blu	TiN
Colour Ring & Application	N	N	N	N
Geometry	6G			
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P
Limit & Nut Tolerance	ISO 2 / 6H	ISO 3 / 6G	ISO 2 / 6H	ISO 2 / 6H
Item #	Item #	Item #	Item #	Item #

Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
3307	MF 33 x 1.50	160	30	-	25	20	23	4	31.5	T154 3307
3308	MF 33 x 2.00	160	30	-	25	20	23	4	31	T154 3308
3407	MF 34 x 1.50	170	30	-	28	22	25	4	32.5	T154 3407
3507	MF 35 x 1.50	170	30	-	28	22	25	4	33.5	T154 3507
3607	MF 36 x 1.50	170	30	-	28	22	25	4	34.5	T154 3607
3608	MF 36 x 2.00	170	30	-	28	22	25	4	34	T154 3608
3609	MF 36 x 3.00	200	56	-	28	22	25	4	33	T154 3609
3807	MF 38 x 1.50	170	30	-	28	22	25	4	36.5	T154 3807
4007	MF 40 x 1.50	170	30	-	32	24	27	4	38.5	T154 4007
4207	MF 42 x 1.50	170	30	-	32	24	27	4	40.5	T154 4207
4208	MF 42 x 2.00	170	30	-	32	24	27	4	40	T154 4208
4209	MF 42 x 3.00	200	30	-	32	24	27	4	39	T154 4209
4507	MF 45 x 1.50	180	32	-	36	29	32	4	43.5	T154 4507
4508	MF 45 x 2.00	180	32	-	36	29	32	4	43	T154 4508
4807	MF 48 x 1.50	190	32	-	36	29	32	4	46.5	T154 4807
5007	MF 50 x 1.50	190	32	-	36	29	32	4	48.5	T154 5007
5207	MF 52 x 1.50	190	32	-	40	32	35	4	50.5	T154 5207

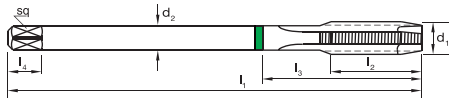
MF

• Available on request as special manufacture. Subject to lead time.

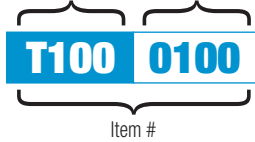
DIN Taps Metric Fine, Gun, UNI



- Universal use. Suitable for a wide range of materials
- Through holes
- Suitable for machine operations
- Depths up to approx. $3 \times d_1$



Catalogue Code Size Ref.



Catalogue Code	T162	T163
Discount Group	D0402	D0410
Material	PM-HSSE V3	PM-HSSE V3
Surface Finish	BrT	TAIN
Colour Ring & Application	UNI	UNI
Geometry		
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P
Limit & Nut Tolerance	ISO2 / 6H	ISO2 / 6H

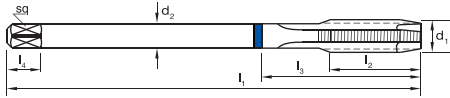
Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #
0302	MF 3 x 0.35		56	8	-	2.2	-	-	3	2.65	T162 0302	T163 0302
0403	MF 4 x 0.50		63	10	-	2.8	2.1	5	3	3.5	T162 0403	T163 0403
0503	MF 5 x 0.50		70	12	-	3.5	2.7	6	3	4.5	T162 0503	T163 0503
0604	MF 6 x 0.75		80	14	-	4.5	3.4	6	3	5.3	T162 0604	T163 0604
0803	MF 8 x 0.50		80	18	-	6.0	4.9	8	3	7.5	T162 0803	T163 0803
0804	MF 8 x 0.75		80	18	-	6.0	4.9	8	3	7.3	T162 0804	T163 0804
0805	MF 8 x 1.00		90	22	-	6.0	4.9	8	3	7.0	T162 0805	T163 0805
1004	MF 10 x 0.75		90	20	-	7.0	5.5	8	3	9.3	T162 1004	T163 1004
1005	MF 10 x 1.00		90	20	-	7.0	5.5	8	3	9.0	T162 1005	T163 1005
1006	MF 10 x 1.25		100	24	-	7.0	5.5	8	3	8.8	T162 1006	T163 1006
1205	MF 12 x 1.00		100	22	-	9.0	7.0	10	3	11.0	T162 1205	T163 1205
1206	MF 12 x 1.25		100	22	-	9.0	7.0	10	3	10.8	T162 1206	T163 1206
1207	MF 12 x 1.50		100	22	-	9.0	7.0	10	3	10.5	T162 1207	T163 1207
1405	MF 14 x 1.00		100	22	-	11.0	9.0	12	3	13.0	T162 1405	T163 1405
1406	MF 14 x 1.25		100	22	-	11.0	9.0	12	3	12.8	T162 1406	T163 1406
1407	MF 14 x 1.50		100	22	-	11.0	9.0	12	3	12.5	T162 1407	T163 1407
1605	MF 16 x 1.00		100	22	-	12.0	9.0	12	3	15.0	T162 1605	T163 1605
1607	MF 16 x 1.50		100	22	-	12.0	9.0	12	3	14.5	T162 1607	T163 1607
1805	MF 18 x 1.00		110	25	-	14.0	11.0	14	4	17.0	T162 1805	T163 1805
1807	MF 18 x 1.50		110	25	-	14.0	11.0	14	4	16.5	T162 1807	T163 1807
1808	MF 18 x 2.00		125	34	-	14.0	11.0	14	4	16.0	T162 1808	T163 1808
2005	MF 20 x 1.00		125	25	-	16.0	12.0	15	4	19.0	T162 2005	T163 2005
2007	MF 20 x 1.50		125	25	-	16.0	12.0	15	4	18.5	T162 2007	T163 2007
2008	MF 20 x 2.00		140	34	-	16.0	12.0	15	4	18.0	T162 2008	T163 2008

MF

DIN Taps Metric Fine, Gun, VA



- Use in stainless steels and high strength steels up to 1000N/mm²
- PM-HSSE V3 offers higher edge hardness than standard VA series
- Through holes
- Suitable for machine operations
- Depths up to approx. 3 x d₁



Catalogue Code Size Ref.



Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
0302	MF 3	x 0.35	56	8	-	2.2	-	-	3	2.65
0403	MF 4	x 0.50	63	10	-	2.8	2.1	5	3	3.5
0503	MF 5	x 0.50	70	12	-	3.5	2.7	6	3	4.5
0604	MF 6	x 0.75	80	14	-	4.5	3.4	6	3	5.3
0803	MF 8	x 0.50	80	18	-	6.0	4.9	8	3	7.5
0804	MF 8	x 0.75	80	18	-	6.0	4.9	8	3	7.3
0805	MF 8	x 1.00	90	22	-	6.0	4.9	8	3	7.0
1004	MF 10	x 0.75	90	20	-	7.0	5.5	8	3	9.3
1005	MF 10	x 1.00	90	20	-	7.0	5.5	8	3	9.0
1006	MF 10	x 1.25	100	24	-	7.0	5.5	8	3	8.8
1205	MF 12	x 1.00	100	22	-	9.0	7.0	10	3	11.0
1206	MF 12	x 1.25	100	22	-	9.0	7.0	10	3	10.8
1207	MF 12	x 1.50	100	22	-	9.0	7.0	10	3	10.5
1405	MF 14	x 1.00	100	22	-	11.0	9.0	12	3	13.0
1406	MF 14	x 1.25	100	22	-	11.0	9.0	12	3	12.8
1407	MF 14	x 1.50	100	22	-	11.0	9.0	12	3	12.5
1605	MF 16	x 1.00	100	22	-	12.0	9.0	12	3	15.0
1607	MF 16	x 1.50	100	22	-	12.0	9.0	12	3	14.5
1805	MF 18	x 1.00	110	25	-	14.0	11.0	14	4	17.0
1807	MF 18	x 1.50	110	25	-	14.0	11.0	14	4	16.5
1808	MF 18	x 2.00	125	34	-	14.0	11.0	14	4	16.0
2005	MF 20	x 1.00	125	25	-	16.0	12.0	15	4	19.0
2007	MF 20	x 1.50	125	25	-	16.0	12.0	15	4	18.5
2008	MF 20	x 2.00	140	34	-	16.0	12.0	15	4	18.0



Catalogue Code	T158	T161
Discount Group	D0402	D0408
Material	HSSE V3	HSSE V3
Surface Finish	Blu	TICN
Colour Ring & Application	VA	VA
Geometry	Special Relief	Special Relief
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P
Limit & Nut Tolerance	ISO 2 / 6H	ISO 2 / 6H

Item #	Item #
•	•
•	•
•	•
T158 0604	T161 0604
T158 0803	T161 0803
T158 0804	T161 0804
T158 0805	T161 0805
•	•
T158 1005	T161 1005
T158 1006	T161 1006
T158 1205	T161 1205
T158 1206	T161 1206
T158 1207	T161 1207
T158 1405	•
T158 1406	T161 1406
T158 1407	T161 1407
T158 1605	•
•	•
T158 1805	•
T158 1807	•
•	•
•	•
T158 2005	•
T158 2007	•
•	•

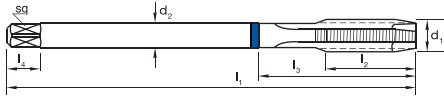
MF

• Available on request as special manufacture. Subject to lead time.

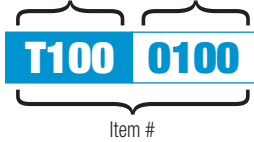
DIN Taps Metric Fine, Gun, VA PM



- Use in stainless steels and high strength steels up to 1000N/mm²
- PM-HSSE V3 offers higher edge hardness than standard VA series
- Through holes
- Suitable for synchronous tapping in machine operations
- Depths up to approx. 3 x d₁



Catalogue Code Size Ref.



Catalogue Code	T159	T160
Discount Group	D0402	D0408
Material	PM-HSSE V3	PM-HSSE V3
Surface Finish	Blu	TCN
Colour Ring & Application	VA	VA
Geometry	Special Relief	Special Relief
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P
Limit & Nut Tolerance	6HX	6HX

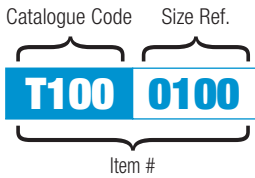
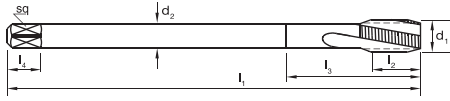
Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #
0302	MF 3 x 0.35	56	8	-	2.2	-	-	3	2.65		•	•
0403	MF 4 x 0.50	63	10	-	2.8	2.1	5	3	3.5		•	•
0503	MF 5 x 0.50	70	12	-	3.5	2.7	6	3	4.5		•	•
0604	MF 6 x 0.75	80	14	-	4.5	3.4	6	3	5.3		•	T160 0604
0803	MF 8 x 0.50	80	18	-	6.0	4.9	8	3	7.5		•	T160 0803
0804	MF 8 x 0.75	80	18	-	6.0	4.9	8	3	7.3		•	•
0805	MF 8 x 1.00	90	22	-	6.0	4.9	8	3	7.0		•	•
1004	MF 10 x 0.75	90	20	-	7.0	5.5	8	3	9.3		•	T160 1004
1005	MF 10 x 1.00	90	20	-	7.0	5.5	8	3	9.0		•	T160 1005
1006	MF 10 x 1.25	100	24	-	7.0	5.5	8	3	8.8		•	•
1205	MF 12 x 1.00	100	22	-	9.0	7.0	10	3	11.0		•	T160 1205
1206	MF 12 x 1.25	100	22	-	9.0	7.0	10	3	10.8		•	T160 1206
1207	MF 12 x 1.50	100	22	-	9.0	7.0	10	3	10.5		•	T160 1207
1405	MF 14 x 1.00	100	22	-	11.0	9.0	12	3	13.0		•	T160 1405
1406	MF 14 x 1.25	100	22	-	11.0	9.0	12	3	12.8		•	T160 1406
1407	MF 14 x 1.50	100	22	-	11.0	9.0	12	3	12.5		•	•
1605	MF 16 x 1.00	100	22	-	12.0	9.0	12	3	15.0		•	T160 1605
1607	MF 16 x 1.50	100	22	-	12.0	9.0	12	3	14.5		•	•
1805	MF 18 x 1.00	110	25	-	14.0	11.0	14	4	17.0		•	•
1807	MF 18 x 1.50	110	25	-	14.0	11.0	14	4	16.5		•	T160 1807
1808	MF 18 x 2.00	125	34	-	14.0	11.0	14	4	16.0		•	•
2005	MF 20 x 1.00	125	25	-	16.0	12.0	15	4	19.0		•	T160 2005
2007	MF 20 x 1.50	125	25	-	16.0	12.0	15	4	18.5		•	•
2008	MF 20 x 2.00	140	34	-	16.0	12.0	15	4	18.0		•	•

• Available on request as special manufacture. Subject to lead time.

DIN Taps Metric Fine, Spiral Flute, R15 N



- General purpose use, materials up to approx. 1000 N/mm²
- Blind holes
- Suitable for machine operations
- Depths up to approx. 1.5 x d₁



Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
0302	MF 3 x 0.35	56	8	-	2.2	-	-	3	2.65	
0403	MF 4 x 0.50	63	10	-	2.8	2.1	5	3	3.5	
0503	MF 5 x 0.50	70	12	-	3.5	2.7	6	3	4.5	
0604	MF 6 x 0.75	80	14	-	4.5	3.4	6	3	5.3	
0803	MF 8 x 0.50	80	18	-	6.0	4.9	8	3	7.5	
0804	MF 8 x 0.75	80	18	-	7.0	4.9	8	3	7.3	
0805	MF 8 x 1.00	90	22	-	6.0	4.9	8	3	7.0	
1004	MF 10 x 0.75	90	20	-	7.0	5.5	8	3	9.3	
1005	MF 10 x 1.00	90	20	-	7.0	5.5	8	3	9.0	
1006	MF 10 x 1.25	100	24	-	7.0	5.5	8	3	8.8	
1205	MF 12 x 1.00	100	22	-	9.0	7.0	10	3	11.0	
1206	MF 12 x 1.25	100	22	-	9.0	7.0	10	3	10.8	
1207	MF 12 x 1.50	100	22	-	9.0	7.0	10	3	10.5	
1405	MF 14 x 1.00	100	22	-	11.0	9.0	12	3	13.0	
1406	MF 14 x 1.25	100	22	-	11.0	9.0	12	3	12.8	
1407	MF 14 x 1.50	100	22	-	11.0	9.0	12	3	12.5	
1605	MF 16 x 1.00	100	22	-	12.0	9.0	12	3	15.0	
1607	MF 16 x 1.50	100	22	-	12.0	9.0	12	3	14.5	
1805	MF 18 x 1.00	110	25	-	14.0	11.0	14	4	17.0	
1807	MF 18 x 1.50	110	25	-	14.0	11.0	14	4	16.5	
1808	MF 18 x 2.00	125	34	-	14.0	11.0	14	4	16.0	
2005	MF 20 x 1.00	125	25	-	16.0	12.0	15	4	19.0	
2007	MF 20 x 1.50	125	25	-	16.0	12.0	15	4	18.5	
2008	MF 20 x 2.00	140	34	-	16.0	12.0	15	4	18.0	



Catalogue Code	T243	T244
Discount Group	D0402	D0406
Material	HSSE V3	HSSE V3
Surface Finish	BrT	TiN
Colour Ring & Application	N	N
Geometry	R15°	R15°
Chamfer	Form C / 2.5 x P	Form C / 2.5 x P
Limit & Nut Tolerance	ISO 2 / 6H	ISO 2 / 6H

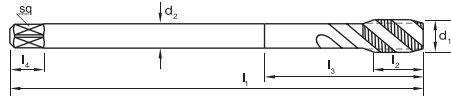
Item #	Item #
T243 0302	•
T243 0403	T244 0403
T243 0503	T244 0503
T243 0604	T244 0604
T243 0803	T244 0803
T243 0804	T244 0804
T243 0805	T244 0805
T243 1004	T244 1004
T243 1005	T244 1005
T243 1006	T244 1006
T243 1205	T244 1205
T243 1206	T244 1206
T243 1207	T244 1207
T243 1405	T244 1405
T243 1406	T244 1406
T243 1407	T244 1407
T243 1605	T244 1605
T243 1607	T244 1607
T243 1805	T244 1805
T243 1807	T244 1807
T243 1808	T244 1808
T243 2005	T244 2005
T243 2007	T244 2007
T243 2008	•

MF

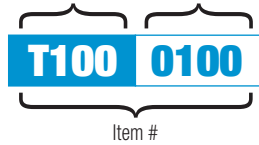
DIN Taps Metric Fine, Spiral Flute, R40 N



- General purpose use, materials up to approx. 1000 N/mm²
- Blind holes
- Suitable for machine operations
- Depths up to approx. 2.5 x d₁



Catalogue Code Size Ref.



- Catalogue Code**
Discount Group
Material
Surface Finish
Colour Ring & Application
Geometry
Chamfer
Limit & Nut Tolerance

T245	T246	T247	T248
D0402	D0402	D0402	D0406
HSSE V3	HSSE V3	HSSE V3	HSSE V3
Brt	Brt	Blu	TIN
N	N	N	N
R40°	R40°	R40°	R40°
Form C / 2.5 x P	Form C / 2.5 x P	Form C / 2.5 x P	Form C / 2.5 x P
ISO 2 / 6H	ISO 3 / 6G	ISO 2 / 6H	ISO 2 / 6H

Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
0302	MF 3 x 0.35	56	4	-	2.2	-	-	3	2.65	
0403	MF 4 x 0.50	63	6	-	2.8	2.1	5	3	3.5	
0503	MF 5 x 0.50	70	7	-	3.5	2.7	6	3	4.5	
0604	MF 6 x 0.75	80	8	-	4.5	3.4	6	3	5.3	
0803	MF 8 x 0.50	80	10	-	6.0	4.9	8	3	7.5	
0804	MF 8 x 0.75	80	10	-	6.0	4.9	8	3	7.3	
0805	MF 8 x 1.00	90	8	-	6.0	4.9	8	3	7.0	
1004	MF 10 x 0.75	90	10	-	7.0	5.5	8	3	9.3	
1005	MF 10 x 1.00	90	10	-	7.0	5.5	8	3	9.0	
1006	MF 10 x 1.25	100	13	-	7.0	5.5	8	3	8.8	
1205	MF 12 x 1.00	100	14	-	9.0	7.0	10	3	11.0	
1206	MF 12 x 1.25	100	14	-	9.0	7.0	10	3	10.8	
1207	MF 12 x 1.50	100	14	-	9.0	7.0	10	3	10.5	
1405	MF 14 x 1.00	100	16	-	11.0	9.0	12	3	13.0	
1406	MF 14 x 1.25	100	16	-	11.0	9.0	12	3	12.8	
1407	MF 14 x 1.50	100	16	-	11.0	9.0	12	3	12.5	
1605	MF 16 x 1.00	100	16	-	12.0	9.0	12	3	14.5	
1607	MF 16 x 1.50	100	16	-	12.0	9.0	12	3	16.5	
1805	MF 18 x 1.00	110	20	-	14.0	11.0	14	4	17.0	
1807	MF 18 x 1.50	110	20	-	14.0	11.0	14	4	16.5	
1808	MF 18 x 2.00	125	20	-	14.0	11.0	14	4	16.0	
2005	MF 20 x 1.00	125	20	-	16.0	12.0	15	4	19.0	
2007	MF 20 x 1.50	125	20	-	16.0	12.0	15	4	18.5	
2008	MF 20 x 2.00	140	20	-	16.0	12.0	15	4	18.0	
2205	MF 22 x 1.00	125	15	-	18.0	14.5	17	4	18.5	
2207	MF 22 x 1.50	125	15	-	18.0	14.5	17	4	20.5	
2208	MF 22 x 2.00	140	20	-	18.0	14.5	17	4	20.0	
2405	MF 24 x 1.00	140	20	-	18.0	14.5	17	4	23.0	
2407	MF 24 x 1.50	140	20	-	18.0	14.5	17	4	22.5	
2408	MF 24 x 2.00	140	20	-	18.0	14.5	17	4	22.0	
2505	MF 25 x 1.00	140	15	-	18.0	14.5	17	4	24.0	
2507	MF 25 x 1.50	140	15	-	18.0	14.5	17	4	23.5	
2508	MF 25 x 2.00	140	15	-	18.0	14.5	17	4	23.0	
2605	MF 26 x 1.00	140	15	-	18.0	14.5	17	4	25.0	
2607	MF 26 x 1.50	140	15	-	18.0	14.5	17	4	24.5	
2608	MF 26 x 2.00	140	15	-	18.0	14.5	17	4	24.0	
2707	MF 27 x 1.50	140	20	-	20.0	16.0	19	4	25.5	
2708	MF 27 x 2.00	140	20	-	20.0	16.0	19	4	25.0	
2807	MF 28 x 1.50	140	15	-	20.0	16.0	19	4	26.5	
2808	MF 28 x 2.00	140	15	-	20.0	16.0	19	4	26.0	
3005	MF 30 x 1.00	150	20	-	22.0	18.0	21	4	29.0	
3007	MF 30 x 1.50	150	20	-	22.0	18.0	21	4	28.5	
3008	MF 30 x 2.00	150	20	-	22.0	18.0	21	4	28.0	

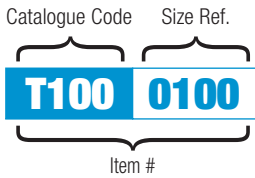
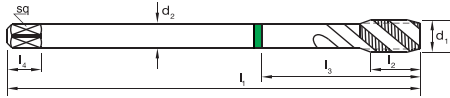
Item #	Item #	Item #	Item #
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•	•	•	•
•	•	•	•
T245 0604	T246 0604	T247 0604	T248 0604
•	•	•	•
•	•	•	•
T245 0805	T246 0805	T247 0805	T248 0805
•	•	•	•
•	•	•	•
T245 1005	T246 1005	T247 1005	T248 1005
T245 1006	T246 1006	T247 1006	T248 1006
•	T246 1205	•	•
T245 1206	T246 1206	T247 1206	T248 1206
T245 1207	•	T247 1207	T248 1207
•	•	•	•
•	•	•	•
T245 1407	T246 1407	T247 1407	T248 1407
•	•	•	•
T245 1607	•	T247 1607	T248 1607
•	•	•	•
•	•	•	•
T245 1807	•	T247 1807	T248 1807
•	•	•	•
•	•	•	•
•	•	•	•
T245 2007	•	T247 2007	T248 2007
•	•	•	•
•	•	•	•
•	•	•	•
T245 2207	•	•	•
T245 2208	•	•	•
•	•	•	•
•	•	•	•
T245 2407	•	•	•
T245 2408	•	•	•
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•	•	•	•
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T245 2607	•	•	•
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•	•	•	•
T245 2707	•	•	•
T245 2708	•	•	•
T245 2807	•	•	•
•	•	•	•
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T245 3007	•	•	•
T245 3008	•	•	•

• Available on request as special manufacture. Subject to lead time.

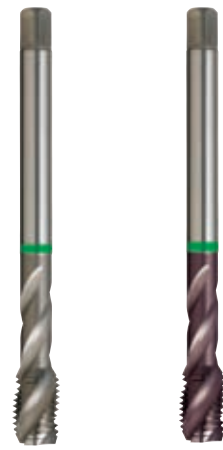
DIN Taps Metric Fine, Spiral Flute, R40 UNI



- Universal use. Suitable for a wide range of materials
- Blind holes
- Suitable for machine operations
- Depths up to approx. $3 \times d_1$



Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #
0302	MF 3 x 0.35	56	4	-	2.2	-	-	3	2.65		T253 0302	T254 0302
0403	MF 4 x 0.50	63	6	-	2.8	2.1	5	3	3.5		T253 0403	T254 0403
0503	MF 5 x 0.50	70	7	-	3.5	2.7	6	3	4.5		T253 0503	T254 0503
0604	MF 6 x 0.75	80	8	-	4.5	3.4	6	3	5.3		T253 0604	T254 0604
0803	MF 8 x 0.50	80	10	-	6.0	4.9	8	3	7.5		T253 0803	T254 0803
0804	MF 8 x 0.75	80	10	-	7.0	4.9	8	3	7.3		T253 0804	T254 0804
0805	MF 8 x 1.00	90	8	-	6.0	4.9	8	3	7.0		T253 0805	T254 0805
1004	MF 10 x 0.75	90	10	-	7.0	5.5	8	3	9.3		T253 1004	T254 1004
1005	MF 10 x 1.00	90	10	-	7.0	5.5	8	3	9.0		T253 1005	T254 1005
1006	MF 10 x 1.25	100	13	-	7.0	5.5	8	3	8.8		T253 1006	T254 1006
1205	MF 12 x 1.00	100	14	-	9.0	7.0	10	3	11.0		T253 1205	T254 1205
1206	MF 12 x 1.25	100	14	-	9.0	7.0	10	3	10.8		T253 1206	T254 1206
1207	MF 12 x 1.50	100	14	-	9.0	7.0	10	3	10.5		T253 1207	T254 1207
1405	MF 14 x 1.00	100	16	-	11.0	9.0	12	3	13.0		T253 1405	T254 1405
1406	MF 14 x 1.25	100	16	-	11.0	9.0	12	3	12.8		T253 1406	T254 1406
1407	MF 14 x 1.50	100	16	-	11.0	9.0	12	3	12.5		T253 1407	T254 1407
1605	MF 16 x 1.00	100	16	-	12.0	9.0	12	3	15.0		T253 1605	T254 1605
1607	MF 16 x 1.50	100	16	-	12.0	9.0	12	3	14.5		T253 1607	T254 1607
1805	MF 18 x 1.00	110	20	-	14.0	11.0	14	4	17.0		T253 1805	T254 1805
1807	MF 18 x 1.50	110	20	-	14.0	11.0	14	4	16.5		T253 1807	T254 1807
1808	MF 18 x 2.00	125	20	-	14.0	11.0	14	4	16.0		T253 1808	T254 1808
2005	MF 20 x 1.00	125	20	-	16.0	12.0	15	4	19.0		T253 2005	T254 2005
2007	MF 20 x 1.50	125	20	-	16.0	12.0	15	4	18.5		T253 2007	T254 2007
2008	MF 20 x 2.00	140	20	-	16.0	12.0	15	4	18.0		T253 2008	T254 2008



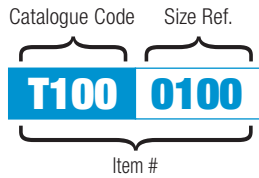
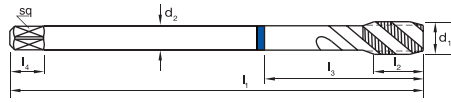
Catalogue Code	T253	T254
Discount Group	D0402	D0410
Material	PM-HSSE V3	PM-HSSE V3
Surface Finish	BrT	TAIIN
Colour Ring & Application	UNI	UNI
Geometry	R40°	R40°
Chamfer	Form C / 2.5 x P	Form C / 2.5 x P
Limit & Nut Tolerance	ISO 2 / 6H	ISO 2 / 6H

MF

DIN Taps Metric Fine, Spiral Flute, R45 VADH



- Use in stainless steels and high strength steels up to 1000N/mm²
- Blind holes
- Suitable for synchronous tapping in machine operations
- Depths up to approx. 3 x d₁



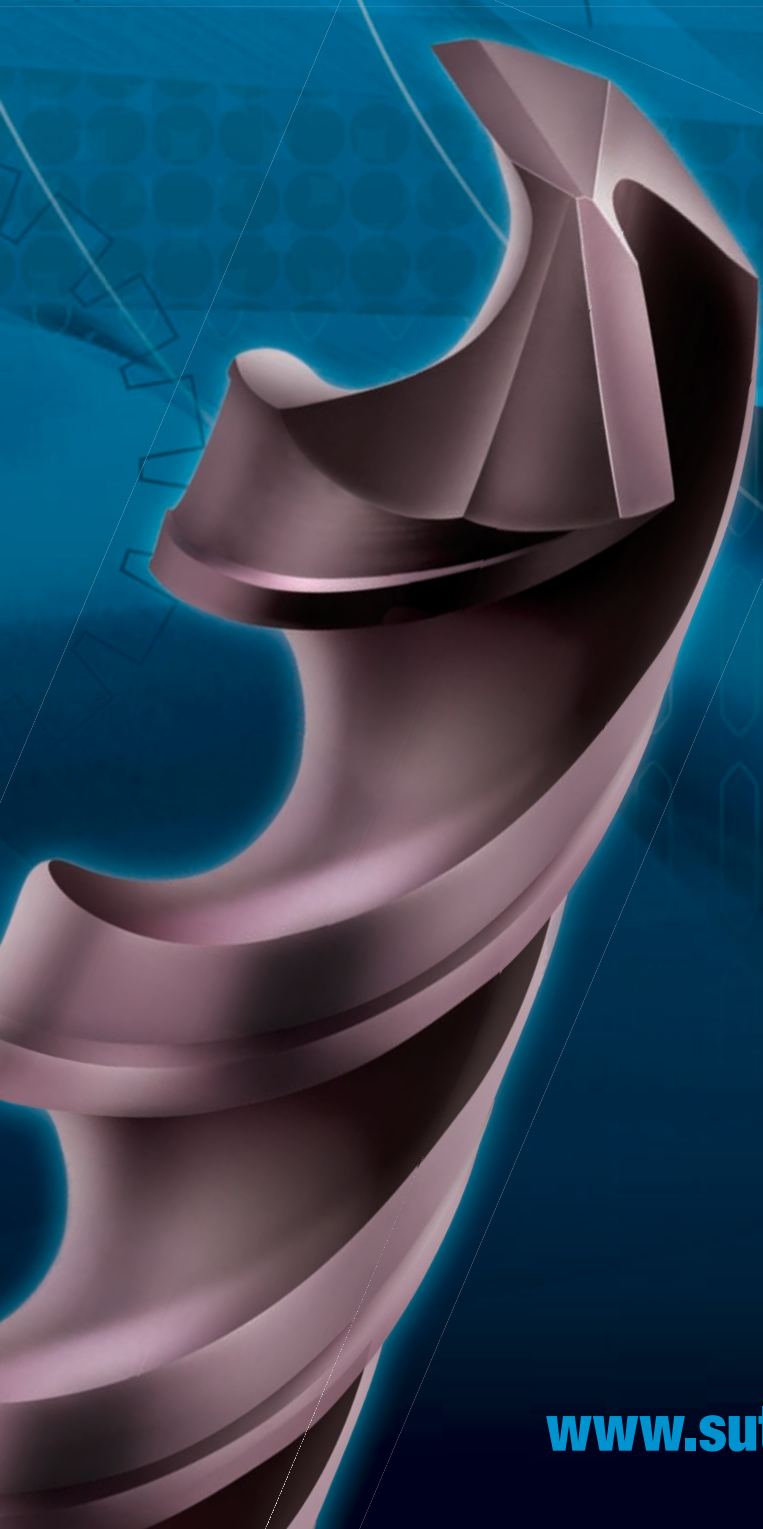
Catalogue Code	T249	T251
Discount Group	D0402	D0408
Material	HSSE V3	HSSE V3
Surface Finish	Blu	TICN
Colour Ring & Application	VA	VA
Geometry	R45°	R45°
Chamfer	Form C / 2.5 x P	Form C / 2.5 x P
Limit & Nut Tolerance	ISO 2 / 6H	ISO 2 / 6H

Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #
0302	MF 3 x 0.35	56	4	-	2.2	-	-	3	2.65		•	•
0403	MF 4 x 0.50	63	6	-	2.8	2.1	5	3	3.5		•	•
0503	MF 5 x 0.50	70	7	-	3.5	2.7	6	3	4.5		•	•
0604	MF 6 x 0.75	80	8	-	4.5	3.4	6	3	5.3		T249 0604	T251 0604
0803	MF 8 x 0.50	80	10	-	6.0	4.9	8	3	7.5		•	•
0804	MF 8 x 0.75	80	10	-	7.0	4.9	8	3	7.3		•	•
0805	MF 8 x 1.00	90	8	-	6.0	4.9	8	3	7.0		T249 0805	T251 0805
1004	MF 10 x 0.75	90	10	-	7.0	5.5	8	3	9.3		•	•
1005	MF 10 x 1.00	90	10	-	7.0	5.5	8	3	9.0		T249 1005	T251 1005
1006	MF 10 x 1.25	100	13	-	7.0	5.5	8	3	8.8		T249 1006	T251 1006
1205	MF 12 x 1.00	100	14	-	9.0	7.0	10	3	11.0		T249 1205	T251 1205
1206	MF 12 x 1.25	100	14	-	9.0	7.0	10	3	10.8		T249 1206	T251 1206
1207	MF 12 x 1.50	100	14	-	9.0	7.0	10	3	10.5		•	•
1405	MF 14 x 1.00	100	16	-	11.0	9.0	12	3	13.0		•	•
1406	MF 14 x 1.25	100	16	-	11.0	9.0	12	3	12.8		•	•
1407	MF 14 x 1.50	100	16	-	11.0	9.0	12	3	12.5		T249 1407	T251 1407
1605	MF 16 x 1.00	100	16	-	12.0	9.0	12	3	15.0		•	•
1607	MF 16 x 1.50	100	16	-	12.0	9.0	12	3	14.5		•	•
1805	MF 18 x 1.00	110	20	-	14.0	11.0	14	4	17.0		•	•
1807	MF 18 x 1.50	110	20	-	14.0	11.0	14	4	16.5		•	•
1808	MF 18 x 2.00	125	20	-	14.0	11.0	14	4	16.0		•	•
2005	MF 20 x 1.00	125	20	-	16.0	12.0	15	4	19.0		•	•
2007	MF 20 x 1.50	125	20	-	16.0	12.0	15	4	18.5		•	•
2008	MF 20 x 2.00	140	20	-	16.0	12.0	15	4	18.0		•	•

• Available on request as special manufacture. Subject to lead time.

drilling stainless steel? a perfect partner for VA taps...

BLACK MAGIC



D153 (stub)

D169 (Jobber)

High Helix & Unique Flute Form:
40° flute helix with unique radiused flute form. Produces short chips, even in Stainless Steel & Copper alloys, allowing for non-step drilling of 3 to 4xd hole depths possible. Resulting in superior drill life & hole condition.



Material: SS304
Ø8mm / depth 16mm
Vc = 20m/min
f = 0.12mm/rev



Material: Cu
Ø8mm / depth 5mm
Vc = 40m/min
f = 0.15mm/rev

Point Geometry:

The cutting edge point geometry is ultra sharp, which generates lower forces when drilling stainless steels.

This also makes it ideal for soft steels, copper and aluminium alloys.

Tool Material & Coating:

Made from premium Cobalt grade of High Speed Steel (HSS Co) with a super smooth TiAlN coating, provides the optimal combination for high heat resistance.

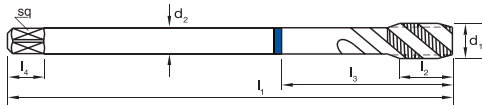
Tapping Drill!

Ideal pre-tapping drill, improves tap life, as work hardening the walls of the hole are eliminated.

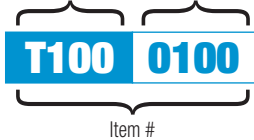
DIN Taps Metric Fine, Spiral Flute, R50 VA PM



- Use in stainless steels and high strength steels up to 1000N/mm²
- PM-HSSE V3 offers higher edge hardness than standard VA series
- Blind holes
- Suitable for synchronous tapping in machine operations
- Depths up to approx. 3 x d₁



Catalogue Code Size Ref.



Catalogue Code	T250	T252
Discount Group	D0402	D0408
Material	PM-HSSE V3	PM-HSSE V3
Surface Finish	Blu	TiCN
Colour Ring & Application	VA PM	VA PM
Geometry	R50°	R50°
Chamfer	Form C / 2.5 x P	Form C / 2.5 x P
Limit & Nut Tolerance	ISO 2 / 6H	6HX

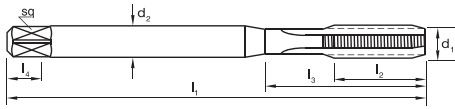
Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #
0302	MF 3 x 0.35	56	4	-	2.2	-	-	3	2.65		•	•
0403	MF 4 x 0.50	63	6	-	2.8	2.1	5	3	3.5		•	•
0503	MF 5 x 0.50	70	7	-	3.5	2.7	6	3	4.5		•	•
0604	MF 6 x 0.75	80	8	-	4.5	3.4	6	3	5.3	T250 0604	•	T252 0604
0803	MF 8 x 0.50	80	10	-	6.0	4.9	8	3	7.5	•	•	T252 0803
0804	MF 8 x 0.75	80	10	-	7.0	4.9	8	3	7.3	•	•	•
0805	MF 8 x 1.00	90	8	-	6.0	4.9	8	3	7.0	T250 0805	•	•
1004	MF 10 x 0.75	90	10	-	7.0	5.5	8	3	9.3	•	•	T252 1004
1005	MF 10 x 1.00	90	10	-	7.0	5.5	8	3	9.0	T250 1005	•	T252 1005
1006	MF 10 x 1.25	100	13	-	7.0	5.5	8	3	8.8	T250 1006	•	•
1205	MF 12 x 1.00	100	14	-	9.0	7.0	10	3	11.0	T250 1205	•	T252 1205
1206	MF 12 x 1.25	100	14	-	9.0	7.0	10	3	10.8	T250 1206	•	T252 1206
1207	MF 12 x 1.50	100	14	-	9.0	7.0	10	3	10.5	T250 1207	•	T252 1207
1405	MF 14 x 1.00	100	16	-	11.0	9.0	12	3	13.0	•	•	T252 1405
1406	MF 14 x 1.25	100	16	-	11.0	9.0	12	3	12.8	•	•	T252 1406
1407	MF 14 x 1.50	100	16	-	11.0	9.0	12	3	12.5	T250 1407	•	T252 1407
1605	MF 16 x 1.00	100	16	-	12.0	9.0	12	3	15.0	•	•	T252 1605
1607	MF 16 x 1.50	100	16	-	12.0	9.0	12	3	14.5	T250 1607	•	T252 1607
1805	MF 18 x 1.00	110	20	-	14.0	11.0	14	4	17.0	•	•	T252 1805
1807	MF 18 x 1.50	110	20	-	14.0	11.0	14	4	16.5	•	•	•
1808	MF 18 x 2.00	125	20	-	14.0	11.0	14	4	16.0	•	•	•
2005	MF 20 x 1.00	125	20	-	16.0	12.0	15	4	19.0	•	•	•
2007	MF 20 x 1.50	125	20	-	16.0	12.0	15	4	18.5	T250 2007	•	T252 2007
2008	MF 20 x 2.00	140	20	-	16.0	12.0	15	4	18.0	•	•	•

• Available on request as special manufacture. Subject to lead time.

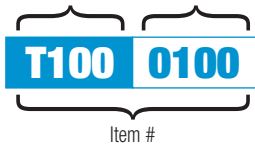
DIN Taps UNC, Straight Flute, GG



- Use in grey cast iron (GG), brittle plastics, hard bronzes to a hardness of 850 N/mm²
- Through & blind holes
- Suitable for machine operations
- Depths up to approx. 3 x d₁



Catalogue Code Size Ref.



Size Ref.	d ₁	TPI	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #
0218	# 2	56	45	9	10	2.8	2.1	5	2	1.85	•
0251	# 3	48	50	9	10	2.8	2.1	5	2	2.1	•
0284	# 4	40	56	11	18	3.5	2.7	6	2	2.3	•
0318	# 5	40	56	11	18	3.5	2.7	6	3	2.6	•
0351	# 6	32	56	13	19	4.0	3.0	6	3	2.8	•
0417	# 8	32	63	13	19	4.5	3.4	6	3	3.4	•
0483	# 10	24	70	16	20	6.0	4.9	8	3	3.8	•
0549	# 12	24	80	19	29	6.0	4.9	8	3	4.5	•
0635	1/4	20	80	19	30	7.0	5.5	8	3	5.1	T302 0635
0794	5/16	18	90	22	34	8.0	6.2	9	3	6.6	T302 0794
0953	3/8	16	100	22	35	10.0	7.0	10	3	8.0	T302 0953

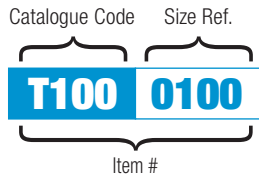
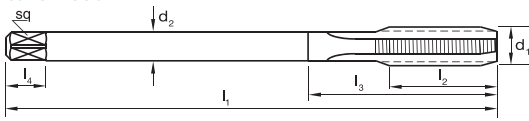
Catalogue Code	T302
Discount Group	D0402
Material	HSSE V3
Surface Finish	Ni + Blu
Colour Ring & Application	GG
Geometry	Low Relief
Chamfer	Form C / 2.5 x P
Limit & Nut Tolerance	2BX

• Available on request as special manufacture. Subject to lead time.

DIN Taps UNC, Straight Flute, GG



- Use in grey cast iron (GG), brittle plastics, hard bronzes to a hardness of 850 N/mm²
- Through & blind holes
- Suitable for machine operations
- Depths up to approx. 3 x d₁



Catalogue Code	T302
Discount Group	D0402
Material	HSSE V3
Surface Finish	Ni + Blu
Colour Ring & Application	GG
Geometry	Low Relief
Chamfer	Form C / 2.5 x P
Limit & Nut Tolerance	2BX

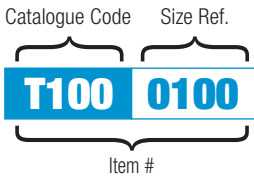
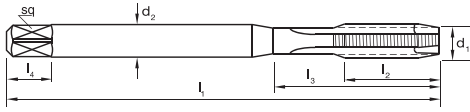
Size Ref.	d ₁	TPI	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #
1111	7/16	14	100	24	-	8.0	6.2	8	3	9.4	•
1270	1/2	13	110	28	-	9.0	7.0	10	3	10.8	T302 1270
1429	9/16	12	110	30	-	11.0	9.0	12	3	12.2	•
1588	5/8	11	110	32	-	12.0	9.0	12	3	13.5	T302 1588
1905	3/4	10	125	34	-	14.0	11.0	14	4	16.5	T302 1905
2223	7/8	9	140	34	-	18.0	14.5	17	4	19.5	•
2540	1	8	160	38	-	18.0	14.5	17	4	22.2	T302 2540

• Available on request as special manufacture. Subject to lead time.

DIN Taps UNC, Gun, N



- General purpose use, materials up to approx. 1000 N/mm²
- Through holes
- Suitable for machine operations
- Depths up to approx. 3 x d₁



Catalogue Code
Discount Group
Material
Surface Finish
Colour Ring & Application
Geometry
Chamfer
Limit & Nut Tolerance

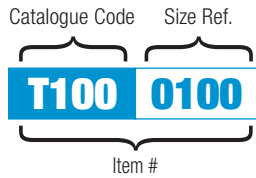
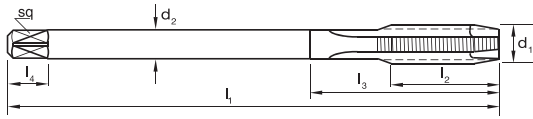
T164	T166	T167
D0402	D0402	D0406
HSSE V3	HSSE V3	HSSE V3
Br t	Bl u	Ti N
N	N	N
Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P
2B	2B	2B

	d ₁	TPI	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #	Item #
0218	# 2	56	45	9	10	2.8	2.1	5	2	1.85	T164 0218	•	T167 0218
0251	# 3	48	50	9	10	2.8	2.1	5	2	2.1	T164 0251	•	T167 0251
0284	# 4	40	56	11	18	3.5	2.7	6	2	2.3	T164 0284	•	T167 0284
0318	# 5	40	56	11	18	3.5	2.7	6	3	2.6	T164 0318	•	•
0351	# 6	32	56	13	19	4.0	3.0	6	3	2.8	T164 0351	•	T167 0351
0417	# 8	32	63	13	19	4.5	3.4	6	3	3.4	T164 0417	•	T167 0417
0483	# 10	24	70	16	20	6.0	4.9	8	3	3.8	T164 0483	•	T167 0483
0549	# 12	24	80	19	29	6.0	4.9	8	3	4.5	T164 0549	•	T167 0549
0635	1/4	20	80	19	30	7.0	5.5	8	3	5.1	T164 0635	T166 0635	T167 0635
0794	5/16	18	90	22	34	8.0	6.2	9	3	6.6	T164 0794	T166 0794	T167 0794
0953	3/8	16	100	22	35	10.0	7.0	10	3	8.0	T164 0953	T166 0953	T167 0953

DIN Taps UNC, Gun, N



- General purpose use, materials up to approx. 1000 N/mm²
- Through holes
- Suitable for machine operations
- Depths up to approx. 3 x d₁



	T164	T166	T167
Catalogue Code	D0402	D0402	D0406
Discount Group			
Material	HSSE V3	HSSE V3	HSSE V3
Surface Finish	Brt	Blu	TIN
Colour Ring & Application	N	N	N
Geometry			
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P
Limit & Nut Tolerance	2B	2B	2B

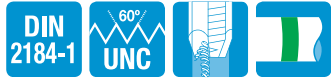
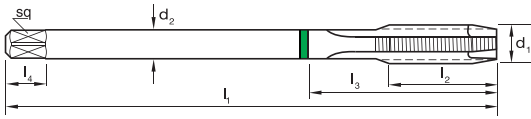
Size Ref.	d ₁	TPI	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #	Item #
1111	7/16	14	100	24	-	8.0	6.2	8	3	9.4	T164 1111	T167 1111	•
1270	1/2	13	110	28	-	9.0	7.0	10	3	10.8	T164 1270	T166 1270	T167 1270
1429	9/16	12	110	30	-	11.0	9.0	12	3	12.2	T164 1429	T167 1429	•
1588	5/8	11	110	32	-	12.0	9.0	12	3	13.5	T164 1588	T166 1588	T167 1588
1905	3/4	10	125	34	-	14.0	11.0	14	4	16.5	T164 1905	T166 1905	T167 1905
2223	7/8	9	140	34	-	18.0	14.5	17	4	19.5	T164 2223	T167 2223	•
2540	1	8	160	38	-	18.0	14.5	17	4	22.2	T164 2540	T167 2540	•

• Available on request as special manufacture. Subject to lead time.

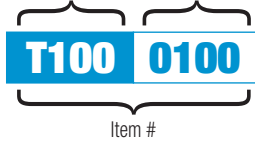
DIN Taps UNC, Gun, UNI



- Universal use. Suitable for a wide range of materials
- Through holes
- Suitable for machine operations
- Depths up to approx. 3 x d₁



Catalogue Code Size Ref.



Catalogue Code	T168	T169
Discount Group	D0402	D0410
Material	PM-HSSE V3	PM-HSSE V3
Surface Finish	Blu	TAIN
Colour Ring & Application	UNI	UNI
Geometry		
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P
Limit & Nut Tolerance	2B	2B

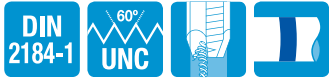
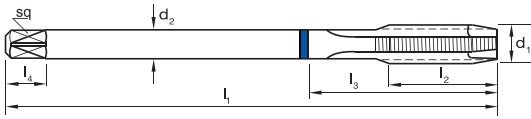
Size Ref.	d ₁	TPI	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #
1111	7/16	14	100	24	-	8.0	6.2	8	3	9.4	•	•
1270	1/2	13	110	28	-	9.0	7.0	10	3	10.8	T168 1270	T169 1270
1429	9/16	12	110	30	-	11.0	9.0	12	3	12.2	•	•
1588	5/8	11	110	32	-	12.0	9.0	12	3	13.5	T168 1588	T169 1588
1905	3/4	10	125	34	-	14.0	11.0	14	4	16.5	T168 1905	T169 1905
2223	7/8*	9	140	34	-	18.0	14.5	17	4	19.5	•	•
2540	1*	8	160	38	-	18.0	14.5	17	4	22.2	T168 2540	T169 2540

• Available on request as special manufacture. Subject to lead time.

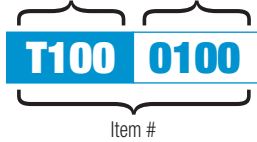
DIN Taps UNC, Gun, VA



- Use in stainless steels and high strength steels up to 1000N/mm²
- Through holes
- Suitable for machine operations
- Depths up to approx. 3 x d₁



Catalogue Code Size Ref.



Catalogue Code	T170	T171
Discount Group	D0402	D0408
Material	HSSE V3	HSSE V3
Surface Finish	Blu	TCN
Colour Ring & Application	VA	VA
Geometry	Special Relief	Special Relief
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P
Limit & Nut Tolerance	2B	2B

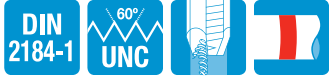
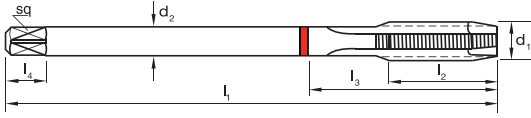
Size Ref.	d ₁	TPI	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #
1111	7/16	14	100	24	-	8.0	6.2	8	3	9.4	T170 1111	T171 1111
1270	1/2	13	110	28	-	9.0	7.0	10	3	10.8	T170 1270	T171 1270
1429	9/16	12	110	30	-	11.0	9.0	12	3	12.2	T170 1429	•
1588	5/8	11	110	32	-	12.0	9.0	12	3	13.5	T170 1588	T171 1588
1905	3/4	10	125	34	-	14.0	11.0	14	4	16.5	T170 1905	T171 1905
2223	7/8	9	140	34	-	18.0	14.5	17	4	19.5	T170 2223	T171 2223
2540	1	8	160	38	-	18.0	14.5	17	4	22.2	T170 2540	T171 2540

• Available on request as special manufacture. Subject to lead time.

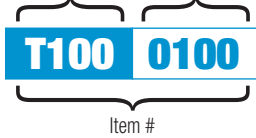
DIN Taps UNC, Gun, H



- Use in harder short chipping materials up to 45 HR_c
- Through holes
- Suitable for machine operations
- Depths up to approx. 3 x d₁



Catalogue Code Size Ref.



Catalogue Code

T172

T666

Discount Group

D0402

D0408

Material

PM-HSS Co

PM-HSS Co

Surface Finish

Blu

T666

Colour Ring & Application

H

H

Geometry

Low Relief

Low Relief

Chamfer

Form C / 3 x P

Form C / 3 x P

Limit & Nut Tolerance

2BX

2BX

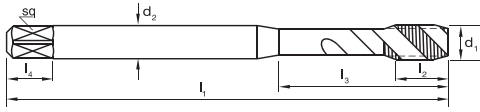
Size Ref.	d ₁	TPI	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
1111	7/16	14	100	24	-	8.0	6.2	8	3	9.4
1270	1/2	13	110	28	-	9.0	7.0	10	3	10.8
1429	9/16	12	110	30	-	11.0	9.0	12	3	12.2
1588	5/8	11	110	32	-	12.0	9.0	12	3	13.5
1905	3/4	10	125	34	-	14.0	11.0	14	4	16.5
2223	7/8*	9	140	34	-	18.0	14.5	17	4	19.5
2540	1*	8	160	38	-	18.0	14.5	17	4	22.2
2858	1.1/8*	7	180	45	-	22.0	18.0	21	4	25.0

	Item #	Item #
	T172 1111	T666 1111
	T172 1270	T666 1270
	T172 1429	T666 1429
	T172 1588	T666 1588
	T172 1905	T666 1905
	T172 2223	T666 2223
	T172 2540	T666 2540
	T172 2858	T666 2858

DIN Taps UNC, Spiral Flute, R40 N



- General purpose use, materials up to approx. 1000 N/mm²
- Blind holes
- Suitable for machine operations
- Depths up to approx. 2.5 x d₁



Catalogue Code Size Ref.



	d ₁	TPI	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
0218	# 2	56	45	9	10	2.8	2.1	5	2	1.85
0251	# 3	48	50	9	10	2.8	2.1	5	2	2.1
0284	# 4	40	56	5	18	3.5	2.7	6	2	2.3
0318	# 5	40	56	6	18	3.5	2.7	6	3	2.6
0351	# 6	32	56	6	19	4.0	3.0	6	3	2.8
0417	# 8	32	63	7	19	4.5	3.4	6	3	3.4
0483	# 10	24	70	8	20	6.0	4.9	8	3	3.8
0549	# 12	24	80	10	29	6.0	4.9	8	3	4.5
0635	1/4	20	80	10	30	7.0	5.5	8	3	5.1
0794	5/16	18	90	13	34	8.0	6.2	9	3	6.6
0953	3/8	16	100	15	35	10.0	7.0	10	3	8.0



Catalogue Code	T258	T260	T273
Discount Group	D0402	D0402	D0406
Material	HSSE V3	HSSE V3	HSSE V3
Surface Finish	Br	Blu	TiN
Colour Ring & Application	N	N	N
Geometry	R40°	R40°	R40°
Chamfer	Form C / 2.5 x P	Form C / 2.5 x P	Form C / 2.5 x P
Limit & Nut Tolerance	2B	2B	2B

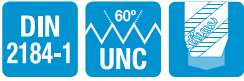
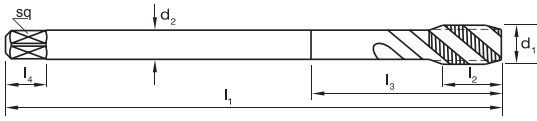
Item #	Item #	Item #
T258 0218	•	T273 0218
•	•	T273 0251
T258 0284	•	T273 0284
T258 0318	•	T273 0318
T258 0351	•	T273 0351
T258 0417	•	T273 0417
T258 0483	•	T273 0483
T258 0549	•	T273 0549
T258 0635	T260 0635	T273 0635
T258 0794	T260 0794	T273 0794
T258 0953	T260 0953	T273 0953

• Available on request as special manufacture. Subject to lead time.

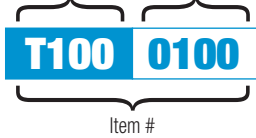
DIN Taps UNC, Spiral Flute, R40 N



- General purpose use, materials up to approx. 1000 N/mm²
- Blind holes
- Suitable for machine operations
- Depths up to approx. 2.5 x d₁



Catalogue Code Size Ref.



Size Ref.	d ₁	TPI	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #	Item #
1111	7/16	14	100	15	-	8.0	6.2	8	3	9.4	T258 1111	•	T273 1111
1270	1/2	13	110	18	-	9.0	7.0	10	3	10.8	T258 1270	T260 1270	T273 1270
1429	9/16	12	110	20	-	11.0	9.0	12	3	12.2	T258 1429	•	T273 1429
1588	5/8	11	110	20	-	12.0	9.0	12	3	13.5	T258 1588	T260 1588	T273 1588
1905	3/4	10	125	25	-	14.0	11.0	14	4	16.5	T258 1905	T260 1905	T273 1905
2223	7/8	9	140	28	-	18.0	14.5	17	4	19.5	T258 2223	•	T273 2223
2540	1	8	160	32	-	18.0	14.5	17	4	22.2	T258 2540	•	T273 2540

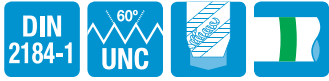
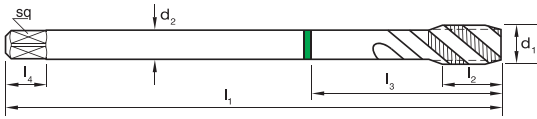


Catalogue Code	T258	T260	T273
Discount Group	D0402	D0402	D0406
Material	HSSE V3	HSSE V3	HSSE V3
Surface Finish	Brt	Blu	TIN
Colour Ring & Application	N	N	N
Geometry	R40°	R40°	R40°
Chamfer	Form C / 2.5 x P	Form C / 2.5 x P	Form C / 2.5 x P
Limit & Nut Tolerance	2B	2B	2B

DIN Taps UNC, Spiral Flute, R40 UNI



- Universal use. Suitable for a wide range of materials
- Blind holes
- Suitable for machine operations
- Depths up to approx. $3 \times d_1$



Catalogue Code Size Ref.

T100	0100
Item #	

Size Ref.	d ₁	TPI	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
1111	7/16	14	100	15	-	8.0	6.2	8	3	9.4
1270	1/2	13	110	18	-	9.0	7.0	10	3	10.8
1429	9/16	12	110	20	-	11.0	9.0	12	3	12.2
1588	5/8	11	110	20	-	12.0	9.0	12	3	13.5
1905	3/4	10	125	25	-	14.0	11.0	14	4	16.5
2223	7/8*	9	140	28	-	18.0	14.5	17	4	19.5
2540	1*	8	160	32	-	18.0	14.5	17	4	22.2



Catalogue Code	T266	T267
Discount Group	D0410	D0410
Material	PM-HSSE V3	PM-HSSE V3
Surface Finish	Blu	TAIN
Colour Ring & Application	UNI	UNI
Geometry	R40°	R40°
Chamfer	Form C / 2.5 x P	Form C / 2.5 x P
Limit & Nut Tolerance	2B	2B

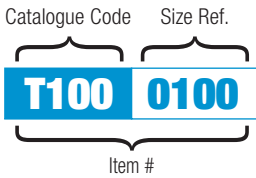
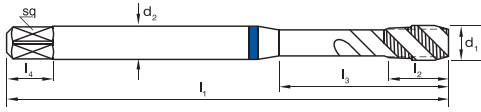
Item #	Item #
•	•
T266 1270	T267 1270
•	•
T266 1588	T267 1588
T266 1905	T267 1905
•	•
T266 2540	T267 2540

• Available on request as special manufacture. Subject to lead time.

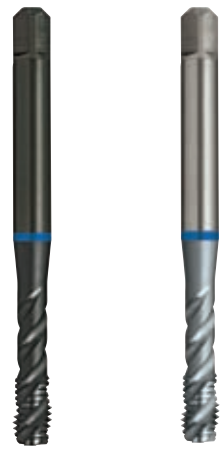
DIN Taps UNC, Spiral Flute, R45 VADH



- Use in stainless steels and high strength steels up to 1000N/mm²
- Blind holes
- Suitable for synchronous tapping in machine operations
- Depths up to approx. 3 x d₁



Size Ref.	d ₁	TPI	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
0218	# 2	56	45	9	10	2.8	2.1	5	2	1.85
0251	# 3	48	50	9	10	2.8	2.1	5	2	2.1
0284	# 4	40	56	5	18	3.5	2.7	6	2	2.3
0318	# 5	40	56	6	18	3.5	2.7	6	3	2.6
0351	# 6	32	56	6	19	4.0	3.0	6	3	2.8
0417	# 8	32	63	7	19	4.5	3.4	6	3	3.4
0483	# 10	24	70	8	20	6.0	4.9	8	3	3.8
0549	# 12	24	80	10	29	6.0	4.9	8	3	4.5
0635	1/4	20	80	10	30	7.0	5.5	8	3	5.1
0794	5/16	18	90	13	34	8.0	6.2	9	3	6.6
0953	3/8	16	100	15	35	10.0	7.0	10	3	8.0



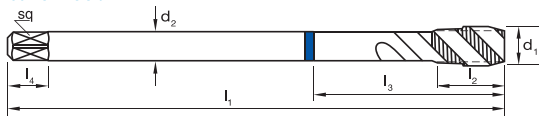
Catalogue Code	T261	T262
Discount Group	D0402	D0408
Material	HSSE V3	HSSE V3
Surface Finish	Blu	TICN
Colour Ring & Application	VA	VA
Geometry	R45°	R45°
Chamfer	Form C / 2.5 x P	Form C / 2.5 x P
Limit & Nut Tolerance	2B	2B

Item #	Item #
•	•
•	•
T261 0284	T262 0284
•	•
T261 0351	T262 0351
T261 0417	T262 0417
T261 0483	T262 0483
•	•
T261 0635	T262 0635
T261 0794	T262 0794
T261 0953	T262 0953

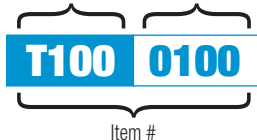
DIN Taps UNC, Spiral Flute, R45 VADH



- Use in stainless steels and high strength steels up to 1000N/mm²
- Blind holes
- Suitable for synchronous tapping in machine operations
- Depths up to approx. 3 x d₁



Catalogue Code Size Ref.



Size Ref.	d ₁	TPI	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
1111	7/16	14	100	15	-	8.0	6.2	8	3	9.4
1270	1/2	13	110	18	-	9.0	7.0	10	3	10.8
1429	9/16	12	110	20	-	11.0	9.0	12	3	12.2
1588	5/8	11	110	20	-	12.0	9.0	12	3	13.5
1905	3/4	10	125	25	-	14.0	11.0	14	4	16.5
2223	7/8	9	140	28	-	18.0	14.5	17	4	19.5
2540	1	8	160	32	-	18.0	14.5	17	4	22.2



Catalogue Code	T261	T262
Discount Group	D0402	D0408
Material	HSSE V3	HSSE V3
Surface Finish	Blu	TCN
Colour Ring & Application	VA	VA
Geometry	R45°	R45°
Chamfer	Form C / 2.5 x P	Form C / 2.5 x P
Limit & Nut Tolerance	2B	2B

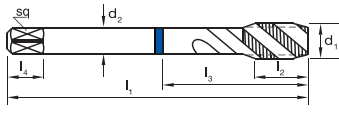
Item #	Item #
T261 1111	T262 1111
T261 1270	T262 1270
•	•
T261 1588	T262 1588
T261 1905	T262 1905
T261 2223	T262 2223
T261 2540	T262 2540

• Available on request as special manufacture. Subject to lead time.

DIN Taps 8UN, Spiral Flute, R40 VA



- Use in stainless steels and high strength steels up to 1000N/mm²
- Blind holes
- Suitable for synchronous tapping in machine operations
- Depths up to approx. 2.5 x d₁



Catalogue Code Size Ref.

T100 **0100**

Item #

Size Ref.	d ₁	TPI	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
2858	1.1/8	8	180	30	-	22.0	18.0	21	4	25.5
3175	1.1/4	8	180	30	-	22.0	18.0	21	4	28.5
3493	1.3/8	8	200	30	-	28.0	22.0	25	4	31.75
3810	1.1/2	8	200	30	-	28.0	22.0	25	6	35.0
4128	1.5/8	8	200	30	-	32.0	24.0	27	6	38.0
4445	1.3/4	8	220	30	-	36.0	29.0	3	6	41.5
4763	1.7/8	8	250	30	-	40.0	32.0	35	6	44.5
5080	2	8	250	33	-	40.0	32.0	35	6	47.5



Catalogue Code	T263	T264
Discount Group	D0402	D0408
Material	HSSE V3	HSSE V3
Surface Finish	Brt	TICN
Colour Ring & Application	VA	VA
Geometry	R40°	R40°
Chamfer	Form C / 2.5 x P	Form C / 2.5 x P
Limit & Nut Tolerance	2B	2B

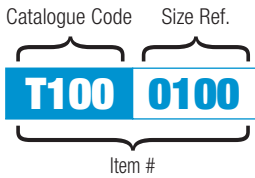
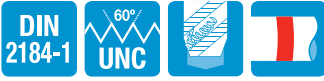
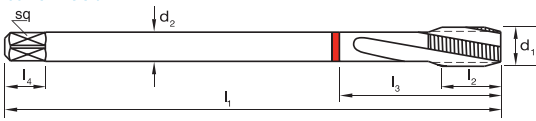
Item #	Item #
T263 2858	T264 2858
T263 3175	T264 3175
T263 3493	T264 3493
T263 3810	T264 3810
T263 4128	T264 4128
T263 4445	T264 4445
T263 4763	T264 4763
T263 5080	T264 5080

UN

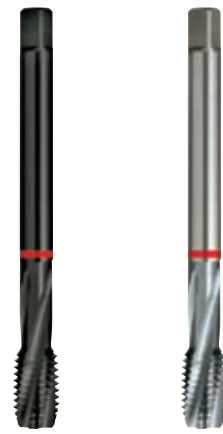
DIN Taps UNC, Spiral Flute, R15 H



- Use in harder short chipping materials up to 45 HR_c
- Blind holes
- Suitable for machine operations
- Depths up to approx. 1.5 x d₁



Size Ref.	d ₁	TPI	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
1111	7/16	14	100	15	-	8.0	6.2	8	3	9.4
1270	1/2	13	110	18	-	9.0	7.0	10	4	10.8
1429	9/16	12	110	20	-	11.0	9.0	12	4	12.2
1588	5/8	11	110	20	-	12.0	9.0	12	4	13.5
1905	3/4	10	125	25	-	14.0	11.0	14	4	16.5
2223	7/8*	9	140	28	-	18.0	14.5	17	4	19.5
2540	1*	8	160	32	-	18.0	14.5	17	4	22.2
2858	1.1/8*	7	180	45	-	22.0	18.0	21	4	25.0



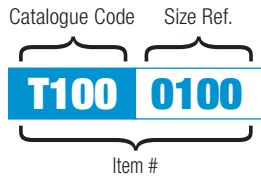
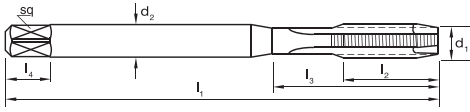
Catalogue Code	T265	T667
Discount Group	D0402	D0408
Material	PM-HSS Co	PM-HSS Co
Surface Finish	Blus	TICN
Colour Ring & Application	H	H
Geometry	R15°	R15°
Chamfer	Form C / 3 x P	Form C / 3 x P
Limit & Nut Tolerance	2BX	2BX

Item #	Item #
T265 1111	T667 1111
T265 1270	T667 1270
T265 1429	T667 1429
T265 1588	T667 1588
T265 1905	T667 1905
T265 2223	T667 2223
T265 2540	T667 2540
T265 2858	T667 2858

DIN Taps UNF, Gun, N



- General purpose use, materials up to approx. 1000 N/mm²
- Through holes
- Suitable for machine operations
- Depths up to approx. 3 x d₁



Catalogue Code	T173	T175
Discount Group	D0402	D0406
Material	HSSE V3	HSSE V3
Surface Finish	Brt	TiN
Colour Ring & Application	N	N
Geometry		
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P
Limit & Nut Tolerance	2B	2B

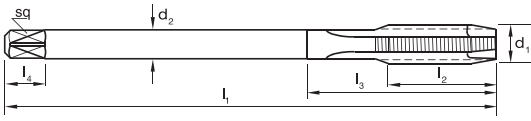
Size Ref.	d ₁	TPI	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #
0218	#2	64	45	9	-	2.8	2.1	5	2	1.9	T173 0218	T175 0218
0251	#3	56	50	9	-	2.8	2.1	5	2	2.1	•	•
0284	#4	48	56	11	18	3.5	2.7	6	2	2.35	T173 0284	T175 0284
0318	#5	44	56	11	18	3.5	2.7	6	3	2.65	•	T175 0318
0351	#6	40	56	13	20	4.0	3.0	6	3	2.9	T173 0351	T175 0351
0417	#8	36	63	13	21	4.5	3.4	6	3	3.5	T173 0417	T175 0417
0483	#10	32	70	16	25	6.0	4.9	8	3	4.1	T173 0483	T175 0483
0549	#12	28	80	19	30	6.0	4.9	8	3	4.6	•	•
0635	1/4	28	80	19	30	7.0	5.5	8	3	5.5	T173 0635	T175 0635
0794	5/16	24	90	22	35	8.0	6.2	9	3	6.9	T173 0794	T175 0794
0953	3/8	24	100	20	35	10.0	8.0	11	3	8.5	T173 0953	T175 0953

• Available on request as special manufacture. Subject to lead time.

DIN Taps UNF, Gun, N



- General purpose use, materials up to approx. 1000 N/mm²
- Through holes
- Suitable for machine operations
- Depths up to approx. 3 x d₁



Catalogue Code Size Ref.

T100 **0100**

Item #

Size Ref.	d ₁	TPI	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
1111	7/16	20	100	24	-	8.0	6.2	8	3	9.8
1270	1/2	20	110	28	-	9.0	7.0	10	3	11.5
1429	9/16	18	110	32	-	11.0	9.0	12	3	12.8
1588	5/8	18	110	32	-	12.0	9.0	12	3	14.5
1905	3/4	16	125	34	-	14.0	11.0	14	4	17.5
2223	7/8	14	140	34	-	18.0	14.5	17	4	20.5
2540	1	12	160	38	-	18.0	14.5	17	4	23.5



Catalogue Code	T173	T175
Discount Group	D0402	D0406
Material	HSSE V3	HSSE V3
Surface Finish	BrT	TiN
Colour Ring & Application	N	N
Geometry		
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P
Limit & Nut Tolerance	2B	2B

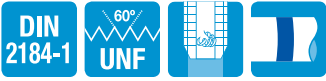
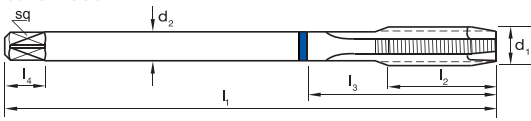
Item #	Item #
T173 1111	T175 1111
T173 1270	T175 1270
T173 1429	T175 1429
T173 1588	T175 1588
T173 1905	T175 1905
T173 2223	T175 2223
T173 2540	T175 2540

UNF

DIN Taps UNF, Gun, VA



- Use in stainless steels and high strength steels up to 1000N/mm²
- Through holes
- Suitable for machine operations
- Depths up to approx. 3 x d₁



Catalogue Code Size Ref.

T100 **0100**

Item #

Size Ref.	d ₁	TPI	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
1111	7/16	20	100	24	-	8.0	6.2	8	3	9.8
1270	1/2	20	110	28	-	9.0	7.0	10	3	11.5
1429	9/16	18	110	32	-	11.0	9.0	12	3	12.8
1588	5/8	18	110	32	-	12.0	9.0	12	3	14.5
1905	3/4	16	125	34	-	14.0	11.0	14	4	17.5
2223	7/8	14	140	34	-	18.0	14.5	17	4	20.5
2540	1	12	160	38	-	18.0	14.5	17	4	23.5



Catalogue Code	T176	T177
Discount Group	D0402	D0408
Material	HSSE V3	HSSE V3
Surface Finish	Blu	TICN
Colour Ring & Application	VA	VA
Geometry	Special Relief	Special Relief
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P
Limit & Nut Tolerance	2B	2B

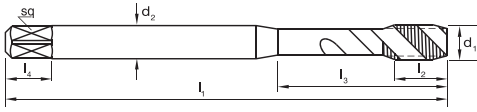
Item #	Item #
T176 1111	T177 1111
T176 1270	T177 1270
T176 1429	T177 1429
T176 1588	T177 1588
T176 1905	T177 1905
T176 2223	T177 2223
T176 2540	T177 2540

UNF

DIN Taps UNF, Spiral Flute, R40 N



- General purpose use, materials up to approx. 1000 N/mm²
- Blind holes
- Suitable for machine operations
- Depths up to approx. 2.5 x d₁



Catalogue Code Size Ref.

T100
0100

Item #

Size Ref.	d ₁	TPI	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #
0218	# 2	64	45	9	-	2.8	2.1	5	2	1.9	•
0251	# 3	56	50	9	-	2.8	2.1	5	2	2.1	•
0284	# 4	48	56	5	18	3.5	2.7	6	2	2.35	•
0318	# 5	44	56	6	18	3.5	2.7	6	3	2.65	•
0351	# 6	40	56	6	20	4.0	3.0	6	3	2.9	T275 0351
0417	# 8	36	63	7	21	4.5	3.4	6	3	3.5	T275 0417
0483	# 10	32	70	8	25	6.0	4.9	8	3	4.1	T275 0483
0549	# 12	28	80	10	30	6.0	4.9	8	3	4.6	•
0635	1/4	28	80	10	30	7.0	5.5	8	3	5.5	T275 0635
0794	5/16	24	90	13	35	8.0	6.2	9	3	6.9	T275 0794
0953	3/8	24	100	15	35	10.0	8.0	11	3	8.5	T275 0953



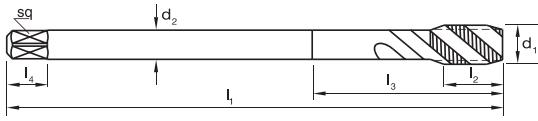
Catalogue Code	T275
Discount Group	D0402
Material	HSSE V3
Surface Finish	Brt
Colour Ring & Application	N
Geometry	R40°
Chamfer	Form C / 2.5 x P
Limit & Nut Tolerance	2B

• Available on request as special manufacture. Subject to lead time.

DIN Taps UNF, Spiral Flute, R40 N



- General purpose use, materials up to approx. 1000 N/mm²
- Blind holes
- Suitable for machine operations
- Depths up to approx. 2.5 x d₁



Catalogue Code Size Ref.

T100 **0100**

Item #



Catalogue Code	T275
Discount Group	D0402
Material	HSSE V3
Surface Finish	Brt
Colour Ring & Application	N
Geometry	R40°
Chamfer	Form C / 2.5 x P
Limit & Nut Tolerance	2B

Size Ref.	d ₁	TPI	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #
1111	7/16	20	100	15	-	8.0	6.2	8	3	9.8	T275 1111
1270	1/2	20	110	18	-	9.0	7.0	10	3	11.5	T275 1270
1429	9/16	18	110	20	-	11.0	9.0	12	3	12.8	•
1588	5/8	18	110	20	-	12.0	9.0	12	3	14.5	T275 1588
1905	3/4	16	125	25	-	14.0	11.0	14	4	17.5	T275 1905
2223	7/8	14	140	28	-	18.0	14.5	17	4	20.5	T275 2223
2540	1	12	160	32	-	18.0	14.5	17	4	23.5	•

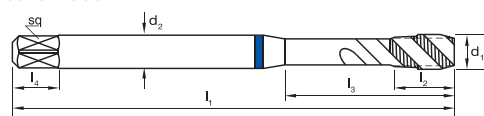
UNF

• Available on request as special manufacture. Subject to lead time.

DIN Taps UNF, Spiral Flute, R45 VADH



- Use in stainless steels and high strength steels up to 1000N/mm²
- Blind holes
- Suitable for synchronous tapping in machine operations
- Depths up to approx. 3 x d₁



Catalogue Code Size Ref.



Catalogue Code

T276

T277

Discount Group

D0402

D0408

Material

HSSE V3

HSSE V3

Surface Finish

Blu

TICN

Colour Ring & Application

VA

VA

Geometry

R45°

R45°

Chamfer

Form C / 2.5 x P

Form C / 2.5 x P

Limit & Nut Tolerance

2B

2B

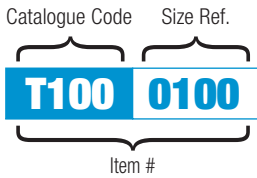
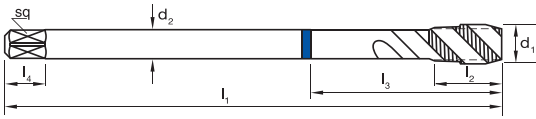
Size Ref.	d ₁	TPI	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #
0218	# 2	64	45	9	-	2.8	2.1	5	2	1.9	•	•
0251	# 3	56	50	9	-	2.8	2.1	5	2	2.1	•	•
0284	# 4	48	56	5	18	3.5	2.7	6	2	2.35	•	•
0318	# 5	44	56	6	18	3.5	2.7	6	3	2.65	•	•
0351	# 6	40	56	6	20	4.0	3.0	6	3	2.9	T276 0351	•
0417	# 8	36	63	7	21	4.5	3.4	6	3	3.5	T276 0417	•
0483	# 10	32	70	8	25	6.0	4.9	8	3	4.1	T276 0483	•
0549	# 12	28	80	10	30	6.0	4.9	8	3	4.6	•	•
0635	1/4	28	80	10	30	7.0	5.5	8	3	5.5	T276 0635	T277 0635
0794	5/16	24	90	13	35	8.0	6.2	9	3	6.9	T276 0794	T277 0794
0953	3/8	24	100	15	35	10.0	8.0	11	3	8.5	T276 0953	T277 0953

• Available on request as special manufacture. Subject to lead time.

DIN Taps UNF, Spiral Flute, R45 VADH



- Use in stainless steels and high strength steels up to 1000N/mm²
- Blind holes
- Suitable for synchronous tapping in machine operations
- Depths up to approx. 3 x d₁



Size Ref.	d ₁	TPI	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
1429	7/16	20	100	15	-	8.0	6.2	8	3	9.8
1270	1/2	20	110	18	-	9.0	7.0	10	3	11.5
1429	9/16	18	110	20	-	11.0	9.0	12	3	12.8
1588	5/8	18	110	20	-	12.0	9.0	12	3	14.5
1905	3/4	16	125	25	-	14.0	11.0	14	4	17.5
2223	7/8	14	140	28	-	18.0	14.5	17	4	20.5
2540	1	12	160	32	-	18.0	14.5	17	4	23.5



Catalogue Code	T276	T277
Discount Group	D0402	D0408
Material	HSSE V3	HSSE V3
Surface Finish	Blu	TICN
Colour Ring & Application	VA	VA
Geometry	R45°	R45°
Chamfer	Form C / 2.5 x P	Form C / 2.5 x P
Limit & Nut Tolerance	2B	2B

Item #	Item #
T276 1111	T277 1111
T276 1270	T277 1270
•	•
T276 1588	T277 1588
T276 1905	T277 1905
T276 2223	T277 2223
T276 2540	T277 2540

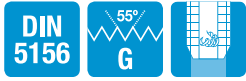
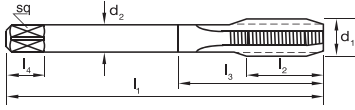
UNF

• Available on request as special manufacture. Subject to lead time.

DIN Taps G (BSPF), Straight Flute, N



- General Purpose use in materials up to approx. 1000 N/mm²
- Through & blind holes
- Suitable machine operations
- Depths up to approx. 1 x d₁



Catalogue Code Size Ref.



Catalogue Code	T304	T305
Discount Group	D0402	D0406
Material	HSSE V3	HSSE V3
Surface Finish	Brt	TIN
Colour Ring & Application	N	N
Geometry		
Chamfer	Form C / 2.5 x P	Form C / 2.5 x P
Limit & Nut Tolerance	ISO 228	ISO 228

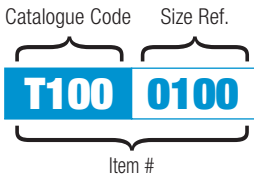
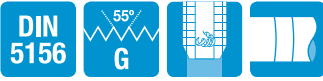
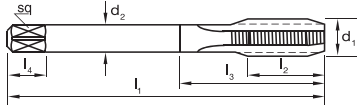
Size Ref.	d ₁	TPI	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #
0973	G 1/8	28	90	20	-	7.0	5.5	8	4	8.8	T304 0973	T305 0973
1316	G 1/4	19	100	22	-	11.0	9.0	12	4	11.8	T304 1316	T305 1316
1666	G 3/8	19	100	22	-	12.0	9.0	12	4	15.3	T304 1666	T305 1666
2096	G 1/2	14	125	25	-	16.0	12.0	15	4	19.0	T304 2096	T305 2096
2291	G 5/8	14	125	25	-	18.0	14.5	17	4	21.0	T304 2291	T305 2291
2644	G 3/4	14	140	28	-	20.0	16.0	19	4	24.5	T304 2644	T305 2644
3020	G 7/8	14	150	28	-	22.0	18.0	21	4	28.5	T304 3020	T305 3020
3325	G 1	11	160	30	-	25.0	20.0	23	4	31.0	T304 3325	T305 3325
3790	G 1-1/8	11	170	30	-	28.0	22.0	25	4	35.5	T304 3790	•
4191	G 1-1/4	11	170	30	-	32.0	24.0	27	6	39.5	T304 4191	•
4432	G 1-3/8	11	180	32	-	36.0	29.0	32	6	42.0	•	•
4780	G 1-1/2	11	190	32	-	36.0	29.0	32	6	45.5	T304 4780	•
5375	G 1-3/4	11	190	32	-	40.0	32.0	35	6	51.0	•	•
5961	G 2	11	220	40	-	45.0	35.0	38	6	57.0	•	•

• Available on request as special manufacture. Subject to lead time.

DIN Taps G (BSPF), Straight Flute, GG



- Use in grey cast iron (GG), brittle plastics, hard bronzes to a hardness of 850 N/mm²
- Through & blind holes
- Suitable machine operations
- Depths up to approx. 1 x d₁



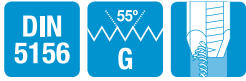
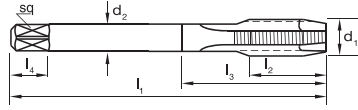
Catalogue Code	T307
Discount Group	D0408
Material	HSSE V3
Surface Finish	TICN
Colour Ring & Application	GG
Geometry	Low Relief
Chamfer	Form C / 2.5 x P
Limit & Nut Tolerance	ISO 228

Size Ref.	d ₁	TPI	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #
0973	G 1/8	28	90	20	-	7.0	5.5	8	4	8.8	T307 0973
1316	G 1/4	19	100	22	-	11.0	9.0	12	4	11.8	T307 1316
1666	G 3/8	19	100	22	-	12.0	9.0	12	5	15.3	T307 1666
2096	G 1/2	14	125	25	-	16.0	12.0	15	5	19.0	T307 2096
2291	G 5/8	14	125	25	-	18.0	14.5	17	5	21.0	T307 2291
2644	G 3/4	14	140	28	-	20.0	16.0	19	6	24.5	T307 2644
3020	G 7/8	14	150	28	-	22.0	18.0	21	6	28.5	T307 3020
3325	G 1	11	160	30	-	25.0	20.0	23	6	31.0	T307 3325

DIN Taps G (BSPF), Gun, N



- General Purpose use in materials up to approx. 1000 N/mm²
- Through holes
- Suitable machine operations
- Depths up to approx. 3 x d₁



Catalogue Code Size Ref.



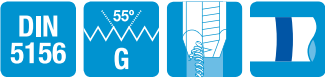
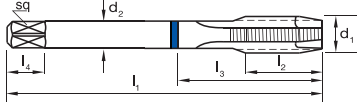
Size Ref.	d ₁	TPI	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	<table border="1"> <thead> <tr> <th>Catalogue Code</th> <th>T178</th> <th>T179</th> <th>T180</th> </tr> </thead> <tbody> <tr> <td>Discount Group</td> <td>D0402</td> <td>D0402</td> <td>D0406</td> </tr> <tr> <td>Material</td> <td>HSSE V3</td> <td>HSSE V3</td> <td>HSSE V3</td> </tr> <tr> <td>Surface Finish</td> <td><i>Br</i>t</td> <td><i>Bl</i>u</td> <td><i>T</i>IN</td> </tr> <tr> <td>Colour Ring & Application</td> <td>N</td> <td>N</td> <td>N</td> </tr> <tr> <td>Geometry</td> <td></td> <td></td> <td></td> </tr> <tr> <td>Chamfer</td> <td>Form B / 4.5 x P</td> <td>Form B / 4.5 x P</td> <td>Form B / 4.5 x P</td> </tr> <tr> <td>Limit & Nut Tolerance</td> <td>ISO 228</td> <td>ISO 228</td> <td>ISO 228</td> </tr> </tbody> </table>			Catalogue Code	T178	T179	T180	Discount Group	D0402	D0402	D0406	Material	HSSE V3	HSSE V3	HSSE V3	Surface Finish	<i>Br</i> t	<i>Bl</i> u	<i>T</i> IN	Colour Ring & Application	N	N	N	Geometry				Chamfer	Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P	Limit & Nut Tolerance	ISO 228	ISO 228	ISO 228
											Catalogue Code	T178	T179	T180																															
Discount Group	D0402	D0402	D0406																																										
Material	HSSE V3	HSSE V3	HSSE V3																																										
Surface Finish	<i>Br</i> t	<i>Bl</i> u	<i>T</i> IN																																										
Colour Ring & Application	N	N	N																																										
Geometry																																													
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P																																										
Limit & Nut Tolerance	ISO 228	ISO 228	ISO 228																																										
Item #	Item #	Item #																																											
0973	G 1/8 28 90 20 - 7.0 5.5 8 3 8.8	T178 0973	T179 0973	T180 0973																																									
1316	G 1/4 19 100 22 - 11.0 9.0 12 3 11.8	T178 1316	T179 1316	T180 1316																																									
1666	G 3/8 19 100 22 - 12.0 9.0 12 3 15.3	T178 1666	T179 1666	T180 1666																																									
2096	G 1/2 14 125 25 - 16.0 12.0 15 3 19.0	T178 2096	T179 2096	T180 2096																																									
2291	G 5/8 14 125 25 - 18.0 14.5 17 4 21.0	T178 2291	T179 2291	T180 2291																																									
2644	G 3/4 14 140 28 - 20.0 16.0 19 4 24.5	T178 2644	T179 2644	T180 2644																																									
3020	G 7/8 14 150 28 - 22.0 18.0 21 4 28.5	T178 3020	T179 3020	T180 3020																																									
3325	G 1 11 160 30 - 25.0 20.0 23 4 31.0	T178 3325	T179 3325	T180 3325																																									



DIN Taps G (BSPF), Gun, VA



- Use in stainless steels and high strength steels up to 1000N/mm²
- Through holes
- Suitable machine operations
- Depths up to approx. 3 x d₁



Catalogue Code Size Ref.

T100 0100

Item #

Size Ref.	d ₁	TPI	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
0973	G 1/8	28	90	20	-	7.0	5.5	8	3	8.8
1316	G 1/4	19	100	22	-	11.0	9.0	12	3	11.8
1666	G 3/8	19	100	22	-	12.0	9.0	12	3	15.3
2096	G 1/2	14	125	25	-	16.0	12.0	15	3	19.0
2291	G 5/8	14	125	25	-	18.0	14.5	17	4	21.0
2644	G 3/4	14	140	28	-	20.0	16.0	19	4	24.5
3020	G 7/8	14	150	28	-	22.0	18.0	21	4	28.5
3325	G 1	11	160	30	-	25.0	20.0	23	4	31.0



Catalogue Code	T181	T182
Discount Group	D0402	D0408
Material	HSSE V3	HSSE V3
Surface Finish	Blu	TICN
Colour Ring & Application	VA	VA
Geometry	Special Relief	Special Relief
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P
Limit & Nut Tolerance	ISO 228	ISO 228

Item #	Item #
T181 0973	T182 0973
T181 1316	T182 1316
T181 1666	T182 1666
T181 2096	T182 2096
T181 2291	T182 2291
T181 2644	T182 2644
T181 3020	T182 3020
T181 3325	T182 3325

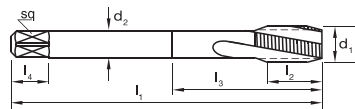


DIN Taps G (BSPF), Spiral Flute, R15N



Sutton Tools

- General purpose use, materials up to approx. 1000 N/mm²
- Blind holes
- Suitable for machine operations
- Depths up to approx. 1.5 x d₁



Catalogue Code Size Ref.

T100 **0100**

Item #

Size Ref.	d ₁	TPI	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
0973	G 1/8	28	90	20	-	7.0	5.5	8	3	8.8
1316	G 1/4	19	100	22	-	11.0	9.0	12	3	11.8
1666	G 3/8	19	100	22	-	12.0	9.0	12	3	15.3
2096	G 1/2	14	125	25	-	16.0	12.0	15	4	19.0
2291	G 5/8	14	125	25	-	18.0	14.5	17	4	21.0
2644	G 3/4	14	140	28	-	20.0	16.0	19	4	24.5
3020	G 7/8	14	150	28	-	22.0	18.0	21	4	28.5
3325	G 1	11	160	30	-	25.0	20.0	23	4	31.0



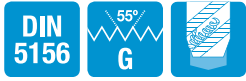
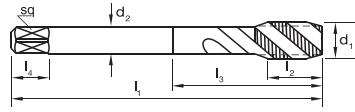
- Catalogue Code
- Discount Group
- Material
- Surface Finish
- Colour Ring & Application
- Geometry
- Chamfer
- Limit & Nut Tolerance

	T278	T279
Catalogue Code	D0402	D0406
Discount Group		
Material	HSSE V3	HSSE V3
Surface Finish	BrT	TiN
Colour Ring & Application	N	N
Geometry	R15°	R15°
Chamfer	Form C / 2.5 x P	Form C / 2.5 x P
Limit & Nut Tolerance	ISO 228	ISO 228
Item #		

DIN Taps G (BSPF), Spiral Flute, R40 N



- General purpose use, materials up to approx. 1000 N/mm²
- Blind holes
- Suitable for machine operations
- Depths up to approx. 2.5 x d₁



Catalogue Code Size Ref.



Catalogue Code	T281	T282	T283
Discount Group	D0402	D0402	D0406
Material	HSSE V3	HSSE V3	HSSE V3
Surface Finish	Brt	Blu	TIN
Colour Ring & Application	N	N	N
Geometry	R40°	R40°	R40°
Chamfer	Form C / 2.5 x P	Form C / 2.5 x P	Form C / 2.5 x P
Limit & Nut Tolerance	ISO 228	ISO 228	ISO 228

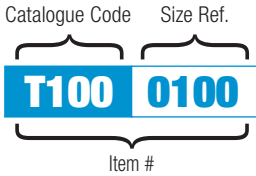
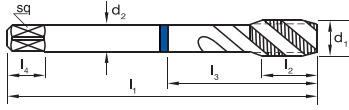
Size Ref.	d ₁	TPI	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #	Item #
0973	G 1/8	28	90	20	-	7.0	5.5	8	3	8.8	T281 0973	T282 0973	T283 0973
1316	G 1/4	19	100	22	-	11.0	9.0	12	3	11.8	T281 1316	T282 1316	T283 1316
1666	G 3/8	19	100	22	-	12.0	9.0	12	3	15.3	T281 1666	T282 1666	T283 1666
2096	G 1/2	14	125	25	-	16.0	12.0	15	4	19.0	T281 2096	T282 2096	T283 2096
2291	G 5/8	14	125	25	-	18.0	14.5	17	4	21.0	T281 2291	T282 2291	T283 2291
2644	G 3/4	14	140	28	-	20.0	16.0	19	4	24.5	T281 2644	T282 2644	T283 2644
3020	G 7/8	14	150	28	-	22.0	18.0	21	4	28.5	T281 3020	T282 3020	T283 3020
3325	G 1	11	160	30	-	25.0	20.0	23	4	31.0	T281 3325	T282 3325	T283 3325
3790	G 1-1/8	11	170	30	-	28.0	22.0	25	4	35.5	•	•	•
4191	G 1-1/4	11	170	30	-	32.0	24.0	27	6	39.5	•	•	•
4432	G 1-3/8	11	180	32	-	36.0	29.0	32	6	42.0	•	•	•
4780	G 1-1/2	11	190	32	-	36.0	29.0	32	6	45.5	•	•	•

• Available on request as special manufacture. Subject to lead time.

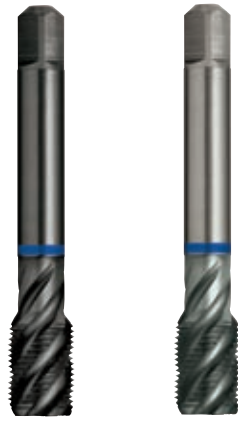
DIN Taps G (BSPF), Spiral Flute, R45 VA



- Use in stainless steels and high strength steels up to 1000N/mm²
- Blind holes
- Suitable for synchronous tapping in machine operations
- Depths up to approx. 3 x d₁



Size Ref.	d ₁	TPI	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
0973	G 1/8	28	90	20	-	7.0	5.5	8	4	8.8
1316	G 1/4	19	100	22	-	11.0	9.0	12	4	11.8
1666	G 3/8	19	100	22	-	12.0	9.0	12	5	15.3
2096	G 1/2	14	125	25	-	16.0	12.0	15	5	19.0
2291	G 5/8	14	125	25	-	18.0	14.5	17	5	21.0
2644	G 3/4	14	140	28	-	20.0	16.0	19	5	24.5
3020	G 7/8	14	150	28	-	22.0	18.0	21	5	28.5
3325	G 1	11	160	30	-	25.0	20.0	23	5	31.0



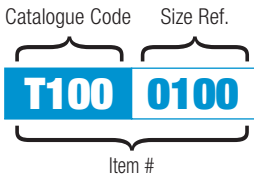
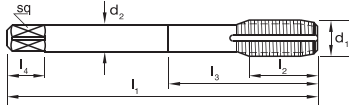
Catalogue Code	T284	T285
Discount Group	D0402	D0408
Material	HSSE V3	HSSE V3
Surface Finish	Blu	TICN
Colour Ring & Application	VA	VA
Geometry	R45°	R45°
Chamfer	Form C / 2.5 x P	Form C / 2.5 x P
Limit & Nut Tolerance	ISO 228	ISO 228

Item #	Item #
T284 0973	T285 0973
T284 1316	T285 1316
T284 1666	T285 1666
T284 2096	T285 2096
T284 2291	T285 2291
T284 2644	T285 2644
T284 3020	T285 3020
T284 3325	T285 3325

DIN Taps G (BSPF), Forming, Multi Coolant Groove



- For cold forming of threads in materials with good flow characteristics
- Brt - For non-ferrous materials. TiN - For steel materials up to 1000 N/mm²
- TiCN - Suitable for abrasive and difficult materials
- Through or blind holes
- Suitable for machine operations
- Depths up to approx. 3 x d₁



Size Ref.	d ₁	TPI	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
0973	G 1/8	28	90	20	-	7.0	5.5	8	9.25	
1316	G 1/4	19	100	22	-	11.0	9.0	12	12.5	
1666	G 3/8	19	100	22	-	12.0	9.0	12	16.0	
2096	G 1/2	14	125	25	-	16.0	12.0	15	20.0	
2291	G 5/8	14	125	25	-	18.0	14.5	17	22.0	
2644	G 3/4	14	140	28	-	20.0	16.0	19	25.5	
3020	G 7/8	14	150	28	-	22.0	18.0	21	29.25	
3325	G 1	11	160	30	-	25.0	20.0	23	32.0	




Catalogue Code	T361	T363
Discount Group	D0402	D0408
Material	HSSE V3	HSSE V3
Surface Finish	Brt	TiCN
Colour Ring & Application	N	N
Geometry	Multi Groove	Multi Groove
Chamfer	Form C / 2.5 x P	Form C / 2.5 x P
Limit & Nut Tolerance	ISO 228 X	ISO 228 X

Item #	Item #
T361 0973	T363 0973
T361 1316	T363 1316
T361 1666	T363 1666
T361 2096	T363 2096
T361 2291	T363 2291
T361 2644	T363 2644
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•	•

Performance Unequaled...

HARMONY



The Harmony range of endmills represents world's latest technologies to provide increases in both performance and tool life. The key to successful milling is to minimize or eliminate the vibration produced in the cutting action.

This is known as a buildup of harmonics in the work piece, which can be detrimental to the tool life of the endmill.

Often this vibration has been rectified by slowing down the cutting speed and feeds, altering the size of the cut & increasing the rigidity of the set-up.

The Harmony Endmill overcomes vibration, through a combination of tool design, micro geometry, material & coating, without the need to sacrifice productivity.



35-38° unequal flute helix, reduces the harmonic build up in the workpiece, resulting in smooth chatter-free milling in various types of milling techniques, increasing your productivity.



45° Corner chamfering provides added strength to the endmills particularly in semi-roughing & roughing type milling applications.



The gash grind of the endteeth blends to the outer corner of the 45° chamfer, strengthening the design in this area.



Post grind treatment of cutting edges, engineered specifically for the relevant material application.



Carbide endmills with neck reduction for extra cutting reach.