Precision is in the details.
Since 1889.

THREADING TOOLS
Gustav Stursberg

GSR Threading Tools
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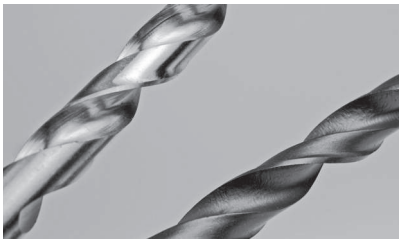

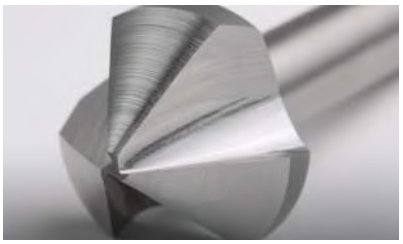

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- COUNTERSINKING
- MEASURING

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OVERVIEW OF ABBREVIATIONS

ISO THREAD TYPES

Thread angle 60°

M	Metric ISO-Thread
MF	Metric ISO-Fine Thread
TR	Metric ISO-Trapezoidal Thread
PG	Armoured Conduit Pipe
RD	Round Thread

AMERICAN THREAD TYPES IN INCHES

Thread angle 60°

UNC	Unified National Coarse
UNF	Unified National Fine
UNEF	Unified National Extra Fine
UN-8	Unified Constant Pitch, 8-Pitch Series
UN-12	Unified Constant Pitch, 12-Pitch Series
UN-16	Unified Constant Pitch, 16-Pitch Series
UNS	Unified Special
NPT	National Pipe Taper 1:16
NPTF	National Pipe Taper Fuel Dryseal 1:16
NPS	National Pipe Straight

BRITISH THREAD TYPES IN INCHES

Thread angle 55°

BSW	British Standard Whitworth
BSF	British Standard Fine
BSP	British Standard Pipe
BSPT	British Standard Pipe Taper
BA	British Association Screw Threads

SYMBOL	DESCRIPTION
	Thread pitch
	Threads per inch
	Tap hole bore
	Square shank size
	Round die diameter
	Hexagon die nut diameter
	Round die height
	Bolt diameter
	Total length
	Working length
	Nominal size
	Shank diameter
	Through hole
	Blind hole
	Countersink
	Counterbore

LEGEND

FASTER TOWARDS THE TARGET

For a targeted search for a specific product, you can find the corresponding page in the following summary table.

HAND TAPS

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HSS	p. 22	p. 30	p. 42	p. 40	p. 47	p. 48	p. 52	p. 54	p. 56	p. 57	p. 58	p. 59
HSS LH	p. 25	p. 37	p. 44	p. 46		p. 50						
HSS ISO			p. 43			p. 49	p. 53	p. 55				
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	M	MF	BSW	BSP	BSF	UNC	UNF	UNEF	UN/UNS	PG	NPT	TR
HSSE	p. 23	p. 34		p. 41								p. 60
HSSE LH												p. 61
HSSE FZ	p. 24											
HSSE FZ VAP	p. 25											

SHORT MACHINE TAPS

	M	MF	BSW	BSP	BSF	UNC	UNF	PG	NPT	NPTF	NPS	TR
HSS Form A	p. 64											
HSS Form A Bits	p. 83											
HSS Form B	p. 64		p. 74									
HSS Form C	p. 66	p. 70	p. 75	p. 76	p. 78	p. 78	p. 79	p. 80	p. 81	p. 82		
HSS Form C LH				p. 77					p. 81			
HSS Form D						p. 79	p. 80					
HSS Form RSP 35°	p. 67											

	M	MF	BSW	BSP	BSF	UNC	UNF	PG	NPT	NPTF	NPS	TR
HSSE Form B	p. 68											
HSSE Form B a.Z.	p. 69											
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HSSE LH		p. 89

MACHINE TAPS

	M	MF	BSW	BSP	UNC	UNF	UNEF	UN/UNS	PG	RD
HSS Form A	p. 96									
HSS Form B	p. 100	p. 126								
HSS Form C	p. 108	p. 129								
HSS Form D										
HSS Form 15° RSP	p. 114	p. 133								
HSS Form B a.Z.										
HSS Form 35° RSP	p. 118	p. 135								

	M	MF	BSW	BSP	UNC	UNF	UNEF	UN/UNS	PG	RD
HSSE Form A	p. 98	p. 138								
HSSE Form B	p. 102	p. 142	p. 163	p. 166	p. 171	p. 176	p. 181	p. 183		
HSSE Form B LH	p. 187									
HSSE Form B VAP	p. 104	p. 146			p. 172	p. 177				
HSSE Form B a.Z.	p. 106									
HSSE Form B TIN	p. 107									
HSSE Form C	p. 110	p. 157	p. 165	p. 169	p. 175	p. 180		p. 185	p. 186	p. 187
HSSE Form C LH	p. 189	p. 190		p. 197						
HSSE Form C VAP	p. 112	p. 161		p. 170						
HSSE Form C TIN	p. 113									
HSSE Form 15° RSP	p. 116	p. 148								
HSSE Form 35° RSP	p. 120	p. 151	p. 164	p. 167	p. 173	p. 178	p. 182	p. 184		
HSSE Form 35° LSP LH		p. 194								
HSSE Form 35° VAP	p. 122	p. 155		p. 168	p. 174	p. 179				
HSSE Form 35° TIN	p. 123									
HSSE Form 45 ° RSP	p. 124									

ROUND DIES

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HSS LH	p. 227	p. 233	p. 236	p. 237		p. 240	p. 241	
HSSE	p. 228			p. 238				
HSSE VAP	p. 229							
ALU die guides	p. 249							
Combined	p. 251							

	UN/UNS	PG	NPT	NPTF	NPS	TR	RD	VG
HSS	p. 243	p. 244	p. 244	p. 245	p. 245	p. 246	p. 247	p. 248
HSS LH						p. 247		
HSSE								
HSSE VAP								
ALU die guides								
Combined								

HEXAGON DIE NUTS

	M	MF	BSW	BSP	BSPT	BSF	UNC	UNF	NPT
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HSS LH	p. 255	p. 259		p. 262					

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Morse taper drills DIN 345	p. 354
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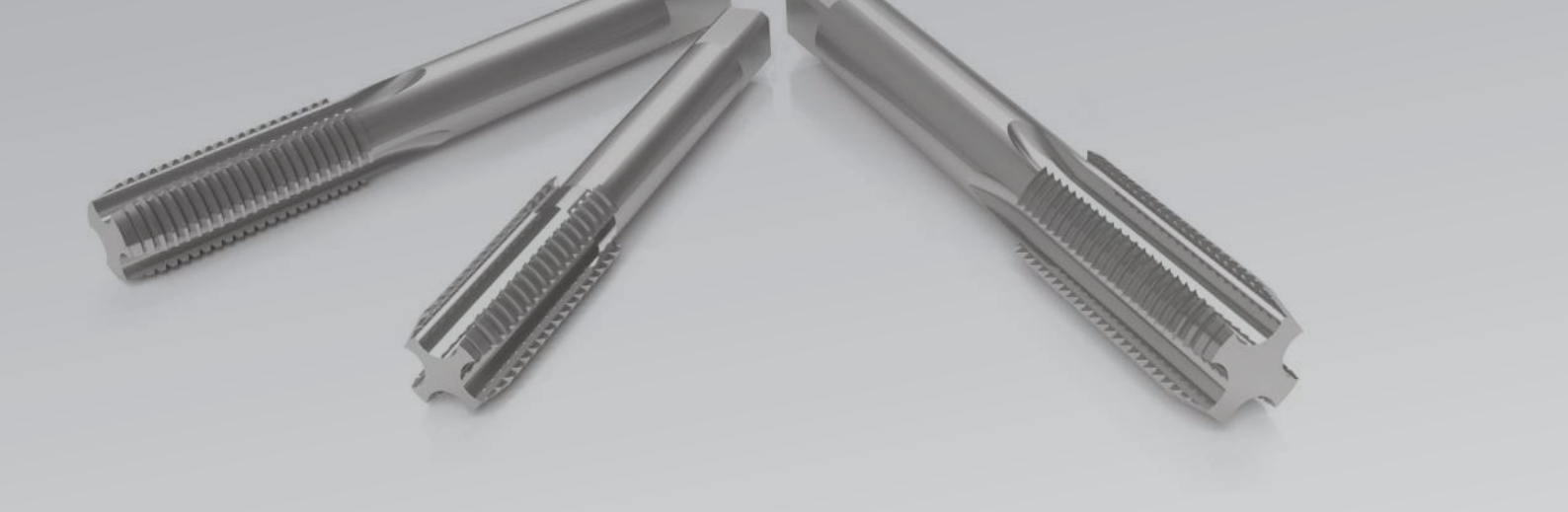
Drills for Spotle / Vario	p. 365
Subland drills DIN 8374	p. 365
Twist drill bits	p. 367

GSR-GLOBAL

With own sales branches in Turkey and Russia as well as production facilities in Germany and China, the GSR Group is globally active. The production programme comprises threading tools, vices, and special tools for electronics (Bernstein tool factory). The latest member of the GSR Group is Kommit5, a specialised service provider for all areas of digital transformation.



TÜV PROFI CERT

ZERTIFIKAT

für das Managementsystem nach

DIN EN ISO 9001:2015

Der Nachweis der regelkonformen Anwendung wurde erbracht
und wird gemäß TÜV PROFICERT-Verfahren bescheinigt für

GSR

Gustav Stursberg GmbH
Schmiedestraße 4
D-42899 Remscheid

Geltungsbereich:

Konfektionierung, Veredelung, Handel und
Vertrieb von Gewindeschneidwerkzeugen

Zertifikat-Registrier-Nr. **73 100 5677**	Zertifikat gültig von 2017-10-27 bis **2020-10-26**
Auditbericht-Nr. 4328 1261	Erstzertifizierung 2014-10-27

DAKKS Deutsche Akkreditierungsstelle D-ZM-14137-01-00

Datum/ort: 2017-10-26
Zertifizierungsstelle der TÜV Nissen
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TÜV PROFI CERT

ZERTIFIKAT

für das Managementsystem nach

DIN EN ISO 14001:2015

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Системы менеджмента согласно

ЕН ИСО 14001:2015

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процедурой TÜV PROFICERT для

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Системы менеджмента согласно

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Представлены свидетельства реализации в соответствии с требованиями, что подтверждено
процедурой TÜV PROFICERT для

GSR

Gustav Stursberg GmbH
Schmiedestraße 4
42899 Remscheid / Германия

Область действия:

Монтаж, обработка, торговля и дистрибуция
резьбонарезного инструмента

Регистрационный номер сертификата **73 100 5677**	Сертификат действует с 2017-10-27 по **2020-10-26**
№ отчета по аудиту 4328 1261	Первоначальная сертификация 2014-10-27

DAKKS Deutsche Akkreditierungsstelle D-ZM-14137-01-00

г.Ремсчейд, 2017-10-26
Сертификационный орган TÜV Nissen
Руководитель Органа по сертификации

СТРАНИЦА 1 ИЗ 1

Данная сертификация была выполнена в соответствии с процедурами проведения аудита и сертификации TÜV PROFICERT, и подлежит периодическому
надзорному аудиту. Авторитетно по надзорным проверкам на шайе основы было сообщено. Организация сертификации содержит изменения в силу разных.
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Yönetim Sistemi

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belirtilen standarda göre aşağıdaki kapsamda bir yönetim sistemi uyguladuğ belgelenmektedir.

TÜV PROFI CERT

SERTİFİKA

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TÜV PROFICERT prosedürleri uyarınca, işbu sertifika ile ürünün kurulusun,
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GSR

Gustav Stursberg GmbH
Schmiedestraße 4
42899 Remscheid / Almanya

Kapsam:

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Sertifika Kayıt No. **73 104 1234**	Sertifika 2017-10-27 kadar **2020-10-26** itibaren geçerlidir
Tetkik Raporu No. 4328 1261	İlk Belgelendirme 2014-10-27

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Datum/yer: 2017-10-26
Belgelendirme Kurulusu TÜV Nissen
Belgelendirme Müdürü

SAYFA 1

Bu belgelendirme ve TÜV PROFICERT prosedürü gerçekleştirilmiştir ve düzenli olarak izlenir.
Hususlar ve sapmalar da TÜV PROFICERT prosedürünün bir uygunluk kontrolünü yapar.
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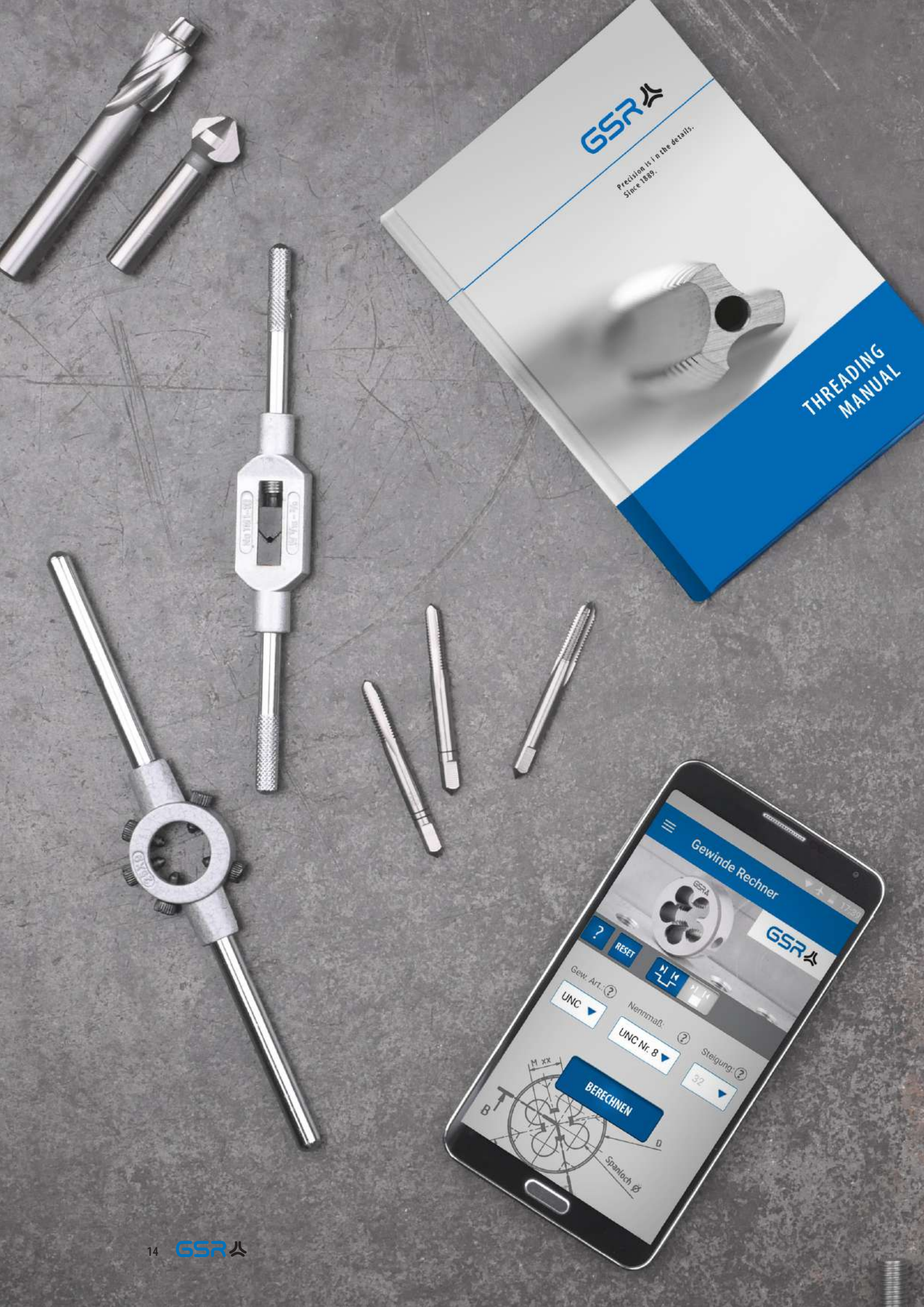
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Since 1889.
THREADING MANUAL
Gewinde Rechner
RESET
Gew. Art.:
UNC
Nennmaß:
UNC Nr. 8
Steigung:
32
BERECHNEN
Spanloch Ø

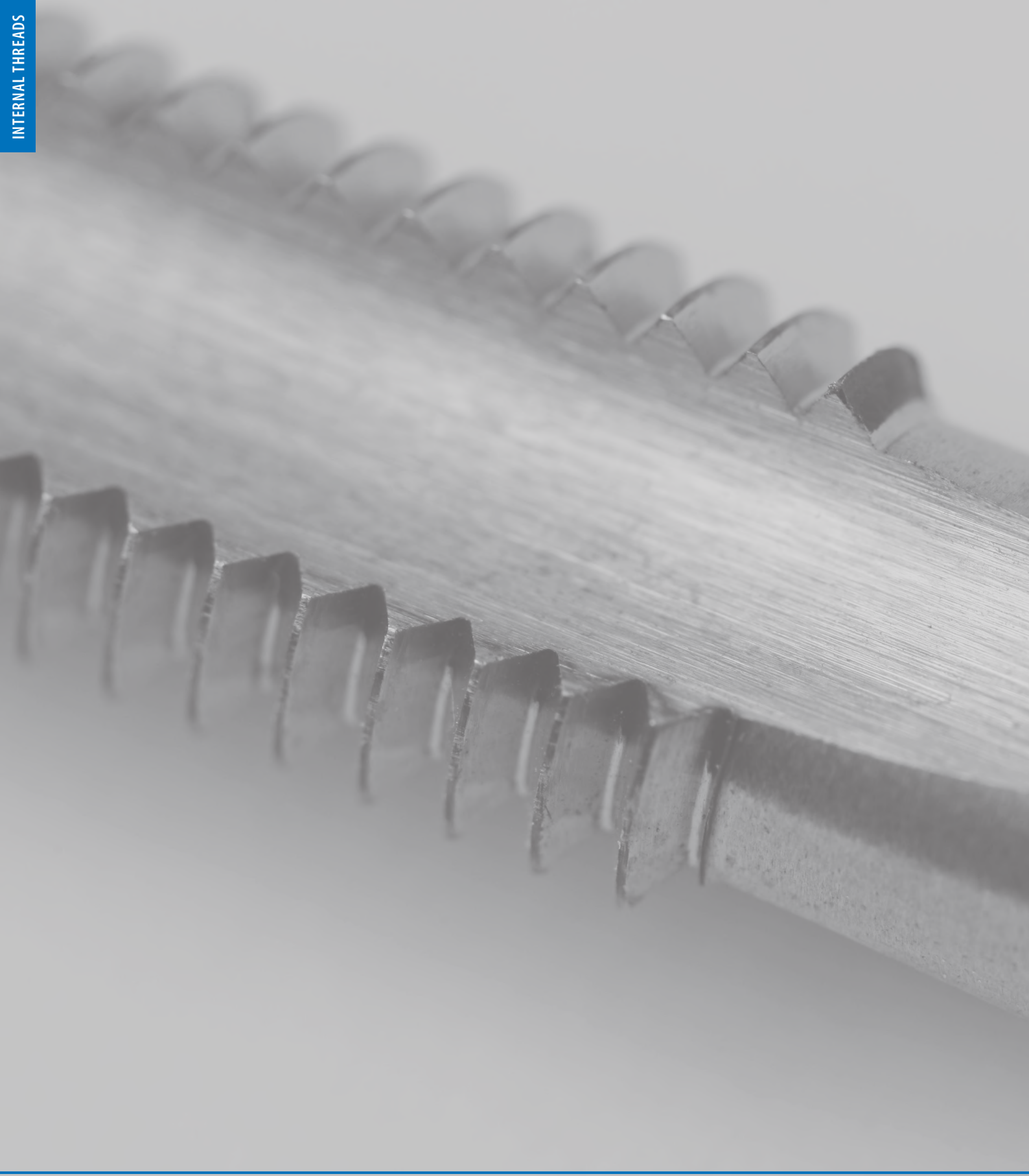
GSR-DIGITAL

With our web-based software systems in the cloud, we are looking towards the future through a digital transformation of corporate processes. All our business processes are conducted digitally.
By installing an audit-proof document management, the last step for a paperless office was taken. From now on, we will continue paperless – efficient and environmentally friendly! We can provide all relevant product data for your database systems digitally, including permanent updates.

GSR ONLINE

Our online activities are all about the benefit for our customers. Our blog continuously provides information on topics related to threading; the GSR YouTube channel demonstrates, in short video clips, how to use our products properly; our thread calculator app offers useful data for threading; and in case one still has questions, we also offer the possibility to contact us via our social media channels.

THREADING



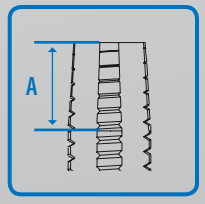
CUTTING OF INTERNAL THREADS

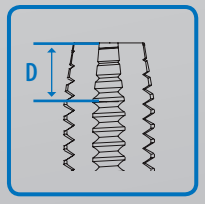
The tap hole is drilled with a tap hole twist drill. Choose the drill diameter according to the table. Important: while making a blind hole, the length of the tap chamfer has to be added to the desired depth of the tap hole. Furthermore, we recommend to countersink the tap hole. Mount the tap into the adjustable tap wrench or, for smaller sizes, into a tool holder. Make sure that the screw thread of the adjustable tap wrench is tightened firmly. Position the tap perpendicular to the hole. With the help of the tap wrench, now twist the tap clockwise under slight pressure into the drilling. After each half turn, the chip has to be broken by twisting back the tap.

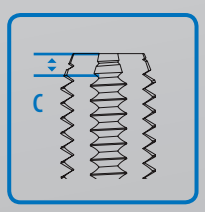
INTERNAL THREADS

SQUARE SHANK ACCORDING TO DIN 10

for mounting the tap
into the adjustable
tap wrench (ATW).







TAPER

Marked with one ring,
long chamfer,
Form A / 6 - 8 threads

PLUG

Marked with two rings,
medium chamfer,
Form D / 3, 5 - 5 threads

BOTTOMING

no marking,
short chamfer,
Form C / 2 - 3 threads

TAPS
DIN 352 · 3S · M4 · 6H · HSS

	Description
DIN 352 =	German Institute for Standardisation
3S =	3-pcs. set
M4 =	Size in mm for ISO metric coarse threads according to DIN 13
6H =	Tolerance class according to DIN 802, part 1
HSS =	High-speed steel

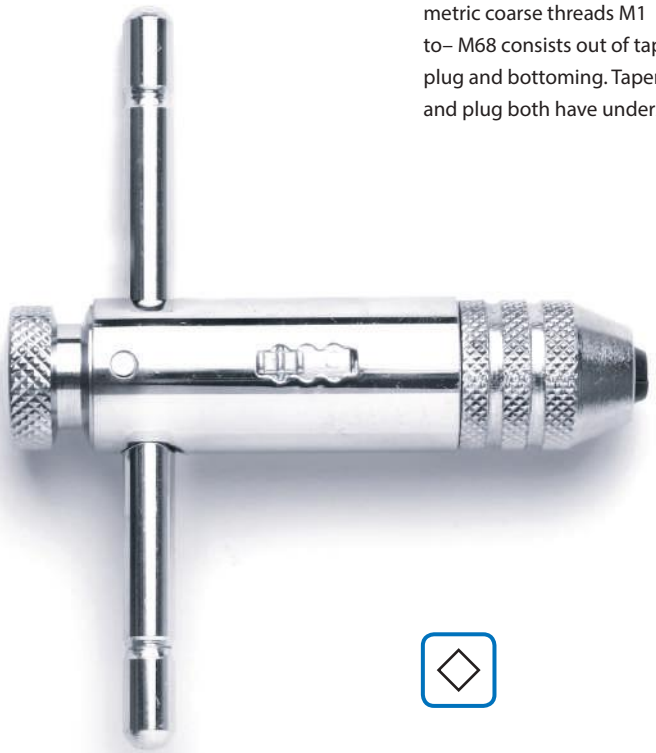
Labelling according to DIN 2791
M4 6H HSS

HAND TAPS

DIN 352

The three-piece set for ISO metric coarse threads M1 to– M68 consists out of taper, plug and bottoming. Taper and plug both have undersize.

The sizes up to M7 have a reinforced shank and three flutes. Sizes from M7 to M68 have a reinforced shank and four flutes.



SQUARE SHANK ACCORDING TO DIN 10

for mounting the tap into the tool holder (TH).

HAND TAPS DIN 352

HAND TAPS

TECHNICAL INFORMATION

Standard	DIN 352	Hole type	Through/blind hole
Thread	M	Direction	Right
Material	HSS-G	Tolerance	ISO2 / 6H
Raw material	Steel		

						◇	Set	No. 1	No. 2	No. 3
M 1	0,25	0,75	32	5,5	2,5	2,1	00105010	00104011	00104012	00104013
M 1,1	0,25	0,85	32	5,5	2,5	2,1	00105020	00104021	00104022	00104023
M 1,2	0,25	0,95	32	5,5	2,5	2,1	00105030	00104031	00104032	00104033
M 1,4	0,3	1,1	32	7	2,5	2,1	00105040	00104041	00104042	00104043
M 1,6	0,35	1,25	32	8	2,5	2,1	00105050	00104051	00104052	00104053
M 1,7	0,35	1,3	32	8	2,5	2,1	00105060	00104061	00104062	00104063
M 1,8	0,35	1,45	32	8	2,5	2,1	00105070	00104071	00104072	00104073
M 2	0,4	1,6	36	8	2,8	2,1	00105080	00104081	00104082	00104083
M 2,2	0,45	1,75	36	9	2,8	2,1	00105090	00104091	00104092	00104093
M 2,3	0,4	1,9	36	9	2,8	2,1	00105100	00104101	00104102	00104103
M 2,5	0,45	2,05	40	9	2,8	2,1	00105110	00104111	00104112	00104113
M 2,6	0,45	2,1	40	9	2,8	2,1	00105120	00104121	00104122	00104123
M 3	0,5	2,5	40	11	3,5	2,7	00105130	00104131	00104132	00104133
M 3,5	0,6	2,9	45	13	4	3	00105140	00104141	00104142	00104143
M 4	0,7	3,3	45	13	4,5	3,4	00105150	00104151	00104152	00104153
M 4,5	0,75	3,7	50	16	6	4,9	00105160	00104161	00104162	00104163
M 5	0,8	4,2	50	16	6	4,9	00105170	00104171	00104172	00104173
M 6	1,0	5,0	56	19	6	4,9	00105190	00104191	00104192	00104193
M 7	1,0	6,0	56	19	6	4,9	00105200	00104201	00104202	00104203
M 8	1,25	6,8	63	22	6	4,9	00105210	00104211	00104212	00104213
M 9	1,25	7,8	63	22	7	5,5	00105220	00104221	00104222	00104223
M 10	1,5	8,5	70	24	7	5,5	00105230	00104231	00104232	00104233
M 11	1,5	9,5	70	24	8	6,2	00105240	00104241	00104242	00104243
M 12	1,75	10,2	75	28	9	7	00105250	00104251	00104252	00104253
M 14	2,0	12,0	80	30	11	9	00105260	00104261	00104262	00104263
M 16	2,0	14,0	80	32	12	9	00105270	00104271	00104272	00104273
M 18	2,5	15,5	95	34	14	11	00105280	00104281	00104282	00104283
M 20	2,5	17,5	95	34	16	12	00105290	00104291	00104292	00104293
M 22	2,5	19,5	100	34	18	14,5	00105300	00104301	00104302	00104303
M 24	3,0	21,0	110	38	18	14,5	00105310	00104311	00104312	00104313
M 27	3,0	24,0	110	38	20	16	00105320	00104321	00104322	00104323
M 30	3,5	26,5	125	45	22	18	00105330	00104331	00104332	00104333

						◇	Set	No. 1	No. 2	No. 3
M 33	3,5	29,5	125	50	25	20	00105340	00104341	00104342	00104343
M 36	4,0	32,0	150	56	28	22	00105350	00104351	00104352	00104353
M 39	4,0	35,0	150	60	32	24	00105360	00104361	00104362	00104363
M 42	4,5	37,5	150	60	32	24	00105370	00104371	00104372	00104373
M 45	4,5	40,5	160	65	36	29	00105380	00104381	00104382	00104383
M 48	5,0	43,0	180	70	36	29	00105390	00104391	00104392	00104393
M 52	5,0	47,0	180	70	40	32	00105400	00104401	00104402	00104403
M 56	5,5	50,5	180	70	40	32	00105410	00104411	00104412	00104413
M 60	5,5	54,5	200	75	45	35	00105420	00104421	00104422	00104423
M 64	6,0	58,0	220	80	50	39	00105430	00104431	00104432	00104433

HAND TAPS

TECHNICAL INFORMATION

Standard	DIN 352	Hole type	Through/blind hole
Thread	M	Direction	Right
Material	HSSE-G	Tolerance	ISO2 / 6H
Raw material	Stainless steel		

						◇	Set	No. 1	No. 2	No. 3
M 3	0,5	2,5	40	12	3,5	2,7	00107130	00106131	00106132	00106133
M 4	0,7	3,3	45	14	4,5	3,4	00107150	00106151	00106152	00106153
M 5	0,8	4,2	50	16	6	4,9	00107170	00106171	00106172	00106173
M 6	1,0	5,0	56	19	6	4,9	00107190	00106191	00106192	00106193
M 8	1,25	6,8	63	22	6	4,9	00107210	00106211	00106212	00106213
M 10	1,5	8,5	70	25	7	5,5	00107230	00106231	00106232	00106233
M 12	1,75	10,2	75	28	9	7	00107250	00106251	00106252	00106253
M 14	2,0	12,0	80	32	11	9	00107260	00106261	00106262	00106263
M 16	2,0	14,0	80	32	12	9	00107270	00106271	00106272	00106273
M 18	2,5	15,5	95	34	14	11	00107280	00106281	00106282	00106283
M 20	2,5	17,5	95	34	16	12	00107290	00106291	00106292	00106293
M 22	2,5	19,5	100	34	18	14,5	00107300	00106301	00106302	00106303
M 24	3,0	21,0	110	38	18	14,5	00107310	00106311	00106312	00106313
M 27	3,0	24,0	110	38	20	16	00107320	00106321	00106322	00106323
M 30	3,5	26,5	125	45	22	18	00107330	00106331	00106332	00106333
M 33	3,5	29,5	125	50	25	20	00107340	00106341	00106342	00106343
M 36	4,0	32,0	150	56	28	22	00107350	00106351	00106352	00106353
M 39	4,0	35,0	150	60	32	24	00107360	00106361	00106362	00106363

HAND TAPS DIN 352

						◇	Set	No. 1	No. 2	No. 3
M 42	4,5	37,5	150	60	32	24	00107370	00106371	00106372	00106373
M 45	4,5	40,5	160	65	36	29	00107380	00106381	00106382	00106383
M 48	5,0	43,0	180	70	36	29	00107390	00106391	00106392	00106393
M 52	5,0	47,0	180	70	40	32	00107400	00106401	00106402	00106403
M 56	5,5	51,5	180	70	40	32	00107410	00106411	00106412	00106413
M 60	5,5	54,5	200	75	45	35	00107420	00106421	00106422	00106423
M 64	6,0	58,0	220	80	50	39	00107430	00106431	00106432	00106433

TAPER WITH GUIDING PIN

TECHNICAL INFORMATION

Standard	DIN 352	Hole type	Through/blind hole
Thread	M	Direction	Right
Material	HSSE-G	Tolerance	ISO2 / 6H
Raw material	Stainless steel		

						◇	Set	No. 1	No. 2	No. 3
M 3	0,5	2,5	40	11	3,5	2,7	00113130	00112131	00112132	00112133
M 4	0,7	3,3	45	13	4,5	3,4	00113150	00112151	00112152	00112153
M 5	0,8	4,2	50	16	6	4,9	00113170	00112171	00112172	00112173
M 6	1,0	5,0	56	19	6	4,9	00113190	00112191	00112192	00112193
M 8	1,25	6,8	63	22	6	4,9	00113210	00112211	00112212	00112213
M 10	1,5	8,5	70	24	7	5,5	00113230	00112231	00112232	00112233
M 12	1,75	10,2	75	28	9	7	00113250	00112251	00112252	00112253
M 14	2,0	12,0	80	32	11	9	00113260	00112261	00112262	00112263
M 16	2,0	14,0	80	32	12	9	00113270	00112271	00112272	00112273
M 18	2,5	15,5	95	34	14	11	00113280	00112281	00112282	00112283
M 20	2,5	17,5	95	34	16	12	00113290	00112291	00112292	00112293
M 22	2,5	19,5	100	34	18	14,5	00113300	00112301	00112302	00112303
M 24	3,0	21,0	110	38	18	14,5	00113310	00112311	00112312	00112313

GSR

TAPER WITH GUIDING PIN, VAPORISED

TECHNICAL INFORMATION

Standard	DIN 352	Hole type	Through/blind hole
Thread	M	Direction	Right
Material	HSSE-VAP	Tolerance	ISO2 / 6H
Raw material	Stainless steel		

						◇	Set	No. 1	No. 2	No. 3
M 3	0,5	2,5	40	11	3,5	2,7	00813130	00812131	00812132	00812133
M 4	0,7	3,3	45	13	4,5	3,4	00813150	00812151	00812152	00812153
M 5	0,8	4,2	50	16	6	4,9	00813170	00812171	00812172	00812173
M 6	1,0	5,0	56	19	6	4,9	00813190	00812191	00812192	00812193
M 8	1,25	6,8	63	22	6	4,9	00813210	00812211	00812212	00812213
M 10	1,5	8,5	70	24	7	5,5	00813230	00812231	00812232	00812233
M 12	1,75	10,2	75	28	9	7	00813250	00812251	00812252	00812253
M 14	2,0	12,0	80	32	11	9	00813260	00812261	00812262	00812263
M 16	2,0	14,0	80	32	12	9	00813270	00812271	00812272	00812273
M 18	2,5	15,5	95	34	14	11	00813280	00812281	00812282	00812283
M 20	2,5	17,5	95	34	16	12	00813290	00812291	00812292	00812293
M 22	2,5	19,5	100	34	18	14,5	00813300	00812301	00812302	00812303
M 24	3,0	21,0	110	38	18	14,5	00813310	00812311	00812312	00812313

HAND TAPS LH

TECHNICAL INFORMATION

Standard	DIN 352	Hole type	Through/blind hole
Thread	M	Direction	Left
Material	HSS-G	Tolerance	ISO2 / 6H
Raw material	Steel		

						◇	Set	No. 1	No. 2	No. 3
M 3	0,5	2,5	40	12	3,5	2,7	00109130	00108131	00108132	00108133
M 4	0,7	3,3	45	14	4,5	3,4	00109150	00108151	00108152	00108153
M 5	0,8	4,2	48	16	6	4,9	00109170	00108171	00108172	00108173
M 6	1,0	5,0	56	19	6	4,9	00109190	00108191	00108192	00108193
M 7	1,0	6,0	56	19	6	4,9	00109200	00108201	00108202	00108203
M 8	1,25	6,8	63	22	6	4,9	00109210	00108211	00108212	00108213
M 9	1,25	7,8	63	22	7	5,5	00109220	00108221	00108222	00108223
M 10	1,5	8,5	70	24	7	5,5	00109230	00108231	00108232	00108233

HAND TAPS DIN 352

						◇	Set	No. 1	No. 2	No. 3
M 12	1,75	10,2	75	28	9	7	00109250	00108251	00108252	00108253
M 14	2,0	12,0	80	32	11	9	00109260	00108261	00108262	00108263
M 16	2,0	14,0	80	32	12	9	00109270	00108271	00108272	00108273
M 18	2,5	15,5	95	34	14	11	00109280	00108281	00108282	00108283
M 20	2,5	17,5	95	34	16	12	00109290	00108291	00108292	00108293
M 22	2,5	19,5	100	34	18	14,5	00109300	00108301	00108302	00108303
M 24	3,0	21,0	110	38	18	14,5	00109310	00108311	00108312	00108313
M 27	3,0	24,0	110	38	20	16	00109320	00108321	00108322	00108323
M 30	3,5	26,5	125	45	22	18	00109330	00108331	00108332	00108333
M 33	3,5	29,5	125	50	25	20	00109340	00108341	00108342	00108343
M 36	4,0	32,0	150	56	28	22	00109350	00108351	00108352	00108353
M 39	4,0	35,0	150	60	32	24	00109360	00108361	00108362	00108363
M 42	4,5	37,5	150	60	32	24	00109370	00108371	00108372	00108373
M 45	4,5	40,5	160	65	36	29	00109380	00108381	00108382	00108383
M 48	5,0	43,0	180	70	36	29	00109390	00108391	00108392	00108393
M 52	5,0	47,0	180	70	40	32	00109400	00108401	00108402	00108403
M 56	5,5	51,5	180	70	40	35	00109410	00108411	00108412	00108413
M 60	5,5	54,5	200	75	45	35	00109420	00108421	00108422	00108423
M 64	6,0	58,0	220	80	50	39	00109430	00108431	00108432	00108433

TAPS
DIN 2181 · 2S · M4 × 0,5 · 6H · HSS

	Description
DIN 2181 =	German Institute for Standardisation
2S =	2pcs. Set
M4 × 0,5 =	ISO metric fine thread size 4mm with 0.5 pitch
6H =	Tolerance class according to DIN 802, part 1
HSS =	High-speed steel

Labelling according to DIN 2197
M4 × 0.5 6H HSS

SQUARE SHANK ACCORDING TO DIN 10

for mounting the tap into the adjustable tap wrench (ATW).

HAND TAPS

DIN 2181

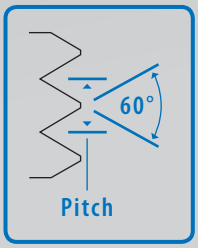
The two-piece set for ISO metric fine thread consists of taper and bottoming. The taper has undersize.

The sizes M1 to M6,5 have a reinforced shank and three flutes. Sizes above M6,5 have a reinforced shank and four flutes.

CHUCK

of the tool holder

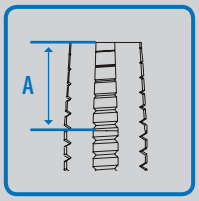
DIN 2181



THREAD WITH METRIC PROFILE

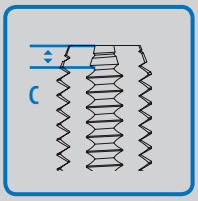
SQUARE SHANK ACCORDING TO DIN10

for mounting the tap into the adjustable tap wrench (ATW).



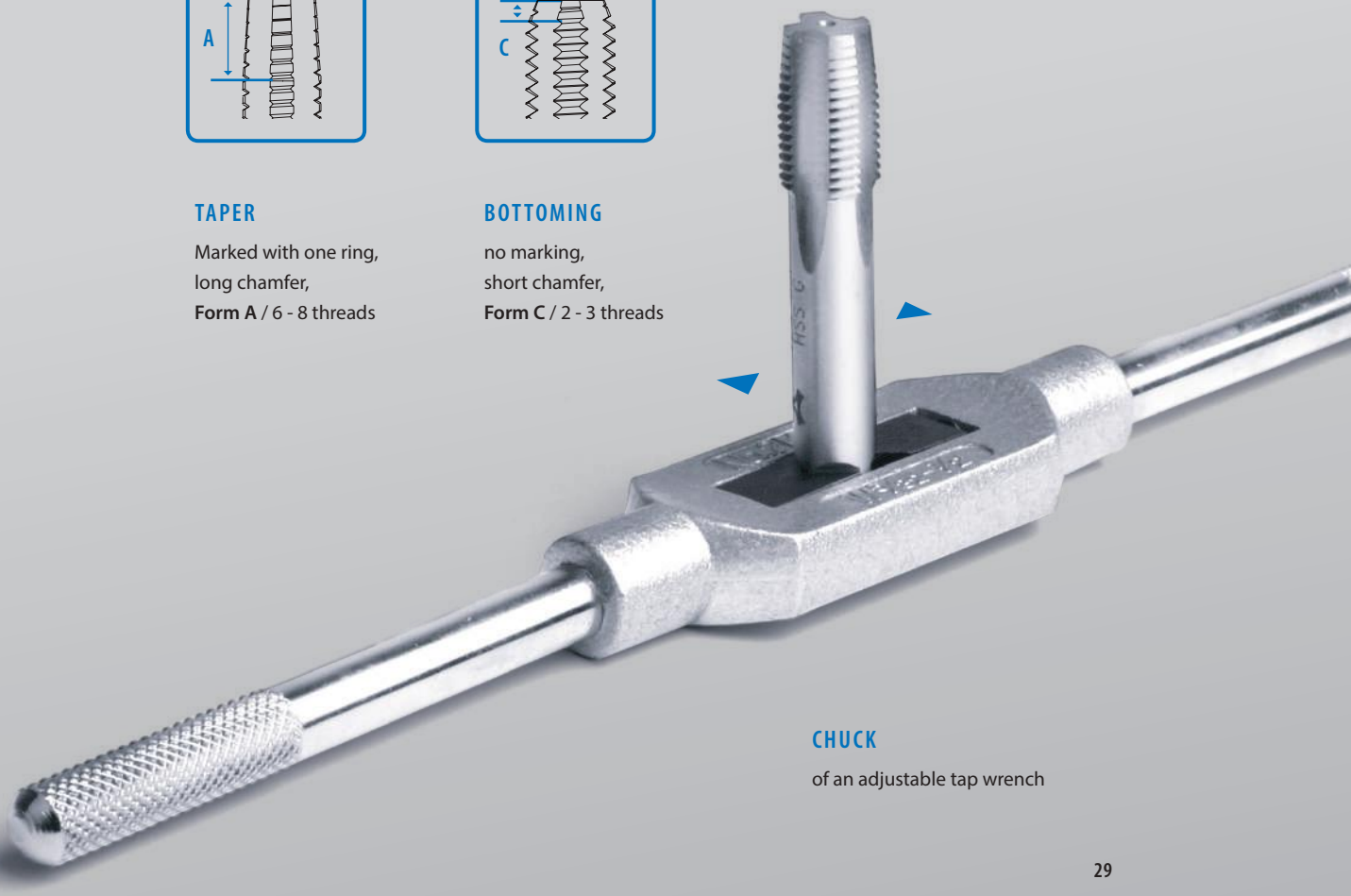
TAPER

Marked with one ring,
long chamfer,
Form A / 6 - 8 threads



BOTTOMING

no marking,
short chamfer,
Form C / 2 - 3 threads

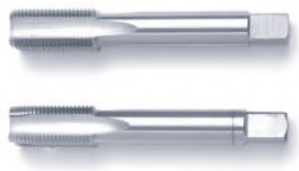


CHUCK

of an adjustable tap wrench

HAND TAPS DIN 2181

HAND TAPS



TECHNICAL INFORMATION

Standard	DIN 2181	Hole type	Through/blind hole
Thread	MF	Direction	Right
Material	HSS-G	Tolerance	ISO2 / 6H
Raw material	Steel		

							Set	No. 1	No. 2
MF 2,5 × 0,35	0,35	2,15	40	8	2,8	2,1	00115150	00114151	00114153
MF 2,6 × 0,35	0,35	2,15	40	8	2,8	2,1	00115160	00114161	00114163
MF 3 × 0,35	0,35	2,65	40	8	3,5	2,7	00115200	00114201	00114203
MF 3,5 × 0,35	0,35	3,15	45	9	4,0	3,0	00115220	00114221	00114223
MF 4 × 0,35	0,35	3,65	45	10	4,5	3,4	00115230	00114231	00114233
MF 4 × 0,5	0,5	3,5	45	10	4,5	3,4	00115240	00114241	00114243
MF 4,5 × 0,35	0,35	4,15	50	12	6,0	3,4	00115250	00114251	00114253
MF 4,5 × 0,5	0,5	4,0	50	12	6,0	3,4	00115260	00114261	00114263
MF 5 × 0,5	0,5	4,5	50	12	6,0	4,9	00115280	00114281	00114283
MF 5 × 0,75	0,75	4,25	50	12	6,0	4,9	00115290	00114291	00114293
MF 5,5 × 0,5	0,5	5,0	56	12	6,0	4,9	00115300	00114301	00114303
MF 5,5 × 0,75	0,75	4,75	56	12	6,0	4,9	00115310	00114311	00114313
MF 6 × 0,5	0,5	5,5	56	14	6,0	4,9	00115320	00114321	00114323
MF 6 × 0,75	0,75	5,25	56	14	6,0	4,9	00115330	00114331	00114333
MF 7 × 0,5	0,5	6,5	56	14	6,0	4,9	00115350	00114351	00114353
MF 7 × 0,75	0,75	6,25	56	14	6,0	4,9	00115360	00114361	00114363
MF 8 × 0,5	0,5	7,5	56	18	6,0	4,9	00115380	00114381	00114383
MF 8 × 0,75	0,75	7,25	56	18	6,0	4,9	00115390	00114391	00114393
MF 8 × 1	1,0	7,0	63	22	6,0	4,9	00115400	00114401	00114403
MF 8 × 1,5	1,5	6,5	63	22	6,0	4,9	00115410	00114411	00114413
MF 9 × 0,5	0,5	8,5	63	22	7,0	5,5	00115420	00114421	00114423
MF 9 × 0,75	0,75	8,25	63	22	7,0	5,5	00115430	00114431	00114433
MF 9 × 1	1,0	8,0	63	22	7,0	5,5	00115440	00114441	00114443
MF 10 × 0,5	0,5	9,5	63	20	7,0	5,5	00115450	00114451	00114453
MF 10 × 0,75	0,75	9,25	63	20	7,0	5,5	00115460	00114461	00114463
MF 10 × 1	1,0	9,0	63	20	7,0	5,5	00115470	00114471	00114473
MF 10 × 1,25	1,25	8,8	70	24	7,0	5,5	00115480	00114481	00114483
MF 11 × 0,5	0,5	10,5	63	20	8,0	6,2	00115490	00114491	00114493
MF 11 × 0,75	0,75	10,25	63	20	8,0	6,2	00115500	00114501	00114503
MF 11 × 1	1,0	10,0	63	20	8,0	6,2	00115510	00114511	00114513
MF 11 × 1,25	1,25	9,75	70	22	8,0	6,2	00115520	00114521	00114523
MF 12 × 0,5	0,5	11,5	70	22	9,0	7,0	00115530	00114531	00114533
MF 12 × 0,75	0,75	11,25	70	22	9,0	7,0	00115540	00114541	00114543
MF 12 × 1	1,0	11,0	70	22	9,0	7,0	00115550	00114551	00114553
MF 12 × 1,25	1,25	10,8	70	22	9,0	7,0	00115560	00114561	00114563
MF 12 × 1,5	1,5	10,5	70	22	9,0	7,0	00115570	00114571	00114573

GSR

						◇	Set	No. 1	No. 2
MF 13 × 0,5	0,5	12,5	70	22	11,0	9,0	00115580	00114581	00114583
MF 13 × 0,75	0,75	12,25	70	22	11,0	9,0	00115590	00114591	00114593
MF 13 × 1	1,0	12,0	70	22	11,0	9,0	00115600	00114601	00114603
MF 13 × 1,25	1,25	11,75	70	22	11,0	9,0	00115610	00114611	00114613
MF 13 × 1,5	1,5	11,5	70	22	11,0	9,0	00115620	00114621	00114623
MF 14 × 0,5	0,5	13,5	70	22	11,0	9,0	00115630	00114631	00114633
MF 14 × 0,75	0,75	13,25	70	22	11,0	9,0	00115640	00114641	00114643
MF 14 × 1	1,0	13,0	70	22	11,0	9,0	00115650	00114651	00114653
MF 14 × 1,25	1,25	12,8	70	22	11,0	9,0	00115660	00114661	00114663
MF 14 × 1,5	1,5	12,5	70	22	11,0	9,0	00115670	00114671	00114673
MF 15 × 0,5	0,5	14,5	70	22	12,0	9,0	00115680	00114681	00114683
MF 15 × 0,75	0,75	14,25	70	22	12,0	9,0	00115690	00114691	00114693
MF 15 × 1	1,0	14,0	70	22	12,0	9,0	00115700	00114701	00114703
MF 15 × 1,25	1,25	13,8	70	22	12,0	9,0	00115710	00114711	00114713
MF 15 × 1,5	1,5	13,5	70	22	12,0	9,0	00115720	00114721	00114723
MF 16 × 0,5	0,5	15,5	70	22	12,0	9,0	00115730	00114731	00114733
MF 16 × 0,75	0,75	15,25	70	22	12,0	9,0	00115740	00114741	00114743
MF 16 × 1	1,0	15,0	70	22	12,0	9,0	00115750	00114751	00114753
MF 16 × 1,25	1,25	14,75	70	22	12,0	9,0	00115760	00114761	00114763
MF 16 × 1,5	1,5	14,5	70	22	12,0	9,0	00115770	00114771	00114773
MF 17 × 0,75	0,75	16,25	70	22	12,0	9,0	00115780	00114781	00114783
MF 17 × 1	1,0	16,0	70	22	12,0	9,0	00115790	00114791	00114793
MF 17 × 1,5	1,5	15,5	70	22	12,0	9,0	00115800	00114801	00114803
MF 18 × 0,5	0,5	17,5	80	22	14,0	11,0	00115820	00114821	00114823
MF 18 × 0,75	0,75	17,25	80	22	14,0	11,0	00115830	00114831	00114833
MF 18 × 1	1,0	17,0	80	22	14,0	11,0	00115840	00114841	00114843
MF 18 × 1,25	1,25	16,75	80	22	14,0	11,0	00115850	00114851	00114853
MF 18 × 1,5	1,5	16,5	80	22	14,0	11,0	00115860	00114861	00114863
MF 18 × 2	2,0	16,0	80	22	14,0	11,0	00115870	00114871	00114873
MF 19 × 1	1,0	18,0	80	22	14,0	11,0	00115880	00114881	00114883
MF 19 × 1,5	1,5	17,5	80	22	14,0	11,0	00115900	00114901	00114903
MF 20 × 0,5	0,5	19,5	80	22	16,0	12,0	00115910	00114911	00114913
MF 20 × 0,75	0,75	19,25	80	22	16,0	12,0	00115920	00114921	00114923
MF 20 × 1	1,0	19,0	80	22	16,0	12,0	00115930	00114931	00114933
MF 20 × 1,25	1,25	18,75	80	22	16,0	12,0	00115940	00114941	00114943
MF 20 × 1,5	1,5	18,5	80	22	16,0	12,0	00115950	00114951	00114953
MF 20 × 2	2,0	18,0	80	22	16,0	12,0	00115960	00114961	00114963
MF 21 × 1	1,0	20,0	80	22	16,0	12,0	00115980	00114981	00114983
MF 21 × 1,5	1,5	19,5	80	22	16,0	12,0	00122000	00120001	00120003
MF 22 × 0,5	0,5	21,5	80	22	18,0	14,5	00122010	00120011	00120013
MF 22 × 0,75	0,75	21,25	80	22	18,0	14,5	00122020	00120021	00120023
MF 22 × 1	1,0	21,0	80	22	18,0	14,5	00122030	00120031	00120033
MF 22 × 1,25	1,25	20,75	80	22	18,0	14,5	00122040	00120041	00120043
MF 22 × 1,5	1,5	20,5	80	22	18,0	14,5	00122050	00120051	00120053

HAND TAPS DIN 2181

						◇	Set	No. 1	No. 2
MF 22 × 2	2,0	20,0	80	22	18,0	14,5	00122060	00120061	00120063
MF 23 × 1	1,0	22,0	80	22	18,0	14,5	00122070	00120071	00120073
MF 23 × 1,5	1,5	21,5	80	22	18,0	14,5	00122080	00120081	00120083
MF 24 × 0,5	0,5	23,5	90	22	18,0	14,5	00122090	00120091	00120093
MF 24 × 0,75	0,75	23,25	90	22	18,0	14,5	00122100	00120101	00120103
MF 24 × 1	1,0	23,0	90	22	18,0	14,5	00122110	00120111	00120113
MF 24 × 1,25	1,25	22,75	90	22	18,0	14,5	00122120	00120121	00120123
MF 24 × 1,5	1,5	22,5	90	22	18,0	14,5	00122130	00120131	00120133
MF 24 × 2	2,0	22,0	90	22	18,0	14,5	00122140	00120141	00120143
MF 25 × 1	1,0	24,0	90	22	18,0	14,5	00122150	00120151	00120153
MF 25 × 1,5	1,5	23,5	90	22	18,0	14,5	00122170	00120171	00120173
MF 25 × 2	2,0	23,0	90	22	18,0	14,5	00122180	00120181	00120183
MF 26 × 1	1,0	25,0	90	22	18,0	14,5	00122190	00120191	00120193
MF 26 × 1,25	1,25	24,75	90	22	18,0	14,5	00122200	00120201	00120203
MF 26 × 1,5	1,5	24,5	90	22	18,0	14,5	00122210	00120211	00120213
MF 26 × 2	2,0	24,0	90	22	18,0	14,5	00122220	00120221	00120223
MF 27 × 1	1,0	26,0	90	22	20,0	16,0	00122230	00120231	00120233
MF 27 × 1,5	1,5	25,5	90	22	20,0	16,0	00122240	00120241	00120243
MF 27 × 2	2,0	25,0	90	22	20,0	16,0	00122250	00120251	00120253
MF 28 × 1	1,0	27,0	90	22	20,0	16,0	00122260	00120261	00120263
MF 28 × 1,5	1,5	26,5	90	22	20,0	16,0	00122270	00120271	00120273
MF 28 × 2	2,0	26,0	90	22	20,0	16,0	00122280	00120281	00120283
MF 30 × 1	1,0	29,0	90	22	22,0	18,0	00122290	00120291	00120293
MF 30 × 1,5	1,5	28,5	90	22	22,0	18,0	00122300	00120301	00120303
MF 30 × 2	2,0	28,0	90	22	22,0	18,0	00122310	00120311	00120313
MF 30 × 3	3,0	27,0	125	45	22,0	18,0	00122320	00120321	00120323
MF 32 × 1	1,0	31,0	90	22	22,0	18,0	00122330	00120331	00120333
MF 32 × 1,5	1,5	30,5	90	22	22,0	18,0	00122340	00120341	00120343
MF 32 × 2	2,0	30,0	90	22	22,0	18,0	00122350	00120351	00120353
MF 32 × 3	3,0	29,0	125	45	22,0	18,0	00122360	00120361	00120363
MF 33 × 1	1,0	32,0	100	25	25,0	20,0	00122370	00120371	00120373
MF 33 × 1,5	1,5	31,5	100	25	25,0	20,0	00122380	00120381	00120383
MF 33 × 2	2,0	31,0	100	25	25,0	20,0	00122390	00120391	00120393
MF 33 × 3	3,0	30,0	125	50	25,0	20,0	00122400	00120401	00120403
MF 34 × 1	1,0	33,0	100	25	28,0	22,0	00122410	00120411	00120413
MF 34 × 1,5	1,5	32,5	100	25	28,0	22,0	00122420	00120421	00120423
MF 34 × 2	2,0	32,0	125	40	28,0	22,0	00122430	00120431	00120433
MF 34 × 3	3,0	31,0	125	40	28,0	22,0	00122440	00120441	00120443
MF 35 × 1	1,0	34,0	100	25	28,0	22,0	00122450	00120451	00120453
MF 35 × 1,5	1,5	33,5	100	25	28,0	22,0	00122460	00120461	00120463
MF 35 × 2	2,0	33,0	125	40	28,0	22,0	00122470	00120471	00120473
MF 35 × 3	3,0	32,0	125	40	28,0	22,0	00122480	00120481	00120483
MF 36 × 1	1,0	35,0	100	25	28,0	22,0	00122490	00120491	00120493
MF 36 × 1,5	1,5	34,5	100	25	28,0	22,0	00122500	00120501	00120503

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						◇	Set	No. 1	No. 2
MF 36 × 2	2,0	34,0	125	40	28,0	22,0	00122510	00120511	00120513
MF 36 × 3	3,0	33,0	125	40	28,0	22,0	00122520	00120521	00120523
MF 38 × 1	1,0	37,0	100	25	28,0	22,0	00122530	00120531	00120533
MF 38 × 1,5	1,5	36,5	100	25	28,0	22,0	00122540	00120541	00120543
MF 38 × 2	2,0	36,0	125	40	28,0	22,0	00122550	00120551	00120553
MF 38 × 3	3,0	35,0	125	40	28,0	22,0	00122560	00120561	00120563
MF 39 × 1,5	1,5	37,5	110	25	32,0	24,0	00122570	00120571	00120573
MF 39 × 2	2,0	37,0	125	40	32,0	24,0	00122580	00120581	00120583
MF 39 × 3	3,0	36,0	125	40	32,0	24,0	00122590	00120591	00120593
MF 40 × 1	1,0	39,0	110	25	32,0	24,0	00122600	00120601	00120603
MF 40 × 1,5	1,5	38,5	110	25	32,0	24,0	00122610	00120611	00120613
MF 40 × 2	2,0	38,0	125	40	32,0	24,0	00122620	00120621	00120623
MF 40 × 3	3,0	37,0	125	40	32,0	24,0	00122630	00120631	00120633
MF 42 × 1,5	1,5	40,5	110	25	32,0	24,0	00122640	00120641	00120643
MF 42 × 2	2,0	40,0	125	40	32,0	24,0	00122650	00120651	00120653
MF 42 × 3	3,0	39,0	125	40	32,0	24,0	00122660	00120661	00120663
MF 42 × 4	4,0	38,0	160	65	32,0	24,0	00122670	00120671	00120673
MF 45 × 1	1,0	44,0	110	25	36,0	29,0	00122680	00120681	00120683
MF 45 × 1,5	1,5	43,5	110	25	36,0	29,0	00122690	00120691	00120693
MF 45 × 2	2,0	43,0	125	40	36,0	29,0	00122700	00120701	00120703
MF 45 × 3	3,0	42,0	125	40	36,0	29,0	00122710	00120711	00120713
MF 45 × 4	4,0	41,0	160	65	36,0	29,0	00122720	00120721	00120723
MF 48 × 1	1,0	47,0	140	40	36,0	29,0	00122730	00120731	00120733
MF 48 × 1,5	1,5	46,5	140	40	36,0	29,0	00122740	00120741	00120743
MF 48 × 2	2,0	46,0	140	40	36,0	29,0	00122750	00120751	00120753
MF 48 × 3	3,0	45,0	140	40	36,0	29,0	00122760	00120761	00120763
MF 48 × 4	4,0	44,0	140	40	36,0	29,0	00122770	00120771	00120773
MF 50 × 1	1,0	49,0	140	40	36,0	29,0	00122780	00120781	00120783
MF 50 × 1,5	1,5	48,5	140	40	36,0	29,0	00122790	00120791	00120793
MF 50 × 2	2,0	48,0	140	40	36,0	29,0	00122800	00120801	00120803
MF 50 × 3	3,0	47,0	140	40	36,0	29,0	00122810	00120811	00120813
MF 50 × 4	4,0	46,0	160	65	40,0	32,0	00122820	00120821	00120823
MF 52 × 1	1,0	51,0	140	40	40,0	32,0	00122830	00120831	00120833
MF 52 × 1,5	1,5	50,5	140	40	40,0	32,0	00122840	00120841	00120843
MF 52 × 2	2,0	50,0	140	40	40,0	32,0	00122850	00120851	00120853
MF 52 × 3	3,0	49,0	140	40	40,0	32,0	00122860	00120861	00120863
MF 52 × 4	4,0	48,0	160	65	40,0	32,0	00122870	00120871	00120873

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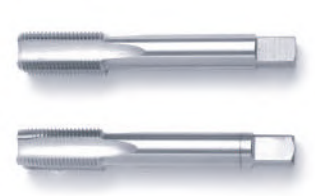

TECHNICAL INFORMATION

Standard	DIN 2181	Hole type	Through/blind hole
Thread	MF	Direction	Right
Material	HSSE-G	Tolerance	ISO2 / 6H
Raw material	Steel		

							Set	No. 1	No. 2
MF 2,5 × 0,35	0,35	2,15	40	8	2,8	2,1	00142150	00142151	00142153
MF 2,6 × 0,35	0,35	2,15	40	8	2,8	2,1	00142161	00142161	00142163
MF 3 × 0,35	0,35	2,65	40	8	3,5	2,7	00142200	00138201	00138203
MF 3,5 × 0,35	0,35	3,15	45	9	4,0	3,0	00142220	00138221	00138223
MF 4 × 0,35	0,35	3,65	45	10	4,5	3,4	00142230	00138231	00138233
MF 4 × 0,5	0,5	3,5	45	10	4,5	3,4	00142240	00138241	00138243
MF 4,5 × 0,35	0,35	4,15	50	12	6,0	3,4	00142250	00138251	00138253
MF 4,5 × 0,5	0,5	4,0	50	12	6,0	3,4	00142260	00138261	00138263
MF 5 × 0,5	0,5	4,5	50	12	6,0	4,9	00142280	00138281	00138283
MF 5 × 0,75	0,75	4,25	50	12	6,0	4,9	00142290	00138291	00138293
MF 5,5 × 0,5	0,5	5,0	56	12	6,0	4,9	00142300	00138301	00138303
MF 5,5 × 0,75	0,75	4,75	56	12	6,0	4,9	00142310	00138311	00138313
MF 6 × 0,5	0,5	5,5	56	14	6,0	4,9	00142320	00138321	00138323
MF 6 × 0,75	0,75	5,25	56	14	6,0	4,9	00142330	00138331	00138333
MF 7 × 0,5	0,5	6,5	56	14	6,0	4,9	00142350	00138351	00138353
MF 7 × 0,75	0,75	6,25	56	14	6,0	4,9	00142360	00138361	00138363
MF 8 × 0,5	0,5	7,5	56	18	6,0	4,9	00142380	00138381	00138383
MF 8 × 0,75	0,75	7,25	56	18	6,0	4,9	00142390	00138391	00138393
MF 8 × 1	1,0	7,0	63	22	6,0	4,9	00142400	00138401	00138403
MF 8 × 1,5	1,5	6,5	63	22	6,0	4,9	00142410	00138411	00138413
MF 9 × 0,5	0,5	8,5	63	22	7,0	5,5	00142420	00138421	00138423
MF 9 × 0,75	0,75	8,25	63	22	7,0	5,5	00142430	00138431	00138433
MF 9 × 1	1,0	8,0	63	22	7,0	5,5	00142440	00138441	00138443
MF 10 × 0,5	0,5	9,5	63	20	7,0	5,5	00142450	00138451	00138453
MF 10 × 0,75	0,75	9,25	63	20	7,0	5,5	00142460	00138461	00138463
MF 10 × 1	1,0	9,0	63	20	7,0	5,5	00142470	00138471	00138473
MF 10 × 1,25	1,25	8,8	70	24	7,0	5,5	00142480	00138481	00138483
MF 11 × 0,5	0,5	10,5	63	20	8,0	6,2	00142490	00138491	00138493
MF 11 × 0,75	0,75	10,25	63	20	8,0	6,2	00142500	00138501	00138503
MF 11 × 1	1,0	10,0	63	20	8,0	6,2	00142510	00138511	00138513
MF 11 × 1,25	1,25	9,75	70	22	8,0	6,2	00142520	00138521	00138523
MF 12 × 0,5	0,5	11,5	70	22	9,0	7,0	00142530	00138531	00138533
MF 12 × 0,75	0,75	11,25	70	22	9,0	7,0	00142540	00138541	00138543
MF 12 × 1	1,0	11,0	70	22	9,0	7,0	00142550	00138551	00138553
MF 12 × 1,25	1,25	10,8	70	22	9,0	7,0	00142560	00138561	00138563
MF 12 × 1,5	1,5	10,5	70	22	9,0	7,0	00142570	00138571	00138573

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						◇	Set	No. 1	No. 2
MF 13 × 0,5	0,5	12,5	70	22	11,0	9,0	00142580	00138581	00138583
MF 13 × 0,75	0,75	12,25	70	22	11,0	9,0	00142590	00138591	00138593
MF 13 × 1	1,0	12,0	70	22	11,0	9,0	00142600	00138601	00138603
MF 13 × 1,25	1,25	11,75	70	22	11,0	9,0	00142610	00138611	00138613
MF 13 × 1,5	1,5	11,5	70	22	11,0	9,0	00142620	00138621	00138623
MF 14 × 0,5	0,5	13,5	70	22	11,0	9,0	00142630	00138631	00138633
MF 14 × 0,75	0,75	13,25	70	22	11,0	9,0	00142640	00138641	00138643
MF 14 × 1	1,0	13,0	70	22	11,0	9,0	00142650	00138651	00138653
MF 14 × 1,25	1,25	12,8	70	22	11,0	9,0	00142660	00138661	00138663
MF 14 × 1,5	1,5	12,5	70	22	11,0	9,0	00142670	00138671	00138673
MF 15 × 0,5	0,5	14,5	70	22	12,0	9,0	00142680	00138681	00138683
MF 15 × 0,75	0,75	14,25	70	22	12,0	9,0	00142690	00138691	00138693
MF 15 × 1	1,0	14,0	70	22	12,0	9,0	00142700	00138701	00138703
MF 15 × 1,25	1,25	13,8	70	22	12,0	9,0	00142710	00138711	00138713
MF 15 × 1,5	1,5	13,5	70	22	12,0	9,0	00142720	00138721	00138723
MF 16 × 0,5	0,5	15,5	70	22	12,0	9,0	00142730	00138731	00138733
MF 16 × 0,75	0,75	15,25	70	22	12,0	9,0	00142740	00138741	00138743
MF 16 × 1	1,0	15,0	70	22	12,0	9,0	00142750	00138751	00138753
MF 16 × 1,25	1,25	14,75	70	22	12,0	9,0	00142760	00138761	00138763
MF 16 × 1,5	1,5	14,5	70	22	12,0	9,0	00142770	00138771	00138773
MF 17 × 0,75	0,75	16,25	70	22	12,0	9,0	00142780	00138781	00138783
MF 17 × 1	1,0	16,0	70	22	12,0	9,0	00142790	00138791	00138793
MF 17 × 1,5	1,5	15,5	70	22	12,0	9,0	00142800	00138801	00138803
MF 18 × 0,5	0,5	17,5	80	22	14,0	11,0	00142820	00138821	00138823
MF 18 × 0,75	0,75	17,25	80	22	14,0	11,0	00142830	00138831	00138833
MF 18 × 1	1,0	17,0	80	22	14,0	11,0	00142840	00138841	00138843
MF 18 × 1,25	1,25	16,75	80	22	14,0	11,0	00142850	00138851	00138853
MF 18 × 1,5	1,5	16,5	80	22	14,0	11,0	00142860	00138861	00138863
MF 18 × 2	2,0	16,0	80	22	14,0	11,0	00142870	00138871	00138873
MF 19 × 1	1,0	18,0	80	22	14,0	11,0	00142880	00138881	00138883
MF 19 × 1,5	1,5	17,5	80	22	14,0	11,0	00142900	00138901	00138903
MF 20 × 0,5	0,5	19,5	80	22	16,0	12,0	00142910	00138911	00138913
MF 20 × 0,75	0,75	19,25	80	22	16,0	12,0	00142920	00138921	00138923
MF 20 × 1	1,0	19,0	80	22	16,0	12,0	00142930	00138931	00138933
MF 20 × 1,25	1,25	18,75	80	22	16,0	12,0	00142940	00138941	00138943
MF 20 × 1,5	1,5	18,5	80	22	16,0	12,0	00142950	00138951	00138953
MF 20 × 2	2,0	18,0	80	22	16,0	12,0	00142960	00138961	00138963
MF 21 × 1	1,0	20,0	80	22	16,0	12,0	00142980	00138981	00138983
MF 21 × 1,5	1,5	19,5	80	22	16,0	12,0	00143000	00139001	00139003
MF 22 × 0,5	0,5	21,5	80	22	18,0	14,5	00143010	00139011	00139013
MF 22 × 0,75	0,75	21,25	80	22	18,0	14,5	00143020	00139021	00139023
MF 22 × 1	1,0	21,0	80	22	18,0	14,5	00143030	00139031	00139033
MF 22 × 1,25	1,25	20,75	80	22	18,0	14,5	00143040	00139041	00139043
MF 22 × 1,5	1,5	20,5	80	22	18,0	14,5	00143050	00139051	00139053

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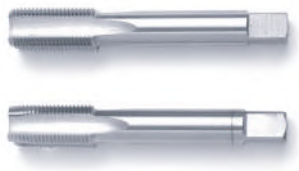
							Set	No. 1	No. 2
MF 22 × 2	2,0	20,0	80	22	18,0	14,5	00143060	00139061	00139063
MF 23 × 1	1,0	22,0	80	22	18,0	14,5	00143070	00139071	00139073
MF 23 × 1,5	1,5	21,5	80	22	18,0	14,5	00143080	00139081	00139083
MF 24 × 0,5	0,5	23,5	90	22	18,0	14,5	00143090	00139091	00139093
MF 24 × 0,75	0,75	23,25	90	22	18,0	14,5	00143100	00139101	00139103
MF 24 × 1	1,0	23,0	90	22	18,0	14,5	00143110	00139111	00139113
MF 24 × 1,25	1,25	22,75	90	22	18,0	14,5	00143120	00139121	00139123
MF 24 × 1,5	1,5	22,5	90	22	18,0	14,5	00143130	00139131	00139133
MF 24 × 2	2,0	22,0	90	22	18,0	14,5	00143140	00139141	00139143
MF 25 × 1	1,0	24,0	90	22	18,0	14,5	00143150	00139151	00139153
MF 25 × 1,5	1,5	23,5	90	22	18,0	14,5	00143170	00139171	00139173
MF 25 × 2	2,0	23,0	90	22	18,0	14,5	00143180	00139181	00139183
MF 26 × 1	1,0	25,0	90	22	18,0	14,5	00143190	00139191	00139193
MF 26 × 1,25	1,25	24,75	90	22	18,0	14,5	00143200	00139201	00139203
MF 26 × 1,5	1,5	24,5	90	22	18,0	14,5	00143210	00139211	00139213
MF 26 × 2	2,0	24,0	90	22	18,0	14,5	00143220	00139221	00139223
MF 27 × 1	1,0	26,0	90	22	20,0	16,0	00143230	00139231	00139233
MF 27 × 1,5	1,5	25,5	90	22	20,0	16,0	00143240	00139241	00139243
MF 27 × 2	2,0	25,0	90	22	20,0	16,0	00143250	00139251	00139253
MF 28 × 1	1,0	27,0	90	22	20,0	16,0	00143260	00139261	00139263
MF 28 × 1,5	1,5	26,5	90	22	20,0	16,0	00143270	00139271	00139273
MF 28 × 2	2,0	26,0	90	22	20,0	16,0	00143280	00139281	00139283
MF 30 × 1	1,0	29,0	90	22	22,0	18,0	00143290	00139291	00139293
MF 30 × 1,5	1,5	28,5	90	22	22,0	18,0	00143300	00139301	00139303
MF 30 × 2	2,0	28,0	90	22	22,0	18,0	00143310	00139311	00139313
MF 30 × 3	3,0	27,0	125	45	22,0	18,0	00143320	00139321	00139323
MF 32 × 1	1,0	31,0	90	22	22,0	18,0	00143330	00139331	00139333
MF 32 × 1,5	1,5	30,5	90	22	22,0	18,0	00143340	00139341	00139343
MF 32 × 2	2,0	30,0	90	22	22,0	18,0	00143350	00139351	00139353
MF 32 × 3	3,0	29,0	125	45	22,0	18,0	00143360	00139361	00139363
MF 33 × 1	1,0	32,0	100	25	25,0	20,0	00143370	00139371	00139373
MF 33 × 1,5	1,5	31,5	100	25	25,0	20,0	00143380	00139381	00139383
MF 33 × 2	2,0	31,0	100	25	25,0	20,0	00143390	00139391	00139393
MF 33 × 3	3,0	30,0	125	50	25,0	20,0	00143400	00139401	00139403
MF 34 × 1	1,0	33,0	100	25	28,0	22,0	00143410	00139411	00139413
MF 34 × 1,5	1,5	32,5	100	25	28,0	22,0	00143420	00139421	00139423
MF 34 × 2	2,0	32,0	125	40	28,0	22,0	00143430	00139431	00139433
MF 34 × 3	3,0	31,0	125	40	28,0	22,0	00143440	00139441	00139443
MF 35 × 1	1,0	34,0	100	25	28,0	22,0	00143450	00139451	00139453
MF 35 × 1,5	1,5	33,5	100	25	28,0	22,0	00143460	00139461	00139463
MF 35 × 2	2,0	33,0	125	40	28,0	22,0	00143470	00139471	00139473
MF 35 × 3	3,0	32,0	125	40	28,0	22,0	00143480	00139481	00139483

						◇	Set	No. 1	No. 2
MF 36 × 1	1,0	35,0	100	25	28,0	22,0	00143490	00139491	00139493
MF 36 × 1,5	1,5	34,5	100	25	28,0	22,0	00143500	00139501	00139503
MF 36 × 2	2,0	34,0	125	40	28,0	22,0	00143510	00139511	00139513
MF 36 × 3	3,0	33,0	125	40	28,0	22,0	00143520	00139521	00139523

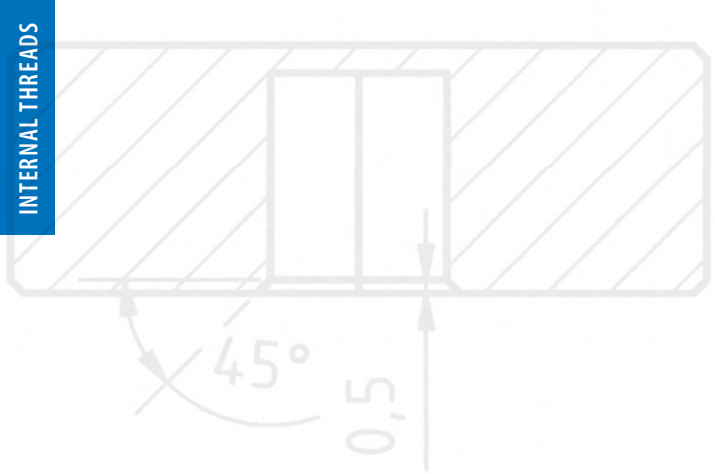
HAND TAPS LH



TECHNICAL INFORMATION

Standard	DIN 2181	Hole type	Through/blind hole
Thread	MF	Direction	Left
Material	HSS-G	Tolerance	ISO2 / 6H
Raw material	Steel		

						◇	Set	No. 1	No. 2
MF 6 × 0,75	0,75	5,25	56	14	6,0	4,9	00117330	00116331	00116333
MF 8 × 0,75	0,75	7,25	56	18	6,0	4,9	00117390	00116391	00116393
MF 8 × 1	1,0	7,0	63	22	6,0	4,9	00117400	00116401	00116403
MF 10 × 1	1,0	9,0	63	20	7,0	5,5	00117470	00116471	00116473
MF 10 × 1,25	1,25	8,8	70	24	7,0	5,5	00117480	00116481	00116483
MF 12 × 1	1,0	11,0	70	22	9,0	7,0	00117550	00116551	00116553
MF 12 × 1,25	1,25	10,8	70	22	9,0	7,0	00117560	00116561	00116563
MF 12 × 1,5	1,5	10,5	70	22	9,0	7,0	00117570	00116571	00116573
MF 14 × 1	1,0	13,0	70	22	11,0	9,0	00117650	00116651	00116653
MF 14 × 1,25	1,25	12,8	70	22	11,0	9,0	00117660	00116661	00116663
MF 14 × 1,5	1,5	12,5	70	22	11,0	9,0	00117670	00116671	00116673
MF 16 × 1	1,0	15,0	70	22	12,0	9,0	00117750	00116751	00116753
MF 16 × 1,5	1,5	14,5	70	22	12,0	9,0	00117770	00116771	00116773
MF 18 × 1,5	1,5	16,5	80	22	14,0	11,0	00117860	00116861	00116863
MF 20 × 1,5	1,5	18,5	80	22	16,0	12,0	00117950	00116951	00116953
MF 22 × 1,5	1,5	20,5	80	22	18,0	14,5	00126050	00124051	00124053
MF 24 × 2	2,0	22,0	90	22	18,0	14,5	00126140	00124141	00124143
MF 30 × 1,5	1,5	28,5	90	22	22,0	18,0	00126300	00124301	00124303
MF 30 × 2	2,0	28,0	90	22	22,0	18,0	00126310	00124311	00124313



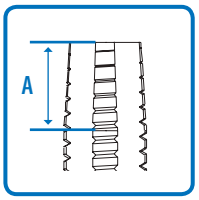
HAND TAPS

DIN 5157

The two-piece set for inner pipe threads – where, according to DIN ISO 228 part 1, pressure-tight joints are not made on the threads – consist of taper and bottoming. The taper has undersize. Sizes from G 1/16 to G4 have a reduced shank and four flutes. The pitch is indicated as threads per inch (25,4 mm).

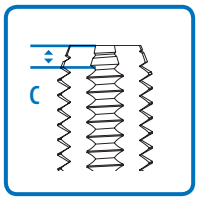
SQUARE SHANK ACCORDING TO DIN 10

for mounting the tap into the adjustable tap wrench (ATW).



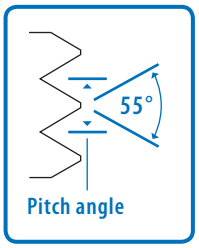
TAPER

Marked with one ring,
long chamfer,
Form A / 5 - 6 threads



BOTTOMING

no marking,
short chamfer,
Form C / 2 - 3 threads



THREAD WITH PIPE PROFILE

Whitworth-threads have a steeper flank compared to metric threads: thread angle 55° compared to thread angle 60° of metric threads. There is a distinction between conical and cylindrical types of Whitworth-threads. Conical threads according to DIN EN 10226-1 (old DIN 2999) are referred to as metallic sealing.

The reason is that the nominal diameter of a conical thread matches the mating thread after several turns. By further tightening the pipe, both threads jam and thus become metallic sealing. Cylindrical threads according to DIN ISO 228 are not self-sealing. (Abbreviation = G)

TAPS
DIN 5157 · 2S · G ½ · 6H · HSS

	Description
DIN 5157 =	German Institute for Standardisation
2S =	2pcs. Set
G ½ =	Whitworth-pipe thread according to DIN ISO 228 ½ inch (=20,955 mm)
6H =	Tolerance class according to DIN 802, part 1
HSS =	High-speed steel

Labelling according to DIN 2197
G ½ 6H HSS

HAND TAPS DIN 5157

HAND TAPS

TECHNICAL INFORMATION

Standard	DIN 5157	Hole type	Through/blind hole
Thread	BSP	Direction	Right
Material	HSS-G		
Raw material	Steel		

							Set	No. 1	No. 2
BSP 1/8	28	8,8	63	20	7,0	5,5	00155020	00154021	00154023
BSP 1/4	19	11,8	70	22	11,0	9,0	00155060	00154061	00154063
BSP 3/8	19	15,3	70	22	12,0	9,0	00155080	00154081	00154083
BSP 1/2	14	19,0	80	22	16,0	12,0	00155100	00154101	00154103
BSP 5/8	14	21,0	80	22	18,0	14,5	00155120	00154121	00154123
BSP 3/4	14	24,5	90	22	20,0	16,0	00155130	00154131	00154133
BSP 7/8	14	28,3	90	22	22,0	18,0	00155140	00154141	00154143
BSP 1	11	30,5	100	25	25,0	20,0	00155150	00154151	00154153
BSP 1.1/8	11	35,5	125	40	28,0	22,0	00155170	00154171	00154173
BSP 1.1/4	11	39,5	125	40	32,0	24,0	00155180	00154181	00154183
BSP 1.3/8	11	42,0	125	40	36,0	29,0	00155190	00154191	00154193
BSP 1.1/2	11	45,0	140	40	36,0	29,0	00155200	00154201	00154203
BSP 1.5/8	11	49,6	140	40	36,0	29,0	00155210	00154211	00154213
BSP 1.3/4	11	51,0	140	40	40,0	32,0	00155220	00154221	00154223
BSP 2	11	57,0	160	40	45,0	35,0	00155230	00154231	00154233
BSP 2.1/4	11	63,3	160	40	50,0	39,0	00155240	00154241	00154243
BSP 2.1/2	11	72,8	160	40	50,0	39,0	00155250	00154251	00154253
BSP 2.3/4	11	79,0	160	40	50,0	39,0	00155260	00154261	00154263
BSP 3	11	85,5	160	40	50,0	39,0	00155270	00154271	00154273
BSP 3.1/4	11	91,6	180	45	56,0	44,0	00155280	00154281	00154283
BSP 3.1/2	11	98,0	180	45	63,0	49,0	00155290	00154291	00154293
BSP 3.3/4	11	104,0	180	45	70,0	55,0	00155300	00154301	00154303
BSP 4	11	110,7	180	45	70,0	55,0	00155310	00154311	00154313

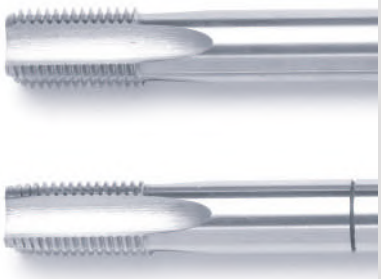
GSR

HAND TAPS

TECHNICAL INFORMATION

Standard	DIN 5157	Hole type	Through/blind hole
Thread	BSP	Direction	Right
Material	HSSE-G		
Raw material	Steel		

						◇	Set	No. 1	No. 2
BSP 1/8	28	8,8	63	20	7,0	5,5	00159020	00158021	00158023
BSP 1/4	19	11,8	70	22	11,0	9,0	00159060	00158061	00158063
BSP 3/8	19	15,3	70	22	12,0	9,0	00159080	00158081	00158083
BSP 1/2	14	19,0	80	22	16,0	12,0	00159100	00158101	00158103
BSP 5/8	14	21,0	80	22	18,0	14,5	00159120	00158121	00158123
BSP 3/4	14	24,5	90	22	20,0	16,0	00159130	00158131	00158133
BSP 7/8	14	28,3	90	22	22,0	18,0	00159140	00158141	00158143
BSP 1	11	30,5	100	25	25,0	20,0	00159150	00158151	00158153
BSP 1.1/8	11	35,5	125	40	28,0	22,0	00159170	00158171	00158173
BSP 1.1/4	11	39,5	125	40	32,0	24,0	00159180	00158181	00158183
BSP 1.3/8	11	42,0	125	40	36,0	29,0	00159190	00158191	00158193
BSP 1.1/2	11	45,0	140	40	36,0	29,0	00159200	00158201	00158203
BSP 1.5/8	11	49,6	140	40	36,0	29,0	00159210	00158211	00158213
BSP 1.3/4	11	51,0	140	40	40,0	32,0	00159220	00158221	00158223
BSP 2	11	57,0	160	40	45,0	35,0	00159230	00158231	00158233
BSP 2.1/4	11	63,3	160	40	50,0	39,0	00159240	00158241	00158243
BSP 2.1/2	11	72,8	160	40	50,0	39,0	00159250	00158251	00158253
BSP 2.3/4	11	79,0	160	40	50,0	39,0	00159260	00158261	00158263
BSP 3	11	85,5	160	40	50,0	39,0	00159270	00158271	00158273



HAND TAPS DIN 2184-2 / ISO 529

HAND TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-2 (~ DIN 352)	Hole type	Through/blind hole
Thread	BSW	Direction	Right
Material	HSS-G		
Raw material	Steel		

							Set	No. 1	No. 2	No. 3
BSW 1/16	60	1,2	32	8	2,5	2,1	00135010	00134011	00134012	00134013
BSW 3/32	48	1,9	40	9	2,8	2,1	00135020	00134021	00134022	00134023
BSW 1/8	40	2,6	40	11	3,5	2,7	00135030	00134031	00134032	00134033
BSW 5/32	32	3,2	45	13	4,5	3,4	00135040	00134041	00134042	00134043
BSW 3/16	24	3,8	50	16	6,0	4,9	00135050	00134051	00134052	00134053
BSW 7/32	24	4,6	56	17	6,0	4,9	00135060	00134061	00134062	00134063
BSW 1/4	20	5,1	56	19	6,0	4,9	00135070	00134071	00134072	00134073
BSW 5/16	18	6,5	63	22	6,0	4,9	00135080	00134081	00134082	00134083
BSW 3/8	16	7,9	70	24	7,0	5,5	00135090	00134091	00134092	00134093
BSW 7/16	14	9,3	70	24	8,0	6,2	00135100	00134101	00134102	00134103
BSW 1/2	12	10,5	75	28	9,0	7,0	00135110	00134111	00134112	00134113
BSW 9/16	12	12,0	80	30	11,0	9,0	00135120	00134121	00134122	00134123
BSW 5/8	11	13,5	80	32	12,0	9,0	00135130	00134131	00134132	00134133
BSW 3/4	10	16,5	95	34	14,0	11,0	00135140	00134141	00134142	00134143
BSW 7/8	9	19,5	100	34	18,0	14,5	00135150	00134151	00134152	00134153
BSW 1	8	22,0	110	38	18,0	14,5	00135160	00134161	00134162	00134163
BSW 1.1/8	7	25,0	125	45	22,0	18,0	00135170	00134171	00134172	00134173
BSW 1.1/4	7	28,0	125	45	22,0	18,0	00135180	00134181	00134182	00134183
BSW 1.3/8	6	30,5	150	56	28,0	22,0	00135190	00134191	00134192	00134193
BSW 1.1/2	6	33,5	150	56	28,0	22,0	00135200	00134201	00134202	00134203
BSW 1.5/8	5	35,5	150	60	32,0	24,0	00135210	00134211	00134212	00134213
BSW 1.3/4	5	39,0	160	65	36,0	29,0	00135220	00134221	00134222	00134223
BSW 1.7/8	4,5	41,5	180	70	36,0	29,0	00135230	00134231	00134232	00134233
BSW 2	4,5	44,5	180	70	40,0	32,0	00135240	00134241	00134242	00134243
BSW 2.1/4	4	50,8	200	75	45,0	35,0	00135250	00134251	00134252	00134253
BSW 2.1/2	4	57,15	220	80	50,0	39,0	00135260	00134261	00134262	00134263
BSW 2.3/4	3,5	62,6	240	80	50,0	39,0	00135270	00134271	00134272	00134273
BSW 3	3,5	68,95	260	85	50,0	39,0	00135280	00134281	00134282	00134283

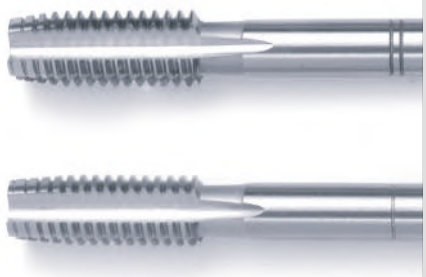
GSR

HAND TAPS

TECHNICAL INFORMATION

Standard	ISO 529	Hole type	Through/blind hole
Thread	BSW	Direction	Right
Material	HSS-G		
Raw material	Steel		

							Set	No. 1	No. 2	No. 3
BSW 1/8	40	2,6	48	11	3,15	2,5	00137030	00136031	00136032	00136033
BSW 5/32	32	3,2	55	13	4,5	3,55	00137040	00136041	00136042	00136043
BSW 3/16	24	3,8	58	16	5,0	4,0	00137050	00136051	00136052	00136053
BSW 1/4	20	5,1	66	19	6,3	5,0	00137070	00136071	00136072	00136073
BSW 5/16	18	6,5	72	22	8,0	6,3	00137080	00136081	00136082	00136083
BSW 3/8	16	7,9	80	24	10,0	8,0	00137090	00136091	00136092	00136093
BSW 7/16	14	9,3	85	25	8,0	6,3	00137100	00136101	00136102	00136103
BSW 1/2	12	10,5	89	29	9,0	7,1	00137110	00136111	00136112	00136113
BSW 9/16	12	12,0	95	30	11,2	9,0	00137120	00136121	00136122	00136123
BSW 5/8	11	13,5	102	32	12,5	10,0	00137130	00136131	00136132	00136133
BSW 3/4	10	16,5	112	37	14,0	11,2	00137140	00136141	00136142	00136143
BSW 7/8	9	19,5	118	38	16,0	12,5	00137150	00136151	00136152	00136153
BSW 1	8	22,0	130	45	18,0	14,0	00137160	00136161	00136162	00136163
BSW 1.1/8	7	25,0	138	48	20,0	16,0	00137170	00136171	00136172	00136173
BSW 1.1/4	7	28,0	151	51	22,4	18,0	00137180	00136181	00136182	00136183
BSW 1.3/8	6	30,5	162	57	25,0	20,0	00137190	00136191	00136192	00136193
BSW 1.1/2	6	33,5	170	60	28,0	22,4	00137200	00136201	00136202	00136203
BSW 1.3/4	5	39,0	187	67	31,5	25,0	00137220	00136221	00136222	00136223
BSW 2	4,5	44,5	200	70	35,5	28,0	00137240	00136241	00136242	00136243



HAND TAPS DIN 2184-2 / ISO 529

HAND TAPS LH

TECHNICAL INFORMATION

Standard	DIN 2184-2 (~ DIN 352)	Hole type	Through/blind hole
Thread	BSW	Direction	Left
Material	HSS-G		
Raw material	Steel		

							Set	No. 1	No. 2	No. 3
BSW 1/16	60	1,2	32	8	2,5	2,1	00153010	00152011	00152012	00152013
BSW 3/32	48	1,9	40	9	2,8	2,1	00153020	00152021	00152022	00152023
BSW 1/8	40	2,6	40	11	3,5	2,7	00153030	00152031	00152032	00152033
BSW 5/32	32	3,2	45	13	4,5	3,4	00153040	00152041	00152042	00152043
BSW 3/16	24	3,8	50	16	6,0	4,9	00153050	00152051	00152052	00152053
BSW 7/32	24	4,6	56	17	6,0	4,9	00153060	00152061	00152062	00152063
BSW 1/4	20	5,1	56	19	6,0	4,9	00153070	00152071	00152072	00152073
BSW 5/16	18	6,5	63	22	6,0	4,9	00153080	00152081	00152082	00152083
BSW 3/8	16	7,9	70	24	7,0	5,5	00153090	00152091	00152092	00152093
BSW 7/16	14	9,3	70	24	8,0	6,2	00153100	00152101	00152102	00152103
BSW 1/2	12	10,5	75	28	9,0	7,0	00153110	00152111	00152112	00152113
BSW 9/16	12	12,0	80	30	11,0	9,0	00153120	00152121	00152122	00152123
BSW 5/8	11	13,5	80	32	12,0	9,0	00153130	00152131	00152132	00152133
BSW 3/4	10	16,5	95	34	14,0	11,0	00153140	00152141	00152142	00152143
BSW 7/8	9	19,5	100	34	18,0	14,5	00153150	00152151	00152152	00152153
BSW 1	8	22,0	110	38	18,0	14,5	00153160	00152161	00152162	00152163
BSW 1.1/8	7	25,0	125	45	22,0	18,0	00153170	00152171	00152172	00152173
BSW 1.1/4	7	28,0	125	45	22,0	18,0	00153180	00152181	00152182	00152183
BSW 1.3/8	6	30,5	150	56	28,0	22,0	00153190	00152191	00152192	00152193
BSW 1.1/2	6	33,5	150	56	28,0	22,0	00153200	00152201	00152202	00152203
BSW 1.5/8	5	35,5	150	60	32,0	24,0	00153210	00152211	00152212	00152213
BSW 1.3/4	5	39	160	65	36,0	29,0	00153220	00152321	00152322	00152323
BSW 1.7/8	4,5	41,5	180	70	36,0	29,0	00153230	00152231	00152232	00152233
BSW 2	4,5	44,5	180	70	40,0	32,0	00153240	00152241	00152242	00152243
BSW 2.1/4	4	50,8	200	75	45,0	35,0	00153250	00152251	00152252	00152253
BSW 2.1/2	4	57,15	220	80	50,0	39,0	00153260	00152261	00152262	00152263
BSW 2.3/4	3,5	62,6	240	80	50,0	39,0	00153270	00152271	00152272	00152273
BSW 3	3,5	68,95	260	85	50,0	39,0	00153280	00152281	00152282	00152283

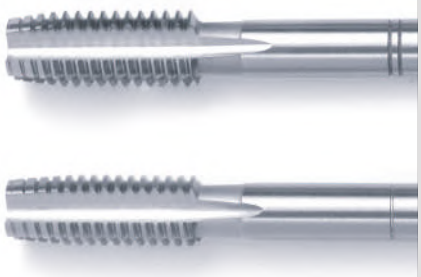
GSR

HAND TAPS LH

TECHNICAL INFORMATION

Standard	ISO 529	Hole type	Through/blind hole
Thread	BSW	Direction	Left
Material	HSS-G		
Raw material	Steel		

						◇	Set	No. 1	No. 2	No. 3
BSW 1/8	40	2,6	48	11	3,15	2,5	00129030	00127031	00127032	00127033
BSW 5/32	32	3,2	55	13	4,5	3,55	00129040	00127041	00127042	00127043
BSW 3/16	24	3,8	58	16	5,0	4,0	00129050	00127051	00127052	00127053
BSW 1/4	20	5,1	66	19	6,3	5,0	00129070	00127071	00127072	00127073
BSW 5/16	18	6,5	72	22	8,0	6,3	00129080	00127081	00127082	00127083
BSW 3/8	16	7,9	80	24	10,0	8,0	00129090	00127091	00127092	00127093
BSW 7/16	14	9,3	85	25	8,0	6,3	00129100	00127101	00127102	00127103
BSW 1/2	12	10,5	89	29	9,0	7,1	00129110	00127111	00127112	00127113
BSW 9/16	12	12,0	95	30	11,2	9,0	00129120	00127121	00127122	00127123
BSW 5/8	11	13,5	102	32	12,5	10,0	00129130	00127131	00127132	00127133
BSW 3/4	10	16,5	112	37	14,0	11,2	00129140	00127141	00127142	00127143
BSW 7/8	9	19,5	118	38	16,0	12,5	00129150	00127151	00127152	00127153
BSW 1	8	22,0	130	45	18,0	14,0	00129160	00127161	00127162	00127163
BSW 1.1/8	7	25,0	138	48	20,0	16,0	00129170	00127171	00127172	00127173
BSW 1.1/4	7	28,0	151	51	22,4	18,0	00129180	00127181	00127182	00127183
BSW 1.3/8	6	30,5	162	57	25,0	20,0	00129190	00127191	00127192	00127193
BSW 1.1/2	6	33,5	170	60	28,0	22,4	00129200	00127201	00127202	00127203
BSW 1.3/4	5	39,0	187	67	31,5	25,0	00129220	00127221	00127222	00127223
BSW 2	4,5	44,5	200	70	35,5	28,0	00129240	00127241	00127242	00127243



HAND TAPS DIN 5157 / 2184-2

HAND TAPS LH

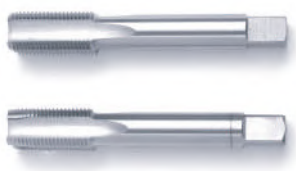
TECHNICAL INFORMATION

Standard	DIN 5157	Hole type	Through/blind hole
Thread	BSP	Direction	Left
Material	HSS-G		
Raw material	Steel		

							Set	No. 1	No. 2
BSP 1/8	28	8,8	63	20	7,0	5,5	00157020	00156021	00156023
BSP 1/4	19	11,8	70	22	11,0	9,0	00157060	00156061	00156063
BSP 3/8	19	15,3	70	22	12,0	9,0	00157080	00156081	00156083
BSP 1/2	14	19,0	80	22	16,0	12,0	00157100	00156101	00156103
BSP 5/8	14	21,0	80	22	18,0	14,5	00157120	00156121	00156123
BSP 3/4	14	24,5	90	22	20,0	16,0	00157130	00156131	00156133
BSP 7/8	14	28,3	90	22	22,0	18,0	00157140	00156141	00156143
BSP 1	11	30,5	100	25	25,0	20,0	00157150	00156151	00156153
BSP 1.1/8	11	35,5	125	40	28,0	22,0	00157170	00156171	00156173
BSP 1.1/4	11	39,5	125	40	32,0	24,0	00157180	00156181	00156183
BSP 1.3/8	11	42,0	125	40	36,0	29,0	00157190	00156191	00156193
BSP 1.1/2	11	45,0	140	40	36,0	29,0	00157200	00156201	00156203
BSP 1.5/8	11	49,6	140	40	36,0	29,0	00157210	00156211	00156213
BSP 1.3/4	11	51,0	140	40	40,0	32,0	00157220	00156221	00156223
BSP 2	11	57,0	160	40	45,0	35,0	00157230	00156231	00156233
BSP 2.1/4	11	63,3	160	40	50,0	39,0	00157240	00156241	00156243
BSP 2.1/2	11	72,8	160	40	50,0	39,0	00157250	00156251	00156253
BSP 2.3/4	11	79,0	160	40	50,0	39,0	00157260	00156261	00156263
BSP 3	11	85,5	160	40	50,0	39,0	00157270	00156271	00156273

GSR

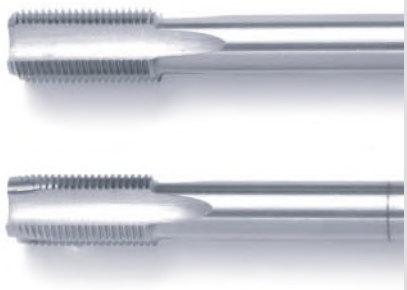
HAND TAPS



TECHNICAL INFORMATION

Standard	DIN 2184-2 (~ DIN 352)	Hole type	Through/blind hole
Thread	BSF	Direction	Right
Material	HSS-G		
Raw material	Steel		

						◇	Set	No. 1	No. 2
BSF 3/16	32	4,0	45	14	5,5	4,3	00145040	00144041	00144043
BSF 1/4	26	5,3	50	16	6,0	4,9	00145060	00144061	00144063
BSF 5/16	22	6,8	56	18	6,0	4,9	00145070	00144071	00144073
BSF 3/8	20	8,3	56	18	7,0	5,5	00145080	00144081	00144083
BSF 7/16	18	9,7	63	22	8,0	6,2	00145090	00144091	00144093
BSF 1/2	16	11,1	70	22	9,0	7,0	00145100	00144101	00144103
BSF 9/16	16	12,7	70	25	11,0	9,0	00145110	00144111	00144113
BSF 5/8	14	14,0	70	25	12,0	9,0	00145120	00144121	00144123
BSF 11/16	14	15,7	80	28	14,0	11,0	00145130	00144131	00144133
BSF 3/4	12	16,8	80	28	14,0	11,0	00145140	00144141	00144143
BSF 13/16	12	18,5	90	28	16,0	12,0	00145150	00144151	00144153
BSF 7/8	11	19,8	90	28	18,0	14,5	00145160	00144161	00144163
BSF 15/16	11	21,5	90	32	18,0	14,5	00145170	00144171	00144173
BSF 1	10	22,8	100	32	20,0	16,0	00145180	00144181	00144183
BSF 1.1/8	9	25,5	110	40	20,0	16,0	00145200	00144201	00144203
BSF 1.1/4	9	28,6	125	46	22,0	18,0	00145210	00144211	00144213
BSF 1.3/8	8	31,5	125	46	25,0	20,0	00145220	00144221	00144223
BSF 1.1/2	8	34,6	150	55	28,0	22,0	00145230	00144231	00144233
BSF 1.5/8	8	38,1	140	45	32,0	24,0	00145240	00144241	00144243
BSF 1.3/4	7	40,8	150	50	36,0	29,0	00145250	00144251	00144253
BSF 2	7	47,2	150	50	40,0	32,0	00145260	00144261	00144263



HAND TAPS DIN 2184-2 / ISO 529

HAND TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-2 (~ DIN 352)	Hole type	Through/blind hole
Thread	UNC	Direction	Right
Material	HSS-G	Tolerance	2B
Raw material	Steel		

						◇	Set	No. 1	No. 2	No. 3
UNC No. 1	64	1,5	36	8	2,8	2,1	00165010	00164011	00164012	00164013
UNC No. 2	56	1,8	36	9	2,8	2,1	00165020	00164021	00164022	00164023
UNC No. 3	48	2,1	40	9	2,8	2,1	00165030	00164031	00164032	00164033
UNC No. 4	40	2,3	40	11	3,5	2,7	00165040	00164041	00164042	00164043
UNC No. 5	40	2,6	40	11	3,5	2,7	00165050	00164051	00164052	00164053
UNC No. 6	32	2,9	45	12	4	3	00165060	00164061	00164062	00164063
UNC No. 8	32	3,5	45	13	4,5	3,4	00165080	00164081	00164082	00164083
UNC No. 10	24	3,9	50	16	6	4,9	00165100	00164101	00164102	00164103
UNC No. 12	24	4,5	56	17	6	4,9	00165120	00164121	00164122	00164123
UNC 1/4	20	5,2	56	19	6	4,9	00165130	00164131	00164132	00164133
UNC 5/16	18	6,6	63	22	6	4,9	00165140	00164141	00164142	00164143
UNC 3/8	16	8	70	24	7	5,5	00165150	00164151	00164152	00164153
UNC 7/16	14	9,4	70	24	8	6,2	00165160	00164161	00164162	00164163
UNC 1/2	13	10,8	75	28	9	7	00165170	00164171	00164172	00164173
UNC 9/16	12	12,3	80	30	11	9	00165180	00164181	00164182	00164183
UNC 5/8	11	13,5	80	32	12	9	00165190	00164191	00164192	00164193
UNC 3/4	10	16,5	95	34	14	11	00165210	00164211	00164212	00164213
UNC 7/8	9	19,5	100	34	18	14,5	00165230	00164231	00164232	00164233
UNC 1	8	22,3	110	38	18	14,5	00165250	00164251	00164252	00164253
UNC 1.1/8	7	25	125	45	22	18	00165260	00164261	00164262	00164263
UNC 1.1/4	7	28,3	125	45	22	18	00165270	00164271	00164272	00164273
UNC 1.3/8	6	30,8	150	56	28	22	00165280	00164281	00164282	00164283
UNC 1.1/2	6	34	150	56	28	22	00165290	00164291	00164292	00164293
UNC 1.5/8	5	37,1	150	60	32	24	00165300	00164301	00164302	00164303
UNC 1.3/4	5	39,5	160	65	36	29	00165310	00164311	00164312	00164313
UNC 1.7/8	4,5	42	180	70	36	29	00165320	00164321	00164322	00164323
UNC 2	4,5	45	180	70	40	32	00165330	00164331	00164332	00164333
UNC 2.1/4	4,5	51,5	200	75	45	35	00165340	00164341	00164342	00164343
UNC 2.1/2	4	57,2	220	80	50	39	00165350	00164351	00164352	00164353
UNC 2.3/4	4	63,25	240	80	50	39	00165360	00164361	00164362	00164363
UNC 3	4	69,85	260	85	50	39	00165370	00164371	00164372	00164373

GSR

HAND TAPS

TECHNICAL INFORMATION

Standard	ISO 529	Hole type	Through/blind hole
Thread	UNC	Direction	Right
Material	HSS-G	Tolerance	2B
Raw material	Steel		

						◇	Set	No. 1	No. 2	No. 3
UNC No. 1	64	1,5	32	7	2,5	2,1	00163010	00162011	00162012	00162013
UNC No. 2	56	1,8	36	8	2,8	2,1	00163020	00162021	00162022	00162023
UNC No. 3	48	2,1	45	10	2,8	2,24	00163030	00162031	00162032	00162033
UNC No. 4	40	2,3	48	15	3,15	2,5	00163040	00162041	00162042	00162043
UNC No. 5	40	2,6	48	15	3,15	2,5	00163050	00162051	00162052	00162053
UNC No. 6	32	2,9	50	17	3,55	2,8	00163060	00162061	00162062	00162063
UNC No. 8	32	3,5	53	13	4,5	3,55	00163080	00162081	00162082	00162083
UNC No. 10	24	3,9	58	16	5	4	00163100	00162101	00162102	00162103
UNC No. 12	24	4,5	62	17	5,6	4,5	00163120	00162121	00162122	00162123
UNC 1/4	20	5,2	66	19	6,3	5,0	00163130	00162131	00162132	00162133
UNC 5/16	18	6,6	72	22	8,0	6,3	00163140	00162141	00162142	00162143
UNC 3/8	16	8	80	24	10,0	8,0	00163150	00162151	00162152	00162153
UNC 7/16	14	9,4	85	25	8,0	6,3	00163160	00162161	00162162	00162163
UNC 1/2	13	10,8	89	29	9,0	7,1	00163170	00162171	00162172	00162173
UNC 9/16	12	12,3	95	30	11,2	9,0	00163180	00162181	00162182	00162183
UNC 5/8	11	13,5	102	32	12,5	10,0	00163190	00162191	00162192	00162193
UNC 3/4	10	16,5	112	37	14,0	11,2	00163210	00162211	00162212	00162213
UNC 7/8	9	19,5	118	38	16,0	12,5	00163230	00162231	00162232	00162233
UNC 1	8	22,3	130	45	18,0	14,0	00163250	00162251	00162252	00162253
UNC 1.1/8	7	25	138	48	20	16	00163260	00162261	00162262	00162263
UNC 1.1/4	7	28,3	151	51	22,4	18	00163270	00162271	00162272	00162273
UNC 1.1/2	6	34	170	60	28	22,4	00163290	00162291	00162292	00162293
UNC 1.3/4	5	39,5	187	67	31,5	25	00163310	00162311	00162312	00162313
UNC 2	4,5	45	200	70	35,5	28	00163330	00162331	00162332	00162333

HAND TAPS DIN 2184-2 / ISO 529

HAND TAPS LH

TECHNICAL INFORMATION

Standard	DIN 2184-2 (~ DIN 352)	Hole type	Through/blind hole
Thread	UNC	Direction	Left
Material	HSS-G	Tolerance	2B
Raw material	Steel		

						◇	Set	No. 1	No. 2	No. 3
UNC No. 1	64	1,5	36	8	2,8	2,1	00811010	00810011	00810012	00810013
UNC No. 2	56	1,8	36	9	2,8	2,1	00811020	00810021	00810022	00810023
UNC No. 3	48	2,1	40	9	2,8	2,1	00811030	00810031	00810032	00810033
UNC No. 4	40	2,3	40	11	3,5	2,7	00811040	00810041	00810042	00810043
UNC No. 5	40	2,6	40	11	3,5	2,7	00811050	00810051	00810052	00810053
UNC No. 6	32	2,9	45	12	4	3	00811060	00810061	00810062	00810063
UNC No. 8	32	3,5	45	13	4,5	3,4	00811080	00810081	00810082	00810083
UNC No. 10	24	3,9	50	16	6	4,9	00811100	00810101	00810102	00810103
UNC No. 12	24	4,5	56	17	6	4,9	00811120	00810121	00810122	00810123
UNC 1/4	20	5,2	56	19	6	4,9	00811130	00810131	00810132	00810133
UNC 5/16	18	6,6	63	22	6	4,9	00811140	00810141	00810142	00810143
UNC 3/8	16	8	70	24	7	5,5	00811150	00810151	00810152	00810153
UNC 7/16	14	9,4	70	24	8	6,2	00811160	00810161	00810162	00810163
UNC 1/2	13	10,8	75	28	9	7	00811170	00810171	00810172	00810173
UNC 9/16	12	12,3	80	30	11	9	00811180	00810181	00810182	00810183
UNC 5/8	11	13,5	80	32	12	9	00811190	00810191	00810192	00810193
UNC 3/4	10	16,5	95	34	14	11	00811210	00810211	00810212	00810213
UNC 7/8	9	19,5	100	34	18	14,5	00811230	00810231	00810232	00810233
UNC 1	8	22,3	110	38	18	14,5	00811250	00810251	00810252	00810253

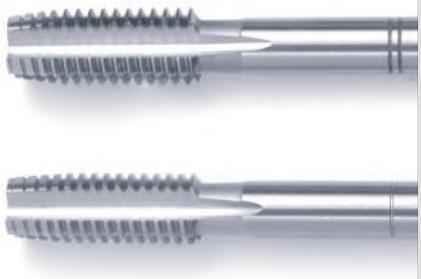
GSR

HAND TAPS

TECHNICAL INFORMATION

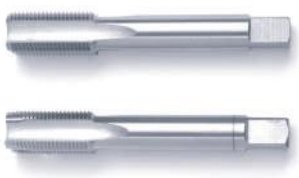
Standard	ISO 529	Hole type	Through/blind hole
Thread	UNC	Direction	Left
Material	HSS-G	Tolerance	2B
Raw material	Steel		

						◇	Set	No. 1	No. 2	No. 3
UNC No. 1	64	1,5	32	7	2,5	2,1	00169010	00168011	00168012	00168013
UNC No. 2	56	1,8	36	8	2,8	2,1	00169020	00168021	00168022	00168023
UNC No. 3	48	2,1	45	10	2,8	2,24	00169030	00168031	00168032	00168033
UNC No. 4	40	2,3	48	15	3,15	2,5	00169040	00168041	00168042	00168043
UNC No. 5	40	2,6	48	15	3,15	2,5	00169050	00168051	00168052	00168053
UNC No. 6	32	2,9	50	17	3,55	2,8	00169060	00168061	00168062	00168063
UNC No. 8	32	3,5	53	13	4,5	3,55	00169080	00168081	00168082	00168083
UNC No. 10	24	3,9	58	16	5	4	00169100	00168101	00168102	00168103
UNC No. 12	24	4,5	62	17	5,6	4,5	00169120	00168121	00168122	00168123
UNC 1/4	20	5,2	66	19	6,3	5,0	00169130	00168131	00168132	00168133
UNC 5/16	18	6,6	72	22	8,0	6,3	00169140	00168141	00168142	00168143
UNC 3/8	16	8	80	24	10,0	8,0	00169150	00168151	00168152	00168153
UNC 7/16	14	9,4	85	25	8,0	6,3	00169160	00168161	00168162	00168163
UNC 1/2	13	10,8	89	29	9,0	7,1	00169170	00168171	00168172	00168173
UNC 9/16	12	12,3	95	30	11,2	9,0	00169180	00168181	00168182	00168183
UNC 5/8	11	13,5	102	32	12,5	10,0	00169190	00168191	00168192	00168193
UNC 3/4	10	16,5	112	37	14,0	11,2	00169210	00168211	00168212	00168213
UNC 7/8	9	19,5	118	38	16,0	12,5	00169230	00168231	00168232	00168233
UNC 1	8	22,3	130	45	18,0	14,0	00169250	00168251	00168252	00168253



HAND TAPS DIN 2184-2 / ISO 529

HAND TAPS



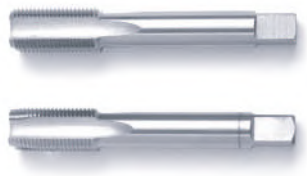
TECHNICAL INFORMATION

Standard	DIN 2184-2 (~ DIN 352)	Hole type	Through/blind hole
Thread	UNF	Direction	Right
Material	HSS-G	Tolerance	2B
Raw material	Steel		

							Set	No. 1	No. 2
UNF No. 0	80	1,25	32	8	2,5	2,1	00175000	00174001	00174003
UNF No. 1	72	1,55	36	8	2,8	2,1	00175010	00174011	00174013
UNF No. 2	64	1,85	36	9	2,8	2,1	00175020	00174021	00174023
UNF No. 3	56	2,1	40	9	2,8	2,1	00175030	00174031	00174033
UNF No. 4	48	2,4	40	11	3,5	2,7	00175040	00174041	00174043
UNF No. 5	44	2,7	40	11	3,5	2,7	00175050	00174051	00174053
UNF No. 6	40	3,0	45	12	4,0	3,0	00175060	00174061	00174063
UNF No. 8	36	3,5	45	13	4,5	3,4	00175080	00174081	00174083
UNF No. 10	32	4,1	50	16	6,0	4,9	00175100	00174101	00174103
UNF No. 12	28	4,65	56	17	6,0	4,9	00175120	00174121	00174123
UNF 1/4	28	5,5	56	19	6,0	4,9	00175130	00174131	00174133
UNF 5/16	24	6,9	63	22	6,0	4,9	00175140	00174141	00174143
UNF 3/8	24	8,5	63	20	7,0	5,5	00175150	00174151	00174153
UNF 7/16	20	9,9	70	24	8,0	6,2	00175160	00174161	00174163
UNF 1/2	20	11,5	70	22	9,0	7,0	00175170	00174171	00174173
UNF 9/16	18	13,0	70	22	11,0	9,0	00175180	00174181	00174183
UNF 5/8	18	14,5	70	22	12,0	9,0	00175190	00174191	00174193
UNF 3/4	16	17,5	80	22	14,0	11,0	00175210	00174211	00174213
UNF 7/8	14	20,5	80	22	18,0	14,5	00175230	00174231	00174233
UNF 1 (14)	14	23,3	90	22	18,0	14,5	00175250	00174251	00174253
UNF 1 (12)	12	23,3	90	22	18,0	14,5	00175260	00174261	00174263
UNF 1.1/8	12	26,5	90	22	22,0	18,0	00175270	00174271	00174273
UNF 1.1/4	12	29,5	90	22	22,0	18,0	00175280	00174281	00174283
UNF 1.3/8	12	32,5	125	40	28,0	22,0	00175290	00174291	00174293
UNF 1.1/2	12	36,0	125	40	28,0	22,0	00175300	00174301	00174303

GSR

HAND TAPS



TECHNICAL INFORMATION

Standard	ISO 529	Hole type	Through/blind hole
Thread	UNF	Direction	Right
Material	HSS-G	Tolerance	2B
Raw material	Steel		

						◇	Set	No. 1	No. 2
UNF No. 1	72	1,55	41	8	—	2	00173040	00172041	00172043
UNF No. 2	64	1,85	44,5	9,5	—	2,24	00173050	00172051	00172053
UNF No. 3	56	2,1	44,5	9,5	—	2,24	00173060	00172061	00172063
UNF No. 4	48	2,4	48	11	2,12	2,5	00173040	00172041	00172043
UNF No. 5	44	2,7	48	11	2,36	2,5	00173050	00172051	00172053
UNF No. 6	40	3	50	13	2,5	2,8	00173060	00172061	00172063
UNF No. 8	36	3,5	53	13	3,15	3,55	00173080	00172081	00172083
UNF No. 10	32	4,1	58	16	3,55	4	00173100	00172101	00172103
UNF No. 12	28	4,65	62	17	4,25	4,5	00173120	00172121	00172123
UNF 1/4	28	5,5	66	19	6,3	5,0	00173130	00172131	00172133
UNF 5/16	24	6,9	69	19	8,0	6,3	00173140	00172141	00172143
UNF 3/8	24	8,5	76	20	10,0	8,0	00173150	00172151	00172153
UNF 7/16	20	9,9	82	22	8,0	6,3	00173160	00172161	00172163
UNF 1/2	20	11,5	84	24	9,0	7,1	00173170	00172171	00172173
UNF 9/16	18	13,0	90	25	11,2	9,0	00173180	00172181	00172183
UNF 5/8	18	14,5	95	25	12,5	10,0	00173190	00172191	00172193
UNF 3/4	16	17,5	104	29	14,0	11,2	00173210	00172211	00172213
UNF 7/8	14	20,5	113	33	16,0	12,5	00173230	00172231	00172233
UNF 1 (14)	14	23,3	120	35	18,0	14,0	00173250	00172251	00172253
UNF 1 (12)	12	23,3	120	35	18,0	14,0	00173260	00172261	00172263
UNF 1.1/8	12	26,5	127	37	20,0	16,0	00173270	00172271	00172273
UNF 1.1/4	12	29,5	137	37	22,4	18,0	00173280	00172281	00172283
UNF 1.3/8	12	32,5	144	39	25,0	20,0	00173290	00172291	00172293
UNF 1.1/2	12	36,0	149	39	28,0	22,4	00173300	00172301	00172303

HAND TAPS DIN 2184-2 / ISO 529

HAND TAPS

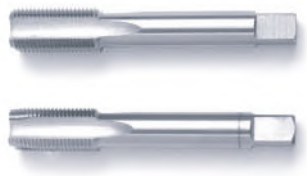
TECHNICAL INFORMATION

Standard	DIN 2184-2	Hole type	Through/blind hole
Thread	UNEF	Direction	Right
Material	HSS-G	Tolerance	2B
Raw material	Steel		

							Set	No. 1	No. 2
UNEF No. 12	32	4,7	56	17	6	4,9	00177010	00176011	00176013
UNEF 1/4	32	5,55	56	14	6,0	4,9	00177020	00176021	00176023
UNEF 5/16	32	7,15	56	18	6,0	4,9	00177030	00176031	00176033
UNEF 3/8	32	8,75	63	20	7,0	5,5	00177040	00176041	00176043
UNEF 7/16	28	10,2	63	20	8,0	6,2	00177050	00176051	00176053
UNEF 1/2	28	11,8	70	22	9,0	7,0	00177060	00176061	00176063
UNEF 9/16	24	13,2	70	22	11,0	9,0	00177070	00176071	00176073
UNEF 5/8	24	14,8	70	22	12,0	9,0	00177080	00176081	00176083
UNEF 11/16	24	16,4	80	22	14,0	11,0	00177090	00176091	00176093
UNEF 3/4	20	17,8	80	22	14,0	11,0	00177100	00176101	00176103
UNEF 13/16	20	19,4	80	22	16,0	12,0	00177110	00176111	00176113
UNEF 7/8	20	21	80	22	18,0	14,5	00177120	00176121	00176123
UNEF 15/16	20	22,5	90	22	18,0	14,5	00177130	00176131	00176133
UNEF 1	20	24,1	90	22	18,0	14,5	00177140	00176141	00176143
UNEF 1.1/16	18	25,6	90	22	20,0	16,0	00177150	00176151	00176153
UNEF 1.1/8	18	27,2	90	22	22,0	18,0	00177160	00176161	00176163
UNEF 1.3/16	18	28,8	90	22	22,0	18,0	00177170	00176171	00176173
UNEF 1.1/4	18	30,3	90	22	22,0	18,0	00177180	00176181	00176183
UNEF 1.5/16	18	31,9	100	25	28,0	22,0	00177190	00176191	00176193
UNEF 1.3/8	18	33,5	100	25	28,0	22,0	00177200	00176201	00176203
UNEF 1.7/16	18	35,1	100	25	28,0	22,0	00177210	00176211	00176213
UNEF 1.1/2	18	36,7	100	25	28,0	22,0	00177220	00176221	00176223
UNEF 1.9/16	18	38,3	100	25	32,0	24,0	00177230	00176231	00176233
UNEF 1.5/8	18	39,9	100	25	32,0	24,0	00177240	00176241	00176243
UNEF 1.11/16	18	41,5	100	25	36,0	29,0	00177250	00176251	00176253

GSR

HAND TAPS



TECHNICAL INFORMATION

Standard	ISO 529	Hole type	Through/blind hole
Thread	UNEF	Direction	Right
Material	HSS-G	Tolerance	2B
Raw material	Steel		

						◇	Set	No. 1	No. 2
UNEF No. 12	32	4,7	48	16	6,0	4,9	00179010	00178011	00178013
UNEF 1/4	32	5,55	48	16	6,0	4,9	00179020	00178021	00178023
UNEF 5/16	32	7,15	56	16	6,0	4,9	00179030	00178031	00178033
UNEF 3/8	32	8,75	63	18	7,0	5,5	00179040	00178041	00178043
UNEF 7/16	28	10,2	63	18	9,0	7,0	00179050	00178051	00178053
UNEF 1/2	28	11,8	70	20	9,0	7,0	00179060	00178061	00178063
UNEF 9/16	24	13,2	70	20	11,0	9,0	00179070	00178071	00178073
UNEF 5/8	24	14,8	70	20	12,0	9,0	00179080	00178081	00178083
UNEF 11/16	24	16,4	80	22	14,0	11,0	00179090	00178091	00178093
UNEF 3/4	20	17,8	80	22	14,0	11,0	00179100	00178101	00178103
UNEF 13/16	20	19,4	80	22	16,0	12,0	00179110	00178111	00178113
UNEF 7/8	20	21	80	22	18,0	14,5	00179120	00178121	00178123
UNEF 15/16	20	22,5	80	22	18,0	14,5	00179130	00178131	00178133
UNEF 1	20	24,1	90	22	20,0	16,0	00179140	00178141	00178143
UNEF 1.1/16	18	25,6	90	22	20,0	16,0	00179150	00178151	00178153
UNEF 1.1/8	18	27,2	90	22	22,0	18,0	00179160	00178161	00178163
UNEF 1.3/16	18	28,8	90	22	22,0	18,0	00179170	00178171	00178173
UNEF 1.1/4	18	30,3	90	22	25,0	20,0	00179180	00178181	00178183
UNEF 1.5/16	18	31,9	90	22	25,0	20,0	00179190	00178191	00178193
UNEF 1.3/8	18	33,5	100	25	28,0	22,0	00179200	00178201	00178203
UNEF 1.7/16	18	35,1	110	25	28,0	22,0	00179210	00178211	00178213
UNEF 1.1/2	18	36,7	110	25	32,0	24,0	00179220	00178221	00178223
UNEF 1.9/16	18	38,3	110	25	32,0	24,0	00179230	00178231	00178233
UNEF 1.5/8	18	39,9	110	25	32,0	24,0	00179240	00178241	00178243
UNEF 1.11/16	18	41,5	110	25	32,0	24,0	00179250	00178251	00178253

HAND TAPS DIN 2184-2

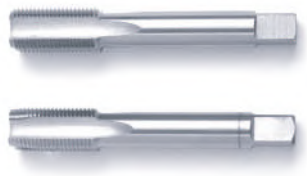
HAND TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-2 (~ DIN 352)	Hole type	Through/blind hole
Thread	UN / UNS	Direction	Right
Material	HSS-G	Tolerance	2B
Raw material	Steel		

							Set	No. 1	No. 2
UNS 1/4	40	5,7	56	14	6	4,9	00167010	00166011	00166013
UNS 1/4	36	5,65	56	14	6	4,9	00167020	00166021	00166023
UNS 1/4	24	5,3	56	19	6	4,9	00167030	00166031	00166033
UNS 7/16	24	10,1	63	20	8	6,2	00167040	00166041	00166043
UNS 1/2	24	11,65	70	22	9	7,0	00167050	00166051	00166053
UN 9/16	20	13,0	70	22	11	9,0	00167060	00166061	00166063
UN 11/16	20	16,2	80	22	14	11	00167070	00166071	00166073
UN 11/16	16	15,9	80	22	14	11	00167080	00166081	00166083
UNS 1	23,6	23,6	90	22	18	14,5	00167090	00166091	00166093
UN 1.1/16	12	24,9	90	22	20	16	00167100	00166101	00166103
UN 1.1/8	8	25,4	125	45	22	18	00167110	00166111	00166113
UN 1.3/16	12	28,1	90	22	22	18	00167120	00166121	00166123
UN 1.1/4	8	28,6	125	45	22	18	00167130	00166131	00166133
UN 1.5/16	12	31,3	125	40	28	22	00167140	00166141	00166143
UN 1.3/8	8	31,75	125	40	28	22	00167150	00166151	00166153
UN 1.1/2	8	34,9	125	40	25	22	00167160	00166161	00166163
UN 1.5/8	12	39,2	125	40	32	24	00167170	00166171	00166173
UN 1.5/8	8	38,1	125	40	32	24	00167180	00166181	00166183
UN 1.3/4	12	42,4	125	40	36	29	00167190	00166191	00166193
UN 1.3/4	8	41,3	125	40	36	29	00167200	00166201	00166203
UN 1.7/8	12	45,5	140	40	36	29	00167210	00166211	00166213
UN 1.7/8	8	44,5	140	40	36	29	00167220	00166221	00166223
UN 2	12	48,7	140	40	40	32	00167230	00166231	00166233
UN 2	8	47,7	140	40	40	32	00167240	00166241	00166243
UN 2.1/4	8	54,0	160	40	45	35	00167250	00166251	00166253
UN 2.1/2	8	60,3	180	56	50	39	00167260	00166261	00166263
UN 2.3/4	8	66,7	200	56	50	39	00167270	00166271	00166273
UN 3	8	73,0	220	60	50	39	00167280	00166281	00166283

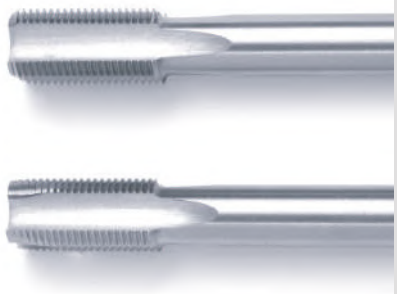
HAND TAPS



TECHNICAL INFORMATION

Standard	DIN 2184-2 (~ DIN40430)	Hole type	Through/blind hole
Thread	PG	Direction	Right
Material	HSS-G		
Raw Material	Steel		

						◇	Set	No. 1	No. 2
Pg 7	20	11,4	70	22	9	7	00191010	00190011	00190013
Pg 9	18	14,0	70	22	12	9	00191020	00190021	00190023
Pg 11	18	17,3	80	22	14	11	00191030	00190031	00190033
Pg 13,5	18	19,0	80	22	16	12	00191040	00190041	00190043
Pg 16	18	21,3	80	22	18	14,5	00191050	00190051	00190053
Pg 21	16	27,0	90	22	22	18	00191060	00190061	00190063
Pg 29	16	35,5	100	25	28	22	00191070	00190071	00190073
Pg 36	16	45,5	140	40	36	29	00191080	00190081	00190083
Pg 42	16	52,5	140	40	40	32	00191090	00190091	00190093
Pg 48	16	58,0	160	40	45	35	00191100	00190101	00190103



HAND TAPS DIN 2184-2 / FACTORY STANDARD

HAND TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-2	Hole type	Through/blind hole
Thread	NPT	Direction	Right
Material	HSS-G		
Raw material	Steel		

							Set	No. 1	No. 2
NPT 1/16	27	6,25	55	13	7,0	5,5	00181010	00180011	00180013
NPT 1/8	27	8,5	63	15	7,0	5,5	00181020	00180021	00180023
NPT 1/4	18	11,1	63	21	11,0	9,0	00181030	00180031	00180033
NPT 3/8	18	14,7	70	21	12,0	9,0	00181040	00180041	00180043
NPT 1/2	14	18,0	80	27	16,0	12,0	00181050	00180051	00180053
NPT 3/4	14	23,3	100	27	20,0	16,0	00181060	00180061	00180063
NPT 1	11,5	29,3	110	32	25,0	20,0	00181070	00180071	00180073
NPT 1.1/4	11,5	38,0	125	33	32,0	24,0	00181080	00180081	00180083
NPT 1.1/2	11,5	44,3	140	33	36,0	29,0	00181090	00180091	00180093
NPT 2	11,5	56,3	160	33	36,0	29,0	00181100	00180101	00180103
NPT 2.1/2	8	66,5	180	75	45,0	35,0	00181110	00180111	00180113
NPT 3	8	82,5	200	75	50,0	39,0	00181120	00180121	00180123
NPT 3.1/2	8	95	220	75	63,0	49,0	00181130	00180131	00180133
NPT 4	8	107,7	240	75	70,0	55,0	00181140	00180141	00180143

GSR

HAND TAPS

TECHNICAL INFORMATION

Standard	Factory Standard	Hole type	Through hole < 3 x d
Thread	Tr	Direction	Right
Material	HSS-G	Tolerance	ISO3 / 7H
Raw material	Steel		

						◇	Set	No. 1	No. 2	No. 3
Tr 10×2*	2	8,0	90	33	7,0	5,5	00193010	00192011	—	00192013
Tr 10×3	3	7,0	100	40	7,0	5,5	00193020	00192021	00192022	00192023
Tr 12×2*	2	10,0	110	35	8,0	6,2	00193030	00192031	—	00192033
Tr 12×3	3	9,0	110	42	8,0	6,2	00193040	00192041	00192042	00192043
Tr 14×2*	2	12,0	120	36	10,0	8,0	00193050	00192051	—	00192053
Tr 14×3	3	11,0	130	43	10,0	8,0	00193060	00192061	00192062	00192063
Tr 14×4	4	10,0	130	54	10,0	8,0	00193070	00192071	00192072	00192073
Tr 16×2*	2	14,0	125	38	11,0	9,0	00193080	00192081	—	00192083
Tr 16×4	4	12,0	140	56	11,0	9,0	00193090	00192091	00192092	00192093
Tr 18×2*	2	16,0	135	40	12,0	9,0	00193100	00192101	—	00192103
Tr 18×4	4	14,0	150	58	12,0	9,0	00193110	00192111	00192112	00192113
Tr 20×2*	2	18,0	145	42	14,0	11,0	00193120	00192121	—	00192123
Tr 20×4	4	16,0	160	60	14,0	11,0	00193130	00192131	00192132	00192133
Tr 22×5	5	17,0	175	72	16,0	12,0	00193140	00192141	00192142	00192143
Tr 24×3*	3	21,0	170	52	18,0	14,5	00193150	00192151	—	00192153
Tr 24×5	5	19,0	190	74	18,0	14,5	00193160	00192161	00192162	00192163
Tr 26×5	5	21,0	210	76	20,0	16,0	00193170	00192171	00192172	00192173
Tr 28×5	5	23,0	220	78	22,0	18,0	00193180	00192181	00192182	00192183
Tr 30×3*	3	27,0	210	57	22,0	18,0	00193190	00192191	—	00192193
Tr 30×6	6	24,0	240	90	22,0	18,0	00193200	00192201	00192202	00192203
Tr 32×6	6	26,0	255	92	25,0	20,0	00193210	00192211	00192212	00192213
Tr 36×3*	3	33,0	240	68	28,0	22,0	00193220	00192221	—	00192223
Tr 36×6	6	30,0	280	96	28,0	22,0	00193230	00192231	00192232	00192233
Tr 40×7	7	33,0	310	107	32,0	24,0	00193240	00192241	00192242	00192243

* 2-pcs. set

HAND TAPS FACTORY STANDARD

HAND TAPS

TECHNICAL INFORMATION

Standard	Factory Standard	Hole type	Through hole < 3 x d
Thread	Tr	Direction	Right
Material	HSSE-G	Tolerance	ISO3 / 7H
Raw material	Steel		

						◇	Set	No. 1	No. 2	No. 3
Tr 10×2*	2	8,0	90	33	7,0	5,5	00183010	00182011	—	00182013
Tr 10×3	3	7,0	100	40	7,0	5,5	00183020	00182021	00182022	00182023
Tr 12×2*	2	10,0	110	35	8,0	6,2	00183030	00182031	—	00182033
Tr 12×3	3	9,0	110	42	8,0	6,2	00183040	00182041	00182042	00182043
Tr 14×2*	2	12,0	120	36	10,0	8,0	00183050	00182051	—	00182053
Tr 14×3	3	11,0	130	43	10,0	8,0	00183060	00182061	00182062	00182063
Tr 14×4	4	10,0	130	54	10,0	8,0	00183070	00182071	00182072	00182073
Tr 16×2*	2	14,0	125	38	11,0	9,0	00183080	00182081	—	00182083
Tr 16×4	4	12,0	140	56	11,0	9,0	00183090	00182091	00182092	00182093
Tr 18×2*	2	16,0	135	40	12,0	9,0	00183100	00182101	—	00182103
Tr 18×4	4	14,0	150	58	12,0	9,0	00183110	00182111	00182112	00182113
Tr 20×2*	2	18,0	145	42	14,0	11,0	00183120	00182121	—	00182123
Tr 20×4	4	16,0	160	60	14,0	11,0	00183130	00182131	00182132	00182133
Tr 22×5	5	17,0	175	72	16,0	12,0	00183140	00182141	00182142	00182143
Tr 24×3*	3	21,0	170	52	18,0	14,5	00183150	00182151	—	00182153
Tr 24×5	5	19,0	190	74	18,0	14,5	00183160	00182161	00182162	00182163
Tr 26×5	5	21,0	210	76	20,0	16,0	00183170	00182171	00182172	00182173
Tr 28×5	5	23,0	220	78	22,0	18,0	00183180	00182181	00182182	00182183
Tr 30×3*	3	27,0	210	57	22,0	18,0	00183190	00182191	—	00182193
Tr 30×6	6	24,0	240	90	22,0	18,0	00183200	00182201	00182202	00182203
Tr 32×6	6	26,0	255	92	25,0	20,0	00183210	00182211	00182212	00182213
Tr 36×3*	3	33,0	240	68	28,0	22,0	00183220	00182221	—	00182223
Tr 36×6	6	30,0	280	96	28,0	22,0	00183230	00182231	00182232	00182233
Tr 40×7	7	33,0	310	107	32,0	24,0	00183240	00182241	00182242	00182243

* 2-pcs. Set

GSR

HAND TAPS LH

TECHNICAL INFORMATION

Standard	Factory Standard	Hole type	Through hole < 3 x d
Thread	Tr	Direction	Left
Material	HSSE-G	Tolerance	ISO3 / 7H
Raw material	Steel		

						◇	Set	No. 1	No. 2	No. 3
Tr 10×2*	2	8,0	90	33	7,0	5,5	00189010	00188011	—	00188013
Tr 10×3	3	7,0	100	40	7,0	5,5	00189020	00188021	00188022	00188023
Tr 12×2*	2	10,	110	35	8,0	6,2	00189030	00188031	—	00188033
Tr 12×3	3	9,0	110	42	8,0	6,2	00189040	00188041	00188042	00188043
Tr 14×2*	2	12,0	120	36	10,0	8,0	00189050	00188051	—	00188053
Tr 14×3	3	11,0	130	43	10,0	8,0	00189060	00188061	00188062	00188063
Tr 14×4	4	10,0	130	54	10,0	8,0	00189070	00188071	00188072	00188073
Tr 16×2*	2	14,0	125	38	11,0	9,0	00189080	00188081	—	00188083
Tr 16×4	4	12,0	140	56	11,0	9,0	00189090	00188091	00188092	00188093
Tr 18×2*	2	16,0	135	40	12,0	9,0	00189100	00188101	—	00188103
Tr 18×4	4	14,0	150	58	12,0	9,0	00189110	00188111	00188112	00188113
Tr 20×2*	2	18,0	145	42	14,0	11,0	00189120	00188121	—	00188123
Tr 20×4	4	16,0	160	60	14,0	11,0	00189130	00188131	00188132	00188133
Tr 22×5	5	17,0	175	72	16,0	12,0	00189140	00188141	00188142	00188143
Tr 24×3*	3	21,0	170	52	18,0	14,5	00189150	00188151	—	00188153
Tr 24×5	5	19,0	190	74	18,0	14,5	00189160	00188161	00188162	00188163
Tr 26×5	5	21,0	210	76	20,0	16,0	00189170	00188171	00188172	00188173
Tr 28×5	5	23,0	220	78	22,0	18,0	00189180	00188181	00188182	00188183
Tr 30×3*	3	27,0	210	57	22,0	18,0	00189190	00188191	—	00188193
Tr 30×6	6	24,0	240	90	22,0	18,0	00189200	00188201	00188202	00188203
Tr 32×6	6	26,0	255	92	25,0	20,0	00189210	00188211	00188212	00188213
Tr 36×3*	3	33,0	240	68	28,0	22,0	00189220	00188221	—	00188223
Tr 36×6	6	30,0	280	96	28,0	22,0	00189230	00188231	00188232	00188233
Tr 40×7	7	33,0	310	107	32,0	24,0	00189240	00188241	00188242	00188243

* 2-pcs. set

SHORT MACHINE TAPS

DIN 352

FORM B

3,5-5 threads,
medium chamfer
with spiral point for
through holes

SQUARE SHANK ACCORDING TO DIN 10

for mounting the tap into the
adjustable tap wrench (ATW).

FORM A

6-8 threads,
long chamfer for
through holes

FORM C

2-3 threads,
short chamfer, for through
and blind holes

The tap for ISO metric coarse thread has a reinforced shank and three flutes for the sizes M1 to M6. For sizes M7 and larger, the tap has a reduced shank and four flutes.

TAPS
DIN 352 · B · M8 · 6H · HSS

	Description
DIN 352 =	German Institute for Standardisation
B =	3,5-5 threads, straight fluted with spiral point for through holes
M8 =	Nominal size for ISO metric coarse threads
6H =	Tolerance class according to DIN 802, part 1
HSS =	High-speed steel

DIN 352

CHUCK
WITH LEVEL VIAL
HEXAGON
SHORT MACHINE
TAP BIT
according to factory standard for ISO metric coarse threads M3 to M10 with ¼"-shank, suitable for holders according to DIN 3126 up to 3,3 for manual and machine usage.
FORM B
medium chamfer, 3,5-5 threads
MAGNETIC BIT HOLDER

SHORT MACHINE TAPS DIN 352

SHORT MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 352	Hole type	Through hole < 1×d
Thread	M	Direction	Right
Material	HSS-G	Tolerance	6H
Raw material	Steel	Form	Form A

Hand tap, single bottoming tap for manual and machine usage, 5-6 thread chamfer

							Art.-No.
M 3	0,5	2,5	40	11	3,5	2,7	00202130
M 4	0,7	3,3	45	13	4,5	3,4	00202150
M 5	0,8	4,2	50	16	6,0	4,2	00202170
M 6	1,0	5,0	56	19	6,0	4,9	00202190
M 8	1,25	6,8	63	22	6,0	6,8	00202210
M 10	1,5	8,5	70	24	7,0	8,5	00202230
M 12	1,75	10,2	75	28	9,0	7,0	00202250
M 14	2,0	12,0	80	30	11,0	9,0	00202260
M 16	2,0	14,0	80	32	12,0	9,0	00202270
M 18	2,5	15,5	95	34	14,0	11,0	00202280
M 20	2,5	17,5	95	34	16,0	12,0	00202290
M 22	2,5	19,5	100	34	18,0	14,5	00202300
M 24	3,0	21,0	110	38	18,0	14,5	00202310

SHORT MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 352	Hole type	Through hole 1.1/2xd
Thread	M	Direction	Right
Material	HSS-G	Tolerance	6H
Raw material	Steel	Form	Form B

Hand tap, single bottoming tap for manual and machine usage, 4-5 thread chamfer

							Art.-No.
M 3	0,5	2,5	40	11	3,5	2,7	00204130
M 4	0,7	3,3	45	13	4,5	3,4	00204150
M 5	0,8	4,2	50	16	6,0	4,2	00204170
M 6	1,0	5,0	56	19	6,0	4,9	00204190
M 7	1,0	6,0	56	19	6,0	6,0	00204200
M 8	1,25	6,8	63	22	6,0	6,8	00204210
M 10	1,5	8,5	70	24	7,0	8,5	00204230
M 12	1,75	10,2	75	28	9,0	7,0	00204250

GSR

						◇	Art.-No.
M 14	2,0	12,0	80	30	11,0	9,0	00204260
M 16	2,0	14,0	80	32	12,0	9,0	00204270
M 18	2,5	15,5	95	34	14,0	11,0	00204280
M 20	2,5	17,5	95	34	16,0	12,0	00204290
M 22	2,5	19,5	100	34	18,0	14,5	00204300
M 24	3,0	21,0	110	38	18,0	14,5	00204310
M 27	3,0	24,0	110	38	20,0	16,0	00204320
M 30	3,5	26,5	125	45	22,0	18,0	00204330
M 33	3,5	29,5	125	50	25,0	20,0	00204340
M 36	4,0	32,0	150	56	28,0	22,0	00204350
M 39	4,0	35,0	150	60	32,0	24,0	00204360
M 42	4,5	37,5	150	60	32,0	24,0	00204370
M 45	4,5	40,5	160	65	36,0	29,0	00204380
M 48	5,0	43,0	180	70	36,0	29,0	00204390
M 52	5,0	47,0	180	70	40,0	32,0	00204400
M 56	5,5	51,5	180	70	40,0	32,0	00204410
M 60	5,5	54,5	200	75	45,0	35,0	00204420
M 64	6,0	58,0	220	80	50,0	39,0	00204430
M 68	6,0	62,0	220	80	50,0	39,0	00204440
M 72	6,0	66,0	240	80	50,0	39,0	00204450
M 76	6,0	70,0	240	80	50,0	39,0	00204460
M 80	6,0	74,0	260	85	50,0	39,0	00204470
M 84	6,0	78,0	260	85	50,0	39,0	00204480
M 88	6,0	82,0	260	85	50,0	39,0	00204490
M 90	6,0	84,0	260	85	50,0	39,0	00204500
M 92	6,0	86,0	280	90	56,0	44,0	00204510
M 96	6,0	90,0	280	90	56,0	44,0	00204520
M 100	6,0	94,0	300	90	56,0	44,0	00204530

SHORT MACHINE TAPS DIN 352

SHORT MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 352	Hole type	Through/blind hole <1.1/2xd
Thread	M	Direction	Right
Material	HSS-G	Tolerance	6H
Raw material	Steel	Form	Form C

Hand tap, single bottoming tap for manual and machine usage, 2-3 thread chamfer

						◇	Art.-No.
M 3	0,5	2,5	40	11	3,5	2,7	00205130
M 4	0,7	3,3	45	13	4,5	3,4	00205150
M 5	0,8	4,2	50	16	6,0	4,2	00205170
M 6	1,0	5,0	56	19	6,0	4,9	00205190
M 7	1,0	6,0	56	19	6,0	6,0	00205200
M 8	1,25	6,8	63	22	6,0	6,8	00205210
M 10	1,5	8,5	70	24	7,0	8,5	00205230
M 12	1,75	10,2	75	28	9,0	7,0	00205250
M 14	2,0	12,0	80	30	11,0	9,0	00205260
M 16	2,0	14,0	80	32	12,0	9,0	00205270
M 18	2,5	15,5	95	34	14,0	11,0	00205280
M 20	2,5	17,5	95	34	16,0	12,0	00205290
M 22	2,5	19,5	100	34	18,0	14,5	00205300
M 24	3,0	21,0	110	38	18,0	14,5	00205310
M 27	3,0	24,0	110	38	20,0	16,0	00205320
M 30	3,5	26,5	125	45	22,0	18,0	00205330
M 33	3,5	29,5	125	50	25,0	20,0	00205340
M 36	4,0	32,0	150	56	28,0	22,0	00205350
M 39	4,0	35,0	150	60	32,0	24,0	00205360
M 42	4,5	37,5	150	60	32,0	24,0	00205370
M 45	4,5	40,5	160	65	36,0	29,0	00205380
M 48	5,0	43,0	180	70	36,0	29,0	00205390
M 52	5,0	47,0	180	70	40,0	32,0	00205400
M 56	5,5	51,5	180	70	40,0	32,0	00205410
M 60	5,5	54,5	200	75	45,0	35,0	00205420
M 64	6,0	58,0	220	80	50,0	39,0	00205430
M 68	6,0	62,0	220	80	50,0	39,0	00205440
M 72	6,0	66,0	240	80	50,0	39,0	00205450
M 76	6,0	70,0	240	80	50,0	39,0	00205460
M 80	6,0	74,0	260	85	50,0	39,0	00205470
M 84	6,0	78,0	260	85	50,0	39,0	00205480
M 88	6,0	82,0	260	85	50,0	39,0	00205490
M 90	6,0	84,0	260	85	50,0	39,0	00205500
M 92	6,0	86,0	280	90	56,0	44,0	00205510
M 96	6,0	90,0	280	90	56,0	44,0	00205520
M 100	6,0	94,0	300	90	56,0	44,0	00205530

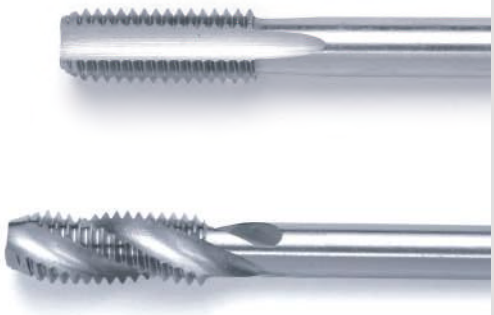
SHORT MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 352	Hole type	Blind hole <1.1/2×d
Thread	M	Direction	Right
Material	HSS-G	Tolerance	6H
Raw material	Steel	Form	Form C/RSP 35°

Hand tap, single bottoming tap with 5-6 thread chamfer, right spiral flute

							Art.-No.
M 3	0,5	2,5	40	11	3,5	2,7	00219130
M 4	0,7	3,3	45	13	4,5	3,4	00219150
M 5	0,8	4,2	50	16	6,0	4,2	00219170
M 6	1,0	5,0	56	19	6,0	4,9	00219190
M 8	1,25	6,8	63	22	6,0	6,8	00219210
M 10	1,5	8,5	70	24	7,0	8,5	00219230
M 12	1,75	10,2	75	28	9,0	7,0	00219250
M 14	2,0	12,0	80	30	11,0	9,0	00219260
M 16	2,0	14,0	80	32	12,0	9,0	00219270
M 18	2,5	15,5	95	34	14,0	11,0	00219280
M 20	2,5	17,5	95	34	16,0	12,0	00219290
M 22	2,5	19,5	100	34	18,0	14,5	00219300
M 24	3,0	21,0	110	38	18,0	14,5	00219310



SHORT MACHINE TAPS DIN 352

SHORT MACHINE TAPS

Hand tap, single bottoming tap with 4-5 thread chamfer and spiral point

TECHNICAL INFORMATION

Standard	DIN 352	Hole type	Through hole <1.1/2×d
Thread	M	Direction	Right
Material	HSSE-G	Tolerance	6H
Raw material	Stainless steel	Form	Form B

							Art.-No.
M 3	0,5	2,5	40	11	3,5	2,7	00206130
M 4	0,7	3,3	45	13	4,5	3,4	00206150
M 5	0,8	4,2	50	16	6,0	4,2	00206170
M 6	1,0	5,0	56	19	6,0	4,9	00206190
M 8	1,25	6,8	63	22	6,0	6,8	00206210
M 10	1,5	8,5	70	24	7,0	8,5	00206230
M 12	1,75	10,2	75	28	9,0	7,0	00206250
M 14	2,0	12,0	80	30	11,0	9,0	00206260
M 16	2,0	14,0	80	32	12,0	9,0	00206270
M 18	2,5	15,5	95	34	14,0	11,0	00206280
M 20	2,5	17,5	95	34	16,0	12,0	00206290
M 22	2,5	19,5	100	34	18,0	14,5	00206300
M 24	3,0	21,0	110	38	18,0	14,5	00206310

SHORT MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 352	Hole type	Through hole <1.1/2×d
Thread	M	Direction	Right
Material	HSS-G	Tolerance	6H
Raw material	Bronze, copper, aluminium	Form	Form B/AZ

Hand tap, single bottoming tap with 4-5 thread chamfer and spiral point with interrupted threads

							Art.-No.
M 3	0,5	2,5	40	11	3,5	2,7	00208130
M 4	0,7	3,3	45	13	4,5	3,4	00208150
M 5	0,8	4,2	50	16	6,0	4,2	00208170
M 6	1,0	5,0	56	19	6,0	4,9	00208190
M 8	1,25	6,8	63	22	6,0	6,8	00208210
M 10	1,5	8,5	70	24	7,0	8,5	00208230
M 12	1,75	10,2	75	28	9,0	7,0	00208250
M 14	2,0	12,0	80	30	11,0	9,0	00208260
M 16	2,0	14,0	80	32	12,0	9,0	00208270
M 18	2,5	15,5	95	34	14,0	11,0	00208280
M 20	2,5	17,5	95	34	16,0	12,0	00208290
M 22	2,5	19,5	100	34	18,0	14,5	00208300
M 24	3,0	21,0	110	38	18,0	14,5	00208310

SHORT MACHINE TAPS DIN 2181

SHORT MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2181	Hole type	Through/blind hole <1.1/2×d
Thread	MF	Direction	Right
Material	HSS-G	Tolerance	6H
Raw material	Steel	Form	Form C

Hand tap, single bottoming tap for manual and machine usage, 2-3 thread chamfer

						◇	Art.-No.
MF 3 × 0,35	0,35	2,65	36	10	3,5	2,7	00220200
MF 3,5 × 0,35	0,35	3,15	36	10	4,0	3,0	00220220
MF 4 × 0,35	0,35	3,65	36	10	4,5	3,4	00220230
MF 4 × 0,5	0,5	3,5	40	12	4,5	3,4	00220240
MF 4,5 × 0,35	0,35	4,15	40	12	4,5	3,4	00220250
MF 4,5 × 0,5	0,5	4,0	40	12	4,5	3,4	00220260
MF 5 × 0,5	0,5	4,5	45	14	6,0	4,9	00220280
MF 5 × 0,75	0,75	4,25	48	16	6,0	4,9	00220290
MF 5,5 × 0,5	0,5	5,0	48	16	6,0	4,9	00220300
MF 5,5 × 0,75	0,75	4,75	48	16	6,0	4,9	00220310
MF 6 × 0,5	0,5	5,5	45	14	6,0	4,9	00220320
MF 6 × 0,75	0,75	5,25	48	16	6,0	4,9	00220330
MF 7 × 0,5	0,5	6,5	48	16	6,0	4,9	00220350
MF 7 × 0,75	0,75	6,25	48	16	6,0	4,9	00220360
MF 8 × 0,5	0,5	7,5	50	14	6,0	4,9	00220380
MF 8 × 0,75	0,75	7,25	50	16	6,0	4,9	00220390
MF 8 × 1	1,0	7,0	56	18	6,0	4,9	00220400
MF 8 × 1,5	1,5	6,5	56	22	6,0	4,9	00220410
MF 9 × 0,5	0,5	8,5	56	18	7,0	5,5	00220420
MF 9 × 0,75	0,75	8,25	56	18	7,0	5,5	00220430
MF 9 × 1	1,0	8,0	56	18	7,0	5,5	00220440
MF 10 × 0,5	0,5	9,5	50	14	7,0	5,5	00220450
MF 10 × 0,75	0,75	9,25	56	16	7,0	5,5	00220460
MF 10 × 1	1,0	9,0	63	18	7,0	5,5	00220470
MF 10 × 1,25	1,25	8,8	63	18	7,0	5,5	00220480
MF 11 × 0,5	0,5	10,5	63	18	8,0	6,2	00220490
MF 11 × 0,75	0,75	10,25	63	18	8,0	6,2	00220500
MF 11 × 1	1,0	10,0	63	18	8,0	6,2	00220510
MF 11 × 1,25	1,25	9,75	63	18	8,0	6,2	00220520
MF 12 × 0,5	0,5	11,5	63	16	9,0	7,0	00220530
MF 12 × 0,75	0,75	11,25	63	16	9,0	7,0	00220540
MF 12 × 1	1,0	11,0	63	20	9,0	7,0	00220550
MF 12 × 1,25	1,25	10,8	63	20	9,0	7,0	00220560
MF 12 × 1,5	1,5	10,5	70	20	9,0	7,0	00220570
MF 13 × 0,5	0,5	12,5	63	20	11,0	9,0	00220580
MF 13 × 0,75	0,75	12,25	63	20	11,0	9,0	00220590

GSR

						◇	Art.-No.
MF 13 × 1	1,0	12,0	63	20	11,0	9,0	00220600
MF 13 × 1,25	1,25	11,75	70	20	11,0	9,0	00220610
MF 13 × 1,5	1,5	11,5	70	20	11,0	9,0	00220620
MF 14 × 0,5	0,5	13,5	70	16	11,0	9,0	00220630
MF 14 × 0,75	0,75	13,25	70	16	11,0	9,0	00220640
MF 14 × 1	1,0	13,0	70	20	11,0	9,0	00220650
MF 14 × 1,25	1,25	12,8	70	20	11,0	9,0	00220660
MF 14 × 1,5	1,5	12,5	70	20	11,0	9,0	00220670
MF 15 × 0,5	0,5	14,5	70	20	12,0	9,0	00220680
MF 15 × 0,75	0,75	14,25	70	20	12,0	9,0	00220690
MF 15 × 1	1,0	14,0	70	20	12,0	9,0	00220700
MF 15 × 1,25	1,25	13,8	70	20	12,0	9,0	00220710
MF 15 × 1,5	1,5	13,5	70	20	12,0	9,0	00220720
MF 16 × 0,5	0,5	15,5	70	20	12,0	9,0	00220730
MF 16 × 0,75	0,75	15,25	70	20	12,0	9,0	00220740
MF 16 × 1	1,0	15,0	70	20	12,0	9,0	00220750
MF 16 × 1,25	1,25	14,75	70	20	12,0	9,0	00220760
MF 16 × 1,5	1,5	14,5	70	20	12,0	9,0	00220770
MF 17 × 0,75	0,75	16,25	70	20	12,0	9,0	00220780
MF 17 × 1	1,0	16,0	70	20	12,0	9,0	00220790
MF 17 × 1,5	1,5	15,5	70	20	12,0	9,0	00220800
MF 18 × 0,5	0,5	17,5	80	22	14,0	11,0	00220820
MF 18 × 0,75	0,75	17,25	80	22	14,0	11,0	00220830
MF 18 × 1	1,0	17,0	80	22	14,0	11,0	00220840
MF 18 × 1,25	1,25	16,75	80	22	14,0	11,0	00220850
MF 18 × 1,5	1,5	16,5	80	22	14,0	11,0	00220860
MF 18 × 2	2,0	16,0	90	25	14,0	11,0	00220870
MF 19 × 1	1,0	18,0	80	22	14,0	11,0	00220880
MF 19 × 1,5	1,5	17,5	80	22	14,0	11,0	00220900
MF 20 × 0,5	0,5	19,5	80	22	16,0	12,0	00220910
MF 20 × 0,75	0,75	19,25	80	22	16,0	12,0	00220920
MF 20 × 1	1,0	19,0	80	22	16,0	12,0	00220930
MF 20 × 1,25	1,25	18,75	80	22	16,0	12,0	00220940
MF 20 × 1,5	1,5	18,5	80	22	16,0	12,0	00220950
MF 20 × 2	2,0	18,0	90	25	16,0	12,0	00220960
MF 21 × 1	1,0	20,0	80	22	16,0	12,0	00220980
MF 21 × 1,5	1,5	19,5	80	22	16,0	12,0	00221000
MF 22 × 0,5	0,5	21,5	80	22	18,0	14,5	00221010
MF 22 × 0,75	0,75	21,25	80	22	18,0	14,5	00221020
MF 22 × 1	1,0	21,0	80	22	18,0	14,5	00221030
MF 22 × 1,25	1,25	20,75	80	22	18,0	14,5	00221040
MF 22 × 1,5	1,5	20,5	80	22	18,0	14,5	00221050
MF 22 × 2	2,0	20,0	90	25	18,0	14,5	00221060
MF 23 × 1	1,0	22,0	80	22	18,0	14,5	00221070

SHORT MACHINE TAPS DIN 2181

						◇	Art.-No.
MF 23 × 1,5	1,5	21,5	80	22	18,0	14,5	00221080
MF 24 × 0,5	0,5	23,5	80	22	18,0	14,5	00221090
MF 24 × 0,75	0,75	23,25	80	22	18,0	14,5	00221100
MF 24 × 1	1,0	23,0	80	22	18,0	14,5	00221110
MF 24 × 1,25	1,25	22,75	80	22	18,0	14,5	00221120
MF 24 × 1,5	1,5	22,5	80	22	18,0	14,5	00221130
MF 24 × 2	2,0	22,0	90	25	18,0	14,5	00221140
MF 25 × 1	1,0	24,0	90	22	18,0	14,5	00221150
MF 25 × 1,5	1,5	23,5	90	22	18,0	14,5	00221170
MF 25 × 2	2,0	23,0	100	28	18,0	14,5	00221180
MF 26 × 1	1,0	25,0	90	22	18,0	14,5	00221190
MF 26 × 1,25	1,25	24,75	90	22	18,0	14,5	00221200
MF 26 × 1,5	1,5	24,5	90	22	18,0	14,5	00221210
MF 26 × 2	2,0	24,0	100	28	18,0	14,5	00221220
MF 27 × 1	1,0	26,0	90	22	20,0	16,0	00221230
MF 27 × 1,5	1,5	25,5	90	22	20,0	16,0	00221240
MF 27 × 2	2,0	25,0	100	28	20,0	16,0	00221250
MF 28 × 1	1,0	27,0	90	22	20,0	16,0	00221260
MF 28 × 1,5	1,5	26,5	90	22	20,0	16,0	00221270
MF 28 × 2	2,0	26,0	100	28	20,0	16,0	00221280
MF 30 × 1	1,0	29,0	90	22	22,0	18,0	00221290
MF 30 × 1,5	1,5	28,5	90	22	22,0	18,0	00221300
MF 30 × 2	2,0	28,0	100	28	22,0	18,0	00221310
MF 30 × 3	3,0	27,0	110	32	22,0	18,0	00221320
MF 32 × 1	1,0	31,0	90	22	22,0	18,0	00221330
MF 32 × 1,5	1,5	30,5	90	22	22,0	18,0	00221340
MF 32 × 2	2,0	30,0	100	28	22,0	18,0	00221350
MF 32 × 3	3,0	29,0	125	36	22,0	18,0	00221360
MF 33 × 1	1,0	32,0	100	25	25,0	20,0	00221370
MF 33 × 1,5	1,5	31,5	100	25	25,0	20,0	00221380
MF 33 × 2	2,0	31,0	110	32	25,0	20,0	00221390
MF 33 × 3	3,0	30,0	125	36	25,0	20,0	00221400
MF 34 × 1	1,0	33,0	100	25	28,0	22,0	00221410
MF 34 × 1,5	1,5	32,5	100	25	28,0	22,0	00221420
MF 34 × 2	2,0	32,0	110	32	28,0	22,0	00221430
MF 34 × 3	3,0	31,0	125	36	28,0	22,0	00221440
MF 35 × 1	1,0	34,0	100	25	28,0	22,0	00221450
MF 35 × 1,5	1,5	33,5	100	25	28,0	22,0	00221460
MF 35 × 2	2,0	33,0	110	32	28,0	22,0	00221470
MF 35 × 3	3,0	32,0	125	36	28,0	22,0	00221480
MF 36 × 1	1,0	35,0	100	25	28,0	22,0	00221490
MF 36 × 1,5	1,5	34,5	100	25	28,0	22,0	00221500
MF 36 × 2	2,0	34,0	110	32	28,0	22,0	00221510
MF 36 × 3	3,0	33,0	125	36	28,0	22,0	00221520

GSR

						◇	Art.-No.
MF 38 × 1	1,0	37,0	110	25	28,0	22,0	00221530
MF 38 × 1,5	1,5	36,5	110	25	28,0	22,0	00221540
MF 38 × 2	2,0	36,0	125	32	28,0	22,0	00221550
MF 38 × 3	3,0	35,0	125	36	28,0	22,0	00221560
MF 39 × 1,5	1,5	37,5	110	25	32,0	24,0	00221570
MF 39 × 2	2,0	37,0	125	32	32,0	24,0	00221580
MF 39 × 3	3,0	36,0	125	36	32,0	24,0	00221590
MF 40 × 1	1,0	39,0	110	25	32,0	24,0	00221600
MF 40 × 1,5	1,5	38,5	110	25	32,0	24,0	00221610
MF 40 × 2	2,0	38,0	125	32	32,0	24,0	00221620
MF 40 × 3	3,0	37,0	125	36	32,0	24,0	00221630
MF 42 × 1,5	1,5	40,5	110	25	32,0	24,0	00221640
MF 42 × 2	2,0	40,0	125	32	32,0	24,0	00221650
MF 42 × 3	3,0	39,0	125	36	32,0	24,0	00221660
MF 42 × 4	4,0	38,0	140	40	32,0	24,0	00221670
MF 45 × 1	1,0	44,0	110	25	36,0	29,0	00221680
MF 45 × 1,5	1,5	43,5	110	25	36,0	29,0	00221690
MF 45 × 2	2,0	43,0	125	32	36,0	29,0	00221700
MF 45 × 3	3,0	42,0	125	36	36,0	29,0	00221710
MF 45 × 4	4,0	41,0	140	40	36,0	29,0	00221720
MF 48 × 1	1,0	47,0	125	25	36,0	29,0	00221730
MF 48 × 1,5	1,5	46,5	125	25	36,0	29,0	00221740
MF 48 × 2	2,0	46,0	140	32	36,0	29,0	00221750
MF 48 × 3	3,0	45,0	140	36	36,0	29,0	00221760
MF 48 × 4	4,0	44,0	140	40	36,0	29,0	00221770
MF 50 × 1	1,0	49,0	125	25	36,0	29,0	00221780
MF 50 × 1,5	1,5	48,5	125	25	36,0	29,0	00221790
MF 50 × 2	2,0	48,0	140	32	36,0	29,0	00221800
MF 50 × 3	3,0	47,0	140	36	36,0	29,0	00221810
MF 50 × 4	4,0	46,0	140	40	40,0	32,0	00221820
MF 52 × 1	1,0	51,0	125	25	40,0	32,0	00221830
MF 52 × 1,5	1,5	50,5	125	25	40,0	32,0	00221840
MF 52 × 2	2,0	50,0	140	32	40,0	32,0	00221850
MF 52 × 3	3,0	49,0	140	36	40,0	32,0	00221860
MF 52 × 4	4,0	48,0	140	40	40,0	32,0	00221870

SHORT MACHINE TAPS DIN 2184-2

SHORT MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-2	Hole type	Through hole <1.1/2xd
Thread	BSW	Direction	Right
Material	HSS-G	Form	Form B
Raw material	Steel		

Hand tap, single bottoming tap with 4-5 thread chamfer and spiral point

							Art.-No.
BSW 1/16	60	1,2	32	8	2,5	2,1	00236010
BSW 3/32	48	1,9	40	9	2,8	2,1	00236020
BSW 1/8	40	2,6	40	11	3,5	2,7	00236030
BSW 5/32	32	3,2	45	13	4,5	3,4	00236040
BSW 3/16	24	3,8	50	16	6	4,9	00236050
BSW 7/32	24	4,6	56	17	6	4,9	00236060
BSW 1/4	20	5,1	56	19	6	4,9	00236070
BSW 5/16	18	6,5	63	22	6	4,9	00236080
BSW 3/8	16	7,9	70	24	7	5,5	00236090
BSW 7/16	14	9,3	70	24	7	5,5	00236100
BSW 1/2	12	10,5	75	28	9	7,0	00236110
BSW 9/16	12	12,0	80	30	11	9,0	00236120
BSW 5/8	11	13,5	80	32	12	9,0	00236130
BSW 3/4	10	16,5	95	34	14	11,0	00236140
BSW 7/8	9	19,5	100	34	18	14,5	00236150
BSW 1"	8	22,0	110	38	18	14,5	00236160
BSW 1.1/8	7	25,0	125	45	22	18,0	00236170
BSW 1.1/4	7	28,0	125	45	22	18,0	00236180
BSW 1.3/8	6	30,5	150	56	28	22,0	00236190
BSW 1.1/2	6	33,5	150	56	28	22,0	00236200
BSW 1.5/8	5	35,5	150	60	32	24,0	00236210
BSW 1.3/4	5	39,0	160	65	36	29,0	00236220
BSW 1.7/8	4,5	41,5	180	70	36	29,0	00236230
BSW 2"	4,5	44,5	180	70	40	32,0	00236240

SHORT MACHINE TAPS

Hand tap, single bottoming tap with 2-3 thread chamfer

TECHNICAL INFORMATION

Standard	DIN 2184-2	Hole type	Through/blind hole <1.1/2xd
Thread	BSW	Direction	Right
Material	HSS-G	Form	Form C
Raw material	Steel		

							Art.-No.
BSW 1/16	60	1,2	32	8	2,5	2,1	00235010
BSW 3/32	48	1,9	40	9	2,8	2,1	00235020
BSW 1/8	40	2,6	40	11	3,5	2,7	00235030
BSW 5/32	32	3,2	45	13	4,5	3,4	00235040
BSW 3/16	24	3,8	50	16	6	4,9	00235050
BSW 7/32	24	4,6	56	17	6	4,9	00235060
BSW 1/4	20	5,1	56	19	6	4,9	00235070
BSW 5/16	18	6,5	63	22	6	4,9	00235080
BSW 3/8	16	7,9	70	24	7	5,5	00235090
BSW 7/16	14	9,3	70	24	7	5,5	00235100
BSW 1/2	12	10,5	75	28	9	7,0	00235110
BSW 9/16	12	12,0	80	30	11	9,0	00235120
BSW 5/8	11	13,5	80	32	12	9,0	00235130
BSW 3/4	11	16,5	95	34	14	11,0	00235140
BSW 7/8	9	19,5	100	34	18	14,5	00235150
BSW 1"	8	22,0	110	38	18	14,5	00235160
BSW 1.1/8	7	25,0	125	45	22	18,0	00235170
BSW 1.1/4	7	28,0	125	45	22	18,0	00235180
BSW 1.3/8	6	30,5	150	56	28	22,0	00235190
BSW 1.1/2	6	33,5	150	56	28	22,0	00235200
BSW 1.5/8	5	35,5	150	60	32	24,0	00235210
BSW 1.3/4	5	39,0	160	65	36	29,0	00235220
BSW 1.7/8	4,5	41,5	180	70	36	29,0	00235230
BSW 2"	4,5	44,5	180	70	40	32,0	00235240

SHORT MACHINE TAPS DIN 5157

SHORT MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 5157	Hole type	Through/blind hole <1.1/2xd
Thread	BSP	Direction	Right
Material	HSS-G	Form	Form C
Raw material	Steel		

Hand tap, single bottoming tap with 2-3 thread chamfer

							Art.-No.
BSP 1/8	28	8,8	63	20	7,0	5,5	00258030
BSP 1/4	19	11,8	70	22	11,0	9,0	00258070
BSP 3/8	19	15,3	70	22	12,0	9,0	00258090
BSP 1/2	14	19,0	80	22	16,0	12,0	00258110
BSP 5/8	14	21,0	80	22	18,0	14,5	00258130
BSP 3/4	14	24,5	90	22	20,0	16,0	00258140
BSP 7/8	14	28,3	90	22	22,0	18,0	00258150
BSP 1	11	30,5	100	25	25,0	20,0	00258160
BSP 1.1/8	11	35,5	125	40	28,0	22,0	00258170
BSP 1.1/4	11	39,5	125	40	32,0	24,0	00258180
BSP 1.3/8	11	42,0	125	40	36,0	29,0	00258190
BSP 1.1/2	11	45,0	140	40	36,0	29,0	00258200
BSP 1.5/8	11	49,6	140	40	36,0	29,0	00258210
BSP 1.3/4	11	51,0	140	40	40,0	32,0	00258220
BSP 2	11	57,0	160	40	45,0	35,0	00258240

SHORT MACHINE TAPS LH

TECHNICAL INFORMATION

Standard	DIN 5157	Hole type	Through/blind hole <1.1/2xd
Thread	BSP	Direction	Left
Material	HSS-G	Form	Form C
Raw material	Steel		

Hand tap, single bottoming tap with 2-3 thread chamfer

							Art.-No.
BSP 1/8	28	8,8	63	20	7,0	5,5	00259030
BSP 1/4	19	11,8	70	22	11,0	9,0	00259070
BSP 3/8	19	15,3	70	22	12,0	9,0	00259090
BSP 1/2	14	19,0	80	22	16,0	12,0	00259110
BSP 5/8	14	21,0	80	22	18,0	14,5	00259130
BSP 3/4	14	24,5	90	22	20,0	16,0	00259140
BSP 7/8	14	28,3	90	22	22,0	18,0	00259150
BSP 1	11	30,5	100	25	25,0	20,0	00259160
BSP 1.1/8	11	35,5	125	40	28,0	22,0	00259170
BSP 1.1/4	11	39,5	125	40	32,0	24,0	00259180
BSP 1.3/8	11	42,0	125	40	36,0	29,0	00259190
BSP 1.1/2	11	45,0	140	40	36,0	29,0	00259200
BSP 1.5/8	11	49,6	140	40	36,0	29,0	00259210
BSP 1.3/4	11	51,0	140	40	40,0	32,0	00259220
BSP 2	11	57,0	160	40	45,0	35,0	00259240

SHORT MACHINE TAPS DIN 2184-2

SHORT MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-2	Hole type	Through/blind hole <1.1/2xd
Thread	BSF	Direction	Right
Material	HSS-G	Form	Form C
Raw material	Steel		

Hand tap, single bottoming tap for manual and machine usage, 5-6 thread chamfer

							Art.-No.
BSF 1/4	26	5,2	56	19	6,0	4,9	00241060
BSF 5/16	22	6,6	63	22	6,0	4,9	00241070
BSF 3/8	20	8,1	70	24	7,0	5,5	00241080
BSF 7/16	18	9,5	70	24	7	5,5	00241090
BSF 1/2	16	11,0	75	28	9,0	7,0	00241100
BSF 9/16	16	12,5	80	30	11,0	9,0	00241110
BSF 5/8	14	14,0	80	32	12	9,0	00241120
BSF 3/4	12	16,75	95	34	14,0	11,0	00241140
BSF 7/8	11	19,7	100	34	18,0	14,5	00241160
BSF 1"	10	22,75	110	38	18,0	14,5	00241180

SHORT MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-2	Hole type	Through/blind hole <1.1/2xd
Thread	UNC	Direction	Right
Material	HSS-G	Tolerance	2B
Raw material	Steel	Form	Form C

Hand tap, single bottoming tap for manual and machine usage, 2-3 thread chamfer

							Art.-No.
UNC 1/4	20	5,2	56	19	6,0	4,9	00260130
UNC 5/16	18	6,6	63	22	6,0	4,9	00260140
UNC 3/8	16	8,0	70	24	7,0	5,5	00260150
UNC 7/16	14	9,4	70	24	7	5,5	00260160
UNC 1/2	13	10,8	75	28	9,0	7,0	00260170
UNC 9/16	12	12,3	80	30	11,0	9,0	00260180
UNC 5/8	11	13,5	80	32	12	9,0	00260190
UNC 3/4	10	16,5	95	34	14,0	11,0	00260210
UNC 7/8	9	19,5	100	34	18,0	14,5	00260230
UNC 1"	8	22,3	110	38	18,0	14,5	00260250

GSR

SHORT MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-2	Hole type	Through hole <1.1/2xd
Thread	UNC	Direction	Right
Material	HSS-G	Tolerance	2B
Raw material	Steel	Form	Form D

Hand tap, single bottoming tap for manual and machine usage, 4-5 thread chamfer

							Art.-No.
UNC 1/4	20	5,2	56	19	6,0	4,9	00261130
UNC 5/16	18	6,6	63	22	6,0	4,9	00261140
UNC 3/8	16	8,0	70	24	7,0	5,5	00261150
UNC 7/16	14	9,4	70	24	7	5,5	00261160
UNC 1/2	13	10,8	75	28	9,0	7,0	00261170
UNC 9/16	12	12,3	80	30	11,0	9,0	00261180
UNC 5/8	11	13,5	80	32	12	9,0	00261190
UNC 3/4	10	16,5	95	34	14,0	11,0	00261210
UNC 7/8	9	19,5	100	34	18,0	14,5	00261230
UNC 1"	8	22,3	110	38	18,0	14,5	00261250

SHORT MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-2	Hole type	Through/blind hole <1.1/2xd
Thread	UNF	Direction	Right
Material	HSS-G	Tolerance	2B
Raw material	Steel	Form	Form C

Hand tap, single bottoming tap for manual and machine usage, 4-5 thread chamfer

							Art.-No.
UNF 1/4	28	5,5	50	16	6,0	4,9	00270130
UNF 5/16	24	6,9	56	16	6,0	4,9	00270140
UNF 3/8	24	8,5	56	16	7,0	5,5	00270150
UNF 7/16	20	9,9	63	18	8,0	6,2	00270160
UNF 9/16	18	13,0	70	22	11,0	9,0	00270180
UNF 5/8	18	14,5	70	22	12,0	9,0	00270190
UNF 3/4	16	17,5	80	25	14,0	11,0	00270210
UNF 7/8	14	20,5	90	28	18,0	14,5	00270230
UNF 1"	12	23,3	100	32	20,0	16,0	00270250

SHORT MACHINE TAPS DIN 2184-2 / FACTORY STANDARD

SHORT MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-2	Hole type	Through hole <1.1/2xd
Thread	UNF	Direction	Right
Material	HSS-G	Tolerance	2B
Raw material	Steel	Form	Form D

Hand tap, single bottoming tap for manual and machine usage, 4-5 thread chamfer

							Art.-No.
UNF 1/4	28	5,5	50	16	6,0	4,9	00271130
UNF 5/16	24	6,9	56	16	6,0	4,9	00271140
UNF 3/8	24	8,5	56	16	7,0	5,5	00271150
UNF 7/16	20	9,9	63	18	8,0	6,2	00271160
UNF 9/16	18	13,0	70	22	11,0	9,0	00271180
UNF 5/8	18	14,5	70	22	12,0	9,0	00271190
UNF 3/4	16	17,5	80	25	14,0	11,0	00271210
UNF 7/8	14	20,5	90	28	18,0	14,5	00271230
UNF 1"	12	23,3	100	32	20,0	16,0	00271250

SHORT MACHINE TAPS

TECHNICAL INFORMATION

Standard	Factory standard	Hole type	Through/blind hole <1.1/2xd
Thread	PG	Direction	Right
Material	HSS-G	Form	Form C
Raw material	Steel		

Hand tap, single bottoming tap for manual and machine usage, 4-5 thread chamfer

							Art.-No.
Pg 7	20	11,4	70	22	9	7	00287010
Pg 9	18	14,0	70	22	12	9	00287020
Pg 11	18	17,3	80	22	14	11	00287030
Pg 13,5	18	19,0	80	22	16	12	00287040
Pg 16	18	21,3	80	22	18	14,5	00287050
Pg 21	16	27,0	90	22	22	18	00287060
Pg 29	16	35,5	100	25	28	22	00287070
Pg 36	16	45,5	140	40	36	29	00287080
Pg 42	16	52,5	140	40	40	32	00287090
Pg 48	16	58,0	160	40	45	35	00287100

SHORT MACHINE TAPS

TECHNICAL INFORMATION

Standard	Factory standard	Hole type	Through/blind hole <1.1/2xd
Thread	NPT	Direction	Right
Material	HSS-G	Form	Form C
Raw material	Steel		

Hand tap, single bottoming tap, 2-3 thread chamfer

							Art.-No.
NPT 1/16	27	6,25	55	13	7,0	5,5	00280010
NPT 1/8	27	8,5	63	15	7,0	5,5	00280020
NPT 1/4	18	11,1	63	21	11,0	9,0	00280030
NPT 3/8	18	14,7	70	21	12,0	9,0	00280040
NPT 1/2	14	18,0	80	27	16,0	12,0	00280050
NPT 3/4	14	23,3	100	27	20,0	16,0	00280060
NPT 1"	11,5	29,3	110	32	25,0	20,0	00280070
NPT 1.1/4	11,5	38,0	125	33	32,0	24,0	00280080
NPT 1.1/2	11,5	44,3	140	33	36,0	29,0	00280090
NPT 2"	11,5	56,3	160	33	36,0	29,0	00280100

SHORT MACHINE TAPS LH

TECHNICAL INFORMATION

Standard	Factory standard	Hole type	Through/blind hole <1.1/2xd
Thread	NPT	Direction	Left
Material	HSS-G	Form	Form C
Raw material	Steel		

Hand tap, single bottoming tap, 2-3 thread chamfer

							Art.-No.
NPT 1/16	27	6,25	55	13	7,0	5,5	00284010
NPT 1/8	27	8,5	63	15	7,0	5,5	00284020
NPT 1/4	18	11,1	63	21	11,0	9,0	00284030
NPT 3/8	18	14,7	70	21	12,0	9,0	00284040
NPT 1/2	14	18,0	80	27	16,0	12,0	00284050
NPT 3/4	14	23,3	100	27	20,0	16,0	00284060
NPT 1"	11,5	29,3	110	32	25,0	20,0	00284070
NPT 1.1/4	11,5	38,0	125	33	32,0	24,0	00284080
NPT 1.1/2	11,5	44,3	140	33	36,0	29,0	00284090
NPT 2"	11,5	56,3	160	33	36,0	29,0	00284100

SHORT MACHINE TAPS FACTORY STANDARD

SHORT MACHINE TAPS

TECHNICAL INFORMATION

Standard	Factory Standard	Hole type	Through/blind hole <1.1/2xd
Thread	NPTF	Direction	Right
Material	HSS-G	Form	Form C
Raw material	Steel		

Hand tap, single bottoming tap, 2-3 thread chamfer

							Art.-No.
NPTF 1/16	27	6,25	55	13	7,0	5,5	00282010
NPTF 1/8	27	8,5	63	15	7,0	5,5	00282020
NPTF 1/4	18	11,1	63	21	11,0	9,0	00282030
NPTF 3/8	18	14,7	70	21	12,0	9,0	00282040
NPTF 1/2	14	18,0	80	27	16,0	12,0	00282050
NPTF 3/4	14	23,3	100	27	20,0	16,0	00282060
NPTF 1"	11,5	29,3	110	32	25,0	20,0	00282070
NPTF 1.1/4	11,5	38,0	125	33	32,0	24,0	00282080
NPTF 1.1/2	11,5	44,3	140	33	36,0	29,0	00282090
NPTF 2"	11,5	56,3	160	33	36,0	29,0	00282100

SHORT MACHINE TAPS

TECHNICAL INFORMATION

Standard	Factory Standard	Hole type	Through/blind hole <1.1/2xd
Thread	NPS	Direction	Right
Material	HSSE-G	Form	Form C
Raw material	Steel		

Hand tap, single bottoming tap, 2-3 thread chamfer

							Art.-No.
NPS 1/16	27	—	54	17,5	8,0	6,0	00289010
NPS 1/8	27	9,2	54	19	8,0	6,0	00289020
NPS 1/4	18	12,1	62	27	14,2	10,7	00289030
NPS 3/8	18	15,5	65	27	17,6	13,5	00289040
NPS 1/2	14	19,1	79	35	17,5	13,0	00289050
NPS 3/4	14	24,5	83	35	23,0	17,0	00289060
NPS 1"	11,5	30,6	95	44	28,8	21,4	00289070
NPS 1.1/4	11,5	—	105	45	32,0	26,0	00289080
NPS 1.1/2	11,5	—	110	45	38,0	29,0	00289090
NPS 2"	11,5	—	120	50	46,0	35,0	00289100

SHORT MACHINE TAPS

TECHNICAL INFORMATION

Standard	Factory Standard	Hole type	Blind hole < 1½ × d
Thread	NPS	Direction	Right
Material	HSSE-G	Form	Form C/RSP 35°
Raw material	Steel		

Hand tap, single bottoming tap, 2-3 thread chamfer

							Art.-No.
NPS 1/16	27	—	54	17,5	8,0	6,0	00290010
NPS 1/8	27	9,2	54	19	8,0	6,0	00290020
NPS 1/4	18	12,1	62	27	14,2	10,7	00290030
NPS 3/8	18	15,5	65	27	17,6	13,5	00290040
NPS 1/2	14	19,1	79	35	17,5	13,0	00290050
NPS 3/4	14	24,5	83	35	23,0	17,0	00290060
NPS 1"	11,5	30,6	95	44	28,8	21,4	00290070
NPS 1.1/4	11,5	—	105	45	32,0	26,0	00290080
NPS 1.1/2	11,5	—	110	45	38,0	29,0	00290090
NPS 2"	11,5	—	120	50	46,0	35,0	00290100

SHORT MACHINE TAP-BITS

TECHNICAL INFORMATION

Standard	Factory Standard	Hole type	Through hole <1×d
Thread	M	Direction	Right
Material	HSS-G	Tolerance	6H
Raw material	Steel	Form	Form A

Single bottoming tap for cordless screw drivers, 4-6 thread chamfer with ¼ " hexagon shank (DIN 3126)

						Art.-No.
M 3	0,5	2,5	33	11	1/4"	00299130
M 4	0,7	3,3	35	12	1/4"	00299150
M 5	0,8	4,2	36	15	1/4"	00299170
M 6	1	5	39	18	1/4"	00299190
M 8	1,25	6,8	40	19	1/4"	00299210
M 10	1,5	8,5	41	21	1/4"	00299230

NUT TAPS DIN 335 / 357

MANUAL NUT TAPS

TECHNICAL INFORMATION

Standard	DIN 335	Hole type	Through hole
Thread	M	Direction	Right
Material	HSS-G	Tolerance	ISO2 / 6H
Raw material	Steel	Form	2/3 × L2

							Art.-No.
M 3	0,5	2,5	70	45	2,2	2,7	00830130
M 4	0,7	3,3	90	55	2,8	3,4	00830150
M 5	0,8	4,2	100	60	3,5	4,9	00830170
M 6	1,0	5,0	110	65	4,5	4,9	00830190
M 8	1,25	6,8	125	72	6,0	4,9	00830210
M 10	1,5	8,5	140	80	7,0	5,5	00830230
M 12	1,75	10,2	180	90	9,0	7,0	00830250
M 14	2,0	12,0	200	95	11,0	9,0	00830260
M 16	2,0	14,0	200	105	12,0	9,0	00830270
M 18	2,5	15,5	220	115	14,0	11,0	00830280
M 20	2,5	17,5	250	120	16,0	12,0	00830290
M 22	2,5	19,5	280	125	18,0	14,5	00830300
M 24	3,0	21,0	280	130	18,0	14,5	00830310

MACHINE NUT TAPS

TECHNICAL INFORMATION

Standard	DIN 357	Hole type	Through hole
Thread	M	Direction	Right
Material	HSSE-G	Tolerance	6H
Raw material	Steel	Form	2/3 × L2

						◇	Art.-No.
M 3	0,5	2,5	70	22	2,2	2,7	03399130
M 4	0,7	3,3	90	25	2,8	3,4	03399150
M 5	0,8	4,2	100	28	3,5	4,9	03399170
M 6	1,0	5,0	110	32	4,5	4,9	03399190
M 8	1,25	6,8	125	40	6,0	4,9	03399210
M 10	1,5	8,5	140	45	7,0	5,5	03399230
M 12	1,75	10,2	180	50	9,0	7,0	03399250
M 14	2,0	12,0	200	56	11,0	9,0	03399260
M 16	2,0	14,0	200	63	12,0	9,0	03399270
M 18	2,5	15,5	220	63	14,0	11,0	03399280
M 20	2,5	17,5	250	70	16,0	12,0	03399290
M 22	2,5	19,5	280	80	18,0	14,5	03399300
M 24	3,0	21,0	280	80	18,0	14,5	03399310
M 27	3,0	24,0	315	90	20,0	16,0	03399320
M 30	3,5	26,5	315	100	22,0	18,0	03399330
M 33	3,5	29,5	355	110	25,0	20,0	03399340
M 36	4,0	32,0	400	110	28,0	22,0	03399350
M 39	4,0	35,0	400	115	32,0	24,0	03399360
M 42	4,5	37,5	450	115	32,0	24,0	03399370
M 45	4,5	40,5	500	130	36,0	29,0	03399380
M 48	5,0	43,0	500	130	36,0	29,0	03399390
M 52	5,0	47,0	500	130	40,0	32,0	03399400

NUT TAPS FACTORY STANDARD

MACHINE NUT TAPS

TECHNICAL INFORMATION

Standard	Factory Standard	Hole type	Through hole < 1×d
Thread	Tr	Direction	Right
Material	HSS-G	Tolerance	7h
Raw material	Steel	Form	2/3 × L2
with guiding pin			

						◇	Art.-No.
Tr 10 × 2	2,0	8	110	63	7,0	5,5	00831010
Tr 10 × 3	3,0	7	125	75	7,0	5,5	00831020
Tr 12 × 3	3,0	9	165	111	8,0	6,2	00831040
Tr 14 × 3	3,0	11	140	85	10,0	8,0	00831060
Tr 14 × 4	4,0	10	170	112	10,0	8,0	00831070
Tr 16 × 4	4,0	12	180	116	11,0	9,0	00831090
Tr 18 × 4	4,0	14	190	120	12,0	9,0	00831110
Tr 20 × 4	4,0	16	200	124	14,0	11,0	00831130
Tr 22 × 5	5,0	17	235	155	16,0	12,0	00831140
Tr 24 × 5	5,0	19	245	160	18,0	14,5	00831160
Tr 26 × 5	5,0	21	255	165	20,0	16,0	00831170
Tr 28 × 5	5,0	23	265	170	22,0	18,0	00831180
Tr 30 × 6	6,0	24	290	185	22,0	18,0	00831200
Tr 32 × 6	6,0	26	300	191	25,0	20,0	00831210
Tr 36 × 6	6,0	30	310	200	28,0	22,0	00831230

MACHINE NUT TAPS LH

TECHNICAL INFORMATION

Standard	Factory Standard	Hole type	Through hole < 1×d
Thread	Tr	Direction	Left
Material	HSS-G	Tolerance	7h
Raw material	Steel	Form	2/3 × L2
with guiding pin			

							Art.-No.
Tr 10 × 2	2,0	8	110	63	7,0	5,5	00832010
Tr 10 × 3	3,0	7	125	75	7,0	5,5	00832020
Tr 12 × 3	3,0	9	165	111	8,0	6,2	00832040
Tr 14 × 3	3,0	11	140	85	10,0	8,0	00832060
Tr 14 × 4	4,0	10	170	112	10,0	8,0	00832070
Tr 16 × 4	4,0	12	180	116	11,0	9,0	00832090
Tr 18 × 4	4,0	14	190	120	12,0	9,0	00832110
Tr 20 × 4	4,0	16	200	124	14,0	11,0	00832130
Tr 22 × 5	5,0	17	235	155	16,0	12,0	00832140
Tr 24 × 5	5,0	19	245	160	18,0	14,5	00832160
Tr 26 × 5	5,0	21	255	165	20,0	16,0	00832170
Tr 28 × 5	5,0	23	265	170	22,0	18,0	00832180
Tr 30 × 6	6,0	24	290	185	22,0	18,0	00832200
Tr 32 × 6	6,0	26	300	191	25,0	20,0	00832210
Tr 36 × 6	6,0	30	310	200	28,0	22,0	00832230

NUT TAPS FACTORY STANDARD

MACHINE NUT TAPS

TECHNICAL INFORMATION

Standard	Factory Standard	Hole type	Through hole < 1.1/2×d
Thread	Tr	Direction	Right
Material	HSSE-V3	Tolerance	7h
Raw material	Stainless steel	Form	2/3 × L2
with guiding pin			

						◇	Art.-No.
Tr 10 × 2	2,0	8,2	110	64	7,0	5,5	00292010
Tr 10 × 3	3,0	7,3	130	91	7,0	5,5	00292020
Tr 12 × 2	2,0	10,2	120	66	8,0	6,2	00292030
Tr 12 × 3	3,0	9,3	140	93	8,0	6,2	00292040
Tr 14 × 2	2,0	12,2	130	68	10,0	8,0	00292050
Tr 14 × 3	3,0	11,3	150	95	10,0	8,0	00292060
Tr 14 × 4	4,0	10,3	180	122	10,0	8,0	00292070
Tr 16 × 2	2,0	14,2	130	70	11,0	9,0	00292080
Tr 16 × 4	4,0	12,3	190	124	11,0	9,0	00292090
Tr 18 × 2	2,0	16,2	140	72	12,0	9,0	00292100
Tr 18 × 4	4,0	14,3	200	126	12,0	9,0	00292110
Tr 20 × 2	2,0	18,2	150	74	14,0	11,0	00292120
Tr 20 × 4	4,0	16,3	210	128	14,0	11,0	00292130
Tr 22 × 5	5,0	17,4	240	157	16,0	12,0	00292140
Tr 24 × 3	3,0	21,3	200	104	18,0	14,5	00292150
Tr 24 × 5	5,0	19,4	250	159	18,0	14,5	00292160
Tr 26 × 5	5,0	21,4	260	160	20,0	16,0	00292170
Tr 28 × 5	5,0	23,4	270	160	22,0	18,0	00292180
Tr 30 × 3	3,0	27,3	220	104	22,0	18,0	00292190
Tr 30 × 6	6,0	24,5	300	188	22,0	18,0	00292200
Tr 32 × 6	6,0	26,5	310	188	25,0	20,0	00292210
Tr 36 × 3	3,0	33,3	240	104	28,0	22,0	00292220
Tr 36 × 6	6,0	30,5	330	188	28,0	22,0	00292230
Tr 40 × 7	7,0	33,5	370	216	32,0	24,0	00292240

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MACHINE NUT TAPS LH

TECHNICAL INFORMATION

Standard	Factory Standard	Hole type	Through hole < 1.1/2×d
Thread	Tr	Direction	Left
Material	HSSE-V3	Tolerance	7h
Raw material	Stainless steel	Form	2/3 × L2
with guiding pin			

							Art.-No.
Tr 10 × 2	2,0	8,2	110	64	7,0	5,5	00293010
Tr 10 × 3	3,0	7,3	130	91	7,0	5,5	00293020
Tr 12 × 2	2,0	10,2	120	66	8,0	6,2	00293030
Tr 12 × 3	3,0	9,3	140	93	8,0	6,2	00293040
Tr 14 × 2	2,0	12,2	130	68	10,0	8,0	00293050
Tr 14 × 3	3,0	11,3	150	95	10,0	8,0	00293060
Tr 14 × 4	4,0	10,3	180	122	10,0	8,0	00293070
Tr 16 × 2	2,0	14,2	130	70	11,0	9,0	00293080
Tr 16 × 4	4,0	12,3	190	124	11,0	9,0	00293090
Tr 18 × 2	2,0	16,2	140	72	12,0	9,0	00293100
Tr 18 × 4	4,0	14,3	200	126	12,0	9,0	00293110
Tr 20 × 2	2,0	18,2	150	74	14,0	11,0	00293120
Tr 20 × 4	4,0	16,3	210	128	14,0	11,0	00293130
Tr 22 × 5	5,0	17,4	240	157	16,0	12,0	00293140
Tr 24 × 3	3,0	21,3	200	104	18,0	14,5	00293150
Tr 24 × 5	5,0	19,4	250	159	18,0	14,5	00293160
Tr 26 × 5	5,0	21,4	260	160	20,0	16,0	00293170
Tr 28 × 5	5,0	23,4	270	160	22,0	18,0	00293180
Tr 30 × 3	3,0	27,3	220	104	22,0	18,0	00293190
Tr 30 × 6	6,0	24,5	300	188	22,0	18,0	00293200
Tr 32 × 6	6,0	26,5	310	188	25,0	20,0	00293210
Tr 36 × 3	3,0	33,3	240	104	28,0	22,0	00293220
Tr 36 × 6	6,0	30,5	330	188	28,0	22,0	00293230
Tr 40 × 7	7,0	33,5	370	216	32,0	24,0	00293240

HSS-E

High-speed steel with the alloy group HSS-E, containing cobalt and a share of vanadium ≤ 2.6%

HSS

High-speed steel with the alloy group HSS, cobalt free and with a share of vanadium > 2,6%

MACHINE TAPS

DIN 371 / DIN 376

TYPE 2
DIN 376 / M2 – M100

TYPE 1
DIN 371 / M1 – M10

Machine taps for ISO metric coarse threads are suitable for cutting internal threads with a machine. The DIN 371 version has a reinforced shank (up to M10) and the DIN 376 version has a reduced shank.

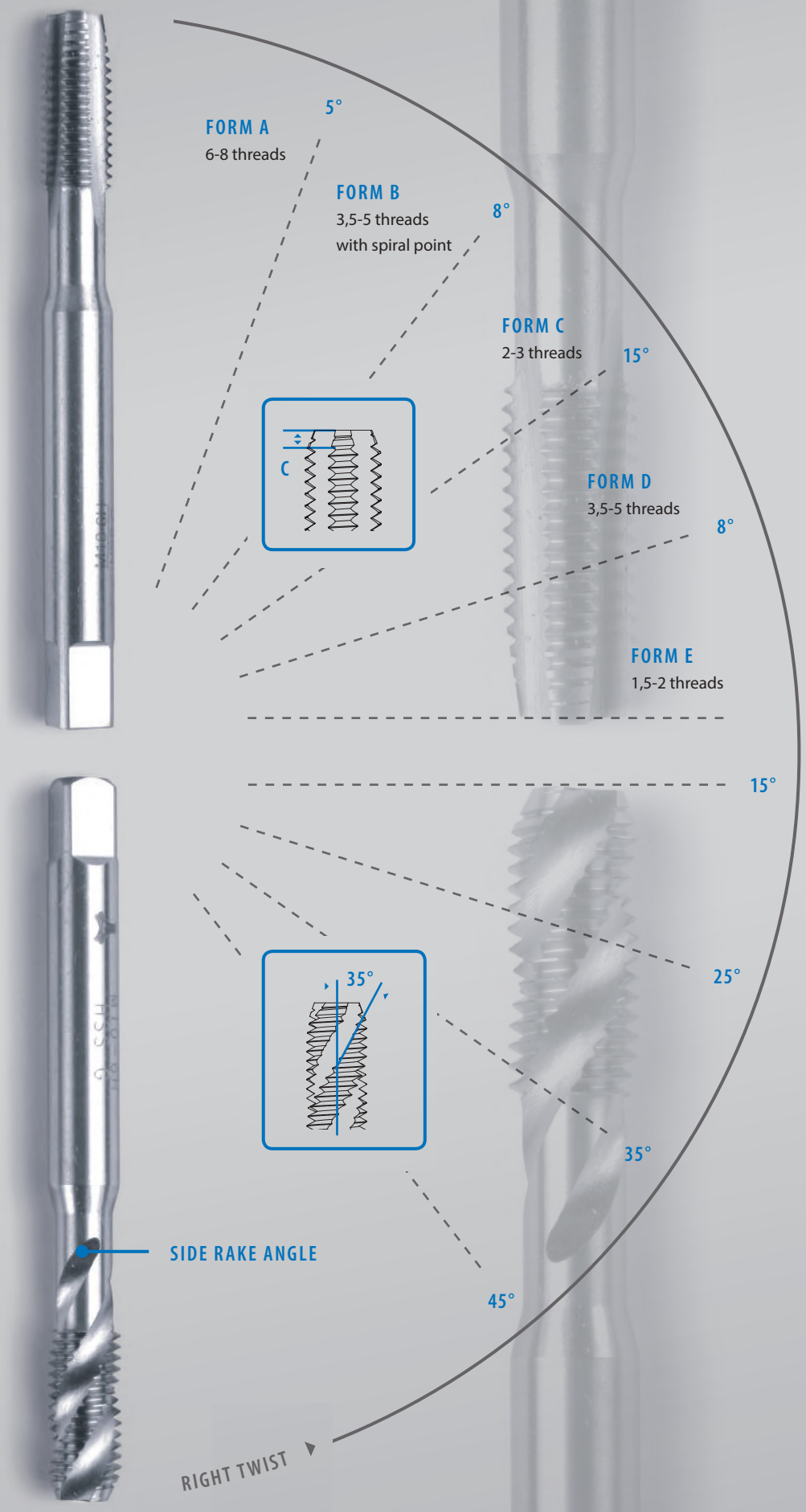
TAPS
DIN 371 · B · M2 · 6H · HSS

	Description
DIN 371 =	German Institute for Standardisation
B =	with spiral point according to DIN 2197
M2 =	Nominal size for ISO metric coarse threads
6H =	Tolerance class according to DIN 802, part 1
HSS =	High-speed steel

Labelling according to DIN 2197
M2 6H HSS

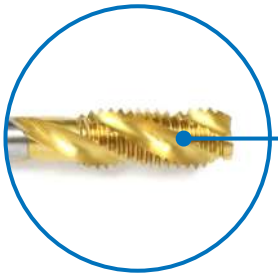
DIN 371

DIN 376



TOOL COATING

GSR offers three different types of coating. The table below gives a summary of the most important characteristics of the different alternatives. All machine taps and twist drills can be coated upon customer request.



TiN TITANIUM NITRIDE COATING

For years, the TiN coating has been the first choice for tap coating, and already established itself as an all-rounder coating. By using this coating, the coefficient of friction and tendency to cold weld are reduced.

AlTin ALUMINIUM TITANIUM NITRIDE COATING

The AlTiN coating is especially used in areas with high cutting data. The high hardness of this coating in combination with oxidation resistance at high temperatures enables demanding cutting tasks, at which extreme temperatures occur at the cutting edges as well as through outgoing chips. The coating can therefore be used with minimum lubrication or even for dry processing.

AlCro CHROME ALUMINIUM COATING

The AlCro coating offers high hardness in combination with excellent temperature resistance and ductility. It proved itself at metal cutting processes and ensures better tool life and high surface quality.

APPLICATION TABLE MACHINE TAPS

Chamfer	Form A	Form B	Form A	Form B
Material	HSSG	HSSG	HSSE	HSSE
Coating				
Thread direction	right	right	right	right
Thread depth	1xd	1.1/2xd	1xd	1.1/2xd
DIN 371 metric with reinforced shank	00301	00302	01001	01004
DIN 376 metric with overflow shank	00307	00309	02001	02004
DIN 374 metric fine				02204
DIN 2184-1 Whitworth				01304
DIN 2184-1 Whitworth-Pipe (BSP)				02504
DIN 2184-1 UNC				01604
DIN 2184-1 UNF				01704
DIN 2184-1 UNEF				01722
DIN 2184-1 UN/UNS				02804
DIN 2184-1 PG				
DIN 2184-1 RD				

THROUGH HOLE

RAW MATERIALS

Soft construction steels up to 500 N/mm²	1.1 Construction Steels	★★	★★	★★	★★
	1.2 Unalloyed cast steels	★	★	★★	★★
Free machining steels and construction steels up to 800 N/mm²	2.1 Free machine steels	★	★	★	★
	2.2 Construction steels and Q & T steels	★	★	★★	★★
	2.3 Unalloyed cast steels	★	★	★	★
Q & T steels and tool steels up to 1100 N/mm²	3.1 Case hardening and nitriding steels				
	3.2 Q & T steels				
	3.3 Tool steels				
High-alloy steels and Q & T steels up to1400 N/mm²	4.1 High-alloy steels				
	4.2 Q & T steels				
Stainless steels and heat-resistant steels	5.1 Strength up to 450-800 N/mm²				
	5.2 Strength up to 600-1000 N/mm²				
Cast materials	6.1 Grey cast iron			★	★
	6.2 Ductile iron and malleable cast iron				
Pure aluminium	7.1 Pure aluminium			★	★
Aluminium alloys	8.1 < 10% /Si content < 10%			★	★
Pure copper	8.2 >10% /Si content > 10%				
	9.1 Pure copper			★	★
Copper alloys	10.1 short-chipping				
Zinc	10.2 long-chipping				
	11.1 Zinc and zinc-alloy				

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Form B LH	Form B AZ	Form B	Form B	Form RSP 35°	Form C	Form C LH	Form C	Form C	Form RSP 35°	Form RSP 35°	Form RSP 35°
HSSE	HSSE	HSSE	HSSE	HSSG	HSSE	HSSE	HSSE	HSSE	HSSE	HSSE	HSSE
		VAP	TIN				VAP	TIN		VAP	TIN
left	right	right	right	right	right	left	right	right	right	right	right
1.1/2xd	1.1/2xd	1.1/2xd	1.1/2xd	2xd	1.1/2xd	1.1/2xd	1.1/2xd	1.1/2xd	2xd	2xd	2xd
			01105	00306	01006	01028	01116	01106	01015	01016	01107
			02105	00311	02006	02028	02116	02106	02015	02016	02109
					02221	02237			02226		
					01321	02522			01315		
					02521				02516		
					01621				01615	01616	
					01721				01715	01716	
									01723		
					02821				02815		
					02901						
					02951						

BLIND HOLE

★ = suitable
★★ = very suitable

★★			★★	★★	★	★		★			
★★		★★	★★	★			★★				
★			★★	★	★	★		★			
★★		★★	★★	★			★★		★★	★	★★
★		★	★★	★			★		★★	★	★★
					★	★		★			
★			★★								★
	★★								★		
★	★★	★★	★★				★★		★★	★	★★
★	★★	★	★		★	★	★	★★		★	★
★			★		★★	★★		★★			
									★		★
		★★					★★			★★	

MACHINE TAPS DIN 371 / 376

MACHINE TAPS

Machine tap with reinforced shank, 6-8 thread chamfer

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 371)	Hole type	Through hole < 1×d
Thread	M	Direction	Right
Material	HSS-G	Tolerance	6H
Raw material	Steel	Form	Form A

						◇	Art.-No.
M 2	0,4	1,6	45	8	2,8	2,1	00301080
M 2,2	0,45	1,75	45	9	2,8	2,1	00301090
M 2,3	0,4	1,9	45	9	2,8	2,1	00301100
M 2,5	0,45	2,05	50	9	2,8	2,1	00301110
M 2,6	0,45	2,1	50	9	2,8	2,1	00301120
M 3	0,5	2,5	56	11	3,5	2,7	00301130
M 3,5	0,6	2,9	56	12	4,0	3,0	00301140
M 4	0,7	3,3	63	13	4,5	3,4	00301150
M 5	0,8	4,2	70	16	6,0	4,9	00301170
M 6	1,0	5,0	80	19	6,0	4,9	00301190
M 7	1,0	6,0	80	19	7,0	5,5	00301200
M 8	1,25	6,8	90	22	8,0	6,2	00301210
M 10	1,5	8,5	100	24	10,0	8,0	00301230

MACHINE TAPS

Machine tap with overflow shank, 6-8 thread chamfer

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 376)	Hole type	Through hole < 1×d
Thread	M	Direction	Right
Material	HSS-G	Tolerance	6H
Raw material	Steel	Form	Form A

						◇	Art.-No.
M 3	0,5	2,5	56	11	2,2	—	00307130
M 4	0,7	3,3	63	13	2,8	2,1	00307150
M 5	0,8	4,2	70	16	3,5	2,7	00307170
M 6	1,0	5,0	80	19	4,5	3,4	00307190
M 7	1,0	6,0	80	19	5,5	4,3	00307200
M 8	1,25	6,8	90	22	6,0	4,9	00307210
M 10	1,5	8,5	100	24	7,0	5,5	00307230
M 12	1,75	10,2	110	28	9,0	7,0	00307250
M 14	2,0	12,0	110	30	11,0	9,0	00307260
M 16	2,0	14,0	110	32	12,0	9,0	00307270
M 18	2,5	15,5	125	34	14,0	11,0	00307280
M 20	2,5	17,5	140	34	16,0	12,0	00307290

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							Art.-No.
M 22	2,5	19,5	140	34	18,0	14,5	00307300
M 24	3,0	21,0	160	38	18,0	14,5	00307310
M 27	3,0	24,0	160	38	20,0	16,0	00307320
M 30	3,5	26,5	180	45	22,0	18,0	00307330
M 33	3,5	29,5	180	50	25,0	20,0	00307340
M 36	4,0	32,0	200	56	28,0	22,0	00307350
M 39	4,0	35,0	200	60	32,0	24,0	00307360
M 42	4,5	37,5	200	60	32,0	24,0	00307370
M 45	4,5	40,5	220	65	36,0	29,0	00307380
M 48	5,0	43,0	250	70	36,0	29,0	00307390
M 52	5,0	47,0	250	70	40,0	32,0	00307400
M 56	5,5	51,5	250	70	40,0	32,0	00307410
M 60	5,5	54,5	280	75	45,0	35,0	00307420
M 64	6,0	58,0	315	80	50,0	39,0	00307430
M 68	6,0	62,0	315	80	50,0	39,0	00307440
M 72	6,0	66,0	340	80	50,0	39,0	00307450
M 76	6,0	70,0	340	80	50,0	39,0	00307460
M 80	6,0	74,0	360	85	50,0	39,0	00307470
M 84	6,0	78,0	380	85	50,0	39,0	00307480
M 88	6,0	82,0	380	85	50,0	39,0	00307490
M 90	6,0	84,0	380	85	50,0	39,0	00307500
M 92	6,0	86,0	400	90	56,0	44,0	00307510
M 96	6,0	90,0	400	90	56,0	44,0	00307520
M 100	6,0	94,0	400	90	56,0	44,0	00307530

MACHINE TAPS DIN 371 / 376

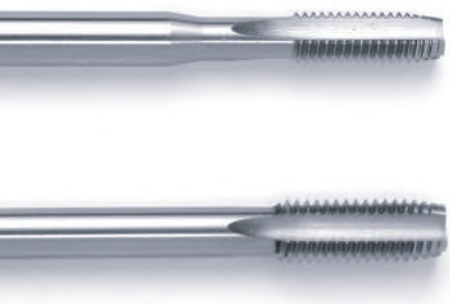
MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 371)	Hole type	Through hole < 1xd
Thread	M	Direction	Right
Material	HSSE-G	Tolerance	6H
Raw material	Steel	Form	Form A

Machine tap with reinforced shank, 6-8 thread chamfer, straight flute

							Art.-No.
M 2	0,4	1,6	45	8	2,8	2,1	01001080
M 2,2	0,45	1,75	45	9	2,8	2,1	01001090
M 2,3	0,4	1,9	45	9	2,8	2,1	01001100
M 2,5	0,45	2,05	50	9	2,8	2,1	01001110
M 2,6	0,45	2,1	50	9	2,8	2,1	01001120
M 3	0,5	2,5	56	11	3,5	2,7	01001130
M 3,5	0,6	2,9	56	12	4,0	3,0	01001140
M 4	0,7	3,3	63	13	4,5	3,4	01001150
M 5	0,8	4,2	70	16	6,0	4,9	01001170
M 6	1,0	5,0	80	19	6,0	4,9	01001190
M 7	1,0	6,0	80	19	7,0	5,5	01001200
M 8	1,25	6,8	90	22	8,0	6,2	01001210
M 10	1,5	8,5	100	24	10,0	8,0	01001230



GSR

MACHINE TAPS

Machine tap with overflow shank, 6-8 thread chamfer, straight flute

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 376)	Hole type	Through hole < 1xd
Thread	M	Direction	Right
Material	HSSE-G	Tolerance	6H
Raw material	Steel	Form	Form A

						◇	Art.-No.
M 3	0,5	2,5	56	11	2,2	—	02001130
M 4	0,7	3,3	63	13	2,8	2,1	02001150
M 5	0,8	4,2	70	16	3,5	2,7	02001170
M 6	1,0	5,0	80	19	4,5	3,4	02001190
M 7	1,0	6,0	80	19	5,5	4,3	02001200
M 8	1,25	6,8	90	22	6,0	4,9	02001210
M 10	1,5	8,5	100	24	7,0	5,5	02001230
M 12	1,75	10,2	110	28	9,0	7,0	02001250
M 14	2,0	12,0	110	30	11,0	9,0	02001260
M 16	2,0	14,0	110	32	12,0	9,0	02001270
M 18	2,5	15,5	125	34	14,0	11,0	02001280
M 20	2,5	17,5	140	34	16,0	12,0	02001290
M 22	2,5	19,5	140	34	18,0	14,5	02001300
M 24	3,0	21,0	160	38	18,0	14,5	02001310
M 27	3,0	24,0	160	38	20,0	16,0	02001320
M 30	3,5	26,5	180	45	22,0	18,0	02001330
M 33	3,5	29,5	180	50	25,0	20,0	02001340
M 36	4,0	32,0	200	56	28,0	22,0	02001350
M 39	4,0	35,0	200	60	32,0	24,0	02001360
M 42	4,5	37,5	200	60	32,0	24,0	02001370
M 45	4,5	40,5	220	65	36,0	29,0	02001380
M 48	5,0	43,0	250	70	36,0	29,0	02001390
M 52	5,0	47,0	250	70	40,0	32,0	02001400
M 56	5,5	51,5	250	70	40,0	32,0	02001410
M 60	5,5	54,5	280	75	45,0	35,0	02001420
M 64	6,0	58,0	315	80	50,0	39,0	02001430
M 68	6,0	62,0	315	80	50,0	39,0	02001440
M 72	6,0	66,0	340	80	50,0	39,0	02001450
M 76	6,0	70,0	340	80	50,0	39,0	02001460
M 80	6,0	74,0	360	85	50,0	39,0	02001470
M 84	6,0	78,0	380	85	50,0	39,0	02001480
M 88	6,0	82,0	380	85	50,0	39,0	02001490
M 90	6,0	84,0	380	85	50,0	39,0	02001500
M 92	6,0	86,0	400	90	56,0	44,0	02001510
M 96	6,0	90,0	400	90	56,0	44,0	02001520
M 100	6,0	94,0	400	90	56,0	44,0	02001530

MACHINE TAPS DIN 371 / 376

MACHINE TAPS

Machine tap with reinforced shank, 4-5 thread chamfer, with spiral point

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 371)	Hole type	Through hole < 1.1/2×d
Thread	M	Direction	Right
Material	HSS-G	Tolerance	6H
Raw material	Steel	Form	Form B

						◇	Art.-No.
M 2	0,4	1,6	45	8	2,8	2,1	00302080
M 2,2	0,45	1,75	45	9	2,8	2,1	00302090
M 2,3	0,4	1,9	45	9	2,8	2,1	00302100
M 2,5	0,45	2,05	50	9	2,8	2,1	00302110
M 2,6	0,45	2,1	50	9	2,8	2,1	00302120
M 3	0,5	2,5	56	11	3,5	2,7	00302130
M 3,5	0,6	2,9	56	12	4,0	3,0	00302140
M 4	0,7	3,3	63	13	4,5	3,4	00302150
M 5	0,8	4,2	70	16	6,0	4,9	00302170
M 6	1,0	5,0	80	19	6,0	4,9	00302190
M 7	1,0	6,0	80	19	7,0	5,5	00302200
M 8	1,25	6,8	90	22	8,0	6,2	00302210
M 10	1,5	8,5	100	24	10,0	8,0	00302230

MACHINE TAPS

Machine tap with overflow shank, 4-5 thread chamfer, with spiral point

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 376)	Hole type	Through hole < 1.1/2×d
Thread	M	Direction	Right
Material	HSS-G	Tolerance	6H
Raw material	Steel	Form	Form B

						◇	Art.-No.
M 3	0,5	2,5	56	11	2,2	—	00309130
M 4	0,7	3,3	63	13	2,8	2,1	00309150
M 5	0,8	4,2	70	16	3,5	2,7	00309170
M 6	1,0	5,0	80	19	4,5	3,4	00309190
M 7	1,0	6,0	80	19	5,5	4,3	00309200
M 8	1,25	6,8	90	22	6,0	4,9	00309210
M 10	1,5	8,5	100	24	7,0	5,5	00309230
M 12	1,75	10,2	110	28	9,0	7,0	00309250
M 14	2,0	12,0	110	30	11,0	9,0	00309260
M 16	2,0	14,0	110	32	12,0	9,0	00309270

						◇	Art.-No.
M 18	2,5	15,5	125	34	14,0	11,0	00309280
M 20	2,5	17,5	140	34	16,0	12,0	00309290
M 22	2,5	19,5	140	34	18,0	14,5	00309300
M 24	3,0	21,0	160	38	18,0	14,5	00309310
M 27	3,0	24,0	160	38	20,0	16,0	00309320
M 30	3,5	26,5	180	45	22,0	18,0	00309330
M 33	3,5	29,5	180	50	25,0	20,0	00309340
M 36	4,0	32,0	200	56	28,0	22,0	00309350
M 39	4,0	35,0	200	60	32,0	24,0	00309360
M 42	4,5	37,5	200	60	32,0	24,0	00309370
M 45	4,5	40,5	220	65	36,0	29,0	00309380
M 48	5,0	43,0	250	70	36,0	29,0	00309390
M 52	5,0	47,0	250	70	40,0	32,0	00309400
M 56	5,5	51,5	250	70	40,0	32,0	00309410
M 60	5,5	54,5	280	75	45,0	35,0	00309420
M 64	6,0	58,0	315	80	50,0	39,0	00309430
M 68	6,0	62,0	315	80	50,0	39,0	00309440
M 72	6,0	66,0	340	80	50,0	39,0	00309450
M 76	6,0	70,0	340	80	50,0	39,0	00309460
M 80	6,0	74,0	360	85	50,0	39,0	00309470
M 84	6,0	78,0	380	85	50,0	39,0	00309480
M 88	6,0	82,0	380	85	50,0	39,0	00309490
M 90	6,0	84,0	380	85	50,0	39,0	00309500
M 92	6,0	86,0	400	90	56,0	44,0	00309510
M 96	6,0	90,0	400	90	56,0	44,0	00309520
M 100	6,0	94,0	400	90	56,0	44,0	00309530

MACHINE TAPS DIN 371 / 376

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 371)	Hole type	Through hole < 1.1/2×d
Thread	M	Direction	Right
Material	HSSE-G	Tolerance	6H
Raw material	Steel	Form	Form B

Machine tap with reinforced shank, 4-5 thread chamfer, with spiral point

							Art.-No.
M 2	0,4	1,6	45	8	2,8	2,1	01004080
M 2,2	0,45	1,75	45	9	2,8	2,1	01004090
M 2,3	0,4	1,9	45	9	2,8	2,1	01004100
M 2,5	0,45	2,05	50	9	2,8	2,1	01004110
M 2,6	0,45	2,1	50	9	2,8	2,1	01004120
M 3	0,5	2,5	56	11	3,5	2,7	01004130
M 3,5	0,6	2,9	56	12	4,0	3,0	01004140
M 4	0,7	3,3	63	13	4,5	3,4	01004150
M 5	0,8	4,2	70	16	6,0	4,9	01004170
M 6	1,0	5,0	80	19	6,0	4,9	01004190
M 7	1,0	6,0	80	19	7,0	5,5	01004200
M 8	1,25	6,8	90	22	8,0	6,2	01004210
M 10	1,5	8,5	100	24	10,0	8,0	01004230

GSR

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 376)	Hole type	Through hole < 1.1/2×d
Thread	M	Direction	Right
Material	HSSE-G	Tolerance	6H
Raw material	Steel	Form	Form B

Machine tap with overflow shank, 4-5 thread chamfer, with spiral point

						◇	Art.-No.
M 3	0,5	2,5	56	11	2,2	—	02004130
M 4	0,7	3,3	63	13	2,8	2,1	02004150
M 5	0,8	4,2	70	16	3,5	2,7	02004170
M 6	1,0	5,0	80	19	4,5	3,4	02004190
M 7	1,0	6,0	80	19	5,5	4,3	02004200
M 8	1,25	6,8	90	22	6,0	4,9	02004210
M 10	1,5	8,5	100	24	7,0	5,5	02004230
M 12	1,75	10,2	110	28	9,0	7,0	02004250
M 14	2,0	12,0	110	30	11,0	9,0	02004260
M 16	2,0	14,0	110	32	12,0	9,0	02004270
M 18	2,5	15,5	125	34	14,0	11,0	02004280
M 20	2,5	17,5	140	34	16,0	12,0	02004290
M 22	2,5	19,5	140	34	18,0	14,5	02004300
M 24	3,0	21,0	160	38	18,0	14,5	02004310
M 27	3,0	24,0	160	38	20,0	16,0	02004320
M 30	3,5	26,5	180	45	22,0	18,0	02004330
M 33	3,5	29,5	180	50	25,0	20,0	02004340
M 36	4,0	32,0	200	56	28,0	22,0	02004350
M 39	4,0	35,0	200	60	32,0	24,0	02004360
M 42	4,5	37,5	200	60	32,0	24,0	02004370
M 45	4,5	40,5	220	65	36,0	29,0	02004380
M 48	5,0	43,0	250	70	36,0	29,0	02004390
M 52	5,0	47,0	250	70	40,0	32,0	02004400
M 56	5,5	51,5	250	70	40,0	32,0	02004410
M 60	5,5	54,5	280	75	45,0	35,0	02004420
M 64	6,0	58,0	315	80	50,0	39,0	02004430
M 68	6,0	62,0	315	80	50,0	39,0	02004440
M 72	6,0	66,0	340	80	50,0	39,0	02004450
M 76	6,0	70,0	340	80	50,0	39,0	02004460
M 80	6,0	74,0	360	85	50,0	39,0	02004470
M 84	6,0	78,0	380	85	50,0	39,0	02004480
M 88	6,0	82,0	380	85	50,0	39,0	02004490
M 90	6,0	84,0	380	85	50,0	39,0	02004500
M 92	6,0	86,0	400	90	56,0	44,0	02004510
M 96	6,0	90,0	400	90	56,0	44,0	02004520
M 100	6,0	94,0	400	90	56,0	44,0	02004530

MACHINE TAPS DIN 371 / 376

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 371)	Hole type	Through hole < 1.1/2×d
Thread	M	Direction	Right
Material	HSSE-G / VAP	Tolerance	6H
Raw material	Stainless steel	Form	Form B

Machine tap with reinforced shank, 4-5 thread chamfer, with spiral point, vaporised

						◇	Art.-No.
M 2	0,4	1,6	45	8	2,8	2,1	01005080
M 2,2	0,45	1,75	45	9	2,8	2,1	01005090
M 2,3	0,4	1,9	45	9	2,8	2,1	01005100
M 2,5	0,45	2,05	50	9	2,8	2,1	01005110
M 2,6	0,45	2,1	50	9	2,8	2,1	01005120
M 3	0,5	2,5	56	11	3,5	2,7	01005130
M 3,5	0,6	2,9	56	12	4,0	3,0	01005140
M 4	0,7	3,3	63	13	4,5	3,4	01005150
M 5	0,8	4,2	70	16	6,0	4,9	01005170
M 6	1,0	5,0	80	19	6,0	4,9	01005190
M 7	1,0	6,0	80	19	7,0	5,5	01005200
M 8	1,25	6,8	90	22	8,0	6,2	01005210
M 10	1,5	8,5	100	24	10,0	8,0	01005230

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 376)	Hole type	Through hole < 1.1/2×d
Thread	M	Direction	Right
Material	HSSE-G / VAP	Tolerance	6H
Raw material	Stainless steel	Form	Form B

Machine tap with overflow shank, 4-5 thread chamfer, with spiral point, vaporised

						◇	Art.-No.
M 3	0,5	2,5	56	11	2,2	—	02005130
M 4	0,7	3,3	63	13	2,8	2,1	02005150
M 5	0,8	4,2	70	16	3,5	2,7	02005170
M 6	1,0	5,0	80	19	4,5	3,4	02005190
M 8	1,25	6,8	90	22	6,0	4,9	02005210
M 10	1,5	8,5	100	24	7,0	5,5	02005230
M 12	1,75	10,2	110	28	9,0	7,0	02005250
M 14	2,0	12,0	110	30	11,0	9,0	02005260
M 16	2,0	14,0	110	32	12,0	9,0	02005270
M 18	2,5	15,5	125	34	14,0	11,0	02005280
M 20	2,5	17,5	140	34	16,0	12,0	02005290
M 22	2,5	19,5	140	34	18,0	14,5	02005300
M 24	3,0	21,0	160	38	18,0	14,5	02005310
M 27	3,0	24,0	160	38	20,0	16,0	02005320
M 30	3,5	26,5	180	45	22,0	18,0	02005330
M 33	3,5	29,5	180	50	25,0	20,0	02005340
M 36	4,0	32,0	200	56	28,0	22,0	02005350

MACHINE TAPS DIN 371 / 376

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 371)	Hole type	Through hole < 1.1/2×d
Thread	M	Direction	Right
Material	HSSE-G	Tolerance	6H
Raw material	Bronze, copper, aluminium	Form	Form B / AZ

Machine tap with reinforced shank, with spiral point and interrupted threads

						◇	Art.-No.
M 2	0,4	1,6	45	8	2,8	2,1	01102080
M 2,2	0,45	1,75	45	9	2,8	2,1	01102090
M 2,3	0,4	1,9	45	9	2,8	2,1	01102100
M 2,5	0,45	2,05	50	9	2,8	2,1	01102110
M 2,6	0,45	2,1	50	9	2,8	2,1	01102120
M 3	0,5	2,5	56	11	3,5	2,7	01102130
M 3,5	0,6	2,9	56	12	4,0	3,0	01102140
M 4	0,7	3,3	63	13	4,5	3,4	01102150
M 5	0,8	4,2	70	16	6,0	4,9	01102170
M 6	1,0	5,0	80	19	6,0	4,9	01102190
M 7	1,0	6,0	80	19	7,0	5,5	01102200
M 8	1,25	6,8	90	22	8,0	6,2	01102210
M 10	1,5	8,5	100	24	10,0	8,0	01102230

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 376)	Hole type	Through hole < 1.1/2×d
Thread	M	Direction	Right
Material	HSSE-G	Tolerance	6H
Raw material	Bronze, copper, aluminium	Form	Form B / AZ

Machine tap with overflow shank, with spiral point and interrupted threads

						◇	Art.-No.
M 12	1,75	10,2	110	28	9,0	7,0	02102250
M 14	2,0	12,0	110	30	11,0	9,0	02102260
M 16	2,0	14,0	110	32	12,0	9,0	02102270
M 18	2,5	15,5	125	34	14,0	11,0	02102280
M 20	2,5	17,5	140	34	16,0	12,0	02102290
M 22	2,5	19,5	140	34	18,0	14,5	02102300
M 24	3,0	21,0	160	38	18,0	14,5	02102310
M 27	3,0	24,0	160	38	20,0	16,0	02102320
M 30	3,5	26,5	180	45	22,0	18,0	02102330
M 33	3,5	29,5	180	50	25,0	20,0	02102340
M 36	4,0	32,0	200	56	28,0	22,0	02102350

GSR

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 371)	Hole type	Through hole < 1.1/2×d
Thread	M	Direction	Right
Material	HSSE-G / TIN	Tolerance	6H
Raw material	Steel	Form	Form B

Machine tap with reinforced shank, 4-5 thread chamfer, titanium nitrified, with spiral point

							Art.-No.
M 2	0,4	1,6	45	8	2,8	2,1	01105080
M 2,2	0,45	1,75	45	9	2,8	2,1	01105090
M 2,3	0,4	1,9	45	9	2,8	2,1	01105100
M 2,5	0,45	2,05	50	9	2,8	2,1	01105110
M 2,6	0,45	2,1	50	9	2,8	2,1	01105120
M 3	0,5	2,5	56	11	3,5	2,7	01105130
M 3,5	0,6	2,9	56	12	4,0	3,0	01105140
M 4	0,7	3,3	63	13	4,5	3,4	01105150
M 5	0,8	4,2	70	16	6,0	4,9	01105170
M 6	1,0	5,0	80	19	6,0	4,9	01105190
M 7	1,0	6,0	80	19	7,0	5,5	01105200
M 8	1,25	6,8	90	22	8,0	6,2	01105210
M 10	1,5	8,5	100	24	10,0	8,0	01105230

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 376)	Hole type	Through hole < 1.1/2×d
Thread	M	Direction	Right
Material	HSSE-G / TIN	Tolerance	6H
Raw material	Steel	Form	Form B

Machine tap with overflow shank, 4-5 thread chamfer, titanium nitrified, with spiral point

							Art.-No.
M 12	1,75	10,2	110	28	9,0	7,0	02105250
M 14	2,0	12,0	110	30	11,0	9,0	02105260
M 16	2,0	14,0	110	32	12,0	9,0	02105270
M 18	2,5	15,5	125	34	14,0	11,0	02105290
M 20	2,5	17,5	140	34	16,0	12,0	02105300
M 22	2,5	19,5	140	34	18,0	14,5	02105310
M 24	3,0	21,0	160	38	18,0	14,5	02105320
M 27	3,0	24,0	160	38	20,0	16,0	02105330
M 30	3,5	26,5	180	45	22,0	18,0	02105340
M 33	3,5	29,5	180	50	25,0	20,0	02105350
M 36	4,0	32,0	200	56	28,0	22,0	02105360

MACHINE TAPS DIN 371 / 376

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 371)	Hole type	Through/blind hole < 1.1/2×d
Thread	M	Direction	Right
Material	HSS-G	Tolerance	6H
Raw material	Steel	Form	Form C

Machine tap with reinforced shank, 2-3 thread chamfer, straight flute

							Art.-No.
M 2	0,4	1,6	45	8	2,8	2,1	00326080
M 2,2	0,45	1,75	45	9	2,8	2,1	00326090
M 2,3	0,4	1,9	45	9	2,8	2,1	00326100
M 2,5	0,45	2,05	50	9	2,8	2,1	00326110
M 2,6	0,45	2,1	50	9	2,8	2,1	00326120
M 3	0,5	2,5	56	11	3,5	2,7	00326130
M 3,5	0,6	2,9	56	12	4,0	3,0	00326140
M 4	0,7	3,3	63	13	4,5	3,4	00326150
M 5	0,8	4,2	70	16	6,0	4,9	00326170
M 6	1,0	5,0	80	19	6,0	4,9	00326190
M 7	1,0	6,0	80	19	7,0	5,5	00326200
M 8	1,25	6,8	90	22	8,0	6,2	00326210
M 10	1,5	8,5	100	24	10,0	8,0	00326230

GSR

MACHINE TAPS

Machine tap with overflow shank, 2-3 thread chamfer, straight flute

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 371)	Hole type	Through/blind hole < 1.1/2×d
Thread	M	Direction	Right
Material	HSS-G	Tolerance	6H
Raw material	Steel	Form	Form C

						◇	Art.-No.
M 3	0,5	2,5	56	11	2,2	—	00308130
M 4	0,7	3,3	63	13	2,8	2,1	00308150
M 5	0,8	4,2	70	16	3,5	2,7	00308170
M 6	1,0	5,0	80	19	4,5	3,4	00308190
M 7	1,0	6,0	80	19	5,5	4,3	00308200
M 8	1,25	6,8	90	22	6,0	4,9	00308210
M 10	1,5	8,5	100	24	7,0	5,5	00308230
M 12	1,75	10,2	110	28	9,0	7,0	00308250
M 14	2,0	12,0	110	30	11,0	9,0	00308260
M 16	2,0	14,0	110	32	12,0	9,0	00308270
M 18	2,5	15,5	125	34	14,0	11,0	00308280
M 20	2,5	17,5	140	34	16,0	12,0	00308290
M 22	2,5	19,5	140	34	18,0	14,5	00308300
M 24	3,0	21,0	160	38	18,0	14,5	00308310
M 27	3,0	24,0	160	38	20,0	16,0	00308320
M 30	3,5	26,5	180	45	22,0	18,0	00308330
M 33	3,5	29,5	180	50	25,0	20,0	00308340
M 36	4,0	32,0	200	56	28,0	22,0	00308350
M 39	4,0	35,0	200	60	32,0	24,0	00308360
M 42	4,5	37,5	200	60	32,0	24,0	00308370
M 45	4,5	40,5	220	65	36,0	29,0	00308380
M 48	5,0	43,0	250	70	36,0	29,0	00308390
M 52	5,0	47,0	250	70	40,0	32,0	00308400
M 56	5,5	51,5	250	70	40,0	32,0	00308410
M 60	5,5	54,5	280	75	45,0	35,0	00308420
M 64	6,0	58,0	315	80	50,0	39,0	00308430
M 68	6,0	62,0	315	80	50,0	39,0	00308440
M 72	6,0	66,0	340	80	50,0	39,0	00308450
M 76	6,0	70,0	340	80	50,0	39,0	00308460
M 80	6,0	74,0	360	85	50,0	39,0	00308470
M 84	6,0	78,0	380	85	50,0	39,0	00308480
M 88	6,0	82,0	380	85	50,0	39,0	00308490
M 90	6,0	84,0	380	85	50,0	39,0	00308500
M 92	6,0	86,0	400	90	56,0	44,0	00308510
M 96	6,0	90,0	400	90	56,0	44,0	00308520
M 100	6,0	94,0	400	90	56,0	44,0	00308530

MACHINE TAPS DIN 371 / 376

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 371)	Hole type	Through/blind hole < 1.1/2×d
Thread	M	Direction	Right
Material	HSSE-G	Tolerance	6H
Raw material	Steel, brass	Form	Form C

Machine tap with reinforced shank, 2-3 thread chamfer, straight flute

							Art.-No.
M 2	0,4	1,6	45	8	2,8	2,1	01006080
M 2,2	0,45	1,75	45	9	2,8	2,1	01006090
M 2,3	0,4	1,9	45	9	2,8	2,1	01006100
M 2,5	0,45	2,05	50	9	2,8	2,1	01006110
M 2,6	0,45	2,1	50	9	2,8	2,1	01006120
M 3	0,5	2,5	56	11	3,5	2,7	01006130
M 3,5	0,6	2,9	56	12	4,0	3,0	01006140
M 4	0,7	3,3	63	13	4,5	3,4	01006150
M 5	0,8	4,2	70	16	6,0	4,9	01006170
M 6	1,0	5,0	80	19	6,0	4,9	01006190
M 7	1,0	6,0	80	19	7,0	5,5	01006200
M 8	1,25	6,8	90	22	8,0	6,2	01006210
M 10	1,5	8,5	100	24	10,0	8,0	01006220

GSR

MACHINE TAPS

Machine tap with overflow shank, 2-3 thread chamfer, straight flute

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 376)	Hole type	Through hole < 1.1/2×d
Thread	M	Direction	Right
Material	HSSE-G	Tolerance	6H
Raw material	Steel, brass	Form	Form C

						◇	Art.-No.
M 3	0,5	2,5	56	11	2,2	—	02006170
M 4	0,7	3,3	63	13	2,8	2,1	02006180
M 5	0,8	4,2	70	16	3,5	2,7	02006190
M 6	1,0	5,0	80	19	4,5	3,4	02006200
M 7	1,0	6,0	80	19	5,5	4,3	02006210
M 8	1,25	6,8	90	22	6,0	4,9	02006220
M 10	1,5	8,5	100	24	7,0	5,5	02006230
M 12	1,75	10,2	110	28	9,0	7,0	02006250
M 14	2,0	12,0	110	30	11,0	9,0	02006260
M 16	2,0	14,0	110	32	12,0	9,0	02006270
M 18	2,5	15,5	125	34	14,0	11,0	02006280
M 20	2,5	17,5	140	34	16,0	12,0	02006290
M 22	2,5	19,5	140	34	18,0	14,5	02006300
M 24	3,0	21,0	160	38	18,0	14,5	02006310
M 27	3,0	24,0	160	38	20,0	16,0	02006320
M 30	3,5	26,5	180	45	22,0	18,0	02006330
M 33	3,5	29,5	180	50	25,0	20,0	02006340
M 36	4,0	32,0	200	56	28,0	22,0	02006350
M 39	4,0	35,0	200	60	32,0	24,0	02006360
M 42	4,5	37,5	200	60	32,0	24,0	02006370
M 45	4,5	40,5	220	65	36,0	29,0	02006380
M 48	5,0	43,0	250	70	36,0	29,0	02006390
M 52	5,0	47,0	250	70	40,0	32,0	02006400
M 56	5,5	51,5	250	70	40,0	32,0	02006410
M 60	5,5	54,5	280	75	45,0	35,0	02006420
M 64	6,0	58,0	315	80	50,0	39,0	02006430
M 68	6,0	62,0	315	80	50,0	39,0	02006440
M 72	6,0	66,0	340	80	50,0	39,0	02006450
M 76	6,0	70,0	340	80	50,0	39,0	02006460
M 80	6,0	74,0	360	85	50,0	39,0	02006470
M 84	6,0	78,0	380	85	50,0	39,0	02006480
M 88	6,0	82,0	380	85	50,0	39,0	02006490
M 90	6,0	84,0	380	85	50,0	39,0	02006500
M 92	6,0	86,0	400	90	56,0	44,0	02006510
M 96	6,0	90,0	400	90	56,0	44,0	02006520
M 100	6,0	94,0	400	90	56,0	44,0	02006530

MACHINE TAPS DIN 371 / 376

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 371)	Hole type	Through/blind hole < 1.1/2×d
Thread	M	Direction	Right
Material	HSSE-G / VAP	Tolerance	6H
Raw material	Stainless steel	Form	Form C

Machine tap with reinforced shank, 2-3 thread chamfer, straight flute, vaporised

						◇	Art.-No.
M 2	0,4	1,6	45	8	2,8	2,1	01116080
M 2,2	0,45	1,75	45	9	2,8	2,1	01116090
M 2,3	0,4	1,9	45	9	2,8	2,1	01116100
M 2,5	0,45	2,05	50	9	2,8	2,1	01116110
M 2,6	0,45	2,1	50	9	2,8	2,1	01116120
M 3	0,5	2,5	56	11	3,5	2,7	01116130
M 3,5	0,6	2,9	56	12	4,0	3,0	01116140
M 4	0,7	3,3	63	13	4,5	3,4	01116150
M 5	0,8	4,2	70	16	6,0	4,9	01116170
M 6	1,0	5,0	80	19	6,0	4,9	01116190
M 7	1,0	6,0	80	19	7,0	5,5	01116200
M 8	1,25	6,8	90	22	8,0	6,2	01116210
M 10	1,5	8,5	100	24	10,0	8,0	01116230

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 376)	Hole type	Through/blind hole < 1.1/2×d
Thread	M	Direction	Right
Material	HSSE-G / VAP	Tolerance	6H
Raw material	Stainless steel	Form	Form C

Machine tap with overflow shank, 2-3 thread chamfer, straight flute, vaporised

						◇	Art.-No.
M 12	1,75	10,2	110	28	9,0	7,0	02116250
M 14	2,0	12,0	110	30	11,0	9,0	02116260
M 16	2,0	14,0	110	32	12,0	9,0	02116270
M 18	2,5	15,5	125	34	14,0	11,0	02116280
M 20	2,5	17,5	140	34	16,0	12,0	02116290
M 22	2,5	19,5	140	34	18,0	14,5	02116300
M 24	3,0	21,0	160	38	18,0	14,5	02116310
M 27	3,0	24,0	160	38	20,0	16,0	02116320
M 30	3,5	26,5	180	45	22,0	18,0	02116330
M 33	3,5	29,5	180	50	25,0	20,0	02116340
M 36	4,0	32,0	200	56	28,0	22,0	02116350

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 371)	Hole type	Through/blind hole < 1.1/2×d
Thread	M	Direction	Right
Material	HSSE-G / TIN	Tolerance	6H
Raw material	Steel	Form	Form C

Machine tap with reinforced shank, 2-3 thread chamfer, titanium nitrified

							Art.-No.
M 2	0,4	1,6	45	8	2,8	2,1	01106080
M 2,2	0,45	1,75	45	9	2,8	2,1	01106090
M 2,3	0,4	1,9	45	9	2,8	2,1	01106100
M 2,5	0,45	2,05	50	9	2,8	2,1	01106110
M 2,6	0,45	2,1	50	9	2,8	2,1	01106120
M 3	0,5	2,5	56	11	3,5	2,7	01106130
M 3,5	0,6	2,9	56	12	4,0	3,0	01106140
M 4	0,7	3,3	63	13	4,5	3,4	01106150
M 5	0,8	4,2	70	16	6,0	4,9	01106170
M 6	1,0	5,0	80	19	6,0	4,9	01106190
M 7	1,0	6,0	80	19	7,0	5,5	01106200
M 8	1,25	6,8	90	22	8,0	6,2	01106210
M 10	1,5	8,5	100	24	10,0	8,0	01106230

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 376)	Hole type	Through/blind hole < 1.1/2×d
Thread	M	Direction	Right
Material	HSSE-G / TIN	Tolerance	6H
Raw material	Steel	Form	Form C

Machine tap with overflow shank, 2-3 thread chamfer, titanium nitrified

							Art.-No.
M 12	1,75	10,2	110	28	9,0	7,0	02106250
M 14	2,0	12,0	110	30	11,0	9,0	02106260
M 16	2,0	14,0	110	32	12,0	9,0	02106270
M 18	2,5	15,5	125	34	14,0	11,0	02106280
M 20	2,5	17,5	140	34	16,0	12,0	02106290
M 22	2,5	19,5	140	34	18,0	14,5	02106300
M 24	3,0	21,0	160	38	18,0	14,5	02106310
M 27	3,0	24,0	160	38	20,0	16,0	02106320
M 30	3,5	26,5	180	45	22,0	18,0	02106330
M 33	3,5	29,5	180	50	25,0	20,0	02106340
M 36	4,0	32,0	200	56	28,0	22,0	02106350

MACHINE TAPS DIN 371 / 376

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 371)	Hole type	Blind hole < 2×d
Thread	M	Direction	Right
Material	HSS-G	Tolerance	6H
Raw material	Steel	Form	Form C / RSP 15°

Machine tap with reinforced shank, 2-3 thread chamfer, 15° right spiral flute

							Art.-No.
M 2	0,4	1,6	45	8	2,8	2,1	00305080
M 2,2	0,45	1,75	45	9	2,8	2,1	00305090
M 2,3	0,4	1,9	45	9	2,8	2,1	00305100
M 2,5	0,45	2,05	50	9	2,8	2,1	00305110
M 2,6	0,45	2,1	50	9	2,8	2,1	00305120
M 3	0,5	2,5	56	11	3,5	2,7	00305130
M 3,5	0,6	2,9	56	12	4,0	3,0	00305140
M 4	0,7	3,3	63	13	4,5	3,4	00305150
M 5	0,8	4,2	70	16	6,0	4,9	00305170
M 6	1,0	5,0	80	19	6,0	4,9	00305190
M 7	1,0	6,0	80	19	7,0	5,5	00305200
M 8	1,25	6,8	90	22	8,0	6,2	00305210
M 10	1,5	8,5	100	24	10,0	8,0	00305230

GSR

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 376)	Hole type	Blind hole < 2×d
Thread	M	Direction	Right
Material	HSS-G	Tolerance	6H
Raw material	Steel	Form	Form C / RSP 15°

Machine tap with overflow shank, 2-3 thread chamfer, 15° right spiral flute

						◇	Art.-No.
M 3	0,5	2,5	56	11	2,2	—	00310130
M 4	0,7	3,3	63	13	2,8	2,1	00310150
M 5	0,8	4,2	70	16	3,5	2,7	00310170
M 6	1,0	5,0	80	19	4,5	3,4	00310190
M 7	1,0	6,0	80	19	5,5	4,3	00310200
M 8	1,25	6,8	90	22	6,0	4,9	00310210
M 10	1,5	8,5	100	24	7,0	5,5	00310230
M 12	1,75	10,2	110	28	9,0	7,0	00310250
M 14	2,0	12,0	110	30	11,0	9,0	00310260
M 16	2,0	14,0	110	32	12,0	9,0	00310270
M 18	2,5	15,5	125	34	14,0	11,0	00310280
M 20	2,5	17,5	140	34	16,0	12,0	00310290
M 22	2,5	19,5	140	34	18,0	14,5	00310300
M 24	3,0	21,0	160	38	18,0	14,5	00310310
M 27	3,0	24,0	160	38	20,0	16,0	00310320
M 30	3,5	26,5	180	45	22,0	18,0	00310330
M 33	3,5	29,5	180	50	25,0	20,0	00310340
M 36	4,0	32,0	200	56	28,0	22,0	00310350
M 39	4,0	35,0	200	60	32,0	24,0	00310360
M 42	4,5	37,5	200	60	32,0	24,0	00310370
M 45	4,5	40,5	220	65	36,0	29,0	00310380
M 48	5,0	43,0	250	70	36,0	29,0	00310390
M 52	5,0	47,0	250	70	40,0	32,0	00310400
M 56	5,5	51,5	250	70	40,0	32,0	00310410
M 60	5,5	54,5	280	75	45,0	35,0	00310420
M 64	6,0	58,0	315	80	50,0	39,0	00310430
M 68	6,0	62,0	315	80	50,0	39,0	00310440
M 72	6,0	66,0	340	80	50,0	39,0	00310450
M 76	6,0	70,0	340	80	50,0	39,0	00310460
M 80	6,0	74,0	360	85	50,0	39,0	00310470
M 84	6,0	78,0	380	85	50,0	39,0	00310480
M 88	6,0	82,0	380	85	50,0	39,0	00310490
M 90	6,0	84,0	380	85	50,0	39,0	00310500
M 92	6,0	86,0	400	90	56,0	44,0	00310510
M 96	6,0	90,0	400	90	56,0	44,0	00310520
M 100	6,0	94,0	400	90	56,0	44,0	00310530

MACHINE TAPS DIN 371 / 376

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 371)	Hole type	Blind hole < 2×d
Thread	M	Direction	Right
Material	HSSE-G	Tolerance	6H
Raw material	Steel	Form	Form C / RSP 15°

Machine tap with reinforced shank, 2-3 thread chamfer, 15° right spiral flute

							Art.-No.
M 2	0,4	1,6	45	8	2,8	2,1	01013080
M 2,2	0,45	1,75	45	9	2,8	2,1	01013090
M 2,3	0,4	1,9	45	9	2,8	2,1	01013100
M 2,5	0,45	2,05	50	9	2,8	2,1	01013110
M 2,6	0,45	2,1	50	9	2,8	2,1	01013120
M 3	0,5	2,5	56	11	3,5	2,7	01013130
M 3,5	0,6	2,9	56	12	4,0	3,0	01013140
M 4	0,7	3,3	63	13	4,5	3,4	01013150
M 5	0,8	4,2	70	16	6,0	4,9	01013170
M 6	1,0	5,0	80	19	6,0	4,9	01013190
M 7	1,0	6,0	80	19	7,0	5,5	01013200
M 8	1,25	6,8	90	22	8,0	6,2	01013210
M 10	1,5	8,5	100	24	10,0	8,0	01013230

GSR

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 376)	Hole type	Blind hole < 2×d
Thread	M	Direction	Right
Material	HSSE-G	Tolerance	6H
Raw material	Steel	Form	Form C / RSP 15°

Machine tap with overflow shank, 2-3 thread chamfer, 15° right spiral flute

						◇	Art.-No.
M 3	0,5	2,5	56	11	2,2	—	02013130
M 4	0,7	3,3	63	13	2,8	2,1	02013150
M 5	0,8	4,2	70	16	3,5	2,7	02013170
M 6	1,0	5,0	80	19	4,5	3,4	02013190
M 7	1,0	6,0	80	19	5,5	4,3	02013200
M 8	1,25	6,8	90	22	6,0	4,9	02013210
M 10	1,5	8,5	100	24	7,0	5,5	02013230
M 12	1,75	10,2	110	28	9,0	7,0	02013250
M 14	2,0	12,0	110	30	11,0	9,0	02013260
M 16	2,0	14,0	110	32	12,0	9,0	02013270
M 18	2,5	15,5	125	34	14,0	11,0	02013280
M 20	2,5	17,5	140	34	16,0	12,0	02013290
M 22	2,5	19,5	140	34	18,0	14,5	02013300
M 24	3,0	21,0	160	38	18,0	14,5	02013310
M 27	3,0	24,0	160	38	20,0	16,0	02013320
M 30	3,5	26,5	180	45	22,0	18,0	02013330
M 33	3,5	29,5	180	50	25,0	20,0	02013340
M 36	4,0	32,0	200	56	28,0	22,0	02013350
M 39	4,0	35,0	200	60	32,0	24,0	02013360
M 42	4,5	37,5	200	60	32,0	24,0	02013370
M 45	4,5	40,5	220	65	36,0	29,0	02013380
M 48	5,0	43,0	250	70	36,0	29,0	02013390
M 52	5,0	47,0	250	70	40,0	32,0	02013400
M 56	5,5	51,5	250	70	40,0	32,0	02013410
M 60	5,5	54,5	280	75	45,0	35,0	02013420
M 64	6,0	58,0	315	80	50,0	39,0	02013430
M 68	6,0	62,0	315	80	50,0	39,0	02013440
M 72	6,0	66,0	340	80	50,0	39,0	02013450
M 76	6,0	70,0	340	80	50,0	39,0	02013460
M 80	6,0	74,0	360	85	50,0	39,0	02013470
M 84	6,0	78,0	380	85	50,0	39,0	02013480
M 88	6,0	82,0	380	85	50,0	39,0	02013490
M 90	6,0	84,0	380	85	50,0	39,0	02013500
M 92	6,0	86,0	400	90	56,0	44,0	02013510
M 96	6,0	90,0	400	90	56,0	44,0	02013520
M 100	6,0	94,0	400	90	56,0	44,0	02013530

MACHINE TAPS DIN 371 / 376

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 371)	Hole type	Blind hole < 2×d
Thread	M	Direction	Right
Material	HSS-G	Tolerance	6H
Raw material	Steel	Form	Form C / RSP 35°

Machine tap with reinforced shank, 2-3 thread chamfer, 35° right spiral flute

							Art.-No.
M 2	0,4	1,6	45	8	2,8	2,1	00306080
M 2,2	0,45	1,75	45	9	2,8	2,1	00306090
M 2,3	0,4	1,9	45	9	2,8	2,1	00306100
M 2,5	0,45	2,05	50	9	2,8	2,1	00306110
M 2,6	0,45	2,1	50	9	2,8	2,1	00306120
M 3	0,5	2,5	56	7	3,5	2,7	00306130
M 3,5	0,6	2,9	56	7	4,0	3,0	00306140
M 4	0,7	3,3	63	8	4,5	3,4	00306150
M 5	0,8	4,2	70	10	6,0	4,9	00306170
M 6	1,0	5,0	80	12	6,0	4,9	00306190
M 7	1,0	6,0	80	12	7,0	5,5	00306200
M 8	1,25	6,8	90	16	8,0	6,2	00306210
M 10	1,5	8,5	100	16	10,0	8,0	00306230

GSR

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 376)	Hole type	Blind hole < 2×d
Thread	M	Direction	Right
Material	HSS-G	Tolerance	6H
Raw material	Steel	Form	Form C / RSP 35°

Machine tap with overflow shank, 2-3 thread chamfer, 35° right spiral flute

						◇	Art.-No.
M 3	0,5	2,5	56	7	2,2	—	00311130
M 4	0,7	3,3	63	8	2,8	2,1	00311150
M 5	0,8	4,2	70	10	3,5	2,7	00311170
M 6	1,0	5,0	80	12	4,5	3,4	00311190
M 7	1,0	6,0	80	12	5,5	4,3	00311200
M 8	1,25	6,8	90	16	6,0	4,9	00311210
M 10	1,5	8,5	100	16	7,0	5,5	00311230
M 12	1,75	10,2	110	18	9,0	7,0	00311250
M 14	2,0	12,0	110	20	11,0	9,0	00311260
M 16	2,0	14,0	110	22	12,0	9,0	00311270
M 18	2,5	15,5	125	25	14,0	11,0	00311280
M 20	2,5	17,5	140	25	16,0	12,0	00311290
M 22	2,5	19,5	140	25	18,0	14,5	00311300
M 24	3,0	21,0	160	30	18,0	14,5	00311310
M 27	3,0	24,0	160	30	20,0	16,0	00311320
M 30	3,5	26,5	180	35	22,0	18,0	00311330
M 33	3,5	29,5	180	35	25,0	20,0	00311340
M 36	4,0	32,0	200	45	28,0	22,0	00311350
M 39	4,0	35,0	200	45	32,0	24,0	00311360
M 42	4,5	37,5	200	45	32,0	24,0	00311370
M 45	4,5	40,5	220	50	36,0	29,0	00311380
M 48	5,0	43,0	250	50	36,0	29,0	00311390
M 52	5,0	47,0	250	55	40,0	32,0	00311400
M 56	5,5	51,5	250	55	40,0	32,0	00311410
M 60	5,5	54,5	280	55	45,0	35,0	00311420
M 64	6,0	58,0	315	70	50,0	39,0	00311430
M 68	6,0	62,0	315	70	50,0	39,0	00311440
M 72	6,0	66,0	340	80	50,0	39,0	00311450
M 76	6,0	70,0	340	80	50,0	39,0	00311460
M 80	6,0	74,0	360	85	50,0	39,0	00311470
M 84	6,0	78,0	380	85	50,0	39,0	00311480
M 88	6,0	82,0	380	85	50,0	39,0	00311490
M 90	6,0	84,0	380	85	50,0	39,0	00311500
M 92	6,0	86,0	400	90	56,0	44,0	00311510
M 96	6,0	90,0	400	90	56,0	44,0	00311520
M 100	6,0	94,0	400	90	56,0	44,0	00311530

MACHINE TAPS DIN 371 / 376

MACHINE TAPS

Machine tap with reinforced shank, 2-3 thread chamfer, 35° right spiral flute

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 371)	Hole type	Blind hole < 2×d
Thread	M	Direction	Right
Material	HSSE-G	Tolerance	6H
Raw material	Steel	Form	Form C / RSP 35°

						◇	Art.-No.
M 2	0,4	1,6	45	8	2,8	2,1	01015080
M 2,2	0,45	1,75	45	9	2,8	2,1	01015090
M 2,3	0,4	1,9	45	9	2,8	2,1	01015100
M 2,5	0,45	2,05	50	9	2,8	2,1	01015110
M 2,6	0,45	2,1	50	9	2,8	2,1	01015120
M 3	0,5	2,5	56	7	3,5	2,7	01015130
M 3,5	0,6	2,9	56	7	4,0	3,0	01015140
M 4	0,7	3,3	63	8	4,5	3,4	01015150
M 5	0,8	4,2	70	10	6,0	4,9	01015170
M 6	1,0	5,0	80	12	6,0	4,9	01015190
M 7	1,0	6,0	80	12	7,0	5,5	01015200
M 8	1,25	6,8	90	16	8,0	6,2	01015210
M 10	1,5	8,5	100	16	10,0	8,0	01015230

GSR

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 376)	Hole type	Blind hole < 2×d
Thread	M	Direction	Right
Material	HSSE-G	Tolerance	6H
Raw material	Steel	Form	Form C / RSP 35°

Machine tap with overflow shank, 2-3 thread chamfer, 35° right spiral flute

						◇	Art.-No.
M 3	0,5	2,5	56	7	2,2	—	02015130
M 4	0,7	3,3	63	8	2,8	2,1	02015150
M 5	0,8	4,2	70	10	3,5	2,7	02015170
M 6	1,0	5,0	80	12	4,5	3,4	02015190
M 7	1,0	6,0	80	12	5,5	4,3	02015200
M 8	1,25	6,8	90	16	6,0	4,9	02015210
M 10	1,5	8,5	100	16	7,0	5,5	02015230
M 12	1,75	10,2	110	18	9,0	7,0	02015250
M 14	2,0	12,0	110	20	11,0	9,0	02015260
M 16	2,0	14,0	110	22	12,0	9,0	02015270
M 18	2,5	15,5	125	25	14,0	11,0	02015280
M 20	2,5	17,5	140	25	16,0	12,0	02015290
M 22	2,5	19,5	140	25	18,0	14,5	02015300
M 24	3,0	21,0	160	30	18,0	14,5	02015310
M 27	3,0	24,0	160	30	20,0	16,0	02015320
M 30	3,5	26,5	180	35	22,0	18,0	02015330
M 33	3,5	29,5	180	35	25,0	20,0	02015340
M 36	4,0	32,0	200	45	28,0	22,0	02015350
M 39	4,0	35,0	200	45	32,0	24,0	02015360
M 42	4,5	37,5	200	45	32,0	24,0	02015370
M 45	4,5	40,5	220	50	36,0	29,0	02015380
M 48	5,0	43,0	250	50	36,0	29,0	02015390
M 52	5,0	47,0	250	55	40,0	32,0	02015400
M 56	5,5	51,5	250	55	40,0	32,0	02015410
M 60	5,5	54,5	280	55	45,0	35,0	02015420
M 64	6,0	58,0	315	70	50,0	39,0	02015430
M 68	6,0	62,0	315	70	50,0	39,0	02015440
M 72	6,0	66,0	340	80	50,0	39,0	02015450
M 76	6,0	70,0	340	80	50,0	39,0	02015460
M 80	6,0	74,0	360	85	50,0	39,0	02015470
M 84	6,0	78,0	380	85	50,0	39,0	02015480
M 88	6,0	82,0	380	85	50,0	39,0	02015490
M 90	6,0	84,0	380	85	50,0	39,0	02015500
M 92	6,0	86,0	400	90	56,0	44,0	02015510
M 96	6,0	90,0	400	90	56,0	44,0	02015520
M 100	6,0	94,0	400	90	56,0	44,0	02015530

MACHINE TAPS DIN 371 / 376

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 371)	Hole type	Blind hole < 2×d
Thread	M	Direction	Right
Material	HSSE-G / VAP	Tolerance	6H
Raw material	Stainless steel	Form	Form C / RSP 35°

Machine tap with reinforced shank, 2-3 thread chamfer, 35° right spiral flute

							Art.-No.
M 2	0,4	1,6	45	8	2,8	2,1	01016080
M 2,2	0,45	1,75	45	9	2,8	2,1	01016090
M 2,3	0,4	1,9	45	9	2,8	2,1	01016100
M 2,5	0,45	2,05	50	9	2,8	2,1	01016110
M 2,6	0,45	2,1	50	9	2,8	2,1	01016120
M 3	0,5	2,5	56	7	3,5	2,7	01016130
M 3,5	0,6	2,9	56	7	4,0	3,0	01016140
M 4	0,7	3,3	63	8	4,5	3,4	01016150
M 5	0,8	4,2	70	10	6,0	4,9	01016170
M 6	1,0	5,0	80	12	6,0	4,9	01016190
M 7	1,0	6,0	80	12	7,0	5,5	01016200
M 8	1,25	6,8	90	16	8,0	6,2	01016210
M 10	1,5	8,5	100	16	10,0	8,0	01016230

GSR

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 376)	Hole type	Blind hole < 2×d
Thread	M	Direction	Right
Material	HSSE-G / VAP	Tolerance	6H
Raw material	Stainless steel	Form	Form C / RSP 35°

Machine tap with overflow shank, 2-3 thread chamfer, 35° right spiral flute

						◇	Art.-No.
M 10	1,5	8,5	100	16	7,0	5,5	02016230
M 12	1,75	10,2	110	18	9,0	7,0	02016250
M 14	2,0	12,0	110	20	11,0	9,0	02016260
M 16	2,0	14,0	110	22	12,0	9,0	02016270
M 18	2,5	15,5	125	25	14,0	11,0	02016280
M 20	2,5	17,5	140	25	16,0	12,0	02016290
M 22	2,5	19,5	140	25	18,0	14,5	02016300
M 24	3,0	21,0	160	30	18,0	14,5	02016310
M 27	3,0	24,0	160	30	20,0	16,0	02016320
M 30	3,5	26,5	180	35	22,0	18,0	02016330
M 33	3,5	29,5	180	35	25,0	20,0	02016340
M 36	4,0	32,0	200	45	28,0	22,0	02016350

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 371)	Hole type	Blind hole < 2×d
Thread	M	Direction	Right
Material	HSSE-G / TiN	Tolerance	6H
Raw material	Steel	Form	Form C / RSP 35°

Machine tap with reinforced shank, 2-3 thread chamfer, 35° right spiral flute

						◇	Art.-No.
M 2	0,4	1,6	45	8	2,8	2,1	01107080
M 2,2	0,45	1,75	45	9	2,8	2,1	01107090
M 2,3	0,4	1,9	45	9	2,8	2,1	01107100
M 2,5	0,45	2,05	50	9	2,8	2,1	01107110
M 2,6	0,45	2,1	50	9	2,8	2,1	01107120
M 3	0,5	2,5	56	7	3,5	2,7	01107130
M 3,5	0,6	2,9	56	7	4,0	3,0	01107140
M 4	0,7	3,3	63	8	4,5	3,4	01107150
M 5	0,8	4,2	70	10	6,0	4,9	01107170
M 6	1,0	5,0	80	12	6,0	4,9	01107190
M 7	1,0	6,0	80	12	7,0	5,5	01107200
M 8	1,25	6,8	90	16	8,0	6,2	01107210
M 10	1,5	8,5	100	16	10,0	8,0	01107230

MACHINE TAPS DIN 371 / 376

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 376)	Hole type	Blind hole < 2×d
Thread	M	Direction	Right
Material	HSSE-G	Tolerance	6H
Raw material	Steel	Form	Form C / RSP 35°

Machine tap with overflow shank, 2-3 thread chamfer, 35° right spiral flute, titanium nitrified

						◇	Art.-No.
M 10	1,5	8,5	100	16	7,0	5,5	02109230
M 12	1,75	10,2	110	18	9,0	7,0	02109250
M 14	2,0	12,0	110	20	11,0	9,0	02109260
M 16	2,0	14,0	110	22	12,0	9,0	02109270
M 18	2,5	15,5	125	25	14,0	11,0	02109280
M 20	2,5	17,5	140	25	16,0	12,0	02109290
M 22	2,5	19,5	140	25	18,0	14,5	02109300
M 24	3,0	21,0	160	30	18,0	14,5	02109310
M 27	3,0	24,0	160	30	20,0	16,0	02109320
M 30	3,5	26,5	180	35	22,0	18,0	02109330
M 33	3,5	29,5	180	35	25,0	20,0	02109340
M 36	4,0	32,0	200	45	28,0	22,0	02109350

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 371)	Hole type	Blind hole < 2×d
Thread	M	Direction	Right
Material	HSSE-G	Tolerance	6H
Raw material	Aluminium	Form	Form RSP 45°

Machine tap with reinforced shank, 45° right spiral flute

						◇	Art.-No.
M 2	0,4	1,6	45	8	2,8	2,1	01018080
M 2,2	0,45	1,75	45	9	2,8	2,1	01018090
M 2,3	0,4	1,9	45	9	2,8	2,1	01018100
M 2,5	0,45	2,05	50	9	2,8	2,1	01018110
M 2,6	0,45	2,1	50	9	2,8	2,1	01018120
M 3	0,5	2,5	56	11	3,5	2,7	01018130
M 3,5	0,6	2,9	56	12	4,0	3,0	01018140
M 4	0,7	3,3	63	13	4,5	3,4	01018150
M 5	0,8	4,2	70	16	6,0	4,9	01018170
M 6	1,0	5,0	80	19	6,0	4,9	01018190
M 7	1,0	6,0	80	19	7,0	5,5	01018200
M 8	1,25	6,8	90	22	8,0	6,2	01018210
M 10	1,5	8,5	100	24	10,0	8,0	01018230

MACHINE TAPS

Machine tap with overflow shank, 45° right spiral flute

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 376)	Hole type	Blind hole < 2×d
Thread	M	Direction	Right
Material	HSSE-G	Tolerance	6H
Raw material	Aluminium	Form	Form RSP 45°

						◇	Art.-No.
M 12	1,75	10,2	110	28	9,0	7,0	02018250
M 14	2,0	12,0	110	30	11,0	9,0	02018260
M 16	2,0	14,0	110	32	12,0	9,0	02018270
M 18	2,5	15,5	125	34	14,0	11,0	02018280
M 20	2,5	17,5	140	34	16,0	12,0	02018290
M 22	2,5	19,5	140	34	18,0	14,5	02018300
M 24	3,0	21,0	160	38	18,0	14,5	02018310
M 27	3,0	24,0	160	38	20,0	16,0	02018320
M 30	3,5	26,5	180	45	22,0	18,0	02018330
M 33	3,5	29,5	180	50	25,0	20,0	02018340
M 36	4,0	32,0	200	56	28,0	22,0	02018350

MACHINE TAPS DIN 374

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 374)	Hole type	Dulo < 1.1/2×d
Thread	MF	Direction	Right
Material	HSS-G	Tolerance	6H
Raw material	Steel	Form	Form B

Machine tap with overflow shank, 4-5 thread chamfer, with spiral point

						◇	Art.-No.
MF 3 × 0,35	0,35	2,65	56	8	2,2	1,9	00320000
MF 4 × 0,5	0,5	3,5	63	10	2,8	2,1	00320010
MF 5 × 0,5	0,5	4,5	70	12	3,5	2,7	00320020
MF 5 × 0,75	0,75	4,25	70	12	3,5	2,7	00320030
MF 6 × 0,5	0,5	5,5	80	14	4,5	3,4	00320040
MF 6 × 0,75	0,75	5,25	80	14	4,5	3,4	00320050
MF 7 × 0,75	0,75	6,25	80	14	5,5	4,3	00320060
MF 8 × 0,5	0,5	7,5	80	18	6,0	4,9	00320070
MF 8 × 0,75	0,75	7,25	80	18	6,0	4,9	00320080
MF 8 × 1	1,0	7,0	90	22	6,0	4,9	00320090
MF 9 × 1	1,0	8,0	90	22	7,0	5,5	00320100
MF 10 × 0,5	0,5	9,5	90	20	7,0	5,5	00320110
MF 10 × 0,75	0,75	9,25	90	20	7,0	5,5	00320120
MF 10 × 1	1,0	9,0	90	20	7,0	5,5	00320130
MF 10 × 1,25	1,25	8,75	100	20	7,0	5,5	00320140
MF 11 × 0,75	0,75	10,25	90	20	8,0	6,2	00320150
MF 11 × 1	1,0	10,0	90	20	8,0	6,2	00320160
MF 11 × 1,25	1,25	9,75	90	20	8,0	6,2	00320170
MF 12 × 0,5	0,5	11,5	100	22	9,0	7,0	00320180
MF 12 × 0,75	0,75	11,25	100	22	9,0	7,0	00320190
MF 12 × 1	1,0	11,0	100	22	9,0	7,0	00320200
MF 12 × 1,25	1,25	10,75	100	22	9,0	7,0	00320210
MF 12 × 1,5	1,5	10,5	100	22	9,0	7,0	00320220
MF 13 × 0,5	0,5	12,5	100	22	11,0	9,0	00320230
MF 13 × 0,75	0,75	12,25	100	22	11,0	9,0	00320240
MF 13 × 1	1,0	12,0	100	22	11,0	9,0	00320250
MF 13 × 1,25	1,25	11,75	100	22	11,0	9,0	00320260
MF 13 × 1,5	1,5	11,5	100	22	11,0	9,0	00320270
MF 14 × 0,5	0,5	13,5	100	22	11,0	9,0	00320280
MF 14 × 0,75	0,75	13,25	100	22	11,0	9,0	00320290
MF 14 × 1	1,0	13,0	100	22	11,0	9,0	00320300
MF 14 × 1,25	1,25	12,75	100	22	11,0	9,0	00320310
MF 14 × 1,5	1,5	12,5	100	22	11,0	9,0	00320320
MF 15 × 0,5	0,5	14,5	100	22	12,0	9,0	00320330
MF 15 × 0,75	0,75	14,25	100	22	12,0	9,0	00320340
MF 15 × 1	1,0	14,0	100	22	12,0	9,0	00320350

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						◇	Art.-No.
MF 15 × 1,25	1,25	13,8	100	22	12,0	9,0	00320360
MF 15 × 1,5	1,5	13,5	100	22	12,0	9,0	00320370
MF 16 × 0,5	0,5	15,5	100	22	12,0	9,0	00320380
MF 16 × 0,75	0,75	15,25	100	22	12,0	9,0	00320390
MF 16 × 1	1,0	15,0	100	22	12,0	9,0	00320400
MF 16 × 1,25	1,25	14,75	100	22	12,0	9,0	00320410
MF 16 × 1,5	1,5	14,5	100	22	12,0	9,0	00320420
MF 17 × 0,75	0,75	16,25	100	22	12,0	9,0	00320430
MF 17 × 1	1,0	16,0	100	22	12,0	9,0	00320440
MF 17 × 1,5	1,5	15,5	100	22	12,0	9,0	00320450
MF 18 × 0,75	0,75	17,25	110	25	14,0	11,0	00320460
MF 18 × 1	1,0	17,0	110	25	14,0	11,0	00320470
MF 18 × 1,25	1,25	16,75	110	25	14,0	11,0	00320480
MF 18 × 1,5	1,5	16,5	110	25	14,0	11,0	00320490
MF 18 × 2	2,0	16,0	125	34	14,0	11,0	00320500
MF 20 × 0,75	0,75	19,25	125	25	16,0	12,0	00320510
MF 20 × 1	1,0	19,0	125	25	16,0	12,0	00320520
MF 20 × 1,25	1,25	18,75	125	25	16,0	12,0	00320530
MF 20 × 1,5	1,5	18,5	125	25	16,0	12,0	00320540
MF 20 × 2	2,0	18,0	140	34	16,0	12,0	00320550
MF 21 × 1	1,0	20,0	125	25	16,0	12,0	00320560
MF 21 × 1,5	1,5	19,5	125	25	16,0	12,0	00320570
MF 22 × 0,75	0,75	21,25	125	25	18,0	14,5	00320580
MF 22 × 1	1,0	21,0	125	25	18,0	14,5	00320590
MF 22 × 1,25	1,25	20,75	125	25	18,0	14,5	00320600
MF 22 × 1,5	1,5	20,5	125	25	18,0	14,5	00320610
MF 22 × 2	2,0	20,0	140	34	18,0	14,5	00320620
MF 23 × 1	1,0	22,0	125	28	18,0	14,5	00320630
MF 23 × 1,5	1,5	21,5	125	28	18,0	14,5	00320640
MF 24 × 0,75	0,75	23,25	140	28	18,0	14,5	00320650
MF 24 × 1	1,0	23,0	140	28	18,0	14,5	00320660
MF 24 × 1,25	1,25	22,75	140	28	18,0	14,5	00320670
MF 24 × 1,5	1,5	22,5	140	28	18,0	14,5	00320680
MF 24 × 2	2,0	22,0	140	28	18,0	14,5	00320690
MF 25 × 1	1,0	24,0	140	28	18,0	14,5	00320700
MF 25 × 1,5	1,5	23,5	140	28	18,0	14,5	00320710
MF 25 × 2	2,0	23,0	140	28	18,0	14,5	00320720
MF 26 × 1	1,0	25,0	140	28	18,0	14,5	00320730
MF 26 × 1,5	1,5	24,5	140	28	18,0	14,5	00320740
MF 26 × 2	2,0	24,0	140	28	18,0	14,5	00320750
MF 27 × 1	1,0	26,0	150	28	20,0	16,0	00320760
MF 27 × 1,5	1,5	25,5	140	28	20,0	16,0	00320770
MF 27 × 2	2,0	25,0	140	28	20,0	16,0	00320780
MF 28 × 1	1,0	27,0	140	28	20,0	16,0	00320790

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							Art.-No.
MF 28 × 1,5	1,5	26,5	140	28	20,0	16,0	00320800
MF 28 × 2	2,0	26,0	140	28	20,0	16,0	00320810
MF 30 × 1	1,0	29,0	150	28	22,0	18,0	00320820
MF 30 × 1,5	1,5	28,5	150	28	22,0	18,0	00320830
MF 30 × 2	2,0	28,0	150	28	22,0	18,0	00320840
MF 30 × 3	3,0	27,0	180	45	22,0	18,0	00320850
MF 32 × 1	1,0	31,0	150	30	22,0	18,0	00320860
MF 32 × 1,5	1,5	30,5	150	30	22,0	18,0	00320870
MF 32 × 2	2,0	30,0	150	30	22,0	18,0	00320880
MF 32 × 3	3,0	29,0	180	50	22,0	18,0	00320890
MF 33 × 1	1,0	32,0	150	30	25,0	20,0	00320900
MF 33 × 1,5	1,5	31,5	160	30	25,0	20,0	00320910
MF 33 × 2	2,0	31,0	160	30	25,0	20,0	00320920
MF 33 × 3	3,0	30,0	180	50	25,0	20,0	00320930
MF 34 × 1	1,0	33,0	170	30	28,0	22,0	00320940
MF 34 × 1,5	1,5	32,5	170	30	28,0	22,0	00320950
MF 34 × 2	2,0	32,0	170	30	28,0	22,0	00320960
MF 34 × 3	3,0	31,0	200	56	28,0	22,0	00320970
MF 35 × 1	1,0	34,0	170	30	28,0	22,0	00320980
MF 35 × 1,5	1,5	33,5	170	30	28,0	22,0	00320990
MF 35 × 2	2,0	33,0	170	30	28,0	22,0	00321000
MF 35 × 3	3,0	32,0	200	56	28,0	22,0	00321010
MF 36 × 1	1,0	35,0	170	30	28,0	22,0	00321020
MF 36 × 1,5	1,5	34,5	170	30	28,0	22,0	00321030
MF 36 × 2	2,0	34,0	170	30	28,0	22,0	00321040
MF 36 × 3	3,0	33,0	200	56	28,0	22,0	00321050
MF 38 × 1	1,0	37,0	170	30	28,0	22,0	00321060
MF 38 × 1,5	1,5	36,5	170	30	28,0	22,0	00321070
MF 38 × 2	2,0	36,0	170	30	28,0	22,0	00321080
MF 38 × 3	3,0	35,0	200	56	28,0	22,0	00321090
MF 39 × 1,5	1,5	37,5	170	30	32,0	24,0	00321100
MF 39 × 2	2,0	37,0	170	30	32,0	24,0	00321110
MF 39 × 3	3,0	36,0	200	60	32,0	24,0	00321120
MF 40 × 1,5	1,5	38,5	170	30	32,0	24,0	00321130
MF 40 × 2	2,0	38,0	170	30	32,0	24,0	00321140
MF 40 × 3	3,0	37,0	200	60	32,0	24,0	00321150
MF 42 × 1,5	1,5	40,5	170	30	32,0	24,0	00321160
MF 42 × 2	2,0	40,0	170	30	32,0	24,0	00321170
MF 42 × 3	3,0	39,0	200	60	32,0	24,0	00321180
MF 42 × 4	4,0	38,0	225	60	32,0	24,0	00321190
MF 45 × 1,5	1,5	43,5	180	32	36,0	29,0	00321200
MF 45 × 2	2,0	43,0	180	32	36,0	29,0	00321210
MF 45 × 3	3,0	42,0	200	50	36,0	29,0	00321220
MF 45 × 4	4,0	41,0	225	65	36,0	29,0	00321230

							Art.-No.
MF 48 × 1,5	1,5	46,5	190	32	36,0	29,0	00321240
MF 48 × 2	2,0	46,0	190	32	36,0	29,0	00321250
MF 48 × 3	3,0	45,0	225	50	36,0	29,0	00321260
MF 48 × 4	4,0	44,0	225	70	36,0	29,0	00321270
MF 50 × 1,5	1,5	48,5	190	32	36,0	29,0	00321280
MF 50 × 2	2,0	48,0	190	32	36,0	29,0	00321290
MF 50 × 3	3,0	47,0	225	50	36,0	29,0	00321300
MF 50 × 4	4,0	46,0	225	70	36,0	29,0	00321310
MF 52 × 1,5	1,5	50,5	190	32	40,0	32,0	00321320
MF 52 × 2	2,0	50,0	190	32	40,0	32,0	00321330
MF 52 × 3	3,0	49,0	225	50	40,0	32,0	00321340
MF 52 × 4	4,0	48,0	225	70	40,0	29,0	00321350

MACHINE TAPS

Machine tap with overflow shank, 2-3 thread chamfer, straight flute

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 374)	Hole type	Blind hole < 1.1/2×d
Thread	MF	Direction	Right
Material	HSS-G	Tolerance	6H
Raw material	Steel	Form	Form C

							Art.-No.
MF 3 × 0,35	0,35	2,65	56	8	2,2	1,9	00315230
MF 4 × 0,5	0,5	3,5	63	10	2,8	2,1	00315240
MF 5 × 0,5	0,5	4,5	70	12	3,5	2,7	00315280
MF 5 × 0,75	0,75	4,25	70	12	3,5	2,7	00315290
MF 6 × 0,5	0,5	5,5	80	14	4,5	3,4	00315310
MF 6 × 0,75	0,75	5,25	80	14	4,5	3,4	00315330
MF 7 × 0,75	0,75	6,25	80	14	5,5	4,3	00315350
MF 8 × 0,5	0,5	7,5	80	18	6,0	4,9	00315370
MF 8 × 0,75	0,75	7,25	80	18	6,0	4,9	00315390
MF 8 × 1	1,0	7,0	90	22	6,0	4,9	00315400
MF 9 × 1	1,0	8,0	90	22	7,0	5,5	00315410
MF 10 × 0,5	0,5	9,5	90	20	7,0	5,5	00315420
MF 10 × 0,75	0,75	9,25	90	20	7,0	5,5	00315430
MF 10 × 1	1,0	9,0	90	20	7,0	5,5	00315470
MF 10 × 1,25	1,25	8,75	100	20	7,0	5,5	00315480
MF 11 × 0,75	0,75	10,25	90	20	8,0	6,2	00315490
MF 11 × 1	1,0	10,0	90	20	8,0	6,2	00315500
MF 11 × 1,25	1,25	9,75	90	20	8,0	6,2	00315510
MF 12 × 0,5	0,5	11,5	100	22	9,0	7,0	00315520
MF 12 × 0,75	0,75	11,25	100	22	9,0	7,0	00315530

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							Art.-No.
MF 12 × 1	1,0	11,0	100	22	9,0	7,0	00315550
MF 12 × 1,25	1,25	10,75	100	22	9,0	7,0	00315560
MF 12 × 1,5	1,5	10,5	100	22	9,0	7,0	00315570
MF 13 × 0,5	0,5	12,5	100	22	11,0	9,0	00315580
MF 13 × 0,75	0,75	12,25	100	22	11,0	9,0	00315590
MF 13 × 1	1,0	12,0	100	22	11,0	9,0	00315600
MF 13 × 1,25	1,25	11,75	100	22	11,0	9,0	00315610
MF 13 × 1,5	1,5	11,5	100	22	11,0	9,0	00315620
MF 14 × 0,5	0,5	13,5	100	22	11,0	9,0	00315630
MF 14 × 0,75	0,75	13,25	100	22	11,0	9,0	00315640
MF 14 × 1	1,0	13,0	100	22	11,0	9,0	00315650
MF 14 × 1,25	1,25	12,75	100	22	11,0	9,0	00315660
MF 14 × 1,5	1,5	12,5	100	22	11,0	9,0	00315670
MF 15 × 0,75	0,75	14,25	100	22	12,0	9,0	00315680
MF 15 × 1	1,0	14,0	100	22	12,0	9,0	00315690
MF 15 × 1,25	1,25	13,8	100	22	12,0	9,0	00315700
MF 15 × 1,5	1,5	13,5	100	22	12,0	9,0	00315710
MF 16 × 0,5	0,5	15,5	100	22	12,0	9,0	00315720
MF 16 × 0,75	0,75	15,25	100	22	12,0	9,0	00315730
MF 16 × 1	1,0	15,0	100	22	12,0	9,0	00315750
MF 16 × 1,25	1,25	14,75	100	22	12,0	9,0	00315760
MF 16 × 1,5	1,5	14,5	100	22	12,0	9,0	00315770
MF 17 × 0,75	0,75	16,25	100	22	12,0	9,0	00315780
MF 17 × 1	1,0	16,0	100	22	12,0	9,0	00315790
MF 17 × 1,5	1,5	15,5	100	22	12,0	9,0	00315800
MF 18 × 0,75	0,75	17,25	110	25	14,0	11,0	00315810
MF 18 × 1	1,0	17,0	110	25	14,0	11,0	00315840
MF 18 × 1,25	1,25	16,75	110	25	14,0	11,0	00315850
MF 18 × 1,5	1,5	16,5	110	25	14,0	11,0	00315860
MF 18 × 2	2,0	16,0	125	34	14,0	11,0	00315870
MF 20 × 0,75	0,75	19,25	125	25	16,0	12,0	00315880
MF 20 × 1	1,0	19,0	125	25	16,0	12,0	00315930
MF 20 × 1,25	1,25	18,75	125	25	16,0	12,0	00315940
MF 20 × 1,5	1,5	18,5	125	25	16,0	12,0	00315950
MF 20 × 2	2,0	18,0	140	34	16,0	12,0	00315960
MF 21 × 1	1,0	20,0	125	25	16,0	12,0	00315970
MF 21 × 1,5	1,5	19,5	125	25	16,0	12,0	00315980
MF 22 × 0,75	0,75	21,25	125	25	18,0	14,5	00315990
MF 22 × 1	1,0	21,0	125	25	18,0	14,5	00316000
MF 22 × 1,25	1,25	20,75	125	25	18,0	14,5	00316010
MF 22 × 1,5	1,5	20,5	125	25	18,0	14,5	00316050
MF 22 × 2	2,0	20,0	140	34	18,0	14,5	00316060
MF 23 × 1	1,0	22,0	125	28	18,0	14,5	00316070
MF 23 × 1,5	1,5	21,5	125	28	18,0	14,5	00316080

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						◇	Art.-No.
MF 24 × 0,75	0,75	23,25	140	28	18,0	14,5	00316090
MF 24 × 1	1,0	23,0	140	28	18,0	14,5	00316110
MF 24 × 1,25	1,25	22,75	140	28	18,0	14,5	00316120
MF 24 × 1,5	1,5	22,5	140	28	18,0	14,5	00316130
MF 24 × 2	2,0	22,0	140	28	18,0	14,5	00316140
MF 25 × 1	1,0	24,0	140	28	18,0	14,5	00316150
MF 25 × 1,5	1,5	23,5	140	28	18,0	14,5	00316160
MF 25 × 2	2,0	23,0	140	28	18,0	14,5	00316170
MF 26 × 1	1,0	25,0	140	28	18,0	14,5	00316190
MF 26 × 1,5	1,5	24,5	140	28	18,0	14,5	00316210
MF 26 × 2	2,0	24,0	140	28	18,0	14,5	00316220
MF 27 × 1	1,0	26,0	150	28	20,0	16,0	00316230
MF 27 × 1,5	1,5	25,5	140	28	20,0	16,0	00316240
MF 27 × 2	2,0	25,0	140	28	20,0	16,0	00316250
MF 28 × 1	1,0	27,0	140	28	20,0	16,0	00316260
MF 28 × 1,5	1,5	26,5	140	28	20,0	16,0	00316270
MF 28 × 2	2,0	26,0	140	28	20,0	16,0	00316280
MF 30 × 1	1,0	29,0	150	28	22,0	18,0	00316290
MF 30 × 1,5	1,5	28,5	150	28	22,0	18,0	00316300
MF 30 × 2	2,0	28,0	150	28	22,0	18,0	00316310
MF 30 × 3	3,0	27,0	180	45	22,0	18,0	00312320
MF 32 × 1	1,0	31,0	150	30	22,0	18,0	00312330
MF 32 × 1,5	1,5	30,5	150	30	22,0	18,0	00312340
MF 32 × 2	2,0	30,0	150	30	22,0	18,0	00312350
MF 32 × 3	3,0	29,0	180	50	22,0	18,0	00312360
MF 33 × 1	1,0	32,0	150	30	25,0	20,0	00312370
MF 33 × 1,5	1,5	31,5	160	30	25,0	20,0	00312380
MF 33 × 2	2,0	31,0	160	30	25,0	20,0	00312390
MF 33 × 3	3,0	30,0	180	50	25,0	20,0	00312400
MF 34 × 1	1,0	33,0	170	30	28,0	22,0	00312410
MF 34 × 1,5	1,5	32,5	170	30	28,0	22,0	00312420
MF 34 × 2	2,0	32,0	170	30	28,0	22,0	00312430
MF 34 × 3	3,0	31,0	200	56	28,0	22,0	00312440
MF 35 × 1	1,0	34,0	170	30	28,0	22,0	00312450
MF 35 × 1,5	1,5	33,5	170	30	28,0	22,0	00312460
MF 35 × 2	2,0	33,0	170	30	28,0	22,0	00312470
MF 35 × 3	3,0	32,0	200	56	28,0	22,0	00312480
MF 36 × 1	1,0	35,0	170	30	28,0	22,0	00312490
MF 36 × 1,5	1,5	34,5	170	30	28,0	22,0	00312500
MF 36 × 2	2,0	34,0	170	30	28,0	22,0	00312510
MF 36 × 3	3,0	33,0	200	56	28,0	22,0	00312520
MF 38 × 1	1,0	37,0	170	30	28,0	22,0	00312530
MF 38 × 1,5	1,5	36,5	170	30	28,0	22,0	00312540
MF 38 × 2	2,0	36,0	170	30	28,0	22,0	00312550

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						◇	Art.-No.
MF 38 × 3	3,0	35,0	200	56	28,0	22,0	00312560
MF 39 × 1,5	1,5	37,5	170	30	32,0	24,0	00312570
MF 39 × 2	2,0	37,0	170	30	32,0	24,0	00312580
MF 39 × 3	3,0	36,0	200	60	32,0	24,0	00312590
MF 40 × 1,5	1,5	38,5	170	30	32,0	24,0	00312610
MF 40 × 2	2,0	38,0	170	30	32,0	24,0	00312620
MF 40 × 3	3,0	37,0	200	60	32,0	24,0	00312630
MF 42 × 1,5	1,5	40,5	170	30	32,0	24,0	00312640
MF 42 × 2	2,0	40,0	170	30	32,0	24,0	00312650
MF 42 × 3	3,0	39,0	200	60	32,0	24,0	00312660
MF 42 × 4	4,0	38,0	225	60	32,0	24,0	00312670
MF 45 × 1,5	1,5	43,5	180	32	36,0	29,0	00312690
MF 45 × 2	2,0	43,0	180	32	36,0	29,0	00312700
MF 45 × 3	3,0	42,0	200	50	36,0	29,0	00312710
MF 45 × 4	4,0	41,0	225	65	36,0	29,0	00312720
MF 48 × 1,5	1,5	46,5	190	32	36,0	29,0	00312740
MF 48 × 2	2,0	46,0	190	32	36,0	29,0	00312750
MF 48 × 3	3,0	45,0	225	50	36,0	29,0	00312760
MF 48 × 4	4,0	44,0	225	70	36,0	29,0	00312770
MF 50 × 1,5	1,5	48,5	190	32	36,0	29,0	00312780
MF 50 × 2	2,0	48,0	190	32	36,0	29,0	00312800
MF 50 × 3	3,0	47,0	225	50	36,0	29,0	00312810
MF 50 × 4	4,0	46,0	225	70	36,0	29,0	00312820
MF 52 × 1,5	1,5	50,5	190	32	40,0	32,0	00312840
MF 52 × 2	2,0	50,0	190	32	40,0	32,0	00312850
MF 52 × 3	3,0	49,0	225	50	40,0	32,0	00312860
MF 52 × 4	4,0	48,0	225	70	40,0	29,0	00312870

GSR

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 374)	Hole type	Blind hole < 2×d
Thread	MF	Direction	Right
Material	HSS-G	Tolerance	6H
Raw material	Steel	Form	Form C / RSP 15°

Machine tap with overflow shank, 15° right spiral flute, 2-3 thread chamfer

						◇	Art.-No.
MF 5 × 0,5	0,5	4,5	70	8	3,5	2,7	00318280
MF 6 × 0,75	0,75	5,25	80	12	4,5	3,4	00318330
MF 8 × 0,75	0,75	7,25	80	12	6,0	4,9	00318390
MF 8 × 1	1,0	7,0	90	16	6,0	4,9	00318400
MF 10 × 1	1,0	9,0	90	16	7,0	5,5	00318470
MF 10 × 1,25	1,25	8,7	100	16	7,0	5,5	00318480
MF 12 × 1	1,0	11,0	100	16	9,0	7,0	00318550
MF 12 × 1,25	1,25	10,7	100	16	9,0	7,0	00318560
MF 12 × 1,5	1,5	10,5	100	16	9,0	7,0	00318570
MF 13 × 1,5	1,5	11,5	100	16	11,0	9,0	00318620
MF 14 × 1	1,0	13,0	100	16	11,0	9,0	00318650
MF 14 × 1,25	1,25	12,75	100	16	11,0	9,0	00318660
MF 14 × 1,5	1,5	12,5	100	16	11,0	9,0	00318670
MF 15 × 1,5	1,5	13,5	100	16	12,0	9,0	00318710
MF 15 × 1,5	1,5	13,5	100	16	12,0	9,0	00318720
MF 16 × 1	1,0	15,0	100	16	12,0	9,0	00318750
MF 16 × 1,25	1,25	14,75	100	16	12,0	9,0	00318760
MF 16 × 1,5	1,5	14,5	100	16	12,0	9,0	00318770
MF 18 × 1	1,0	17,0	110	20	14,0	11,0	00318840
MF 18 × 1,5	1,5	16,5	110	20	14,0	11,0	00318860
MF 20 × 1	1,0	19,0	125	20	16,0	12,0	00318930
MF 20 × 1,5	1,5	18,5	125	20	16,0	12,0	00318950
MF 20 × 2	2,0	18,0	140	25	16,0	12,0	00318960
MF 22 × 1	1,0	21,0	125	20	18,0	14,5	00319030
MF 22 × 1,5	1,5	20,5	125	20	18,0	14,5	00319050
MF 22 × 2	2,0	20,0	140	25	18,0	14,5	00319060
MF 24 × 1	1,0	23,0	125	20	18,0	14,5	00319110
MF 24 × 1,5	1,5	22,5	140	20	18,0	14,5	00319130
MF 24 × 2	2,0	22,0	140	20	18,0	14,5	00319140
MF 26 × 1	1,0	25,0	140	20	18,0	14,5	00319190
MF 26 × 1,5	1,5	24,5	140	20	18,0	14,5	00319210
MF 26 × 2	2,0	24,0	140	20	18,0	14,5	00319220
MF 27 × 1	1,0	26,0	150	20	20,0	16,0	00319230
MF 27 × 1,5	1,5	25,5	140	20	20,0	16,0	00319240
MF 27 × 2	2,0	25,0	140	20	20,0	16,0	00319250
MF 28 × 1	1,0	27,0	150	20	20,0	16,0	00319260

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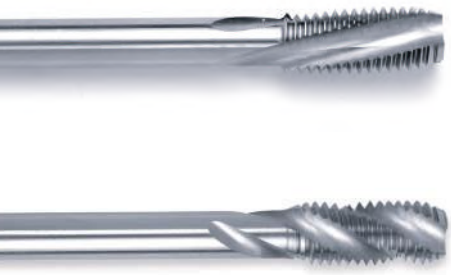
							Art.-No.
MF 28 × 1,5	1,5	26,5	140	20	20,0	16,0	00319270
MF 28 × 2	2,0	26,0	140	20	20,0	16,0	00319280
MF 30 × 1	1,0	29,0	150	22	22,0	18,0	00319290
MF 30 × 1,5	1,5	28,5	150	22	22,0	18,0	00319300
MF 30 × 2	2,0	28,0	150	22	22,0	18,0	00319310
MF 30 × 3	3,0	27,0	180	35	22,0	18,0	00319320
MF 32 × 1,5	1,5	30,5	150	22	22,0	18,0	00319340
MF 32 × 2	2,0	30,0	150	22	22,0	18,0	00319350
MF 33 × 1,5	1,5	31,5	160	25	25,0	20,0	00319380
MF 33 × 2	2,0	31,0	160	25	25,0	20,0	00319390
MF 35 × 1,5	1,5	33,5	170	25	28,0	22,0	00319460
MF 36 × 1,5	1,5	34,5	170	25	28,0	22,0	00319500
MF 36 × 2	2,0	34,0	170	25	28,0	22,0	00319510
MF 38 × 1,5	1,5	36,5	170	25	28,0	22,0	00319540
MF 39 × 1,5	1,5	37,5	170	25	32,0	24,0	00319570
MF 40 × 1,5	1,5	38,5	170	25	32,0	24,0	00319610
MF 42 × 1,5	1,5	40,5	170	25	32,0	24,0	00319640
MF 45 × 1,5	1,5	43,5	180	27	36,0	29,0	00319690
MF 48 × 1,5	1,5	46,5	190	27	36,0	29,0	00319740
MF 50 × 1,5	1,5	48,5	190	27	36,0	29,0	00319790



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MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 374)	Hole type	Blind hole < 3×d
Thread	MF	Direction	Right
Material	HSS-G	Tolerance	6H
Raw material	Steel	Form	Form C / RSP 35°

Machine tap with overflow shank, 15° right spiral flute, 2-3 thread chamfer

						◇	Art.-No.
MF 3 × 0,35	0,35	2,65	56	8	2,2	1,9	00323000
MF 4 × 0,5	0,5	3,5	63	8	2,8	2,1	00323010
MF 5 × 0,5	0,5	4,5	70	8	3,5	2,7	00323020
MF 5 × 0,75	0,75	4,25	70	8	3,5	2,7	00323030
MF 6 × 0,5	0,5	5,5	80	12	4,5	3,4	00323040
MF 6 × 0,75	0,75	5,25	80	12	4,5	3,4	00323050
MF 7 × 0,75	0,75	6,25	80	12	5,5	4,3	00323060
MF 8 × 0,5	0,5	7,5	80	12	6,0	4,9	00323070
MF 8 × 0,75	0,75	7,25	80	12	6,0	4,9	00323080
MF 8 × 1	1,0	7,0	90	16	6,0	4,9	00323090
MF 9 × 1	1,0	8,0	90	16	7,0	5,5	00323100
MF 10 × 0,5	0,5	9,5	90	16	7,0	5,5	00323110
MF 10 × 0,75	0,75	9,25	90	16	7,0	5,5	00323120
MF 10 × 1	1,0	9,0	90	16	7,0	5,5	00323130
MF 10 × 1,25	1,25	8,75	100	16	7,0	5,5	00323140
MF 11 × 0,75	0,75	10,25	90	16	8,0	6,2	00323150
MF 11 × 1	1,0	10,0	90	16	8,0	6,2	00323160
MF 11 × 1,25	1,25	9,75	90	16	8,0	6,2	00323170
MF 12 × 0,5	0,5	11,5	100	16	9,0	7,0	00323180
MF 12 × 0,75	0,75	11,25	100	16	9,0	7,0	00323190
MF 12 × 1	1,0	11,0	100	16	9,0	7,0	00323200
MF 12 × 1,25	1,25	10,75	100	16	9,0	7,0	00323210
MF 12 × 1,5	1,5	10,5	100	16	9,0	7,0	00323220
MF 13 × 0,5	0,5	12,5	100	16	11,0	9,0	00323230
MF 13 × 0,75	0,75	12,25	100	16	11,0	9,0	00323240
MF 13 × 1	1,0	12,0	100	16	11,0	9,0	00323250
MF 13 × 1,25	1,25	11,75	100	16	11,0	9,0	00323260
MF 13 × 1,5	1,5	11,5	100	16	11,0	9,0	00323270
MF 14 × 0,5	0,5	13,5	100	16	11,0	9,0	00323280
MF 14 × 0,75	0,75	13,25	100	16	11,0	9,0	00323290
MF 14 × 1	1,0	13,0	100	16	11,0	9,0	00323300
MF 14 × 1,25	1,25	12,75	100	16	11,0	9,0	00323310
MF 14 × 1,5	1,5	12,5	100	16	11,0	9,0	00323320
MF 15 × 0,5	0,5	14,5	100	16	12,0	9,0	00323330
MF 15 × 0,75	0,75	14,25	100	16	12,0	9,0	00323340
MF 15 × 1	1,0	14,0	100	16	12,0	9,0	00323350

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						◇	Art.-No.
MF 15 × 1,25	1,25	13,8	100	16	12,0	9,0	00323360
MF 15 × 1,5	1,5	13,5	100	16	12,0	9,0	00323370
MF 16 × 0,5	0,5	15,5	100	16	12,0	9,0	00323380
MF 16 × 0,75	0,75	15,25	100	16	12,0	9,0	00323390
MF 16 × 1	1,0	15,0	100	16	12,0	9,0	00323400
MF 16 × 1,25	1,25	14,75	100	16	12,0	9,0	00323410
MF 16 × 1,5	1,5	14,5	100	16	12,0	9,0	00323420
MF 17 × 0,75	0,75	16,25	100	16	12,0	9,0	00323430
MF 17 × 1	1,0	16,0	100	16	12,0	9,0	00323440
MF 17 × 1,5	1,5	15,5	100	16	12,0	9,0	00323450
MF 18 × 0,75	0,75	17,25	110	20	14,0	11,0	00323460
MF 18 × 1	1,0	17,0	110	20	14,0	11,0	00323470
MF 18 × 1,25	1,25	16,75	110	20	14,0	11,0	00323480
MF 18 × 1,5	1,5	16,5	110	20	14,0	11,0	00323490
MF 18 × 2	2,0	16,0	125	25	14,0	11,0	00323500
MF 20 × 0,75	0,75	19,25	125	20	16,0	12,0	00323510
MF 20 × 1	1,0	19,0	125	20	16,0	12,0	00323520
MF 20 × 1,25	1,25	18,75	125	20	16,0	12,0	00323530
MF 20 × 1,5	1,5	18,5	125	20	16,0	12,0	00323540
MF 20 × 2	2,0	18,0	140	25	16,0	12,0	00323550
MF 21 × 1	1,0	20,0	125	20	16,0	12,0	00323560
MF 21 × 1,5	1,5	19,5	125	20	16,0	12,0	00323570
MF 22 × 0,75	0,75	21,25	125	20	18,0	14,5	00323580
MF 22 × 1	1,0	21,0	125	20	18,0	14,5	00323590
MF 22 × 1,25	1,25	20,75	125	20	18,0	14,5	00323600
MF 22 × 1,5	1,5	20,5	125	20	18,0	14,5	00323610
MF 22 × 2	2,0	20,0	140	25	18,0	14,5	00323620
MF 23 × 1	1,0	22,0	125	20	18,0	14,5	00323630
MF 23 × 1,5	1,5	21,5	125	20	18,0	14,5	00323640
MF 24 × 0,75	0,75	23,25	140	20	18,0	14,5	00323650
MF 24 × 1	1,0	23,0	140	20	18,0	14,5	00323660
MF 24 × 1,25	1,25	22,75	140	20	18,0	14,5	00323670
MF 24 × 1,5	1,5	22,5	140	20	18,0	14,5	00323680
MF 24 × 2	2,0	22,0	140	20	18,0	14,5	00323690
MF 25 × 1	1,0	24,0	140	20	18,0	14,5	00323700
MF 25 × 1,5	1,5	23,5	140	20	18,0	14,5	00323710
MF 25 × 2	2,0	23,0	140	20	18,0	14,5	00323720
MF 26 × 1	1,0	25,0	140	20	18,0	14,5	00323730
MF 26 × 1,5	1,5	24,5	140	20	18,0	14,5	00323740
MF 26 × 2	2,0	24,0	140	20	18,0	14,5	00323750
MF 27 × 1	1,0	26,0	150	20	20,0	16,0	00323760
MF 27 × 1,5	1,5	25,5	140	20	20,0	16,0	00323770
MF 27 × 2	2,0	25,0	140	20	20,0	16,0	00323780
MF 28 × 1	1,0	27,0	140	20	20,0	16,0	00323790

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						◇	Art.-No.
MF 28 × 1,5	1,5	26,5	140	20	20,0	16,0	00323800
MF 28 × 2	2,0	26,0	140	20	20,0	16,0	00323810
MF 30 × 1	1,0	29,0	150	22	22,0	18,0	00323820
MF 30 × 1,5	1,5	28,5	150	22	22,0	18,0	00323830
MF 30 × 2	2,0	28,0	150	22	22,0	18,0	00323840
MF 30 × 3	3,0	27,0	180	35	22,0	18,0	00323850
MF 32 × 1	1,0	31,0	150	22	22,0	18,0	00323860
MF 32 × 1,5	1,5	30,5	150	22	22,0	18,0	00323870
MF 32 × 2	2,0	30,0	150	22	22,0	18,0	00323880
MF 32 × 3	3,0	29,0	180	35	22,0	18,0	00323890
MF 33 × 1	1,0	32,0	150	25	25,0	20,0	00323900
MF 33 × 1,5	1,5	31,5	160	25	25,0	20,0	00323910
MF 33 × 2	2,0	31,0	160	25	25,0	20,0	00323920
MF 33 × 3	3,0	30,0	180	35	25,0	20,0	00323930
MF 34 × 1	1,0	33,0	170	25	28,0	22,0	00323940
MF 34 × 1,5	1,5	32,5	170	28	28,0	22,0	00323950
MF 34 × 2	2,0	32,0	170	32	28,0	22,0	00323960
MF 34 × 3	3,0	31,0	200	36	28,0	22,0	00323970
MF 35 × 1	1,0	34,0	170	25	28,0	22,0	00323980
MF 35 × 1,5	1,5	33,5	170	25	28,0	22,0	00323990
MF 35 × 2	2,0	33,0	170	25	28,0	22,0	00324000
MF 35 × 3	3,0	32,0	200	45	28,0	22,0	00324010
MF 36 × 1	1,0	35,0	170	25	28,0	22,0	00324020
MF 36 × 1,5	1,5	34,5	170	25	28,0	22,0	00324030
MF 36 × 2	2,0	34,0	170	25	28,0	22,0	00324040
MF 36 × 3	3,0	33,0	200	45	28,0	22,0	00324050
MF 38 × 1	1,0	37,0	170	25	28,0	22,0	00324060
MF 38 × 1,5	1,5	36,5	170	25	28,0	22,0	00324070
MF 38 × 2	2,0	36,0	170	25	28,0	22,0	00324080
MF 38 × 3	3,0	35,0	200	30	28,0	22,0	00324090
MF 39 × 1,5	1,5	37,5	170	25	32,0	24,0	00324100
MF 39 × 2	2,0	37,0	170	25	32,0	24,0	00324110
MF 39 × 3	3,0	36,0	200	30	32,0	24,0	00324120
MF 40 × 1,5	1,5	38,5	170	25	32,0	24,0	00324130
MF 40 × 2	2,0	38,0	170	25	32,0	24,0	00324140
MF 40 × 3	3,0	37,0	200	30	32,0	24,0	00324150
MF 42 × 1,5	1,5	40,5	170	25	32,0	24,0	00324160
MF 42 × 2	2,0	40,0	170	25	32,0	24,0	00324170
MF 42 × 3	3,0	39,0	200	30	32,0	24,0	00324180
MF 42 × 4	4,0	38,0	225	30	32,0	24,0	00324190
MF 45 × 1,5	1,5	43,5	180	27	36,0	29,0	00324200
MF 45 × 2	2,0	43,0	180	27	36,0	29,0	00324210
MF 45 × 3	3,0	42,0	200	30	36,0	29,0	00324220
MF 45 × 4	4,0	41,0	225	30	36,0	29,0	00324230

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							Art.-No.
MF 48 × 1,5	1,5	46,5	190	27	36,0	29,0	00324240
MF 48 × 2	2,0	46,0	190	27	36,0	29,0	00324250
MF 48 × 3	3,0	45,0	225	33	36,0	29,0	00324260
MF 48 × 4	4,0	44,0	225	33	36,0	29,0	00324270
MF 50 × 1,5	1,5	48,5	190	27	36,0	29,0	00324280
MF 50 × 2	2,0	48,0	190	27	36,0	29,0	00324290
MF 50 × 3	3,0	47,0	225	33	36,0	29,0	00324300
MF 50 × 4	4,0	46,0	225	33	36,0	29,0	00324310
MF 52 × 1,5	1,5	50,5	190	27	40,0	32,0	00324320
MF 52 × 2	2,0	50,0	190	27	40,0	32,0	00324330
MF 52 × 3	3,0	49,0	225	33	40,0	32,0	00324340
MF 52 × 4	4,0	48,0	225	33	36,0	29,0	00324350

MACHINE TAPS

Machine tap with overflow shank, 6-8 thread chamfer

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 374)	Hole type	Through hole < 1.1/2×d
Thread	MF	Direction	Right
Material	HSSE-G	Tolerance	6H
Raw material	Steel	Form	Form A

							Art.-No.
MF 3 × 0,35	0,35	2,65	56	8	2,2	—	02201200
MF 3,5 × 0,35	0,35	3,15	56	8	2,5	2,1	02201220
MF 4 × 0,35	0,35	3,65	63	10	2,8	2,1	02201230
MF 4 × 0,5	0,5	3,5	63	10	2,8	2,7	02201240
MF 4,5 × 0,5	0,5	4,0	70	12	3,5	2,7	02201260
MF 5 × 0,5	0,5	4,5	70	12	3,5	2,7	02201280
MF 5 × 0,75	0,75	4,25	70	12	3,5	2,7	02201290
MF 6 × 0,5	0,5	5,5	80	14	4,5	3,4	02201320
MF 6 × 0,75	0,75	5,25	80	14	4,5	3,4	02201330
MF 7 × 0,5	0,5	6,5	80	14	5,5	4,3	02201350
MF 7 × 0,75	0,75	6,25	80	14	5,5	4,3	02201360
MF 8 × 0,5	0,5	7,5	80	18	6,0	4,9	02201380
MF 8 × 0,75	0,75	7,25	80	18	6,0	4,9	02201390
MF 8 × 1	1,0	7,0	90	22	6,0	4,9	02201400
MF 8 × 1,5	1,5	6,5	90	22	6,0	4,9	02201410
MF 9 × 0,5	0,5	8,5	90	20	7,0	5,5	02201420
MF 9 × 0,75	0,75	8,25	90	20	7,0	5,5	02201430
MF 9 × 1	1,0	8,0	90	22	7,0	5,5	02201440

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						◇	Art.-No.
MF 10 × 0,5	0,5	9,5	90	20	7,0	5,5	02201450
MF 10 × 0,75	0,75	9,25	90	20	7,0	5,5	02201460
MF 10 × 1	1,0	9,0	90	20	7,0	5,5	02201470
MF 10 × 1,25	1,25	8,8	100	20	7,0	5,5	02201480
MF 11 × 0,5	0,5	10,5	90	20	8,0	6,2	02201490
MF 11 × 0,75	0,75	10,25	90	20	8,0	6,2	02201500
MF 11 × 1	1,0	10,0	90	20	8,0	6,2	02201510
MF 11 × 1,25	1,25	9,75	90	20	8,0	6,2	02201520
MF 12 × 0,5	0,5	11,5	100	22	9,0	7,0	02201530
MF 12 × 0,75	0,75	11,25	100	22	9,0	7,0	02201540
MF 12 × 1	1,0	11,0	100	22	9,0	7,0	02201550
MF 12 × 1,25	1,25	10,8	100	22	9,0	7,0	02201560
MF 12 × 1,5	1,5	10,5	100	22	9,0	7,0	02201570
MF 13 × 0,5	0,5	12,5	100	22	11,0	9,0	02201580
MF 13 × 0,75	0,75	12,25	100	22	11,0	9,0	02201590
MF 13 × 1	1,0	12,0	100	22	11,0	9,0	02201600
MF 13 × 1,25	1,25	11,75	100	22	11,0	9,0	02201610
MF 13 × 1,5	1,5	11,5	100	22	11,0	9,0	02201620
MF 14 × 0,5	0,5	13,5	100	22	11,0	9,0	02201630
MF 14 × 0,75	0,75	13,25	100	22	11,0	9,0	02201640
MF 14 × 1	1,0	13,0	100	22	11,0	9,0	02201650
MF 14 × 1,25	1,25	12,8	100	22	11,0	9,0	02201660
MF 14 × 1,5	1,5	12,5	100	22	11,0	9,0	02201670
MF 15 × 0,5	0,5	14,5	100	22	12,0	9,0	02201680
MF 15 × 0,75	0,75	14,25	100	22	12,0	9,0	02201690
MF 15 × 1	1,0	14,0	100	22	12,0	9,0	02201700
MF 15 × 1,25	1,25	13,8	100	22	12,0	9,0	02201710
MF 15 × 1,5	1,5	13,5	100	22	12,0	9,0	02201720
MF 16 × 0,5	0,5	15,5	100	22	12,0	9,0	02201730
MF 16 × 0,75	0,75	15,25	100	22	12,0	9,0	02201740
MF 16 × 1	1,0	15,0	100	22	12,0	9,0	02201750
MF 16 × 1,25	1,25	14,75	100	22	12,0	9,0	02201760
MF 16 × 1,5	1,5	14,5	100	22	12,0	9,0	02201770
MF 17 × 0,75	0,75	16,25	100	22	12,0	9,0	02201780
MF 17 × 1	1,0	16,0	100	22	12,0	9,0	02201790
MF 17 × 1,5	1,5	15,5	100	22	12,0	9,0	02201810
MF 18 × 0,5	0,5	17,5	110	25	14,0	11,0	02201820
MF 18 × 0,75	0,75	17,25	110	25	14,0	11,0	02201830
MF 18 × 1	1,0	17,0	110	25	14,0	11,0	02201840
MF 18 × 1,25	1,25	16,75	110	25	14,0	11,0	02201850
MF 18 × 1,5	1,5	16,5	110	25	14,0	11,0	02201860
MF 18 × 2	2,0	16,0	125	34	14,0	11,0	02201870
MF 19 × 1	1,0	18,0	125	25	14,0	11,0	02201880
MF 19 × 1,5	1,5	17,5	125	25	14,0	11,0	02201890

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							Art.-No.
MF 20 × 0,5	0,5	19,5	125	25	16,0	12,0	02201910
MF 20 × 0,75	0,75	19,25	125	25	16,0	12,0	02201920
MF 20 × 1	1,0	19,0	125	25	16,0	12,0	02201930
MF 20 × 1,25	1,25	18,75	125	25	16,0	12,0	02201940
MF 20 × 1,5	1,5	18,5	125	25	16,0	12,0	02201950
MF 20 × 2	2,0	18,0	140	34	16,0	12,0	02201960
MF 21 × 1	1,0	20,0	125	25	16,0	12,0	02201980
MF 21 × 1,5	1,5	19,5	125	25	16,0	12,0	02202000
MF 22 × 0,5	0,5	21,5	125	20	18,0	14,5	02202010
MF 22 × 0,75	0,75	21,25	125	25	18,0	14,5	02202020
MF 22 × 1	1,0	21,0	125	25	18,0	14,5	02202030
MF 22 × 1,25	1,25	20,75	125	25	18,0	14,5	02202040
MF 22 × 1,5	1,5	20,5	125	25	18,0	14,5	02202050
MF 22 × 2	2,0	20,0	140	34	18,0	14,5	02202060
MF 23 × 1	1,0	22,0	125	28	18,0	14,5	02202070
MF 23 × 1,5	1,5	21,5	125	28	18,0	14,5	02202080
MF 24 × 0,5	0,5	23,5	125	28	18,0	14,5	02202090
MF 24 × 0,75	0,75	23,25	140	28	18,0	14,5	02202100
MF 24 × 1	1,0	23,0	140	28	18,0	14,5	02202110
MF 24 × 1,25	1,25	22,75	140	28	18,0	14,5	02202120
MF 24 × 1,5	1,5	22,5	140	28	18,0	14,5	02202130
MF 24 × 2	2,0	22,0	140	28	18,0	14,5	02202140
MF 25 × 1	1,0	24,0	140	28	18,0	14,5	02202150
MF 25 × 1,5	1,5	23,5	140	28	18,0	14,5	02202170
MF 25 × 2	2,0	23,0	140	28	18,0	14,5	02202180
MF 26 × 1	1,0	25,0	140	28	18,0	14,5	02202190
MF 26 × 1,25	1,25	24,75	140	28	18,0	14,5	02202200
MF 26 × 1,5	1,5	24,5	140	28	18,0	14,5	02202210
MF 26 × 2	2,0	24,0	140	28	18,0	14,5	02202220
MF 27 × 1	1,0	26,0	150	28	20,0	16,0	02202230
MF 27 × 1,5	1,5	25,5	140	28	20,0	16,0	02202240
MF 27 × 2	2,0	25,0	150	28	20,0	16,0	02202250
MF 28 × 1	1,0	27,0	150	28	20,0	16,0	02202260
MF 28 × 1,5	1,5	26,5	150	28	20,0	16,0	02202270
MF 28 × 2	2,0	26,0	140	28	20,0	16,0	02202280
MF 30 × 1	1,0	29,0	150	28	22,0	18,0	02202290
MF 30 × 1,5	1,5	28,5	150	28	22,0	18,0	02202300
MF 30 × 2	2,0	28,0	150	28	22,0	18,0	02202310
MF 30 × 3	3,0	27,0	180	45	22,0	18,0	02202320
MF 32 × 1	1,0	31,0	150	30	22,0	18,0	02202330
MF 32 × 1,5	1,5	30,5	150	30	22,0	18,0	02202340
MF 32 × 2	2,0	30,0	150	30	22,0	18,0	02202350
MF 32 × 3	3,0	29,0	180	50	22,0	18,0	02202360
MF 33 × 1	1,0	32,0	150	30	25,0	20,0	02202370

GSR

						◇	Art.-No.
MF 33 × 1,5	1,5	31,5	160	30	25,0	20,0	02202380
MF 33 × 2	2,0	31,0	160	30	25,0	20,0	02202390
MF 33 × 3	3,0	30,0	180	50	25,0	20,0	02202400
MF 34 × 1	1,0	33,0	170	30	28,0	22,0	02202410
MF 34 × 1,5	1,5	32,5	170	30	28,0	22,0	02202420
MF 34 × 2	2,0	32,0	170	30	28,0	22,0	02202430
MF 34 × 3	3,0	31,0	200	56	28,0	22,0	02202440
MF 35 × 1	1,0	34,0	170	30	28,0	22,0	02202450
MF 35 × 1,5	1,5	33,5	170	30	28,0	22,0	02202460
MF 35 × 2	2,0	33,0	170	30	28,0	22,0	02202470
MF 35 × 3	3,0	32,0	200	56	28,0	22,0	02202480
MF 36 × 1	1,0	35,0	170	30	28,0	22,0	02202490
MF 36 × 1,5	1,5	34,5	170	30	28,0	22,0	02202500
MF 36 × 2	2,0	34,0	170	30	28,0	22,0	02202510
MF 36 × 3	3,0	33,0	200	56	28,0	22,0	02202520
MF 38 × 1	1,0	37,0	170	30	28,0	22,0	02202530
MF 38 × 1,5	1,5	36,5	170	30	28,0	22,0	02202540
MF 38 × 2	2,0	36,0	170	30	28,0	22,0	02202550
MF 38 × 3	3,0	35,0	200	56	28,0	22,0	02202560
MF 39 × 1,5	1,5	37,5	170	30	32,0	24,0	02202570
MF 39 × 2	2,0	37,0	170	30	32,0	24,0	02202580
MF 39 × 3	3,0	36,0	200	60	32,0	24,0	02202590
MF 40 × 1	1,0	39,0	170	30	32,0	24,0	02202600
MF 40 × 1,5	1,5	38,5	170	30	32,0	24,0	02202610
MF 40 × 2	2,0	38,0	170	30	32,0	24,0	02202620
MF 40 × 3	3,0	37,0	200	60	32,0	24,0	02202630
MF 42 × 1,5	1,5	40,5	170	30	32,0	24,0	02202640
MF 42 × 2	2,0	40,0	170	30	32,0	24,0	02202650
MF 42 × 3	3,0	39,0	200	60	32,0	24,0	02202660
MF 42 × 4	4,0	38,0	225	60	32,0	24,0	02202670
MF 45 × 1	1,0	44,0	180	32	36,0	29,0	02202680
MF 45 × 1,5	1,5	43,5	180	32	36,0	29,0	02202690
MF 45 × 2	2,0	43,0	180	32	36,0	29,0	02202700
MF 45 × 3	3,0	42,0	200	50	36,0	29,0	02202710
MF 45 × 4	4,0	41,0	225	65	36,0	29,0	02202720
MF 48 × 1	1,0	47,0	190	32	36,0	29,0	02202730
MF 48 × 1,5	1,5	46,5	190	32	36,0	29,0	02202740
MF 48 × 2	2,0	46,0	190	32	36,0	29,0	02202750
MF 48 × 3	3,0	45,0	225	50	36,0	29,0	02202760
MF 48 × 4	4,0	44,0	225	70	36,0	29,0	02202770
MF 50 × 1	1,0	49,0	190	32	36,0	29,0	02202780
MF 50 × 1,5	1,5	48,5	190	32	36,0	29,0	02202790
MF 50 × 2	2,0	48,0	190	32	36,0	29,0	02202800
MF 50 × 3	3,0	47,0	225	50	36,0	29,0	02202810

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							Art.-No.
MF 50 × 4	4,0	46,0	225	70	36,0	29,0	02202820
MF 52 × 1	1,0	51,0	190	32	40,0	32,0	02202830
MF 52 × 1,5	1,5	50,5	190	32	40,0	32,0	02202840
MF 52 × 2	2,0	50,0	190	32	40,0	32,0	02202850
MF 52 × 3	3,0	49,0	225	50	40,0	32,0	02202860
MF 52 × 4	4,0	48,0	225	70	36,0	29,0	02202870

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 374)	Hole type	Through hole < 1.1/2×d
Thread	MF	Direction	Right
Material	HSSE-G	Tolerance	6H
Raw material	Steel	Form	Form B

Machine tap with overflow shank, 4-5 thread chamfer, with spiral point

							Art.-No.
MF 3 × 0,35	0,35	2,65	56	8	2,2	1,9	02204260
MF 4 × 0,5	0,5	3,5	63	10	2,8	2,1	02204270
MF 5 × 0,5	0,5	4,5	70	12	3,5	2,7	02204280
MF 5 × 0,75	0,75	4,25	70	12	3,5	2,7	02204290
MF 6 × 0,5	0,5	5,5	80	14	4,5	3,4	02204320
MF 6 × 0,75	0,75	5,25	80	14	4,5	3,4	02204330
MF 7 × 0,75	0,75	6,25	80	14	5,5	4,3	02204340
MF 8 × 0,5	0,5	7,5	80	18	6,0	4,9	02204350
MF 8 × 0,75	0,75	7,25	80	18	6,0	4,9	02204390
MF 8 × 1	1,0	7,0	90	22	6,0	4,9	02204400
MF 9 × 1	1,0	8,0	90	22	7,0	5,5	02204440
MF 10 × 0,5	0,5	9,5	90	20	7,0	5,5	02204450
MF 10 × 0,75	0,75	9,25	90	20	7,0	5,5	02204460
MF 10 × 1	1,0	9,0	90	20	7,0	5,5	02204470
MF 10 × 1,25	1,25	8,75	100	20	7,0	5,5	02204480
MF 11 × 0,75	0,75	10,25	90	20	8,0	6,2	02204490
MF 11 × 1	1,0	10,0	90	20	8,0	6,2	02204510
MF 11 × 1,25	1,25	9,75	90	20	8,0	6,2	02204520
MF 12 × 0,5	0,5	11,5	100	22	9,0	7,0	02204530
MF 12 × 0,75	0,75	11,25	100	22	9,0	7,0	02204540
MF 12 × 1	1,0	11,0	100	22	9,0	7,0	02204550
MF 12 × 1,25	1,25	10,75	100	22	9,0	7,0	02204560
MF 12 × 1,5	1,5	10,5	100	22	9,0	7,0	02204570
MF 13 × 0,5	0,5	12,5	100	22	11,0	9,0	02204580

GSR

						◇	Art.-No.
MF 13 × 0,75	0,75	12,25	100	22	11,0	9,0	02204590
MF 13 × 1	1,0	12,0	100	22	11,0	9,0	02204600
MF 13 × 1,25	1,25	11,75	100	22	11,0	9,0	02204610
MF 13 × 1,5	1,5	11,5	100	22	11,0	9,0	02204620
MF 14 × 0,5	0,5	13,5	100	22	11,0	9,0	02204630
MF 14 × 0,75	0,75	13,25	100	22	11,0	9,0	02204640
MF 14 × 1	1,0	13,0	100	22	11,0	9,0	02204650
MF 14 × 1,25	1,25	12,75	100	22	11,0	9,0	02204660
MF 14 × 1,5	1,5	12,5	100	22	11,0	9,0	02204670
MF 15 × 0,5	0,5	14,5	100	22	12,0	9,0	02204680
MF 15 × 0,75	0,75	14,25	100	22	12,0	9,0	02204690
MF 15 × 1	1,0	14,0	100	22	12,0	9,0	02204700
MF 15 × 1,25	1,25	13,8	100	22	12,0	9,0	02204710
MF 15 × 1,5	1,5	13,5	100	22	12,0	9,0	02204720
MF 16 × 0,5	0,5	15,5	100	22	12,0	9,0	02204730
MF 16 × 0,75	0,75	15,25	100	22	12,0	9,0	02204740
MF 16 × 1	1,0	15,0	100	22	12,0	9,0	02204750
MF 16 × 1,25	1,25	14,75	100	22	12,0	9,0	02204760
MF 16 × 1,5	1,5	14,5	100	22	12,0	9,0	02204770
MF 17 × 0,75	0,75	16,25	100	22	12,0	9,0	02204780
MF 17 × 1	1,0	16,0	100	22	12,0	9,0	02204790
MF 17 × 1,5	1,5	15,5	100	22	12,0	9,0	02204800
MF 18 × 0,75	0,75	17,25	110	25	14,0	11,0	02204810
MF 18 × 1	1,0	17,0	110	25	14,0	11,0	02204840
MF 18 × 1,25	1,25	16,75	110	25	14,0	11,0	02204850
MF 18 × 1,5	1,5	16,5	110	25	14,0	11,0	02204860
MF 18 × 2	2,0	16,0	125	34	14,0	11,0	02204870
MF 20 × 0,75	0,75	19,25	125	25	16,0	12,0	02204880
MF 20 × 1	1,0	19,0	125	25	16,0	12,0	02204930
MF 20 × 1,25	1,25	18,75	125	25	16,0	12,0	02204940
MF 20 × 1,5	1,5	18,5	125	25	16,0	12,0	02204950
MF 20 × 2	2,0	18,0	140	34	16,0	12,0	02204960
MF 21 × 1	1,0	20,0	125	25	16,0	12,0	02204970
MF 21 × 1,5	1,5	19,5	125	25	16,0	12,0	02204980
MF 22 × 0,75	0,75	21,25	125	25	18,0	14,5	02204990
MF 22 × 1	1,0	21,0	125	25	18,0	14,5	02206030
MF 22 × 1,25	1,25	20,75	125	25	18,0	14,5	02206040
MF 22 × 1,5	1,5	20,5	125	25	18,0	14,5	02206050
MF 22 × 2	2,0	20,0	140	34	18,0	14,5	02206060
MF 23 × 1	1,0	22,0	125	28	18,0	14,5	02206070
MF 23 × 1,5	1,5	21,5	125	28	18,0	14,5	02206080
MF 24 × 0,75	0,75	23,25	140	28	18,0	14,5	02206090
MF 24 × 1	1,0	23,0	140	28	18,0	14,5	02206110
MF 24 × 1,25	1,25	22,75	140	28	18,0	14,5	02206120

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							Art.-No.
MF 24 × 1,5	1,5	22,5	140	28	18,0	14,5	02206130
MF 24 × 2	2,0	22,0	140	28	18,0	14,5	02206140
MF 25 × 1	1,0	24,0	140	28	18,0	14,5	02206150
MF 25 × 1,5	1,5	23,5	140	28	18,0	14,5	02206170
MF 25 × 2	2,0	23,0	140	28	18,0	14,5	02206180
MF 26 × 1	1,0	25,0	140	28	18,0	14,5	02206200
MF 26 × 1,5	1,5	24,5	140	28	18,0	14,5	02206210
MF 26 × 2	2,0	24,0	140	28	18,0	14,5	02206220
MF 27 × 1	1,0	26,0	150	28	20,0	16,0	02206230
MF 27 × 1,5	1,5	25,5	140	28	20,0	16,0	02206240
MF 27 × 2	2,0	25,0	140	28	20,0	16,0	02206250
MF 28 × 1	1,0	27,0	140	28	20,0	16,0	02206260
MF 28 × 1,5	1,5	26,5	140	28	20,0	16,0	02206270
MF 28 × 2	2,0	26,0	140	28	20,0	16,0	02206280
MF 30 × 1	1,0	29,0	150	28	22,0	18,0	02206290
MF 30 × 1,5	1,5	28,5	150	28	22,0	18,0	02206300
MF 30 × 2	2,0	28,0	150	28	22,0	18,0	02206310
MF 30 × 3	3,0	27,0	180	45	22,0	18,0	02206320
MF 32 × 1	1,0	31,0	150	30	22,0	18,0	02206330
MF 32 × 1,5	1,5	30,5	150	30	22,0	18,0	02206340
MF 32 × 2	2,0	30,0	150	30	22,0	18,0	02206350
MF 32 × 3	3,0	29,0	180	50	22,0	18,0	02206360
MF 33 × 1	1,0	32,0	150	30	25,0	20,0	02206370
MF 33 × 1,5	1,5	31,5	160	30	25,0	20,0	02206380
MF 33 × 2	2,0	31,0	160	30	25,0	20,0	02206390
MF 33 × 3	3,0	30,0	180	50	25,0	20,0	02206400
MF 34 × 1	1,0	33,0	170	30	28,0	22,0	02206410
MF 34 × 1,5	1,5	32,5	170	30	28,0	22,0	02206420
MF 34 × 2	2,0	32,0	170	30	28,0	22,0	02206430
MF 34 × 3	3,0	31,0	200	56	28,0	22,0	02206440
MF 35 × 1	1,0	34,0	170	30	28,0	22,0	02206450
MF 35 × 1,5	1,5	33,5	170	30	28,0	22,0	02206460
MF 35 × 2	2,0	33,0	170	30	28,0	22,0	02206470
MF 35 × 3	3,0	32,0	200	56	28,0	22,0	02206480
MF 36 × 1	1,0	35,0	170	30	28,0	22,0	02206490
MF 36 × 1,5	1,5	34,5	170	30	28,0	22,0	02206500
MF 36 × 2	2,0	34,0	170	30	28,0	22,0	02206510
MF 36 × 3	3,0	33,0	200	56	28,0	22,0	02206520
MF 38 × 1	1,0	37,0	170	30	28,0	22,0	02206530
MF 38 × 1,5	1,5	36,5	170	30	28,0	22,0	02206540
MF 38 × 2	2,0	36,0	170	30	28,0	22,0	02206550
MF 38 × 3	3,0	35,0	200	56	28,0	22,0	02206560
MF 39 × 1,5	1,5	37,5	170	30	32,0	24,0	02206570
MF 39 × 2	2,0	37,0	170	30	32,0	24,0	02206580

						◇	Art.-No.
MF 39 × 3	3,0	36,0	200	60	32,0	24,0	02206590
MF 40 × 1,5	1,5	38,5	170	30	32,0	24,0	02206610
MF 40 × 2	2,0	38,0	170	30	32,0	24,0	02206620
MF 40 × 3	3,0	37,0	200	60	32,0	24,0	02206630
MF 42 × 1,5	1,5	40,5	170	30	32,0	24,0	02206640
MF 42 × 2	2,0	40,0	170	30	32,0	24,0	02206650
MF 42 × 3	3,0	39,0	200	60	32,0	24,0	02206660
MF 42 × 4	4,0	38,0	225	60	32,0	24,0	02206670
MF 45 × 1,5	1,5	43,5	180	32	36,0	29,0	02206690
MF 45 × 2	2,0	43,0	180	32	36,0	29,0	02206700
MF 45 × 3	3,0	42,0	200	50	36,0	29,0	02206710
MF 45 × 4	4,0	41,0	225	65	36,0	29,0	02206720
MF 48 × 1,5	1,5	46,5	190	32	36,0	29,0	02206740
MF 48 × 2	2,0	46,0	190	32	36,0	29,0	02206750
MF 48 × 3	3,0	45,0	225	50	36,0	29,0	02206760
MF 48 × 4	4,0	44,0	225	70	36,0	29,0	02206770
MF 50 × 1,5	1,5	48,5	190	32	36,0	29,0	02206790
MF 50 × 2	2,0	48,0	190	32	36,0	29,0	02206800
MF 50 × 3	3,0	47,0	225	50	36,0	29,0	02206810
MF 50 × 4	4,0	46,0	225	70	36,0	29,0	02206820
MF 52 × 1,5	1,5	50,5	190	32	40,0	32,0	02206840
MF 52 × 2	2,0	50,0	190	32	40,0	32,0	02206850
MF 52 × 3	3,0	49,0	225	50	40,0	32,0	02206860
MF 52 × 4	4,0	48,0	225	70	36,0	29,0	02206870

MACHINE TAPS DIN 374

MACHINE TAPS

Machine tap with overflow shank, 4-5 thread chamfer, vaporised

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 374)	Hole type	Through hole < 1.1/2×d
Thread	MF	Direction	Right
Material	HSSE-G / VAP	Tolerance	6H
Raw material	Stainlees steel	Form	Form B

							Art.-No.
MF 3 × 0,35	0,35	2,65	56	8	2,2	1,9	02205280
MF 4 × 0,5	0,5	3,5	63	10	2,8	2,1	02205290
MF 5 × 0,5	0,5	4,5	70	12	3,5	2,7	02205300
MF 5 × 0,75	0,75	4,25	70	12	3,5	2,7	02205310
MF 6 × 0,5	0,5	5,5	80	14	4,5	3,4	02205320
MF 6 × 0,75	0,75	5,25	80	14	4,5	3,4	02205330
MF 7 × 0,75	0,75	6,25	80	14	5,5	4,3	02205340
MF 8 × 0,5	0,5	7,5	80	18	6,0	4,9	02205350
MF 8 × 0,75	0,75	7,25	80	18	6,0	4,9	02205390
MF 8 × 1	1,0	7,0	90	22	6,0	4,9	02205400
MF 9 × 1	1,0	8,0	90	22	7,0	5,5	02205410
MF 10 × 0,5	0,5	9,5	90	20	7,0	5,5	02205420
MF 10 × 0,75	0,75	9,25	90	20	7,0	5,5	02205430
MF 10 × 1	1,0	9,0	90	20	7,0	5,5	02205470
MF 10 × 1,25	1,25	8,75	100	20	7,0	5,5	02205480
MF 11 × 0,75	0,75	10,25	90	20	8,0	6,2	02205490
MF 11 × 1	1,0	10,0	90	20	8,0	6,2	02205500
MF 11 × 1,25	1,25	9,75	90	20	8,0	6,2	02205510
MF 12 × 0,5	0,5	11,5	100	22	9,0	7,0	02205520
MF 12 × 0,75	0,75	11,25	100	22	9,0	7,0	02205530
MF 12 × 1	1,0	11,0	100	22	9,0	7,0	02205540
MF 12 × 1,25	1,25	10,75	100	22	9,0	7,0	02205550
MF 12 × 1,5	1,5	10,5	100	22	9,0	7,0	02205570
MF 13 × 0,5	0,5	12,5	100	22	11,0	9,0	02205580
MF 13 × 0,75	0,75	12,25	100	22	11,0	9,0	02205590
MF 13 × 1	1,0	12,0	100	22	11,0	9,0	02205600
MF 13 × 1,25	1,25	11,75	100	22	11,0	9,0	02205610
MF 13 × 1,5	1,5	11,5	100	22	11,0	9,0	02205620
MF 14 × 0,5	0,5	13,5	100	22	11,0	9,0	02205630
MF 14 × 0,75	0,75	13,25	100	22	11,0	9,0	02205640
MF 14 × 1	1,0	13,0	100	22	11,0	9,0	02205650
MF 14 × 1,25	1,25	12,75	100	22	11,0	9,0	02205660
MF 14 × 1,5	1,5	12,5	100	22	11,0	9,0	02205670
MF 15 × 0,5	0,5	14,5	100	22	12,0	9,0	02205680
MF 15 × 0,75	0,75	14,25	100	22	12,0	9,0	02205690
MF 15 × 1	1,0	14,0	100	22	12,0	9,0	02205700

GSR

						◇	Art.-No.
MF 15 × 1,25	1,25	13,8	100	22	12,0	9,0	02205710
MF 15 × 1,5	1,5	13,5	100	22	12,0	9,0	02205720
MF 16 × 0,5	0,5	15,5	100	22	12,0	9,0	02205730
MF 16 × 0,75	0,75	15,25	100	22	12,0	9,0	02205740
MF 16 × 1	1,0	15,0	100	22	12,0	9,0	02205750
MF 16 × 1,25	1,25	14,75	100	22	12,0	9,0	02205760
MF 16 × 1,5	1,5	14,5	100	22	12,0	9,0	02205770
MF 17 × 0,75	0,75	16,25	100	22	12,0	9,0	02205780
MF 17 × 1	1,0	16,0	100	22	12,0	9,0	02205790
MF 17 × 1,5	1,5	15,5	100	22	12,0	9,0	02205800
MF 18 × 0,75	0,75	17,25	110	25	14,0	11,0	02205810
MF 18 × 1	1,0	17,0	110	25	14,0	11,0	02205820
MF 18 × 1,25	1,25	16,75	110	25	14,0	11,0	02205830
MF 18 × 1,5	1,5	16,5	110	25	14,0	11,0	02205860
MF 18 × 2	2,0	16,0	125	34	14,0	11,0	02205870
MF 20 × 0,75	0,75	19,25	125	25	16,0	12,0	02205880
MF 20 × 1	1,0	19,0	125	25	16,0	12,0	02205890
MF 20 × 1,25	1,25	18,75	125	25	16,0	12,0	02205900
MF 20 × 1,5	1,5	18,5	125	25	16,0	12,0	02205950
MF 20 × 2	2,0	18,0	140	34	16,0	12,0	02205960
MF 21 × 1	1,0	20,0	125	25	16,0	12,0	02205970
MF 21 × 1,5	1,5	19,5	125	25	16,0	12,0	02205980
MF 22 × 0,75	0,75	21,25	125	25	18,0	14,5	02205990
MF 22 × 1	1,0	21,0	125	25	18,0	14,5	02224010
MF 22 × 1,25	1,25	20,75	125	25	18,0	14,5	02224020
MF 22 × 1,5	1,5	20,5	125	25	18,0	14,5	02224030
MF 22 × 2	2,0	20,0	140	34	18,0	14,5	02224040
MF 23 × 1	1,0	22,0	125	28	18,0	14,5	02224050
MF 23 × 1,5	1,5	21,5	125	28	18,0	14,5	02224060
MF 24 × 0,75	0,75	23,25	140	28	18,0	14,5	02224070
MF 24 × 1	1,0	23,0	140	28	18,0	14,5	02224080
MF 24 × 1,25	1,25	22,75	140	28	18,0	14,5	02224090
MF 24 × 1,5	1,5	22,5	140	28	18,0	14,5	02224100
MF 24 × 2	2,0	22,0	140	28	18,0	14,5	02224110

MACHINE TAPS DIN 374

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 374)	Hole type	Blind hole < 2×d
Thread	MF	Direction	Right
Material	HSSE-G	Tolerance	6H
Raw material	Steel	Form	Form C / RSP 15°

Machine tap with overflow shank, 15° right spiral flute, 2-3 thread chamfer

						◇	Art.-No.
MF 3 × 0,35	0,35	2,65	56	8	2,2	1,9	02213260
MF 4 × 0,5	0,5	3,5	63	8	2,8	2,1	02213270
MF 5 × 0,5	0,5	4,5	70	8	3,5	2,7	02213280
MF 5 × 0,75	0,75	4,25	70	8	3,5	2,7	02213290
MF 6 × 0,5	0,5	5,5	80	12	4,5	3,4	02213320
MF 6 × 0,75	0,75	5,25	80	12	4,5	3,4	02213330
MF 7 × 0,75	0,75	6,25	80	12	5,5	4,3	02213360
MF 8 × 0,5	0,5	7,5	80	12	6,0	4,9	02213380
MF 8 × 0,75	0,75	7,25	80	12	6,0	4,9	02213390
MF 8 × 1	1,0	7,0	90	16	6,0	4,9	02213400
MF 9 × 1	1,0	8,0	90	16	7,0	5,5	02213440
MF 10 × 0,5	0,5	9,5	90	16	7,0	5,5	02213450
MF 10 × 0,75	0,75	9,25	90	16	7,0	5,5	02213460
MF 10 × 1	1,0	9,0	90	16	7,0	5,5	02213470
MF 10 × 1,25	1,25	8,75	100	16	7,0	5,5	02213480
MF 11 × 0,75	0,75	10,25	90	16	8,0	6,2	02213500
MF 11 × 1	1,0	10,0	90	16	8,0	6,2	02213510
MF 11 × 1,25	1,25	9,75	90	16	8,0	6,2	02213520
MF 12 × 0,5	0,5	11,5	100	16	9,0	7,0	02213530
MF 12 × 0,75	0,75	11,25	100	16	9,0	7,0	02213540
MF 12 × 1	1,0	11,0	100	16	9,0	7,0	02213550
MF 12 × 1,25	1,25	10,75	100	16	9,0	7,0	02213560
MF 12 × 1,5	1,5	10,5	100	16	9,0	7,0	02213570
MF 13 × 0,5	0,5	12,5	100	16	11,0	9,0	02213580
MF 13 × 0,75	0,75	12,25	100	16	11,0	9,0	02213590
MF 13 × 1	1,0	12,0	100	16	11,0	9,0	02213600
MF 13 × 1,25	1,25	11,75	100	16	11,0	9,0	02213610
MF 13 × 1,5	1,5	11,5	100	16	11,0	9,0	02213620
MF 14 × 0,5	0,5	13,5	100	16	11,0	9,0	02213630
MF 14 × 0,75	0,75	13,25	100	16	11,0	9,0	02213640
MF 14 × 1	1,0	13,0	100	16	11,0	9,0	02213650
MF 14 × 1,25	1,25	12,75	100	16	11,0	9,0	02213660
MF 14 × 1,5	1,5	12,5	100	16	11,0	9,0	02213670
MF 15 × 0,5	0,5	14,5	100	16	12,0	9,0	02213680
MF 15 × 0,75	0,75	14,25	100	16	12,0	9,0	02213690
MF 15 × 1	1,0	14,0	100	16	12,0	9,0	02213700

GSR

						◇	Art.-No.
MF 15 × 1,25	1,25	13,8	100	16	12,0	9,0	02213710
MF 15 × 1,5	1,5	13,5	100	16	12,0	9,0	02213720
MF 16 × 0,5	0,5	15,5	100	16	12,0	9,0	02213730
MF 16 × 0,75	0,75	15,25	100	16	12,0	9,0	02213740
MF 16 × 1	1,0	15,0	100	16	12,0	9,0	02213750
MF 16 × 1,25	1,25	14,75	100	16	12,0	9,0	02213760
MF 16 × 1,5	1,5	14,5	100	16	12,0	9,0	02213770
MF 17 × 0,75	0,75	16,25	100	16	12,0	9,0	02213780
MF 17 × 1	1,0	16,0	100	16	12,0	9,0	02213790
MF 17 × 1,5	1,5	15,5	100	16	12,0	9,0	02213810
MF 18 × 0,75	0,75	17,25	110	20	14,0	11,0	02213830
MF 18 × 1	1,0	17,0	110	20	14,0	11,0	02213840
MF 18 × 1,25	1,25	16,75	110	20	14,0	11,0	02213850
MF 18 × 1,5	1,5	16,5	110	20	14,0	11,0	02213860
MF 18 × 2	2,0	16,0	125	25	14,0	11,0	02213870
MF 20 × 0,75	0,75	19,25	125	20	16,0	12,0	02213920
MF 20 × 1	1,0	19,0	125	20	16,0	12,0	02213930
MF 20 × 1,25	1,25	18,75	125	20	16,0	12,0	02213940
MF 20 × 1,5	1,5	18,5	125	20	16,0	12,0	02213950
MF 20 × 2	2,0	18,0	140	25	16,0	12,0	02213960
MF 21 × 1	1,0	20,0	125	20	16,0	12,0	02213980
MF 21 × 1,5	1,5	19,5	125	20	16,0	12,0	02214000
MF 22 × 0,75	0,75	21,25	125	20	18,0	14,5	02214020
MF 22 × 1	1,0	21,0	125	20	18,0	14,5	02214030
MF 22 × 1,25	1,25	20,75	125	20	18,0	14,5	02214040
MF 22 × 1,5	1,5	20,5	125	20	18,0	14,5	02214050
MF 22 × 2	2,0	20,0	140	25	18,0	14,5	02214060
MF 23 × 1	1,0	22,0	125	20	18,0	14,5	02214070
MF 23 × 1,5	1,5	21,5	125	20	18,0	14,5	02214080
MF 24 × 0,75	0,75	23,25	140	20	18,0	14,5	02214100
MF 24 × 1	1,0	23,0	140	20	18,0	14,5	02214110
MF 24 × 1,25	1,25	22,75	140	20	18,0	14,5	02214120
MF 24 × 1,5	1,5	22,5	140	20	18,0	14,5	02214130
MF 24 × 2	2,0	22,0	140	20	18,0	14,5	02214140
MF 25 × 1	1,0	24,0	140	20	18,0	14,5	02214150
MF 25 × 1,5	1,5	23,5	140	20	18,0	14,5	02214170
MF 25 × 2	2,0	23,0	140	20	18,0	14,5	02214180
MF 26 × 1	1,0	25,0	140	20	18,0	14,5	02214190
MF 26 × 1,5	1,5	24,5	140	20	18,0	14,5	02214210
MF 26 × 2	2,0	24,0	140	20	18,0	14,5	02214220
MF 27 × 1	1,0	26,0	150	20	20,0	16,0	02214230
MF 27 × 1,5	1,5	25,5	140	20	20,0	16,0	02214240
MF 27 × 2	2,0	25,0	140	20	20,0	16,0	02214250
MF 28 × 1	1,0	27,0	140	20	20,0	16,0	02214260

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							Art.-No.
MF 28 × 1,5	1,5	26,5	140	20	20,0	16,0	02214270
MF 28 × 2	2,0	26,0	140	20	20,0	16,0	02214280
MF 30 × 1	1,0	29,0	150	22	22,0	18,0	02214290
MF 30 × 1,5	1,5	28,5	150	22	22,0	18,0	02214300
MF 30 × 2	2,0	28,0	150	22	22,0	18,0	02214310
MF 30 × 3	3,0	27,0	180	35	22,0	18,0	02214320
MF 32 × 1	1,0	31,0	150	22	22,0	18,0	02214330
MF 32 × 1,5	1,5	30,5	150	22	22,0	18,0	02214340
MF 32 × 2	2,0	30,0	150	22	22,0	18,0	02214350
MF 32 × 3	3,0	29,0	180	35	22,0	18,0	02214360
MF 33 × 1	1,0	32,0	150	25	25,0	20,0	02214370
MF 33 × 1,5	1,5	31,5	160	25	25,0	20,0	02214380
MF 33 × 2	2,0	31,0	160	25	25,0	20,0	02214390
MF 33 × 3	3,0	30,0	180	35	25,0	20,0	02214400
MF 34 × 1	1,0	33,0	170	25	28,0	22,0	02214410
MF 34 × 1,5	1,5	32,5	170	28	28,0	22,0	02214420
MF 34 × 2	2,0	32,0	170	32	28,0	22,0	02214430
MF 34 × 3	3,0	31,0	200	36	28,0	22,0	02214440
MF 35 × 1	1,0	34,0	170	25	28,0	22,0	02214450
MF 35 × 1,5	1,5	33,5	170	25	28,0	22,0	02214460
MF 35 × 2	2,0	33,0	170	25	28,0	22,0	02214470
MF 35 × 3	3,0	32,0	200	45	28,0	22,0	02214480
MF 36 × 1	1,0	35,0	170	25	28,0	22,0	02214490
MF 36 × 1,5	1,5	34,5	170	25	28,0	22,0	02214500
MF 36 × 2	2,0	34,0	170	25	28,0	22,0	02214510
MF 36 × 3	3,0	33,0	200	45	28,0	22,0	02214520
MF 38 × 1	1,0	37,0	170	25	28,0	22,0	02214530
MF 38 × 1,5	1,5	36,5	170	25	28,0	22,0	02214540
MF 38 × 2	2,0	36,0	170	25	28,0	22,0	02214550
MF 38 × 3	3,0	35,0	200	30	28,0	22,0	02214560
MF 39 × 1,5	1,5	37,5	170	25	32,0	24,0	02214570
MF 39 × 2	2,0	37,0	170	25	32,0	24,0	02214580
MF 39 × 3	3,0	36,0	200	30	32,0	24,0	02214590
MF 40 × 1,5	1,5	38,5	170	25	32,0	24,0	02214610
MF 40 × 2	2,0	38,0	170	25	32,0	24,0	02214620
MF 40 × 3	3,0	37,0	200	30	32,0	24,0	02214630
MF 42 × 1,5	1,5	40,5	170	25	32,0	24,0	02214640
MF 42 × 2	2,0	40,0	170	25	32,0	24,0	02214650
MF 42 × 3	3,0	39,0	200	30	32,0	24,0	02214660
MF 42 × 4	4,0	38,0	225	30	32,0	24,0	02214670
MF 45 × 1,5	1,5	43,5	180	27	36,0	29,0	02214690
MF 45 × 2	2,0	43,0	180	27	36,0	29,0	02214700
MF 45 × 3	3,0	42,0	200	30	36,0	29,0	02214710
MF 45 × 4	4,0	41,0	225	30	36,0	29,0	02214720

							Art.-No.
MF 48 × 1,5	1,5	46,5	190	27	36,0	29,0	02214740
MF 48 × 2	2,0	46,0	190	27	36,0	29,0	02214750
MF 48 × 3	3,0	45,0	225	33	36,0	29,0	02214760
MF 48 × 4	4,0	44,0	225	33	36,0	29,0	02214770
MF 50 × 1,5	1,5	48,5	190	27	36,0	29,0	02214790
MF 50 × 2	2,0	48,0	190	27	36,0	29,0	02214800
MF 50 × 3	3,0	47,0	225	33	36,0	29,0	02214810
MF 50 × 4	4,0	46,0	225	33	36,0	29,0	02214820
MF 52 × 1,5	1,5	50,5	190	27	40,0	32,0	02214840
MF 52 × 2	2,0	50,0	190	27	40,0	32,0	02214850
MF 52 × 3	3,0	49,0	225	33	40,0	32,0	02214860
MF 52 × 4	4,0	48,0	225	33	36,0	29,0	02214870

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 374)	Hole type	Blind hole < 2×d
Thread	MF	Direction	Right
Material	HSSE-G	Tolerance	6H
Raw material	Steel	Form	Form C / RSP 35°

Machine tap with overflow shank, 35° right spiral flute, 2-3 thread chamfer

							Art.-No.
MF 3 × 0,35	0,35	2,65	56	8	2,2	1,9	02226260
MF 4 × 0,5	0,5	3,5	63	8	2,8	2,1	02226270
MF 5 × 0,5	0,5	4,5	70	8	3,5	2,7	02226280
MF 5 × 0,75	0,75	4,25	70	8	3,5	2,7	02226290
MF 6 × 0,5	0,5	5,5	80	12	4,5	3,4	02226320
MF 6 × 0,75	0,75	5,25	80	12	4,5	3,4	02226330
MF 7 × 0,75	0,75	6,25	80	12	5,5	4,3	02226360
MF 8 × 0,5	0,5	7,5	80	12	6,0	4,9	02226380
MF 8 × 0,75	0,75	7,25	80	12	6,0	4,9	02226390
MF 8 × 1	1,0	7,0	90	16	6,0	4,9	02226400
MF 9 × 1	1,0	8,0	90	16	7,0	5,5	02226440
MF 10 × 0,5	0,5	9,5	90	16	7,0	5,5	02226450
MF 10 × 0,75	0,75	9,25	90	16	7,0	5,5	02226460
MF 10 × 1	1,0	9,0	90	16	7,0	5,5	02226470
MF 10 × 1,25	1,25	8,75	100	16	7,0	5,5	02226480
MF 11 × 0,75	0,75	10,25	90	16	8,0	6,2	02226500
MF 11 × 1	1,0	10,0	90	16	8,0	6,2	02226510
MF 11 × 1,25	1,25	9,75	90	16	8,0	6,2	02226520
MF 12 × 0,5	0,5	11,5	100	16	9,0	7,0	02226530
MF 12 × 0,75	0,75	11,25	100	16	9,0	7,0	02226540

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							Art.-No.
MF 12 × 1	1,0	11,0	100	16	9,0	7,0	02226550
MF 12 × 1,25	1,25	10,75	100	16	9,0	7,0	02226560
MF 12 × 1,5	1,5	10,5	100	16	9,0	7,0	02226570
MF 13 × 0,5	0,5	12,5	100	16	11,0	9,0	02226580
MF 13 × 0,75	0,75	12,25	100	16	11,0	9,0	02226590
MF 13 × 1	1,0	12,0	100	16	11,0	9,0	02226600
MF 13 × 1,25	1,25	11,75	100	16	11,0	9,0	02226610
MF 13 × 1,5	1,5	11,5	100	16	11,0	9,0	02226620
MF 14 × 0,5	0,5	13,5	100	16	11,0	9,0	02226630
MF 14 × 0,75	0,75	13,25	100	16	11,0	9,0	02226640
MF 14 × 1	1,0	13,0	100	16	11,0	9,0	02226650
MF 14 × 1,25	1,25	12,75	100	16	11,0	9,0	02226660
MF 14 × 1,5	1,5	12,5	100	16	11,0	9,0	02226670
MF 15 × 0,5	0,5	14,5	100	16	12,0	9,0	02226680
MF 15 × 0,75	0,75	14,25	100	16	12,0	9,0	02226690
MF 15 × 1	1,0	14,0	100	16	12,0	9,0	02226700
MF 15 × 1,25	1,25	13,8	100	16	12,0	9,0	02226710
MF 15 × 1,5	1,5	13,5	100	16	12,0	9,0	02226720
MF 16 × 0,5	0,5	15,5	100	16	12,0	9,0	02226730
MF 16 × 0,75	0,75	15,25	100	16	12,0	9,0	02226740
MF 16 × 1	1,0	15,0	100	16	12,0	9,0	02226750
MF 16 × 1,25	1,25	14,75	100	16	12,0	9,0	02226760
MF 16 × 1,5	1,5	14,5	100	16	12,0	9,0	02226770
MF 17 × 0,75	0,75	16,25	100	16	12,0	9,0	02226780
MF 17 × 1	1,0	16,0	100	16	12,0	9,0	02226790
MF 17 × 1,5	1,5	15,5	100	16	12,0	9,0	02226810
MF 18 × 0,75	0,75	17,25	110	20	14,0	11,0	02226830
MF 18 × 1	1,0	17,0	110	20	14,0	11,0	02226840
MF 18 × 1,25	1,25	16,75	110	20	14,0	11,0	02226850
MF 18 × 1,5	1,5	16,5	110	20	14,0	11,0	02226860
MF 18 × 2	2,0	16,0	125	25	14,0	11,0	02226870
MF 20 × 0,75	0,75	19,25	125	20	16,0	12,0	02226920
MF 20 × 1	1,0	19,0	125	20	16,0	12,0	02226930
MF 20 × 1,25	1,25	18,75	125	20	16,0	12,0	02226940
MF 20 × 1,5	1,5	18,5	125	20	16,0	12,0	02226950
MF 20 × 2	2,0	18,0	140	25	16,0	12,0	02226960
MF 21 × 1	1,0	20,0	125	20	16,0	12,0	02226980
MF 21 × 1,5	1,5	19,5	125	20	16,0	12,0	02228000
MF 22 × 0,75	0,75	21,25	125	20	18,0	14,5	02228020
MF 22 × 1	1,0	21,0	125	20	18,0	14,5	02228030
MF 22 × 1,25	1,25	20,75	125	20	18,0	14,5	02228040
MF 22 × 1,5	1,5	20,5	125	20	18,0	14,5	02228050
MF 22 × 2	2,0	20,0	140	25	18,0	14,5	02228060
MF 23 × 1	1,0	22,0	125	20	18,0	14,5	02228070

GSR

						◇	Art.-No.
MF 23 × 1,5	1,5	21,5	125	20	18,0	14,5	02228080
MF 24 × 0,75	0,75	23,25	125	20	18,0	14,5	02228100
MF 24 × 1	1,0	23,0	125	20	18,0	14,5	02228110
MF 24 × 1,25	1,25	22,75	125	20	18,0	14,5	02228120
MF 24 × 1,5	1,5	22,5	140	20	18,0	14,5	02228130
MF 24 × 2	2,0	22,0	140	20	18,0	14,5	02228140
MF 25 × 1	1,0	24,0	140	20	18,0	14,5	02228150
MF 25 × 1,5	1,5	23,5	140	20	18,0	14,5	02228170
MF 25 × 2	2,0	23,0	140	20	18,0	14,5	02228180
MF 26 × 1	1,0	25,0	140	20	18,0	14,5	02228190
MF 26 × 1,5	1,5	24,5	140	20	18,0	14,5	02228210
MF 26 × 2	2,0	24,0	140	20	18,0	14,5	02228220
MF 27 × 1	1,0	26,0	150	20	20,0	16,0	02228230
MF 27 × 1,5	1,5	25,5	140	20	20,0	16,0	02228240
MF 27 × 2	2,0	25,0	140	20	20,0	16,0	02228250
MF 28 × 1	1,0	27,0	150	20	20,0	16,0	02228260
MF 28 × 1,5	1,5	26,5	140	20	20,0	16,0	02228270
MF 28 × 2	2,0	26,0	140	20	20,0	16,0	02228280
MF 30 × 1	1,0	29,0	150	22	22,0	18,0	02228290
MF 30 × 1,5	1,5	28,5	150	22	22,0	18,0	02228300
MF 30 × 2	2,0	28,0	150	22	22,0	18,0	02228310
MF 30 × 3	3,0	27,0	160	35	22,0	18,0	02228320
MF 32 × 1	1,0	31,0	150	22	22,0	18,0	02228330
MF 32 × 1,5	1,5	30,5	150	22	22,0	18,0	02228340
MF 32 × 2	2,0	30,0	160	22	22,0	18,0	02228350
MF 32 × 3	3,0	29,0	160	35	22,0	18,0	02228360
MF 33 × 1	1,0	32,0	150	25	25,0	20,0	02228370
MF 33 × 1,5	1,5	31,5	160	25	25,0	20,0	02228380
MF 33 × 2	2,0	31,0	160	25	25,0	20,0	02228390
MF 33 × 3	3,0	30,0	160	35	25,0	20,0	02228400
MF 34 × 1	1,0	33,0	150	25	28,0	22,0	02228410
MF 34 × 1,5	1,5	32,5	170	28	28,0	22,0	02228420
MF 34 × 2	2,0	32,0	160	32	28,0	22,0	02228430
MF 34 × 3	3,0	31,0	160	36	28,0	22,0	02228440
MF 35 × 1	1,0	34,0	150	25	28,0	22,0	02228450
MF 35 × 1,5	1,5	33,5	170	25	28,0	22,0	02228460
MF 35 × 2	2,0	33,0	160	25	28,0	22,0	02228470
MF 35 × 3	3,0	32,0	160	45	28,0	22,0	02228480
MF 36 × 1	1,0	35,0	170	25	28,0	22,0	02228490
MF 36 × 1,5	1,5	34,5	170	25	28,0	22,0	02228500
MF 36 × 2	2,0	34,0	170	25	28,0	22,0	02228510
MF 36 × 3	3,0	33,0	200	45	28,0	22,0	02228520
MF 38 × 1	1,0	37,0	170	25	28,0	22,0	02228530
MF 38 × 1,5	1,5	36,5	170	25	28,0	22,0	02228540

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							Art.-No.
MF 38 × 2	2,0	36,0	180	25	28,0	22,0	02228550
MF 38 × 3	3,0	35,0	190	30	28,0	22,0	02228560
MF 39 × 1,5	1,5	37,5	170	25	32,0	24,0	02228570
MF 39 × 2	2,0	37,0	170	25	32,0	24,0	02228580
MF 39 × 3	3,0	36,0	200	30	32,0	24,0	02228590
MF 40 × 1,5	1,5	38,5	170	25	32,0	24,0	02228610
MF 40 × 2	2,0	38,0	170	25	32,0	24,0	02228620
MF 40 × 3	3,0	37,0	200	30	32,0	24,0	02228630
MF 42 × 1,5	1,5	40,5	180	25	32,0	24,0	02228640
MF 42 × 2	2,0	40,0	180	25	32,0	24,0	02228650
MF 42 × 3	3,0	39,0	200	30	32,0	24,0	02228660
MF 42 × 4	4,0	38,0	225	30	32,0	24,0	02228670
MF 45 × 1,5	1,5	43,5	180	27	36,0	29,0	02228690
MF 45 × 2	2,0	43,0	180	27	36,0	29,0	02228700
MF 45 × 3	3,0	42,0	200	30	36,0	29,0	02228710
MF 45 × 4	4,0	41,0	225	30	36,0	29,0	02228720
MF 48 × 1,5	1,5	46,5	190	27	36,0	29,0	02228740
MF 48 × 2	2,0	46,0	190	27	36,0	29,0	02228750
MF 48 × 3	3,0	45,0	225	33	36,0	29,0	02228760
MF 48 × 4	4,0	44,0	225	33	36,0	29,0	02228770
MF 50 × 1,5	1,5	48,5	190	27	36,0	29,0	02228780
MF 50 × 2	2,0	48,0	190	32	36,0	29,0	02228800
MF 50 × 3	3,0	47,0	225	33	36,0	29,0	02228810
MF 50 × 4	4,0	46,0	225	33	36,0	29,0	02228820
MF 52 × 1,5	1,5	50,5	190	27	40,0	32,0	02228840
MF 52 × 2	2,0	50,0	190	27	40,0	32,0	02228850
MF 52 × 3	3,0	49,0	225	33	40,0	32,0	02228860
MF 52 × 4	4,0	48,0	225	33	36,0	29,0	02228870

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MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 374)	Hole type	Blind hole < 2×d
Thread	MF	Direction	Right
Material	HSSE-G / VAP	Tolerance	6H
Raw material	Stainlees steel	Form	Form C / RSP 35°

Machine tap with overflow shank, 35° right spiral flute, 2-3 thread chamfer, vaporised

						◇	Art.-No.
MF 3 × 0,35	0,35	2,65	56	8	2,2	1,9	02216340
MF 4 × 0,5	0,5	3,5	63	8	2,8	2,1	02216350
MF 5 × 0,5	0,5	4,5	70	8	3,5	2,7	02216360
MF 5 × 0,75	0,75	4,25	70	8	3,5	2,7	02216370
MF 6 × 0,5	0,5	5,5	80	12	4,5	3,4	02216380
MF 6 × 0,75	0,75	5,25	80	12	4,5	3,4	02216390
MF 7 × 0,75	0,75	6,25	80	12	5,5	4,3	02216400
MF 8 × 0,5	0,5	7,5	80	12	6,0	4,9	02216410
MF 8 × 0,75	0,75	7,25	80	12	6,0	4,9	02216420
MF 8 × 1	1,0	7,0	90	16	6,0	4,9	02216430
MF 9 × 1	1,0	8,0	90	16	7,0	5,5	02216440
MF 10 × 0,5	0,5	9,5	90	16	7,0	5,5	02216450
MF 10 × 0,75	0,75	9,25	90	16	7,0	5,5	02216460
MF 10 × 1	1,0	9,0	100	16	7,0	5,5	02216470
MF 10 × 1,25	1,25	8,75	100	16	7,0	5,5	02216480
MF 11 × 0,75	0,75	10,25	90	16	8,0	6,2	02216490
MF 11 × 1	1,0	10,0	90	16	8,0	6,2	02216500
MF 11 × 1,25	1,25	9,75	90	16	8,0	6,2	02216510
MF 12 × 0,5	0,5	11,5	100	16	9,0	7,0	02216520
MF 12 × 0,75	0,75	11,25	100	16	9,0	7,0	02216530
MF 12 × 1	1,0	11,0	100	16	9,0	7,0	02216540
MF 12 × 1,25	1,25	10,75	100	16	9,0	7,0	02216550
MF 12 × 1,5	1,5	10,5	100	16	9,0	7,0	02216570
MF 13 × 0,5	0,5	12,5	100	16	11,0	9,0	02216580
MF 13 × 0,75	0,75	12,25	100	16	11,0	9,0	02216590
MF 13 × 1	1,0	12,0	100	16	11,0	9,0	02216600
MF 13 × 1,25	1,25	11,75	100	16	11,0	9,0	02216610
MF 13 × 1,5	1,5	11,5	100	16	11,0	9,0	02216620
MF 14 × 0,5	0,5	13,5	100	16	11,0	9,0	02216630
MF 14 × 0,75	0,75	13,25	100	16	11,0	9,0	02216640
MF 14 × 1	1,0	13,0	100	16	11,0	9,0	02216650
MF 14 × 1,25	1,25	12,75	100	16	11,0	9,0	02216660
MF 14 × 1,5	1,5	12,5	100	16	11,0	9,0	02216670
MF 15 × 0,5	0,5	14,5	100	16	12,0	9,0	02216680
MF 15 × 0,75	0,75	14,25	100	16	12,0	9,0	02216690
MF 15 × 1	1,0	14,0	100	16	12,0	9,0	02216700

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						◇	Art.-No.
MF 15 × 1,25	1,25	13,8	100	16	12,0	9,0	02216710
MF 15 × 1,5	1,5	13,5	100	16	12,0	9,0	02216720
MF 16 × 0,5	0,5	15,5	100	16	12,0	9,0	02216730
MF 16 × 0,75	0,75	15,25	100	16	12,0	9,0	02216740
MF 16 × 1	1,0	15,0	100	16	12,0	9,0	02216750
MF 16 × 1,25	1,25	14,75	100	16	12,0	9,0	02216760
MF 16 × 1,5	1,5	14,5	100	16	12,0	9,0	02216770
MF 17 × 0,75	0,75	16,25	100	16	12,0	9,0	02216780
MF 17 × 1	1,0	16,0	100	16	12,0	9,0	02216790
MF 17 × 1,5	1,5	15,5	100	16	12,0	9,0	02216800
MF 18 × 0,75	0,75	17,25	110	20	14,0	11,0	02216810
MF 18 × 1	1,0	17,0	110	20	14,0	11,0	02216820
MF 18 × 1,25	1,25	16,75	110	20	14,0	11,0	02216830
MF 18 × 1,5	1,5	16,5	110	20	14,0	11,0	02216860
MF 18 × 2	2,0	16,0	125	25	14,0	11,0	02216870
MF 20 × 0,75	0,75	19,25	125	20	16,0	12,0	02216880
MF 20 × 1	1,0	19,0	125	20	16,0	12,0	02216890
MF 20 × 1,25	1,25	18,75	125	20	16,0	12,0	02216900
MF 20 × 1,5	1,5	18,5	125	20	16,0	12,0	02216950
MF 20 × 2	2,0	18,0	140	25	16,0	12,0	02216960
MF 21 × 1	1,0	20,0	125	20	16,0	12,0	02216970
MF 21 × 1,5	1,5	19,5	125	20	16,0	12,0	02216980
MF 22 × 0,75	0,75	21,25	125	20	18,0	14,5	02216990
MF 22 × 1	1,0	21,0	125	20	18,0	14,5	02217000
MF 22 × 1,25	1,25	20,75	125	20	18,0	14,5	02217010
MF 22 × 1,5	1,5	20,5	125	20	18,0	14,5	02217020
MF 22 × 2	2,0	20,0	140	25	18,0	14,5	02217030
MF 23 × 1	1,0	22,0	125	20	18,0	14,5	02217040
MF 23 × 1,5	1,5	21,5	125	20	18,0	14,5	02217050
MF 24 × 0,75	0,75	23,25	125	20	18,0	14,5	02217060
MF 24 × 1	1,0	23,0	125	20	18,0	14,5	02217070
MF 24 × 1,25	1,25	22,75	125	20	18,0	14,5	02217080
MF 24 × 1,5	1,5	22,5	140	20	18,0	14,5	02217090
MF 24 × 2	2,0	22,0	140	20	18,0	14,5	02217100

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MACHINE TAPS

Machine tap with overflow shank, 2-3 thread chamfer

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 374)	Hole type	Blind hole < 1.1/2×d
Thread	MF	Direction	Right
Material	HSSE-G	Tolerance	6H
Raw material	Steel	Form	Form C

						◇	Art.-No.
MF 3 × 0,35	0,35	2,65	56	8	2,2	—	02221200
MF 3,5 × 0,35	0,35	3,15	56	8	2,5	2,1	02221220
MF 4 × 0,35	0,35	3,65	63	10	2,8	2,1	02221230
MF 4 × 0,5	0,5	3,5	63	10	2,8	2,7	02221240
MF 4,5 × 0,5	0,5	4,0	70	12	3,5	2,7	02221260
MF 5 × 0,5	0,5	4,5	70	12	3,5	2,7	02221280
MF 5 × 0,75	0,75	4,25	70	12	3,5	2,7	02221290
MF 6 × 0,5	0,5	5,5	80	14	4,5	3,4	02221320
MF 6 × 0,75	0,75	5,25	80	14	4,5	3,4	02221330
MF 7 × 0,5	0,5	6,5	80	14	5,5	4,3	02221350
MF 7 × 0,75	0,75	6,25	80	14	5,5	4,3	02221360
MF 8 × 0,5	0,5	7,5	80	18	6,0	4,9	02221380
MF 8 × 0,75	0,75	7,25	80	18	6,0	4,9	02221390
MF 8 × 1	1,0	7,0	90	22	6,0	4,9	02221400
MF 8 × 1,5	1,5	6,5	90	22	6,0	4,9	02221410
MF 9 × 0,5	0,5	8,5	90	20	7,0	5,5	02221420
MF 9 × 0,75	0,75	8,25	90	20	7,0	5,5	02221430
MF 9 × 1	1,0	8,0	90	22	7,0	5,5	02221440
MF 10 × 0,5	0,5	9,5	90	20	7,0	5,5	02221450
MF 10 × 0,75	0,75	9,25	90	20	7,0	5,5	02221460
MF 10 × 1	1,0	9,0	90	20	7	5,5	02221470
MF 10 × 1,25	1,25	8,75	100	20	7,0	5,5	02221480
MF 11 × 0,5	0,5	10,5	90	20	8,0	6,2	02221490
MF 11 × 0,75	0,75	10,25	90	20	8,0	6,2	02221500
MF 11 × 1	1,0	10,0	90	20	8,0	6,2	02221510
MF 11 × 1,25	1,25	9,75	90	20	8,0	6,2	02221520
MF 12 × 0,5	0,5	11,5	100	22	9,0	7,0	02221530
MF 12 × 0,75	0,75	11,25	100	22	9,0	7,0	02221540
MF 12 × 1	1,0	11,0	100	22	9,0	7,0	02221550
MF 12 × 1,25	1,25	10,75	100	22	9,0	7,0	02221560
MF 12 × 1,5	1,5	10,5	100	22	9,0	7,0	02221570
MF 13 × 0,5	0,5	12,5	100	22	11,0	9,0	02221580
MF 13 × 0,75	0,75	12,25	100	22	11,0	9,0	02221590
MF 13 × 1	1,0	12,0	100	22	11,0	9,0	02221600
MF 13 × 1,25	1,25	11,75	100	22	11,0	9,0	02221610
MF 13 × 1,5	1,5	11,5	100	22	11,0	9,0	02221620

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						◇	Art.-No.
MF 14 × 0,5	0,5	13,5	100	22	11,0	9,0	02221630
MF 14 × 0,75	0,75	13,25	100	22	11,0	9,0	02221640
MF 14 × 1	1,0	13,0	100	22	11,0	9,0	02221650
MF 14 × 1,25	1,25	12,75	100	22	11,0	9,0	02221660
MF 14 × 1,5	1,5	12,5	100	22	11,0	9,0	02221670
MF 15 × 0,5	0,5	14,5	100	22	12,0	9,0	02221680
MF 15 × 0,75	0,75	14,25	100	22	12,0	9,0	02221690
MF 15 × 1	1,0	14,0	100	22	12,0	9,0	02221700
MF 15 × 1,25	1,25	13,8	100	22	12,0	9,0	02221710
MF 15 × 1,5	1,5	13,5	100	22	12,0	9,0	02221720
MF 16 × 0,5	0,5	15,5	100	22	12,0	9,0	02221730
MF 16 × 0,75	0,75	15,25	100	22	12,0	9,0	02221740
MF 16 × 1	1,0	15,0	100	22	12,0	9,0	02221750
MF 16 × 1,25	1,25	14,75	100	22	12,0	9,0	02221760
MF 16 × 1,5	1,5	14,5	100	22	12,0	9,0	02221770
MF 17 × 0,75	0,75	16,25	100	22	12,0	9,0	02221780
MF 17 × 1	1,0	16,0	100	22	12,0	9,0	02221790
MF 17 × 1,5	1,5	15,5	100	22	12,0	9,0	02221810
MF 18 × 0,5	0,5	17,5	110	25	14,0	11,0	02221820
MF 18 × 0,75	0,75	17,25	110	25	14,0	11,0	02221830
MF 18 × 1	1,0	17,0	110	25	14,0	11,0	02221840
MF 18 × 1,25	1,25	16,75	110	25	14,0	11,0	02221850
MF 18 × 1,5	1,5	16,5	110	25	14,0	11,0	02221860
MF 18 × 2	2,0	16,0	125	34	14,0	11,0	02221870
MF 19 × 1	1,0	18,0	125	25	14,0	11,0	02221880
MF 19 × 1,5	1,5	17,5	125	25	14,0	11,0	02221890
MF 20 × 0,5	0,5	19,5	125	25	16,0	12,0	02221910
MF 20 × 0,75	0,75	19,25	125	25	16,0	12,0	02221920
MF 20 × 1	1,0	19,0	125	25	16,0	12,0	02221930
MF 20 × 1,25	1,25	18,75	125	25	16,0	12,0	02221940
MF 20 × 1,5	1,5	18,5	125	25	16,0	12,0	02221950
MF 20 × 2	2,0	18,0	140	34	16,0	12,0	02221960
MF 21 × 1	1,0	20,0	125	25	16,0	12,0	02221980
MF 21 × 1,5	1,5	19,5	125	25	16,0	12,0	02222000
MF 22 × 0,5	0,5	21,5	125	20	18,0	14,5	02222010
MF 22 × 0,75	0,75	21,25	125	25	18,0	14,5	02222020
MF 22 × 1	1,0	21,0	125	25	18,0	14,5	02222030
MF 22 × 1,25	1,25	20,75	125	25	18,0	14,5	02222040
MF 22 × 1,5	1,5	20,5	125	25	18,0	14,5	02222050
MF 22 × 2	2,0	20,0	140	34	18,0	14,5	02222060
MF 23 × 1	1,0	22,0	125	28	18,0	14,5	02222070
MF 23 × 1,5	1,5	21,5	125	28	18,0	14,5	02222080
MF 24 × 0,5	0,5	23,5	125	28	18,0	14,5	02222090
MF 24 × 0,75	0,75	23,25	140	28	18,0	14,5	02222100

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						◇	Art.-No.
MF 24 × 1	1,0	23,0	140	28	18,0	14,5	02222110
MF 24 × 1,25	1,25	22,75	140	28	18,0	14,5	02222120
MF 24 × 1,5	1,5	22,5	140	28	18,0	14,5	02222130
MF 24 × 2	2,0	22,0	140	28	18,0	14,5	02222140
MF 25 × 1	1,0	24,0	140	28	18,0	14,5	02222150
MF 25 × 1,5	1,5	23,5	140	28	18,0	14,5	02222170
MF 25 × 2	2,0	23,0	140	28	18,0	14,5	02222180
MF 26 × 1	1,0	25,0	140	28	18,0	14,5	02222190
MF 26 × 1,25	1,25	24,75	140	28	18,0	14,5	02222200
MF 26 × 1,5	1,5	24,5	140	28	18,0	14,5	02222210
MF 26 × 2	2,0	24,0	140	28	18,0	14,5	02222220
MF 27 × 1	1,0	26,0	150	28	20,0	16,0	02222230
MF 27 × 1,5	1,5	25,5	140	28	20,0	16,0	02222240
MF 27 × 2	2,0	25,0	150	28	20,0	16,0	02222250
MF 28 × 1	1,0	27,0	150	28	20,0	16,0	02222260
MF 28 × 1,5	1,5	26,5	150	28	20,0	16,0	02222270
MF 28 × 2	2,0	26,0	140	28	20,0	16,0	02222280
MF 30 × 1	1,0	29,0	150	28	22,0	18,0	02222290
MF 30 × 1,5	1,5	28,5	150	28	22,0	18,0	02222300
MF 30 × 2	2,0	28,0	150	28	22,0	18,0	02222310
MF 30 × 3	3,0	27,0	180	45	22,0	18,0	02222320
MF 32 × 1	1,0	31,0	150	30	22,0	18,0	02222330
MF 32 × 1,5	1,5	30,5	150	30	22,0	18,0	02222340
MF 32 × 2	2,0	30,0	150	30	22,0	18,0	02222350
MF 32 × 3	3,0	29,0	180	50	22,0	18,0	02222360
MF 33 × 1	1,0	32,0	150	30	25,0	20,0	02222370
MF 33 × 1,5	1,5	31,5	160	30	25,0	20,0	02222380
MF 33 × 2	2,0	31,0	160	30	25,0	20,0	02222390
MF 33 × 3	3,0	30,0	180	50	25,0	20,0	02222400
MF 34 × 1	1,0	33,0	170	30	28,0	22,0	02222410
MF 34 × 1,5	1,5	32,5	170	30	28,0	22,0	02222420
MF 34 × 2	2,0	32,0	170	30	28,0	22,0	02222430
MF 34 × 3	3,0	31,0	200	56	28,0	22,0	02222440
MF 35 × 1	1,0	34,0	170	30	28,0	22,0	02222450
MF 35 × 1,5	1,5	33,5	170	30	28,0	22,0	02222460
MF 35 × 2	2,0	33,0	170	30	28,0	22,0	02222470
MF 35 × 3	3,0	32,0	200	56	28,0	22,0	02222480
MF 36 × 1	1,0	35,0	170	30	28,0	22,0	02222490
MF 36 × 1,5	1,5	34,5	170	30	28,0	22,0	02222500
MF 36 × 2	2,0	34,0	170	30	28,0	22,0	02222510
MF 36 × 3	3,0	33,0	200	56	28,0	22,0	02222520
MF 38 × 1	1,0	37,0	170	30	28,0	22,0	02222530
MF 38 × 1,5	1,5	36,5	170	30	28,0	22,0	02222540
MF 38 × 2	2,0	36,0	170	30	28,0	22,0	02222550

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							Art.-No.
MF 38 × 3	3,0	35,0	200	56	28,0	22,0	02222560
MF 39 × 1,5	1,5	37,5	170	30	32,0	24,0	02222570
MF 39 × 2	2,0	37,0	170	30	32,0	24,0	02222580
MF 39 × 3	3,0	36,0	200	60	32,0	24,0	02222590
MF 40 × 1	1,0	39,0	170	30	32,0	24,0	02222600
MF 40 × 1,5	1,5	38,5	170	30	32,0	24,0	02222610
MF 40 × 2	2,0	38,0	170	30	32,0	24,0	02222620
MF 40 × 3	3,0	37,0	200	60	32,0	24,0	02222630
MF 42 × 1,5	1,5	40,5	170	30	32,0	24,0	02222640
MF 42 × 2	2,0	40,0	170	30	32,0	24,0	02222650
MF 42 × 3	3,0	39,0	200	60	32,0	24,0	02222660
MF 42 × 4	4,0	38,0	225	60	32,0	24,0	02222670
MF 45 × 1	1,0	44,0	180	32	36,0	29,0	02222680
MF 45 × 1,5	1,5	43,5	180	32	36,0	29,0	02222690
MF 45 × 2	2,0	43,0	180	32	36,0	29,0	02222700
MF 45 × 3	3,0	42,0	200	50	36,0	29,0	02222710
MF 45 × 4	4,0	41,0	225	65	36,0	29,0	02222720
MF 48 × 1	1,0	47,0	190	32	36,0	29,0	02222730
MF 48 × 1,5	1,5	46,5	190	32	36,0	29,0	02222740
MF 48 × 2	2,0	46,0	190	32	36,0	29,0	02222750
MF 48 × 3	3,0	45,0	225	50	36,0	29,0	02222760
MF 48 × 4	4,0	44,0	225	70	36,0	29,0	02222770
MF 50 × 1	1,0	49,0	190	32	36,0	29,0	02222780
MF 50 × 1,5	1,5	48,5	190	32	36,0	29,0	02222790
MF 50 × 2	2,0	48,0	190	32	36,0	29,0	02222800
MF 50 × 3	3,0	47,0	225	50	36,0	29,0	02222810
MF 50 × 4	4,0	46,0	225	70	36,0	29,0	02222820
MF 52 × 1	1,0	51,0	190	32	40,0	32,0	02222830
MF 52 × 1,5	1,5	50,5	190	32	40,0	32,0	02222840
MF 52 × 2	2,0	50,0	190	32	40,0	32,0	02222850
MF 52 × 3	3,0	49,0	225	50	40,0	32,0	02222860
MF 52 × 4	4,0	48,0	225	70	36,0	29,0	02222870

GSR

MACHINE TAPS

Machine tap with overflow shank, 2-3 thread chamfer, vaporised

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 374)	Hole type	Blind hole < 1.1/2×d
Thread	MF	Direction	Right
Material	HSSE-G / VAP	Tolerance	6H
Raw material	Stainlees steel	Form	Form C

						◇	Art.-No.
MF 3 × 0,35	0,35	2,65	56	8	2,2	—	02217250
MF 3,5 × 0,35	0,35	3,15	56	8	2,5	2,1	02217260
MF 4 × 0,35	0,35	3,65	63	10	2,8	2,1	02217270
MF 4 × 0,5	0,5	3,5	63	10	2,8	2,7	02217280
MF 4,5 × 0,5	0,5	4,0	70	12	3,5	2,7	02217290
MF 5 × 0,5	0,5	4,5	70	12	3,5	2,7	02217300
MF 5 × 0,75	0,75	4,25	70	12	3,5	2,7	02217310
MF 6 × 0,5	0,5	5,5	80	14	4,5	3,4	02217320
MF 6 × 0,75	0,75	5,25	80	14	4,5	3,4	02217330
MF 7 × 0,5	0,5	6,5	80	14	5,5	4,3	02217340
MF 7 × 0,75	0,75	6,25	80	14	5,5	4,3	02217350
MF 8 × 0,5	0,5	7,5	80	18	6,0	4,9	02217360
MF 8 × 0,75	0,75	7,25	80	18	6,0	4,9	02217390
MF 8 × 1	1,0	7,0	90	22	6,0	4,9	02217400
MF 8 × 1,5	1,5	6,5	90	22	6,0	4,9	02217410
MF 9 × 0,5	0,5	8,5	90	20	7,0	5,5	02217420
MF 9 × 0,75	0,75	8,25	90	20	7,0	5,5	02217430
MF 9 × 1	1,0	8,0	90	22	7,0	5,5	02217440
MF 10 × 0,5	0,5	9,5	90	20	7,0	5,5	02217450
MF 10 × 0,75	0,75	9,25	90	20	7,0	5,5	02217460
MF 10 × 1	1,0	9,0	90	20	7	5,5	02217470
MF 10 × 1,25	1,25	8,75	100	20	7,0	5,5	02217480
MF 11 × 0,5	0,5	10,5	90	20	8,0	6,2	02217490
MF 11 × 0,75	0,75	10,25	90	20	8,0	6,2	02217500
MF 11 × 1	1,0	10,0	90	20	8,0	6,2	02217510
MF 11 × 1,25	1,25	9,75	90	20	8,0	6,2	02217520
MF 12 × 0,5	0,5	11,5	100	22	9,0	7,0	02217530
MF 12 × 0,75	0,75	11,25	100	22	9,0	7,0	02217540
MF 12 × 1	1,0	11,0	100	22	9,0	7,0	02217550
MF 12 × 1,25	1,25	10,75	100	22	9,0	7,0	02217560
MF 12 × 1,5	1,5	10,5	100	22	9,0	7,0	02217570
MF 13 × 0,5	0,5	12,5	100	22	11,0	9,0	02217580
MF 13 × 0,75	0,75	12,25	100	22	11,0	9,0	02217590
MF 13 × 1	1,0	12,0	100	22	11,0	9,0	02217600
MF 13 × 1,25	1,25	11,75	100	22	11,0	9,0	02217610
MF 13 × 1,5	1,5	11,5	100	22	11,0	9,0	02217620

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							Art.-No.
MF 14 × 0,5	0,5	13,5	100	22	11,0	9,0	02217630
MF 14 × 0,75	0,75	13,25	100	22	11,0	9,0	02217640
MF 14 × 1	1,0	13,0	100	22	11,0	9,0	02217650
MF 14 × 1,25	1,25	12,75	100	22	11,0	9,0	02217660
MF 14 × 1,5	1,5	12,5	100	22	11,0	9,0	02217670
MF 15 × 0,5	0,5	14,5	100	22	12,0	9,0	02217680
MF 15 × 0,75	0,75	14,25	100	22	12,0	9,0	02217690
MF 15 × 1	1,0	14,0	100	22	12,0	9,0	02217700
MF 15 × 1,25	1,25	13,8	100	22	12,0	9,0	02217710
MF 15 × 1,5	1,5	13,5	100	22	12,0	9,0	02217720
MF 16 × 0,5	0,5	15,5	100	22	12,0	9,0	02217730
MF 16 × 0,75	0,75	15,25	100	22	12,0	9,0	02217740
MF 16 × 1	1,0	15,0	100	22	12,0	9,0	02217750
MF 16 × 1,25	1,25	14,75	100	22	12,0	9,0	02217760
MF 16 × 1,5	1,5	14,5	100	22	12,0	9,0	02217770
MF 17 × 0,75	0,75	16,25	100	22	12,0	9,0	02217780
MF 17 × 1	1,0	16,0	100	22	12,0	9,0	02217790
MF 17 × 1,5	1,5	15,5	100	22	12,0	9,0	02217800
MF 18 × 0,5	0,5	17,5	110	25	14,0	11,0	02217810
MF 18 × 0,75	0,75	17,25	110	25	14,0	11,0	02217820
MF 18 × 1	1,0	17,0	110	25	14,0	11,0	02217830
MF 18 × 1,25	1,25	16,75	110	25	14,0	11,0	02217840
MF 18 × 1,5	1,5	16,5	110	25	14,0	11,0	02217860
MF 18 × 2	2,0	16,0	125	34	14,0	11,0	02217870
MF 19 × 1	1,0	18,0	125	25	14,0	11,0	02217880
MF 19 × 1,5	1,5	17,5	125	25	14,0	11,0	02217890
MF 20 × 0,5	0,5	19,5	125	25	16,0	12,0	02217900
MF 20 × 0,75	0,75	19,25	125	25	16,0	12,0	02217910
MF 20 × 1	1,0	19,0	125	25	16,0	12,0	02217920
MF 20 × 1,25	1,25	18,75	125	25	16,0	12,0	02217930
MF 20 × 1,5	1,5	18,5	125	25	16,0	12,0	02217950
MF 20 × 2	2,0	18,0	140	34	16,0	12,0	02217960
MF 21 × 1	1,0	20,0	125	25	16,0	12,0	02217970
MF 21 × 1,5	1,5	19,5	125	25	16,0	12,0	02217980
MF 22 × 0,5	0,5	21,5	125	20	18,0	14,5	02217990
MF 22 × 0,75	0,75	21,25	125	25	18,0	14,5	02219020
MF 22 × 1	1,0	21,0	125	25	18,0	14,5	02219030
MF 22 × 1,25	1,25	20,75	125	25	18,0	14,5	02219040
MF 22 × 1,5	1,5	20,5	125	25	18,0	14,5	02219050
MF 22 × 2	2,0	20,0	140	34	18,0	14,5	02219060
MF 23 × 1	1,0	22,0	125	28	18,0	14,5	02219070
MF 23 × 1,5	1,5	21,5	125	28	18,0	14,5	02219080
MF 24 × 0,5	0,5	23,5	125	28	18,0	14,5	02219090
MF 24 × 0,75	0,75	23,25	140	28	18,0	14,5	02219100

							Art.-No.
MF 24 × 1	1,0	23,0	140	28	18,0	14,5	02219110
MF 24 × 1,25	1,25	22,75	140	28	18,0	14,5	02219120
MF 24 × 1,5	1,5	22,5	140	28	18,0	14,5	02219130
MF 24 × 2	2,0	22,0	140	28	18,0	14,5	02219140

MACHINE TAPS

Machine tap with overflow shank, 2-3 thread chamfer, vaporised

TECHNICAL INFORMATION

Standard	DIN 2184-1	Hole type	Through hole < 1.1/2×d
Thread	BSW	Direction	Right
Material	HSSE-G	Form	Form B
Raw material	Steel		

							Art.-No.
BSW 1/8	40	2,6	56	12	3,5	2,7	01304030
BSW 5/32	32	3,2	63	14	4,5	3,4	01304040
BSW 3/16	24	3,8	70	14	5,5	4,3	01304050
BSW 7/32	24	4,6	80	18	6,0	4,9	01304060
BSW 1/4	20	5,1	80	22	7,0	5,5	01304070
BSW 5/16	18	6,5	90	22	8,0	6,2	01304080
BSW 3/8	16	7,9	100	25	9,0	7,0	01304090
BSW 7/16	14	9,3	100	30	8,0	6,2	01304100
BSW 1/2	12	10,5	110	30	9,0	7,0	01304110
BSW 9/16	12	12,0	110	32	11,0	9,0	01304120
BSW 5/8	11	13,5	110	32	12,0	9,0	01304130
BSW 3/4	10	16,5	125	40	14,0	11,0	01304140
BSW 7/8	9	19,5	140	40	18,0	14,5	01304150
BSW 1	8	22,0	160	50	20,0	16,0	01304160
BSW 1.1/8	7	25,0	180	56	22,0	18,0	01304170
BSW 1.1/4	7	28,0	180	56	25,0	20,0	01304180
BSW 1.3/8	6	30,5	200	63	28,0	22,0	01304190
BSW 1.1/2	6	33,5	200	63	32,0	24,0	01304200
BSW 1.5/8	5	35,5	200	70	32,0	24,0	01304210
BSW 1.3/4	5	39,0	220	70	36,0	29,0	01304220
BSW 1.7/8	4,5	41,5	220	80	36,0	29,0	01304230
BSW 2	4,5	44,5	250	80	40,0	32,0	01304240

MACHINE TAPS DIN 2184-1

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1	Hole type	Blind hole < 2×d
Thread	BSW	Direction	Right
Material	HSSE-G	Form	Form C / RSP 35°
Raw material	Steel		

Machine tap with ≤ 3/8 reinforced shank, 35° right spiral flute, 2-3 thread chamfer

						◇	Art.-No.
BSW 1/8	40	2,6	56	11	3,5	2,7	01315030
BSW 5/32	32	3,2	63	13	4,5	3,4	01315040
BSW 3/16	24	3,8	70	14	5,5	4,3	01315050
BSW 7/32	24	4,6	80	16	6,0	4,9	01315060
BSW 1/4	20	5,1	80	16	7,0	5,5	01315070
BSW 5/16	18	6,5	90	18	8,0	6,2	01315080
BSW 3/8	16	7,9	100	20	9,0	7,0	01315090
BSW 7/16	14	9,3	100	22	8,0	6,2	01315100
BSW 1/2	12	10,5	110	25	9,0	7,0	01315110
BSW 9/16	12	12,0	110	25	11,0	9,0	01315120
BSW 5/8	11	13,5	110	28	12,0	9,0	01315130
BSW 3/4	10	16,5	125	32	14,0	11,0	01315140
BSW 7/8	9	19,5	140	32	18,0	14,5	01315150
BSW 1	8	22,0	160	36	20,0	16,0	01315160
BSW 1.1/8	7	25,0	180	40	22,0	18,0	01315170
BSW 1.1/4	7	28,0	180	40	25,0	20,0	01315180
BSW 1.3/8	6	30,5	200	45	28,0	22,0	01315190
BSW 1.1/2	6	33,5	200	45	32,0	24,0	01315200
BSW 1.5/8	5	35,5	200	56	32,0	24,0	01315210
BSW 1.3/4	5	39,0	220	63	36,0	29,0	01315220
BSW 1.7/8	4,5	41,5	220	63	36,0	29,0	01315230
BSW 2	4,5	44,5	250	70	40,0	32,0	01315240

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1	Hole type	Blind hole <1.1/2×d
Thread	BSW	Direction	Right
Material	HSSE-G	Form	Form C
Raw material	Steel		

Machine tap with ≤ 3/8 reinforced shank, 2-3 thread chamfer, straight flute

							Art.-No.
BSW 3/32	48	1,9	50	11	2,8	2,1	01321010
BSW 1/8	40	2,6	56	12	3,5	2,7	01321030
BSW 5/32	32	3,2	63	14	4,5	3,4	01321040
BSW 3/16	24	3,8	70	14	5,5	4,3	01321050
BSW 7/32	24	4,6	80	18	6,0	4,9	01321060
BSW 1/4	20	5,1	80	22	7,0	5,5	01321070
BSW 5/16	18	6,5	90	22	8,0	6,2	01321080
BSW 3/8	16	7,9	100	25	9,0	7,0	01321090
BSW 7/16	14	9,3	100	30	8,0	6,2	01321100
BSW 1/2	12	10,5	110	30	9,0	7,0	01321110
BSW 9/16	12	12,0	110	32	11,0	9,0	01321120
BSW 5/8	11	13,5	110	32	12,0	9,0	01321130
BSW 3/4	10	16,5	125	40	14,0	11,0	01321140
BSW 7/8	9	19,5	140	40	18,0	14,5	01321150
BSW 1	8	22,0	160	50	20,0	16,0	01321160
BSW 1.1/8	7	25,0	180	56	22,0	18,0	01321170
BSW 1.1/4	7	28,0	180	56	25,0	20,0	01321180
BSW 1.3/8	6	30,5	200	63	28,0	22,0	01321190
BSW 1.1/2	6	33,5	200	63	32,0	24,0	01321200
BSW 1.5/8	5	35,5	200	70	32,0	24,0	01321210
BSW 1.3/4	5	39,0	220	70	36,0	29,0	01321220
BSW 1.7/8	4,5	41,5	220	80	36,0	29,0	01321230
BSW 2	4,5	44,5	250	80	40,0	32,0	01321240

MACHINE TAPS DIN 5156

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 5156)	Hole type	Through hole >1.1/2×d
Thread	BSP	Direction	Right
Material	HSSE-G	Form	Form B
Raw material	Steel		

Machine tap with overflow shank, 4-5 thread chamfer, straight flute, with spiral point

							Art.-No.
BSP 1/8	28	8,8	100	16	7,0	5,5	02504020
BSP 1/4	19	11,8	100	22	11,0	9,0	02504060
BSP 3/8	19	15,3	100	22	12,0	9,0	02504080
BSP 1/2	14	19,0	125	25	16,0	12,0	02504100
BSP 5/8	14	21,0	125	25	18,0	14,5	02504120
BSP 3/4	14	24,5	140	28	20,0	16,0	02504130
BSP 7/8	14	28,3	150	28	22,0	18,0	02504140
BSP 1	11	30,5	160	32	25,0	20,0	02504150
BSP 1.1/8	11	35,5	170	30	28,0	22,0	02504160
BSP 1.1/4	11	39,5	170	30	32,0	24,0	02504180
BSP 1.3/8	11	42,0	190	32	36,0	29,0	02504190
BSP 1.1/2	11	45,0	190	32	36,0	29,0	02504200
BSP 1.5/8	11	49,6	200	40	36,0	29,0	02504210
BSP 1.3/4	11	51,0	200	40	40,0	32,0	02504220
BSP 2	11	57,0	220	40	45,0	35,0	02504230

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 5156)	Hole type	Blind hole > 2×d
Thread	BSP	Direction	Right
Material	HSSE-G	Form	Form C / RSP 35°
Raw material	Steel		

Machine tap with overflow shank, 35° right spiral flute, 2-3 thread chamfer

						◇	Art.-No.
BSP 1/8	28	8,8	90	12	7,0	5,5	02516020
BSP 1/4	19	11,8	100	16	11,0	9,0	02516060
BSP 3/8	19	15,3	100	18	12,0	9,0	02516080
BSP 1/2	14	19,0	125	25	16,0	12,0	02516100
BSP 5/8	14	21,0	125	25	18,0	14,5	02516120
BSP 3/4	14	24,5	140	28	20,0	16,0	02516130
BSP 7/8	14	28,3	150	28	22,0	18,0	02516140
BSP 1	11	30,5	160	30	25,0	20,0	02516150
BSP 1.1/8	11	35,5	170	30	28,0	22,0	02516170
BSP 1.1/4	11	39,5	170	30	32,0	24,0	02516180
BSP 1.3/8	11	42,0	190	32	36,0	29,0	02516190
BSP 1.1/2	11	45,0	190	32	36,0	29,0	02516200
BSP 1.5/8	11	49,6	200	40	36,0	29,0	02516210
BSP 1.3/4	11	51,0	200	40	40,0	32,0	02516220
BSP 2	11	57,0	220	40	45,0	35,0	02516230

MACHINE TAPS DIN 5156

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 5156)	Hole type	Blind hole > 2×d
Thread	BSP	Direction	Right
Material	HSSE-G / VAP	Form	Form C / RSP 35°
Raw material	Stainlees steel		

Machine tap with overflow shank, 35° right spiral flute, 2-3 thread chamfer, vaporised

							Art.-No.
BSP 1/8	28	8,8	90	12	7,0	5,5	02515020
BSP 1/4	19	11,8	100	16	11,0	9,0	02515060
BSP 3/8	19	15,3	100	18	12,0	9,0	02515080
BSP 1/2	14	19,0	125	25	16,0	12,0	02515100
BSP 5/8	14	21,0	125	25	18,0	14,5	02515110
BSP 3/4	14	24,5	140	28	20,0	16,0	02515130
BSP 7/8	14	28,3	150	28	22,0	18,0	02515140
BSP 1	11	30,5	160	30	25,0	20,0	02515150
BSP 1.1/8	11	35,5	170	30	28,0	22,0	02515160
BSP 1.1/4	11	39,5	170	30	32,0	24,0	02515170
BSP 1.3/8	11	42,0	190	32	36,0	29,0	02515180
BSP 1.1/2	11	45,0	190	32	36,0	29,0	02515200
BSP 1.5/8	11	49,6	200	40	36,0	29,0	02515210
BSP 1.3/4	11	51,0	200	40	40,0	32,0	02515220
BSP 2	11	57,0	220	40	45,0	35,0	02515230

MACHINE TAPS

Machine tap with overflow shank, straight flute, 2-3 thread chamfer

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 5156)	Hole type	Blind hole < 1.1/2×d
Thread	BSP	Direction	Right
Material	HSSE-G	Form	Form C
Raw material	Steel		

						◇	Art.-No.
BSP 1/8	28	8,8	90	20	7,0	5,5	02521020
BSP 1/4	19	11,8	100	22	11,0	9,0	02521060
BSP 3/8	19	15,3	100	22	12,0	9,0	02521080
BSP 1/2	14	19,0	125	25	16,0	12,0	02521100
BSP 5/8	14	21,0	125	25	18,0	14,5	02521120
BSP 3/4	14	24,5	140	28	20,0	16,0	02521130
BSP 7/8	14	28,3	150	28	22,0	18,0	02521140
BSP 1	11	30,5	160	30	25,0	20,0	02521150
BSP 1.1/8	11	35,5	170	30	28,0	22,0	02521170
BSP 1.1/4	11	39,5	170	30	32,0	24,0	02521180
BSP 1.3/8	11	42,0	190	32	36,0	29,0	02521190
BSP 1.1/2	11	45,0	190	32	36,0	29,0	02521200
BSP 1.3/4	11	51,0	200	40	40,0	32,0	02521220
BSP 2	11	57,0	220	40	45,0	35,0	02521230

MACHINE TAPS DIN 5156 / 2184-1

MACHINE TAPS

Machine tap with overflow shank, 2-3 thread chamfer, vaporised

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 5156)	Hole type	Blind hole < 1.1/2×d
Thread	BSP	Direction	Right
Material	HSSE-G / VAP	Form	Form C
Raw material	Stainlees steel		

							Art.-No.
BSP 1/8	28	8,8	90	20	7,0	5,5	02517020
BSP 1/4	19	11,8	100	22	11,0	9,0	02517060
BSP 3/8	19	15,3	100	22	12,0	9,0	02517080
BSP 1/2	14	19,0	125	25	16,0	12,0	02517100
BSP 5/8	14	21,0	125	25	18,0	14,5	02517120
BSP 3/4	14	24,5	140	28	20,0	16,0	02517130
BSP 7/8	14	28,3	150	28	22,0	18,0	02517140
BSP 1	11	30,5	160	30	25,0	20,0	02517150
BSP 1.1/8	11	35,5	170	30	28,0	22,0	02517170
BSP 1.1/4	11	39,5	170	30	32,0	24,0	02517180
BSP 1.3/8	11	42,0	190	32	36,0	29,0	02517190
BSP 1.1/2	11	45,0	190	32	36,0	29,0	02517200
BSP 1.3/4	11	51,0	200	40	40,0	32,0	02517220
BSP 2	11	57,0	220	40	45,0	35,0	02517230

GSR

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1	Hole type	Through hole <1.1/2×d
Thread	UNC	Direction	Right
Material	HSSE-G	Tolerance	2B
Raw material	Steel	Form	Form B

Machine tap with ≤ 3/8 reinforced shank, 4-5 thread chamfer, straight flute, with spiral point

						◇	Art.-No.
UNC No. 2	56	1,8	45	9	2,8	2,1	01604020
UNC No. 3	48	2,1	50	9	2,8	2,1	01604030
UNC No. 4	40	2,3	56	11	3,5	2,7	01604040
UNC No. 5	40	2,6	56	11	3,5	2,7	01604050
UNC No. 6	32	2,9	56	12	4,0	3,0	01604060
UNC No. 8	32	3,5	63	13	4,5	3,4	01604080
UNC No. 10	24	3,9	70	15	6,0	4,9	01604100
UNC No. 12	24	4,5	80	16	6,0	4,9	01604120
UNC 1/4	20	5,2	80	17	7,0	5,5	01604130
UNC 5/16	18	6,6	90	22	8	6,2	01604140
UNC 3/8	16	8	100	24	10	8	01604150
UNC 7/16	14	9,4	100	22	8,0	6,2	01604160
UNC 1/2	13	10,8	110	24	9,0	7,0	01604170
UNC 9/16	12	12,3	110	26	11,0	9,0	01604180
UNC 5/8	11	13,5	110	27	12,0	9,0	01604190
UNC 3/4	10	16,5	125	30	14,0	11,0	01604210
UNC 7/8	9	19,5	140	32	18,0	14,5	01604230
UNC 1	8	22,3	160	36	20,0	16,0	01604250
UNC 1.1/8	7	25,0	180	40	22,0	18,0	01604260
UNC 1.1/4	7	28,3	180	40	22,0	18,0	01604270
UNC 1.3/8	6	30,8	200	45	28,0	22,0	01604280
UNC 1.1/2	6	34,0	200	45	32,0	24,0	01604290
UNC 1.5/8	6	37,1	200	56	32,0	24,0	01604300
UNC 1.3/4	5	39,5	220	63	36,0	29,0	01604310
UNC 1.7/8	4,5	42,0	220	63	36,0	29,0	01604320
UNC 2	4,5	45,0	250	70	40,0	32,0	01604330
UNC 2.1/4	4,5	51,5	280	75	45	35	01604340
UNC 2.1/2	4	57,2	315	80	50	39	01604350
UNC 2.3/4	4	63,25	340	80	50	39	01604360
UNC 3	4	69,85	360	85	50	39	01604370

MACHINE TAPS DIN 2184-1

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1	Hole type	Through hole <1.1/2×d
Thread	UNC	Direction	Right
Material	HSSE-G / VAP	Tolerance	2B
Raw material	Stainlees steel	Form	Form B

Machine tap with ≤ 3/8 reinforced shank, 4-5 thread chamfer, with spiral point, vaporised

						◇	Art.-No.
UNC No. 2	56	1,8	45	9	2,8	2,1	01605020
UNC No. 3	48	2,1	50	9	2,8	2,1	01605030
UNC No. 4	40	2,3	56	11	3,5	2,7	01605040
UNC No. 5	40	2,6	56	11	3,5	2,7	01605050
UNC No. 6	32	2,9	56	12	4,0	3,0	01605060
UNC No. 8	32	3,5	63	13	4,5	3,4	01605080
UNC No. 10	24	3,9	70	15	6,0	4,9	01605100
UNC No. 12	24	4,5	80	16	6,0	4,9	01605120
UNC 1/4	20	5,2	80	17	7,0	5,5	01605130
UNC 5/16	18	6,6	90	22	8	6,2	01605140
UNC 3/8	16	8	100	24	10	8	01605150
UNC 7/16	14	9,4	100	22	8,0	6,2	01605160
UNC 1/2	13	10,8	110	24	9,0	7,0	01605170
UNC 9/16	12	12,3	110	26	11,0	9,0	01605180
UNC 5/8	11	13,5	110	27	12,0	9,0	01605190
UNC 3/4	10	16,5	125	30	14,0	11,0	01605210
UNC 7/8	9	19,5	140	32	18,0	14,5	01605230
UNC 1	8	22,3	160	36	20,0	16,0	01605250
UNC 1.1/8	7	25,0	180	40	22,0	18,0	01605260
UNC 1.1/4	7	28,3	180	40	22,0	18,0	01605270
UNC 1.3/8	6	30,8	200	45	28,0	22,0	01605280
UNC 1.1/2	6	34,0	200	45	32,0	24,0	01605290
UNC 1.5/8	6	37,1	200	56	32,0	24,0	01605300
UNC 1.3/4	5	39,5	220	63	36,0	29,0	01605310
UNC 1.7/8	4,5	42,0	220	63	36,0	29,0	01605320
UNC 2	4,5	45,0	250	70	40,0	32,0	01605330
UNC 2.1/4	4,5	51,5	280	75	45	35	01605340
UNC 2.1/2	4	57,2	315	80	50	39	01605350
UNC 2.3/4	4	63,25	340	80	50	39	01605360
UNC 3	4	69,85	360	85	50	39	01605370

GSR

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1	Hole type	Blind hole < 2×d
Thread	UNC	Direction	Right
Material	HSSE-G	Tolerance	2B
Raw material	Steel	Form	Form C / RSP 35°

Machine tap with ≤ 3/8 reinforced shank, 2-3 thread chamfer, 35° right spiral flute

							Art.-No.
UNC No. 2	56	1,8	45	5	2,8	2,1	01615020
UNC No. 3	48	2,1	50	5	2,8	2,1	01615030
UNC No. 4	40	2,3	56	5	3,5	2,7	01615040
UNC No. 5	40	2,6	56	5	3,5	2,7	01615050
UNC No. 6	32	2,9	56	6	4,0	3,0	01615060
UNC No. 8	32	3,5	63	7	4,5	3,4	01615080
UNC No. 10	24	3,9	70	9	6,0	4,9	01615100
UNC No. 12	24	4,5	80	9	6,0	4,9	01615120
UNC 1/4	20	5,2	80	10	7,0	5,5	01615130
UNC 5/16	18	6,6	90	12	8,0	6,2	01615140
UNC 3/8	16	8,0	100	14	9,0	7,0	01615150
UNC 7/16	14	9,4	100	16	8,0	6,2	01615160
UNC 1/2	13	10,8	110	18	9,0	7,0	01615170
UNC 9/16	12	12,3	110	18	11,0	9,0	01615180
UNC 5/8	11	13,5	110	20	12,0	9,0	01615190
UNC 3/4	10	16,5	125	25	14,0	11,0	01615210
UNC 7/8	9	19,5	140	28	18,0	14,5	01615230
UNC 1	8	22,3	160	32	20,0	16,0	01615250
UNC 1.1/8	7	25,0	180	36	22,0	18,0	01615260
UNC 1.1/4	7	28,3	180	36	22,0	18,0	01615270
UNC 1.3/8	6	30,8	200	40	28,0	22,0	01615280
UNC 1.1/2	6	34,0	200	45	32,0	24,0	01615290
UNC 1.5/8	6	37,1	200	45	32,0	24,0	01615300
UNC 1.3/4	5	39,5	220	52	36,0	29,0	01615310
UNC 1.7/8	4,5	42,0	220	52	36,0	29,0	01615320
UNC 2	4,5	45,0	250	60	40,0	32,0	01615330
UNC 2.1/4	4,5	51,5	280	75	45	35	01615340
UNC 2.1/2	4	57,2	315	80	50	39	01615350
UNC 2.3/4	4	63,25	340	80	50	39	01615360
UNC 3	4	69,85	360	85	50	39	01615370

MACHINE TAPS DIN 2184-1

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1	Hole type	Blind hole < 2×d
Thread	UNC	Direction	Right
Material	HSSE-G / VAP	Tolerance	2B
Raw material	Stainlees steel	Form	Form C / RSP 35°

Machine tap with ≤ 3/8 reinforced shank, 2-3 thread chamfer, 35° right spiral flute, vaporised

							Art.-No.
UNC No. 2	56	1,8	45	5	2,8	2,1	01616020
UNC No. 3	48	2,1	50	5	2,8	2,1	01616030
UNC No. 4	40	2,3	56	5	3,5	2,7	01616040
UNC No. 5	40	2,6	56	5	3,5	2,7	01616050
UNC No. 6	32	2,9	56	6	4,0	3,0	01616060
UNC No. 8	32	3,5	63	7	4,5	3,4	01616080
UNC No. 10	24	3,9	70	9	6,0	4,9	01616100
UNC No. 12	24	4,5	80	9	6,0	4,9	01616120
UNC 1/4	20	5,2	80	10	7,0	5,5	01616130
UNC 5/16	18	6,6	90	12	8,0	6,2	01616140
UNC 3/8	16	8,0	100	14	9,0	7,0	01616150
UNC 7/16	14	9,4	100	16	8,0	6,2	01616160
UNC 1/2	13	10,8	110	18	9,0	7,0	01616170
UNC 9/16	12	12,3	110	18	11,0	9,0	01616180
UNC 5/8	11	13,5	110	20	12,0	9,0	01616190
UNC 3/4	10	16,5	125	25	14,0	11,0	01616210
UNC 7/8	9	19,5	140	28	18,0	14,5	01616230
UNC 1	8	22,3	160	32	20,0	16,0	01616250
UNC 1.1/8	7	25,0	180	36	22,0	18,0	01616260
UNC 1.1/4	7	28,3	180	36	22,0	18,0	01616270
UNC 1.3/8	6	30,8	200	40	28,0	22,0	01616280
UNC 1.1/2	6	34,0	200	45	32,0	24,0	01616290
UNC 1.5/8	6	37,1	200	45	32,0	24,0	01616300
UNC 1.3/4	5	39,5	220	52	36,0	29,0	01616310
UNC 1.7/8	4,5	42,0	220	52	36,0	29,0	01616320
UNC 2	4,5	45,0	250	60	40,0	32,0	01616330
UNC 2.1/4	4,5	51,5	280	75	45	35	01616340
UNC 2.1/2	4	57,2	315	80	50	39	01616350
UNC 2.3/4	4	63,25	340	80	50	39	01616360
UNC 3	4	69,85	360	85	50	39	01616370

GSR

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1	Hole type	Blind hole <1.1/2×d
Thread	UNC	Direction	Right
Material	HSSE-G	Tolerance	2B
Raw material	Steel	Form	Form C

Machine tap with ≤ 3/8 reinforced shank, 2-3 thread chamfer, straight flute

							Art.-No.
UNC No. 4	40	2,3	56	11	3,,5	2,7	01621040
UNC No. 5	40	2,6	56	11	3,5	2,7	01621050
UNC No. 6	32	2,9	56	12	4,0	3,0	01621060
UNC No. 8	32	3,5	63	13	4,5	3,4	01621080
UNC No. 10	24	3,9	70	15	6,0	4,9	01621100
UNC No. 12	24	4,5	80	16	6,0	4,9	01621120
UNC 1/4	20	5,2	80	17	7,0	5,5	01621130
UNC 5/16	18	6,6	90	20	8,0	6,2	01621140
UNC 3/8	16	8,0	100	22	9,0	7,0	01621150
UNC 7/16	14	9,4	100	22	8,0	6,2	01621160
UNC 1/2	13	10,8	110	24	9,0	7,0	01621170
UNC 9/16	12	12,3	110	26	11,0	9,0	01621180
UNC 5/8	11	13,5	110	27	12,0	9,0	01621190
UNC 3/4	10	16,5	125	30	14,0	11,0	01621210
UNC 7/8	9	19,5	140	32	18,0	14,5	01621230
UNC 1	8	22,3	160	36	20,0	16,0	01621250
UNC 1.1/8	7	25,0	180	40	22,0	18,0	01621260
UNC 1.1/4	7	28,3	180	40	22,0	18,0	01621270
UNC 1.3/8	6	30,8	200	45	28,0	22,0	01621280
UNC 1.1/2	6	34,0	200	45	32,0	24,0	01621290
UNC 1.5/8	6	37,10	200	56	32,0	24,0	01621300
UNC 1.3/4	5	39,5	220	63	36,0	29,0	01621310
UNC 1.7/8	4,5	42,0	220	63	36,0	29,0	01621320
UNC 2	4,5	45,0	250	70	40,0	32,0	01621330
UNC 2.1/4	4,5	51,5	280	75	45	35	01621340
UNC 2.1/2	4	57,2	315	80	50	39	01621350
UNC 2.3/4	4	63,25	340	80	50	39	01621360
UNC 3	4	69,85	360	85	50	39	01621370

MACHINE TAPS DIN 2184-1

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1	Hole type	Through hole <1.1/2×d
Thread	UNF	Direction	Right
Material	HSSE-G	Tolerance	2B
Raw material	Steel	Form	Form B

Machine tap with ≤ 3/8 reinforced shank, 4-5 thread chamfer, straight flute, with spiral point

							Art.-No.
UNF No. 2	64	1,85	45	9	2,8	2,1	01704020
UNF No. 3	56	2,1	50	9	2,8	2,1	01704030
UNF No. 4	48	2,4	56	11	3,5	2,7	01704040
UNF No. 5	44	2,7	56	11	3,5	2,7	01704050
UNF No. 6	40	3,0	56	12	4,0	3,0	01704060
UNF No. 8	36	3,5	63	13	4,5	3,4	01704080
UNF No. 10	32	4,1	70	15	6,0	4,9	01704100
UNF No. 12	28	4,65	80	16	6,0	4,9	01704120
UNF 1/4	28	5,5	80	17	7,0	5,5	01704130
UNF 5/16	24	6,9	90	20	8,0	6,2	01704140
UNF 3/8	24	8,5	100	22	9,0	7,0	01704150
UNF 7/16	20	9,9	100	22	8,0	6,2	01704160
UNF 1/2	20	11,5	100	22	9,0	7,0	01704170
UNF 9/16	18	13,0	100	22	11,0	9,0	01704180
UNF 5/8	18	14,5	100	22	12,0	9,0	01704190
UNF 3/4	16	17,5	110	25	14,0	11,0	01704210
UNF 7/8	14	20,5	125	25	18,0	14,5	01704230
UNF 1	12	23,3	140	28	18,0	14,5	01704250
UNF 1.1/8	12	26,5	150	28	22,0	18,0	01704270
UNF 1.1/4	12	29,5	150	28	22,0	18,0	01704280
UNF 1.3/8	12	32,5	170	30	28,0	22,0	01704290
UNF 1.1/2	12	36,0	170	30	28,0	22,0	01704300

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1	Hole type	Through hole <1.1/2×d
Thread	UNF	Direction	Right
Material	HSSE-G / VAP	Tolerance	2B
Raw material	Stainlees steel	Form	Form B

Machine tap with ≤ 3/8 reinforced shank, 4-5 thread chamfer, straight flute, with spiral point, vaporised

						◇	Art.-No.
UNF No. 2	64	1,85	45	9	2,8	2,1	01705020
UNF No. 3	56	2,1	50	9	2,8	2,1	01705030
UNF No. 4	48	2,4	56	11	3,5	2,7	01705040
UNF No. 5	44	2,7	56	11	3,5	2,7	01705050
UNF No. 6	40	3,0	56	12	4,0	3,0	01705060
UNF No. 8	36	3,5	63	13	4,5	3,4	01705080
UNF No. 10	32	4,1	70	15	6,0	4,9	01705100
UNF No. 12	28	4,65	80	16	6,0	4,9	01705120
UNF 1/4	28	5,5	80	17	7,0	5,5	01705130
UNF 5/16	24	6,9	90	20	8,0	6,2	01705140
UNF 3/8	24	8,5	100	22	9,0	7,0	01705150
UNF 7/16	20	9,9	100	22	8,0	6,2	01705160
UNF 1/2	20	11,5	100	22	9,0	7,0	01705170
UNF 9/16	18	13,0	100	22	11,0	9,0	01705180
UNF 5/8	18	14,5	100	22	12,0	9,0	01705190
UNF 3/4	16	17,5	110	25	14,0	11,0	01705210
UNF 7/8	14	20,5	125	25	18,0	14,5	01705230
UNF 1	12	23,3	140	28	18,0	14,5	01705250
UNF 1.1/8	12	26,5	150	28	22,0	18,0	01705270
UNF 1.1/4	12	29,5	150	28	22,0	18,0	01705280
UNF 1.3/8	12	32,5	170	30	28,0	22,0	01705290
UNF 1.1/2	12	36,0	170	30	28,0	22,0	01705300

MACHINE TAPS DIN 2184-1

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1	Hole type	Blind hole < 2×d
Thread	UNF	Direction	Right
Material	HSSE-G	Tolerance	2B
Raw material	Steel	Form	Form C / RSP 35°

Machine tap with ≤ 3/8 reinforced shank, 4-5 thread chamfer, 35° right spiral flute

							Art.-No.
UNF No. 2	64	1,85	45	5	2,8	2,1	01715020
UNF No. 3	56	2,1	50	5	2,8	2,1	01715030
UNF No. 4	48	2,4	56	5	3,5	2,4	01715040
UNF No. 5	44	2,7	56	5	3,5	2,7	01715050
UNF No. 6	40	3,0	56	6	4,0	3,0	01715060
UNF No. 8	36	3,5	63	8	4,5	3,4	01715080
UNF No. 10	32	4,1	70	8	6,0	4,9	01715100
UNF No. 12	28	4,65	80	9	6,0	4,9	01715120
UNF 1/4	28	5,5	80	10	7,0	5,5	01715130
UNF 5/16	24	6,9	90	12	8,0	6,2	01715140
UNF 3/8	24	8,5	100	12	9,0	7,0	01715150
UNF 7/16	20	9,9	100	22	8,0	6,2	01715160
UNF 1/2	20	11,5	100	22	9,0	7,0	01715170
UNF 9/16	18	13,0	100	22	11,0	9,0	01715180
UNF 5/8	18	14,5	100	22	12,0	9,0	01715190
UNF 3/4	16	17,5	110	25	14,0	11,0	01715210
UNF 7/8	14	20,5	125	25	18,0	14,5	01715230
UNF 1	12	23,3	140	28	18,0	14,5	01715250
UNF 1.1/8	12	26,5	150	28	22,0	18,0	01715270
UNF 1.1/4	12	29,5	150	28	22,0	18,0	01715280
UNF 1.3/8	12	32,5	170	30	28,0	22,0	01715290
UNF 1.1/2	12	36,0	170	30	28,0	22,0	01715300

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1	Hole type	Blind hole < 2×d
Thread	UNF	Direction	Right
Material	HSSE-G / VAP	Tolerance	2B
Raw material	Stainlees steel	Form	Form C / RSP 35°

Machine tap with ≤ 3/8 reinforced shank, 2-3 thread chamfer, 35° right spiral flute, vaporised

						◇	Art.-No.
UNF No. 2	64	1,85	45	5	2,8	2,1	01716020
UNF No. 3	56	2,1	50	5	2,8	2,1	01716030
UNF No. 4	48	2,4	56	5	3,5	2,4	01716040
UNF No. 5	44	2,7	56	5	3,5	2,7	01716050
UNF No. 6	40	3,0	56	6	4,0	3,0	01716060
UNF No. 8	36	3,5	63	8	4,5	3,4	01716080
UNF No. 10	32	4,1	70	8	6,0	4,9	01716100
UNF No. 12	28	4,65	80	9	6,0	4,9	01716120
UNF 1/4	28	5,5	80	10	7,0	5,5	01716130
UNF 5/16	24	6,9	90	12	8,0	6,2	01716140
UNF 3/8	24	8,5	100	12	9,0	7,0	01716150
UNF 7/16	20	9,9	100	22	8,0	6,2	01716160
UNF 1/2	20	11,5	100	22	9,0	7,0	01716170
UNF 9/16	18	13,0	100	22	11,0	9,0	01716180
UNF 5/8	18	14,5	100	22	12,0	9,0	01716190
UNF 3/4	16	17,5	110	25	14,0	11,0	01716210
UNF 7/8	14	20,5	125	25	18,0	14,5	01716230
UNF 1	12	23,3	140	28	18,0	14,5	01716250
UNF 1.1/8	12	26,5	150	28	22,0	18,0	01716270
UNF 1.1/4	12	29,5	150	28	22,0	18,0	01716280
UNF 1.3/8	12	32,5	170	30	28,0	22,0	01716290
UNF 1.1/2	12	36,0	170	30	28,0	22,0	01716300

MACHINE TAPS DIN 2184-1

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1	Hole type	Blind hole < 1.1/2×d
Thread	UNF	Direction	Right
Material	HSSE-G	Tolerance	2B
Raw material	Steel	Form	Form C

Machine tap with ≤ 3/8 reinforced shank, 2-3 thread chamfer, straight flute

							Art.-No.
UNF No. 4	48	2,4	56	11	3,5	2,7	01721040
UNF No. 5	44	2,7	56	11	3,5	2,7	01721050
UNF No. 6	40	3,0	56	12	4,0	3,0	01721060
UNF No. 8	36	3,5	63	13	4,5	3,4	01721080
UNF No. 10	32	4,10	70	15	6,0	4,9	01721100
UNF No. 12	28	4,65	80	16	6,0	4,9	01721120
UNF 1/4	28	5,5	80	17	7,0	5,5	01721130
UNF 5/16	24	6,9	90	20	8,0	6,2	01721140
UNF 3/8	24	8,5	100	22	9,0	7,0	01721150
UNF 7/16	20	9,9	100	22	8,0	6,2	01721160
UNF 1/2	20	11,5	100	22	9,0	7,0	01721170
UNF 9/16	18	13,0	100	22	11,0	9,0	01721180
UNF 5/8	18	14,5	100	22	12,0	9,0	01721190
UNF 3/4	16	17,5	110	25	14,0	11,0	01721210
UNF 7/8	14	20,5	125	25	18,0	14,5	01721230
UNF 1	12	23,3	140	28	18,0	14,5	01721250
UNF 1.1/8	12	26,5	150	28	22,0	18,0	01721270
UNF 1.1/4	12	29,5	150	28	22,0	18,0	01721280
UNF 1.3/8	12	32,5	170	30	28,0	22,0	01721290
UNF 1.1/2	12	36,0	170	30	28,0	22,0	01721300

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1	Hole type	Through hole < 1.1/2×d
Thread	UNEF	Direction	Right
Material	HSSE-G	Tolerance	2B
Raw material	Steel	Form	Form B

Machine tap with ≤ 3/8 reinforced shank, 4-5 thread chamfer, straight flute, with spiral point

							Art.-No.
UNEF No. 12	32	4,8	80	16	6,0	4,9	01722120
UNEF 1/4	32	5,7	80	17	7,0	5,5	01722130
UNEF 5/16	32	7,25	90	20	8,0	6,2	01722140
UNEF 3/8	32	8,85	100	22	9,0	7,0	01722150
UNEF 7/16	28	10,35	100	22	8,0	6,2	01722160
UNEF 1/2	28	11,8	100	22	9,0	7,0	01722170
UNEF 9/16	24	13,4	100	22	11,0	9,0	01722180
UNEF 5/8	24	15	100	22	12,0	9,0	01722190
UNEF 3/4	20	18	110	25	14,0	11,0	01722210
UNEF 7/8	20	21,15	125	25	18,0	14,5	01722230
UNEF 1	20	24,3	140	28	18,0	14,5	01722250
UNEF 1.1/8	18	27,35	150	28	22,0	18,0	01722270
UNEF 1.1/4	18	30,55	150	28	22,0	18,0	01722280
UNEF 1.3/8	18	33,7	170	30	28,0	22,0	01722290
UNEF 1.1/2	18	36,9	170	30	28,0	22,0	01722300

MACHINE TAPS DIN 2184-1

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1	Hole type	Blind hole < 2×d
Thread	UNEF	Direction	Right
Material	HSSE-G	Tolerance	2B
Raw material	Steel	Form	Form C / RSP 35°

Machine tap with ≤ 3/8 reinforced shank, 2-3 thread chamfer, 35° right spiral flute

							Art.-No.
UNEF No. 12	32	4,8	80	9	6,0	4,9	01723120
UNEF 1/4	32	5,7	80	10	7,0	5,5	01723130
UNEF 5/16	32	7,25	90	12	8,0	6,2	01723140
UNEF 3/8	32	8,85	100	12	9,0	7,0	01723150
UNEF 7/16	28	10,35	100	22	8,0	6,2	01723160
UNEF 1/2	28	11,8	100	22	9,0	7,0	01723170
UNEF 9/16	24	13,4	100	22	11,0	9,0	01723180
UNEF 5/8	24	15	100	22	12,0	9,0	01723190
UNEF 3/4	20	18	110	25	14,0	11,0	01723210
UNEF 7/8	20	21,15	125	25	18,0	14,5	01723230
UNEF 1	20	24,3	140	28	18,0	14,5	01723250
UNEF 1.1/8	18	27,35	150	28	22,0	18,0	01723270
UNEF 1.1/4	18	30,55	150	28	22,0	18,0	01723280
UNEF 1.3/8	18	33,7	170	30	28,0	22,0	01723290
UNEF 1.1/2	18	36,9	170	30	28,0	22,0	01723300

MACHINE TAPS

Machine tap with overflow shank, 4-5 thread chamfer, straight flute

TECHNICAL INFORMATION

Standard	DIN 2184-1	Hole type	Through hole < 1.1/2×d
Thread	UN / UNS	Direction	Right
Material	HSSE-G	Tolerance	2B
Raw material	Steel	Form	Form B

							Art.-No.
UN 1.1/8	8	25,4	180	50	22,0	18,0	02804110
UN 1.1/4	8	28,6	180	50	25,0	20,0	02804130
UN 1.3/8	8	31,75	180	50	28,0	22,0	02804150
UN 1.1/2	8	34,9	180	50	32,0	24,0	02804160
UN 1.5/8	12	39,2	200	55	32,0	24,0	02804170
UN 1.5/8	8	38,1	200	55	32,0	24,0	02804180
UN 1.3/4	12	42,4	200	55	36,0	29,0	02804190
UN 1.3/4	8	41,3	200	55	36,0	29,0	02804200
UN 1.7/8	12	45,5	220	60	36,0	29,0	02804210
UN 1.7/8	8	44,5	220	60	36,0	29,0	02804220
UN 2	12	48,7	220	60	40,0	32,0	02804230
UN 2	8	47,7	220	60	40,0	32,0	02804240

MACHINE TAPS DIN 2184-1

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1	Hole type	Blind hole < 2×d
Thread	UN / UNS	Direction	Right
Material	HSSE-G	Tolerance	2B
Raw material	Steel	Form	Form C / RSP 35°

Machine tap with overflow shank, 2-3 thread chamfer, 35° right spiral flute

							Art.-No.
UN 1.1/8	8	25,4	180	50	22,0	18,0	02815110
UN 1.1/4	8	28,6	180	50	25,0	20,0	02815130
UN 1.3/8	8	31,75	180	50	28,0	22,0	02815150
UN 1.1/2	8	34,9	180	50	32,0	24,0	02815160
UN 1.5/8	12	39,2	200	55	32,0	24,0	02815170
UN 1.5/8	8	38,1	200	55	32,0	24,0	02815180
UN 1.3/4	12	42,4	200	55	36,0	29,0	02815190
UN 1.3/4	8	41,3	200	55	36,0	29,0	02815200
UN 1.7/8	12	45,5	220	60	36,0	29,0	02815210
UN 1.7/8	8	44,5	220	60	36,0	29,0	02815220
UN 2	12	48,7	220	60	40,0	32,0	02815230
UN 2	8	47,7	220	60	40,0	32,0	02815240

GSR

MACHINE TAPS

Machine tap with overflow shank, 2-3 thread chamfer

TECHNICAL INFORMATION

Standard	DIN 2184-1	Hole type	Blind hole < 1.1/2×d
Thread	UN / UNS	Direction	Right
Material	HSSE-G	Tolerance	2B
Raw material	Steel	Form	Form C

						◇	Art.-No.
UNS 1/4	40	5,7	80	17	7,0	5,5	02821010
UNS 1/4	36	5,65	80	17	7,0	5,5	02821020
UNS 1/4	24	5,3	80	17	7,0	5,5	02821030
UNS 7/16	24	10,1	100	22	8,0	6,2	02821040
UNS 1/2	24	11,65	100	22	9,0	7,0	02821050
UN 9/16	20	13,0	100	22	11,0	9,0	02821060
UN 11/16	20	16,2	110	25	14,0	11,0	02821070
UN 11/16	16	15,9	110	25	14,0	11,0	02821080
UNS 1	14	23,6	150	32	20,0	16,0	02821090
UN 1.1/16	12	24,9	150	32	20,0	16,0	02821100
UN 1.1/8	8	25,4	180	50	22,0	18,0	02821110
UN 1.3/16	12	28,10	180	50	22,0	18,0	02821120
UN 1.1/4	8	28,6	180	50	25,0	20,0	02821130
UN 1.5/16	12	31,3	180	50	25,0	20,0	02821140
UN 1.3/8	8	31,75	180	50	28,0	22,0	02821150
UN 1.1/2	8	34,9	180	50	32,0	24,0	02821160
UN 1.5/8	12	39,2	200	55	32,0	24,0	02821170
UN 1.5/8	8	38,1	200	55	32,0	24,0	02821180
UN 1.3/4	12	42,4	200	55	36,0	29,0	02821190
UN 1.3/4	8	41,3	200	55	36,0	29,0	02821200
UN 1.7/8	12	45,5	220	60	36,0	29,0	02821210
UN 1.7/8	8	44,5	220	60	36,0	29,0	02821220
UN 2	12	48,7	220	60	40,0	32,0	02821230
UN 2	8	47,7	220	60	40,0	32,0	02821240
UN 2.1/4	8	54,0	260	65	45,0	35,0	02821250
UN 2.1/2	8	60,3	260	65	50,0	39,0	02821260
UN 2.3/4	8	66,7	260	65	56,0	44,0	02821270
UN 3	8	73,0	260	65	56,0	44,0	02821280

MACHINE TAPS DIN 2184-1 / 374 / 371

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1	Hole type	Blind hole < 1.1/2.d
Thread	Pg	Direction	Right
Material	HSSE-G	Form	Form C
Raw material	Steel		

Machine tap with overflow shank, 2-3 thread chamfer, straight flute, for steel armoured conduit threads

							Art.-No.
Pg 7	20	11,4	100	22	9,0	7,0	02901010
Pg 9	18	14,0	100	22	12,0	9,0	02901020
Pg 11	18	17,3	110	25	14,0	11,0	02901030
Pg 13,5	18	19,0	125	25	16,0	12,0	02901040
Pg 16	18	21,3	125	25	18,0	14,5	02901050
Pg 21	16	27,0	150	28	22,0	18,0	02901060
Pg 29	16	35,5	170	30	28,0	22,0	02901070
Pg 36	16	45,5	190	32	36,0	29,0	02901080
Pg 42	16	52,5	190	32	40,0	32,0	02901090
Pg 48	16	58,0	220	40	45,0	32,0	02901100

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 374)	Hole type	Blind hole < 1.1/2.d
Thread	Rd	Direction	Right
Material	HSSE-G	Tolerance	7h
Raw material	Steel	Form	Form C

Machine tap with overflow shank, 2-3 thread chamfer, straight flute, round thread DIN 405

							Art.-No.
Rd 8	10	5,7	90	26	6	4,9	02951010
Rd 9	10	6,7	90	26	9,0	5,5	02951020
Rd 10	10	7,7	100	26	7	5,5	02951030
Rd 12	10	9,7	110	26	9	7	02951040
Rd 14	8	11,2	110	32	11	9	02951050
Rd 16	8	13,2	110	32	12	9,0	02951060
Rd 18	8	15,2	125	34	14	11	02951070
Rd 20	8	17,2	140	34	16	12	02951080
Rd 22	8	19,2	140	34	18	14,5	02951090
Rd 24	8	21,2	160	38	18,0	14,5	02951100
Rd 26	8	23,2	160	38	18	14,5	02951110
Rd 28	8	25,2	160	38	20	16	02951120
Rd 30	8	27,2	180	45	22,0	18	02951130
Rd 32	8	29,2	180	45	25,0	20,0	02951140
Rd 34	8	31,2	200	56	28,0	22,0	02951150
Rd 36	8	33,2	200	56	28,0	22,0	02951160

MACHINE TAPS LH

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 371)	Hole type	Through hole <1.1/2×d
Thread	M	Direction	Left
Material	HSSE-G	Tolerance	6H
Raw material	Steel	Form	Form B

Machine tap with reinforced shank, 4-5 thread chamfer, with spiral point

							Art.-No.
M 3	0,5	2,5	56	11	3,5	2,7	02107130
M 4	0,7	3,3	63	13	4,5	3,4	02107150
M 5	0,8	4,2	70	16	6,0	4,9	02107170
M 6	1,0	5,0	80	19	6,0	4,9	02107190
M 8	1,25	6,8	90	22	8,0	6,2	02107210
M 10	1,5	8,5	100	24	10,0	8,0	02107230

MACHINE TAPS DIN 376 / 371

MACHINE TAPS LH

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 376)	Hole type	Through hole < 1.1/2×d
Thread	M	Direction	Left
Material	HSSE-G	Tolerance	6H
Raw material	Steel	Form	Form B

Machine tap with overflow shank, 4-5 thread chamfer, with spiral point

						◇	Art.-No.
M 3	0,5	2,5	56	11	2,2	—	02108130
M 4	0,7	3,3	63	13	2,8	2,1	02108150
M 5	0,8	4,2	70	16	3,5	2,7	02108170
M 6	1,0	5,0	80	19	4,5	3,4	02108190
M 8	1,25	6,8	90	22	6,0	4,9	02108210
M 10	1,5	8,5	100	24	7,0	5,5	02108230
M 12	1,75	10,2	110	28	9,0	7,0	02108250
M 14	2,0	12,0	110	30	11,0	9,0	02108260
M 16	2,0	14,0	110	32	12,0	9,0	02108270
M 18	2,5	15,5	125	34	14,0	11,0	02108280
M 20	2,5	17,5	140	34	16,0	12,0	02108290
M 22	2,5	19,5	140	34	18,0	14,5	02108300
M 24	3,0	21,0	160	38	18,0	14,5	02108310
M 27	3,0	24,0	160	38	20,0	16,0	02108320
M 30	3,5	26,5	180	45	22,0	18,0	02108330
M 33	3,5	29,5	180	50	25,0	20,0	02108340
M 36	4,0	32,0	200	56	28,0	22,0	02108350
M 39	4,0	35,0	200	60	32,0	24,0	02108360
M 42	4,5	37,5	200	60	32,0	24,0	02108370
M 45	4,5	40,5	220	65	36,0	29,0	02108380
M 48	5,0	43,0	250	70	36,0	29,0	02108390
M 52	5,0	47,0	250	70	40,0	32,0	02108400

MACHINE TAPS LH

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 371)	Hole type	Through/blind hole
Thread	M	Direction	Left
Material	HSSE-G	Tolerance	6H
Raw material	Steel	Form	Form C

Machine tap with reinforced shank, 2-3 thread chamfer, straight flute

						◇	Art.-No.
M 3	0,5	2,5	56	11	3,5	2,7	01028130
M 4	0,7	3,3	63	13	4,5	3,4	01028150
M 5	0,8	4,2	70	16	6,0	4,9	01028170
M 6	1,0	5,0	80	19	6,0	4,9	01028190
M 8	1,25	6,8	90	22	8,0	6,2	01028210
M 10	1,5	8,5	100	24	10,0	8,0	01028230

MACHINE TAPS LH

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 376)	Hole type	Through/blind hole
Thread	M	Direction	Left
Material	HSSE-G	Tolerance	6H
Raw material	Steel	Form	Form C

Machine tap with overflow shank, 2-3 thread chamfer, straight flute

						◇	Art.-No.
M 3	0,5	2,5	56	11	2,2	—	02028130
M 4	0,7	3,3	63	13	2,8	2,1	02028150
M 5	0,8	4,2	70	16	3,5	2,7	02028170
M 6	1,0	5,0	80	19	4,5	3,4	02028190
M 8	1,25	6,8	90	22	6,0	4,9	02028210
M 10	1,5	8,5	100	24	7,0	5,5	02028230
M 12	1,75	10,2	110	28	9,0	7,0	02028250
M 14	2,0	12,0	110	30	11,0	9,0	02028260
M 16	2,0	14,0	110	32	12,0	9,0	02028270
M 18	2,5	15,5	125	34	14,0	11,0	02028280
M 20	2,5	17,5	140	34	16,0	12,0	02028290
M 22	2,5	19,5	140	34	18,0	14,5	02028300
M 24	3,0	21,0	160	38	18,0	14,5	02028310
M 27	3,0	24,0	160	38	20,0	16,0	02028320
M 30	3,5	26,5	180	45	22,0	18,0	02028330
M 33	3,5	29,5	180	50	25,0	20,0	02028340

MACHINE TAPS DIN 376 / 374

							Art.-No.
M 36	4,0	32,0	200	56	28,0	22,0	02028350
M 39	4,0	35,0	200	60	32,0	24,0	02028360
M 42	4,5	37,5	200	60	32,0	24,0	02028370
M 45	4,5	40,5	220	65	36,0	29,0	02028380
M 48	5,0	43,0	250	70	36,0	29,0	02028390
M 52	5,0	47,0	250	70	40,0	32,0	02028400

MACHINE TAPS LH

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 374)	Hole type	Through/blind hole
Thread	MF	Direction	Left
Material	HSSE-G	Tolerance	6H
Raw material	Steel	Form	Form C

Machine tap with overflow shank, 2-3 thread chamfer, straight flute

							Art.-No.
MF 3 × 0,35	0,35	2,65	56	8	2,2	1,9	02237000
MF 4 × 0,5	0,5	3,5	61	10	2,8	2,1	02237010
MF 5 × 0,5	0,5	4,5	70	1	3,5	2,7	02237020
MF 5 × 0,75	0,75	4,25	70	11	3,5	2,7	02237030
MF 6 × 0,5	0,5	5,5	80	12	4,5	3,4	02237040
MF 6 × 0,75	0,75	5,25	80	14	4,5	3,4	02237050
MF 7 × 0,75	0,75	6,25	80	14	5,5	4,3	02237060
MF 8 × 0,5	0,5	7,5	80	12	6,0	4,9	02237070
MF 8 × 0,75	0,75	7,25	80	14	6,0	4,9	02237080
MF 8 × 1	1,0	7,0	90	16	6,0	4,9	02237090
MF 9 × 1	1,0	8,0	90	16	7,0	5,5	02237100
MF 10 × 0,5	0,5	9,5	90	14	7,0	5,5	02237110
MF 10 × 0,75	0,75	9,25	90	14	7,0	5,5	02237120
MF 10 × 1	1,0	9,0	100	12	7,0	5,5	02237130
MF 10 × 1,25	1,25	8,75	100	20	7,0	5,5	02237140
MF 11 × 0,75	0,75	10,25	90	16	8,0	6,2	02237150
MF 11 × 1	1,0	10,0	90	16	8,0	6,2	02237160
MF 11 × 1,25	1,25	9,75	90	16	8,0	6,2	02237170
MF 12 × 0,5	0,5	11,5	100	18	9,0	7,0	02237180
MF 12 × 0,75	0,75	11,25	100	18	9,0	7,0	02237190
MF 12 × 1	1,0	11,0	100	22	9,0	7,0	02237200
MF 12 × 1,25	1,25	10,75	100	22	9,0	7,0	02237210
MF 12 × 1,5	1,5	10,5	100	14	9,0	7,0	02237220
MF 13 × 0,5	0,5	12,5	100	18	11,0	9,0	02237230

GSR

						◇	Art.-No.
MF 13 × 0,75	0,75	12,25	100	18	11,0	9,0	02237240
MF 13 × 1	1,0	12,0	100	22	11,0	9,0	02237250
MF 13 × 1,25	1,25	11,75	100	18	11,0	9,0	02237260
MF 13 × 1,5	1,5	11,5	100	22	11,0	9,0	02237270
MF 14 × 0,5	0,5	13,5	100	18	11,0	9,0	02237280
MF 14 × 0,75	0,75	13,25	100	22	11,0	9,0	02237290
MF 14 × 1	1,0	13,0	100	22	11,0	9,0	02237300
MF 14 × 1,25	1,25	12,75	100	22	11,0	9,0	02237310
MF 14 × 1,5	1,5	12,5	100	18	11,0	9,0	02237320
MF 15 × 0,5	0,5	14,5	100	18	12,0	9,0	02237330
MF 15 × 0,75	0,75	14,25	100	18	12,0	9,0	02237340
MF 15 × 1	1,0	14,0	100	22	12,0	9,0	02237350
MF 15 × 1,25	1,25	13,8	100	22	12,0	9,0	02237360
MF 15 × 1,5	1,5	13,5	100	22	12,0	9,0	02237370
MF 16 × 0,5	0,5	15,5	100	18	12,0	9,0	02237380
MF 16 × 0,75	0,75	15,25	100	18	12,0	9,0	02237390
MF 16 × 1	1,0	15,0	100	22	12,0	9,0	02237400
MF 16 × 1,25	1,25	14,75	100	22	12,0	9,0	02237410
MF 16 × 1,5	1,5	14,5	100	18	12,0	9,0	02237420
MF 17 × 0,75	0,75	16,25	100	18	12,0	9,0	02237430
MF 17 × 1	1,0	16,0	100	18	12,0	9,0	02237440
MF 17 × 1,5	1,5	15,5	100	22	12,0	9,0	02237450
MF 18 × 0,75	0,75	17,25	110	20	14,0	11,0	02237460
MF 18 × 1	1,0	17,0	110	25	14,0	11,0	02237470
MF 18 × 1,25	1,25	16,75	110	25	14,0	11,0	02237480
MF 18 × 1,5	1,5	16,5	110	22	14,0	11,0	02237490
MF 18 × 2	2,0	16,0	125	28	14,0	11,0	02237500
MF 20 × 0,75	0,75	19,25	125	20	16,0	12,0	02237510
MF 20 × 1	1,0	19,0	125	25	16,0	12,0	02237520
MF 20 × 1,25	1,25	18,75	125	25	16,0	12,0	02237530
MF 20 × 1,5	1,5	18,5	125	25	16,0	12,0	02237540
MF 20 × 2	2,0	18,0	140	28	16,0	12,0	02237550
MF 21 × 1	1,0	20,0	125	20	16,0	12,0	02237560
MF 21 × 1,5	1,5	19,5	125	25	16,0	12,0	02237570
MF 22 × 0,75	0,75	21,25	125	20	18,0	14,5	02237580
MF 22 × 1	1,0	21,0	125	25	18,0	14,5	02237590
MF 22 × 1,25	1,25	20,75	125	25	18,0	14,5	02237600
MF 22 × 1,5	1,5	20,5	125	25	18,0	14,5	02237610
MF 22 × 2	2,0	20,0	140	28	18,0	14,5	02237620
MF 23 × 1	1,0	22,0	125	20	18,0	14,5	02237630
MF 23 × 1,5	1,5	21,5	125	20	18,0	14,5	02237640
MF 24 × 0,75	0,75	23,25	125	20	18,0	14,5	02237650
MF 24 × 1	1,0	23,0	125	20	18,0	14,5	02237660
MF 24 × 1,25	1,25	22,75	125	25	18,0	14,5	02237670

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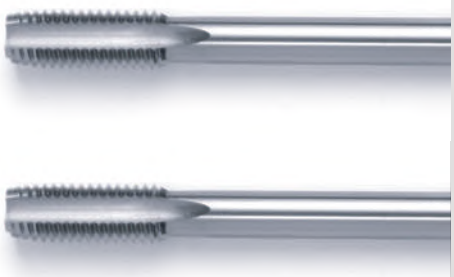
							Art.-No.
MF 24 × 1,5	1,5	22,5	125	25	18,0	14,5	02237680
MF 24 × 2	2,0	22,0	140	28	18,0	14,5	02237690
MF 25 × 1	1,0	24,0	140	25	18,0	14,5	02237700
MF 25 × 1,5	1,5	23,5	140	25	18,0	14,5	02237710
MF 25 × 2	2,0	23,0	140	32	18,0	14,5	02237720
MF 26 × 1	1,0	25,0	140	25	18,0	14,5	02237730
MF 26 × 1,5	1,5	24,5	140	28	18,0	14,5	02237740
MF 26 × 2	2,0	24,0	140	32	18,0	14,5	02237750
MF 27 × 1	1,0	26,0	150	25	20,0	16,0	02237760
MF 27 × 1,5	1,5	25,5	140	28	20,0	16,0	02237770
MF 27 × 2	2,0	25,0	140	28	20,0	16,0	02237780
MF 28 × 1	1,0	27,0	150	25	20,0	16,0	02237790
MF 28 × 1,5	1,5	26,5	150	28	20,0	16,0	02237800
MF 28 × 2	2,0	26,0	140	28	20,0	16,0	02237810
MF 30 × 1	1,0	29,0	150	28	22,0	18,0	02237820
MF 30 × 1,5	1,5	28,5	150	28	22,0	18,0	02237830
MF 30 × 2	2,0	28,0	150	28	22,0	18,0	02237840
MF 30 × 3	3,0	27,0	160	36	22,0	18,0	02237850
MF 32 × 1	1,0	31,0	150	25	22,0	18,0	02237860
MF 32 × 1,5	1,5	30,5	150	28	22,0	18,0	02237870
MF 32 × 2	2,0	30,0	160	32	22,0	18,0	02237880
MF 32 × 3	3,0	29,0	160	36	22,0	18,0	02237890
MF 33 × 1	1,0	32,0	150	25	25,0	20,0	02237900
MF 33 × 1,5	1,5	31,5	160	28	25,0	20,0	02237910
MF 33 × 2	2,0	31,0	160	28	25,0	20,0	02237920
MF 33 × 3	3,0	30,0	160	36	25,0	20,0	02237930
MF 34 × 1	1,0	33,0	150	25	28,0	22,0	02237940
MF 34 × 1,5	1,5	32,5	170	28	28,0	22,0	02237950
MF 34 × 2	2,0	32,0	160	32	28,0	22,0	02237960
MF 34 × 3	3,0	31,0	160	36	28,0	22,0	02237970
MF 35 × 1	1,0	34,0	150	25	28,0	22,0	02237980
MF 35 × 1,5	1,5	33,5	170	28	28,0	22,0	02237990
MF 35 × 2	2,0	33,0	160	32	28,0	22,0	02238000
MF 35 × 3	3,0	32,0	160	36	28,0	22,0	02238010
MF 36 × 1	1,0	35,0	170	28	28,0	22,0	02238020
MF 36 × 1,5	1,5	34,5	170	28	28,0	22,0	02238030
MF 36 × 2	2,0	34,0	170	28	28,0	22,0	02238040
MF 36 × 3	3,0	33,0	200	36	28,0	22,0	02238050
MF 38 × 1	1,0	37,0	170	28	28,0	22,0	02238060
MF 38 × 1,5	1,5	36,5	170	28	28,0	22,0	02238070
MF 38 × 2	2,0	36,0	180	32	28,0	22,0	02238080
MF 38 × 3	3,0	35,0	190	36	28,0	22,0	02238090
MF 39 × 1,5	1,5	37,5	170	28	32,0	24,0	02238100
MF 39 × 2	2,0	37,0	170	28	32,0	24,0	02238110

						◇	Art.-No.
MF 39 × 3	3,0	36,0	200	36	32,0	24,0	02238120
MF 40 × 1,5	1,5	38,5	170	28	32,0	24,0	02238130
MF 40 × 2	2,0	38,0	170	28	32,0	24,0	02238140
MF 40 × 3	3,0	37,0	200	36	32,0	24,0	02238150
MF 42 × 1,5	1,5	40,5	180	32	32,0	24,0	02238160
MF 42 × 2	2,0	40,0	180	32	32,0	24,0	02238170
MF 42 × 3	3,0	39,0	200	36	32,0	24,0	02238180
MF 42 × 4	4,0	38,0	225	52	32,0	24,0	02238190
MF 45 × 1,5	1,5	43,5	180	32	36,0	29,0	02238200
MF 45 × 2	2,0	43,0	180	32	36,0	29,0	02238210
MF 45 × 3	3,0	42,0	200	36	36,0	29,0	02238220
MF 45 × 4	4,0	41,0	225	52	36,0	29,0	02238230
MF 48 × 1,5	1,5	46,5	190	32	36,0	29,0	02238240
MF 48 × 2	2,0	46,0	190	32	36,0	29,0	02238250
MF 48 × 3	3,0	45,0	225	36	36,0	29,0	02238260
MF 48 × 4	4,0	44,0	225	64	36,0	29,0	02238270
MF 50 × 1,5	1,5	48,5	190	32	36,0	29,0	02238280
MF 50 × 2	2,0	48,0	190	32	36,0	29,0	02238290
MF 50 × 3	3,0	47,0	225	36	36,0	29,0	02238300
MF 50 × 4	4,0	46,0	225	64	36,0	29,0	02238310
MF 52 × 1,5	1,5	50,5	190	32	40,0	32,0	02238320
MF 52 × 2	2,0	50,0	190	32	40,0	32,0	02238330
MF 52 × 3	3,0	49,0	225	40	40,0	32,0	02238340
MF 52 × 4	4,0	48,0	225	64	36,0	29,0	02238350



MACHINE TAPS DIN 374

MACHINE TAPS LH

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 374)	Hole type	Blind hole < 2 x d
Thread	MF	Direction	Left
Material	HSSE-G	Tolerance	6H
Raw material	Steel	Form	Form C / LSP 35°

Machine tap with overflow shank, 2-3 thread chamfer, 35° left spiral flute

						◇	Art.-No.
MF 3 × 0,35	0,35	2,65	56	8	2,2	1,9	02239000
MF 4 × 0,5	0,5	3,5	61	10	2,8	2,1	02239010
MF 5 × 0,5	0,5	4,5	70	1	3,5	2,7	02239020
MF 5 × 0,75	0,75	4,25	70	11	3,5	2,7	02239030
MF 6 × 0,5	0,5	5,5	80	12	4,5	3,4	02239040
MF 6 × 0,75	0,75	5,25	80	14	4,5	3,4	02239050
MF 7 × 0,75	0,75	6,25	80	14	5,5	4,3	02239060
MF 8 × 0,5	0,5	7,5	80	12	6,0	4,9	02239070
MF 8 × 0,75	0,75	7,25	80	14	6,0	4,9	02239080
MF 8 × 1	1,0	7,0	90	16	6,0	4,9	02239090
MF 9 × 1	1,0	8,0	90	16	7,0	5,5	02239100
MF 10 × 0,5	0,5	9,5	90	14	7,0	5,5	02239110
MF 10 × 0,75	0,75	9,25	90	14	7,0	5,5	02239120
MF 10 × 1	1,0	9,0	100	12	7,0	5,5	02239130
MF 10 × 1,25	1,25	8,75	100	20	7,0	5,5	02239140
MF 11 × 0,75	0,75	10,25	90	16	8,0	6,2	02239150
MF 11 × 1	1,0	10,0	90	16	8,0	6,2	02239160
MF 11 × 1,25	1,25	9,75	90	16	8,0	6,2	02239170
MF 12 × 0,5	0,5	11,5	100	18	9,0	7,0	02239180
MF 12 × 0,75	0,75	11,25	100	18	9,0	7,0	02239190
MF 12 × 1	1,0	11,0	100	22	9,0	7,0	02239200
MF 12 × 1,25	1,25	10,75	100	22	9,0	7,0	02239210
MF 12 × 1,5	1,5	10,5	100	14	9,0	7,0	02239220
MF 13 × 0,5	0,5	12,5	100	18	11,0	9,0	02239230
MF 13 × 0,75	0,75	12,25	100	18	11,0	9,0	02239240
MF 13 × 1	1,0	12,0	100	22	11,0	9,0	02239250
MF 13 × 1,25	1,25	11,75	100	18	11,0	9,0	02239260
MF 13 × 1,5	1,5	11,5	100	22	11,0	9,0	02239270
MF 14 × 0,5	0,5	13,5	100	18	11,0	9,0	02239280
MF 14 × 0,75	0,75	13,25	100	22	11,0	9,0	02239290
MF 14 × 1	1,0	13,0	100	22	11,0	9,0	02239300
MF 14 × 1,25	1,25	12,75	100	22	11,0	9,0	02239310
MF 14 × 1,5	1,5	12,5	100	18	11,0	9,0	02239320
MF 15 × 0,5	0,5	14,5	100	18	12,0	9,0	02239330
MF 15 × 0,75	0,75	14,25	100	18	12,0	9,0	02239340
MF 15 × 1	1,0	14,0	100	22	12,0	9,0	02239350

GSR

						◇	Art.-No.
MF 15 × 1,25	1,25	13,8	100	22	12,0	9,0	02239360
MF 15 × 1,5	1,5	13,5	100	22	12,0	9,0	02239370
MF 16 × 0,5	0,5	15,5	100	18	12,0	9,0	02239380
MF 16 × 0,75	0,75	15,25	100	18	12,0	9,0	02239390
MF 16 × 1	1,0	15,0	100	22	12,0	9,0	02239400
MF 16 × 1,25	1,25	14,75	100	22	12,0	9,0	02239410
MF 16 × 1,5	1,5	14,5	100	18	12,0	9,0	02239420
MF 17 × 0,75	0,75	16,25	100	18	12,0	9,0	02239430
MF 17 × 1	1,0	16,0	100	18	12,0	9,0	02239440
MF 17 × 1,5	1,5	15,5	100	22	12,0	9,0	02239450
MF 18 × 0,75	0,75	17,25	110	20	14,0	11,0	02239460
MF 18 × 1	1,0	17,0	110	25	14,0	11,0	02239470
MF 18 × 1,25	1,25	16,75	110	25	14,0	11,0	02239480
MF 18 × 1,5	1,5	16,5	110	22	14,0	11,0	02239490
MF 18 × 2	2,0	16,0	125	28	14,0	11,0	02239500
MF 20 × 0,75	0,75	19,25	125	20	16,0	12,0	02239510
MF 20 × 1	1,0	19,0	125	25	16,0	12,0	02239520
MF 20 × 1,25	1,25	18,75	125	25	16,0	12,0	02239530
MF 20 × 1,5	1,5	18,5	125	25	16,0	12,0	02239540
MF 20 × 2	2,0	18,0	140	28	16,0	12,0	02239550
MF 21 × 1	1,0	20,0	125	20	16,0	12,0	02239560
MF 21 × 1,5	1,5	19,5	125	25	16,0	12,0	02239570
MF 22 × 0,75	0,75	21,25	125	20	18,0	14,5	02239580
MF 22 × 1	1,0	21,0	125	25	18,0	14,5	02239590
MF 22 × 1,25	1,25	20,75	125	25	18,0	14,5	02239600
MF 22 × 1,5	1,5	20,5	125	25	18,0	14,5	02239610
MF 22 × 2	2,0	20,0	140	28	18,0	14,5	02239620
MF 23 × 1	1,0	22,0	125	20	18,0	14,5	02239630
MF 23 × 1,5	1,5	21,5	125	20	18,0	14,5	02239640
MF 24 × 0,75	0,75	23,25	125	20	18,0	14,5	02239650
MF 24 × 1	1,0	23,0	125	20	18,0	14,5	02239660
MF 24 × 1,25	1,25	22,75	125	25	18,0	14,5	02239670
MF 24 × 1,5	1,5	22,5	125	25	18,0	14,5	02239680
MF 24 × 2	2,0	22,0	140	28	18,0	14,5	02239690
MF 25 × 1	1,0	24,0	140	25	18,0	14,5	02239700
MF 25 × 1,5	1,5	23,5	140	25	18,0	14,5	02239710
MF 25 × 2	2,0	23,0	140	32	18,0	14,5	02239720
MF 26 × 1	1,0	25,0	140	25	18,0	14,5	02239730
MF 26 × 1,5	1,5	24,5	140	28	18,0	14,5	02239740
MF 26 × 2	2,0	24,0	140	32	18,0	14,5	02239750
MF 27 × 1	1,0	26,0	150	25	20,0	16,0	02239760
MF 27 × 1,5	1,5	25,5	140	28	20,0	16,0	02239770
MF 27 × 2	2,0	25,0	140	28	20,0	16,0	02239780
MF 28 × 1	1,0	27,0	150	25	20,0	16,0	02239790

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							Art.-No.
MF 28 × 1,5	1,5	26,5	150	28	20,0	16,0	02239800
MF 28 × 2	2,0	26,0	140	28	20,0	16,0	02239810
MF 30 × 1	1,0	29,0	150	28	22,0	18,0	02239820
MF 30 × 1,5	1,5	28,5	150	28	22,0	18,0	02239830
MF 30 × 2	2,0	28,0	150	28	22,0	18,0	02239840
MF 30 × 3	3,0	27,0	160	36	22,0	18,0	02239850
MF 32 × 1	1,0	31,0	150	25	22,0	18,0	02239860
MF 32 × 1,5	1,5	30,5	150	28	22,0	18,0	02239870
MF 32 × 2	2,0	30,0	160	32	22,0	18,0	02239880
MF 32 × 3	3,0	29,0	160	36	22,0	18,0	02239890
MF 33 × 1	1,0	32,0	150	25	25,0	20,0	02239900
MF 33 × 1,5	1,5	31,5	160	28	25,0	20,0	02239910
MF 33 × 2	2,0	31,0	160	28	25,0	20,0	02239920
MF 33 × 3	3,0	30,0	160	36	25,0	20,0	02239930
MF 34 × 1	1,0	33,0	150	25	28,0	22,0	02239940
MF 34 × 1,5	1,5	32,5	170	28	28,0	22,0	02239950
MF 34 × 2	2,0	32,0	160	32	28,0	22,0	02239960
MF 34 × 3	3,0	31,0	160	36	28,0	22,0	02239970
MF 35 × 1	1,0	34,0	150	25	28,0	22,0	02239980
MF 35 × 1,5	1,5	33,5	170	28	28,0	22,0	02239990
MF 35 × 2	2,0	33,0	160	32	28,0	22,0	02240000
MF 35 × 3	3,0	32,0	160	36	28,0	22,0	02240010
MF 36 × 1	1,0	35,0	170	28	28,0	22,0	02240020
MF 36 × 1,5	1,5	34,5	170	28	28,0	22,0	02240030
MF 36 × 2	2,0	34,0	170	28	28,0	22,0	02240040
MF 36 × 3	3,0	33,0	200	36	28,0	22,0	02240050
MF 38 × 1	1,0	37,0	170	28	28,0	22,0	02240060
MF 38 × 1,5	1,5	36,5	170	28	28,0	22,0	02240070
MF 38 × 2	2,0	36,0	180	32	28,0	22,0	02240080
MF 38 × 3	3,0	35,0	190	36	28,0	22,0	02240090
MF 39 × 1,5	1,5	37,5	170	28	32,0	24,0	02240100
MF 39 × 2	2,0	37,0	170	28	32,0	24,0	02240110
MF 39 × 3	3,0	36,0	200	36	32,0	24,0	02240120
MF 40 × 1,5	1,5	38,5	170	28	32,0	24,0	02240130
MF 40 × 2	2,0	38,0	170	28	32,0	24,0	02240140
MF 40 × 3	3,0	37,0	200	36	32,0	24,0	02240150
MF 42 × 1,5	1,5	40,5	180	32	32,0	24,0	02240160
MF 42 × 2	2,0	40,0	180	32	32,0	24,0	02240170
MF 42 × 3	3,0	39,0	200	36	32,0	24,0	02240180
MF 42 × 4	4,0	38,0	225	52	32,0	24,0	02240190
MF 45 × 1,5	1,5	43,5	180	32	36,0	29,0	02240200
MF 45 × 2	2,0	43,0	180	32	36,0	29,0	02240210
MF 45 × 3	3,0	42,0	200	36	36,0	29,0	02240220
MF 45 × 4	4,0	41,0	225	52	36,0	29,0	02240230

							Art.-No.
MF 48 × 1,5	1,5	46,5	190	32	36,0	29,0	02240240
MF 48 × 2	2,0	46,0	190	32	36,0	29,0	02240250
MF 48 × 3	3,0	45,0	225	36	36,0	29,0	02240260
MF 48 × 4	4,0	44,0	225	64	36,0	29,0	02240270
MF 50 × 1,5	1,5	48,5	190	32	36,0	29,0	02240280
MF 50 × 2	2,0	48,0	190	32	36,0	29,0	02240290
MF 50 × 3	3,0	47,0	225	36	36,0	29,0	02240300
MF 50 × 4	4,0	46,0	225	64	36,0	29,0	02240310
MF 52 × 1,5	1,5	50,5	190	32	40,0	32,0	02240320
MF 52 × 2	2,0	50,0	190	32	40,0	32,0	02240330
MF 52 × 3	3,0	49,0	225	40	40,0	32,0	02240340
MF 52 × 4	4,0	48,0	225	64	36,0	29,0	02240350

MACHINE TAPS LH

Machine tap with overflow shank, 2-3 thread chamfer, straight flute

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 5156)	Hole type	Through/blind hole
Thread	BSP	Direction	Left
Material	HSSE-G	Form	Form C
Raw material	Steel		

							Art.-No.
BSP 1/8	28	8,8	90	20	7,0	5,5	02522020
BSP 1/4	19	11,8	100	22	11,0	9,0	02522060
BSP 3/8	19	15,3	100	22	12,0	9,0	02522080
BSP 1/2	14	19,0	125	25	16,0	12,0	02522100
BSP 5/8	14	21,0	125	25	18,0	14,5	02522120
BSP 3/4	14	24,5	140	28	20,0	16,0	02522130
BSP 7/8	14	28,3	150	28	22,0	18,0	02522140
BSP 1	11	30,5	160	30	25,0	20,0	02522150

		BLUE RING							
	DIN standard	371 / 376	371 / 376	371 / 376	371 / 376	371 / 376	371 / 376	371 / 376	371 / 376
	Coating		TiN	VAP	PM-TiAlN		TiN	VAP	PM-TiAlN
	Thread type	M	M	M	M	M	M	M	M
	Form	B	B	B	B	C/RSP 35°	C/RSP 35°	C/RSP 35°	C/RSP 35°
	Hole type	Through hole	Through hole	Through hole	Through hole	Blind hole	Blind hole	Blind hole	Blind hole
1 Q & T steels and tool steels up to 1100 N/mm²	1.1 Case hardening and nitriding steels	★	★★	★	★★	★★	★★	★	★★
	1.2 Q & T steels								★
	1.3 Tool steels				★		★★		★★
2 Stainless steels and heat-resistant steels	2.1 strength of 450-800 N/mm²	★★	★★	★	★★	★★	★★	★	★★
	2.2 strength of 600-1000 N/mm²	★★	★★	★	★★	★★	★★	★	★★
3 Cast materials	3.1 Grey cast iron								
	3.2 Ductile iron and malleable cast iron	★				★	★★		
4 Pure aluminium									
5 Aluminium alloy with Si content > 10%									
6 Pure copper		★	★★		★★	★	★★		★★
7 Copper alloy, long chipping		★	★★		★★	★	★★		★★

		RED RING				YELLOW RING		WHITE RING	
	DIN standard	371 / 376	371 / 376	371 / 376	371 / 376	371 / 376	371 / 376	371 / 376	371 / 376
	Coating		TiCN		TiCN				TiCN
	Thread type	M	M	M	M	M	M	M	M
	Form	B	B	C/RSP 40°	C/RSP 40°	B	C/RSP 45°	C / E	C / E
	Hole type	Through hole	Through hole	Blind hole	Blind hole	Through hole	Blind hole	Through/ blind hole	Through/ blind hole
1 Q & T steels and tool steels up to 1100 N/mm²	1.1 Case hardening nitriding steels	★★	★★	★	★				
	1.2 Q & T steels	★	★★	★	★★				
	1.3 Tool steels	★	★★	★	★				
2 Stainless steels and heat-resistant steels	2.1 strength of 450-800 N/mm²								
	2.2 strength of 600-1000 N/mm²								
3 Cast materials	3.1 Grey cast iron							★	★★
	3.2 Ductile iron malleable cast iron	★	★	★	★				
4 Pure aluminium						★★	★★		
5 Aluminium alloy with Si content > 10%		★	★★	★★	★★			★	★
6 Pure copper									
7 Copper alloy, long-chipping									

★★ very suitable
★ suitable
red ring 1100 N/mm²
blue ring INOX
yellow ring ALU
white ring Grey cast iron

Forms:
B 3.5 – 6 thread with spiral point
C 2 – 3 thread
C/RSP 2 – 3 thread right spiral
E 1 – 1.5 thread

The chip angle determines the material's chip removal and thus the cutting performance of the tap. It therefore has to be adapted to the mechanical properties of the processed material. For this reason, the individual raw materials are combined into material groups according to identical or similar mechanical properties.

COLOUR RING MACHINE TAPS

DIN 371 / 376

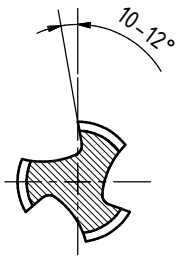
For a better assignment of the taps to a material group, the high performance machine taps are labelled with a colour ring. Each ring corresponds to a material group. We decided for the adjacent classification.

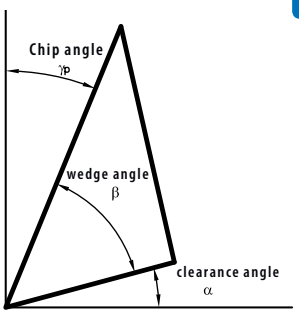
MATERIAL GROUPS

RAW MATERIAL TYPE	TENSILE STRENGTH	ABBREV.	ID	CHIP ANGLE
Stainless steels	700 – 1100	VA	Blue	8 – 10
Q&T steels	600 – 1200	VG	Red	10 – 12
Alu long chipping	100 – 600	Alu	Yellow	20 – 25
Grey cast iron	800 – 900	GG	White	3 – 5

Well-chipping steels with a tensile strength of 400-900 N/mm² can be processed with machine taps of our standard assortment. Special adjustments of the cutting geometry for special raw material properties or special working conditions are possible in individual cases.

CHIP ANGLE





MACHINE TAPS DIN 371 / 376

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 371)	Hole type	Through hole (L>1,5×d1)
Thread	M	Direction	Right
Material	HSS-E	Tolerance	6H
		Form	Form B

Blue ring INOX / machine tap with reinforced shank / 3,5-6 thread chamfer

						◇	Art.-No.
M 3	0,5	2,5	56	9	3,5	2,7	01029130
M 3,5	0,6	2,9	56	11	4	3	01029140
M 4	0,7	3,3	63	12	4,5	3,4	01029150
M 5	0,8	4,2	70	16	6,0	4,9	01029170
M 6	1,0	5,0	80	15	6,0	4,9	01029190
M 8	1,25	6,8	90	18	8,0	6,2	01029210
M 10	1,5	8,5	100	20	10,0	8,0	01029230

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 376)	Hole type	Through hole (L>1,5×d1)
Thread	M	Direction	Right
Material	HSS-E	Tolerance	6H
		Form	Form B

Blue ring INOX / machine tap with overflow shank / 3,5-6 thread chamfer

						◇	Art.-No.
M 12	1,75	10,2	110	23	9	7	01030250
M 14	2,0	12,0	110	25	11	9	01030260
M 16	2,0	14,0	110	25	12	9	01030270
M 18	2,5	15,5	125	30	14	11	01030280
M 20	2,5	17,5	140	30	16	12	01030290
M 22	2,5	19,5	140	30	18	14,5	01030300
M 24	3,0	21,0	160	36	18	14,5	01030310
M 27	3,0	24,0	160	36	20	16	01030320
M 30	3,5	26,5	180	40	22	18	01030330
M 33	3,5	29,5	180	42	25	20	01030340
M 36	4,0	32,0	200	50	28	22	01030350

BLUE RING

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 371)	Hole type	Through hole (L>1,5×d1)
Thread	M	Direction	Right
Material	HSS-E TiN	Tolerance	6H
		Form	Form B

Blue ring INOX / machine tap with reinforced shank / 3,5-6 thread chamfer

						◇	Art.-No.
M 3	0,5	2,5	56	9	3,5	2,7	01031130
M 3,5	0,6	2,9	56	11	4	3	01031140
M 4	0,7	3,3	63	12	4,5	3,4	01031150
M 5	0,8	4,2	70	16	6,0	4,9	01031170
M 6	1,0	5,0	80	15	6,0	4,9	01031190
M 8	1,25	6,8	90	18	8,0	6,2	01031210
M 10	1,5	8,5	100	20	10,0	8,0	01031230

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 376)	Hole type	Through hole (L>1,5×d1)
Thread	M	Direction	Right
Material	HSS-E TiN	Tolerance	6H
		Form	Form B

Blue ring INOX / machine tap with overflow shank / 3,5-6 thread chamfer

						◇	Art.-No.
M 12	1,75	10,2	110	23	9	7	01032250
M 14	2,0	12,0	110	25	11	9	01032260
M 16	2,0	14,0	110	25	12	9	01032270
M 18	2,5	15,5	125	30	14	11	01032280
M 20	2,5	17,5	140	30	16	12	01032290
M 22	2,5	19,5	140	30	18	14,5	01032300
M 24	3,0	21,0	160	36	18	14,5	01032310
M 27	3,0	24,0	160	36	20	16	01032320
M 30	3,5	26,5	180	40	22	18	01032330
M 33	3,5	29,5	180	42	25	20	01032340
M 36	4,0	32,0	200	50	28	22	01032350

MACHINE TAPS DIN 371 / 376

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 371)	Hole type	Through hole (L>1,5×d1)
Thread	M	Direction	Right
Material	HSS-E VAP	Tolerance	6H
		Form	Form B

Blue ring INOX / machine tap with reinforced shank / 3,5-6 thread chamfer

						◇	Art.-No.
M 3	0,5	2,5	56	9	3,5	2,7	01033130
M 3,5	0,6	2,9	56	11	4	3	01033140
M 4	0,7	3,3	63	12	4,5	3,4	01033150
M 5	0,8	4,2	70	16	6,0	4,9	01033170
M 6	1,0	5,0	80	15	6,0	4,9	01033190
M 8	1,25	6,8	90	18	8,0	6,2	01033210
M 10	1,5	8,5	100	20	10,0	8,0	01033230

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 376)	Hole type	Through hole (L>1,5×d1)
Thread	M	Direction	Right
Material	HSS-E VAP	Tolerance	6H
		Form	Form B

Blue ring INOX / machine tap with overflow shank / 3,5-6 thread chamfer

						◇	Art.-No.
M 12	1,75	10,2	110	23	9	7	01034250
M 14	2,0	12,0	110	25	11	9	01034260
M 16	2,0	14,0	110	25	12	9	01034270
M 18	2,5	15,5	125	30	14	11	01034280
M 20	2,5	17,5	140	30	16	12	01034290
M 22	2,5	19,5	140	30	18	14,5	01034300
M 24	3,0	21,0	160	36	18	14,5	01034310
M 27	3,0	24,0	160	36	20	16	01034320
M 30	3,5	26,5	180	40	22	18	01034330
M 33	3,5	29,5	180	42	25	20	01034340
M 36	4,0	32,0	200	50	28	22	01034350

BLUE RING

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 371)	Hole type	Through hole (L>1,5×d1)
Thread	M	Direction	Right
Material	HSSE-PM TiAlN	Tolerance	6H
		Form	Form B

Blue ring INOX / machine tap with reinforced shank / 3,5-6 thread chamfer

						◇	Art.-No.
M 3	0,5	2,5	56	9	3,5	2,7	01035130
M 3,5	0,6	2,9	56	11	4	3	01035140
M 4	0,7	3,3	63	12	4,5	3,4	01035150
M 5	0,8	4,2	70	16	6,0	4,9	01035170
M 6	1,0	5,0	80	15	6,0	4,9	01035190
M 8	1,25	6,8	90	18	8,0	6,2	01035210
M 10	1,5	8,5	100	20	10,0	8,0	01035230

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 376)	Hole type	Through hole (L>1,5×d1)
Thread	M	Direction	Right
Material	HSSE-PM TiAlN	Tolerance	6H
		Form	Form B

Blue ring INOX / machine tap with overflow shank / 3,5-6 thread chamfer

						◇	Art.-No.
M 12	1,75	10,2	110	23	9	7,0	01036250

MACHINE TAPS DIN 371 / 376

MACHINE TAPS

Blue ring INOX / machine tap with reinforced shank / 2-3 thread chamfer

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 371)	Hole type	w (L<2d1)
Thread	M	Direction	Right
Material	HSS-E	Tolerance	6H
		Form	Form C/RSP 35°

						◇	Art.-No.
M 3	0,5	2,5	56	5	3,5	2,7	01037130
M 3,5	0,6	2,9	56	6	4	3	01037140
M 4	0,7	3,3	63	7	4,5	3,4	01037150
M 5	0,8	4,2	70	8	6	4,9	01037170
M 6	1,0	5,0	80	10	6	4,9	01037190
M 8	1,25	6,8	90	13	8	6,2	01037210
M 10	1,5	8,5	100	15	10	8	01037230

MACHINE TAPS

Blue ring INOX / machine tap with overflow shank / 2-3 thread chamfer

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 376)	Hole type	Blind hole (L<2d1)
Thread	M	Direction	Right
Material	HSS-E	Tolerance	6H
		Form	Form C/RSP 35°

						◇	Art.-No.
M 12	1,75	10,2	110	18	9	7	01038250
M 14	2,0	12,0	110	20	11	9	01038260
M 16	2,0	14,0	110	20	12	9	01038270
M 18	2,5	15,5	125	25	14	11	01038280
M 20	2,5	17,5	140	25	16	12	01038290
M 22	2,5	19,5	140	25	18	14,5	01038300
M 24	3,0	21,0	160	30	18	14,5	01038310
M 27	3,0	24,0	160	30	20	16	01038320
M 30	3,5	26,5	180	35	22	18	01038330
M 33	3,5	29,5	180	35	25	20	01038340
M 36	4,0	32,0	200	40	28	22	01038350

BLUE RING

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 371)	Hole type	Blind hole (L<2d1)
Thread	M	Direction	Right
Material	HSS-E TiN	Tolerance	6H
		Form	Form C/RSP 35°

Blue ring INOX / machine tap with reinforced shank / 2-3 thread chamfer

						◇	Art.-No.
M 3	0,5	2,5	56	5	3,5	2,7	01039130
M 3,5	0,6	2,9	56	6	4	3	01039140
M 4	0,7	3,3	63	7	4,5	3,4	01039150
M 5	0,8	4,2	70	8	6	4,9	01039170
M 6	1,0	5,0	80	10	6	4,9	01039190
M 8	1,25	6,8	90	13	8	6,2	01039210
M 10	1,5	8,5	100	15	10	8	01039230

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 376)	Hole type	Blind hole (L<2d1)
Thread	M	Direction	Right
Material	HSS-E TiN	Tolerance	6H
		Form	Form C/RSP 35°

Blue ring INOX / machine tap with overflow shank / 2-3 thread chamfer

						◇	Art.-No.
M 12	1,75	10,2	110	18	9	7	01040250
M 14	2,0	12,0	110	20	11	9	01040260
M 16	2,0	14,0	110	20	12	9	01040270
M 18	2,5	15,5	125	25	14	11	01040280
M 20	2,5	17,5	140	25	16	12	01040290
M 22	2,5	19,5	140	25	18	14,5	01040300
M 24	3,0	21,0	160	30	18	14,5	01040310
M 27	3,0	24,0	160	30	20	16	01040320
M 30	3,5	26,5	180	35	22	18	01040330
M 33	3,5	29,5	180	35	25	20	01040340
M 36	4,0	32,0	200	40	28	22	01040350

MACHINE TAPS DIN 371 / 376

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 371)	Hole type	Blind hole (L<2d1)
Thread	M	Direction	Right
Material	HSS-E VAP	Tolerance	6H
		Form	Form C/RSP 35°

Blue ring INOX / machine tap with reinforced shank / 2-3 thread chamfer

						◇	Art.-No.
M 3	0,5	2,5	56	5	3,5	2,7	01041130
M 3,5	0,6	2,9	56	6	4	3	01041140
M 4	0,7	3,3	63	7	4,5	3,4	01041150
M 5	0,8	4,2	70	8	6	4,9	01041170
M 6	1,0	5,0	80	10	6	4,9	01041190
M 8	1,25	6,8	90	13	8	6,2	01041210
M 10	1,5	8,5	100	15	10	8	01041230

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 376)	Hole type	Blind hole (L<2d1)
Thread	M	Direction	Right
Material	HSS-E VAP	Tolerance	6H
		Form	Form C/RSP 35°

Blue ring INOX / machine tap with overflow shank / 2-3 thread chamfer

						◇	Art.-No.
M 12	1,75	10,2	110	18	9	7	01042250
M 14	2,0	12,0	110	20	11	9	01042260
M 16	2,0	14,0	110	20	12	9	01042270
M 18	2,5	15,5	125	25	14	11	01042280
M 20	2,5	17,5	140	25	16	12	01042290
M 22	2,5	19,5	140	25	18	14,5	01042300
M 24	3,0	21,0	160	30	18	14,5	01042310
M 27	3,0	24,0	160	30	20	16	01042320
M 30	3,5	26,5	180	35	22	18	01042330
M 33	3,5	29,5	180	35	25	20	01042340
M 36	4,0	32,0	200	40	28	22	01042350

BLUE RING

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 371)	Hole type	Blind hole (L<2d1)
Thread	M	Direction	Right
Material	HSSE-PM TiAlN	Tolerance	6H
		Form	Form C/RSP 35°

Blue ring INOX / machine tap with reinforced shank / 2-3 thread chamfer

						◇	Art.-No.
M 3	0,5	2,5	56	5	3,5	2,7	01043130
M 3,5	0,6	2,9	56	6	4	3	01043140
M 4	0,7	3,3	63	7	4,5	3,4	01043150
M 5	0,8	4,2	70	8	6	4,9	01043170
M 6	1,0	5,0	80	10	6	4,9	01043190
M 8	1,25	6,8	90	13	8	6,2	01043210
M 10	1,5	8,5	100	15	10	8	01043230

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 376)	Hole type	Blind hole (L<2d1)
Thread	M	Direction	Right
Material	HSSE-PM TiAlN	Tolerance	6H
		Form	Form C/RSP 35°

Blue ring INOX / machine tap with overflow shank / 2-3 thread chamfer

						◇	Art.-No.
M 12	1,75	10,2	110	18	9	7	01044250

MACHINE TAPS DIN 371 / 376

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 371)	Hole type	Through hole (L>1,5×d1)
Thread	M	Direction	Right
Material	HSS-E V3	Tolerance	6H
		Form	Form B

Red ring 1200 N/mm² / machine tap with reinforced shank / 3,5-6 thread chamfer

						◇	Art.-No.
M 3	0,5	2,5	56	9	3,5	2,7	01045130
M 3,5	0,6	2,9	56	11	4	3	01045140
M 4	0,7	3,3	63	12	4,5	3,4	01045150
M 5	0,8	4,2	70	16	6,0	4,9	01045170
M 6	1,0	5,0	80	15	6,0	4,9	01045190
M 8	1,25	6,8	90	18	8,0	6,2	01045210
M 10	1,5	8,5	100	20	10,0	8,0	01045230

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 376)	Hole type	Through hole (L>1,5×d1)
Thread	M	Direction	Right
Material	HSS-E V3	Tolerance	6H
		Form	Form B

Red ring 1200 N/mm² / machine tap with overflow shank / 3,5-6 thread chamfer

						◇	Art.-No.
M 12	1,75	10,2	110	23	9	7	01046250
M 14	2,0	12,0	110	25	11	9	01046260
M 16	2,0	14,0	110	25	12	9	01046270
M 18	2,5	15,5	125	30	14	11	01046280
M 20	2,5	17,5	140	30	16	12	01046290
M 22	2,5	19,5	140	30	18	14,5	01046300
M 24	3,0	21,0	160	36	18	14,5	01046310
M 27	3,0	24,0	160	36	20	16	01046320
M 30	3,5	26,5	180	40	22	18	01046330
M 33	3,5	29,5	180	42	25	20	01046340
M 36	4,0	32,0	200	50	28	22	01046350

RED RING

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 371)	Hole type	Through hole (L>1,5×d1)
Thread	M	Direction	Right
Material	HSS-E V3 TiCN	Tolerance	6H
		Form	Form B

Red ring 1200 N/mm² / machine tap with reinforced shank / 3,5-6 thread chamfer

						◇	Art.-No.
M 3	0,5	2,5	56	9	3,5	2,7	01047130
M 3,5	0,6	2,9	56	11	4	3	01047140
M 4	0,7	3,3	63	12	4,5	3,4	01047150
M 5	0,8	4,2	70	16	6,0	4,9	01047170
M 6	1,0	5,0	80	15	6,0	4,9	01047190
M 8	1,25	6,8	90	18	8,0	6,2	01047210
M 10	1,5	8,5	100	20	10,0	8,0	01047230

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 376)	Hole type	Through hole (L>1,5×d1)
Thread	M	Direction	Right
Material	HSS-E V3 TiCN	Tolerance	6H
		Form	Form B

Red ring 1200 N/mm² / machine tap with overflow shank / 3,5-6 thread chamfer

						◇	Art.-No.
M 12	1,75	10,2	110	23	9	7	01048250
M 14	2,0	12,0	110	25	11	9	01048260
M 16	2,0	14,0	110	25	12	9	01048270
M 18	2,5	15,5	125	30	14	11	01048280
M 20	2,5	17,5	140	30	16	12	01048290
M 22	2,5	19,5	140	30	18	14,5	01048300
M 24	3,0	21,0	160	36	18	14,5	01048310
M 27	3,0	24,0	160	36	20	16	01048320
M 30	3,5	26,5	180	40	22	18	01048330
M 33	3,5	29,5	180	42	25	20	01048340
M 36	4,0	32,0	200	50	28	22	01048350

MACHINE TAPS DIN 371 / 376

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 371)	Hole type	Blind hole (L<2d1)
Thread	M	Direction	Right
Material	HSS-E V3	Tolerance	6H
		Form	Form C/RSP 40°

Red ring 1200 N/mm² / machine tap with reinforced shank / 2-3 thread chamfer

							Art.-No.
M 3	0,5	2,5	56	5	3,5	2,7	01049130
M 3,5	0,6	2,9	56	6	4	3	01049140
M 4	0,7	3,3	63	7	4,5	3,4	01049150
M 5	0,8	4,2	70	8	6	4,9	01049170
M 6	1,0	5,0	80	10	6	4,9	01049190
M 8	1,25	6,8	90	13	8	6,2	01049210
M 10	1,5	8,5	100	15	10	8	01049230

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 376)	Hole type	Blind hole (L<2d1)
Thread	M	Direction	Right
Material	HSS-E V3	Tolerance	6H
		Form	Form C/RSP 40°

Red ring 1200 N/mm² / machine tap with overflow shank / 2-3 thread chamfer

							Art.-No.
M 12	1,75	10,2	110	18	9	7	01050250
M 14	2,0	12,0	110	20	11	9	01050260
M 16	2,0	14,0	110	20	12	9	01050270
M 18	2,5	15,5	125	25	14	11	01050280
M 20	2,5	17,5	140	25	16	12	01050290
M 22	2,5	19,5	140	25	18	14,5	01050300
M 24	3,0	21,0	160	30	18	14,5	01050310
M 27	3,0	24,0	160	30	20	16	01050320
M 30	3,5	26,5	180	35	22	18	01050330
M 33	3,5	29,5	180	35	25	20	01050340
M 36	4,0	32,0	200	40	28	22	01050350

RED RING

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 371)	Hole type	Blind hole (L<2d1)
Thread	M	Direction	Right
Material	HSS-E V3 TiCN	Tolerance	6H
		Form	Form C/RSP 40°

Red ring 1200 N/mm² / machine tap with reinforced shank / 2-3 thread chamfer

						◇	Art.-No.
M 3	0,5	2,5	56	5	3,5	2,7	01051130
M 3,5	0,6	2,9	56	6	4	3	01051140
M 4	0,7	3,3	63	7	4,5	3,4	01051150
M 5	0,8	4,2	70	8	6	4,9	01051170
M 6	1,0	5,0	80	10	6	4,9	01051190
M 8	1,25	6,8	90	13	8	6,2	01051210
M 10	1,5	8,5	100	15	10	8	01051230

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 376)	Hole type	Blind hole (L<2d1)
Thread	M	Direction	Right
Material	HSS-E V3 TiCN	Tolerance	6H
		Form	Form C/RSP 40°

Red ring 1200 N/mm² / machine tap with overflow shank / 2-3 thread chamfer

						◇	Art.-No.
M 12	1,75	10,2	110	18	9	7	01052250
M 14	2,0	12,0	110	20	11	9	01052260
M 16	2,0	14,0	110	20	12	9	01052270
M 18	2,5	15,5	125	25	14	11	01052280
M 20	2,5	17,5	140	25	16	12	01052290
M 22	2,5	19,5	140	25	18	14,5	01052300
M 24	3,0	21,0	160	30	18	14,5	01052310
M 27	3,0	24,0	160	30	20	16	01052320
M 30	3,5	26,5	180	35	22	18	01052330
M 33	3,5	29,5	180	35	25	20	01052340
M 36	4,0	32,0	200	40	28	22	01052350

MACHINE TAPS DIN 371 / 376

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 371)	Hole type	Through hole (L>1,5×d1)
Thread	M	Direction	Right
Material	HSS-E	Tolerance	6H
		Form	Form B

Yellow ring ALU / machine tap with reinforced shank / 3,5-6 thread chamfer

						◇	Art.-No.
M 3	0,5	2,5	56	9	3,5	2,7	01053130
M 3,5	0,6	2,9	56	11	4	3	01053140
M 4	0,7	3,3	63	12	4,5	3,4	01053150
M 5	0,8	4,2	70	16	6,0	4,9	01053170
M 6	1,0	5,0	80	15	6,0	4,9	01053190
M 8	1,25	6,8	90	18	8,0	6,2	01053210
M 10	1,5	8,5	100	20	10,0	8,0	01053230

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 376)	Hole type	Through hole (L>1,5×d1)
Thread	M	Direction	Right
Material	HSS-E	Tolerance	6H
		Form	Form B

Yellow ring ALU / machine tap with overflow shank / 3,5-6 thread chamfer

						◇	Art.-No.
M 12	1,75	10,2	110	23	9	7	01054250
M 14	2,0	12,0	110	25	11	9	01054260
M 16	2,0	14,0	110	25	12	9	01054270
M 18	2,5	15,5	125	30	14	11	01054280
M 20	2,5	17,5	140	30	16	12	01054290
M 22	2,5	19,5	140	30	18	14,5	01054300
M 24	3,0	21,0	160	36	18	14,5	01054310
M 27	3,0	24,0	160	36	20	16	01054320
M 30	3,5	26,5	180	40	22	18	01054330
M 33	3,5	29,5	180	42	25	20	01054340
M 36	4,0	32,0	200	50	28	22	01054350

YELLOW RING

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 371)	Hole type	Blind hole (L<2d1)
Thread	M	Direction	Right
Material	HSS-E	Tolerance	6H
		Form	Form C/RSP 45°

Yellow ring ALU / machine tap with reinforced shank / 2-3 thread chamfer

						◇	Art.-No.
M 3	0,5	2,5	56	5	3,5	2,7	01055130
M 3,5	0,6	2,9	56	6	4	3	01055140
M 4	0,7	3,3	63	7	4,5	3,4	01055150
M 5	0,8	4,2	70	8	6	4,9	01055170
M 6	1,0	5,0	80	10	6	4,9	01055190
M 8	1,25	6,8	90	13	8	6,2	01055210
M 10	1,5	8,5	100	15	10	8	01055230

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 376)	Hole type	Blind hole (L<2d1)
Thread	M	Direction	Right
Material	HSS-E	Tolerance	6H
		Form	Form C/RSP 45°

Yellow ring ALU / machine tap with overflow shank / 2-3 thread chamfer

						◇	Art.-No.
M 12	1,75	10,2	110	18	9	7	01056250
M 14	2,0	12,0	110	20	11	9	01056260
M 16	2,0	14,0	110	20	12	9	01056270
M 18	2,5	15,5	125	25	14	11	01056280
M 20	2,5	17,5	140	25	16	12	01056290
M 22	2,5	19,5	140	25	18	14,5	01056300
M 24	3,0	21,0	160	30	18	14,5	01056310
M 27	3,0	24,0	160	30	20	16	01056320
M 30	3,5	26,5	180	35	22	18	01056330
M 33	3,5	29,5	180	35	25	20	01056340
M 36	4,0	32,0	200	40	28	22	01056350

MACHINE TAPS DIN 371 / 376

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 371)	Hole type	Blind hole (L<2,5d1) / Through hole (L>1,5×d1)
Thread	M		
Material	HSS-E	Direction	Right
Form	Form C	Tolerance	6HX

White ring GG / machine tap with reinforced shank / 2-3 thread chamfer

							Art.-No.
M 3	0,5	2,5	56	9	3,5	2,7	01057130
M 3,5	0,6	2,9	56	10	4	3	01057140
M 4	0,7	3,3	63	12	4,5	3,4	01057150
M 5	0,8	4,2	70	13	6	4,9	01057170
M 6	1,0	5,0	80	15	6	4,9	01057190
M 8	1,25	6,8	90	18	8	6,2	01057210
M 10	1,5	8,5	100	20	10	8	01057230

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 376)	Hole type	Blind hole (L<2,5d1) / Through hole (L>1,5×d1)
Thread	M		
Material	HSS-E	Direction	Right
Form	Form C	Tolerance	6HX

White ring GG / machine tap with overflow shank / 2-3 thread chamfer

							Art.-No.
M 12	1,75	10,2	110	23	9	7	01058250
M 14	2,0	12,0	110	25	11	9	01058260
M 16	2,0	14,0	110	25	12	9	01058270
M 18	2,5	15,5	125	30	14	11	01058280
M 20	2,5	17,5	140	30	16	12	01058290
M 22	2,5	19,5	140	30	18	14,5	01058300
M 24	3,0	21,0	160	36	18	14,5	01058310
M 27	3,0	24,0	160	36	20	16	01058320
M 30	3,5	26,5	180	40	22	18	01058330
M 33	3,5	29,5	180	42	25	20	01058340
M 36	4,0	32,0	200	50	28	22	01058350

WHITE RING

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 371)	Hole type	Blind hole (L<2,5d1) /
Thread	M		Dulo (L>1,5×d1)
Material	HSS-E TiCN	Direction	Right
Form	Form C	Tolerance	6HX

White ring GG / machine tap with reinforced shank / 2-3 thread chamfer

						◇	Art.-No.
M 3	0,5	2,5	56	9	3,5	2,7	01059130
M 3,5	0,6	2,9	56	10	4	3	01059140
M 4	0,7	3,3	63	12	4,5	3,4	01059150
M 5	0,8	4,2	70	13	6	4,9	01059170
M 6	1,0	5,0	80	15	6	4,9	01059190
M 8	1,25	6,8	90	18	8	6,2	01059210
M 10	1,5	8,5	100	20	10	8	01059230

MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 376)	Hole type	Blind hole (L<2,5d1)/
Thread	M		Dulo (L>1,5×d1)
Material	HSS-E TiCN	Direction	Right
Form	Form C	Tolerance	6HX

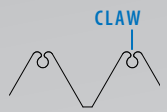
White ring GG / machine tap with overflow shank / 2-3 thread chamfer

						◇	Art.-No.
M 12	1,75	10,2	110	23	9	7	01060250
M 14	2,0	12,0	110	25	11	9	01060260
M 16	2,0	14,0	110	25	12	9	01060270
M 18	2,5	15,5	125	30	14	11	01060280
M 20	2,5	17,5	140	30	16	12	01060290
M 22	2,5	19,5	140	30	18	14,5	01060300
M 24	3,0	21,0	160	36	18	14,5	01060310
M 27	3,0	24,0	160	36	20	16	01060320
M 30	3,5	26,5	180	40	22	18	01060330
M 33	3,5	29,5	180	42	25	20	01060340
M 36	4,0	32,0	200	50	28	22	01060350

DIN 371

COLD FORMING

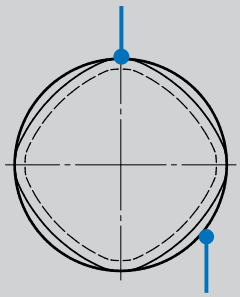
Cold forming describes the forming of metals at a temperature significantly below the recrystallization temperature, which results in an increase in strength and a decrease of elongation at break. During this procedure, the typical claws are formed.

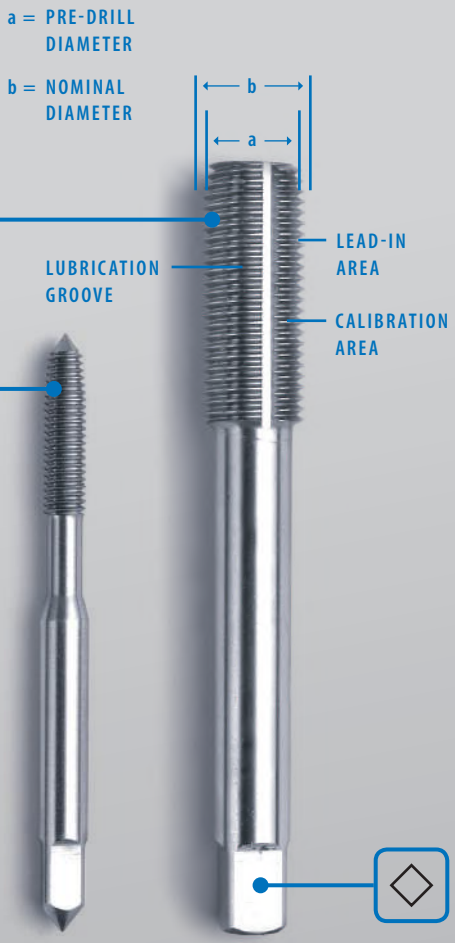


FORMED

CUT

FORMING TAPS





A forming tap produces internal threads chipping free through cold forming. Only pre-condition is a good cold formability of the raw material. The forming wedges push the material aside and form it into a thread.

No chips are produced, the surface is smooth and the procedure quick. However, the tolerances of the bore hole are lower and the used torque higher compared to thread cutting.

SQUARE SHANK

according to DIN 10

FORMING TAPS DIN 371

FORMING TAPS

Forming tap with 4-5 thread chamfer, titanium nitrified

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 371)	Hole type	Through/blind hole
Thread	M	Direction	Right
Material	HSSE-G / TIN	Tolerance	ISO 2 / 6HX
Raw material	Steel	Form	Form D

						◇	Art.-No.
M 3	0,5	2,8	56	11	3,5	2,7	01900130
M 4	0,7	3,7	63	13	4,5	3,4	01900150
M 5	0,8	4,65	70	16	6,0	4,9	01900170
M 6	1,0	5,55	80	19	6,0	4,9	01900190
M 8	1,25	7,45	90	22	8,0	6,2	01900210
M 10	1,5	9,35	100	24	10,0	8,0	01900230

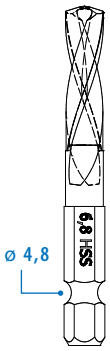
FORMING TAPS

Forming tap with 4-5 thread chamfer, vaporised

TECHNICAL INFORMATION

Standard	DIN 2184-1 (DIN 371)	Hole type	Through/blind hole
Thread	M	Direction	Right
Material	HSSE-G / VAP	Tolerance	ISO 2 / 6HX
Raw material	Stainlees steel	Form	Form D

						◇	Art.-No.
M 3	0,5	2,8	56	11	3,5	2,7	01901130
M 4	0,7	3,7	63	13	4,5	3,4	01901150
M 5	0,8	4,65	70	16	6,0	4,9	01901170
M 6	1,0	5,55	80	19	6,0	4,9	01901190
M 8	1,25	7,45	90	22	8,0	6,2	01901210
M 10	1,5	9,35	100	24	10,0	8,0	01901230



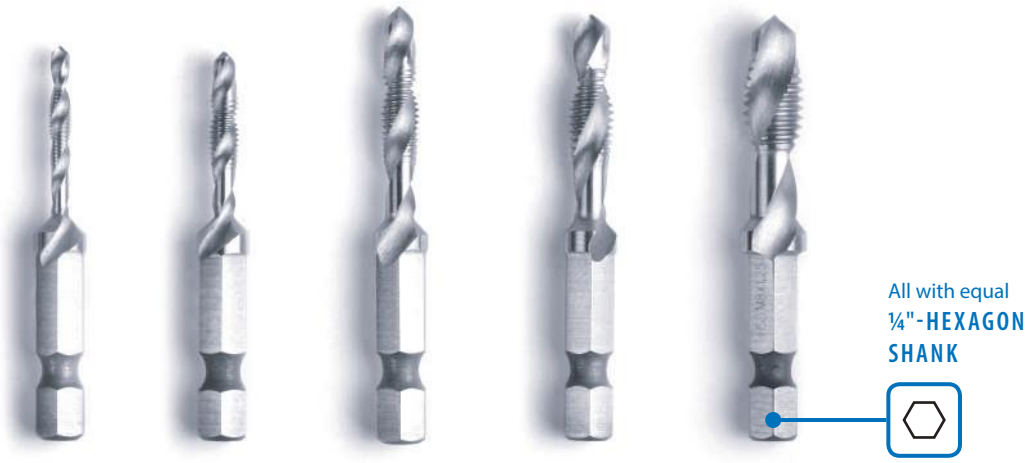
HEXAGON SHANK FORM E

The round trepan Ø4,8 serves for locking and clamping the hexagon shank. By doing so, it is secured against falling out. The holding system is the choice of the manufacturer.

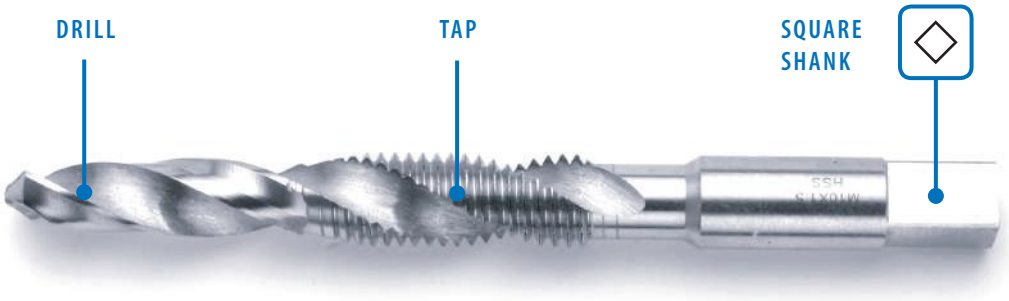
COMBINED TAP BITS

with long hexagon shank Form E

The combined tap bits for ISO metric coarse threads from M3 to M10 are suitable for drilling and tapping of short through holes (max. 1 x d). They can be used in hand drills with clockwise and counter clockwise rotation in materials up to 600 N/mm². The type corresponds to the GSR factory standard.



M3 M4 M5 M6 M8



The combined taps with square shank are produced in accordance with the factory standard. They are constructed for drilling and tapping with just one tool.

They can be used with all stationary drilling machines with switchable rotational speed up to 600 N/mm² tensile strength.

COMBINED TAPS

COMBINED TAP BITS

Combined tap bits are produced in accordance with the factory standard. They can be used for drilling, tapping and countersinking with just one tool. Due to their ¼ " hexagon shank, they can be used with all regular hand drills with clockwise and counter clockwise rotation as well as with stationary drilling machines. They are suitable for short through holes with max. 1 x d in materials up to 600 N/mm².

All with equal
¼"-HEXAGON SHANK

M4 M5 M6 M8 M10

COMBINED MACHINE TAPS FACTORY STANDARD

COMBINED MACHINE TAPS

TECHNICAL INFORMATION

Standard	Factory Standard	Hole type	Through hole
Thread	M	Direction	Right
Material	HSSE-G	Tolerance	6H
Raw material	VA-Steel	with split point	

					Art.-No.
M 3	0,5	2,5	56	2,4	00331030
M 4	0,7	3,3	63	3,0	00331040
M 5	0,8	4,2	71	3,8	00331050
M 6	1,0	5,0	80	4,9	00331060
M 8	1,25	6,8	95	6,2	00331080
M 10	1,5	8,5	106	8,0	00331100
M 12	1,75	10,2	115	9,0	00331120

COMBINED BITS

TECHNICAL INFORMATION

Standard	Factory Standard	Hole type	Through hole < 1×d
Thread	M	Direction	Right
Material	HSS-G	Tolerance	6H
Raw material	Steel		

Combined bit for tap hole drilling, tapping and deburring, with ¼ " hexagon shank (DIN 3126) and split point

					Art.-No.
M 3	0,5	2,5	36	1/4"	04501130
M 4	0,7	3,3	39	1/4"	04501150
M 5	0,8	4,2	41	1/4"	04501170
M 6	1	5	44	1/4"	04501190
M 8	1,25	6,8	50	1/4"	04501210
M 10	1,5	8,5	59	1/4"	04501230

GSR

COMBINED BIT SET

TECHNICAL INFORMATION

incl. ¼ " magnetic bit holder (DIN 3126)

in a steel box

	Art.-No.
M3 - M 10	04501000

HSS

CUTTING OF EXTERNAL THREADS

Chamfer the end of the round steel bolt in order to ease the threading. Put the round die into the round die holder. Make sure to align the round die indent with the middle screw of the round die holder. Tighten the screws with a screwdriver to prevent the round die from slipping. Furthermore, pay attention that the screws engage with the holes and the indent of the round die to ensure a secure hold. You can use the round die from both sides as it is chamfered on each side.

Make sure to have an even approach and lubricate with cutting oil. The round die then is twisted onto the bolt under slight pressure. From time to time, twist the round die back to break the chip.

EXTERNAL THREADS

55 × 22 mm

20 × 5 mm

20 × 5 mm

ROUND DIES

EN 22568 (old = DIN 223)

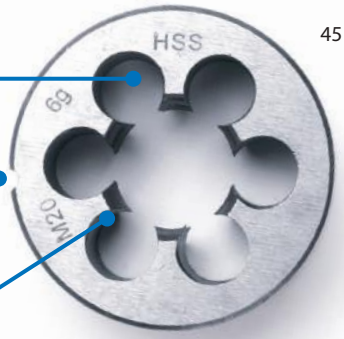
For cutting external threads according to ISO standards for metric coarse threads M1 to M56, pre-slit round dies (form B) are used.

38 × 14 mm

20 × 7 mm

20 × 7 mm

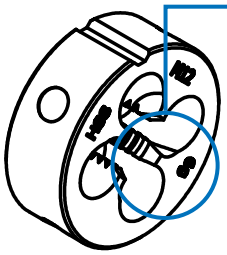
45 × 18 mm

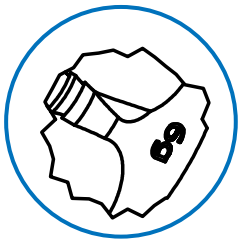


CHIP HOLE

FORM B
= pre-slit

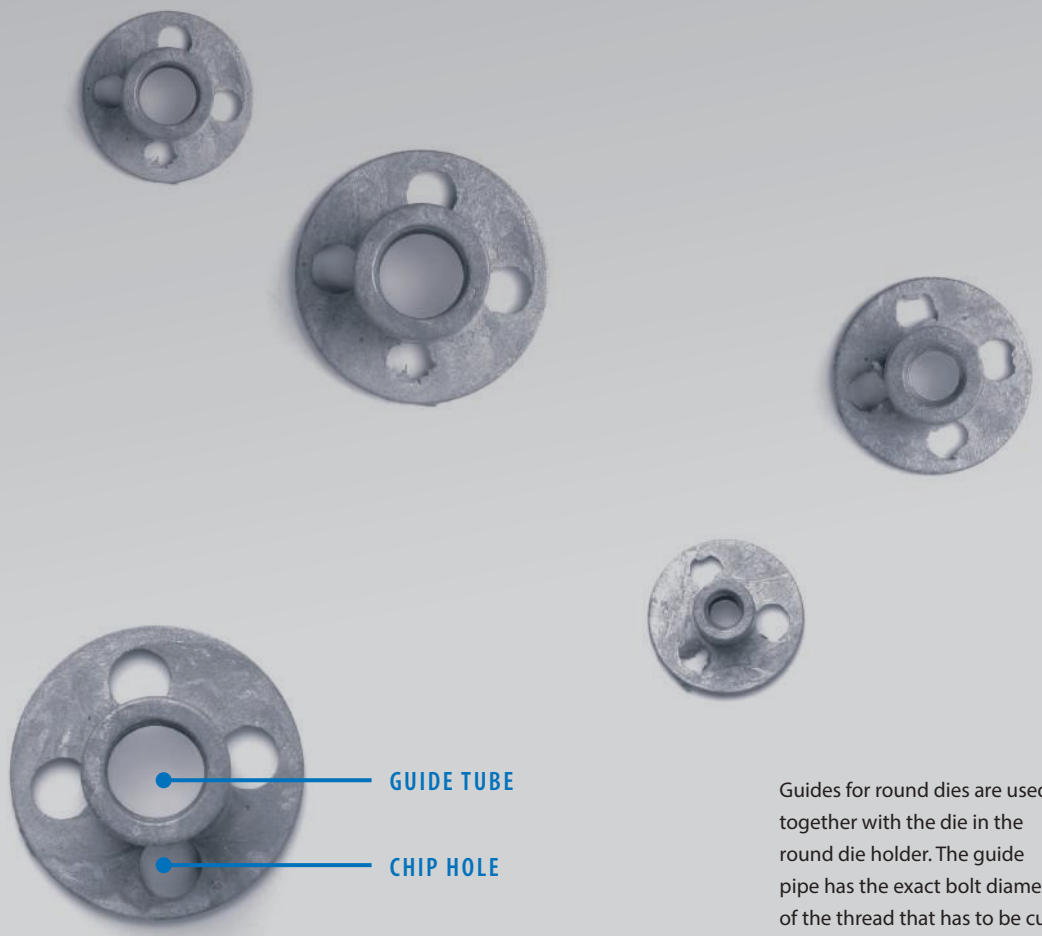
SPIRAL POINT





Round dies with an outer diameter of d=16mm and d=20mm have three chip holes, bigger round dies do have four or more. It does not matter from which side the round dies are used, as they are chamfered on each side.

65 × 25 mm



Guides for round dies are used together with the die in the round die holder. The guide pipe has the exact bolt diameter of the thread that has to be cut.

ROUND DIE GUIDES

FACTORY STANDARD

Thus, the first cut is done perpendicular and the thread flanks are cut evenly. Die guides are die casted from aluminium and have integrated chip holes to enable a good chip removal.

ROUND DIES

TECHNICAL INFORMATION

Standard	DIN EN 22568 (DIN 223)	Direction	Right
Thread	M	Tolerance	6g
Material	HSS	Form	Form B
Raw material	Steel		

Round die, with spiral point

					Art.-No.
M 1	0,25	0,97	16	5	00402010
M 1,1	0,25	1,07	16	5	00402020
M 1,2	0,25	1,17	16	5	00402030
M 1,4	0,30	1,36	16	5	00402040
M 1,6	0,35	1,54	16	5	00402050
M 1,7	0,35	1,66	16	5	00402060
M 1,8	0,35	1,74	16	5	00402070
M 2	0,40	1,94	16	5	00402080
M 2,2	0,45	2,13	16	5	00402090
M 2,3	0,40	2,25	16	5	00402100
M 2,5	0,45	2,43	16	5	00402110
M 2,6	0,45	2,54	16	5	00402120
M 3	0,5	2,92	20	5	00402130
M 3,5	0,60	3,41	20	5	00402140
M 4	0,7	3,91	20	5	00402150
M 4,5	0,75	4,41	20	7	00402160
M 5	0,8	4,9	20	7	00402170
M 5,5	0,9	5,4	20	7	00402180
M 6	1,0	5,88	20	7	00402190
M 7	1,0	6,88	25	9	00402200
M 8	1,25	7,87	25	9	00402210
M 9	1,25	8,87	25	9	00402220
M 10	1,5	9,85	30	11	00402230
M 11	1,5	10,85	30	11	00402240
M 12	1,75	11,83	38	14	00402250
M 14	2,0	13,82	38	14	00402260
M 15	2	14,82	38	14	00402265
M 16	2,0	15,82	45	18	00402270
M 18	2,5	17,79	45	18	00402280
M 20	2,5	19,79	45	18	00402290
M 22	2,5	21,79	55	22	00402300
M 24	3,0	23,77	55	22	00402310
M 27	3,0	26,77	65	25	00402320
M 30	3,5	29,73	65	25	00402330
M 33	3,5	32,73	65	25	00402340
M 36	4,0	35,7	65	25	00402350

					Art.-No.
M 39	4,0	38,70	75	30	00402360
M 42	4,5	41,69	75	30	00402370
M 45	4,5	44,69	90	36	00402380
M 48	5,0	47,66	90	36	00402390
M 52	5,0	51,66	90	36	00402400
M 56	5,5	55,62	105	36	00402410
M 60	5,5	59,62	105	36	00402420
M 64	6,0	63,58	105	36	00402430

ROUND DIES LH

TECHNICAL INFORMATION

Standard	DIN EN 22568 (DIN 223)	Direction	Left
Thread	M	Tolerance	6g
Material	HSS	Form	Form B
Raw material	Steel		

Round die, with spiral point

					Art.-No.
M 2	0,4	1,94	16	5	00404080
M 3	0,5	2,92	20	5	00404130
M 3,5	0,6	3,41	20	5	00404140
M 4	0,7	3,91	20	5	00404150
M 4,5	0,75	4,41	20	7	00404160
M 5	0,8	4,9	20	7	00404170
M 6	1,0	5,88	20	7	00404190
M 7	1,0	6,88	25	9	00404200
M 8	1,25	7,87	25	9	00404210
M 9	1,25	8,87	25	9	00404220
M 10	1,5	9,85	30	11	00404230
M 12	1,75	11,83	38	14	00404250
M 14	2,0	13,82	38	14	00404260
M 16	2,0	15,82	45	18	00404270
M 18	2,5	17,79	45	18	00404280
M 20	2,5	19,79	45	18	00404290
M 22	2,5	21,79	55	22	00404300
M 24	3,0	23,77	55	22	00404310
M 27	3,0	26,77	65	25	00404320
M 30	3,5	29,73	65	25	00404330
M 33	3,5	32,73	65	25	00404340
M 36	4,0	35,7	65	25	00404350

					Art.-No.
M 39	4,0	38,7	75	30	00404360
M 42	4,5	41,69	75	30	00404370
M 45	4,5	44,69	90	36	00404380
M 48	5,0	47,66	90	36	00404390
M 52	5,0	51,66	90	36	00404400

ROUND DIES

TECHNICAL INFORMATION

Standard	DIN EN 22568 (DIN 223)	Direction	Right
Thread	M	Tolerance	6g
Material	HSS-E	Form	Form B
Raw material	Stainlees steel		

Round die, with spiral point

					Art.-No.
M 3	0,5	2,92	20	5	00406130
M 3,5	0,6	3,41	20	5	00406140
M 4	0,7	3,91	20	5	00406150
M 4,5	0,75	4,41	20	7	00406160
M 5	0,8	4,9	20	7	00406170
M 6	1,0	5,88	20	7	00406190
M 7	1,0	6,88	25	9	00406200
M 8	1,25	7,87	25	9	00406210
M 9	1,25	8,87	25	9	00406220
M 10	1,5	9,85	30	11	00406230
M 12	1,75	11,83	38	14	00406250
M 14	2,0	13,82	38	14	00406260
M 16	2,0	15,82	45	18	00406270
M 18	2,5	17,79	45	18	00406280
M 20	2,5	19,79	45	18	00406290
M 22	2,5	21,79	55	22	00406300
M 24	3,0	23,77	55	22	00406310
M 27	3,0	26,77	65	25	00406320
M 30	3,5	29,73	65	25	00406330
M 33	3,5	32,73	65	25	00406340
M 36	4,0	35,7	65	25	00406350
M 39	4,0	38,7	75	30	00406360
M 42	4,5	41,69	75	30	00406370
M 45	4,5	44,69	90	36	00406380
M 48	5,0	47,66	90	36	00406390
M 52	5,0	51,66	90	36	00406400

ROUND DIES

TECHNICAL INFORMATION

Standard	DIN EN 22568 (DIN 223)	Direction	Right
Thread	M	Tolerance	6g
Material	HSSE-VAP	Form	Form B
Raw material	Stainlees steel		

Round die, with spiral point, vaporised

					Art.-No.
M 3	0,5	2,92	20	5	00409130
M 3,5	0,6	3,41	20	5	00409140
M 4	0,7	3,91	20	5	00409150
M 4,5	0,75	4,41	20	7	00409160
M 5	0,8	4,9	20	7	00409170
M 6	1,0	5,88	20	7	00409190
M 7	1,0	6,88	25	9	00409200
M 8	1,25	7,87	25	9	00409210
M 9	1,25	8,87	25	9	00409220
M 10	1,5	9,85	30	11	00409230
M 12	1,75	11,83	38	14	00409250
M 14	2,0	13,82	38	14	00409260
M 16	2,0	15,82	45	18	00409270
M 18	2,5	17,79	45	18	00409280
M 20	2,5	19,79	45	18	00409290
M 22	2,5	21,79	55	22	00409300
M 24	3,0	23,77	55	22	00409310
M 27	3,0	26,77	65	25	00409320
M 30	3,5	29,73	65	25	00409330
M 33	3,5	32,73	65	25	00409340
M 36	4,0	35,7	65	25	00409350
M 39	4,0	38,7	75	30	00409360
M 42	4,5	41,69	75	30	00409370
M 45	4,5	44,69	90	36	00409380
M 48	5,0	47,66	90	36	00409390
M 52	5,0	51,66	90	36	00409400

ROUND DIES

TECHNICAL INFORMATION

Standard	DIN EN 22568 (DIN 223)	Direction	Right
Thread	MF	Tolerance	6g
Material	HSS	Form	Form B
Raw material	Steel		

Round die, with spiral point

					Art.-No.
MF 2 × 0,25	0,25	1,97	16	5	00414100
MF 3 × 0,35	0,35	2,94	20	5	00414200
MF 3 × 0,5	0,5	2,93	20	5	00414210
MF 3,5 × 0,35	0,35	3,44	20	5	00414220
MF 3,5 × 0,5	0,5	3,43	20	5	00414225
MF 4 × 0,35	0,35	3,94	20	5	00414230
MF 4 × 0,5	0,5	3,93	20	5	00414240
MF 4,5 × 0,5	0,5	4,43	20	5	00414260
MF 5 × 0,5	0,5	4,93	20	5	00414280
MF 5 × 0,75	0,75	4,91	20	5	00414290
MF 5,5 × 0,5	0,5	5,43	20	5	00414300
MF 5,5 × 0,75	0,75	5,41	20	5	00414310
MF 6 × 0,5	0,5	5,93	20	5	00414320
MF 6 × 0,75	0,75	5,91	20	7	00414330
MF 7 × 0,75	0,75	6,91	25	9	00414360
MF 8 × 0,5	0,5	7,93	25	9	00414380
MF 8 × 0,75	0,75	7,91	25	9	00414390
MF 8 × 1	1,0	7,88	25	9	00414400
MF 8 × 1,5	1,5	7,85	25	9	00414410
MF 9 × 0,75	0,75	8,91	25	9	00414430
MF 9 × 1	1,0	8,88	25	9	00414440
MF 10 × 0,5	0,5	9,93	30	11	00414450
MF 10 × 0,75	0,75	9,91	30	11	00414460
MF 10 × 1	1,0	9,88	30	11	00414470
MF 10 × 1,25	1,25	9,87	30	11	00414480
MF 11 × 0,75	0,75	10,91	30	11	00414500
MF 11 × 1	1,0	10,88	30	11	00414510
MF 11 × 1,25	1,25	10,87	30	11	00414520
MF 12 × 0,5	0,5	11,93	38	10	00414530
MF 12 × 0,75	0,75	11,91	38	10	00414540
MF 12 × 1	1,0	11,88	38	10	00414550
MF 12 × 1,25	1,25	11,87	38	10	00414560
MF 12 × 1,5	1,5	11,85	38	10	00414570
MF 13 × 1	1,0	12,88	38	10	00414600
MF 13 × 1,25	1,25	12,87	38	10	00414610
MF 13 × 1,5	1,5	11,5	38	10	00414620

					Art.-No.
MF 14 × 0,5	0,5	13,93	38	10	00414630
MF 14 × 0,75	0,75	13,91	38	10	00414640
MF 14 × 1	1,0	13,88	38	10	00414650
MF 14 × 1,25	1,25	13,87	38	10	00414660
MF 14 × 1,5	1,5	13,85	38	10	00414670
MF 15 × 1	1,0	14,88	38	10	00414700
MF 15 × 1,5	1,5	14,85	38	10	00414720
MF 16 × 0,5	0,5	15,93	45	14	00414730
MF 16 × 0,75	0,75	15,98	45	14	00414740
MF 16 × 1	1,0	15,88	45	14	00414750
MF 16 × 1,25	1,25	15,86	45	14	00414760
MF 16 × 1,5	1,5	15,85	45	14	00414770
MF 17 × 1	1,0	16,88	45	14	00414790
MF 17 × 1,5	1,5	16,85	45	14	00414800
MF 18 × 0,5	0,5	17,93	45	14	00414820
MF 18 × 1	1,0	17,88	45	14	00414840
MF 18 × 1,25	1,25	17,86	45	14	00414850
MF 18 × 1,5	1,5	17,85	45	14	00414860
MF 18 × 2	2,0	17,82	45	14	00414870
MF 19 × 1	1,0	18,88	45	14	00414880
MF 19 × 1,5	1,5	18,85	45	14	00414890
MF 20 × 0,5	0,5	19,93	45	14	00414910
MF 20 × 0,75	0,75	19,91	45	14	00414920
MF 20 × 1	1,0	19,88	45	14	00414930
MF 20 × 1,25	1,25	19,86	45	14	00414940
MF 20 × 1,5	1,5	19,85	45	14	00414950
MF 20 × 2	2,0	19,82	45	14	00414960
MF 21 × 1,5	1,5	20,85	55	16	00415000
MF 22 × 1	1,0	21,88	55	16	00415030
MF 22 × 1,25	1,25	21,86	55	16	00415040
MF 22 × 1,5	1,5	21,85	55	16	00415050
MF 22 × 2	2,0	21,82	55	16	00415060
MF 23 × 1	1,0	22,88	55	16	00415070
MF 23 × 1,5	1,5	22,85	55	16	00415080
MF 24 × 1	1,0	23,88	55	16	00415110
MF 24 × 1,25	1,25	23,86	55	16	00415120
MF 24 × 1,5	1,5	23,85	55	16	00415130
MF 24 × 2	2,0	23,82	55	16	00415140
MF 25 × 1	1,0	24,88	55	16	00415150
MF 25 × 1,5	1,5	24,85	55	16	00415170
MF 25 × 2	2,0	24,82	55	16	00415180
MF 26 × 1	1,0	25,88	55	16	00415190
MF 26 × 1,5	1,5	25,85	55	16	00415210
MF 26 × 2	2,0	25,82	55	16	00415220

					Art.-No.
MF 27 × 1	1,0	26,88	65	18	00415230
MF 27 × 1,5	1,5	26,85	65	18	00415240
MF 27 × 2	2,0	26,82	65	18	00415250
MF 28 × 1	1,0	27,88	65	18	00415260
MF 28 × 1,5	1,5	27,85	65	18	00415270
MF 28 × 2	2,0	27,82	65	18	00415280
MF 30 × 1	1,0	29,88	65	18	00415290
MF 30 × 1,5	1,5	29,85	65	18	00415300
MF 30 × 2	2,0	29,82	65	18	00415310
MF 30 × 3	3,0	29,76	65	25	00415320
MF 32 × 1	1,0	31,88	65	18	00415330
MF 32 × 1,5	1,5	31,85	65	18	00415340
MF 32 × 2	2,0	31,82	65	18	00415350
MF 33 × 1	1,0	32,88	65	18	00415370
MF 33 × 1,5	1,5	32,85	65	18	00415380
MF 33 × 2	2,0	32,82	65	18	00415390
MF 33 × 3	3,0	32,76	65	25	00415400
MF 34 × 1	1,0	33,88	65	18	00415410
MF 34 × 1,5	1,5	33,85	65	18	00415420
MF 34 × 2	2,0	33,82	65	18	00415430
MF 35 × 1	1,0	34,88	65	18	00415450
MF 35 × 1,5	1,5	34,85	65	18	00415460
MF 35 × 2	2,0	34,82	65	18	00415470
MF 36 × 1	1,0	35,88	65	18	00415490
MF 36 × 1,5	1,5	35,85	65	18	00415500
MF 36 × 2	2,0	35,82	65	18	00415510
MF 36 × 3	3,0	35,76	65	25	00415520
MF 38 × 1	1,0	37,88	75	20	00415530
MF 38 × 1,5	1,5	37,85	75	20	00415540
MF 38 × 2	2,0	37,82	75	20	00415550
MF 38 × 3	3,0	37,76	75	20	00415560
MF 39 × 1,5	1,5	38,85	75	20	00415570
MF 39 × 2	2,0	38,82	75	20	00415580
MF 39 × 3	3,0	38,76	75	30	00415590
MF 40 × 1	1,0	39,88	75	20	00415600
MF 40 × 1,5	1,5	39,85	75	20	00415610
MF 40 × 2	2,0	39,82	75	20	00415620
MF 40 × 3	3,0	39,76	75	30	00415630
MF 42 × 1,5	1,5	41,85	75	20	00415640
MF 42 × 2	2,0	41,82	75	20	00415650
MF 42 × 3	3,0	41,76	75	30	00415660
MF 45 × 1	1,0	44,88	90	22	00415680
MF 45 × 1,5	1,5	44,85	90	22	00415690
MF 45 × 2	2,0	44,82	90	22	00415700

					Art.-No.
MF 45 × 3	3,0	44,76	90	36	00415710
MF 48 × 1,5	1,5	47,85	90	22	00415740
MF 48 × 2	2,0	47,82	90	22	00415750
MF 48 × 3	3,0	47,76	90	36	00415760
MF 48 × 4	4,0	47,68	90	36	00415770
MF 50 × 1	1,0	49,88	90	22	00415780
MF 50 × 1,5	1,5	49,85	90	22	00415790
MF 50 × 2	2,0	49,82	90	22	00415800
MF 50 × 3	3,0	49,76	90	36	00415810
MF 52 × 1,5	1,5	51,85	90	22	00415840
MF 52 × 2	2,0	51,82	90	22	00415850
MF 52 × 3	3,0	51,76	90	36	00415860
MF 52 × 4	4,0	51,68	90	36	00415870

ROUND DIES LH

TECHNICAL INFORMATION

Standard	DIN EN 22568 (DIN 223)	Direction	Left
Thread	MF	Tolerance	6g
Material	HSS	Form	Form B
Raw material	Steel		

Round die, with spiral point

					Art.-No.
MF 4 × 0,5	0,5	3,93	20	5	00417240
MF 5 × 0,5	0,5	4,93	20	5	00417280
MF 6 × 0,5	0,5	5,93	20	5	00417320
MF 6 × 0,75	0,75	5,91	20	7	00417330
MF 7 × 0,75	0,75	6,91	25	9	00417360
MF 8 × 0,5	0,5	7,93	25	9	00417380
MF 8 × 0,75	0,75	7,91	25	9	00417390
MF 8 × 1	1,0	7,88	25	9	00417400
MF 10 × 0,75	0,75	9,91	30	11	00417460
MF 10 × 1	1,0	9,88	30	11	00417470
MF 10 × 1,25	1,25	9,87	30	11	00417480
MF 12 × 1	1,0	11,88	38	10	00417550
MF 12 × 1,25	1,25	11,87	38	10	00417560
MF 12 × 1,5	1,5	11,85	38	10	00417570
MF 14 × 1	1,0	13,88	38	10	00417650
MF 14 × 1,25	1,25	13,87	38	10	00417660

					Art.-No.
MF 14 × 1,5	1,5	13,85	38	10	00417670
MF 16 × 1	1,0	15,88	45	14	00417750
MF 16 × 1,5	1,5	15,85	45	14	00417770
MF 18 × 1	1,0	17,88	45	14	00417840
MF 18 × 1,5	1,5	17,85	45	14	00417860
MF 18 × 2	2,0	17,82	45	14	00417870
MF 20 × 1	1,0	19,88	45	14	00417930
MF 20 × 1,5	1,5	19,85	45	14	00417950
MF 20 × 2	2,0	19,82	45	14	00417960
MF 22 × 1	1,0	21,88	55	16	00418030
MF 22 × 1,5	1,5	21,85	55	16	00418050
MF 24 × 1	1,0	23,88	55	16	00418110
MF 24 × 1,5	1,5	23,85	55	16	00418130
MF 24 × 2	2,0	23,82	55	16	00418140
MF 25 × 1,5	1,5	24,85	55	16	00418170
MF 26 × 1,5	1,5	25,85	55	16	00418210
MF 27 × 1,5	1,5	26,85	65	18	00418240
MF 27 × 2	2,0	26,82	65	18	00418250
MF 28 × 1,5	1,5	27,85	65	18	00418270
MF 30 × 1,5	1,5	29,85	65	18	00418300
MF 30 × 2	2,0	29,82	65	18	00418310
MF 32 × 1,5	1,5	31,85	65	18	00418340
MF 35 × 1,5	1,5	34,85	65	18	00418460
MF 36 × 1,5	1,5	35,85	65	18	00418500
MF 36 × 2	2,0	35,82	65	18	00418510
MF 38 × 1,5	1,5	37,85	75	20	00418540
MF 40 × 1,5	1,5	39,85	75	20	00418610
MF 40 × 2	2,0	39,76	75	20	00418620
MF 42 × 1,5	1,5	41,85	75	20	00418640
MF 45 × 1,5	1,5	44,85	90	22	00418690
MF 45 × 2	2,0	44,82	90	22	00418700
MF 48 × 1,5	1,5	47,85	90	22	00418740
MF 48 × 2	2,0	47,82	90	22	00418750
MF 50 × 1,5	1,5	49,85	90	22	00418790
MF 50 × 2	2,0	49,82	90	22	00418800
MF 52 × 1,5	1,5	51,85	90	22	00418840
MF 52 × 2	2,0	51,82	90	22	00418850

ROUND DIES

TECHNICAL INFORMATION

Standard	DIN EN 22568 (DIN 223)	Direction	Right
Thread	BSW		
Material	HSS	Form	Form B
Raw material	Steel		

Round die, with spiral point

					Art.-No.
BSW 1/16	60	1,55	16	5	00436010
BSW 3/32	48	2,3	16	5	00436020
BSW 1/8	40	2,6	20	5	00436030
BSW 5/32	32	3,2	20	5	00436040
BSW 3/16	24	3,8	20	7	00436050
BSW 7/32	24	4,6	20	7	00436060
BSW 1/4	20	5,1	20	7	00436070
BSW 5/16	18	6,5	25	9	00436080
BSW 3/8	16	7,9	30	11	00436090
BSW 7/16	14	9,3	30	11	00436100
BSW 1/2	13	10,5	38	14	00436110
BSW 9/16	12	12,0	38	14	00436120
BSW 5/8	11	13,5	45	18	00436130
BSW 3/4	10	16,5	45	18	00436140
BSW 7/8	9	19,5	55	22	00436150
BSW 1	8	22,0	55	22	00436160
BSW 1.1/8	7	25,0	65	25	00436170
BSW 1.1/4	7	28,0	65	25	00436180
BSW 1.3/8	6	30,5	65	25	00436190
BSW 1.1/2	6	33,5	75	30	00436200
BSW 1.5/8	5	40,76	75	30	00436210
BSW 1.3/4	5	43,94	90	36	00436220
BSW 1.7/8	4,5	47,08	90	36	00436230
BSW 2	4,5	50,27	90	36	00436240
BSW 2.1/4	4	56,57	105	36	00436250
BSW 2.1/2	4	62,92	120	36	00436260
BSW 2.3/4	3,5	69,27	120	36	00436270
BSW 3	3,5	75,62	120	36	00436280

ROUND DIES LH

TECHNICAL INFORMATION

Standard	DIN EN 22568 (DIN 223)	Direction	Left
Thread	BSW		
Material	HSS	Form	Form B
Raw material	Steel		

Round die, with spiral point

					Art.-No.
BSW 1/8	40	2,6	20	5	00437030
BSW 5/32	32	3,2	20	5	00437040
BSW 3/16	24	3,8	20	7	00437050
BSW 1/4	20	5,1	20	7	00437070
BSW 5/16	18	6,5	25	9	00437080
BSW 3/8	16	7,9	30	11	00437090
BSW 7/16	14	9,3	30	11	00437100
BSW 1/2	13	10,5	38	14	00437110
BSW 9/16	12	12,0	38	14	00437120
BSW 5/8	11	13,5	45	18	00437130
BSW 3/4	10	16,5	45	18	00437140
BSW 7/8	9	19,5	55	22	00437150
BSW 1	8	22,0	55	22	00437160

ROUND DIES

TECHNICAL INFORMATION

Standard	DIN EN 22568 (DIN 5158)	Direction	Right
Thread	BSP		
Material	HSS	Form	Form B
Raw material	Steel		

Round die, with spiral point

					Art.-No.
BSP 1/8	28	8,8	30	11	00452020
BSP 1/4	19	11,8	38	10	00452060
BSP 3/8	19	15,3	45	14	00452080
BSP 1/2	14	19,0	45	14	00452100
BSP 5/8	14	21,0	55	16	00452120
BSP 3/4	14	24,5	55	16	00452130
BSP 7/8	14	28,3	65	18	00452140
BSP 1	11	30,5	65	18	00452150
BSP 1.1/8	11	35,5	75	20	00452170
BSP 1.1/4	11	39,5	75	20	00452180

					Art.-No.
BSP 1.3/8	11	42,0	90	22	00452190
BSP 1.1/2	11	45,0	90	22	00452200
BSP 1.3/4	11	53,57	105	22	00452220
BSP 2	11	59,43	105	22	00452230
BSP 2.1/4	11	65,49	120	22	00452240
BSP 2.1/2	11	74,97	120	25	00452250
BSP 2.3/4	11	81,32	120	25	00452260
BSP 3	11	87,67	130	25	00452270

ROUND DIES LH

TECHNICAL INFORMATION

Standard	DIN EN 22568 (DIN 5158)	Direction	Left
Thread	BSP		
Material	HSS	Form	Form B
Raw material	Steel		

Round die, with spiral point

					Art.-No.
BSP 1/8	28	9,62	30	11	00456020
BSP 1/4	19	13,03	38	10	00456060
BSP 3/8	19	16,54	45	14	00456080
BSP 1/2	14	20,81	45	14	00456100
BSP 5/8	14	22,77	55	16	00456120
BSP 3/4	14	26,3	55	16	00456130
BSP 7/8	14	30,06	65	18	00456140
BSP 1	11	33,07	65	18	00456150
BSP 1.1/8	11	37,72	75	20	00456170
BSP 1.1/4	11	41,73	75	20	00456180
BSP 1.3/8	11	44,14	90	22	00456190
BSP 1.1/2	11	47,62	90	22	00456200
BSP 1.3/4	11	53,57	105	22	00456210
BSP 2	11	59,43	105	22	00456220

ROUND DIES

TECHNICAL INFORMATION

Standard	DIN EN 22568 (DIN 5158)	Direction	Right
Thread	BSP		
Material	HSSE	Form	Form B
Raw material	Stainlees steel		

Round die, with spiral point

					Art.-No.
BSP 1/8	28	9,62	30	11	00458020
BSP 1/4	19	13,03	38	10	00458060
BSP 3/8	19	16,54	45	14	00458080
BSP 1/2	14	20,81	45	14	00458100
BSP 3/4	14	26,3	55	16	00458130
BSP 1	11	33,07	60	18	00458150
BSP 1.1/4	11	41,73	75	20	00458180
BSP 1.1/2	11	47,62	90	22	00458200

ROUND DIES

TECHNICAL INFORMATION

Standard	DIN EN 22568 (DIN 223)	Direction	Right
Thread	BSF		
Material	HSS	Form	Form B
Raw material	Steel		

Round die, with spiral point

					Art.-No.
BSF 3/16	32	4,68	20	7	00444040
BSF 1/4	26	5,3	20	7	00444060
BSF 5/16	22	6,8	25	9	00444070
BSF 3/8	20	8,3	30	11	00444080
BSF 7/16	18	9,7	30	11	00444090
BSF 1/2	16	11,1	38	10	00444100
BSF 5/8	14	14,0	45	14	00444120
BSF 3/4	12	16,8	45	14	00444140
BSF 7/8	11	19,8	55	22	00444160
BSF 1	10	22,8	55	22	00444180
BSF 1.1/8	9	28,25	65	25	00444200
BSF 1.1/4	9	31,4	65	25	00444210
BSF 1.3/8	8	34,6	65	25	00444220
BSF 1.1/2	8	37,7	75	30	00444230

ROUND DIES

TECHNICAL INFORMATION

Standard	DIN EN 22568 (DIN 223)	Direction	Right
Thread	UNC	Tolerance	2a
Material	HSS	Form	Form B
Raw material	Steel		

Round die, with spiral point

					Art.-No.
UNC No. 1	64	1,79	16	5	462010
UNC No. 2	56	2,12	16	5	462020
UNC No. 3	48	2,44	16	5	462030
UNC No. 4	40	2,76	20	5	462040
UNC No. 5	40	3,09	20	5	462050
UNC No. 6	32	3,41	20	7	462060
UNC No. 8	32	4,07	20	7	462080
UNC No. 10	24	4,71	20	7	462100
UNC No. 12	24	5,4	20	7	462120
UNC 1/4	20	6,2	20	7	462130
UNC 5/16	18	7,8	25	9	462140
UNC 3/8	16	9,37	30	11	462150
UNC 7/16	14	10,95	38	14	462160
UNC 1/2	13	12,52	38	14	462170
UNC 9/16	12	14,1	38	14	462180
UNC 5/8	11	15,68	45	18	462190
UNC 3/4	10	18,84	45	18	462210
UNC 7/8	9	22,08	55	22	462230
UNC 1	8	25,16	55	22	462250
UNC 1.1/8	7	28,31	65	25	462260
UNC 1.1/4	7	31,49	65	25	462270
UNC 1.3/8	6	34,63	65	25	462280
UNC 1.1/2	6	37,81	75	30	462290
UNC 1.3/4	5	44,12	90	36	462300
UNC 2	4,5	50,45	85	36	462310

ROUND DIES LH

TECHNICAL INFORMATION

Standard	DIN EN 22568 (DIN 223)	Direction	Left
Thread	UNC	Tolerance	2a
Material	HSS	Form	Form B
Raw material	Steel		

Round die, with spiral point

					Art.-No.
UNC No. 6	32	3,41	20	7	00465060
UNC No. 8	32	4,07	20	7	00465080
UNC No. 10	24	4,71	20	7	00465100
UNC No. 12	24	5,4	20	7	00465120
UNC 1/4	20	6,2	20	7	00465130
UNC 5/16	18	7,8	25	9	00465140
UNC 3/8	16	9,37	30	11	00465150
UNC 7/16	14	10,95	30	11	00465160
UNC 1/2	13	12,52	38	14	00465170
UNC 9/16	12	14,1	38	14	00465180
UNC 5/8	11	15,68	45	18	00465190
UNC 3/4	10	18,84	45	18	00465210
UNC 7/8	9	22,08	55	22	00465230
UNC 1	8	25,16	55	22	00465250

ROUND DIES

TECHNICAL INFORMATION

Standard	DIN EN 22568 (DIN 223)	Direction	Right
Thread	UNF	Tolerance	2a
Material	HSS	Form	Form B
Raw material	Steel		

Round die, with spiral point

					Art.-No.
UNF No. 0	80	1,47	16	5	00472000
UNF No. 1	72	1,79	16	5	00472010
UNF No. 2	64	2,12	16	5	00472020
UNF No. 3	56	2,45	16	5	00472030
UNF No. 4	48	2,77	20	5	00472040
UNF No. 5	44	3,1	20	5	00472050
UNF No. 6	40	3,42	20	5	00472060
UNF No. 8	36	4,08	20	7	00472080
UNF No. 10	32	4,73	20	7	00472100
UNF No. 12	28	5,38	20	7	00472120

					Art.-No.
UNF 1/4	28	6,24	20	7	00472130
UNF 5/16	24	7,82	25	9	00472140
UNF 3/8	24	9,41	30	11	00472150
UNF 7/16	20	10,98	30	11	00472160
UNF 1/2	20	12,56	38	10	00472170
UNF 9/16	18	14,14	38	10	00472180
UNF 5/8	18	15,73	45	14	00472190
UNF 3/4	16	18,89	45	14	00472210
UNF 7/8	14	22,05	55	16	00472230
UNF 1 (14)	14	25354	55	16	00472250
UNF 1 (12)	12	25,21	55	16	00472260
UNF 1.1/8	12	28,38	65	18	00472270
UNF 1.1/4	12	31,56	65	18	00472280
UNF 1.3/8	12	34,73	65	18	00472290
UNF 1.1/2	12	37,91	75	20	00472300

ROUND DIES LH

TECHNICAL INFORMATION

Standard	DIN EN 22568 (DIN 223)	Direction	Left
Thread	UNF	Tolerance	2a
Material	HSS	Form	Form B
Raw material	Steel		

Round die, with spiral point

					Art.-No.
UNF No. 10	32	4,73	20	7	00475100
UNF No. 12	28	5,38	20	7	00475120
UNF 1/4	28	6,24	20	7	00475130
UNF 5/16	24	7,82	25	9	00475140
UNF 3/8	24	9,41	30	11	00475150
UNF 7/16	20	10,98	30	11	00475160
UNF 1/2	20	12,56	38	10	00475170
UNF 9/16	18	14,14	38	10	00475180
UNF 5/8	18	15,73	45	14	00475190
UNF 3/4	16	18,89	45	14	00475210
UNF 7/8	14	22,05	55	16	00475230
UNF 1 (14)	14	25354	55	16	00475250
UNF 1 (12)	12	25,21	55	16	00475260

ROUND DIES

TECHNICAL INFORMATION

Standard	DIN EN 22568 (DIN 223)	Direction	Right
Thread	UNEF	Tolerance	2a
Material	HSS	Form	Form B
Raw material	Steel		

Round die, with spiral point

					Art.-No.
UNEF No. 12	32	5,41	20	7	00478010
UNEF 1/4	32	6,27	20	7	00478020
UNEF 5/16	32	7,86	25	9	00478030
UNEF 3/8	32	9,45	30	11	00478040
UNEF 7/16	28	11,0	30	11	00478050
UNEF 1/2	28	12,6	38	10	00478060
UNEF 9/16	24	14,2	38	10	00478070
UNEF 5/8	24	15,8	45	14	00478080
UNEF 11/16	24	17,4	45	14	00478090
UNEF 3/4	20	18,9	45	14	00478100
UNEF 13/16	20	20,5	55	16	00478110
UNEF 7/8	20	22,1	55	16	00478120
UNEF 15/16	20	23,7	55	16	00478130
UNEF 1	20	25,3	55	16	00478140
UNEF 1.1/16	18	26,8	65	18	00478150
UNEF 1.1/8	18	28,4	65	18	00478160
UNEF 1.3/16	18	30,0	65	18	00478170
UNEF 1.1/4	18	31,6	65	18	00478180
UNEF 1.5/16	18	33,2	65	18	00478190
UNEF 1.3/8	18	34,8	65	18	00478200
UNEF 1.7/16	18	36,4	75	20	00478210
UNEF 1.1/2	18	37,9	75	20	00478220

ROUND DIES

TECHNICAL INFORMATION

Standard	DIN EN 22568 (DIN 223)	Direction	Right
Thread	UN / UNS	Tolerance	2a
Material	HSS	Form	Form B
Raw material	Steel		

Round die, with spiral point

					Art.-No.
UNS 1/4	40	6,28	20	5	00466010
UNS 1/4	36	6,27	20	5	00466020
UNS 1/4	24	6,23	20	7	00466030
UNS 1/2	24	12,58	38	10	00466050
UN 11/16	20	17,33	45	14	00466070
UN 11/16	16	17,31	45	14	00466080
UNS 1"	14	25,24	55	16	00466090
UN 1.1/16	12	26,8	65	18	00466100
UN 1.1/8	8	28,34	65	25	00466110
UN 1.1/4	8	31,51	65	25	00466130
UN 1.5/16	12	33,15	65	18	00466140
UN 1.3/8	8	34,69	65	25	00466150
UN 1.1/2	8	37,86	75	20	00466160
UN 1.5/8	12	41,09	75	20	00466170
UN 1.3/4	12	44,26	90	22	00466190
UN 1.3/4	8	44,21	90	22	00466200
UN 2"	12	50,61	90	22	00466230

ROUND DIES

TECHNICAL INFORMATION

Standard	DIN EN 22568 (DIN 223)	Direction	Right
Thread	Pg	Form	Form B
Material	HSS		
Raw material	Steel		

Round die, with spiral point

					Art.-No.
Pg 7	20	12,4	38	10	00490010
Pg 9	18	15,1	38	10	00490020
Pg 11	18	18,5	45	14	00490030
Pg 13,5	18	20,3	45	14	00490040
Pg 16	18	22,4	55	16	00490050
Pg 21	16	28,1	65	18	00490060
Pg 29	16	36,9	65	18	00490070
Pg 36	16	46,9	90	22	00490080
Pg 42	16	53,9	90	22	00490090
Pg 48	16	59,2	105	22	00490100

ROUND DIES

TECHNICAL INFORMATION

Standard	DIN EN 22568 (DIN 223)	Direction	Right
Thread	NPT	Form	Form B
Material	HSS		
Raw material	Steel		

Round die, with spiral point

					Art.-No.
NPT 1/16	27	7,94	25	9	00480010
NPT 1/8	27	10,29	30	11	00480020
NPT 1/4	18	13,72	38	14	00480030
NPT 3/8	18	17,15	45	18	00480040
NPT 1/2	14	21,34	45	18	00480050
NPT 3/4	14	26,67	55	22	00480060
NPT 1	11,5	33,4	65	25	00480070
NPT 1.1/4	11,5	42,16	75	26	00480080
NPT 1.1/2	11,5	48,26	90	27	00480090
NPT 2	11,5	60,33	105	28	00480100

ROUND DIES

TECHNICAL INFORMATION

Standard	DIN EN 22568 (DIN 223)	Direction	Right
Thread	NPTF	Form	Form B
Material	HSS		
Raw material	Steel		

Round die, with spiral point

					Art.-No.
NPTF 1/16	27	7,94	25	9	00482010
NPTF 1/8	27	10,29	30	11	00482020
NPTF 1/4	18	13,72	38	14	00482030
NPTF 3/8	18	17,15	45	18	00482040
NPTF 1/2	14	21,34	45	18	00482050
NPTF 3/4	14	26,67	55	22	00482060
NPTF 1	11,5	33,4	65	25	00482070

ROUND DIES

TECHNICAL INFORMATION

Standard	DIN EN 22568 (DIN 223)	Direction	Right
Thread	NPS	Form	Form B
Material	HSS		
Raw material	Steel		

Round die, with spiral point

					Art.-No.
NPS 1/8	27		38	10	00485010
NPS 1/4	18		38	10	00485020
NPS 3/8	18		45	14	00485030
NPS 1/2	14		45	14	00485040
NPS 3/4	14		65	18	00485050
NPS 1	11,5		65	18	00485060

ROUND DIES

TECHNICAL INFORMATION

Standard	DIN EN 22568 (DIN 223)	Direction	Right
Thread	Tr	Tolerance	7e
Material	HSS	Form	Form B
Raw material	Steel		

Round die, with spiral point

					Art.-No.
Tr 10×2	2	9,91	38	14	00492010
Tr 10×3	3	9,88	38	14	00492020
Tr 12×2	2	11,91	38	14	00492030
Tr 12×3	3	11,88	38	14	00492040
Tr 14×2	2	13,91	38	14	00492050
Tr 14×3	3	13,88	45	18	00492060
Tr 14×4	4	13,85	45	18	00492070
Tr 16×2	2	15,91	45	18	00492080
Tr 16×4	4	15,85	45	18	00492090
Tr 18×2	2	17,91	45	18	00492100
Tr 18×4	4	17,85	45	18	00492110
Tr 20×2	2	19,91	45	18	00492120
Tr 20×4	4	19,85	55	22	00492130
Tr 22×5	5	21,83	55	22	00492140
Tr 24×3	3	23,88	55	22	00492150
Tr 24×5	5	23,83	65	25	00492160
Tr 26×5	5	25,83	65	25	00492170
Tr 28×5	5	27,83	65	25	00492180
Tr 30×6	6	29,81	65	25	00492200
Tr 32×6	6	31,81	65	25	00492210
Tr 36×3	3	35,88	65	25	00492220
Tr 36×6	6	35,81	65	25	00492230

ROUND DIES LH

TECHNICAL INFORMATION

Standard	DIN EN 22568 (DIN 223)	Direction	Left
Thread	Tr	Tolerance	7e
Material	HSS	Form	Form B
Raw material	Steel		

Round die, with spiral point

					Art.-No.
Tr 10×2	2	9,91	38	14	00494010
Tr 10×3	3	9,88	38	14	00494020
Tr 12×3	3	11,88	38	14	00494040
Tr 14×4	4	13,85	45	18	00494070
Tr 16×4	4	15,85	45	18	00494090
Tr 18×4	4	17,85	45	18	00494110
Tr 20×4	4	19,85	55	22	00494130
Tr 24×5	5	23,83	65	25	00494160

ROUND DIES

TECHNICAL INFORMATION

Standard	DIN EN 22568 (DIN 223)	Direction	Right
Thread	Rd	Tolerance	7g
Material	HSS	Form	Form B
Raw material	Steel		

Round die, with spiral point

					Art.-No.
Rd 8	10	7,9	30	11	00496010
Rd 9	10	8,9	38	14	00496020
Rd 10	10	9,9	38	14	00496030
Rd 12	10	11,9	38	14	00496040
Rd 14	8	13,8	45	18	00496050
Rd 16	8	15,8	45	18	00496060
Rd 18	8	17,8	45	18	00496070
Rd 20	8	19,8	55	22	00496080
Rd 22	8	21,8	55	22	00496090
Rd 24	8	23,8	55	22	00496100
Rd 26	8	25,8	65	25	00496110
Rd 28	8	27,8	65	25	00496120
Rd 30	8	29,8	65	25	00496130
Rd 32	8	31,8	65	25	00496140
Rd 36	8	35,8	65	25	00496160

ROUND DIES

TECHNICAL INFORMATION

Standard	DIN EN 22568 (DIN 223)	Direction	Right
Thread	Vg	Form	Form B
Material	HSS		
Raw material	Steel		

Round die, with spiral point, for valve threads according to DIN 7756, thread angle 60°

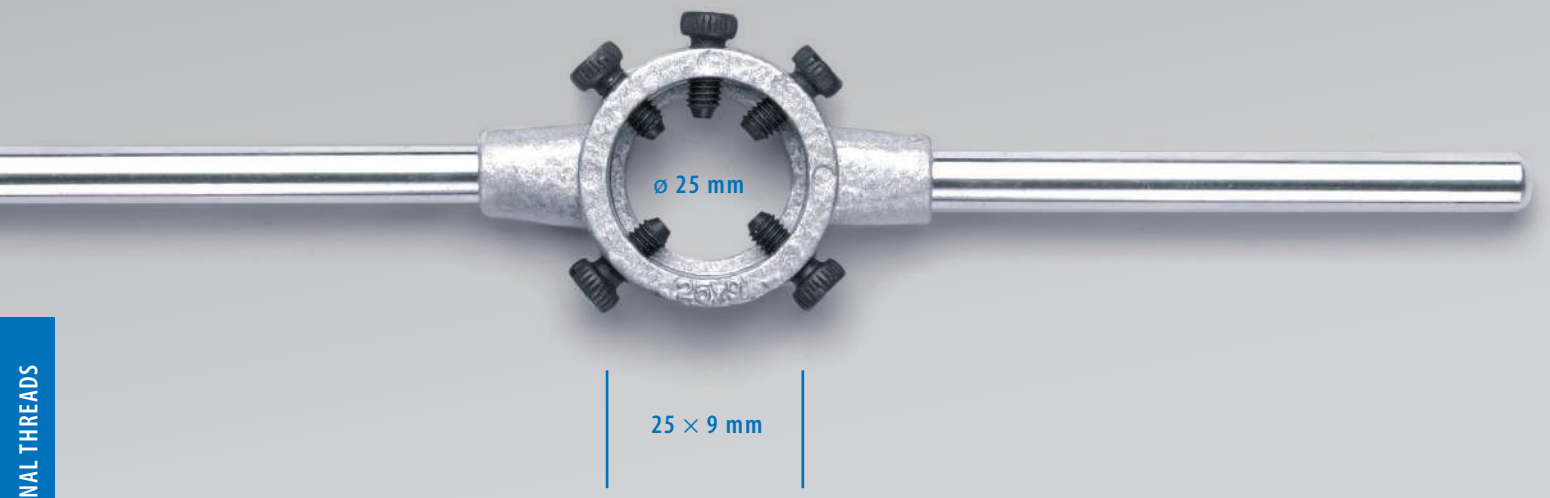
					Art.-No.
Vg 5	36		20	7	00498010
Vg 5,2	24		20	7	00498020
Vg 6	32		20	7	00498030
Vg 8	32		25	9	00498050
Vg 10	28		30	11	00498060
Vg 12	26		30	11	00498070

ROUND DIE GUIDES

TECHNICAL INFORMATION

Material	Aluminium

No.			Art.-No.
1	M 3	2,92	00499001
2	M 4	3,91	00499002
3	M 5	4,9	00499003
4	M 6	5,88	00499004
5	M 8	7,87	00499005
6	M 10	9,95	00499006
7	M 12	11,83	00499007
Set 1–7	M 3–12	—	00499010



M3

M4

M5

M6

M8

M10

M12

COMBINED ROUND DIES

ACCORDING TO FACTORY STANDARD (SIMILAR TO DIN EN 22568)

Round dies that have the same outer diameter of d=25 for the sizes M3, M4, M5, M6, M8, M10 and M12 are called combined round dies. They vary from the DIN EN standard in their outer diameter. Thus, the user only needs one round die holder size 25 x 9 mm for the sizes M3 to M12. (see also: Combined threading tool sets)

COMBINED ROUND DIES

TECHNICAL INFORMATION

Standard	Factory Standard	Direction	Right
Thread	M	Tolerance	6g
Material	HSS	Form	Form B
Raw material	Steel		

Round die, diameter 25 x 9 mm

					Art.-No.
M 3	0,5	2,92	25	9	00403130
M 4	0,7	3,91	25	9	00403150
M 5	0,8	4,9	25	9	00403170
M 6	1,0	5,88	25	9	00403190
M 8	1,25	7,87	25	9	00403210
M 10	1,5	9,85	25	9	00403230
M 12	1,75	11,83	25	9	00403250

COMBINED ROUND DIE GUIDES

TECHNICAL INFORMATION

Material	Aluminium

For round die holders according to factory standard, d=25mm

No.			Art.-No.
1	M 3	2,92	00499101
2	M 4	3,91	00499102
3	M 5	4,9	00499103
4	M 6	5,88	00499104
5	M 8	7,87	00499105
6	M 10	9,95	00499106
7	M 12	11,83	00499107
Set 1–7	M 3–12	—	00499110

M16
6g

HSS
M18
6g

HSS
M4
6g

M10

M16

M4

HEXAGON DIE NUTS

DIN 382

M6

Hexagon die nuts are used for assembly works and re-cutting of threads with low and medium tensile strength. The standardized key metrics of the hexagon enable the usage of ring wrenches and open-end wrenches as operating tools. The hexagon's surfaces are abrasion resistant and corrosion-resistant burnished.

M3

M18

HEXAGON DIE NUTS DIN 382

HEXAGON DIE NUTS

TECHNICAL INFORMATION

Standard	DIN 382	Direction	Right
Thread	M	Tolerance	6g
Material	HSS		
Raw material	Steel		

					Art.-No.
M 3	0,5	2,92	19	5	00502130
M 3,5	0,6	3,41	19	5	00502140
M 4	0,7	3,91	19	5	00502150
M 4,5	0,75	4,41	19	7	00502160
M 5	0,8	4,9	19	7	00502170
M 5,5	0,9	5,4	19	7	00502180
M 6	1,0	5,88	19	7	00502190
M 7	1,0	6,88	22	9	00502200
M 8	1,25	7,87	22	9	00502210
M 9	1,25	8,87	22	9	00502220
M 10	1,5	9,85	27	11	00502230
M 11	1,5	10,85	27	11	00502240
M 12	1,75	11,83	36	14	00502250
M 14	2,0	13,82	36	14	00502260
M 16	2,0	15,82	41	18	00502270
M 18	2,5	17,79	41	18	00502280
M 20	2,5	19,79	41	18	00502290
M 22	2,5	21,79	50	22	00502300
M 24	3,0	23,77	50	22	00502310
M 27	3,0	26,77	60	25	00502320
M 30	3,5	29,73	60	25	00502330
M 33	3,5	32,73	60	25	00502340
M 36	4,0	35,7	60	25	00502350
M 39	4,0	38,7	70	30	00502360
M 42	4,5	41,69	70	30	00502370
M 45	4,5	44,69	85	36	00502380
M 48	5,0	47,66	85	36	00502390
M 52	5,0	51,66	85	36	00502400
M 56	5,0	51,66	85	36	00502410
M 60	5,5	59,62	100	36	00502420
M 64	6,0	63,58	115	36	00502430
M 68	6,0	67,58	115	36	00502440
M 70	6,0	69,58	120	36	00502450
M 72	6,0	71,58	120	36	00502460
M 76	6,0	75,58	120	36	00502470
M 80	6,0	79,58	130	36	00502480

HEXAGON DIE NUTS LH

TECHNICAL INFORMATION

Standard	DIN 382	Direction	Left
Thread	M	Tolerance	6g
Material	HSS		
Raw material	Steel		

					Art.-No.
M 3	0,5	2,92	20	5	00504130
M 4	0,7	3,91	20	5	00504150
M 5	0,8	4,9	20	7	00504170
M 6	1,0	5,88	20	7	00504190
M 7	1,0	6,88	25	9	00504200
M 8	1,25	7,87	25	9	00504210
M 10	1,5	9,85	30	11	00504230
M 12	1,75	11,83	38	14	00504250
M 14	2,0	13,82	38	14	00504260
M 16	2,0	15,82	45	18	00504270
M 18	2,5	17,79	45	18	00504280
M 20	2,5	19,79	45	18	00504290
M 22	2,5	21,79	55	22	00504300
M 24	3,0	23,77	55	22	00504310
M 27	3,0	26,77	65	25	00504320
M 30	3,5	29,73	65	25	00504330
M 33	3,5	32,73	65	25	00504340
M 36	4,0	35,7	65	25	00504350
M 39	4,0	38,7	75	30	00504360
M 42	4,5	41,69	75	30	00504370
M 45	4,5	44,69	90	36	00504380
M 48	5,0	47,66	90	36	00504390
M 52	5,0	51,66	90	36	00504400

HEXAGON DIE NUTS DIN 382

HEXAGON DIE NUTS

TECHNICAL INFORMATION

Standard	DIN 382	Direction	Right
Thread	MF	Tolerance	6g
Material	HSS		
Raw material	Steel		

					Art.-No.
MF 3 × 0,35	0,35	2,65	19	5	00514200
MF 3,5 × 0,35	0,35	3,44	19	5	00514220
MF 4 × 0,35	0,35	3,65	19	5	00514230
MF 4 × 0,5	0,5	3,93	19	5	00514240
MF 4,5 × 0,5	0,5	4,43	19	5	00514260
MF 5 × 0,5	0,5	4,5	19	5	00514280
MF 5 × 0,75	0,75	4,91	19	5	00514290
MF 6 × 0,5	0,5	5,93	19	5	00514320
MF 6 × 0,75	0,75	5,25	19	7	00514330
MF 7 × 0,75	0,75	6,91	22	9	00514360
MF 8 × 0,5	0,5	7,93	22	9	00514380
MF 8 × 0,75	0,75	7,25	22	9	00514390
MF 8 × 1	1,0	7,0	22	9	00514400
MF 8 × 1,5	1,5	7,85	22	9	00514410
MF 9 × 0,75	0,75	8,91	22	9	00514430
MF 9 × 1	1,0	8,88	22	9	00514440
MF 10 × 0,5	0,5	9,93	27	11	00514450
MF 10 × 0,75	0,75	9,91	27	11	00514460
MF 10 × 1	1,0	9,0	27	11	00514470
MF 10 × 1,25	1,25	9,87	27	11	00514480
MF 11 × 1	1,0	10,88	27	11	00514510
MF 11 × 1,25	1,25	10,87	27	11	00514520
MF 12 × 0,5	0,5	11,93	36	10	00514530
MF 12 × 0,75	0,75	11,91	36	10	00514540
MF 12 × 1	1,0	11,88	36	10	00514550
MF 12 × 1,25	1,25	11,87	36	10	00514560
MF 12 × 1,5	1,5	10,5	36	10	00514570
MF 13 × 1	1,0	12,88	36	10	00514600
MF 13 × 1,25	1,25	12,87	36	10	00514610
MF 13 × 1,5	1,5	12,85	36	10	00514620
MF 14 × 0,75	0,75	13,91	36	10	00514640
MF 14 × 1	1,0	13,88	36	10	00514650
MF 14 × 1,25	1,25	12,75	36	10	00514660
MF 14 × 1,5	1,5	12,5	36	10	00514670
MF 15 × 1	1,0	14,88	36	10	00514700
MF 15 × 1,5	1,5	14,85	36	10	00514720

					Art.-No.
MF 16 × 0,75	0,75	15,98	41	14	00514740
MF 16 × 1	1,0	15,88	41	14	00514750
MF 16 × 1,25	1,25	15,86	41	14	00514760
MF 16 × 1,5	1,5	14,5	41	14	00514770
MF 17 × 1	1,0	16,88	41	14	00514790
MF 17 × 1,5	1,5	16,85	41	14	00514800
MF 18 × 1	1,0	17,88	41	14	00514840
MF 18 × 1,25	1,25	17,86	41	14	00514850
MF 18 × 1,5	1,5	16,5	41	14	00514860
MF 18 × 2	2,0	16,0	41	14	00514870
MF 19 × 1,5	1,5	18,85	41	14	00514890
MF 20 × 1	1,0	19,88	41	14	00514930
MF 20 × 1,25	1,25	19,86	41	14	00514940
MF 20 × 1,5	1,5	18,5	41	14	00514950
MF 20 × 2	2,0	18,0	41	14	00514960
MF 21 × 1,5	1,5	20,85	50	16	00515000
MF 22 × 1	1,0	21,88	50	16	00515030
MF 22 × 1,25	1,25	21,86	50	16	00515040
MF 22 × 1,5	1,5	20,5	50	16	00515050
MF 22 × 2	2,0	20,0	50	16	00515060
MF 23 × 1,5	1,5	22,85	50	16	00515080
MF 24 × 1	1,0	23,88	50	16	00515110
MF 24 × 1,25	1,25	23,86	50	16	00515120
MF 24 × 1,5	1,5	22,5	50	16	00515130
MF 24 × 2	2,0	22,0	50	16	00515140
MF 25 × 1	1,0	24,88	50	16	00515150
MF 25 × 1,5	1,5	24,85	50	16	00515170
MF 25 × 2	2,0	24,82	50	16	00515180
MF 26 × 1	1,0	25,88	50	16	00515190
MF 26 × 1,5	1,5	24,5	60	18	00515210
MF 26 × 2	2,0	24,0	60	18	00515220
MF 27 × 1	1,0	26,88	60	18	00515230
MF 27 × 1,5	1,5	25,5	60	18	00515240
MF 27 × 2	2,0	25,0	60	18	00515250
MF 28 × 1	1,0	27,88	60	18	00515260
MF 28 × 1,5	1,5	26,5	60	18	00515270
MF 28 × 2	2,0	26,0	60	18	00515280
MF 30 × 1	1,0	29,88	60	18	00515290
MF 30 × 1,5	1,5	28,5	60	18	00515300
MF 30 × 2	2,0	28,0	60	18	00515310
MF 30 × 3	3,0	29,76	60	25	00515320
MF 32 × 1	1,0	31,88	60	18	00515330
MF 32 × 1,5	1,5	30,5	60	18	00515340
MF 32 × 2	2,0	31,82	60	18	00515350

HEXAGON DIE NUTS DIN 382

					Art.-No.
MF 33 × 1	1,0	32,88	60	18	00515370
MF 33 × 1,5	1,5	32,85	60	18	00515380
MF 33 × 2	2,0	32,82	60	18	00515390
MF 33 × 3	3,0	32,76	60	25	00515400
MF 34 × 1	1,0	33,88	60	18	00515410
MF 34 × 1,5	1,5	33,85	60	18	00515420
MF 34 × 2	2,0	33,82	60	18	00515430
MF 35 × 1	1,0	34,88	60	18	00515450
MF 35 × 1,5	1,5	33,5	60	18	00515460
MF 35 × 2	2,0	34,82	60	18	00515470
MF 36 × 1	1,0	35,88	60	18	00515490
MF 36 × 1,5	1,5	34,5	60	18	00515500
MF 36 × 2	2,0	35,82	60	18	00515510
MF 36 × 3	3,0	35,76	60	25	00515520
MF 38 × 1	1,0	37,88	70	20	00515530
MF 38 × 1,5	1,5	36,5	70	20	00515540
MF 38 × 2	2,0	37,82	70	20	00515550
MF 38 × 3	3,0	37,76	70	20	00515560
MF 39 × 1,5	1,5	38,85	70	20	00515570
MF 39 × 2	2,0	38,82	70	20	00515580
MF 39 × 3	3,0	38,76	70	20	00515590
MF 40 × 1	1,0	39,88	70	20	00515600
MF 40 × 1,5	1,5	38,5	70	20	00515610
MF 40 × 2	2,0	39,82	70	20	00515620
MF 40 × 3	3,0	39,76	70	20	00515630
MF 42 × 1,5	1,5	40,5	70	20	00515640
MF 42 × 2	2,0	41,82	70	20	00515650
MF 42 × 3	3,0	41,76	70	20	00515660
MF 45 × 1	1,0	44,88	85	22	00515680
MF 45 × 1,5	1,5	44,85	85	22	00515690
MF 45 × 2	2,0	44,82	85	22	00515700
MF 45 × 3	3,0	44,76	85	22	00515710
MF 48 × 1,5	1,5	47,85	85	22	00515740
MF 48 × 2	2,0	47,82	85	22	00515750
MF 48 × 3	3,0	47,76	85	22	00515760
MF 48 × 4	4,0	47,68	85	22	00515770
MF 50 × 1,5	1,5	49,85	85	22	00515790
MF 50 × 2	2,0	49,82	85	22	00515800
MF 50 × 3	3,0	49,76	85	22	00515810
MF 52 × 1,5	1,5	51,85	85	22	00515840
MF 52 × 2	2,0	51,82	85	22	00515850
MF 52 × 3	3,0	51,76	85	22	00515860

HEXAGON DIE NUTS LH

TECHNICAL INFORMATION

Standard	DIN 382	Direction	Left
Thread	MF	Tolerance	6g
Material	HSS		
Raw material	Steel		

					Art.-No.
MF 8 × 1	1,0	7,88	22	9	00517400
MF 10 × 1	1,0	9,88	27	11	00517470
MF 12 × 1,5	1,5	11,85	36	10	00517570
MF 14 × 1,5	1,5	13,85	36	10	00517670
MF 16 × 1,5	1,5	15,85	41	14	00517770
MF 18 × 1,5	1,5	17,85	41	14	00517860
MF 20 × 1,5	1,5	19,85	41	14	00517950
MF 22 × 1,5	1,5	21,85	50	16	00518050
MF 24 × 1,5	1,5	23,85	50	16	00518130
MF 26 × 1,5	1,5	25,85	60	18	00518210
MF 28 × 1,5	1,5	27,85	60	18	00518270
MF 30 × 1,5	1,5	29,85	60	18	00518300

HEXAGON DIE NUTS

TECHNICAL INFORMATION

Standard	DIN 382	Direction	Right
Thread	BSW		
Material	HSS		
Raw material	Steel		

					Art.-No.
BSW 1/8	40	2,6	19	5	00536030
BSW 5/32	32	3,88	19	5	00536040
BSW 3/16	24	3,8	19	7	00536050
BSW 7/32	24	5,43	19	7	00536060
BSW 1/4	20	5,1	19	7	00536070
BSW 5/16	18	6,5	22	9	00536080
BSW 3/8	16	7,9	27	11	00536090
BSW 7/16	14	9,3	27	11	00536100
BSW 1/2	12	10,5	36	14	00536110
BSW 9/16	12	12,0	36	14	00536120
BSW 5/8	11	13,5	41	18	00536130
BSW 3/4	10	16,5	41	18	00536140

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					Art.-No.
BSW 7/8	9	19,5	50	22	00536150
BSW 1	8	22,0	50	22	00536160
BSW 1.1/8	7	25,0	60	25	00536170
BSW 1.1/4	7	28,0	60	25	00536180
BSW 1.3/8	6	30,5	60	25	00536190
BSW 1.1/2	6	33,5	70	30	00536200
BSW 1.5/8	5	40,76	70	30	00536210
BSW 1.3/4	5	39,0	85	36	00536220
BSW 1.7/8	4,5	47,08	85	36	00536230
BSW 2	4,5	44,5	85	36	00536240
BSW 2.1/4	4	56,57	100	36	00536250
BSW 2.1/2	4	62,92	115	36	00536260
BSW 2.3/4	3,5	69,27	115	36	00536270
BSW 3	3,5	75,62	115	36	00536280

HEXAGON DIE NUTS

TECHNICAL INFORMATION

Standard	DIN 382	Direction	Right
Thread	BSF		
Material	HSS		
Raw material	Steel		

					Art.-No.
BSF 3/16	32	4,0	19	7	00544040
BSF 1/4	26	5,3	19	7	00544060
BSF 5/16	22	6,8	22	9	00544070
BSF 3/8	20	8,3	27	11	00544080
BSF 7/16	18	9,7	27	11	00544090
BSF 1/2	16	11,1	36	10	00544100
BSF 9/16	16	12,7	36	10	00544110
BSF 5/8	14	14,0	41	14	00544120
BSF 3/4	12	16,8	41	14	00544140
BSF 7/8	11	19,8	50	16	00544160
BSF 1	10	22,8	50	16	00544180

HEXAGON DIE NUTS

TECHNICAL INFORMATION

Standard	DIN 382	Direction	Right
Thread	BSP		
Material	HSS		
Raw Material	Steel		

					Art.-No.
BSP 1/8	28	8,8	36	10	00552020
BSP 1/4	19	11,8	36	10	00552060
BSP 3/8	19	15,3	41	14	00552080
BSP 1/2	14	19,0	41	14	00552100
BSP 5/8	14	21,0	50	16	00552120
BSP 3/4	14	24,5	60	18	00552130
BSP 7/8	14	28,3	60	18	00552140
BSP 1	11	30,5	60	18	00552150
BSP 1.1/8	11	35,5	70	22	00552170
BSP 1.1/4	11	39,5	70	22	00552180
BSP 1.3/8	11	42,0	85	22	00552190
BSP 1.1/2	11	45,0	85	22	00552200
BSP 1.3/4	11	51,0	100	22	00552210
BSP 2	11	57,0	100	22	00552220
BSP 2.1/4	11	65,49	115	22	00552240
BSP 2.1/2	11	74,97	115	22	00552250
BSP 2.3/4	11	81,32	115	22	00552260
BSP 3	11	87,67	130	25	00552270

HEXAGON DIE NUTS

TECHNICAL INFORMATION

Standard	DIN 382	Direction	Right
Thread	BSPT		
Material	HSS		
Raw material	Steel		

					Art.-No.
BSPT 1/4	19		28	12,7	00553060
BSPT 3/8	19		33	15,9	00553080
BSPT 1/2	14		42	20,6	00553100
BSPT 3/4	14		52	23,8	00553130
BSPT 1	11		65	28,5	00553150

HEXAGON DIE NUTS DIN 382

HEXAGON DIE NUTS LH

TECHNICAL INFORMATION

Standard	DIN 382	Direction	Left
Thread	BSP		
Material	HSS		
Raw material	Steel		

					Art.-No.
BSP 1/8	28	9,62	36	10	00556010
BSP 1/4	19	13,03	36	10	00556020
BSP 3/8	19	16,54	41	14	00556030
BSP 1/2	14	20,81	41	14	00556040
BSP 5/8	14	22,77	50	16	00556050
BSP 3/4	14	26,3	60	18	00556060
BSP 7/8	14	30,06	60	18	00556070
BSP 1	11	33,07	60	18	00556080
BSP 1.1/8	11	37,72	70	22	00556090
BSP 1.1/4	11	41,73	70	22	00556100
BSP 1.3/8	11	44,14	85	22	00556110
BSP 1.1/2	11	47,62	85	22	00556120
BSP 1.3/4	11	53,57	100	22	00556220
BSP 2	11	59,43	100	22	00556230

HEXAGON DIE NUTS

TECHNICAL INFORMATION

Standard	DIN 382	Direction	Right
Thread	UNC	Tolerance	2a
Material	HSS		
Raw material	Steel		

					Art.-No.
UNC No. 10	24	4,71	19	7	00562100
UNC No. 12	24	5,37	19	7	00562120
UNC 1/4	20	5,2	19	7	00562130
UNC 5/16	18	6,6	22	9	00562140
UNC 3/8	16	8,0	27	11	00562150
UNC 7/16	14	9,4	27	11	00562160
UNC 1/2	13	10,8	36	14	00562170
UNC 9/16	12	12,3	36	14	00562180
UNC 5/8	11	13,5	41	18	00562190
UNC 3/4	10	16,5	41	18	00562210
UNC 7/8	9	19,5	50	22	00562230
UNC 1	8	22,3	50	22	00562250
UNC 1.1/8	7	25,0	60	25	00562260
UNC 1.1/4	7	28,3	60	25	00562270
UNC 1.3/8	6	30,8	60	25	00562280
UNC 1.1/2	6	34,0	70	30	00562290
UNC 1.3/4	5	39,5	85	36	00562310
UNC 2	4,5	45,0	85	36	00562330

HEXAGON DIE NUTS DIN 382

HEXAGON DIE NUTS

TECHNICAL INFORMATION

Standard	DIN 382	Direction	Right
Thread	UNF	Tolerance	2a
Material	HSS		
Raw material	Steel		

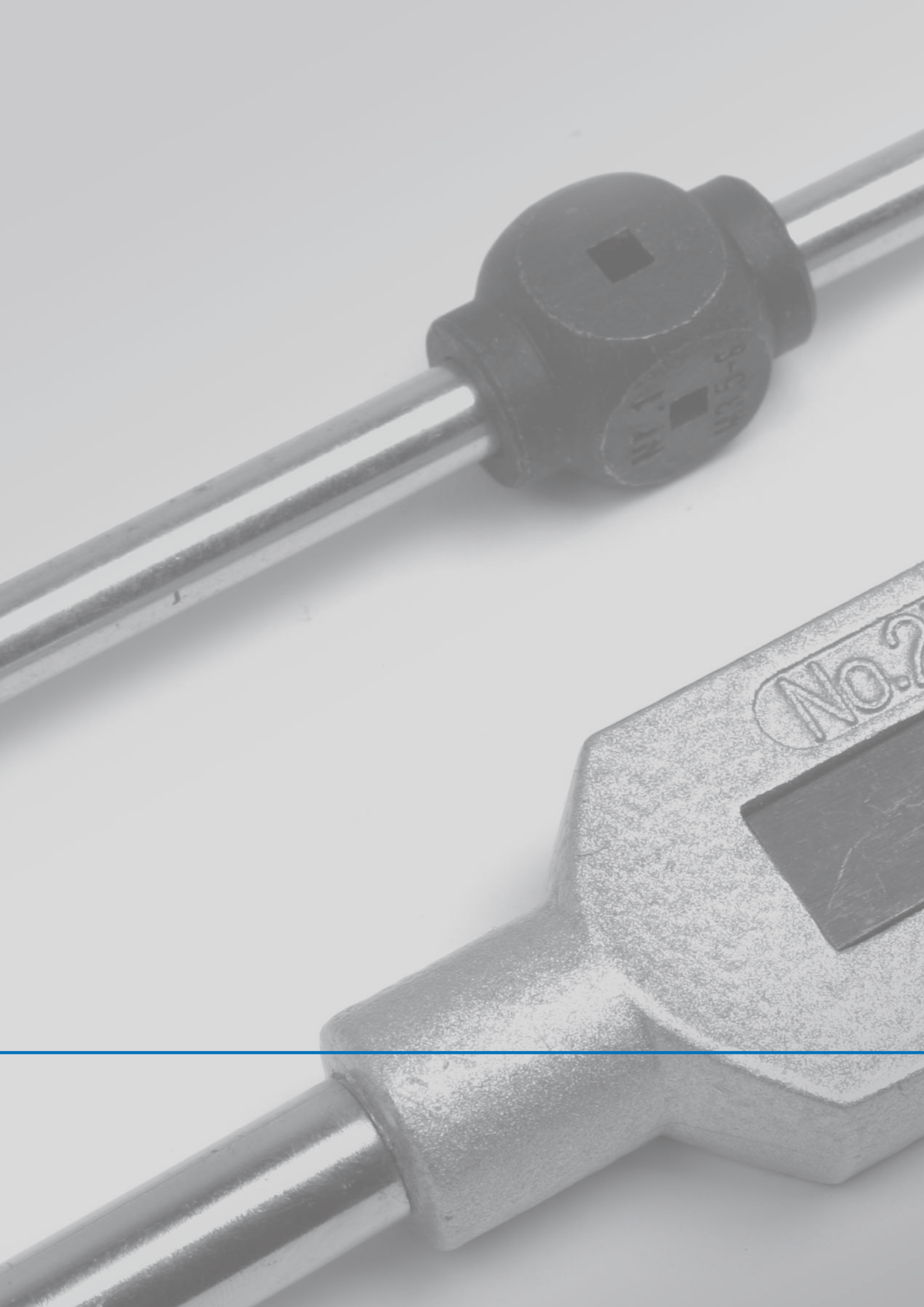
					Art.-No.
UNF No. 10	32	4,73	18	7	00572100
UNF No. 12	28	5,38	18	7	00572120
UNF 1/4	28	6,24	19	7	00572130
UNF 5/16	24	7,82	22	9	00572140
UNF 3/8	24	9,41	27	11	00572150
UNF 7/16	20	10,98	27	11	00572160
UNF 1/2	20	12,56	36	10	00572170
UNF 9/16	18	14,14	36	10	00572180
UNF 5/8	18	15,73	41	14	00572190
UNF 3/4	16	18,89	41	14	00572210
UNF 7/8	14	22,05	50	16	00572230
UNF 1	12	25,21	50	16	00572250
UNF 1.1/8	12	28,38	60	18	00572270
UNF 1.1/4	12	31,56	60	18	00572280
UNF 1.3/8	12	34,73	60	18	00572290
UNF 1.1/2	12	37,91	70	20	00572300

HEXAGON DIE NUTS

TECHNICAL INFORMATION

Standard	DIN 382	Direction	Right
Thread	NPT		
Material	HSS		
Raw material	Steel		

					Art.-No.
NPT 1/8	27	9,93	27	11	00580020
NPT 1/4	18	13,18	36	14	00580030
NPT 3/8	18	16,6	41	14	00580040
NPT 1/2	14	20,63	41	18	00580050
NPT 3/4	14	25,95	60	18	00580060
NPT 1	11,5	32,51	60	25	00580070

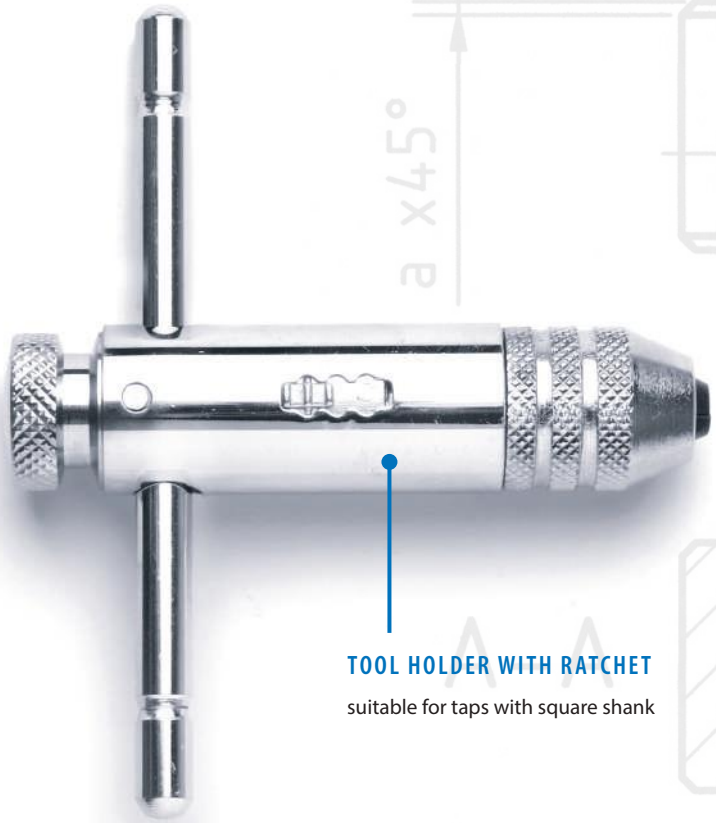


TOOL HOLDERS

Adjustable tap wrenches and round die holders are summarised under the term tool holders. Taps are mounted into the adjustable tap wrench. The square shank of the tap is fixed with the clawing jams. As the clawing jams are adjustable, taps with different square shank sizes can be used. The clawing jams are moved by rotating a handle of the tap wrench. Cutting by hand is simplified, as the length of the handles will give you more leverage. Screw extractors or hand reamers can also be used with the tap wrench. The design of the tap wrench makes it easy to position the tap correctly. Design elements of adjustable tap wrenches are known for over 100 years and have not really changed since. However, the materials have changed. Nowadays, the body's material is die-cast zinc instead of grey cast iron.

At the beginning of the last century, die holders for round dies were completely unknown. External threads were cut with slanted or straight die stocks, that later became outdated and were replaced by round dies. Round dies are placed into the die holder and fixed with the five screws. Usually, the body is made out of die-cast zinc.

TOOL HOLDERS



TOOL HOLDER WITH RATCHET

suitable for taps with square shank

TOOL HOLDERS AND TAP WRENCHES

TOOL HOLDERS

Tool holders with a switchable ratchet are designed for mounting taps with square shanks into the hardened two-jaw drill chuck. The body is completely made out of steel. Clockwise and counter clockwise rotation can be set with a slider. The rotary handle can be locked at three positions.
The tool holder is available in two sizes: for taps M3 to M10 as well as for taps M5 to M12.

LONG VERSION

CHUCK

suitable for taps with square shanks according to DIN 10

ADJUSTABLE TAP WRENCH

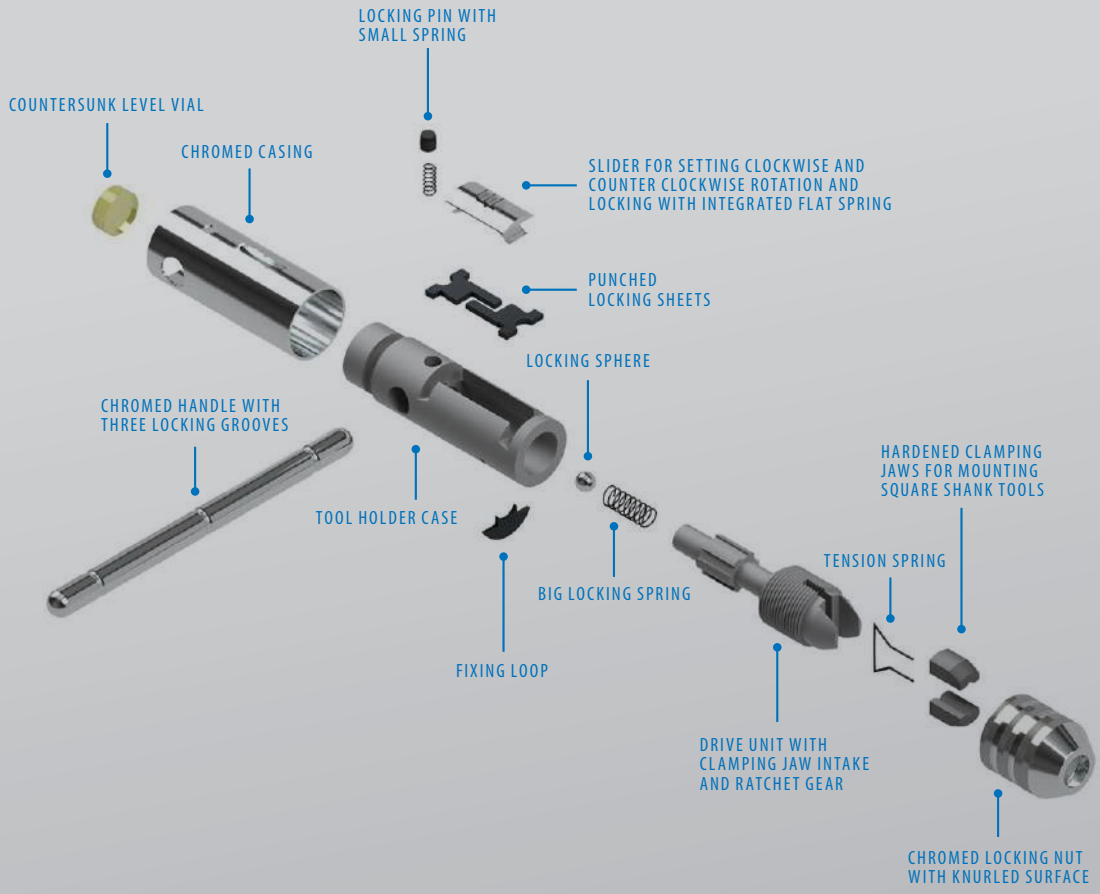
The adjustable tap wrench with hardened clamping jaws made from steel has knurled steel handles that are unscrewable on one side. It is suitable for taps with square shanks as well as tap extensions. The body is made from die-cast zinc according to DIN 1743.

TAP EXTENSION

suitable for taps with square shanks according to DIN 10

Square Shank size	Size M for taps	Total length
2,1 mm	1,0 – 2,6	60 mm
2,4 mm	—	70 mm
2,7 mm	3	80 mm
3,0 mm	3,5	90 mm
3,4 mm	4	95 mm
3,8 mm	—	100 mm
4,3 mm	—	105 mm
4,9 mm	5 – 8	110 mm
5,5 mm	9 – 10	115 mm
6,2 mm	11	120 mm
7,0 mm	12	125 mm
8,0 mm	—	125 mm
9,0 mm	14	130 mm
11,0 mm	18	150 mm
12,0 mm	20	155 mm
14,5 mm	22	175 mm
16,0 mm	27	180 mm
18,0 mm	30	200 mm
20,0 mm	33	220 mm
22,0 mm	34 – 36	220 mm
24,0 mm	39 – 42	235 mm
26,0 mm	—	250 mm
29,0 mm	45 – 48	265 mm
32,0 mm	50 – 52	285 mm
35,0 mm	—	300 mm
35,5 mm	56 – 60	320 mm

TOOL HOLDER WITH LEVEL VIAL



TOOL HOLDER WITH RATCHET

Like all other tool holders in our product range, our GSR product innovation also has an adjustable ratchet and belongs to the group of tool holders. These tool holders are suitable for mounting especially taps with square shanks. The adjustable and hardened clamping jaws enable the use of square shanks of different sizes.

Furthermore, they are parallel chipping and replaceable. The body is seamlessly made of steel and chromed. The inserted and durable cross-handle is adjustable in both directions and has three grooves to enable the usage of the tool holder even in areas difficult to access.

The chuck as well as the tool head both have a round and knurled surface. This enables an even better grip of the tool holder. However, the true innovation of the product can be found in the tool head. A countersunk level vial facilitates a simple alignment of the whole tool holder and guarantees a clean cutting result.

Our tool holder with ratchet and integrated level vial can not only be used for cutting threads. All tools with square shanks can be mounted into the tool holder. *(On page 273 you can find different versions).*

TOOL HOLDER WITH RATCHET

suitable for taps with square shank

ADJUSTABLE TAP WRENCHES

TECHNICAL INFORMATION

Standard	DIN 1814
Material	Die-cast zinc

Size	Suitable for	Suitable for	Suitable for	Total length	Art.-No.
No. 0	W 1/16-5/16	—	M 1-8	130	00600020
No. 1	W 1/16-3/8	—	M 1-10	175	00600030
No. 1.1/2	W 1/16-1/2	G 1/8	M 1-12	175	00600040
No. 2	W 5/32-1/2	G 1/8	M 4-12	280	00600050
No. 3	W 7/32-3/4	G 1/8-1/2	M 5-20	375	00600060
No. 4	W 7/16-1	G 1/4-3/4	M 9-27	470	00600070
No. 5	W 1/2-1.1/4	G 1/4-1	M 12-33	700	00600080

ADJUSTABLE TAP WRENCHES

TECHNICAL INFORMATION

Standard	DIN 1814
Material	Steel

Size	Suitable for	Suitable for	Suitable for	Total length	Art.-No.
No. 0	W 1/16-5/16	—	M 1-8	130	00602020
No. 1	W 1/16-3/8	—	M 1-10	180	00602030
No. 1.1/2	W 1/16-1/2	G 1/8	M 1-12	180	00602040
No. 2	W 5/32-1/2	G 1/8	M 4-12	280	00602050
No. 3	W 7/32-3/4	G 1/8-1/2	M 5-20	380	00602060
No. 4	W 7/16-1	G 1/4-3/4	M 9-27	515	00602070
No. 5	W 1/2-1.1/4	G 1/4-1	M 12-33	700	00602080
No. 6	W 3/4-1.5/8	G 1/2-1 1/4	M 18-42	1000	00602090
No. 7	W 1 - 2.1/8	G 3/4-1 3/4	M 25-52	1250	00602100
No. 8	W 1-2.1/2	G 3/4-3	M 25-68	1250	00602110

BALL-TYPE TAP WRENCHES

TECHNICAL INFORMATION

Material Steel

For square shanks according to DIN 10

Size	Suitable for	Suitable for	Suitable for	Total length	Art.-No.
No. 0	W 1/16-5/32	—	M 1-4	200	00604020
No. 1	W 5/32-5/16	—	M 4-8	200	00604030
No. 2	W 5/32-3/8	G 1/8	M 4-10	240	00604050
No. 3	W 3/16-1/2	—	M 5-12	300	00604060
No. 4	W 3/8-5/8	G 1/8-3/8	M 10-16	340	00604070
No. 5	W 1/2-3/4	G 1/4-1/2	M 12-20	500	00604080
No. 6	W 3/4-1	G 1/2-3/4	M 18-27	650	00604090

TOOL HOLDERS

TECHNICAL INFORMATION

with ratchet

Size	Suitable for	Total length	Art.-No.
No. 1	M3 – M10	85	00612020
No. 2	M5 – M12	100	00612030

TOOL HOLDER

TECHNICAL INFORMATION

with ratchet

long version

Size	Suitable for	Total length	Art.-No.
No. 10	M3- M10	250	00614020
No. 20	M5- M12	300	00614030

TOOL HOLDERS WITH LEVEL VIAL

TECHNICAL INFORMATION

with ratchet

Size	Suitable for	Total length	Art.-No.
No. 1	M3 – M10	85	00612120
No. 2	M5 – M12	100	00612130

TOOL HOLDERS WITH LEVEL VIAL

TECHNICAL INFORMATION

with ratchet

long version

Size	Suitable for	Total length	Art.-No.
No. 10	M3- M10	250	00614120
No. 20	M5- M12	300	00614130

TAP EXTENSIONS

TECHNICAL INFORMATION

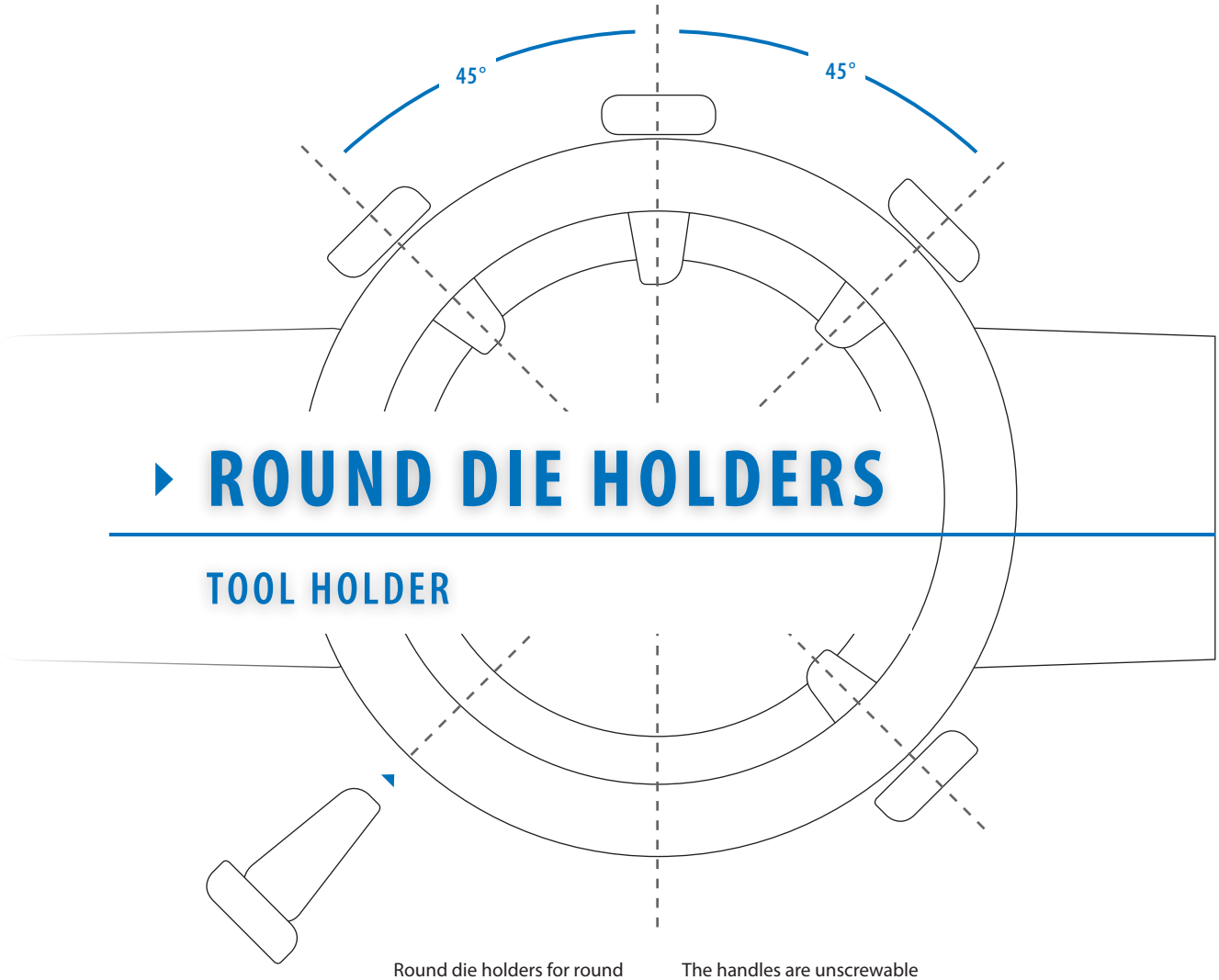
Standard	DIN 377
Material	Steel
square shank according to DIN 10	

Square shank	Length	for taps according to DIN 352 BSW	for taps according to DIN 352 M	Art.-No.
2,1	60	W 1/16 - 3/32	M1-M2,6	00620010
2,4	70	—	—	00620015
2,7	80	W 1/8	M3	00620020
3	90	—	M3,5	00620030
3,4	95	W 5/32	M4	00620040
3,8	100	—	—	00620050
4,3	105	W 3/16	—	00620060
4,9	110	W 7/32 - 5/16	M4,5-M8	00620070
5,5	115	W 3/8	M9-M10	00620080
6,2	120	W 7/16	M11	00620090
7	125	W 1/2	M12	00620100
8	125	—	—	00620110
9	130	W 9/16 - 5/8	M14-M16	00620120
10	140	—	—	00620130
11	150	W 11/16 - 3/4	M18	00620140
12	155	W 13/16	M20	00620150
13	165	—	—	00620155
14,5	175	W 7/8 - 15/16	M22-M24	00620160
16	180	W 1"; M 25 - 27"	M27	00620170
18	200	W 1.1/8	M30	00620180
20	220	W 1.1/4	M33	00620190
22	220	W 1.3/8	M36	00620200
24	235	W 1.1/2 - 1.5/8	M39-M42	00620210
26	250	—	—	00620220
29	265	W 1.3/4 - 1.7/8	M45-M48	00620230
32	285	W 2 - 2.1/4"	M52	00620240
35	300	W 2.1/4 - 2.1/2	—	00620250
35,5	320	—	M56-M60	00620260

45°
CHAMFERED
LOCKING SCREW
ASSEMBLY
for an easy assembly of the round die holder, a standard screwdriver can be used
HSS
6g
M8
M24
6g
HSS

ROUND DIE HOLDERS
DIN 225 · 38 × 14

	Description
DIN EN 22568	= German Institute for Standardisation
38 = d	Inner diameter of the chuck = outer diameter of the round die
14 = h	height of the chuck = width of the round die



ROUND DIE HOLDERS

TOOL HOLDER

Round die holders for round dies with an outer diameter of d=16mm and d=20mm have four locking screws. The bigger die holders have five chamfered locking screws.

The handles are unscrewable on both sides and made of steel with a polished, galvanised surface. The body is die-cast zinc according to DIN 1743.

ROUND DIE HOLDER

ROUND DIE HOLDERS

TECHNICAL INFORMATION

Standard	DIN EN 22568 (225)
Material	Die-cast zinc

Size	Suitable for	Suitable for	Total length	Art.-No.
16 × 5	W 1/6 - 3/32	M 1 - 2,6	160	00633010
20 × 5	W 1/8 - 5/32	M 3 - 4	195	00633020
20 × 7	W 3/16 - 1/4	M 4,5 - 6	195	00633030
25 × 9	W 5/16	M 7 - 9	215	00633040
30 × 11	W 3/8 - 7/16	M 10 - 11	260	00633050
38 × 14	W 1/2 - 9/16	M 12 - 14	315	00633060
38 × 10	G 1/4	MF 12 - 15	315	00633070
45 × 18	W 5/8 - 13/16	M 16 - 20	445	00633080
45 × 14	G 3/8 - 1/2	MF 16 - 20	445	00633090
55 × 22	W 7/8 - 1	M 22 - 24	495	00633100
55 × 16	G 5/8 - 3/4	MF 22 - 26	495	00633110
65 × 25	W 1.1/8-1.3/8	M 27 - 36	630	00633120
65 × 18	G 7/8 - 1	MF 27 - 36	630	00633130
75 × 30	W 1.1/2 - 1.5/8	M 39 - 42	700	00633140
75 × 20	G 1.1/8 - 1.1/4	MF 38 - 42	700	00633150

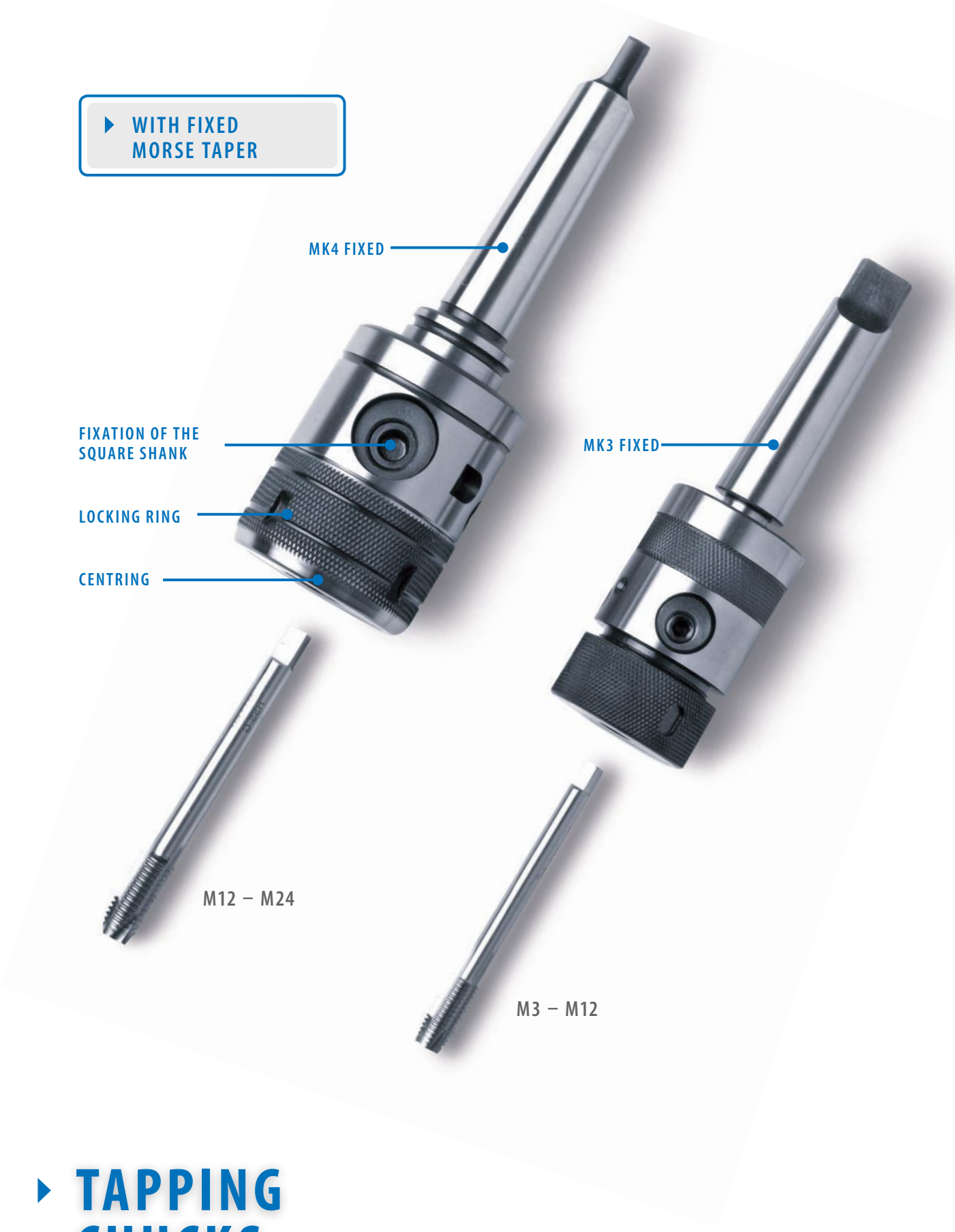
ROUND DIE HOLDERS

TECHNICAL INFORMATION

Standard	DIN EN 22568 (225)
Material	Steel

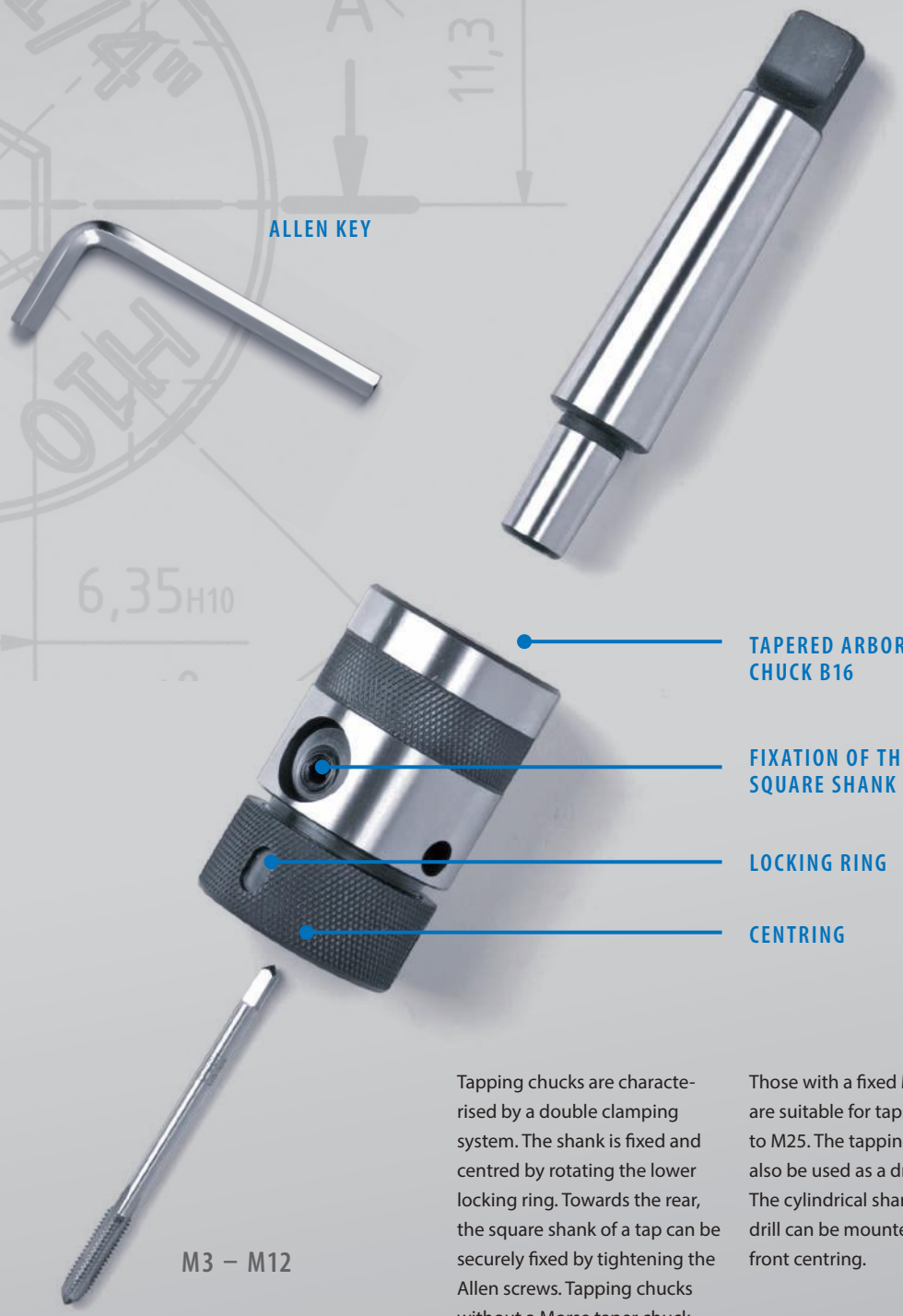
Size	Suitable for	Suitable for	Total length	Art.-No.
45 × 18	W 5/8 - 13/16	M 16 - 20	445	00634080
45 × 14	G 3/8 - 1/2	MF 16 - 20	445	00634090
55 × 22	W 7/8 - 1	M 22 - 24	495	00634100
55 × 16	G 5/8 - 3/4	MF 22 - 26	495	00634110
65 × 25	W 1.1/8-1.3/8	M 27 - 36	630	00634120
65 × 18	G 7/8 - 1	MF 27 - 36	630	00634130
75 × 30	W 1.1/2 - 1.5/8	M 39 - 42	700	00634140
75 × 20	G 1.1/8 - 1.1/4	MF 37 - 42	700	00634150
90 × 36	W 1.3/4 - 2	M 45 - 52	900	00634160
90 × 22	G 1.3/8 - 1.3/4	MF 44 - 52	900	00634170
105 × 36	W 2.1/4 - 2.1/2	M 56 - 64	930	00634180
105 × 22	G 2 - 2.1/4	MF 54 - 65	930	00634190
120 × 36	—	M 68 - 76	1100	00634200
120 × 22	G 2.3/8 - 2.3/4	MF 68 - 80	1100	00634210
130 × 36	—	M 80	1200	00634220
130 × 22	G 3";MF 82 - 85	—	1200	00634230
140 × 22	G 3.1/4	MF 88 - 95	1200	00634240
140 × 36	—	—	1200	00634250
170 × 25	—	—	1270	00634290

WITH FIXED MORSE TAPER



TAPPING CHUCKS

WITHOUT MORSE TAPER CHUCK



Tapping chucks are characterised by a double clamping system. The shank is fixed and centred by rotating the lower locking ring. Towards the rear, the square shank of a tap can be securely fixed by tightening the Allen screws. Tapping chucks without a Morse taper chuck have a chucking area suitable for taps from M3 to M12.

Those with a fixed Morse taper are suitable for taps from M12 to M25. The tapping chuck can also be used as a drill chuck. The cylindrical shank of a twist drill can be mounted into the front centring.

TAPPING CHUCKS

TECHNICAL INFORMATION

Material	Metal sleeves

Chucking range	Clamping cone	ø	Length	Art.-No.
M3 – M12	B16	46	70	04845010
M3 – M12	B18	46	70	04845020

TAPPING CHUCKS WITH TAPER CHUCK

TECHNICAL INFORMATION

Material	Metal sleeves

Chucking range	Clamping cone	ø	Length	Art.-No.
M3 – M12	MT3	46	158	04846010
M12 – M24	MT3	58,5	190	04846020

TECHNICAL DETAILS

Speed	400 rpm
Working length	950 mm
Weight	15 kg
Working area	M3 – M12
Pressure	6 bar
Air requirement	750 l/min

QUICK CHANGE SYSTEM

The tapping machine is delivered with six safety slip clutches of your choice, ranging from M3 up to M12.

	M3	M4	M5 / M6	M8	M10	M12
Square shank	2,7	3	3,4	4,9	5,5	6,2 7 8
DIN 371	M3	M3.5	M4	M5/6/8	M10	M12
DIN 376	M3	M3.5	M4	M5/6	M8	M10

COMPRESSED AIR UNIT

The compressed air unit consists of a compressed air filter with a controller and a mist lubricator. With the adjustment button at the top, you can set the pressure of the compressed air unit. Turning the button clockwise increases the pressure, turning it counter clockwise reduces the pressure. In order to prevent accidental adjusting of the pressure, the button can be locked in its starting position.

The compressed air is filtered – water and dust are automatically emitted at a pressure below 0.7kg/cm². The valve can be operated manually. The mist lubricator mixes the compressed air with oil. The amount can be adjusted with the oil adjustment screw.

TAPPING MACHINES

If you have to cut threads on a regular basis, we recommend the purchase of out tapping machine.

It consist of a pneumatic drive spindle, a parallel arm that can be bolted down to a workbench, and different tap adapters for various square shank sizes. Thus, you can quickly cut threads securely and with high precision.

The machine will be delivered with six safety slip clutches of your choice, ranging from M3 up to M12.

PNEUMATIC TAPPING ARMS

PNEUMATIC TAPPING ARMS

TECHNICAL INFORMATION

- Parallel arm
- Compressed air motor
- Column with mounting flange
- Six safety slip clutches of choice
- Radial jib (for a flexible working range)
- Compressed air- tapping device
- Movable arm

For taps	Speed (rpm)	Torque	Working radius	Air requirement	Weight in kg	Art.-No.
M2~M8	700	12 (n-m)	Rmax 950 mm ; Rmin 100 mm ; movable arm	840 litre/min	16	00920010
M3~M12	400	32 (n-m)	Rmax 950 mm ; Rmin 100 mm ; movable arm	840 litre/min	16	00920020
M3~M16	300	52 (n-m)	Rmax 950 mm ; Rmin 100 mm ; movable arm	935 litre/min	24	00920030
M3~M20	150/400	90 (n-m)	Rmax 1000 mm ; Rmin 100 mm ; movable arm	935 litre/min	25	00920040
M3~M22	120/300	100 (n-m)	Rmax 1000 mm ; Rmin 100 mm ; movable arm	935 litre/min	25	00920050
M3~M24	100/300	130 (n-m)	Rmax 1000 mm ; Rmin 100 mm ; movable arm	935 litre/min	25	00920060
M3~M27	70/220	160 (n-m)	Rmax 1000 mm ; Rmin 100 mm ; movable arm	935 litre/min	25	00920070
M3~M30	40/200	190 (n-m)	Rmax 1000 mm ; Rmin 100 mm ; movable arm	935 litre/min	25	00920080

PNEUMATIC TAPPING ARMS

TECHNICAL INFORMATION

- Parallel arm
- Compressed air motor
- Column with mounting flange
- Six safety slip clutches of choice
- Radial jib (for a flexible working range)
- Compressed air- tapping device
- Movable arm (+500mm)

For taps	Speed (rpm)	Torque	Working radius	Air requirement	Weight in kg	Art.-No.
M2~M8	700	12 (n-m)	Rmax 1900 mm ; Rmin 200 mm ; movable arm	840 litre/min	23	00921010
M3~M12	400	32 (n-m)	Rmax 1900 mm ; Rmin 200 mm ; movable arm	840 litre/min	23	00921020
M3~M16	300	52 (n-m)	Rmax 1900 mm ; Rmin 200 mm ; movable arm	935 litre/min	27	00921030
M3~M20	150/400	90 (n-m)	Rmax 1900 mm ; Rmin 200 mm ; movable arm	935 litre/min	38	00921040
M3~M22	120/300	100 (n-m)	Rmax 1900 mm ; Rmin 200 mm ; movable arm	935 litre/min	38	00921050
M3~M24	100/300	130 (n-m)	Rmax 1900 mm ; Rmin 200 mm ; movable arm	935 litre/min	38	00921060
M3~M27	70/220	160 (n-m)	Rmax 1900 mm ; Rmin 200 mm ; movable arm	935 litre/min	38	00921070
M3~M30	40/200	190 (n-m)	Rmax 1900 mm ; Rmin 200 mm ; movable arm	935 litre/min	38	00921080

SWIVEL DEVICES

With the swivel device you can, without aligning the workpiece, cut threads into slanted bores.

For taps	Weight in kg	Art.-No.
M2~M8	2	00922010
M3~M12	2	00922020
M3~M16	2	00922030
M3~M20	2	00922040
M3~M22	2	00922050
M3~M24	2	00922060
M3~M27	2	00922070
M3~M30	2	00922080

PNEUMATIC DRILL UNITS / INTERCHANGABLE UNITS

Function	Weight in kg	Art.-No.
for vertical drilling and tapping	9	00922090
for vertical and horizontal drilling and tapping	9	00922100

MAGNETS

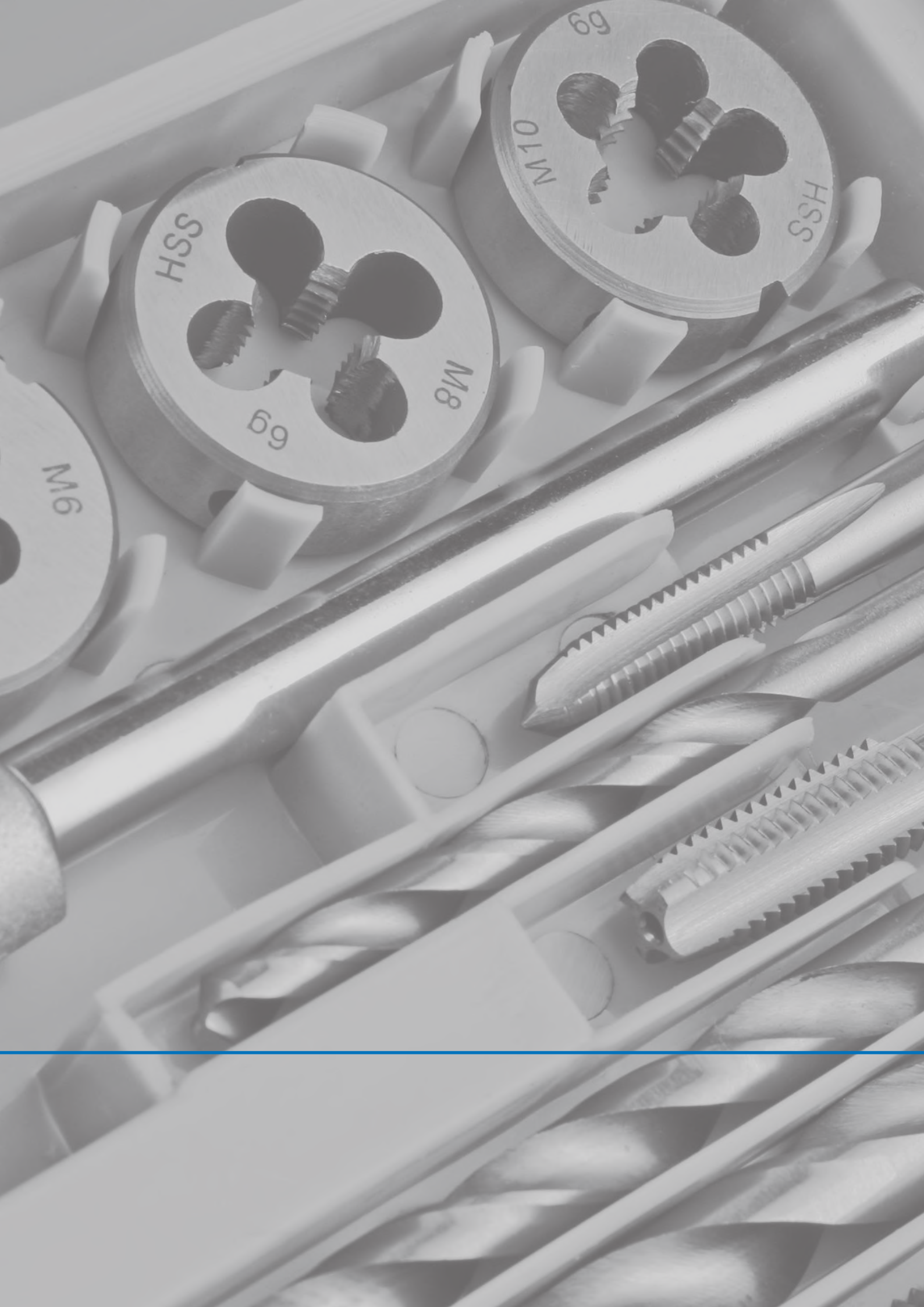
Holding force	Dimensions (L × W × H in mm)	Suitable for Art. No.	Weight in kg	Art.-No.
300 kg	150 × 90 × 93	00920010 - 00920080 00921010 - 00921030	10	00922110
600 kg	224 × 115 × 120	00921040 - 00921080	23	00922120

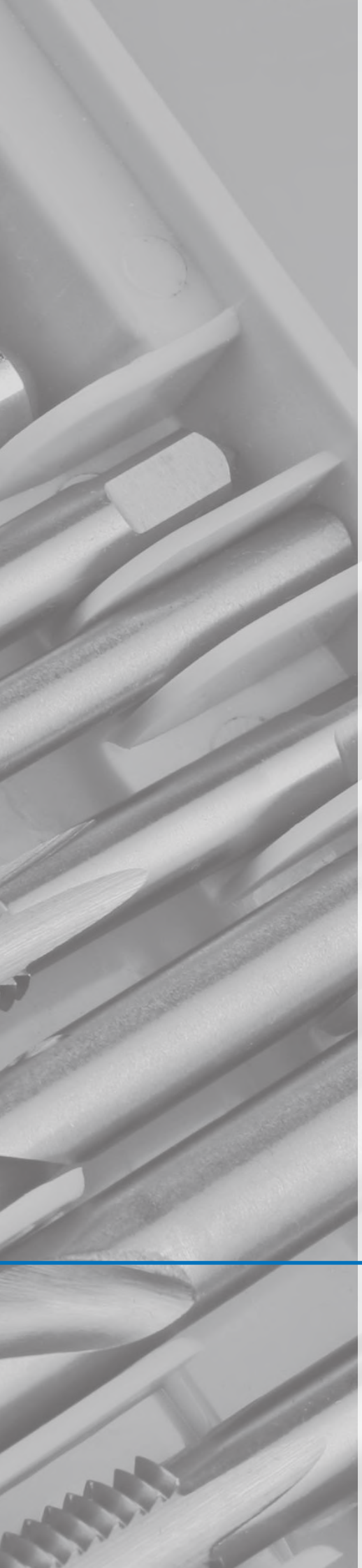
ELECTRIC TAPPING ARM

For taps	Speed (rpm)	Working radius	Power	Voltage	Material	Weight in kg	Art.-No.
M3-M32	0-300 / 0-55	Rmax 1500 mm Rmin 200 mm movable arm	0,75 kw	220 Volt	Arm made of coated aluminium; spindle and tap holder made of harnened and coated metal	260	00923010

WORK TABLE

Dimensions (L × W × H in mm)	Weight in kg	Art.-No.
900 × 630 × 900	200	00924010


M6
HSS
6g
M8
M10
6g
HSS

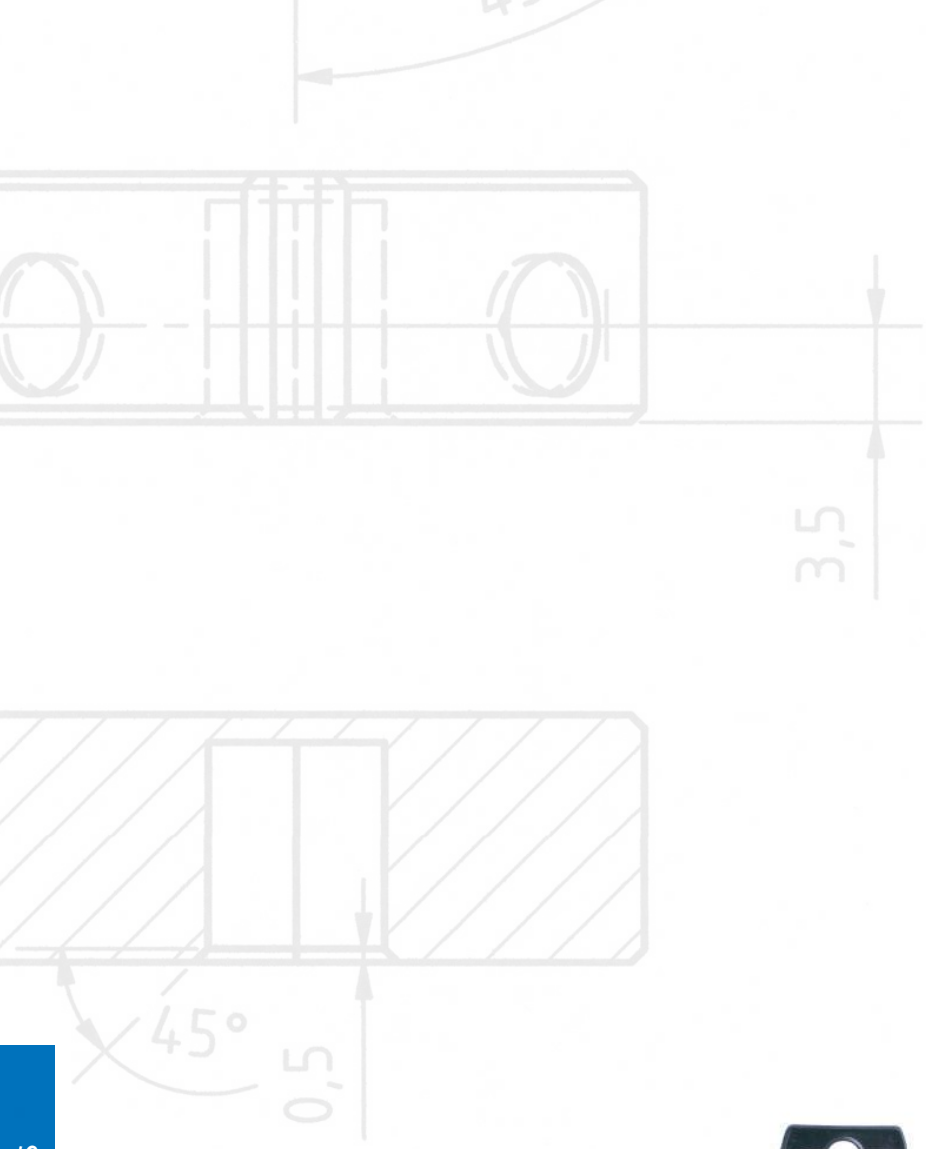


ASSORTMENTS

The product category "assortments" includes tool sets, tool packaging as well as assortments for the DIY section. Tool sets are divided into groups for processing internal threads and processing internal and external threads. We also offer empty metal boxes for all our assortments.

The DIY programme with the environmentally friendly GSR cardboard packaging and the new GSR tap box is designed for the latest sale systems. Single packaging and assortment packaging can be combined to the GSR product line.
This way GSR also had the latest solutions for hardware stores specialist retailers.

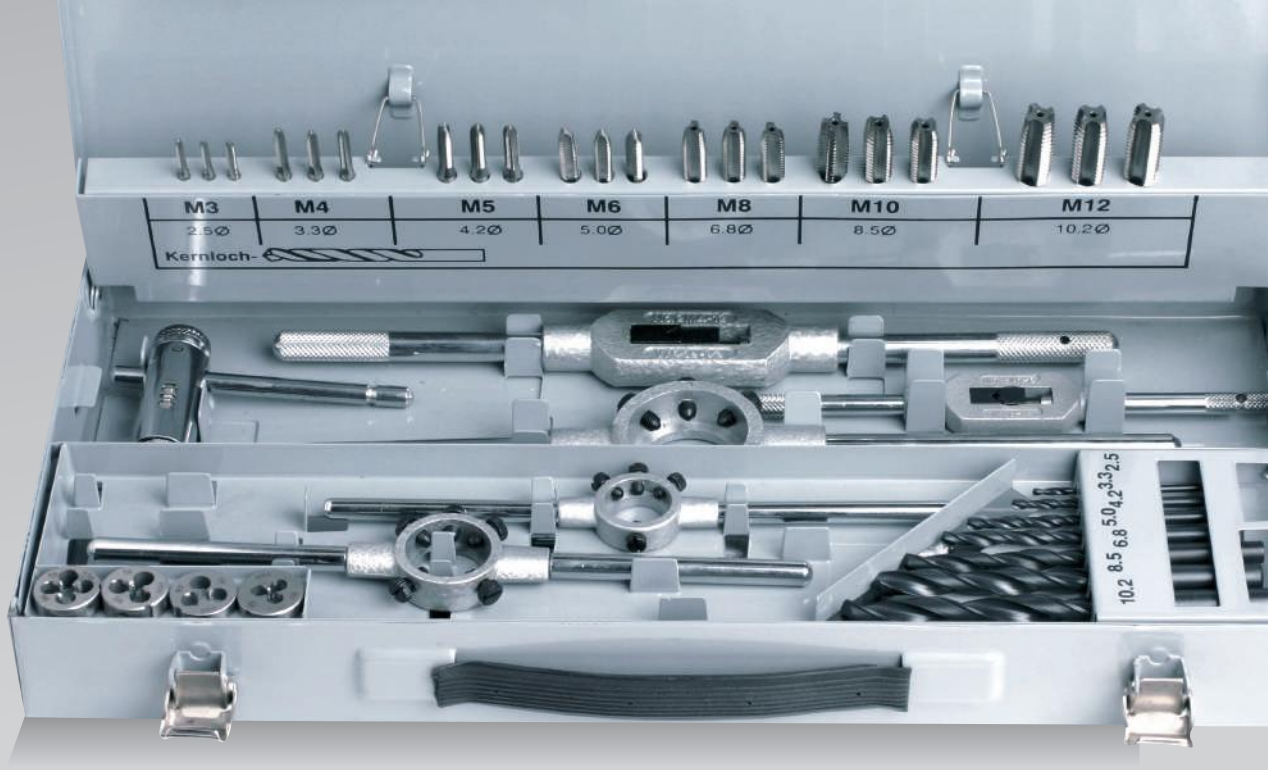
ASSORTMENTS


3,5
45°
0,5

M12
M10
M8
M6
M5
M4
M3

M12
M10
M8
M6
M5
M4
M3

M 8
M 6
M 5
M 4
M 3



THREADING TOOL ASSORTMENTS

METAL BOXES

INDIVIDUAL IMPRINT

GSR metal boxes are made of steel sheets according to DIN 1541 with a thickness ranging from 0,3mm to 0,5mm. The sheets are protected against corrosion by a high-quality powder coating. Descriptions, labels and company logos are applied via screen printing. Therefore, even small series with individual labelling, which is firmly attached to the product, are possible at short notice.

The metal boxes are sent out in a neutral white slip case. On request, the carton can be imprinted with a four-colour print. Metal boxes are environmentally friendly, resistant and durable. Especially their sturdiness and heat resistance during tough workshop usage are appreciated. There are six different base sizes. The internal mounting is set by the tools.

INDIVIDUAL COLOUR CHOICE

The GSR metal boxes can be delivered in various colours.

THREADING TOOL ASSORTMENTS

Assortments are tool sets for cutting internal and external threads with matching tool holders, optional with tap hole twist drills, in metal cases or plastic boxes. Individual contents as well as customized company imprints are available upon request.

INDIVIDUAL IMPRINT

The GSR metal boxes can be imprinted and labelled individually.

SET	TECHNICAL INFORMATION
	for short machine taps
	(short machine taps DIN 352)

08302030

08302080

Set	ATW	TH	Tap hole drill	Round die holder
M3 – M12 Form B	No. 1.1/2	—	2,5 / 3,3 / 4,2 / 5,0 / 6,8 / 8,5 / 10,2 mm	—
M3 – M12 RSP35°	No. 1.1/2	—	2,5 / 3,3 / 4,2 / 5,0 / 6,8 / 8,5 / 10,2 mm	—
M3 – M12 Form B	No. 1.1/2	—	—	25 × 9
M3 – M12 Form B / RSP35°	No. 1.1/2	—	—	25 × 9

08305110

08305120

Extras	Material	Pieces	Art. No. equipped	Art. No. empty
	HSS	15	08302030	08902030
	HSS	15	08302080	08902030
Thread gauge, Screwdriver	HSS	25	08305110	08905110
Thread gauge, Screwdriver	HSS	25	08305120	08905110

SET	TECHNICAL INFORMATION
	for short machine taps
	(short machine taps DIN 352)

08332010

Set	ATW	TH	Tap hole drill	Round die holder
M3 – M12 Form B	No. 1+2	No. 1	2,5 / 3,3 / 4,2 / 5,0 / 6,8 / 8,5 / 10,2 mm	20 × 5 / 20 × 7 / 25 × 9 / 30 × 11 / 38 × 14
M3 – M12 Form B / RSP35°	No. 1+2	No. 1	2,5 / 3,3 / 4,2 / 5,0 / 6,8 / 8,5 / 10,2 mm	20 × 5 / 20 × 7 / 25 × 9 / 30 × 11 / 38 × 14

08332020

Extras	Material	Pieces	Art. No. equipped	Art. No. empty
Thread gauge, Screwdriver	HSS	38	08332010	08932020
Thread gauge, Screwdriver	HSS	38	08332020	08932020

SET	TECHNICAL INFORMATION
	for machine taps
	DIN 371 / DIN 376

08303015

08303004

08303017

08303018

Form	DIN 371	DIN 376	Tap hole drill	Material	Pieces	Art.-No. equipped	Art.-No. empty
A	M3 – M10	M12		HSSG	7	08303001	08903000
B	M3 – M10	M12		HSSG	7	08303004	08903000
RSP 35°	M3 – M10	M12		HSSG	7	08303015	08903000
A	M3 – M10	M12	2,5 / 3,3 / 4,2 / 5,0 / 6,8 / 8,5 / 10,2 mm	HSSG	14	08303016	08903020
B	M3 – M10	M12	2,5 / 3,3 / 4,2 / 5,0 / 6,8 / 8,5 / 10,2 mm	HSSG	14	08303017	08903020
RSP 35°	M3 – M10	M12	2,5 / 3,3 / 4,2 / 5,0 / 6,8 / 8,5 / 10,2 mm	HSSG	14	08303018	08903020
A	M3 – M10	M12		HSSE	7	08403001	08903000
B	M3 – M10	M12		HSSE	7	08403004	08903000
RSP 35°	M3 – M10	M12		HSSE	7	08403015	08903000
A	M3 – M10	M12	2,5 / 3,3 / 4,2 / 5,0 / 6,8 / 8,5 / 10,2 mm	HSSE	14	08403016	08903020
B	M3 – M10	M12	2,5 / 3,3 / 4,2 / 5,0 / 6,8 / 8,5 / 10,2 mm	HSSE	14	08403017	08903020
RSP 35°	M3 – M10	M12	2,5 / 3,3 / 4,2 / 5,0 / 6,8 / 8,5 / 10,2 mm	HSSE	14	08403018	08903020

SET

TECHNICAL INFORMATION

for hand taps DIN 352

08301000

08307010

08308010

08308020

Taps	ATW	TH	Tap hole drill	Material	Pieces	Art.-No. equipped	Art.-No. empty
M3 – M12	—	—	—	HSS	21	08301000	08901000
M3 – M12	No. 1.1/2	—	—	HSS	22	08307010	08907010
M3 – M12	No. 1.1/2	—	2,5 / 3,3 / 4,2 / 5,0 / 6,8 / 8,5 / 10,2 mm	HSS	29	08308010	08908010
M3 – M12	No. 1.1/2	No.1	2,5 / 3,3 / 4,2 / 5,0 / 6,8 / 8,5 / 10,2 mm	HSS	30	08308020	08908010

SET	TECHNICAL INFORMATION
	DIN

08331030

Set	ATW	TH	Tap hole drill	Round die holder
M3 – M12	No. 1+2	No. 1	2,5 / 3,3 / 4,2 / 5,0 / 6,8 / 8,5 / 10,2 mm	20 × 5 / 20 × 7 / 25 × 9 / 30 × 11 / 38 × 14
M3 – M12	No. 1+2	No. 1	2,5 / 3,3 / 4,2 / 5,0 / 6,8 / 8,5 / 10,2 mm	20 × 5 / 20 × 7 / 25 × 9 / 30 × 11 / 38 × 14 + Round die guides M3 – M12

08331050

Set	ATW	TH	Tap hole drill	Round die holder
M3 – M20	No. 1+3	No. 1+2	—	20 × 5 / 20 × 7 / 25 × 9 / 30 × 11 / 38 × 14 / 45 × 18
M3 – M24	No. 0+2+4	—	—	20 × 5 / 20 × 7 / 25 × 9 / 30 × 11 / 38 × 14 / 45 × 18 / 55 × 22

08331070

Extras	Material	Pieces	Art. No. equipped	Art. No. empty
Thread gauge, Screwdriver	HSS	45	08331030	08931020
Thread gauge, Screwdriver	HSS	52	08331070	08931020

08331040

Extras	Material	Pieces	Art. No. equipped	Art. No. empty
Thread gauge, Screwdriver	HSS	56	08331040	08931040
Thread gauge, Screwdriver	HSS	64	08331050	08931050

SET	TECHNICAL INFORMATION
	Tap and die set with combined round dies

Set	ATW	Round die holder	Extras	Material	Pieces	Art.-No. equipped	Art.-No. empty
M3 – M12	No. 1.1/2	25 x 9	Thread gauge, Screwdriver	HSS	32	08305010	08905010

SET

08304010

08304000

TECHNICAL INFORMATION

for round dies

Round die	Round die holder	Standard	Material	Pieces	Art.-No. equipped	Art.-No. empty
M3 – M12	25×9	Factory Standard	HSS	8	08304010	08904010
M3 – M12	–	DIN 22568 (DIN 223)	HSS	7	08304000	08904000

ASSORTMENTS FOR INTERNAL AND EXTERNAL THREADS

UNC / UNF / BSP / BSW
Hand taps sets
Round dies
Adjustable tap wrenches
Round die holders
Screwdrivers
Thread gauges

GSR SERIES WITH IMPERIAL THREADING TOOLS

The clever compilation of inch-based tools are delivered in boxes made of high quality ABS material – because the contents packs a punch.

The closures and full length hinges ensure a high stability. Thanks to modern foam inserts, the tools are optimally arranged and stored safely.

BSP TAP AND DIE SET

Art. No. 08333100

BSP / G = British Standard Pipe – a cylindrical pipe thread according to DIN ISO 228 part 1, where pressure-tight joints are not made on the threads. It is a two-part set, consisting of taper and bottoming.

One have to keep in mind that the inch indication does not equal the inch diameter, e.g. BSP 1" = 33,25mm

This thread type is used when pipes are screwed into each other, e.g. water, oil or compressed air.

UNC/BSW TAP AND DIE SET

Art. No. 08333150 / 08333250
These are three-piece sets, consisting of taper, plug, and bottoming.

UNC = Unified National Coarse – an American coarse thread with a thread angle of 60°.

This thread type is used in Western countries (especially the US and Canada). In its usage it is comparable with a metric thread.

UNC is an important thread type for restorations and repairs of American machines of all types, vehicles, and motorcycles.

BSW / WW = British Standard Whitworth –
a cylindrical Whitworth thread with a thread angle of 55°, for pressure-tight joints that are not made on the threads according to DIN ISO 228 part 1.

The British Standard Whitworth is a standard thread as well as a screw thread. It is often abbreviated as W or WW. Its importance and usage is comparable with the ISO metric coarse thread.

UNF TAP AND DIE SET

Art. No. 08333200

UNF = Unified National Fine – an American fine thread with a thread angle of 60°.

It is a two-piece set, consisting of taper and bottoming.

This thread type is, like UNC, used in Western countries (especially the US and Canada). In its usage it is comparable with a metric-fine thread.

UNF is an important thread type for restorations and repairs of American machines of all types, vehicles, and motorcycles.

SET

TECHNICAL INFORMATION

Tap and die set BSP

Set	ATW	Round die holder	Extras	Material	Pieces	Art.-No.
1/8 - 1/4 - 3/8 1/2 - 3/4 - 1"	No. 3+5	30 x 11 38 x 10 45 x 14 55 x 16 65 x 18	Thread gauge 20 leafs, screwdriver	HSS	27	08333100

SET

TECHNICAL INFORMATION

Tap and die set BSW

Set	ATW	Round die holder	Extras	Material	Pieces	Art.-No.
1/4 - 5/16 - 3/8 7/16 - 1/2 - 5/8 3/4 - 7/8 - 1"	No. 1.1/2 No. 4	20 x 7 25 x 9 30 x 11 38 x 14 45 x 18 55 x 22	Thread gauge 20 leafs, screwdriver	HSS	46	08333250

SET

TECHNICAL INFORMATION

Tap and die set UNC

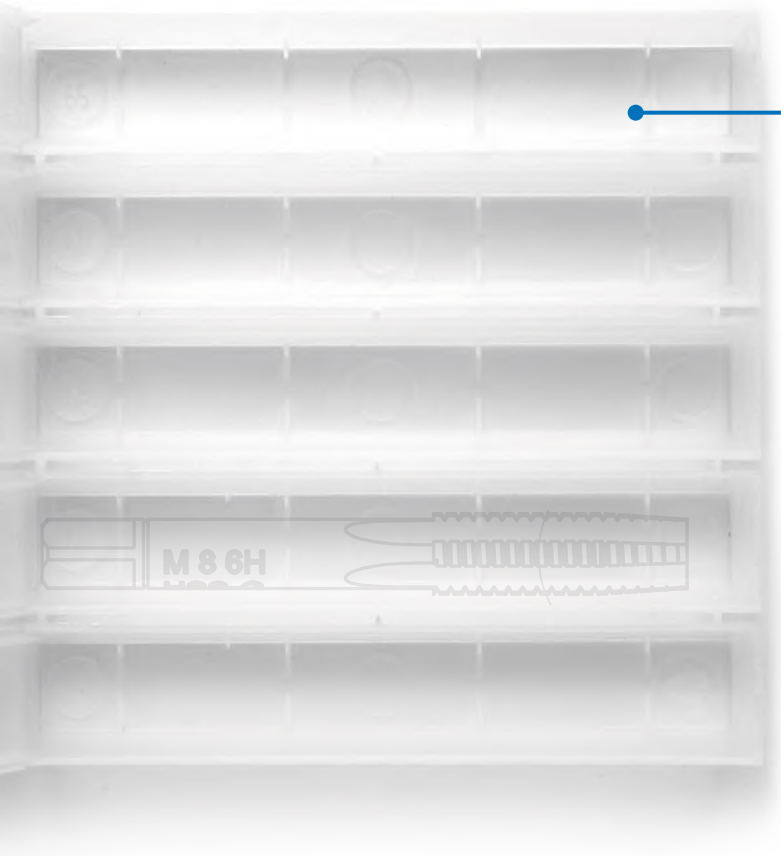
Set	ATW	Round die holder	Extras	Material	Pieces	Art.-No.
1/4 - 5/16 - 3/8 7/16 - 1/2 - 5/8 3/4 - 7/8 - 1"	No. 1.1/2 No. 4	20 x 7 25 x 9 30 x 11 38 x 14 45 x 18 55 x 22	Thread gauge 22 leafs, screwdriver	HSS	46	08333150

SET

TECHNICAL INFORMATION

Tap and die set UNF

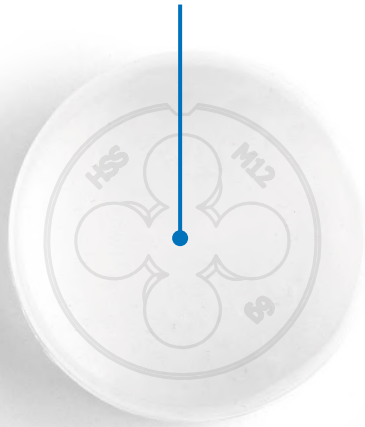
Set	ATW	Round die holder	Extras	Material	Pieces	Art.-No.
1/4 - 5/16 - 3/8 7/16 - 1/2 - 5/8 3/4 - 7/8 - 1"	No. 1.1/2 No. 4	20 x 7 25 x 9 30 x 11	Thread gauge 16 leafs, screwdriver	HSS	37	08333200



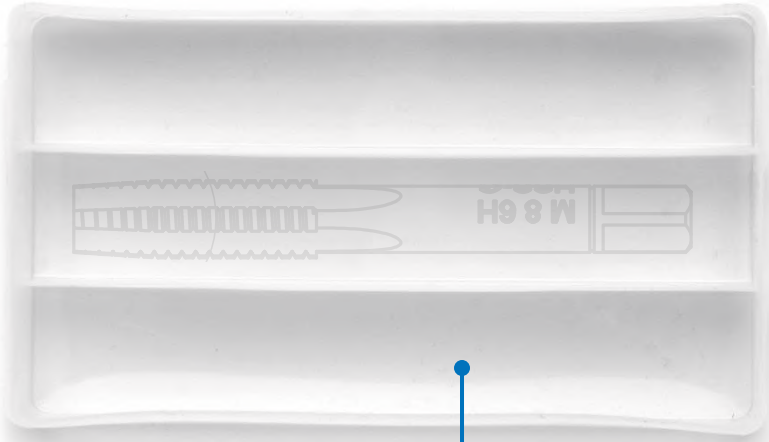
FOR SINGLE HAND AND MACHINE TAPS

with two, five or ten compartments

FOR ROUND DIES



PLASTIC PACKAGING



FOR HAND TAPS

with two compartments

FOR HAND TAPS

with three compartments

GSR plastic packaging is made of polypropylene. It is a semi-crystalline thermoplastic, characterised by its stiffness, hardness and strength.

It is odourless and can be processed into transparent and break-proof tool packaging.

INDIVIDUAL IMPRINT

The GSR plastic packages can be imprinted and labelled individually.

SNAP PACK

No.	Length x Width	Units
1	56 × 4,5 mm	10 Stück
2	81 × 6,5 mm	10 Stück
3	86 × 10 mm	5 Stück
4	88 × 12,5 mm	5 Stück
5	102 × 14,5 mm	5 Stück
6	112,3 × 14,5 mm	5 Stück
7	131 × 21,5 mm	5 Stück
8	140 × 27,5 mm	2 Stück

ROUND DIE PACKAGING

No.	for size
1	O/D 20 × 7 mm
2	O/D 25 × 9 mm
3	O/D 30 × 11 mm
4	O/D 38 × 14 mm
5	O/D 45 × 18 mm
6	O/D 55 × 22 mm
7	O/D 65 × 24 mm

2-PCS. HAND TAPS PACKAGING

No.	for size
1	M3 – M5
2	M6 – M8
3	M10 – M12
4	M14 – M16
5	M18 – M20
6	M22 – M24

3-PCS. HAND TAPS PACKAGING

No.	for size
1	M3 – M4
2	M5 – M6
3	M8 – M10
4	M12
5	M14 – M16
6	M18 – M20
7	M22 – M24

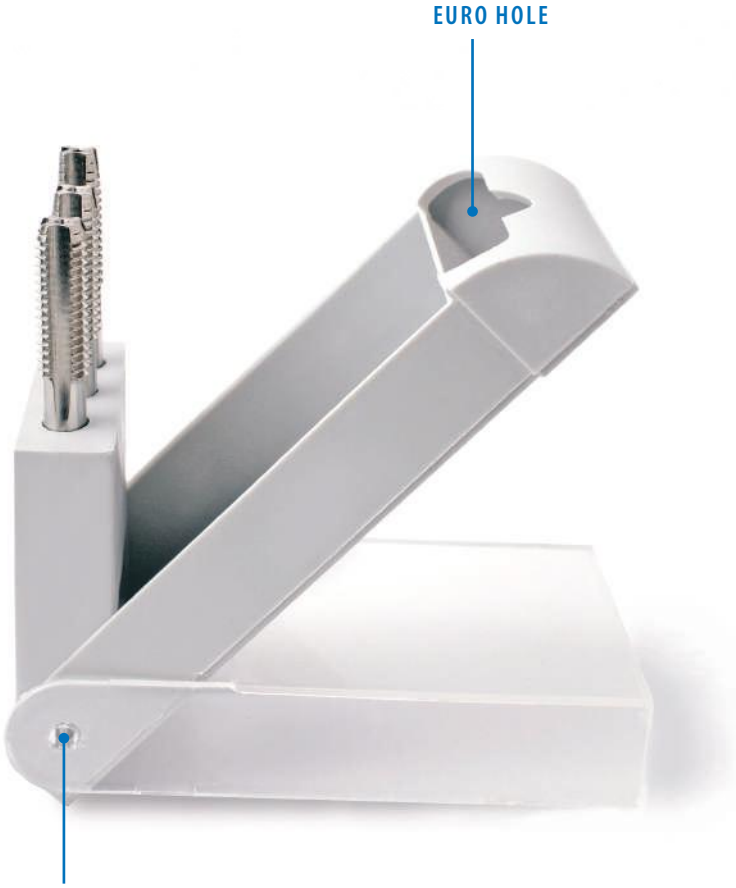
DIY PROGRAMME

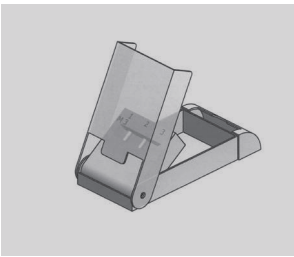
3-PCS. HAND TAPS BOX

PATENTED DESIGN

The GSR box for taps has three benefits for you:

- The box fits perfectly into the latest sales systems, as it has a Euro hole and a handy anti-theft device.
- Especially in daily use, the box demonstrates its practical benefit. It can – thanks to the special GSR patent – be opened in a way so that the hand taps can be taken out one by one.
- After being used, the valuable taps are stored safely in the box.





GSR uses the latest software for product development. Thus, models can be presented three-dimensional and processes simulated. By using 3D-printers, the software models become tangible models. Therefore, a quick and precise product development is possible.

EURO HOLE

APPLICATION INFORMATION

TRADEMARK QUALITY

DIY PROGRAMME

The environmentally friendly cardboard packaging has been designed to minimise environmental impacts by sales packaging. It consists only of printed cardboard and can be disposed as waste-paper.

HAND TAPS SET

TECHNICAL INFORMATION

Standard	DIN 352
Material	HSS-G
3-pcs. Set	
Plastic box	

							Total weight	Art.-No.
M 3	0,5	2,5	40	12	3,5	2,7	15	00706130
M 4	0,7	3,3	45	14	4,5	3,4	21	00706150
M 5	0,8	4,2	48	16	6,0	4,9	31	00706170
M 6	1,0	5,0	56	18	6,0	4,9	34	00706190
M 8	1,25	6,8	63	22	6,0	4,9	41	00706210
M 10	1,5	8,5	70	25	7,0	5,5	70	00706230
M 12	1,75	10,2	75	30	9,0	7,0	117	00706250

SHORT MACHINE TAPS

TECHNICAL INFORMATION

Standard	DIN 352
Material	HSS-G
Form	Form A
Single bottoming tap for manual and machine usage	
Cardboard packaging	

							Total weight	Art.-No.
M 3	0,5	2,5	40	12	3,5	2,7	8	00702130
M 4	0,7	3,3	45	14	4,5	3,4	10	00702150
M 5	0,8	4,2	48	16	6,0	4,9	13	00702170
M 6	1,0	5,0	56	18	6,0	4,9	14	00702190
M 8	1,25	6,8	63	22	6,0	4,9	17	00702210
M 10	1,5	8,5	70	25	7,0	5,5	19	00702230
M 12	1,75	10,2	75	30	9,0	7,0	40	00702250

SHORT MACHINE TAPS SET

TECHNICAL INFORMATION

Standard	DIN 352
Material	HSS-G
Form	Form A
Bottoming taps for manual and machine usage	
Plastic box	

	Total weight	Art.-No.
M 3 / M 4 / M 5 / M 6	40	00702000
M 8 / M 10 / M 12	71	00702010

ROUND DIE WITH GUIDE

TECHNICAL INFORMATION

Standard	Factory Standard
Material	HSS
25 × 9 mm	
Plastic box	

					Total weight	Art.-No.
M 3	0,5	2,92	25	9	30	00703130
M 4	0,7	3,91	25	9	30	00703150
M 5	0,8	4,9	25	9	30	00703170
M 6	1,0	5,88	25	9	30	00703190
M 8	1,25	7,87	25	9	30	00703210
M 10	1,5	9,85	25	9	30	00703230
M 12	1,75	11,83	25	9	30	00703250

SCREW EXTRACTORS SET

TECHNICAL INFORMATION

Standard	Factory Standard
Material	Tool steel

	Total weight	Art.-No.
M 3 - M 18	110	00710010

ROUND DIE HOLDER

TECHNICAL INFORMATION

Standard	DIN EN 22568 (DIN 225)
Die-cast zinc	
Cardboard packaging	

Nominal size	Total weight	Art.-No.
25 × 9 M3 – M12	112	00704040

ADJUSTABLE TAP WRENCH

TECHNICAL INFORMATION

Standard	DIN 1814
Die-cast zinc	
Cardboard packaging	

Nominal size	Total weight	Art.-No.
No. 1.1/2 M3 – M12	110	00705040

TOOL HOLDER WITH RATCHET

TECHNICAL INFORMATION

Standard	Factory Standard
Cardboard packaging	

Nominal size	Total weight	Art.-No.
No. 1. M3 – M10	183	00705050

TAP AND DIE SETS

TECHNICAL INFORMATION

Plastic packaging

Set / Form	Taps	Round die	ATW	RDH	Other	Art.-No.
13pcs. M3 – M8 Special steel	M3 × 0,5 M4 × 0,7 M5 × 0,8 M6 × 1,0 M8 × 1,25	M3 × 0,5 M4 × 0,7 M5 × 0,8 M6 × 1,0 M8 × 1,25	No. 1 1/2	25 × 9mm	Allen key	00706010
20pcs. M3 – M12 Special steel	M3 × 0,5 M3,5 × 0,6 M4 × 0,7 M5 × 0,8 M6 × 1,0 M8 × 1,25 M10 × 1,0 M10 × 1,5 M12 × 1,75	M3 × 0,5 M3,5 × 0,6 M4 × 0,7 M5 × 0,8 M6 × 1,0 M8 × 1,25 M10 × 1,0 M10 × 1,5 M12 × 1,75	No. 1 1/2	25 × 9mm		00706020
20pcs. M3 – M12 Tool steel	M3 × 0,5 M4 × 0,7 M5 × 0,8 M6 × 1,0 M7 × 1,0 M8 × 1,25 M9 × 1,25 M10 × 1,5 M12 × 1,75	M3 × 0,5 M4 × 0,7 M5 × 0,8 M6 × 1,0 M7 × 1,0 M8 × 1,25 M9 × 1,25 M10 × 1,5 M12 × 1,75	No. 1 1/2	25 × 9mm		00706030
40pcs. M3 – M12 Special steel	M3 × 0,5 M3 × 0,6 M4 × 0,7 M4 × 0,75 M5 × 0,8 M5 × 0,9 M6 × 0,75 M6 × 1,0 M7 × 0,75 M7 × 1,0 M8 × 1,0 M8 × 1,25 M10 × 1,25 M10 × 1,5 M12 × 1,5 M12 × 1,75 1/8 BSP28	M3 × 0,5 M3 × 0,6 M4 × 0,7 M4 × 0,75 M5 × 0,8 M5 × 0,9 M6 × 0,75 M6 × 1,0 M7 × 0,75 M7 × 1,0 M8 × 1,0 M8 × 1,25 M10 × 1,25 M10 × 1,5 M12 × 1,5 M12 × 1,75 1/8 BSP28	No. 1 1/2	25 × 9mm	Tool holder, thread gauge, screwdriver	00706040

COUNTERSINKS SET HSS

TECHNICAL INFORMATION

Form	Form C 90°
Standard	DIN 335
Set in GSR design steel box with Euro hole	
incl. user manual	

Sizes	Art.-No.
6,3 / 8,3 / 10,4 / 12,4 / 16,5 / 20,5	00708010

COMBINED BIT SET HSS

TECHNICAL INFORMATION

Form	Factory Standard
Standard	Hexagon shank DIN 3126
Set in GSR design steel box with Euro hole	
incl. user manual	

Sizes	Art.-No.
M3 / M4 / M5 / M6 / M8 / M10	00708020

ROUND DIE SET HSS

TECHNICAL INFORMATION

Form	Form B pre-slit
Standard	Factory Standard 25x9
Set in GSR design steel box with Euro hole	
incl. user manual	

Round dies	Round die holder	Standard	Material	Pieces	Art.-No.
M3 – M12	25×9	Factory Standard	HSS	8	00708030

SHORT MACHINE TAPS SET HSS

TECHNICAL INFORMATION

Form	Form B with spiral point
Standard	DIN 352 / DIN 1814 / DIN 338
Set in GSR design steel box with Euro hole	
incl. user manual	
incl. combined thread gauge for internal and external threads	
Tap holder M3-M10 with hexagon chuck	

Set	ATW	Tap hole drill	Extras	Material	Pieces	Art.-No.
M3 – M12 Form B	No. 1.1/2	2,5 / 3,3 / 4,2 / 5,0 / 6,8 / 8,5 / 10,2 mm	Combined thread gauge, tap holder	HSS	17	00708040

HAND TAPS

TECHNICAL INFORMATION

Standard	DIN 352 / DIN 1814
Set in GSR design steel box with Euro hole	
incl. user manual	
incl. combined thread gauge for internal and external threads	

Set	ATW	Extras	Material	Pieces	Art.-No.
M3 – M12	No. 1.1/2	combined thread gauge	HSS	23	00708040

HANDGEWINDEBOHRERSORTIMENT

TECHNICAL INFORMATION

Standard	DIN 352 / DIN 1814 / DIN 338
Set in GSR design steel box with Euro hole	
incl. user manual	
incl. combined thread gauge for internal and external threads	

Set	ATW	Tap hole drill	Extras	Material	Pieces	Art.-No.
M3 – M12	No. 1.1/2	2,5 / 3,3 / 4,2 / 5,0 / 6,8 / 8,5 / 10,2 mm	combined thread gauge	HSS	30	00708060

KOMBI-GEWINDESCHNEIDSORTIMENT

TECHNICAL INFORMATION

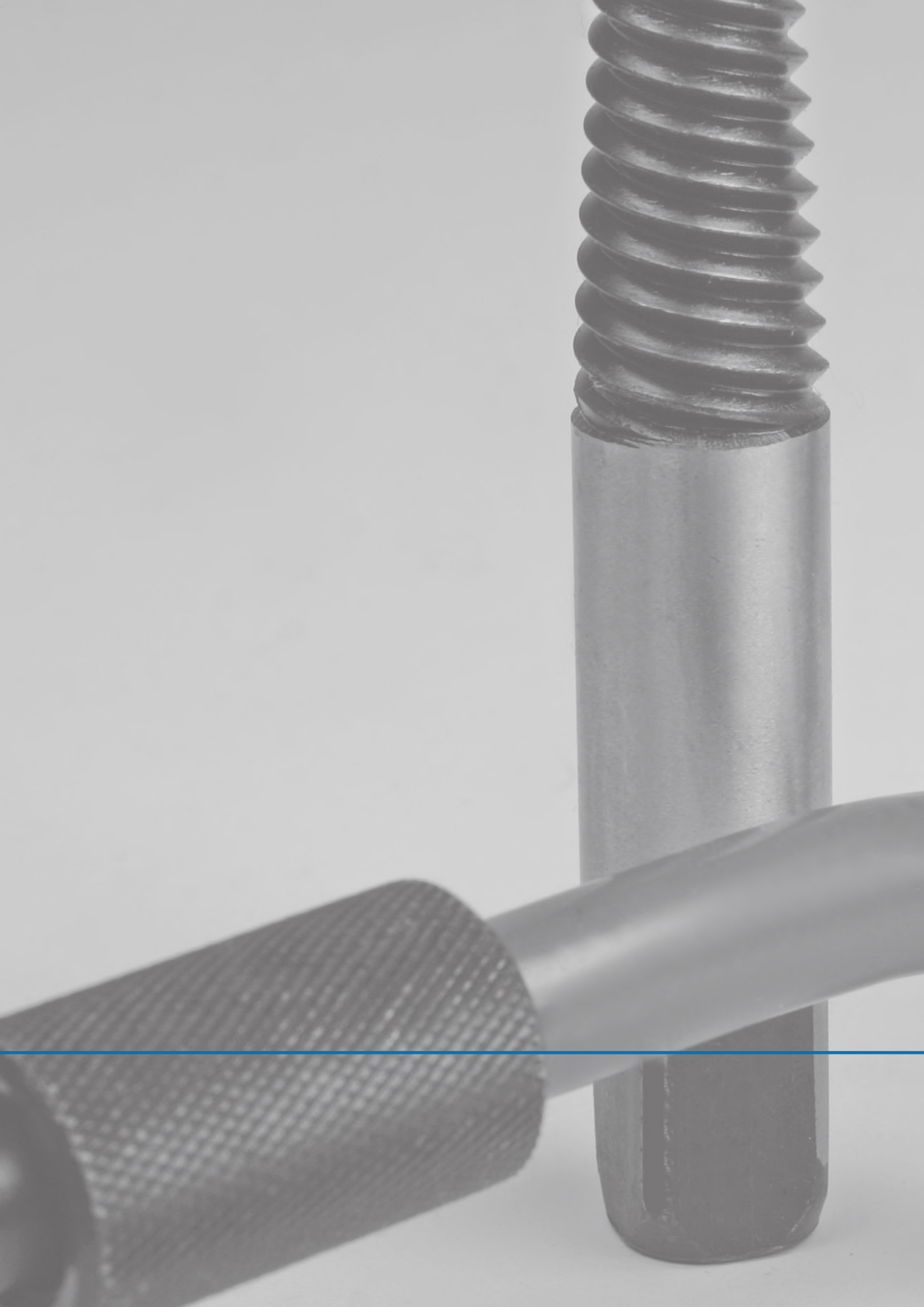
Standard	DIN 352 / Factory Standard 25x9 / DIN 1814 / DIN EN 22568
Round dies according to factory standard with equal outer diameter	
Set in GSR design steel box with Euro hole	
incl. user manual	
incl. combined thread gauge for internal and external threads	

Set	ATW	Round die holder	Extras	Material	Pieces	Art.-No.
M3 – M12	No. 1.1/2	25 x 9	combined thread gauge, screwdriver	HSS	32	00708070

TAP AND DIE SET	TECHNICAL INFORMATION
	Set in GSR design steel box with carry handle
	incl. user manual

Set	ATW	TH	Tap hole drill	Round die holder
M3 – M12	No. 1+2	No. 1	2,5 / 3,3 / 4,2 / 5,0 / 6,8 / 8,5 / 10,2 mm	20 × 5 / 20 × 7 / 25 × 9 / 30 × 11 / 38 × 14
M3 – M20	No. 1+3	No. 1+2	—	20 × 5 / 20 × 7 / 25 × 9 / 30 × 11 / 38 × 14 / 45 × 18

Extras	Material	Pieces	Art. No. equipped
Combined thread gauge for internal and external threads, screwdriver	HSS	45	00708080
thread gauge, screwdriver	HSS	56	00708090



THREAD REPAIR

Thread repair inserts are used to repair or reinforce a thread while maintaining the nominal diameter.

The following tools are required: Tap hole twist drill, screw tap, insertion tool and break tool. Stainless steel thread inserts guarantee a very good corrosion and heat resistance. The cross section is rhombic. The wire is coiled into an elastic spring. There is a tappet at the lower end. While screwing in the thread insert, the spring is slightly tensed and holds the insert in the internal thread. The thread insert is therefore bigger when inserted compared to its initial state. There are three sizes, oriented at the nominal sizes (1 x d, 1.5 x d and 2.5 x d).

REPAIR

PROCEDURE

1 ▸ Drilling out the damaged thread

2 ▸ Cleaning the bore

3 ▸ Thread cutting for the thread insert

4 ▸ Cleaning the thread

5 ▸ Screwing in the thread insert

6 ▸ Breaking off the tappet of the thread insert

BREAK TOOL

INSERTION TOOL

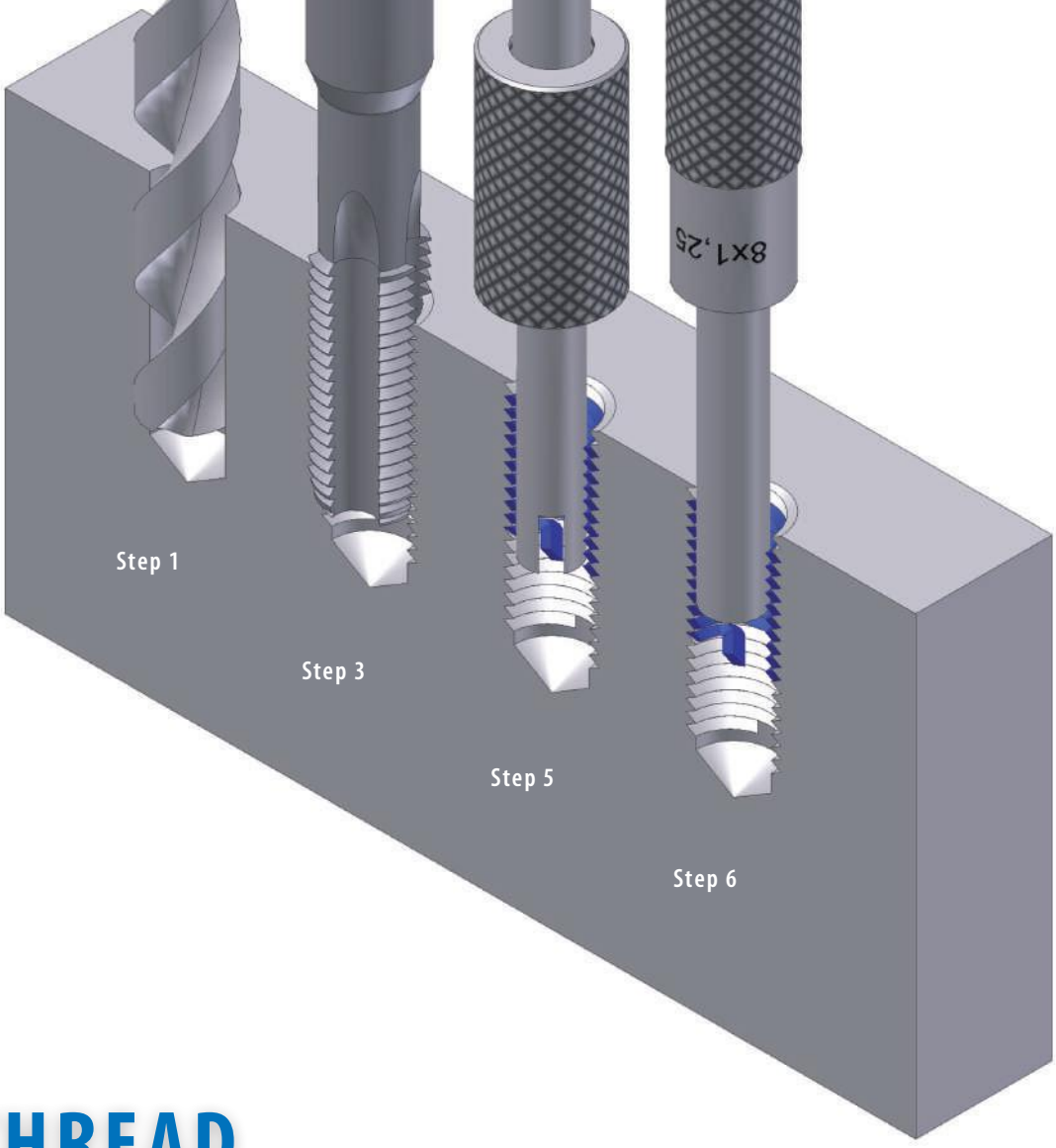
USAGE

Thread repair inserts are used to repair or reinforce a thread while maintaining the nominal diameter.

TOOLS

Following tools are required:

- Tap hole twist drill
- Screw tap
- Insertion tool
- Break tool

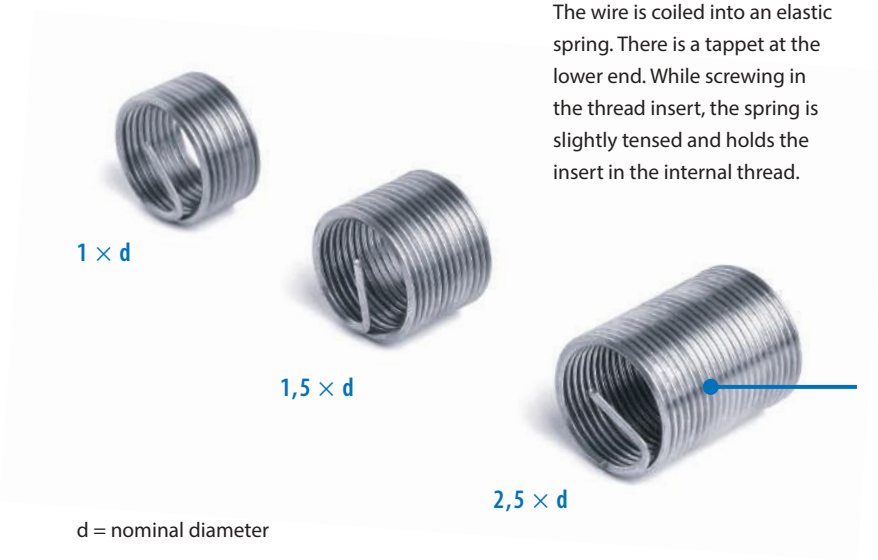


THREAD REPAIR TOOLS

THREAD INSERTS

Stainless steel GSR thread inserts guarantee a very good corrosion and heat resistance. The cross section is rhombic. The wire is coiled into an elastic spring. There is a tappet at the lower end. While screwing in the thread insert, the spring is slightly tensed and holds the insert in the internal thread.

The thread insert is therefore bigger when inserted compared to its initial state. There are three sizes, oriented at the nominal sizes (1 x d, 1.5 x d and 2.5 x d).



d = nominal diameter

THREAD REPAIR KIT

TECHNICAL INFORMATION

Material	HSS / TS
Direction	Right

each 1x twist drill – tap – insertion tool – break tool / each 5x thread inserts: 1d – 1.5 d – 2.5 d

Size	Tap		Twist drill		Insertion tool		Break tool		Art. No.
	Ø	Length	Ø	Length	Ø	Length	Ø	Length	
M 2 × 0,4	2,52	45	2,1	60	1,1	104	1	100	00803001
M 2,5 × 0,45	3,08	48	2,6	60	1,4	104	1,5	100	00803002
M 3 × 0,5	3,65	50	3,1	75	1,8	104	2,1	100	00803003
M 4 × 0,7	4,91	58	4,1	85	2,5	104	2,8	100	00803004
M 5 × 0,8	6,04	66	5,2	85	3,2	104	3,6	100	00803005
M 6 × 1,0	7,3	72	6,2	85	4,4	104	4,5	105	00803006
M 7 × 1,0	8,3	72	7,2	85	5	1304	5	110	00803007
M 8 × 1	9,3	80	8,2	115	5,7	140	5	110	00803008
M 8 × 1,25	9,62	80	8,3	115	5,7	140	6,2	110	00803009
M 9 × 1,25	10,62	89	9,3	115	6,5	145	6	110	00803010
M 10 × 1	11,3	89	10,3	130	7,5	150	7	115	00803011
M 10 × 1,25	11,62	89	10,3	130	7,5	150	7	115	00803012
M 10× 1,5	11,95	89	10,3	130	7,5	150	7,85	115	00803013
M 12 × 1	13,3	95	12,3	140	9	150	9	120	00803014
M 12 × 1,25	13,62	95	12,3	140	9	150	9	120	00803015
M 12 × 1,5	13,95	95	12,5	140	9	150	9	120	00803016
M 12 × 1,75	14,27	95	12,4	140	9	150	9	120	00803035

THREAD REPAIR KIT

TECHNICAL INFORMATION

Material	HSS / TS
Direction	Right

each 1x tap – insertion tool – break tool / each 4x thread inserts: 1d – 1.5 d – 2.5 d

Size	Tap		Insertion tool		Break tool		Art. No.
	Ø	Length	Ø	Length	Ø	Length	
M 14 × 1	15,3	102	11,2	170	10	103	00803017
M 14 × 1,25	15,62	102	10,8	170	10	103	00803018
M 14 × 1,5	15,95	102	10,8	170	10	103	00803019
M 14 × 2	16,6	102	10,5	170	10	103	00803020
M 16 × 1,5	17,95	112	12,5	170	12	103	00803021
M 16 × 2,0	18,6	112	12,2	170	12	103	00803022

THREAD REPAIR KIT

TECHNICAL INFORMATION

Material	HSS / TS
Direction	Right

each 1x tap – insertion tool – break tool / each 2x thread inserts: 1d – 1.5 d – 2.5 d

Size	Tap		Insertion tool		Break tool		Art. No.
	Ø	Length	Ø	Length	Ø	Length	
M 18 × 1,5	19,95	112	14,5	200	14	138	00803023
M 18 × 2,0	20,6	118	14	200	14	138	00803024
M 18 × 2,5	21,25	118	13,5	200	14	138	00803025
M 20 × 1,5	21,95	118	16,5	200	16	138	00803026
M 20 × 2,0	22,6	118	16	200	16	138	00803027
M 20 × 2,5	23,25	130	15,5	200	16	138	00803028
M 22 × 1,5	23,95	120	18,5	210	18	138	00803029
M 22 × 2,0	24,6	120	18	210	18	138	00803030
M 22 × 2,5	25,25	135	17,5	210	18	138	00803031
M 24 × 1,5	25,95	127	20,5	215	19	138	00803032
M 24 × 2,0	27,6	127	20	215	19	138	00803033
M 24 × 3,0	27,9	135	18,5	215	19	138	00803034

THREAD REPAIR KIT M5 – M12

TECHNICAL INFORMATION

Material	HSS / TS
Direction	Right

each 5x twist drills – taps – insertion tools – break tools / each 25x M5-M10 thread inserts: 1d
10x M12 thread inserts: 1d

Size	Tap		Twist drill		Insertion tool		Break tool		Art. No.
	Ø	Length	Ø	Length	Ø	Length	Ø	Length	
5 × 0,8	6,04	66	5,2	85	3,2	104	3,6	100	00803040
6 × 1,0	7,3	72	6,2	85	4,4	104	4,5	105	00803040
8 × 1,25	9,62	80	8,3	115	5,7	140	6,2	110	00803040
10 × 1,25	11,62	89	10,3	130	7,5	150	7	115	00803040
12 × 1,75	14,27	95	12,4	140	9	150	9	120	00803040

THREAD REPAIR KIT M6 – M14

TECHNICAL INFORMATION

Material	HSS / TS
Direction	Right

4x twist drills – each 5x taps – insertion tools – break tools / M14 x 1.25 for spark plug threads
each 25x M6-M10 thread inserts: 1d / 10x M12-M14 thread inserts: 1d

Size	Tap		Twist drill		Insertion tool		Break tool		Art. No.
	Ø	Length	Ø	Length	Ø	Length	Ø	Length	
6 × 1,0	7,3	72	6,2	85	4,4	104	4,5	105	00803041
8 × 1,25	9,62	80	8,3	115	5,7	140	6,2	110	00803041
10× 1,5	11,95	89	10,3	130	7,5	150	7,85	115	00803041
12 × 1,5	13,95	95	12,5	140	9	150	9	120	00803041
14 × 1,25	15,62	102	14,3	90	10,8	170	10	103	00803041

THREAD INSERTS

TECHNICAL INFORMATION

Material	Stainless steel
Thread	6H / ISO2

Size	QTY	Art.-No. 1,0 d	Art.-No. 1,5 d	Art.-No. 2,5 d
M 2 × 0,4	100	00806001	00806002	00806003
M 2,5 × 0,45	100	00806004	00806005	00806006
M 3 × 0,5	100	00806007	00806008	00806009
M 4 × 0,7	100	00806010	00806011	00806012
M 5 × 0,8	100	00806013	00806014	00806015
M 6 × 1,0	100	00806016	00806017	00806018
M 7 × 1,0	100	00806019	00806020	00806021
M 8 × 1	100	00806022	00806023	00806024
M 8 × 1,25	100	00806025	00806026	00806027
M 9 × 1,25	100	00806028	00806029	00806030
M 10 × 1	100	00806031	00806032	00806033
M 10 × 1,25	100	00806034	00806035	00806036
M 10× 1,5	100	00806037	00806038	00806039
M 12 × 1	100	00806040	00806041	00806042
M 12 × 1,25	100	00806043	00806044	00806045
M 12 × 1,5	100	00806046	00806047	00806048
M 12 × 1,75	100	00806103	00806104	00806105
M 14 × 1	100	00806049	00806050	00806051
M 14 × 1,25	50	00806052	00806053	00806054
M 14 × 1,5	50	00806055	00806056	00806057
M 14 × 2	50	00806058	00806059	00806060
M 16 × 1,5	50	00806061	00806062	00806063
M 16 × 2,0	50	00806064	00806065	00806066
M 18 × 1,5	50	00806067	00806068	00806069
M 18 × 2,0	25	00806070	00806071	00806072
M 18 × 2,5	25	00806073	00806074	00806075
M 20 × 1,5	25	00806076	00806077	00806078
M 20 × 2,0	25	00806079	00806080	00806081
M 20 × 2,5	25	00806082	00806083	00806084
M 22 × 1,5	25	00806085	00806086	00806087
M 22 × 2,0	10	00806088	00806089	00806090
M 22 × 2,5	10	00806091	00806092	00806093
M 24 × 1,5	10	00806094	00806095	00806096
M 24 × 2,0	10	00806097	00806098	00806099
M 24 × 3,0	10	00806100	00806101	00806102

INSERTION TOOLS

Material: TS

Size	ø	Length	Art.-No.
M 2 × 0,4	1,1	104	00805001
M 2,5 × 0,45	1,4	104	00805002
M 3 × 0,5	1,8	104	00805003
M 4 × 0,7	2,5	104	00805004
M 5 × 0,8	3,2	104	00805005
M 6 × 1,0	4,4	104	00805006
M 7 × 1,0	5	1304	00805007
M 8 × 1	5,7	140	00805008
M 8 × 1,25	5,7	140	00805009
M 9 × 1,25	6,5	145	00805010
M 10 × 1	7,5	150	00805011
M 10 × 1,25	7,5	150	00805012
M 10× 1,5	7,5	150	00805013
M 12 × 1	9	150	00805014
M 12 × 1,25	9	150	00805015
M 12 × 1,5	9	150	00805016
M 12 × 1,75	9	150	00805035
M 14 × 1	11,2	170	00805017
M 14 × 1,25	10,8	170	00805018
M 14 × 1,5	10,8	170	00805019
M 14 × 2	10,5	170	00805020
M 16 × 1,5	12,5	170	00805021
M 16 × 2,0	12,2	170	00805022
M 18 × 1,5	14,5	200	00805023
M 18 × 2,0	14	200	00805024
M 18 × 2,5	13,5	200	00805025
M 20 × 1,5	16,5	200	00805026
M 20 × 2,0	16	200	00805027
M 20 × 2,5	15,5	200	00805028
M 22 × 1,5	18,5	210	00805029
M 22 × 2,0	18	210	00805030
M 22 × 2,5	17,5	210	00805031
M 24 × 1,5	20,5	215	00805032
M 24 × 2,0	20	215	00805033
M 24 × 3,0	18,5	215	00805034

BREAK TOOLS

Material: TS

Size	ø	Length	Art.-No.
M 2 × 0,4	1	100	00804001
M 2,5 × 0,45	1,5	100	00804002
M 3 × 0,5	2,1	100	00804003
M 4 × 0,7	2,8	100	00804004
M 5 × 0,8	3,6	100	00804005
M 6 × 1,0	4,5	105	00804006
M 7 × 1,0	5	110	00804007
M 8 × 1	5	110	00804008
M 8 × 1,25	6,2	110	00804009
M 9 × 1,25	6	110	00804010
M 10 × 1	7	115	00804011
M 10 × 1,25	7	115	00804012
M 10× 1,5	7,85	115	00804013
M 12 × 1	9	120	00804014
M 12 × 1,25	9	120	00804015
M 12 × 1,5	9	120	00804016
M 12 × 1,75	9	120	00804035
M 14 × 1	10	103	00804017
M 14 × 1,25	10	103	00804018
M 14 × 1,5	10	103	00804019
M 14 × 2	10	103	00804020
M 16 × 1,5	12	103	00804021
M 16 × 2,0	12	103	00804022
M 18 × 1,5	14	138	00804023
M 18 × 2,0	14	138	00804024
M 18 × 2,5	14	138	00804025
M 20 × 1,5	16	138	00804026
M 20 × 2,0	16	138	00804027
M 20 × 2,5	16	138	00804028
M 22 × 1,5	18	138	00804029
M 22 × 2,0	18	138	00804030
M 22 × 2,5	18	138	00804031
M 24 × 1,5	19	138	00804032
M 24 × 2,0	19	138	00804033
M 24 × 3,0	19	138	00804034

TAPS

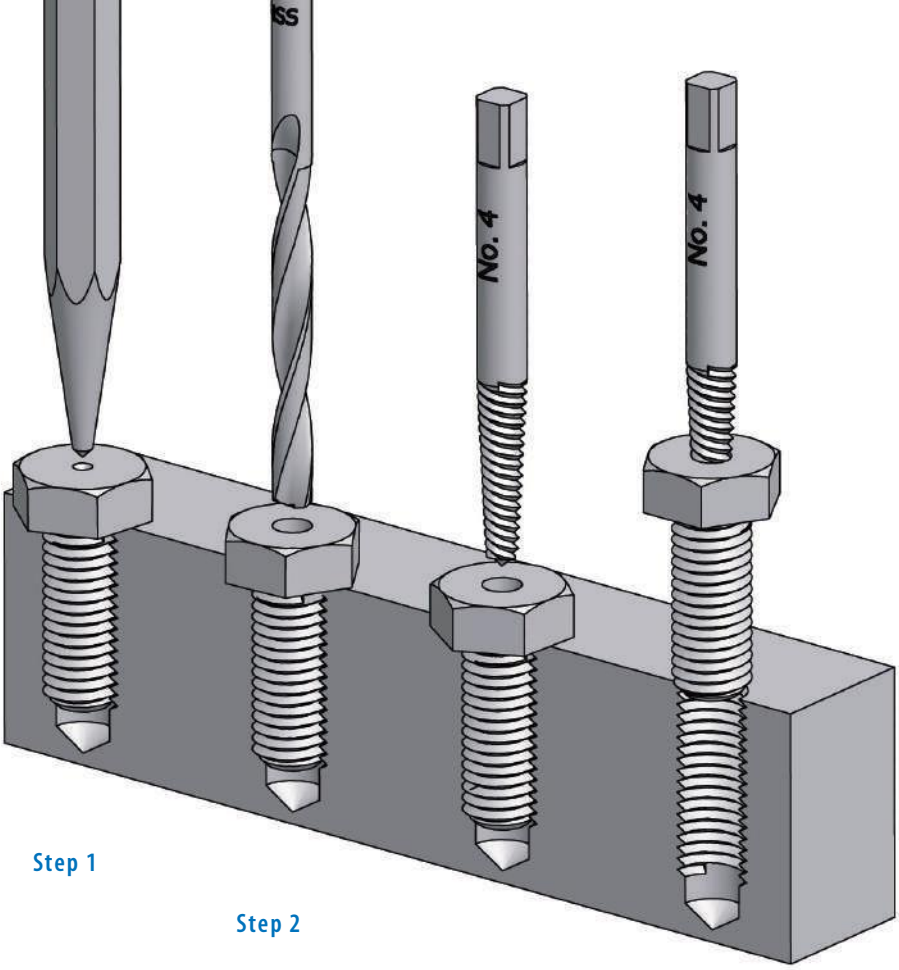
Material: HSS

Size	ø	Length	Art.-No.
M 2 × 0,4	2,52	45	00802000
M 2,5 × 0,45	3,08	48	00802010
M 3 × 0,5	3,65	50	00802020
M 4 × 0,7	4,91	58	00802030
M 5 × 0,8	6,04	66	00802040
M 6 × 1,0	7,3	72	00802050
M 7 × 1,0	8,3	72	00802060
M 8 × 1	9,3	80	00802070
M 8 × 1,25	9,62	80	00802080
M 9 × 1,25	10,62	89	00802090
M 10 × 1	11,3	89	00802100
M 10 × 1,25	11,62	89	00802110
M 10× 1,5	11,95	89	00802120
M 12 × 1	13,3	95	00802130
M 12 × 1,25	13,62	95	00802140
M 12 × 1,5	13,95	95	00802150
M 12 × 1,75	14,27	95	00802340
M 14 × 1	15,3	102	00802160
M 14 × 1,25	15,62	102	00802170
M 14 × 1,5	15,95	102	00802180
M 14 × 2	16,6	102	00802190
M 16 × 1,5	17,95	112	00802200
M 16 × 2,0	18,6	112	00802210
M 18 × 1,5	19,95	112	00802220
M 18 × 2,0	20,6	118	00802230
M 18 × 2,5	21,25	118	00802240
M 20 × 1,5	21,95	118	00802250
M 20 × 2,0	22,6	118	00802260
M 20 × 2,5	23,25	130	00802270
M 22 × 1,5	23,95	120	00802280
M 22 × 2,0	24,6	120	00802290
M 22 × 2,5	25,25	135	00802300
M 24 × 1,5	25,95	127	00802310
M 24 × 2,0	27,6	127	00802320
M 24 × 3,0	27,9	135	00802330

TWIST DRILLS

Material: HSS

Size	ø	Length	Art.-No.
M 2 × 0,4	2,1	60	03445021
M 2,5 × 0,45	2,6	60	03445026
M 3 × 0,5	3,1	75	03445031
M 4 × 0,7	4,1	85	03445041
M 5 × 0,8	5,2	85	03445052
M 6 × 1,0	6,2	85	03445062
M 7 × 1,0	7,2	85	03445072
M 8 × 1	8,2	115	03445082
M 8 × 1,25	8,3	115	03445083
M 9 × 1,25	9,3	115	03445093
M 10 × 1	10,3	130	03445103
M 10 × 1,25	10,3	130	03445103
M 10× 1,5	10,3	130	03445103
M 12 × 1	12,3	140	03445123
M 12 × 1,25	12,3	140	03445123
M 12 × 1,5	12,5	140	03445125
M 12 × 1,75	12,4	140	03445124



Step 1

Step 2

Step 3

Step 4

SCREW EXTRACTORS

Screw extractors allow the unscrewing of broken screws. First, the centre of the screw has to be punched properly with a centre punch. Then, a centric hole is drilled into the screw. Next, the screw extractor is twisted counter clockwise into the drilled hole. An adjustable tap wrench or a tool holder without a ratchet can be used as a holder.

PRECISION TAPER THREAD
rolled
Hardness: 54-65 HRC

SQUARE SHANK
according to DIN 10

HARDNESS ROCKWELL

Rockwell is an international measuring unit for the hardness of technical materials. The abbreviation consists of HR (Hardness Rockwell) as an identifier for the test procedure, followed by another letter which indicates the scale and thus the test force and specimens.

According to DIN EN ISO 6508-1, eleven scales with different test forces and specimens are standardised. Those scales are identified by the letters A-H, K, N and T. The standardised visualisation consists of the hardness value, test procedure and the scale, e.g. 65 HRC.

MAXIMAL USER TORQUE

N/mm² tensile strength

SIZE	SCREWS	DRILLS	DRILL DEPTH	TORQUE	SQUARE SHANK	TAP WRENCH
1	4 – 6	1,8	7	2,2	2	No. 1
2	6 – 8	3,2	10	10	3	No. 1
3	8 – 11	4,5	13	23	4	No. 2
4	11 – 14	6,5	16	70	5	No. 2
5	14 – 18	8,5	21	150	8	No. 3
6	18 – 24	11	24	180	9	No. 4

SCREW EXTRACTORS

SCREW EXTRACTORS

TECHNICAL INFORMATION

Material	Tool steel

Size	suitable for	suitable for	Total length	Diameter	Art.-No.
No. 1	W 1/8 – 1/4	M 3 – 6	51	3,8	00903000
No. 2	W 1/4 – 5/16	M 6 – 8	60	4,8	00903010
No. 3	W 5/16 – 7/16	M 8 – 11	68	6,4	00903020
No. 4	W 7/16 – 9/16	M 11 – 14	76	8,4	00903030
No. 5	W 9/16 – 3/4	M 14 – 18	86	10,9	00903040
No. 6	W 3/4 – 1	M 18 – 24	95	12,0	00903050
No. 7	W 1 – 1.3/8	M 24 – 33	100	18,9	00903060
No. 8	W 1.3/8 – 1.3/4	M 33 – 50	105	24,9	00903070

SCREW EXTRACTORS SET

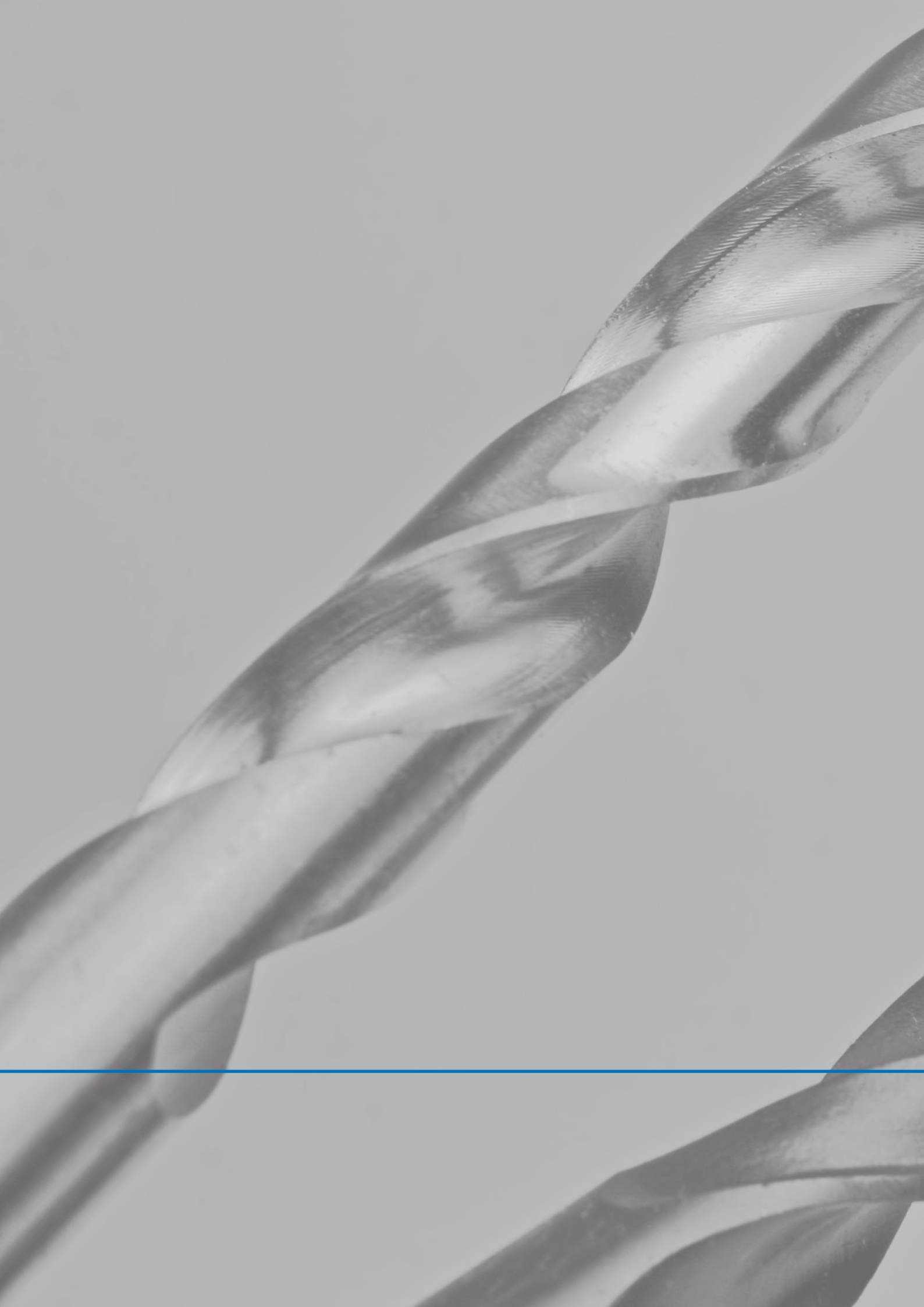
TECHNICAL INFORMATION

Material	Tool steel

Size	suitable for	suitable for	Art.-No.
No. 1 – 5	W 1/8 – 3/4	M 3 – 18	00902000
No. 1 – 6	W 1/8 – 1	M 3 – 24	00902020
No. 1 – 8	W 1/8 – 1.3/4	M 3 – 50	00902040

M14-18
M11-14
M8-11
M6-8
M3-6

DRILLING



DRILLING

Drilling is a mechanic separation processes, aimed at producing circular holes into a material by machining. The hole is referred to as bore. There is a differentiation between through holes and blind holes. In order to cut a thread into those bores, a tap hole has to be drilled. Tap holes have a distinctive size, matched with the required thread. Those drills are referred to as tap hole drills. Corresponding tap hole sizes can be found in the tap tables. These dimensions have to be maintained in any case while cutting threads.

DRILLS

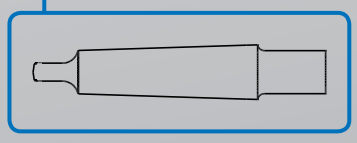
DRILLS DIN 345 · 20 · HSS

	Description
DIN 345 =	Twist drill with Morse taper shank
20 =	Diameter d = 20 mm
HSS =	High-speed steel

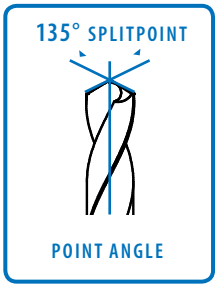
TWIST DRILLS

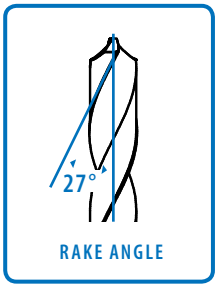
DIN 345

Twist drills according to DIN 345 have a rake angle of 27°, a point angle of 118°, as well as a Morse taper shank according to DIN 228 form B. The spiral coils are milled when the material is still soft.



MORSE TAPER SHANK





SHORT TWIST DRILLS

DIN 338

Short twist drills have a rank angle (sometimes referred to as angle of twist) of 27°, a point angle between 118° and 135° as well as a cylindrical shank. Type N is suitable for standard chipping materials. A distinction is made between roll forged and fully ground twist drills, depending on the production process.

When producing roll forged drills, the slugs are heated and formed into spiral coils. Fully ground drills get their spiral coil cut while being fully hardened. For a better distinction between the different types of twist drills, the following finishes are assigned to the different drills:

CYLINDRICAL SHANK

FULLY GROUND
= bright finish

ROLL FORGED
= black finish

FULLY GROUND HSSE
= amber finish

APPLICATION TABLE TWIST DRILLS

DIN		ARTICLE NO.	MATERIAL	COATING
DIN 338		03440	HSSR	Burnished
DIN 338		03445	HSSG	
DIN 338		03446	HSSG	TiN
DIN 338		03447	HSSE	HSS-Co
DIN 338		03460	HSSR	Burnished
DIN 338		03461	HSSR	Burnished
DIN 338		03462	HSSR	Burnished
DIN 340		03452	HSSG	
DIN 345		03454	HSS	Burnished
DIN 345		03463	HSSG	Burnished
DIN 345		03464	HSSE	HSS-Co
Factory Standard		03453	HSSG	
DIN 1897		03458	HSSR	Burnished
DIN 1897		03456	HSSG	
DIN 1897		03459	HSSE	HSS-Co
~DIN 1897		03466	HSS	Burnished
~DIN 1897		03465	HSSG	HSS-Co
Factory Standard		03467	HSSE	HSS-Co
Factory Standard		03468	HSSE	Tin HSS-Co
Factory Standard		03469	HSSE	HSS-Co
Factory Standard		03470	HSSE	Tin HSS-Co

POINT ANGLE	DESCRIPTION	APPLICATION	PAGE
118°	Short twist drill, roll forged, chisel edge	Standard bore – steel and cast steel up to 800 N/mm², grey cast iron, malleable cast iron, ductile iron, sintered iron, nickel silver, graphite	348
135°	Short twist drill, fully ground, split point	Standard bore – steel and cast steel up to 900 N/mm², grey cast iron, malleable cast iron, ductile iron, sintered iron, nickel silver, graphite	348
135°	Short twist drill, fully ground with TiN coating, split point	Standard bore – steel and cast steel up to 900 N/mm², grey cast iron, malleable cast iron, ductile iron, sintered iron, nickel silver, graphite	348
135°	Short twist drill, fully ground (gold-finish), cobalt alloyed, split point	Standard bore – alloyed and unalloyed steels and casts over 800 N/mm², high-alloyed steels and Q&T steels, case hardening steels	348
118°	Short twist drill red. 8mm, roll forged with reduced shank, chisel edge	Standard bore – steel and cast steel up to 800 N/mm², grey cast iron, malleable cast iron, ductile iron, sintered iron, nickel silver, graphite	352
118°	Short twist drill red. 10mm, roll forged with reduced shank, chisel edge	Standard bore – steel and cast steel up to 800 N/mm², grey cast iron, malleable cast iron, ductile iron, sintered iron, nickel silver, graphite	352
118°	Short twist drill red. 13mm, roll forged with reduced shank, chisel edge	Standard bore – steel and cast steel up to 800 N/mm², grey cast iron, malleable cast iron, ductile iron, sintered iron, nickel silver, graphite	352
135°	Long twist drill, fully ground, split point	Deep bore – steel and cast steel, grey cast iron, malleable cast iron, ductile iron, sintered iron, nickel silver, graphite	353
118°	Morse taper drill, extruded, chisel edge	Standard bore – steel and cast steel up to 900 N/mm², grey cast iron, malleable cast iron, ductile iron, sintered iron, nickel silver, graphite	354
118°	Morse taper drill, milled, split point DIN 1412A, chisel edge	Standard bore – steel and cast steel up to 900 N/mm², grey cast iron, malleable cast iron, ductile iron, sintered iron, nickel silver, graphite	354
118°	Morse taper drill, milled, cobalt alloyed, split point DIN 1412A, chisel edge	Standard machine bore – alloyed and unalloyed steels and casts over 800 N/mm², high-alloyed steels and Q&T steels, case hardening steels	354
118°	Double end drill, fully ground, split point	Thin materials at body construction or rivet holes	357
135°	Extra short twist drill, roll forged, chisel edge	Thin materials at body construction or rivet holes	358
135°	Extra short twist drill, fully ground, split point	Thin materials at body construction or rivet holes	358
135°	Extra short twist drill, fully ground (gold-finish), cobalt alloyed, split point	Thin materials – alloyed and unalloyed steels and casts over 800 N/mm², high-alloyed steels and Q&T steels, case hardening steels	358
118°	Extra short twist drill, point angle	Extra thin materials – metal sheet (steel, brass, aluminium), plastic sheets, body and metal construction	361
118°	Extra short twist drill, fully ground, split point	Extra thin materials – metal sheet (steel, brass, aluminium), plastic sheets, body and metal construction	361
90°	NC spot drill 90°, fully ground, cobalt alloyed	For usage in CNC machines and for centring and chamfering	362
90°	NC spot drill 90°, fully ground with TiN coating, cobalt alloyed	For usage in CNC machines and for centring and chamfering	362
120°	NC spot drill 120°, fully ground, cobalt alloyed	For usage in CNC machines and for centring and chamfering	362
120°	NC spot drill 120°, fully ground with TiN coating, cobalt alloyed	For usage in CNC machines and for centring and chamfering	362

APPLICATION TABLE TWIST DRILLS

DIN		ARTICLE NO.	MATERIAL	COATING
DIN 1869/1		03471	HSSG	
DIN 1869/2		03472	HSSG	
DIN 1869/3		03473	HSSG	
Factory Standard		03474	HSS	
Factory Standard		03475	HSS	TiN
~DIN 1897		03478	HSSE	HSS-Co
~DIN 1897		03479	HSSE	TiN HSS-Co
Factory Standard		03480	HSSE	HSS-Co
Factory Standard		03490	HSSE	TiN HSS-Co
DIN 8374		03486	HSS	Burnished
DIN 8376		03488	HSS	Burnished
DIN 8378		03489	HSS	Burnished
Factory Standard		04502	HSSG	

POINT ANGLE	DESCRIPTION	APPLICATION	PAGE
130°	Deep-hole twist drill series 1, fully ground, split point	Extra deep bore – grey cast iron and steels up to 1000 N/mm²	363
130°	Deep-hole twist drill series 2, fully ground, split point	Extra deep bore – grey cast iron and steels up to 1000 N/mm²	363
130°	Deep-hole twist drill series 3, fully ground, split point	Extra deep bore – grey cast iron and steels up to 1000 N/mm²	364
118°	Milling drill, fully ground	Special milling drill – drilling and milling of metal, wood and plastic	364
118°	Milling drill, fully ground with TiN coating	Special milling drill – drilling and milling of metal, wood and plastic	364
	Spot weld drill, fully ground, cobalt alloyed, special tip	Alloyed and unalloyed steels and casts up to 900 N/mm², high-alloyed steels and Q&T steels, case hardening steels	365
	Spot weld drill, fully ground with TiN coating, special tip DIN 1412E	Alloyed and unalloyed steels and casts up to 900 N/mm², high-alloyed steels and Q&T steels, case hardening steels	365
	Spotle/Vario spot weld drill, fully ground, cobalt alloyed, special tip	Spotle-drill for Spotle T575, Vario-drill for Vario WS90	365
	Spotle/Vario spot weld drill, fully ground, cobalt alloyed with TiN coating, special tip DIN 1412	Spotle-drill for Spotle T575, Vario-drill for Vario WS90	365
90°	Subland drill 90°, milled	Steel and cast steel up to 900 N/mm², grey cast iron, malleable cast iron, ductile iron, sintered iron, nickel silver, graphite	365
180°	Subland drill 180°, milled	Steel and cast steel up to 900 N/mm², grey cast iron, malleable cast iron, ductile iron, sintered iron, nickel silver, graphite	366
90°	Subland drill 90°, milled	Steel and cast steel up to 900 N/mm², grey cast iron, malleable cast iron, ductile iron, sintered iron, nickel silver, graphite	366
130°	Twist drill bit, fully ground, split point	Steel and cast steel up to 900 N/mm², grey cast iron, malleable cast iron, ductile iron, sintered iron, nickel silver, graphite	367

TWIST DRILLS

TECHNICAL INFORMATION

Standard	DIN 338	Raw material	Steel / Stainless steel
Material	HSSR / HSSG / HSSG-TiN / HSSE	Form	Typ N
short version, chisel edge at HSSR			
split point over 3mm at HSSG / HSSG-TiN / HSSE			

			Art.-No. HSSR	Art.-No. HSSG	Art.-No. HSSG-TiN	Art.-No. HSSE
0,5	22	6	03440005	03445005	03446005	03447005
0,6	24	7	03440006	03445006	03446006	03447006
0,7	28	9	03440007	03445007	03446007	03447007
0,8	30	10	03440008	03445008	03446008	03447008
0,9	32	11	03440009	03445009	03446009	03447009
1,0	34	12	03440010	03445010	03446010	03447010
1,1	36	14	03440011	03445011	03446011	03447011
1,2	38	16	03440012	03445012	03446012	03447012
1,3	38	16	03440013	03445013	03446013	03447013
1,4	40	18	03440014	03445014	03446014	03447014
1,5	40	18	03440015	03445015	03446015	03447015
1,6	43	20	03440016	03445016	03446016	03447016
1,7	43	20	03440017	03445017	03446017	03447017
1,8	46	22	03440018	03445018	03446018	03447018
1,9	46	22	03440019	03445019	03446019	03447019
2,0	49	24	03440020	03445020	03446020	03447020
2,1	49	24	03440021	03445021	03446021	03447021
2,2	53	27	03440022	03445022	03446022	03447022
2,3	53	27	03440023	03445023	03446023	03447023
2,4	57	30	03440024	03445024	03446024	03447024
2,5	57	30	03440025	03445025	03446025	03447025
2,6	57	30	03440026	03445026	03446026	03447026
2,7	61	33	03440027	03445027	03446027	03447027
2,8	61	33	03440028	03445028	03446028	03447028
2,9	61	33	03440029	03445029	03446029	03447029
3,0	65	33	03440030	03445030	03446030	03447030
3,1	65	36	03440031	03445031	03446031	03447031
3,2	65	36	03440032	03445032	03446032	03447032
3,3	70	36	03440033	03445033	03446033	03447033
3,4	70	39	03440034	03445034	03446034	03447034
3,5	70	39	03440035	03445035	03446035	03447035
3,6	70	39	03440036	03445036	03446036	03447036
3,7	70	39	03440037	03445037	03446037	03447037
3,8	75	43	03440038	03445038	03446038	03447038
3,9	75	43	03440039	03445039	03446039	03447039
4,0	75	43	03440040	03445040	03446040	03447040

			Art.-No. HSSR	Art.-No. HSSG	Art.-No. HSSG-TiN	Art.-No. HSSE
4,1	75	43	03440041	03445041	03446041	03447041
4,2	75	43	03440042	03445042	03446042	03447042
4,3	80	47	03440043	03445043	03446043	03447043
4,4	80	47	03440044	03445044	03446044	03447044
4,5	80	47	03440045	03445045	03446045	03447045
4,6	80	47	03440046	03445046	03446046	03447046
4,7	80	47	03440047	03445047	03446047	03447047
4,8	86	52	03440048	03445048	03446048	03447048
4,9	86	52	03440049	03445049	03446049	03447049
5,0	86	52	03440050	03445050	03446050	03447050
5,1	86	52	03440051	03445051	03446051	03447051
5,2	86	52	03440052	03445052	03446052	03447052
5,3	86	52	03440053	03445053	03446053	03447053
5,4	93	57	03440054	03445054	03446054	03447054
5,5	93	57	03440055	03445055	03446055	03447055
5,6	93	57	03440056	03445056	03446056	03447056
5,7	93	57	03440057	03445057	03446057	03447057
5,8	93	57	03440058	03445058	03446058	03447058
5,9	93	57	03440059	03445059	03446059	03447059
6,0	93	57	03440060	03445060	03446060	03447060
6,1	101	63	03440061	03445061	03446061	03447061
6,2	101	63	03440062	03445062	03446062	03447062
6,3	101	63	03440063	03445063	03446063	03447063
6,4	101	63	03440064	03445064	03446064	03447064
6,5	101	63	03440065	03445065	03446065	03447065
6,6	101	63	03440066	03445066	03446066	03447066
6,7	101	63	03440067	03445067	03446067	03447067
6,8	109	69	03440068	03445068	03446068	03447068
6,9	109	69	03440069	03445069	03446069	03447069
7,0	109	69	03440070	03445070	03446070	03447070
7,1	109	69	03440071	03445071	03446071	03447071
7,2	109	69	03440072	03445072	03446072	03447072
7,3	109	69	03440073	03445073	03446073	03447073
7,4	109	69	03440074	03445074	03446074	03447074
7,5	109	69	03440075	03445075	03446075	03447075
7,6	117	75	03440076	03445076	03446076	03447076
7,7	117	75	03440077	03445077	03446077	03447077
7,8	117	75	03440078	03445078	03446078	03447078
7,9	117	75	03440079	03445079	03446079	03447079
8,0	117	75	03440080	03445080	03446080	03447080
8,1	117	75	03440081	03445081	03446081	03447081
8,2	117	75	03440082	03445082	03446082	03447082
8,3	117	75	03440083	03445083	03446083	03447083
8,4	117	75	03440084	03445084	03446084	03447084

			Art.-No. HSSR	Art.-No. HSSG	Art.-No. HSSG-TiN	Art.-No. HSSE
8,5	117	75	03440085	03445085	03446085	03447085
8,6	125	81	03440086	03445086	03446086	03447086
8,7	125	81	03440087	03445087	03446087	03447087
8,8	125	81	03440088	03445088	03446088	03447088
8,9	125	81	03440089	03445089	03446089	03447089
9,0	125	81	03440090	03445090	03446090	03447090
9,1	125	81	03440091	03445091	03446091	03447091
9,2	125	81	03440092	03445092	03446092	03447092
9,3	125	81	03440093	03445093	03446093	03447093
9,4	125	81	03440094	03445094	03446094	03447094
9,5	125	81	03440095	03445095	03446095	03447095
9,6	133	87	03440096	03445096	03446096	03447096
9,7	133	87	03440097	03445097	03446097	03447097
9,8	133	87	03440098	03445098	03446098	03447098
9,9	133	87	03440099	03445099	03446099	03447099
10,0	133	87	03440100	03445100	03446100	03447100
10,1	133	87	03440101	03445101	03446101	03447101
10,2	133	87	03440102	03445102	03446102	03447102
10,3	133	87	03440103	03445103	03446103	03447103
10,4	133	87	03440104	03445104	03446104	03447104
10,5	133	87	03440105	03445105	03446105	03447105
10,6	142	94	03440106	03445106	03446106	03447106
10,7	142	94	03440107	03445107	03446107	03447107
10,8	142	94	03440108	03445108	03446108	03447108
10,9	142	94	03440109	03445109	03446109	03447109
11,0	142	94	03440110	03445110	03446110	03447110
11,1	142	94	03440111	03445111	03446111	03447111
11,2	142	94	03440112	03445112	03446112	03447112
11,3	142	94	03440113	03445113	03446113	03447113
11,4	142	94	03440114	03445114	03446114	03447114
11,5	142	94	03440115	03445115	03446115	03447115
11,6	142	94	03440116	03445116	03446116	03447116
11,7	142	94	03440117	03445117	03446117	03447117
11,8	142	94	03440118	03445118	03446118	03447118
11,9	151	101	03440119	03445119	03446119	03447119
12,0	151	101	03440120	03445120	03446120	03447120
12,1	151	101	03440121	03445121	03446121	03447121
12,2	151	101	03440122	03445122	03446122	03447122
12,3	151	101	03440123	03445123	03446123	03447123
12,4	151	101	03440124	03445124	03446124	03447124
12,5	151	101	03440125	03445125	03446125	03447125
12,6	151	101	03440126	03445126	03446126	03447126
12,7	151	101	03440127	03445127	03446127	03447127
12,8	151	101	03440128	03445128	03446128	03447128

			Art.-No. HSSR	Art.-No. HSSG	Art.-No. HSSG-TiN	Art.-No. HSSE
12,9	151	101	03440129	03445129	03446129	03447129
13,0	151	101	03440130	03445130	03446130	03447130
13,5	160	108	03440135	03445135	03446135	03447135
14,0	160	108	03440140	03445140	03446140	03447140
14,5	169	114	03440145	03445145	03446145	03447145
15,0	169	114	03440150	03445150	03446150	03447150
15,5	178	120	03440155	03445155	03446155	03447155
16,0	178	120	03440160	03445160	03446160	03447160
16,5	184	125	03440165			
17,0	184	125	03440170			
17,5	191	130	03440175			
18,0	191	130	03440180			
18,5	198	135	03440185			
19,0	198	135	03440190			
19,5	205	140	03440195			
20,0	205	140	03440200			

TWIST DRILLS

TECHNICAL INFORMATION

Standard	DIN 338	Hole type	Through hole
Material	HSS	Direction	Right
Raw material	Steel	Form	Typ N

with reduced shank, roll forged, black

			Art.-No. 8 mm	Art.-No. 10 mm	Art.-No. 13 mm
8,5	117	75	03460085	—	—
9,0	125	81	03460090	—	—
9,5	125	81	03460095	—	—
10,0	133	87	03460100	03461100	—
10,5	133	87	03460105	03461105	—
11,0	142	94	03460110	03461110	—
11,5	142	94	03460115	03461115	—
12,0	151	101	03460120	03461120	—
12,5	151	101	03460125	03461125	—
13,0	151	101	03460130	03461130	—
13,5	160	108	—	03461135	03462135
14,0	160	108	—	03461140	03462140
14,5	169	114	—	03461145	03462145
15,0	169	114	—	03461150	03462150
15,5	178	120	—	03461155	03462155
16,0	178	120	—	03461160	03462160
16,5	184	125	—	03461165	03462165
17,0	184	125	—	03461170	03462170
17,5	191	130	—	03461175	03462175
18,0	191	130	—	03461180	03462180
18,5	198	135	—	03461185	03462185
19,0	198	135	—	03461190	03462190
19,5	205	140	—	03461195	03462195
20,0	205	140	—	03461200	03462200
20,5	205	145	—	—	03462205
21,0	205	145	—	—	03462210
21,5	210	150	—	—	03462215
22,0	210	150	—	—	03462220
23,0	215	155	—	—	03462230
24,0	220	160	—	—	03462240
25,0	220	160	—	—	03462250
26,0	235	165	—	—	03462260
27,0	235	170	—	—	03462270
28,0	235	170	—	—	03462280
29,0	240	175	—	—	03462290
30,0	240	175	—	—	03462300

TWIST DRILLS

TECHNICAL INFORMATION

Standard	DIN 340	Form	Typ N
Material	HSSG		
Raw material	Steel		

with split point, long version, fully ground

			Art.-No.
0,7	42	21	03452007
1,0	56	33	03452010
1,5	70	45	03452015
2,0	85	56	03452020
2,5	95	62	03452025
2,9	100	66	03452029
3,0	100	66	03452030
3,1	106	69	03452031
3,2	106	69	03452032
3,3	106	69	03452033
3,5	112	73	03452035
3,8	119	78	03452038
3,9	119	78	03452039
4,0	119	78	03452040
4,1	119	78	03452041
4,2	119	78	03452042
4,3	126	80	03452043
4,5	126	82	03452045
4,8	132	87	03452048
4,9	132	87	03452049
5,0	132	87	03452050
5,1	132	87	03452051
5,2	132	87	03452052
5,3	132	87	03452053
5,5	139	91	03452055
5,8	139	91	03452058
6,0	139	91	03452060
6,2	148	97	03452062
6,3	148	97	03452063
6,5	148	97	03452065
6,8	156	102	03452068
7,0	156	102	03452070
7,2	156	102	03452072
7,5	156	102	03452075
7,8	165	109	03452078
8,0	165	109	03452080

			Art.-No.
8,2	165	109	03452082
8,5	165	109	03452085
9,0	175	115	03452090
9,5	175	115	03452095
9,8	184	121	03452098
10,0	184	121	03452100
10,2	184	121	03452102
10,5	184	121	03452105
11,0	195	128	03452110
11,5	195	128	03452115
12,0	205	134	03452120
12,5	205	134	03452125
13,0	205	134	03452130
14,0	214	140	03452140
15,0	220	144	03452150

TWIST DRILLS

TECHNICAL INFORMATION

Standard	DIN 345	Raw material	Steel / Stainless steel
Material	HSS / HSSG / HSSE	Form	Typ N

with Morse taper shank

			Art.-No. HSS	Art.-No. HSSG	Art.-No. HSSE
6	138	57	03454060	03463060	03464060
6,5	144	63	03454065	03463065	03464065
6,8	150	69	03454068	03463068	03464068
7	150	69	03454070	03463070	03464070
7,5	150	69	03454075	03463075	03464075
8	156	75	03454080	03463080	03464080
8,5	156	75	03454085	03463085	03464085
9	162	81	03454090	03463090	03464090
9,5	162	81	03454095	03463095	03464095
10	168	87	03454100	03463100	03464100
10,2	168	87	03454102	03463102	03464102
10,5	168	87	03454105	03463105	03464105
11	175	94	03454110	03463110	03464110
11,5	175	94	03454115	03463115	03464115
12	182	101	03454120	03463120	03464120
12,5	182	101	03454125	03463125	03464125
13	182	101	03454130	03463130	03464130

			Art.-No. HSS	Art.-No. HSSG	Art.-No. HSSE
13,5	189	108	03454135	03463135	03464135
14	189	108	03454140	03463140	03464140
14,5	212	114	03454145	03463145	03464145
15	212	114	03454150	03463150	03464150
15,5	218	120	03454155	03463155	03464155
16	218	120	03454160	03463160	03464160
16,5	223	125	03454165	03463165	03464165
17	223	125	03454170	03463170	03464170
17,5	228	130	03454175	03463175	03464175
18	228	130	03454180	03463180	03464180
18,5	233	135	03454185	03463185	03464185
19	233	135	03454190	03463190	03464190
19,5	238	140	03454195	03463195	03464195
20	238	140	03454200	03463200	03464200
20,5	243	145	03454205	03463205	03464205
21	243	145	03454210	03463210	03464210
21,5	248	150	03454215	03463215	03464215
22	248	150	03454220	03463220	03464220
22,5	253	155	03454225	03463225	03464225
23	253	155	03454230	03463230	03464230
23,5	276	155	03454235	03463235	03464235
24	281	160	03454240	03463240	03464240
24,5	281	160	03454245	03463245	03464245
25	281	160	03454250	03463250	03464250
25,5	286	165	03454255	03463255	03464255
26	286	165	03454260	03463260	03464260
26,5	286	165	03454265	03463265	03464265
27	291	170	03454270	03463270	03464270
27,5	291	170	03454275	03463275	03464275
28	291	170	03454280	03463280	03464280
28,5	296	175	03454285	03463285	03464285
29	296	175	03454290	03463290	03464290
29,5	296	175	03454295	03463295	03464295
30	296	175	03454300	03463300	03464300
30,5	301	180	03454305	03463305	03464305
31	301	180	03454310	03463310	03464310
31,5	301	180	03454315	03463315	03464315
32	334	185	03454320	03463320	03464320
32,5	334	185	03454325	03463325	03464325
33	334	185	03454330	03463330	03464330
33,5	334	185	03454335	03463335	03464335
34	339	190	03454340	03463340	03464340
34,5	339	190	03454345	03463345	03464345
35	339	190	03454350	03463350	03464350

			Art.-No. HSS	Art.-No. HSSG	Art.-No. HSSE
35,5	339	190	03454355	03463355	03464355
36	344	195	03454360	03463360	03464360
36,5	344	195	03454365	03463365	03464365
37	344	195	03454370	03463370	03464370
37,5	344	195	03454375	03463375	03464375
38	349	200	03454380	03463380	03464380
38,5	349	200	03454385	03463385	03464385
39	349	200	03454390	03463390	03464390
39,5	349	200	03454395	03463395	03464395
40	349	200	03454400	03463400	03464400
40,5	354	205	03454405	03463405	03464405
41	354	205	03454410	03463410	03464410
41,5	354	205	03454415	03463415	03464415
42	354	205	03454420	03463420	03464420
42,5	354	205	03454425	03463425	03464425
43	359	210	03454430	03463430	03464430
43,5	359	210	03454435	03463435	03464435
44	359	210	03454440	03463440	03464440
44,5	359	210	03454445	03463445	03464445
45	359	210	03454450	03463450	03464450
45,5	364	215	03454455	03463455	03464455
46	364	215	03454460	03463460	03464460
46,5	364	215	03454465	03463465	03464465
47	364	215	03454470	03463470	03464470
47,5	364	215	03454475	03463475	03464475
48	369	220	03454480	03463480	03464480
48,5	369	220	03454485	03463485	03464485
49	369	220	03454490	03463490	03464490
49,5	369	220	03454495	03463495	03464495
50	369	220	03454500	03463500	03464500
51	412	225	03454510	03463510	03464510
52	412	225	03454520	03463520	03464520
53	412	225	03454530	03463530	03464530
54	417	230	03454540	03463540	03464540
55	417	230	03454550	03463550	03464550
56	417	230	03454560	03463560	03464560
57	422	235	03454570	03463570	03464570
58	422	235	03454580	03463580	03464580
59	422	235	03454590	03463590	03464590
60	422	235	03454600	03463600	03464600
61	427	240	03454610	—	—
62	427	240	03454620	—	—
63	427	240	03454630	—	—
64	432	245	03454640	—	—
65	432	245	03454650	—	—

			Art.-No. HSS	Art.-No. HSSG	Art.-No. HSSE
66	432	245	03454660	—	—
67	432	245	03454670	—	—
68	437	250	03454680	—	—
69	437	250	03454690	—	—
70	437	250	03454700	—	—
71	437	250	03454710	—	—
72	442	255	03454720	—	—
73	442	255	03454730	—	—
74	442	255	03454740	—	—
75	442	255	03454750	—	—

DOUBLE END DRILLS

TECHNICAL INFORMATION

Material	HSSG
Raw material	Steel

double-sided, fully ground, with split point

			Art.-No.
2,0	38	7,5	03453020
2,5	43	9,5	03453025
2,7	46	9,5	03453027
3,0	46	9,5	03453030
3,1	49	9,5	03453031
3,2	49	9,5	03453032
3,3	49	9,5	03453033
3,4	52	13	03453034
3,5	52	13	03453035
3,8	55	13	03453038
4,0	55	13	03453040
4,1	55	13	03453041
4,2	55	13	03453042
4,5	58	16	03453045
4,8	62	16	03453048
4,9	62	16	03453049
5,0	62	16	03453050
5,1	62	16	03453051
5,2	62	16	03453052
5,5	66	16	03453055
6,0	66	16	03453060
6,5	70	18	03453065
7,0	74	19	03453070
8,0	79	20	03453080

TWIST DRILLS

TECHNICAL INFORMATION

Standard	DIN 1897	Raw material	Steel / Stainless steel
Material	HSSR / HSSG / HSSG-TiN / HSSE	Form	Typ N

with cylindrical shank, short version, with split point

			Art.-No. HSSR	Art.-No. HSSG	Art.-No. HSSG-TiN	Art.-No. HSSE
1,0	26	6	03458010	03456010	03457010	03459010
1,5	32	9	03458015	03456015	03457015	03459015
2,0	38	12	03458020	03456020	03457020	03459020
2,1	38	12	03458021	03456021	03457021	03459021
2,2	40	13	03458022	03456022	03457022	03459022
2,3	40	13	03458023	03456023	03457023	03459023
2,4	43	14	03458024	03456024	03457024	03459024
2,5	43	14	03458025	03456025	03457025	03459025
2,6	43	14	03458026	03456026	03457026	03459026
2,7	46	16	03458027	03456027	03457027	03459027
2,8	46	16	03458028	03456028	03457028	03459028
2,9	46	16	03458029	03456029	03457029	03459029
3,0	46	16	03458030	03456030	03457030	03459030
3,1	49	18	03458031	03456031	03457031	03459031
3,2	49	18	03458032	03456032	03457032	03459032
3,3	49	18	03458033	03456033	03457033	03459033
3,4	52	20	03458034	03456034	03457034	03459034
3,5	52	20	03458035	03456035	03457035	03459035
3,6	52	20	03458036	03456036	03457036	03459036
3,7	52	20	03458037	03456037	03457037	03459037
3,8	55	22	03458038	03456038	03457038	03459038
3,9	55	22	03458039	03456039	03457039	03459039
4,0	55	22	03458040	03456040	03457040	03459040
4,1	55	22	03458041	03456041	03457041	03459041
4,2	55	22	03458042	03456042	03457042	03459042
4,3	58	24	03458043	03456043	03457043	03459043
4,4	58	24	03458044	03456044	03457044	03459044
4,5	58	24	03458045	03456045	03457045	03459045
4,6	58	24	03458046	03456046	03457046	03459046
4,7	58	24	03458047	03456047	03457047	03459047
4,8	62	26	03458048	03456048	03457048	03459048
4,9	62	26	03458049	03456049	03457049	03459049
5,0	62	26	03458050	03456050	03457050	03459050
5,1	62	26	03458051	03456051	03457051	03459051
5,2	62	26	03458052	03456052	03457052	03459052
5,3	62	26	03458053	03456053	03457053	03459053

			Art.-No. HSSR	Art.-No. HSSG	Art.-No. HSSG-TiN	Art.-No. HSSE
5,4	66	28	03458054	03456054	03457054	03459054
5,5	66	28	03458055	03456055	03457055	03459055
5,6	66	28	03458056	03456056	03457056	03459056
5,7	66	28	03458057	03456057	03457057	03459057
5,8	66	28	03458058	03456058	03457058	03459058
5,9	66	28	03458059	03456059	03457059	03459059
6,0	66	28	03458060	03456060	03457060	03459060
6,1	70	31	03458061	03456061	03457061	03459061
6,2	70	31	03458062	03456062	03457062	03459062
6,3	70	31	03458063	03456063	03457063	03459063
6,4	70	31	03458064	03456064	03457064	03459064
6,5	70	31	03458065	03456065	03457065	03459065
6,6	70	31	03458066	03456066	03457066	03459066
6,7	70	31	03458067	03456067	03457067	03459067
6,8	74	34	03458068	03456068	03457068	03459068
6,9	74	34	03458069	03456069	03457069	03459069
7,0	74	34	03458070	03456070	03457070	03459070
7,1	74	34	03458071	03456071	03457071	03459071
7,2	74	34	03458072	03456072	03457072	03459072
7,3	74	34	03458073	03456073	03457073	03459073
7,4	74	34	03458074	03456074	03457074	03459074
7,5	74	34	03458075	03456075	03457075	03459075
7,6	79	37	03458076	03456076	03457076	03459076
7,7	79	37	03458077	03456077	03457077	03459077
7,8	79	37	03458078	03456078	03457078	03459078
7,9	79	37	03458079	03456079	03457079	03459079
8,0	79	37	03458080	03456080	03457080	03459080
8,1	79	37	03458081	03456081	03457081	03459081
8,2	79	37	03458082	03456082	03457082	03459082
8,3	79	37	03458083	03456083	03457083	03459083
8,4	79	37	03458084	03456084	03457084	03459084
8,5	79	37	03458085	03456085	03457085	03459085
8,6	84	40	03458086	03456086	03457086	03459086
8,7	84	40	03458087	03456087	03457087	03459087
8,8	84	40	03458088	03456088	03457088	03459088
8,9	84	40	03458089	03456089	03457089	03459089
9,0	84	40	03458090	03456090	03457090	03459090
9,1	84	40	03458091	03456091	03457091	03459091
9,2	84	40	03458092	03456092	03457092	03459092
9,3	84	40	03458093	03456093	03457093	03459093
9,4	84	40	03458094	03456094	03457094	03459094
9,5	84	40	03458095	03456095	03457095	03459095
9,6	89	43	03458096	03456096	03457096	03459096
9,7	89	43	03458097	03456097	03457097	03459097

			Art.-No. HSSR	Art.-No. HSSG	Art.-No. HSSG-TiN	Art.-No. HSSE
9,8	89	43	03458098	03456098	03457098	03459098
9,9	89	43	03458099	03456099	03457099	03459099
10,0	89	43	03458100	03456100	03457100	03459100
10,1	89	43	03458101	03456101	03457101	03459101
10,2	89	43	03458102	03456102	03457102	03459102
10,3	89	43	03458103	03456103	03457103	03459103
10,4	89	43	03458104	03456104	03457104	03459104
10,5	89	43	03458105	03456105	03457105	03459105
10,6	89	43	03458106	03456106	03457106	03459106
10,7	95	47	03458107	03456107	03457107	03459107
10,8	95	47	03458108	03456108	03457108	03459108
10,9	95	47	03458109	03456109	03457109	03459109
11,0	95	47	03458110	03456110	03457110	03459110
11,1	95	47	03458111	03456111	03457111	03459111
11,2	95	47	03458112	03456112	03457112	03459112
11,3	95	47	03458113	03456113	03457113	03459113
11,4	95	47	03458114	03456114	03457114	03459114
11,5	95	47	03458115	03456115	03457115	03459115
11,6	95	47	03458116	03456116	03457116	03459116
11,7	95	47	03458117	03456117	03457117	03459117
11,8	95	47	03458118	03456118	03457118	03459118
11,9	102	51	03458119	03456119	03457119	03459119
12,0	102	51	03458120	03456120	03457120	03459120
12,1	102	51	03458121	03456121	03457121	03459121
12,2	102	51	03458122	03456122	03457122	03459122
12,3	102	51	03458123	03456123	03457123	03459123
12,4	102	51	03458124	03456124	03457124	03459124
12,5	102	51	03458125	03456125	03457125	03459125
12,6	102	51	03458126	03456126	03457126	03459126
12,7	102	51	03458127	03456127	03457127	03459127
12,8	102	51	03458128	03456128	03457128	03459128
12,9	102	51	03458129	03456129	03457129	03459129
13,0	102	51	03458130	03456130	03457130	03459130

SPOT DRILLS

TECHNICAL INFORMATION

Standard	~ DIN 1897	Raw material	Steel
Material	HSS / HSSG	Form	Typ N

with cylindrical shank, extra short version, with split point

			Art.-No. HSS	Art.-No. HSSG
3,0	37	14	03466030	03465030
3,1	37	14	03466031	03465031
3,2	37	14	03466032	03465032
3,3	40	16	03466033	03465033
3,4	40	16	03466034	03465034
3,5	42	16	03466035	03465035
3,6	42	16	03466036	03465036
3,7	42	16	03466037	03465037
3,8	42	16	03466038	03465038
4,0	42	16	03466040	03465040
4,1	44	18	03466041	03465041
4,2	44	18	03466042	03465042
4,5	48	20	03466045	03465045
4,8	48	20	03466048	03465048
4,9	50	22	03466049	03465049
5,0	50	22	03466050	03465050
5,1	52	24	03466051	03465051
5,2	52	24	03466052	03465052
5,3	52	24	03466053	03465053
5,5	52	24	03466055	03465055
5,6	55	26	03466056	03465056
5,7	55	26	03466057	03465057
5,8	55	26	03466058	03465058
6,0	55	26	03466060	03465060

NC SPOT DRILLS 90°

TECHNICAL INFORMATION

Standard	Factory Standard	Raw material	VA-Steel
Material	HSSE / HSSE-TiN	Form	Typ N

with cylindrical shank, right, bright finish

			Art.-No. HSSE	Art.-No. HSSE-TiN
2,0	40	8	03467020	03468020
3,0	46	12	03467030	03468030
4,0	55	12	03467040	03468040
5,0	62	14	03467050	03468050
6,0	66	16	03467060	03468060
8,0	79	21	03467080	03468080
10,0	89	25	03467100	03468100
12,0	102	30	03467120	03468120
14,0	107	34	03467140	03468140
16,0	115	38	03467160	03468160
20,0	131	45	03467200	03468200
25,0	151	53	03467250	03468250

NC SPOT DRILLS 120°

TECHNICAL INFORMATION

Standard	Factory Standard	Raw material	VA-Steel
Material	HSSE / HSSE-TiN	Form	Typ N

with cylindrical shank, right, bright finish

			Art.-No. HSSE	Art.-No. HSSE-TiN
2,0	40	8	03469020	03470020
3,0	46	12	03469030	03470030
4,0	55	12	03469040	03470040
5,0	62	14	03469050	03470050
6,0	66	16	03469060	03470060
8,0	79	21	03469080	03470080
10,0	89	25	03469100	03470100
12,0	102	30	03469120	03470120
14,0	107	34	03469140	03470140
16,0	115	38	03469160	03470160
20,0	131	45	03469200	03470200
25,0	151	53	03469250	03470250

DEEP-HOLE TWIST DRILLS SERIES 1

TECHNICAL INFORMATION

Standard	DIN 1869	Raw material	Steel
Material	HSSG	Form	Typ TS
with cylindrical shank, extra long version			
fully ground, with split point			

			Art.-No.
1,0	100	60	03471010
1,5	100	60	03471015
2,0	125	85	03471020
2,5	140	95	03471025
3,0	150	100	03471030
3,1	155	105	03471031
3,2	155	105	03471032
3,3	155	105	03471033
3,5	165	115	03471035
4,0	175	120	03471040
4,2	175	120	03471042
4,5	185	125	03471045
5,0	195	135	03471050
5,5	205	140	03471055
6,0	205	140	03471060
6,5	215	150	03471065
6,8	225	155	03471068
7,0	225	155	03471070
7,5	225	155	03471075
8,0	240	165	03471080
8,5	240	165	03471085
9,0	250	175	03471090
9,5	250	175	03471095
10,0	265	185	03471100
10,2	265	185	03471102
10,5	265	185	03471105
11,0	280	195	03471110
11,5	280	195	03471115
12,0	295	205	03471120
12,5	295	205	03471125
13,0	295	205	03471130

DEEP-HOLE TWIST DRILLS SERIES 2

TECHNICAL INFORMATION

Standard	DIN 1869	Raw material	Steel
Material	HSSG	Form	Typ TS
with cylindrical shank, extra long			
fully ground, with split point			

			Art.-No.
1,5	150	100	03472015
2,0	160	110	03472020
2,5	180	120	03472025
3,0	190	130	03472030
3,2	200	135	03472032
3,5	210	145	03472035
4,0	220	150	03472040
4,2	220	150	03472042
4,5	235	160	03472045
5,0	245	170	03472050
5,5	260	180	03472055
6,0	260	180	03472060
6,5	275	190	03472065
6,8	290	200	03472068
7,0	290	200	03472070
7,5	290	200	03472075
8,0	305	210	03472080
8,5	305	210	03472085
9,0	320	220	03472090
9,5	320	220	03472095
10,0	340	235	03472100
10,2	340	235	03472102
10,5	340	235	03472105
11,0	365	250	03472110
11,5	365	250	03472115
12,0	375	260	03472120
12,5	375	260	03472125
13,0	375	260	03472130

DEEP-HOLE TWIST DRILLS SERIES 3

TECHNICAL INFORMATION

Standard	DIN 1869	Raw material	Steel
Material	HSSG	Form	Typ TS
with cylindrical shank, extra long version			
fully ground, with split point			

			Art.-No.
2,0	200	135	03473020
2,5	225	150	03473025
3,0	240	160	03473030
3,2	250	170	03473032
3,5	265	180	03473035
4,0	280	190	03473040
4,2	280	190	03473042
4,5	295	200	03473045
5,0	315	210	03473050
5,5	330	225	03473055
6,0	330	225	03473060
6,5	350	235	03473065
6,8	370	250	03473068
7,0	370	250	03473070
7,5	370	250	03473075
8,0	390	265	03473080
8,5	390	265	03473085
9,0	410	280	03473090
9,5	410	280	03473095
10,0	430	295	03473100
10,2	430	295	03473102
10,5	430	295	03473105
11,0	455	310	03473110
11,5	455	310	03473115
12,0	480	330	03473120
12,5	480	330	03473125
13,0	480	330	03473130

MILLING DRILLS

TECHNICAL INFORMATION

Standard	Factory Standard
Material	HSSG / HSSG-TiN
Raw material	Steel, metal, wood, plastic

	Art.-No. HSSG	Art.-No. HSSG-TiN
6,0 × 90 mm	03474060	03475060
8,0 × 90 mm	03474080	03475080

SPOT WELD DRILLS

TECHNICAL INFORMATION

Standard	Dimensions according to DIN 1897
Material	HSSE / HSSE-TiN
Raw material	Steel
	Fully ground

	Art.-No. HSSE	Art.-No. HSSE-TiN
6,0 × 66 mm	03478060	03479060
7,0 × 74 mm	03478070	03479070
8,0 × 79 mm	03478080	03479080
10,0 × 89 mm	03478100	03479100

SPOT WELD DRILLS

TECHNICAL INFORMATION

Standard	Drills for Spotle/Vario	Raw material	Steel
Material	HSSE / HSSE-TiN		
Form	Spotle T575 / Vario WS90		
Fully ground, 8mm shank			

	Art.-No. HSSE	Art.-No. HSSE-TiN
Spotle drill 6,0 × 40 mm	03480060	03490060
Spotle drill 8,0 × 40 mm	03480080	03490080
Vario drill 8,0 × 44 mm	03480081	03490081
Vario drill 10,0 × 44 mm	03480101	03490101

SUBLAND DRILLS

TECHNICAL INFORMATION

Standard	DIN 8374	Raw material	Steel
Material	HSS	Form	Typ N
with cylindrical shank			
right			

black version – fine, countersink angle 90°

Size	Countersink ø	Drill ø	Total length	Flute length	Step length	Art.-No.
M 3	6	3,2	93	57	9	03486130
M 4	8	4,3	117	75	11	03486150
M 5	10	5,3	133	87	13	03486170
M 6	11,5	6,4	142	94	15	03486190
M 8	15	8,4	169	114	19	03486210
M 10	19	10,5	198	135	23	03486230

SUBLAND DRILLS

TECHNICAL INFORMATION

Standard	DIN 8376	Raw material	Steel
Material	HSS	Form	Typ N
with cylindrical shank			
right			

black version – countersink angle 180°

Size	Countersink ø	Drill ø	Total length	Flute length	Step length	Art.-No.
M 3	6	3,4	93	57	9	03488130
M 4	8	4,5	117	75	11	03488150
M 5	10	5,5	133	87	13	03488170
M 6	11	6,6	142	94	15	03488190
M 8	15	9	169	114	19	03488210
M 10	18	11	191	130	23	03488230

SUBLAND DRILLS

TECHNICAL INFORMATION

Standard	DIN 8378	Raw material	Steel
Material	HSS	Form	Typ N
with cylindrical shank			
right			

black version – countersink angle 90°

Size	Countersink ø	Drill ø	Total length	Flute length	Step length	Art.-No.
M 3	3,4	2,5	70	39	8,8	03489130
M 4	4,5	3,3	80	47	11,4	03489150
M 5	5,5	4,2	93	57	13,6	03489170
M 6	6,6	5	101	63	16,5	03489190
M 8	9	6,8	125	81	21	03489210
M 10	11	8,5	142	94	25,5	03489230
M 12	13,5	10,2	160	108	30	03489250

TWIST DRILL BITS

TECHNICAL INFORMATION

Standard	Factory Standard	Raw material	Steel
Material	HSSG	Form	Typ N

bits with ¼ " hexagon shank (DIN 3126) and split point

				Art.-No.
1,0	32	7	1/4"	04502010
1,5	32	10	1/4"	04502015
2,0	34	12	1/4"	04502020
2,5 for M3	36	14	1/4"	04502025
3,0	38	16	1/4"	04502030
3,3 for M4	40	18	1/4"	04502033
3,5	40	18	1/4"	04502035
4,0	44	20	1/4"	04502040
4,2 for M5	45	20	1/4"	04502042
4,5	46	24	1/4"	04502045
5,0 for M6	50	26	1/4"	04502050
5,5	50	26	1/4"	04502055
6,0	50	26	1/4"	04502060
6,5	50	30	1/4"	04502065
6,8 for M8	50	30	1/4"	04502068
7,0	50	30	1/4"	04502070
7,5	51	32	1/4"	04502075
8,0	51	32	1/4"	04502080
8,5 for M10	53	33	1/4"	04502085
9,0	53	33	1/4"	04502090
9,5	54	38	1/4"	04502095
10,0	54	38	1/4"	04502100
10,2 for M12	54	38	1/4"	04502102

TWIST DRILL ASSORTMENTS

Size	Pitch	Tap hole drill	Pieces
1 – 10	× 0,5		19
1 – 10	× 0,5	2,5 / 3,3 / 4,2 / 6,8 / 10,2	24
1 – 13	× 0,5		25
1,0 – 5,9	× 0,1		50
6,0 – 10,0	× 0,1		41
1,0 – 10,0	× 0,5		170
1,0 – 8,0 each 10 pcs 8,5 – 10,0 each 5 pcs			

ALL CASSETTES HAVE AN EURO HOLE

TWIST DRILL ASSORTMENTS

twist drill assortments are compilations of twist drills according to DIN 338 in metal boxes from 1mm up to 13mm, partly with tap hole drills. Those are required for bores in which a metric internal thread should be cut.

The sets are offered in different quality levels: roll forged twist drills made from HSS steel (HSS-R), fully ground twist drills made from HSS steel (HSS-G), either with a bright finish or TiN (titanium nitrified) coating and fully grounded made from HSS Co material (HSS-E).

TIN

TiN is the abbreviation for titanium nitride, a chemical compound of titanium and nitrogen. The material is characterised by high hardness and corrosion resistance. It is used for coating of drills and milling cutters in order to increase wear protection. TiN drills can be easily recognised by their golden yellow colour.

TWIST DRILLS SET

TECHNICAL INFORMATION

roll forged version

chisel angle 118°

Description	Size	Material	Content	Art.-No. equipped	Art.-No. empty
19-pcs. twist drill set DIN 338, roll forged	1,0 - 10,0 mm	HSS-R	each 1× twist drill 1,0 - 10,0 mm 0,5 mm ascend	08340100	08940100
24-pcs. twist drill set DIN 338, roll forged	1,0 - 10,5 mm + tap hole drill	HSS-R	each 1× twist drill 1,0 - 10,5 mm 0,5 mm ascend + 3,3 / 4,2 / 6,8 / 10,2 mm	08340200	08940200
25-pcs. twist drill set DIN 338, roll forged	1,0 - 13,0 mm	HSS-R	each 1× twist drill 1,0 - 13,0 mm 0,5 mm ascend	08340300	08940300
50-pcs. twist drill set DIN 338, roll forged	1,0 - 5,9 mm	HSS-R	each 1× twist drill 1,0 - 5,9 mm 0,1 mm ascend	08340400	08940400
41-pcs. twist drill set DIN 338, roll forged	6,0 - 10,0 mm	HSS-R	each 1× twist drill 6,0 - 10,0 mm 0,1 mm ascend	08340500	08940500
170-pcs. twist drill set DIN 338, roll forged	1,0 - 10,0 mm	HSS-R	each 10× twist drill 1,0 - 8,0 mm 0,5 mm ascend each 5× twist drill 8,5 - 10,0 mm 0,5 mm ascend	08340600	08940600

TWIST DRILLS SET

TECHNICAL INFORMATION

fully ground version

with split point 135° (from 2,0mm)

Description	Size	Material	Content	Art.-No. equipped	Art.-No. empty
19-pcs. twist drill set DIN 338, fully ground, from 2mm with split point	1,0 - 10,0 mm	HSSG	each 1× twist drill 1,0 - 10,0 mm 0,5 mm ascend	08343100	08940100
24-pcs. twist drill set DIN 338, fully ground, from 2mm with split point	1,0 - 10,5 mm + tap hole drill	HSSG	each 1× twist drill 1,0 - 10,5 mm 0,5 mm ascend + 3,3 / 4,2 / 6,8 / 10,2 mm	08343200	08940200
25-pcs. twist drill set DIN 338, fully ground, from 2mm with split point	1,0 - 13,0 mm	HSSG	each 1× twist drill 1,0 - 13,0 mm 0,5 mm ascend	08343300	08940300
50-pcs. twist drill set DIN 338, fully ground, from 2mm with split point	1,0 - 5,9 mm	HSSG	each 1× twist drill 1,0 - 5,9 mm 0,1 mm ascend	08343400	08940400
41-pcs. twist drill set DIN 338, fully ground, from 2mm with split point	6,0 - 10,0 mm	HSSG	each 1× twist drill 6,0 - 10,0 mm 0,1 mm ascend	08343500	08940500
170-pcs. twist drill set DIN 338, fully ground, from 2mm with split point	1,0 - 10,0 mm	HSSG	each 10× twist drill 1,0 - 8,0 mm 0,5 mm ascend each 5× twist drill 8,5 - 10,0 mm 0,5 mm ascend	08343600	08940600

TWIST DRILL ASSORTMENTS

TWIST DRILLS SET

TECHNICAL INFORMATION

TiN coated version

with split point 135° (from 2.0mm)

Description	Size	Material	Content	Art.-No. equipped	Art.-No. empty
19-pcs. twist drill set DIN 338, fully ground with TiN coating, from 2mm with split point	1,0 - 10,0 mm	HSSG-TiN	each 1× twist drill 1,0 - 10,0 mm 0,5 mm ascend	08344100	08940100
24-pcs. twist drill set DIN 338, fully ground with TiN coating, from 2mm with split point	1,0 - 10,5 mm + tap hole drill	HSSG-TiN	each 1× twist drill 1,0 - 10,5 mm 0,5 mm ascend + 3,3 / 4,2 / 6,8 / 10,2 mm	08344200	08940200
25-pcs. twist drill set DIN 338, fully ground with TiN coating, from 2mm with split point	1,0 - 13,0 mm	HSSG-TiN	each 1× twist drill 1,0 - 13,0 mm 0,5 mm ascend	08344300	08940300
50-pcs. twist drill set DIN 338, fully ground with TiN coating, from 2mm with split point	1,0 - 5,9 mm	HSSG-TiN	each 1× twist drill 1,0 - 5,9 mm 0,1 mm ascend	08344400	08940400
41-pcs. twist drill set DIN 338, fully ground TiN-coating, from 2mm with split point	6,0 - 10,0 mm	HSSG-TiN	each 1× twist drill 6,0 - 10,0 mm 0,1 mm ascend	08344500	08940500
170-pcs. twist drill set DIN 338, fully ground with TiN coating, from 2mm with split point	1,0 - 10,0 mm	HSSG-TiN	each 10× twist drill 1,0 - 8,0 mm 0,5 mm ascend each 5× twist drill 8,5 - 10,0 mm 0,5 mm ascend	08344600	08940600

TWIST DRILLS SET

TECHNICAL INFORMATION

Cobalt version

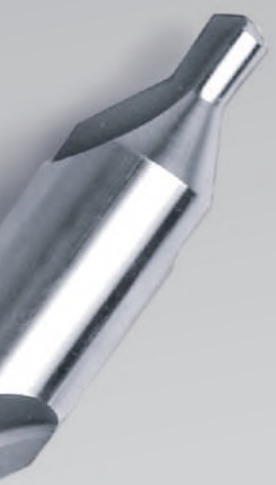
with split point 135° (from 2.0mm)

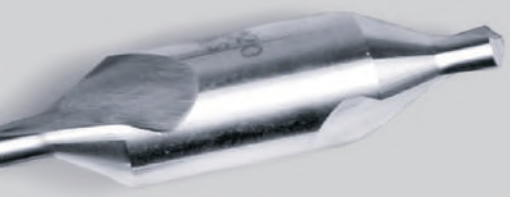
Description	Size	Material	Content	Art.-No. equipped	Art.-No. empty
19-pcs. twist drill set DIN 338, 5 % cobalt, from 2mm with split point	1,0 - 10,0 mm	HSSE	each 1× twist drill 1,0 - 10,0 mm 0,5 mm ascend	08347100	08940100
24-pcs. twist drill set DIN 338, 5 % cobalt, from 2mm with split point	1,0 - 10,5 mm + tap hole drill	HSSE	each 1× twist drill 1,0 - 10,5 mm 0,5 mm ascend + 3,3 / 4,2 / 6,8 / 10,2 mm	08347200	08940200
25-pcs. twist drill set DIN 338, 5 % cobalt, from 2mm with split point	1,0 - 13,0 mm	HSSE	each 1× twist drill 1,0 - 13,0 mm 0,5 mm ascend	08347300	08940300
50-pcs. twist drill set DIN 338, 5 % cobalt, from 2mm with split point	1,0 - 5,9 mm	HSSE	each 1× twist drill 1,0 - 5,9 mm 0,1 mm ascend	08347400	08940400
41-pcs. twist drill set DIN 338, 5 % cobalt, from 2mm with split point	6,0 - 10,0 mm	HSSE	each 1× twist drill 6,0 - 10,0 mm 0,1 mm ascend	08347500	08940500
170-pcs. twist drill set DIN 338, 5 % cobalt, from 2mm with split point	1,0 - 10,0 mm	HSSE	each 10× twist drill 1,0 - 8,0 mm 0,5 mm ascend each 5× twist drill 8,5 - 10,0 mm 0,5 mm ascend	08347600	08940600

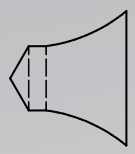
Due to its short design with a thick shank, drifting of the spot drill is hampered. The actual drilling is made with a laterally guided twist drill. The spot drill is right-hand cutting, spiral fluted, and made of HSS steel or carbide.

SPOT DRILLS

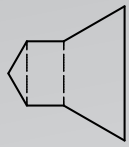
Spot drills are used to make centre bores according to DIN 332.



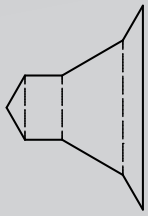




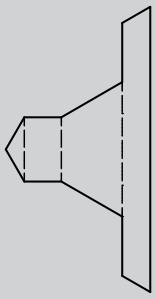
FORM R
Centre bore 60° with rounded tread areas



FORM A
Centre bore 60° with straight tread areas



FORM B
Centre bore 60° with protective sinking 120°



FORM C
Centre bore 60° with truncated countersink

SPOT DRILLS
DIN 333 · R · 4 × 10 · HSS

	Description
DIN 333 =	German Institute for Standardisation
R =	Form R
4 × 10 =	diameter d1 = 4mm
	diameter d2 = 10 mm
HSS =	High-speed steel

SPOT DRILLS

TECHNICAL INFORMATION

Standard	DIN 333	Raw material	Steel
Material	HSSG	Form	Form A
Countersink angle	60°	fully ground, bright finish	

			Art.-No.
1,0	3,15	31,5	00950010
1,6	4,0	35,5	00950016
2,0	5,0	40,0	00950020
2,5	6,3	45,0	00950025
4,0	10,0	56,0	00950040
5,0	12,5	63,0	00950050
6,3	16,0	71,0	00950063
8,0	20,0	80,0	00950080
10,0	25,0	100,0	00950100
12,5	31,5	125,0	00950125

SPOT DRILLS

TECHNICAL INFORMATION

Standard	DIN 333	Raw material	Steel
Material	HSSG	Form	Form A overlongfully
Countersink angle	60°	fully ground, bright finish	

			Art.-No.
1,0	3,15	120	00955010
1,6	4,0	120	00955016
2,0	5,0	120	00955020
2,5	6,3	120	00955025
4,0	10,0	120	00955040
5,0	12,5	120	00955050

SPOT DRILLS

TECHNICAL INFORMATION

Standard	DIN 333	Raw material	Steel
Material	HSSG	Form	Form B
Countersink angle	60° / 120°	fully ground, blank	
with protective sinking 120 °			

			Art.-No.
1,6	6,3	45	00956016
2,0	8,0	50	00956020
2,5	10,0	56	00956025
4,0	14,0	67	00956040
5,0	18,0	75	00956050
6,3	20,0	80	00956063

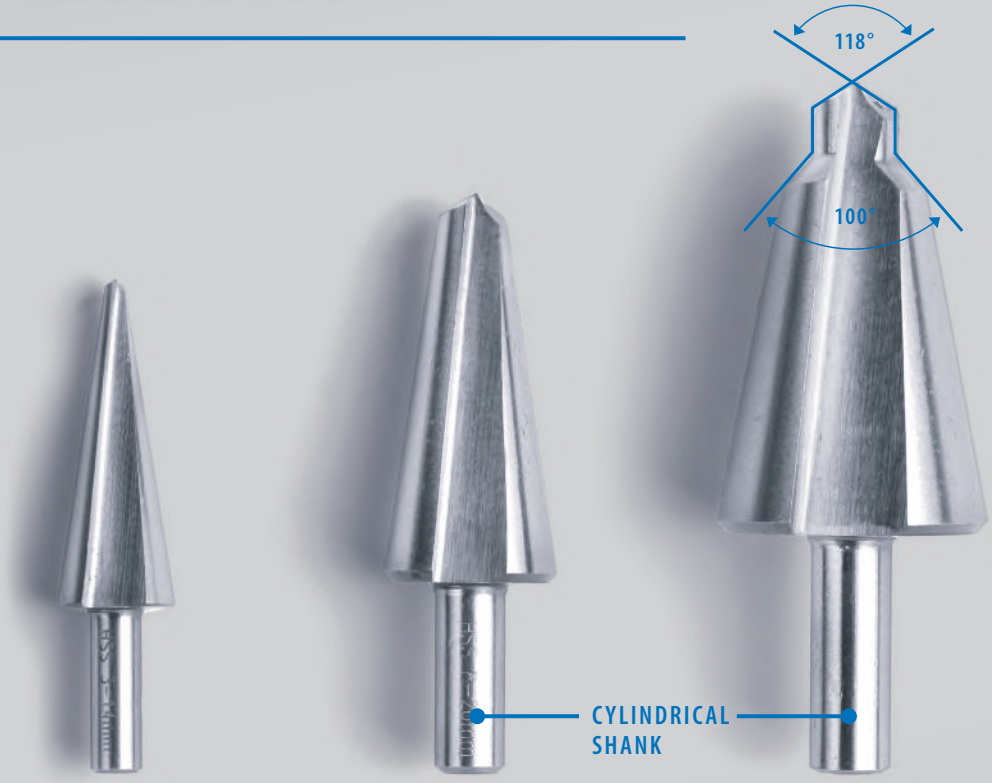
SPOT DRILLS

TECHNICAL INFORMATION

Standard	DIN 333	Raw material	Steel
Material	HSSG	Form	Form R
with radius, fully ground, bright finish			

			Art.-No.
1,0	3,15	31,5	00957010
1,6	4,0	35,5	00957016
2,5	6,3	45,0	00957025
4,0	10,0	56,0	00957040
5,0	12,5	63,0	00957050
6,3	16,0	71,0	00957063

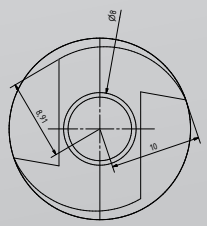
SHEET METAL CONE DRILL BITS



16 – 30 mm

6 – 20 mm

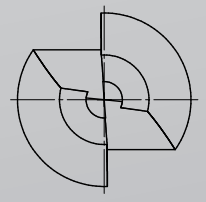
RELIEF GRINDING



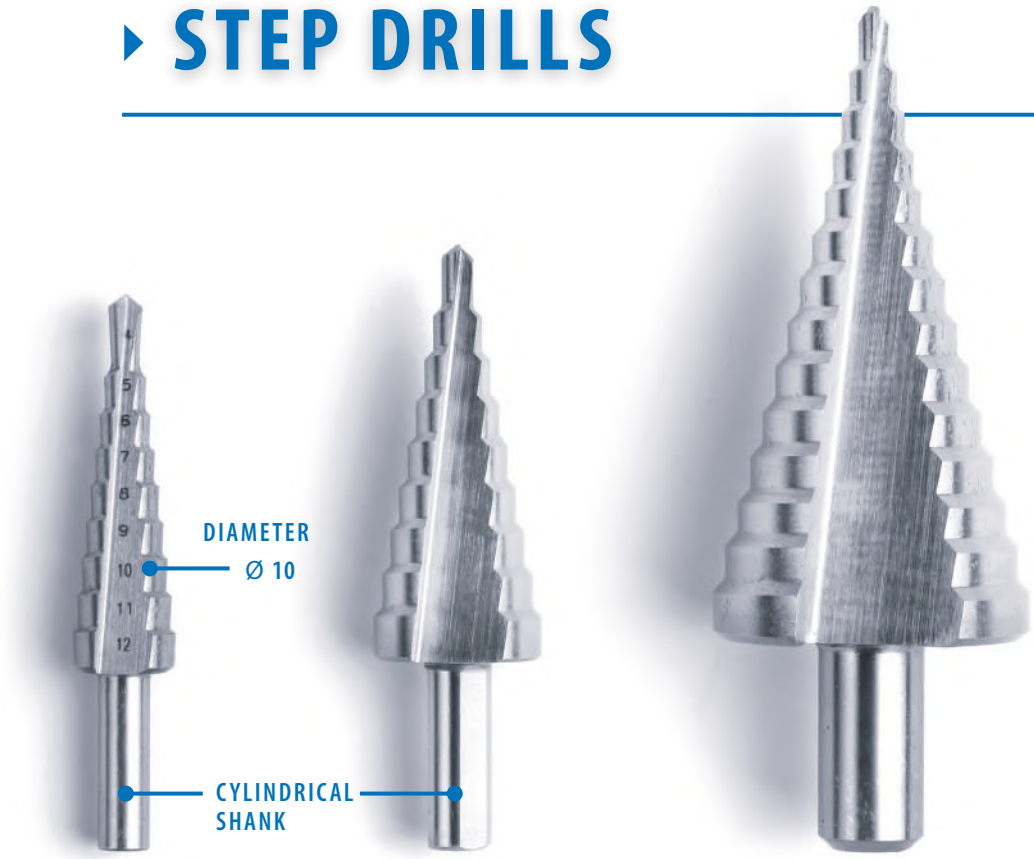
CIRCULAR

The right-hand cutting sheet metal cone drill bits with a straight or spiral flute are used for continuous drilling into thinnest metal sheets. Pre-drilling is not necessary, as the drill is chamfered according to DIN 1412 C. The drilling is free of burrs and without a deformation of the sheet. The drill is axial and radial relief grinded and is available with either a cylindrical shank or a hexagon shank.

POINT GEOMETRY

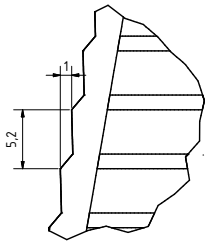


STEP DRILLS



The right-hand cutting step drills with a straight spiral flute are used for burr free drilling in the thinnest metal sheets with pitches from 1,2 or 3mm. Pre-drilling is not necessary. The drill is axial and radial relief grinded and has a cylindrical shank, usable up to a material thickness of 5mm.

PITCH



STEP DIAMETER

d1 mm	Steps mm
4-12	4 / 5 / 6 / 7 / 8 / 9 / 10 / 11 / 12
4-20	4 / 6 / 8 / 10 / 12 / 14 / 16 / 18 / 20
6-30	6 / 8 / 10 / 12 / 14 / 16 / 18 / 20 / 22 / 24 / 26 / 28 / 30
6-36	6 / 9 / 12 / 15 / 18 / 21 / 24 / 27 / 30 / 33 / 36
12-20	12 / 13 / 14 / 15 / 16 / 17 / 18 / 19 / 20
20-30	20 / 21 / 22 / 23 / 24 / 25 / 26 / 27 / 28 / 29 / 30
30-40	30 / 31 / 32 / 33 / 34 / 35 / 36 / 37 / 38 / 39 / 40
40-50	40 / 41 / 42 / 43 / 44 / 45 / 46 / 47 / 48 / 49 / 50
50-60	50 / 51 / 52 / 53 / 54 / 55 / 56 / 57 / 58 / 59 / 60
3,5-40	3,5 / 6,3 / 10,5 / 12,5 PG7 / 15,3 PG9 / 18,7 PG11 / 20,5 PG13,5 / 22,6 PG16 / 26 / 28,3 PG21 / 29,1 / 32 / 35,6 / 37,5 PG29 / 40

SHEET METAL CONE DRILL BITS

SHEET METAL CONE DRILL BITS

TECHNICAL INFORMATION

with cylindrical shank

2 cutting edges, straight flute

Countersink diameter	Shank diameter	Total length	Art.-No. HSS	Art.-No. HSS TIN	Art.-No. HSSE	Art.-No. HSSE-TIN
3 – 14	6	58	04021010	04022010	04023010	04024010
6 – 20	8	66	04021020	04022020	04023020	04024020
6 – 25	8	80	04021030	04022030	04023030	04024030
6 – 30	10	102	04021040	04022040	04023040	04024040
16 – 30	10	74	04021050	04022050	04023050	04024050
26 – 40	12	86	04021060	04022060	04023060	04024060
36 – 50	12	90	04021070	04022070	04023070	04024070

SHEET METAL CONE DRILL BITS SET

TECHNICAL INFORMATION

with cylindrical shank

2 cutting edges, straight flute

set in a plastic box

Sizes	Art.-No. HSS	Art.-No. HSS TIN	Art.-No. HSSE	Art.-No. HSSE-TIN
3 – 14 / 6 – 20 / 16 – 30	04020010	04020020	04020030	04020040

GSR sheet metal cone drill bits
and step drills are also available
in a practical plastic box.

STEP DRILLS

TECHNICAL INFORMATION

- with cylindrical shank
- straight flute

d1 mm	d2 mm	Art.-No. HSS	Art.-No. HSS TIN	Art.-No. HSS AlTiN	Art.-No. HSSE	Art.-No. HSSE-TIN	Art.-No. HSSE AlTiN
4-12	6	04011010	04012010	04025010	04013010	04014010	04026010
4-20	8	04011020	04012020	04025020	04013020	04014020	04026020
6-30	10	04011030	04012030	04025030	04013030	04014030	04026030
6-36	10	04011040	04012040	04025040	04013040	04014040	04026040
12-20	10	04011070	04012070	04025070	04013070	04014070	04026070
20-30	10	04011080	04012080	04025080	04013080	04014080	04026080
30-40	10	04011050	04012050	04025050	04013050	04014050	04026050
40-50	10	04011090	04012090	04025090	04013090	04014090	04026090
50-60	10	04011100	04012100	04025100	04013100	04014100	04026100
3,5-40*	10	04011060	-	-	-	-	-

STEP DRILLS SET

TECHNICAL INFORMATION

- with cylindrical shank
- straight flute
- set in a plastic box

Sizes	Art.-No. HSS	Art.-No. HSS TIN	Art.-No. HSS AlTiN	Art.-No. HSSE	Art.-No. HSSE-TIN	Art.-No. HSSE AlTiN
4-12 4-20 6-30	04010010	04010020	04010050	04010030	04010040	04010060

STEP DRILLS

TECHNICAL INFORMATION

- with cylindrical shank
- spiral flute

d1 mm	d2 mm	Art.-No. HSS	Art.-No. HSS TIN	Art.-No. HSS AlTiN	Art.-No. HSSE	Art.-No. HSSE-TIN	Art.-No. HSSE AlTiN
4-12	6	04015010	04016010	04027010	04017010	04018010	04028010
4-20	8	04015020	04016020	04027020	04017020	04018020	04028020
6-30	10	04015030	04016030	04027030	04017030	04018030	04028030
6-36	10	04015040	04016040	04027040	04017040	04018040	04028040
12-20	10	04015070	04016070	04027070	04017070	04018070	04028070
20-30	10	04015080	04016080	04027080	04017080	04018080	04028080
30-40	10	04015050	04016050	04027050	04017050	04018050	04028050
40-50	10	04015090	04016090	04027090	04017090	04018090	04028090
50-60	10	04015100	04016100	04027100	04017100	04018100	04028100

STEP DRILLS SET

TECHNICAL INFORMATION

- with cylindrical shank
- spiral flute
- set in a plastic box

Sizes	Art.-No. HSS	Art.-No. HSS TIN	Art.-No. HSS AlTiN	Art.-No. HSSE	Art.-No. HSSE-TIN	Art.-No. HSSE AlTiN
4-12 4-20 6-30	04010110	04010120	04010150	04010130	04010140	04010160

HOLE SAWS

HSS hole saws are used to saw through holes into various materials. The basic body is made of tool steel and has a HSS annular gear welded onto it. The crosswise put arrangement of the HSS saw teeth masters effortless the usage in steel and sheet irons, non-ferrous and light metals, wood, plasterboard, plastic, acrylic glass and many more.

The hole saws equipped with a HSS cobalt annular gear can also be used with stainless steels such as V2A + V4A sheets. The total height of the hole saws varies between 55mm and 43.5mm, depending on the size. GSR hole saws have a so called Vario-toothing.

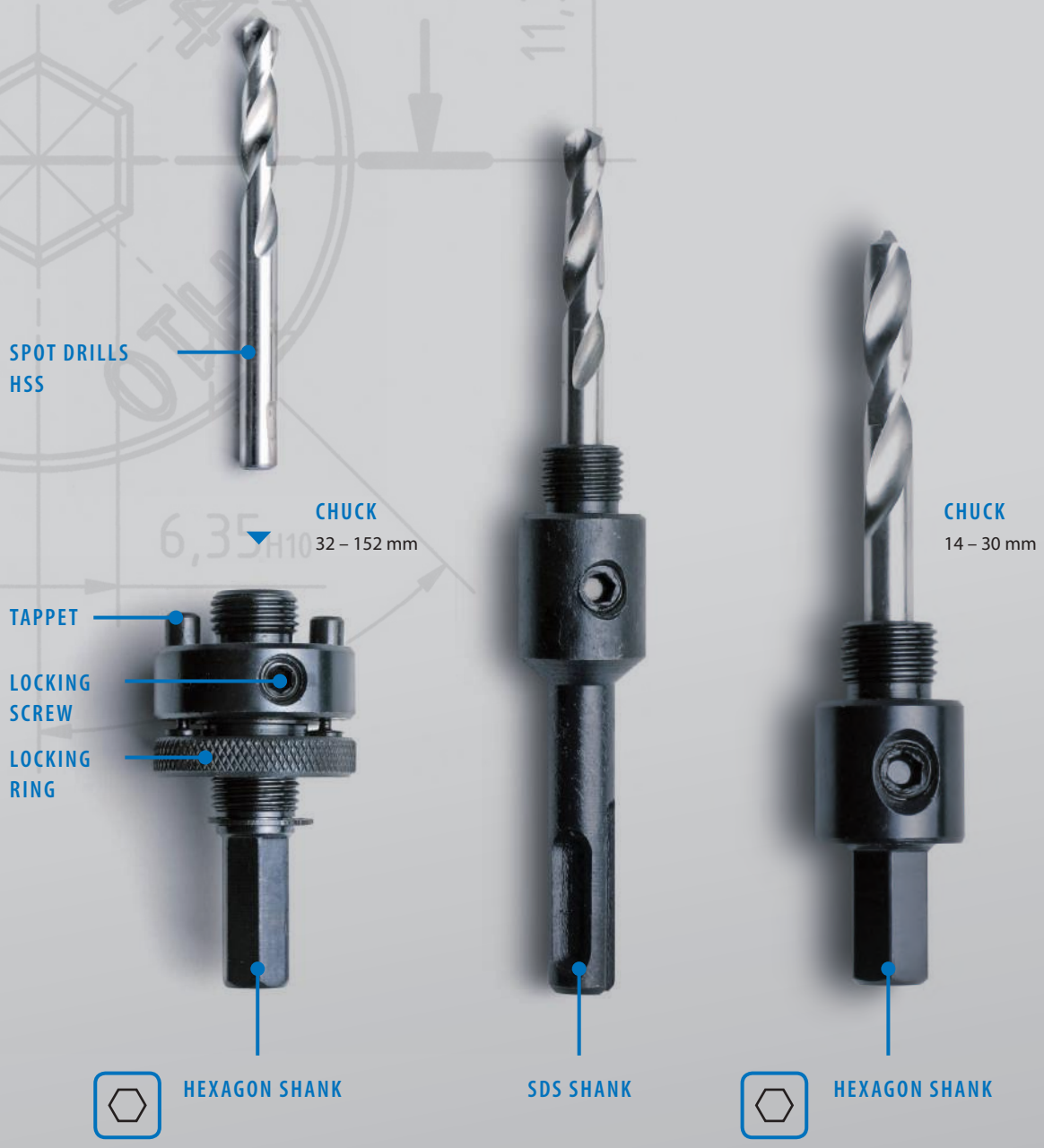
VARIO TOOTHING

This type of toothing has alternate 4-6 different sized teeth per inch (tpt – teeth per inch).

SDS SHANK

The chuck has a diameter of 10mm and enables a quick drill exchange without tools. The drill lock and torque transmission are separated.

The abbreviation SDS originated from the German "Streck, Dreh, Sitz" (stretch, twist, sit). Nowadays, the international name Special Direct System is used.



HOLE SAWS

TECHNICAL INFORMATION

Material	HSS
Raw material	M3 quality
special alloyed tool body	

Size	Inches	Art.-No.
14	9/16	04400014
16	5/8	04400016
17	11/16	04400017
19	3/4	04400019
20	25/32	04400020
21	13/16	04400021
22	7/8	04400022
24	15/16	04400024
25	1	04400025
27	1-1/16	04400027
29	1-1/8	04400029
30	1-3/16	04400030
32	1-1/4	04400032
33	1-5/16	04400033
35	1-3/8	04400035
37	1-7/16	04400037
38	1-1/2	04400038
40	1-9/16	04400040
41	1-5/8	04400041
43	11/16	04400043
44	1-3/4	04400044
46	1-13/16	04400046
48	1-7/8	04400048
51	2	04400051
52	2-1/16	04400052
54	2-1/8	04400054
57	2-1/4	04400057
59	2-5/16	04400059
60	2-3/8	04400060
64	2-1/2	04400064

Size	Inches	Art.-No.
65	2-9/16	04400065
67	2-5/8	04400067
68	2-11/16	04400068
70	2-3/4	04400070
73	2-7/8	04400073
76	3	04400076
79	3-1/8	04400079
83	3-1/4	04400083
86	3-3/8	04400086
89	3-1/2	04400089
92	3-5/8	04400092
95	3-3/4	04400095
98	3-7/8	04400098
102	4	04400102
105	4-1/8	04400105
108	4-1/4	04400108
111	4-3/8	04400111
114	4-1/2	04400114
121	4-3/4	04400121
127	5	04400127
133	5-1/4	04400133
140	5-1/2	04400140
146	5-3/4	04400146
152	6	04400152
160	6-19/64	04400160
168	6-5/8	04400168
177	6-31/32	04400177
200	7-7/8	04400200
210	8-17/64	04400210

HOLE SAWS

TECHNICAL INFORMATION

Material	HSSE
Raw material	M35 quality with 8% cobalt
specially alloyed tool body	

Size	Inches	Art.-No.
14	9/16	04405014
16	5/8	04405016
17	11/16	04405017
19	3/4	04405019
20	25/32	04405020
21	13/16	04405021
22	7/8	04405022
24	15/16	04405024
25	1	04405025
27	1-1/16	04405027
29	1-1/8	04405029
30	1-3/16	04405030
32	1-1/4	04405032
33	1-5/16	04405033
35	1-3/8	04405035
37	1-7/16	04405037
38	1-1/2	04405038
40	1-9/16	04405040
41	1-5/8	04405041
43	11/16	04405043
44	1-3/4	04405044
46	1-13/16	04405046
48	1-7/8	04405048
51	2	04405051
52	2-1/16	04405052
54	2-1/8	04405054
57	2-1/4	04405057
59	2-5/16	04405059
60	2-3/8	04405060
64	2-1/2	04405064

Size	Inches	Art.-No.
65	2-9/16	04405065
67	2-5/8	04405067
68	2-11/16	04405068
70	2-3/4	04405070
73	2-7/8	04405073
76	3	04405076
79	3-1/8	04405079
83	3-1/4	04405083
86	3-3/8	04405086
89	3-1/2	04405089
92	3-5/8	04405092
95	3-3/4	04405095
98	3-7/8	04405098
102	4	04405102
105	4-1/8	04405105
108	4-1/4	04405108
111	4-3/8	04405111
114	4-1/2	04405114
121	4-3/4	04405121
127	5	04405127
133	5-1/4	04405133
140	5-1/2	04405140
146	5-3/4	04405146
152	6	04405152
160	6-19/64	04405160
168	6-5/8	04405168
177	6-31/32	04405177
200	7-7/8	04405200
210	8-17/64	04405210

HOLE SAW CHUCKS

with SDS shank and spot drill

Size	Art.-No.
14 – 30	04402030
32 – 152	04402152

HOLE SAW CHUCKS

with SDS shank and spot drill

Size	Art.-No.
14 – 30	04401030
32 – 152	04401152

GUIDE DRILLS

Material HSSG

Size	Total length	Art.-No.
6,35	70	04404070
6,35	115	04404115

HOLE SAW EXTENTION

Material Tool steel

Size	Total length	Art.-No.
9,5	300	04404170

SET

TECHNICAL INFORMATION

Material	HSS Bi-Metall
Raw material	M3 quality

Specification	HOLE SAWS	Supplies	Pieces	Art.-No.
Electrician set	22 / 29 / 35 / 44 / 51 / 64 / 68 mm	2 chucks with hexagon shank 2 spare guide drills	12	04403100
Plumber set	16 / 19 / 24 / 29 / 38 / 44 / 57 67 mm	2 chucks with hexagon shank 2 spare guide drills	13	04403110
DIY set	16 / 19 / 22 / 29 / 35 / 44 / 52 / 57 67 mm	2 chucks with hexagon shank 2 spare guide drills	14	04403120
Universal set	16 / 19 / 22 / 25 / 29 / 32 / 35 / 38 44 / 51 / 64 / 76 mm	2 chucks with hexagon shank 2 spare guide drills	17	04403130

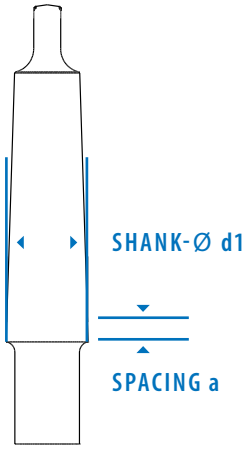
SET

TECHNICAL INFORMATION

Material	HSS-Co8 Bi-Metall
Raw material	M42 quality

Specification	HOLE SAWS	Supplies	Pieces	Art.-No.
Electrician set	22 / 29 / 35 / 44 / 51 / 64 / 68 mm	2 chucks with hexagon shank 2 spare guide drills	12	04403200
Plumber set	16 / 19 / 24 / 29 / 38 / 44 / 57 67 mm	2 chucks with hexagon shank 2 spare guide drills	13	04403210
DIY set	16 / 19 / 22 / 29 / 35 / 44 / 52 / 57 67 mm	2 chucks with hexagon shank 2 spare guide drills	14	04403220
Universal set	16 / 19 / 22 / 25 / 29 / 32 / 35 / 38 44 / 51 / 64 / 76 mm	2 chucks with hexagon shank 2 spare guide drills	17	04403230

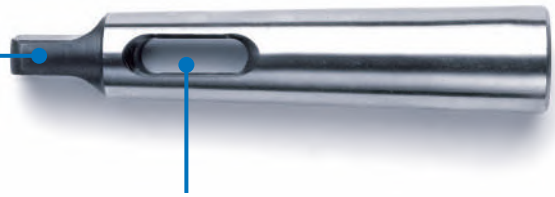
DRILLING SUPPLIES



SHANK DIAMETER OF MORSE TAPERS ACCORDING TO DIN 228

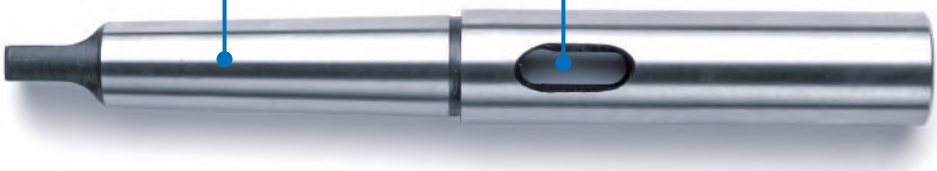
Description	Spacing a	Shank -Ø d1
MK0	3.0	9.045 mm
MK1	3.5	12.065 mm
MK2	5.0	17.780 mm
MK3	5.0	23.825 mm
MK4	6.5	31.267 mm
MK5	6.5	44.399 mm
MK6	8.0	63.348 mm

DRILL DRIFT



EXTENSION SLEEVE

OPENING FOR DRILL DRIFT



MORSE TAPER

The Morse taper (MT) is the standardised form of a tool taper for clamping tools into the chuck of a machine tool. The torque transmission of the hollow cone of the driven tool spindle onto the clamped shank of the tool is done by friction. Morse taper are available in seven sizes from MK0 to MK6. They are standardised according to DIN 228 part 1 and 2.

On average, the inclination is 1°26'. In addition to this Morse taper series, there are two smaller (4 and 6mm) and five bigger metric taper (ME) (80 to 200mm). Morse Taper are available in 4 forms: Form A (shank) and C (sleeve) with a thread for attachment and Form B (shank) and D (sleeve) with a tang at the shank and a slit in the sleeve for the drill drift.

DRILL DRIFT

TECHNICAL INFORMATION

Drill drift according to DIN 317

for tool tapers according to DIN 228

Morse taper	Length	Weight	Art.-No.
MK 0	90	0,014	04860100
MK 1+2	140	0,07	04860200
MK 3	190	0,15	04860300
MK 4	225	0,31	04860400
MK 5+6	265	0,65	04860500

SEMI-AUTOMATIC DRILL DRIFT

TECHNICAL INFORMATION

Semi-automatic drill drift

for tool tapers according to DIN 228

Morsekegel	Length	Weight	Art.-No.
MK 1 – 3	317	0,31	04850010
MK 4 – 6	380	0,55	04850020

EXTENSION SLEEVES FOR MORSE TAPERS

TECHNICAL INFORMATION

Standard DIN 2185

Material Tool steel

completely hardened and fully ground

Morse taper according to DIN 228

Outer MT > Inner MT	Cylinder length	Weight	Art.-No.
MK1 > MK1	83	140	04821100
MK1 > MK2	98	160	04821200
MK2 > MK1	85	160	04822100
MK2 > MK2	100	175	04822200
MK2 > MK3	121	196	04822300
MK3 > MK1	81	175	04823100

Outer MT > Inner MT	Cylinder length	Weight	Art.-No.
MK3 > MK2	100	194	04823200
MK3 > MK3	121	215	04823300
MK3 > MK4	146	240	04823400
MK4 > MK1	82,5	200	04824100
MK4 > MK2	97,5	215	04824200
MK4 > MK3	122,5	240	04824300
MK4 > MK4	147,5	265	04824400
MK4 > MK5	182,5	300	04824500
MK5 > MK2	97,5	247	04825200
MK5 > MK3	122,5	268	04825300
MK5 > MK4	147,5	300	04825400
MK5 > MK5	182,5	335	04825500
MK5 > MK6	196,5	347	04825600
MK6 > MK4	180	355	04826400
MK6 > MK5	180	390	04826500
MK6 > MK6	180	425	04826600

REDUCTION SLEEVES FOR MORSE TAPER

Standard: DIN 2185 / Material: Tool steel completely hardened and fully ground / Morse taper according to DIN 228

Outer MT > Inner MT	Art.-No.
MK2 × MK1	04812100
MK3 × MK1	04813100
MK3 × MK2	04813200
MK4 × MK1	04814100
MK4 × MK2	04814200
MK4 × MK3	04814300
MK5 × MK1	04815100
MK5 × Mk2	04815200
MK5 × MK3	04815300
MK5 × MK4	04815400
MK6 × MK3	04816300
MK6 × MK4	04816400
MK6 × MK5	04816500

TAPERED ARBORS

Standard: DIN 238 / Material: Tool steel completely hardened and fully ground / Morse taper according to DIN 228

Morse taper	Chuck	Art.-No.
MK1	B10	04831010
MK1	B12	04831210
MK1	B16	04831610
MK1	B18	04831810
MK2	B12	04831220
MK2	B16	04831620
MK2	B18	04831820
Mk2	B22	04832220
MK3	B12	04831230
MK3	B16	04831630
MK3	B18	04831830
MK3	B22	04832230
MK4	B18	04831840
MK4	B22	04832240

KEYLESS DRILL CHUCK
Metal sleeve

KEYLESS DRILL CHUCK
Plastic sleeve

KEYLESS DRILL CHUCKS

KEY-TYPE DRILL CHUCK
Metal sleeve

The chuck for every work assignment

CHUCK KEY
for a quick change

Chuck capacity	Tapered arbor chuck
0,5 – 8,0	B12
1,0 – 10,0	B12
1,0 – 13,0	B16
1,0 – 16,0	B16
1,0 – 16,0	B18

Chuck capacity	specify thread
0,5 – 10,0	½ UNF
0,5 – 10,0	⅜ UNF
1 – 13	½ UNF
1 – 13	⅜ UNF

Chucking of the tools is done without any additional instruments. When the cutting force increases, the chuck retightens itself. Even after intensive stress for the drill, the chuck can be opened easily. The high concentricity allows the use even in CNC machines.

KEYLESS DRILL CHUCKS

TECHNICAL INFORMATION

- Keyless drill chuck for stationary machines
- Metal sleeves
- Tolerance M – 0,05

Chuck capacity	Internal thread	Diameter	Total length	Art.-No.
0,5 – 8	B12	34	71,2	04840020
1 – 10	B12	44	93,4	04840030
1 – 13	B16	51	104	04840040
1 – 16	B16	51	104	04840050
1 – 16	B18	54	115,2	04840060
5 – 20	B22	57	129,2	04840070

KEYLESS DRILL CHUCKS

TECHNICAL INFORMATION

- Keyless drill chuck for impact drills
- Metal sleeves
- Impact resistant version
- Keyless for a quick tool change

Chuck capacity	Internal thread	Diameter	Total length	Art.-No.
0,8 – 10	3/8 – 24 UNF	41	64	04841010
0,8 – 10	1/2 – 20 UNF	41	64	04841020
1,5 – 13	3/8 – 24 UNF	43	75	04841030
1,5 – 13	1/2 – 20 UNF	43	75	04841040

KEYLESS DRILL CHUCKS

TECHNICAL INFORMATION

- Keyless drill chuck for impact drills
- Plastic sleeves
- Impact resistant version
- Keyless for a quick tool change

Chuck capacity	Internal thread	Diameter	Total length	Art.-No.
0,8 – 10	3/8 – 24 UNF	41	64	04842010
0,8 – 10	1/2 – 20 UNF	41	64	04842020
1,5 – 13	3/8 – 24 UNF	43	75	04842030
1,5 – 13	1/2 – 20 UNF	43	75	04842040

KEY-TYPE DRILL CHUCKS

TECHNICAL INFORMATION

- Key-type drill chuck with mounting thread
- Metal sleeves
- the chuck for every work assignment
- with chuck key for changing tools

Chuck capacity	Internal thread	Diameter	Total length	Art.-No.
0,6 – 6	3/8 – 24 UNF	30,3	49	04843010
1,5 – 10	3/8 – 24 UNF	33	59,5	04843020
1,5 – 10	1/2 – 20 UNF	33	59,5	04843030
1,5 – 13	3/8 – 24 UNF	42	71,5	04843040
1,5 – 13	1/2 – 20 UNF	42	70	04843050
3 – 16	3/8 – 24 UNF	50,5	86	04843060
3 – 16	1/2 – 20 UNF	50,5	86	04843070
3 – 16	5/8 – 16 UNF	50,5	86	04843080

KEY-TYPE DRILL CHUCKS

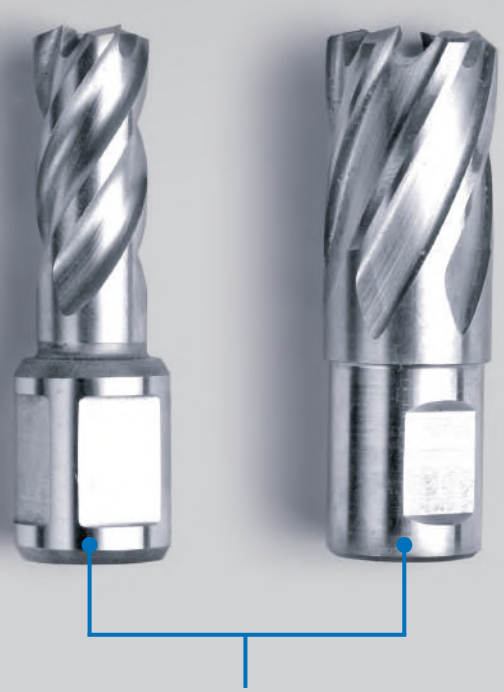
TECHNICAL INFORMATION

- Key-type drill chuck with taper chuck
- Metal sleeves
- the chuck for every work assignment

Chuck capacity	Internal thread	Diameter	Total length	Art.-No.
0,6 – 6	B10	30,3	49	04844010
1,5 – 10	B12	34	58,5	04844020
1,5 – 13	B16	42	72	04844030
3 – 16	B16	50,5	85	04844040
3 – 16	B18	50,5	85	04844050

AVAILABLE VERSIONS

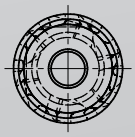
- **HSS**
- **HSS Co 8 %**
- **TCT** with carbide tips
- **TRC** with carbide tips
(optimised for railway tracks)



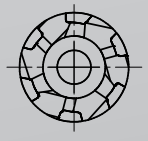
The different versions are suitable for aluminium and steel with low tensile strength (HSS), steels with high tensile strength (HHS Co 8%) as well as stainless steels and cast (TCT).

There is a differentiation between the following maximal drilling depths: 30mm, 55mm, 75mm and 100mm.

CORE DRILLS



TWIST DRILL

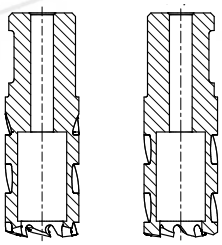


CORE DRILLS

Core drills are used in core drilling machines. They are cutting with the edges and do not chip the whole drilling diameter. Thus, the drilling time is reduced and the tool life prolonged. With a drilling diameter of 100mm, a twist drill chips 650 % more material.

Core drills are mounted with guide pins which centre the drill. A core drill has spiral flutes and a special cutting edge geometry. Inner and outer edges are processed reciprocal.

WELDON SHANK



Core drills have a Weldon shank ¾ inch (19,05 mm) up to 60 mm drilling depth or 32 mm up to 130 mm drilling depth, or a so called "Quickin" shank or a combination of Weldon and "Quickin" shank – the so-called multi shank.

QUICKIN SHANK

CORE DRILLING MACHINE

CORE DRILLS

TECHNICAL INFORMATION

Material	HSS
3/4" Weldon shank	

Diameter	Art.-No. Cutting depth 30 mm	Art.-No. Cutting depth 55 mm	Art.-No. Cutting depth 75 mm	Art.-No. Cutting depth 100 mm
12	06010012	06011012	06012012	06013012
13	06010013	06011013	06012013	06013013
14	06010014	06011014	06012014	06013014
15	06010015	06011015	06012015	06013015
16	06010016	06011016	06012016	06013016
17	06010017	06011017	06012017	06013017
18	06010018	06011018	06012018	06013018
19	06010019	06011019	06012019	06013019
20	06010020	06011020	06012020	06013020
21	06010021	06011021	06012021	06013021
22	06010022	06011022	06012022	06013022
23	06010023	06011023	06012023	06013023
24	06010024	06011024	06012024	06013024
25	06010025	06011025	06012025	06013025
26	06010026	06011026	06012026	06013026
27	06010027	06011027	06012027	06013027
28	06010028	06011028	06012028	06013028
29	06010029	06011029	06012029	06013029
30	06010030	06011030	06012030	06013030
31	06010031	06011031	06012031	06013031
32	06010032	06011032	06012032	06013032
33	06010033	06011033	06012033	06013033
34	06010034	06011034	06012034	06013034
35	06010035	06011035	06012035	06013035
36	06010036	06011036	06012036	06013036
37	06010037	06011037	06012037	06013037
38	06010038	06011038	06012038	06013038
39	06010039	06011039	06012039	06013039
40	06010040	06011040	06012040	06013040
41	06010041	06011041	06012041	06013041
42	06010042	06011042	06012042	06013042
43	06010043	06011043	06012043	06013043
44	06010044	06011044	06012044	06013044
45	06010045	06011045	06012045	06013045
46	06010046	06011046	06012046	06013046
47	06010047	06011047	06012047	06013047

Diameter	Art.-No. Cutting depth 30 mm	Art.-No. Cutting depth 55 mm	Art.-No. Cutting depth 75 mm	Art.-No. Cutting depth 100 mm
48	06010048	06011048	06012048	06013048
49	06010049	06011049	06012049	06013049
50	06010050	06011050	06012050	06013050
51	06010051	06011051	06012051	06013051
52	06010052	06011052	06012052	06013052
53	06010053	06011053	06012053	06013053
54	06010054	06011054	06012054	06013054
55	06010055	06011055	06012055	06013055
56	06010056	06011056	06012056	06013056
57	06010057	06011057	06012057	06013057
58	06010058	06011058	06012058	06013058
59	06010059	06011059	06012059	06013059
60	06010060	06011060	06012060	06013060
61	06010061	06011061	06012061	06013061
62	06010062	06011062	06012062	06013062
63	06010063	06011063	06012063	06013063
64	06010064	06011064	06012064	06013064
65	06010065	06011065	06012065	06013065
66	06010066	06011066	06012066	06013066
67	06010067	06011067	06012067	06013067
68	06010068	06011068	06012068	06013068
69	06010069	06011069	06012069	06013069
70	06010070	06011070	06012070	06013070
71	06010071	06011071	06012071	06013071
72	06010072	06011072	06012072	06013072
73	06010073	06011073	06012073	06013073
74	06010074	06011074	06012074	06013074
75	06010075	06011075	06012075	06013075
76	06010076	06011076	06012076	06013076
77	06010077	06011077	06012077	06013077
78	06010078	06011078	06012078	06013078
79	06010079	06011079	06012079	06013079
80	06010080	06011080	06012080	06013080
81	06010081	06011081	06012081	06013081
82	06010082	06011082	06012082	06013082
83	06010083	06011083	06012083	06013083
84	06010084	06011084	06012084	06013084
85	06010085	06011085	06012085	06013085
86	06010086	06011086	06012086	06013086
87	06010087	06011087	06012087	06013087
88	06010088	06011088	06012088	06013088
89	06010089	06011089	06012089	06013089
90	06010090	06011090	06012090	06013090
91	06010091	06011091	06012091	06013091

Diameter	Art.-No. Cutting depth 30 mm	Art.-No. Cutting depth 55 mm	Art.-No. Cutting depth 75 mm	Art.-No. Cutting depth 100 mm
92	06010092	06011092	06012092	06013092
93	06010093	06011093	06012093	06013093
94	06010094	06011094	06012094	06013094
95	06010095	06011095	06012095	06013095
96	06010096	06011096	06012096	06013096
97	06010097	06011097	06012097	06013097
98	06010098	06011098	06012098	06013098
99	06010099	06011099	06012099	06013099
100	06010100	06011100	06012100	06013100

CORE DRILLS WITH CARBIDE TEETH

TECHNICAL INFORMATION

Material	HSS + carbide teeth
Quickin shank	

Diameter	Art.-No. Cutting-depth 35 mm	Art.-No. Cutting-depth 50 mm
14	06020014	06021014
15	06020015	06021015
16	06020016	06021016
17	06020017	06021017
18	06020018	06021018
19	06020019	06021019
20	06020020	06021020
21	06020021	06021021
22	06020022	06021022
23	06020023	06021023
24	06020024	06021024
25	06020025	06021025
26	06020026	06021026
27	06020027	06021027
28	06020028	06021028
29	06020029	06021029
30	06020030	06021030
31	06020031	06021031
32	06020032	06021032
33	06020033	06021033
34	06020034	06021034
35	06020035	06021035
36	06020036	06021036
37	06020037	06021037

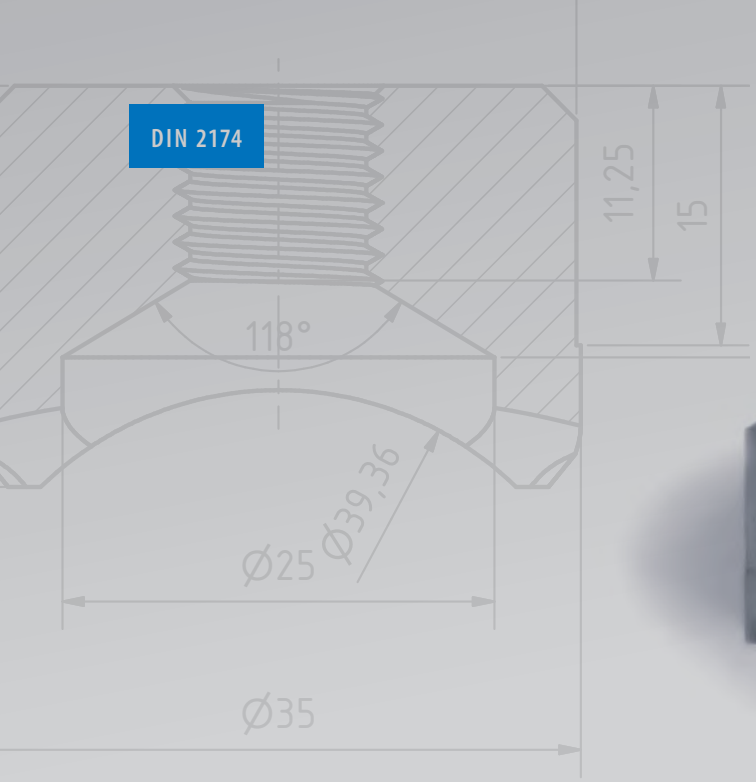
Diameter	Art.-No. Cutting-depth 35 mm	Art.-No. Cutting-depth 50 mm
38	06020038	06021038
39	06020039	06021039
40	06020040	06021040
41	06020041	06021041
42	06020042	06021042
43	06020043	06021043
44	06020044	06021044
45	06020045	06021045
46	06020046	06021046
47	06020047	06021047
48	06020048	06021048
49	06020049	06021049
50	06020050	06021050
51	06020051	06021051
52	06020052	06021052
53	06020053	06021053
54	06020054	06021054
55	06020055	06021055
56	06020056	06021056
57	06020057	06021057
58	06020058	06021058
59	06020059	06021059
60	06020060	06021060
61	06020061	06021061

CORE DRILLS WITH CARBIDE TEETH

TECHNICAL INFORMATION

Material	HSS + carbide teeth
18 mm Quickin shank	
35 mm cutting depth	
for railway tracks	

Diameter	Art.-No.
19	06030019
20	06030020
21	06030021
22	06030022
23	06030023
24	06030024
25	06030025
26	06030026
27	06030027
28	06030028
29	06030029
30	06030030
31	06030031
32	06030032
33	06030033



LOCKING SCREW
with fine thread

SCREW HOLE PUNCHES

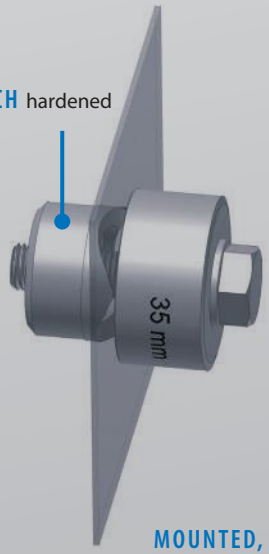
SHEET METAL PUNCHES

Screw hole puncher are used to punch holes into thin-walled materials. The punching creates no burr and the workpiece will not be deformed. The operating speed is high.

THREE-POINT TIP

MOUNTED, GAP
12 mm

PUNCH hardened



MOUNTED, GAP
0 mm

First, a punched hole is pre-drilled with a step drill or a sheet metal cone drill bit. Then, the sheet metal punch is mounted and the locking screw tightened with a wrench.

Due to its three-point cutting tip, the punch is exactly positioned. The locking screw has a fine thread. The punch is hardened (HRC 48), the Q & T steel burnished and the label lasered.

SCREW HOLE PUNCHES

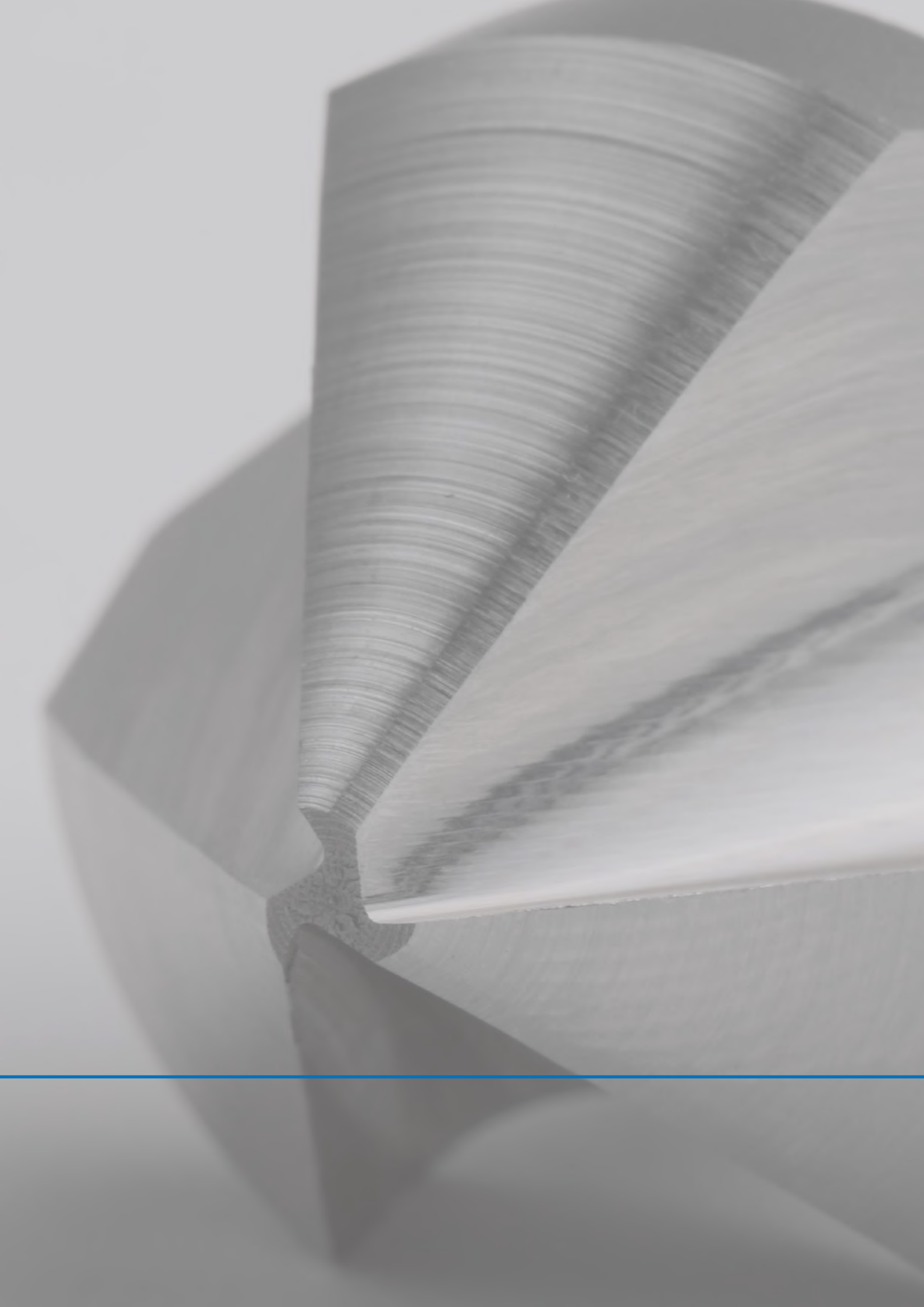
TECHNICAL INFORMATION

Material	CrV
3 cutting edges	
Locking screw from M8 up with strength class 12,9	

Size	Locking screw	Art.-No.
12,7	M8 × 1,0	00904127
14,0	M8 × 1,0	00904140
15,2	M10 × 1,25	00904152
16,0	M10 × 1,25	00904160
16,5	M10 × 1,25	00904165
17,0	M10 × 1,25	00904170
18,0	M10 × 1,25	00904180
18,6	M10 × 1,25	00904186
19,0	M10 × 1,25	00904190
20,0	M10 × 1,25	00904200
20,4	M10 × 1,25	00904204
21,0	M10 × 1,25	00904210
22,0	M10 × 1,25	00904220
22,5	M10 × 1,25	00904225
23,0	M10 × 1,25	00904230
24,0	M10 × 1,25	00904240
25,0	M10 × 1,25	00904250
25,4	M10 × 1,25	00904254
26,0	M10 × 1,25	00904260
27,0	M10 × 1,25	00904270

Size	Locking screw	Art.-No.
28,3	M12 × 1,5	00904283
29,0	M12 × 1,5	00904290
30,0	M12 × 1,5	00904300
31,0	M12 × 1,5	00904310
32,0	M12 × 1,5	00904320
32,5	M12 × 1,5	00904325
33,0	M12 × 1,5	00904330
34,0	M12 × 1,5	00904340
35,0	M12 × 1,5	00904350
36,0	M12 × 1,5	00904360
37,0	M12 × 1,5	00904370
38,0	M12 × 1,5	00904380
39,0	M12 × 1,5	00904390
40,0	M12 × 1,5	00904400
40,5	M16 × 1,5	00904405
41,0	M16 × 1,5	00904410
42,0	M16 × 1,5	00904420
43,0	M16 × 1,5	00904430
44,0	M16 × 1,5	00904440
45,0	M16 × 1,5	00904450
46,0	M16 × 1,5	00904460
47,0	M16 × 1,5	00904470
48,0	M16 × 1,5	00904480
49,0	M16 × 1,5	00904490
50,0	M16 × 1,5	00904500
50,5	M16 × 1,5	00904505
51,0	M16 × 1,5	00904510
52,0	M16 × 1,5	00904520
53,0	M16 × 1,5	00904530
54,0	M16 × 1,5	00904540
55,0	M16 × 1,5	00904550
60,0	M16 × 1,5	00904600
63,5	M16 × 1,5	00904635

COUNTERSINKING AND MEASURING



COUNTERSINKING

DIN 335

DIN 334

COUNTERSINKS & COUNTERBORES CBN-GRINDED

CBN **CBN GRINDED**

GSR countersinks are produced according to the latest methods and grinded with CBN grinding wheels (CBN= cubic boron nitride). This leads to a high surface finish, sharpness and tool life compared to traditionally grinded countersinks.

i **NOTE!**

While working with aluminium, we recommend a TiN coated countersink, as otherwise the aluminium chips would stick to the tool.

COUNTERSINKS DIN 335 • C 12,4 • HSS

Description

DIN 335 =	Countersinks with 3 cutting edges 90°
DIN 334 =	Countersinks with 3 cutting edges 60°
Form C =	3 cutting edges with cylindrical shank
Form D =	3 edges with Morse taper shank

Labelling according DIN 2197

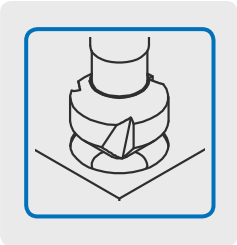
12.4 mm =	D1 = biggest diameter
HSS =	High-speed steel

HSS **USAGE HSS COUNTERSINKS**

Steel, cast steel alloyed and unalloyed up to 900 N/mm² tensile strength, grey cast iron, malleable cast iron, spheroidal graphite iron, die-casting, sintered iron, nickel silver, graphite, short chipping aluminium alloys, brass and bronze.

HSSE **USAGE HSSE COUNTERSINKS**

additionally usable for hot and cold work steels as well as stainless and acid-resistant steel (V2A / V4A)



COUNTERSINKS

Countersinks have a conical cutting edge geometry. The most common types are 60°, 90° and 120°. They are used for countersinking, deburring and chamfering.

APPLICATION RANGE

60° Countersinks are used for deburring bores. DIN 334 Form C HSS/HSSE

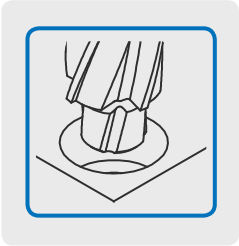
90° Countersinks are used to make countersunk screws sit flush. DIN 335 Form C HSS/HSSE

120° Countersinks are used to make sheet metal rivets sit flush. Factory standard Form C

COUNTERBORES

Counterbores in 3 versions **with fixed guiding pins**

Counterbores have spiral flutes and make a flat 180° counterbore according to DIN 974-1. They are used to make socket screws according to DIN 912, 6912, 7984 and cap screws according to ISO 1207 (DIN 84) sit flush. Counterbores for through holes are used to fix countersunk screws with a nut. Counterbores are also used for tap holes.



SENKER DIN 373·8 × 4,5·HSS

	Description
DIN 373 =	Counterbore with replaceable guiding pin and Morse taper shank
8 mm =	Counterbore diameter
4,5 mm =	Guiding pin diameter
	Labelling according to DIN 2197
HSS =	High-speed steel

3 VERSIONS

- for through hole counterbores (medium)
- for through hole counterbores (fine)
- for tap hole counterbores

COUNTERSINKS CBN GRINDED

COUNTERSINKS CBN 90°

TECHNICAL INFORMATION

Standard	DIN 335
Form	C 90°
Shank	Cylindrical shank

Countersink diameter mm	Shank diameter mm	Nose diameter mm	Total length	Art.-No. HSSG	Art.-No. HSSG-TiN	Art.-No. HSSE
4,3	4	1,3	40	04042043	04043043	-
5,0	4	1,5	40	04042050	04043050	-
5,3	4	1,5	40	04042053	04043053	-
5,8	5	1,5	45	04042058	04043058	-
6,0	5	1,5	45	04042060	04043060	-
6,3	5	1,5	45	04042063	04043063	04044063
7,0	6	1,8	50	04042070	04043070	-
7,3	6	1,8	50	04042073	04043073	-
8,0	6	2	50	04042080	04043080	-
8,3	6	2	50	04042083	04043083	04044083
9,4	6	2,2	50	04042094	04043094	-
10,0	6	2,5	50	04042100	04043100	-
10,4	6	2,5	50	04042104	04043104	04044104
11,5	8	2,8	56	04042115	04043115	-
12,4	8	2,8	56	04042124	04043124	04044124
13,4	8	2,9	56	04042134	04043134	-
15,0	10	3,2	60	04042150	04043150	04044150
16,5	10	3,2	60	04042165	04043165	04044165
19,0	10	3,5	63	04042190	04043190	-
20,5	10	3,5	63	04042205	04043205	04044205
23,0	10	3,8	67	04042230	04043230	-
25,0	10	3,8	67	04042250	04043250	04044250
28,0	12	4	71	04042280	04043280	-
30,0	12	4,2	71	04042300	04043300	-
31,0	12	4,2	71	04042310	04043310	04044310
40,0	15	10	80	04042400	04043400	04044400

COUNTERSINKS CBN 60°

TECHNICAL INFORMATION

Standard	DIN 334
Form	C 60°
Shank	Cylindrical shank

Countersink diameter mm	Shank diameter mm	Nose diameter mm	Total length	Art.-No. HSSG	Art.-No. HSSG-TiN
6,3	5	1,6	45	04045063	04046063
8,0	6	2	50	04045080	04046080
10,0	6	2,5	53	04045100	04046100
12,5	8	3,2	56	04045125	04046125
16,0	10	4	63	04045160	04046160
20,0	10	5	67	04045200	04046200
25,0	10	6,3	71	04045250	04046250
31,5	12	10	76	04045315	04046315

COUNTERSINKS CBN 120°

TECHNICAL INFORMATION

Standard	Factory Standard
Form	C 120°
Shank	Cylindrical shank

Countersink diameter mm	Shank diameter mm	Nose diameter mm	Total length	Art.-No. HSSG
6,3	5	1,5	45	04047063
8,3	6	2	50	04047083
10,4	6	2,5	50	04047104
12,4	8	3	56	04047124
16,5	10	3,5	60	04047165
20,5	10	4	60	04047205
25,0	10	5	63	04047250

COUNTERSINKS SET 60°

TECHNICAL INFORMATION

Standard	DIN 334
Form	C 60°
set in a plastic box	

Sizes	Art.-No. HSSG	Art.-No. HSSG TiN
6,3 - 8,0 - 10,0 - 12,5 - 16,0 - 20,0	08333450	08333460

COUNTERSINKS SET 90°

TECHNICAL INFORMATION

Standard	DIN 335
Form	C 90°
set in a plastic box	

Sizes	Art.-No. HSSG	Art.-No. HSSG TiN	Art.-No. HSSE
6,3 - 8,3 - 10,4 - 12,4 - 16,5 - 20,5	08333400	08333410	08333420

COUNTERSINKS SET 120°

TECHNICAL INFORMATION

Standard	Factory Standard
Form	C 120°
set in a plastic box	

Sizes	Art.-No. HSSG
6,3 - 8,3 - 10,4 12,4 - 16,5 - 20,5	08333550

COUNTERBORES

TECHNICAL INFORMATION

Standard	DIN 373
Material	HSS
for through holes, medium	

Size	Counterbore	Pin	Shank	Total length	Art.-No.
M 3	6	3,4	5	71	04033010
M 4	8	4,5	5	71	04033020
M 5	10	5,5	8	80	04033030
M 6	11	6,6	8	80	04033040
M 8	15	9	12,5	100	04033050
M 10	18	11	12,5	100	04033060
M 12	20	13,5	12,5	100	04033070

COUNTERBORES

TECHNICAL INFORMATION

Standard	DIN 373
Material	HSS
for through holes, fine	

Size	Counterbore	Pin	Shank	Total length	Art.-No.
M 3	6	3,2	5	71	04034010
M 4	8	4,3	5	71	04034020
M 5	10	5,3	8	80	04034030
M 6	11	6,4	8	80	04034040
M 8	15	8,4	12,5	100	04034050
M 10	18	10,5	12,5	100	04034060
M 12	20	13	12,5	100	04034070

COUNTERBORES CBN-GRINDED

COUNTERBORES

TECHNICAL INFORMATION

Standard	DIN 373
Material	HSS
for tap holes	

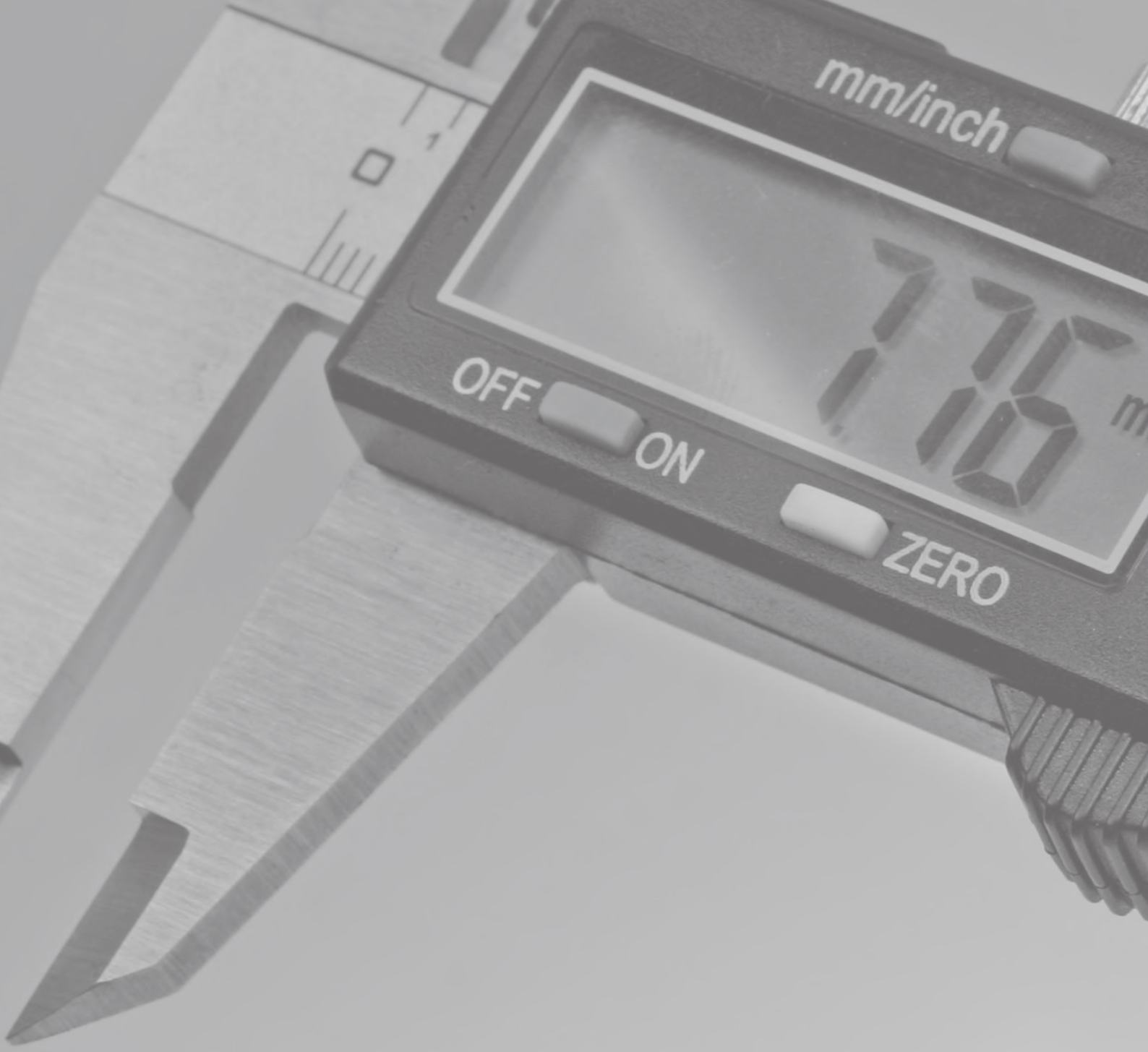
Nennmaß	Counterbore	Pin	Shank	Total length	Art.-No.
M 3	6	2,5	5	71	04035010
M 4	8	3,3	5	71	04035020
M 5	10	4,2	8	80	04035030
M 6	11	5	8	80	04035040
M 8	15	6,8	12,5	100	04035050
M 10	18	8,8	12,5	100	04035060
M 12	20	10,2	12,5	100	04035070

COUNTERBORES SET

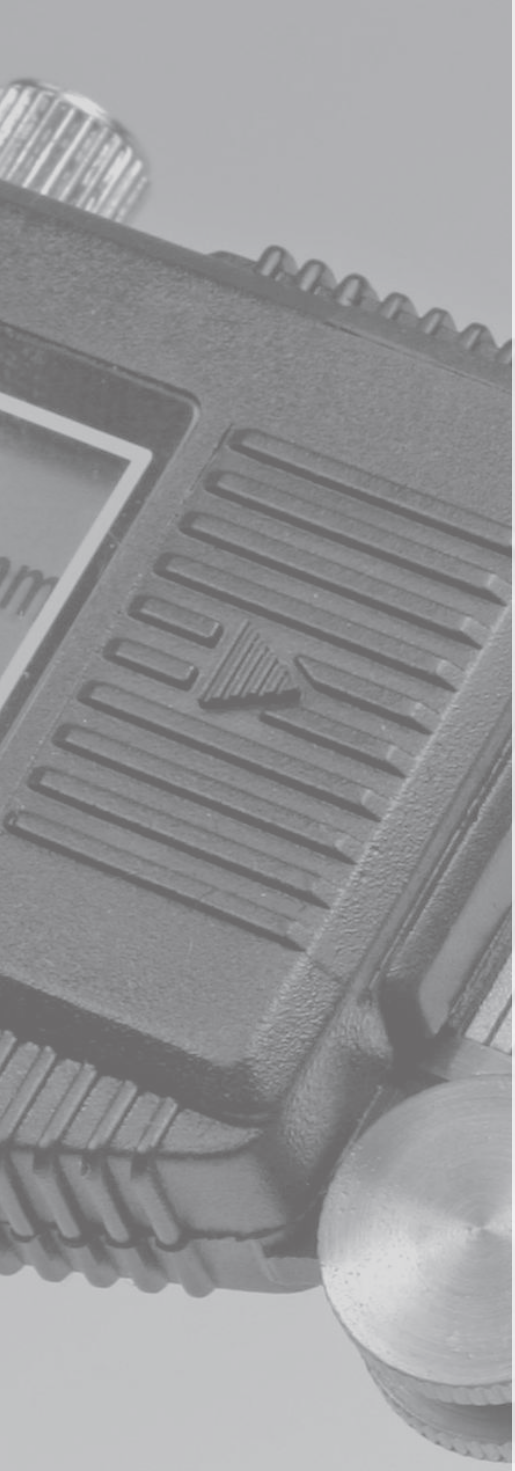
TECHNICAL INFORMATION

Standard	DIN 373
set in a plastic box	

Sizes	Version	Art.-No. HSS
M3 - M4 - M5 - M6 - M8 - M10 - M12	medium	08333300
M3 - M4 - M5 - M6 - M8 - M10 - M12	fine	08333310
M3 - M4 - M5 - M6 - M8 - M10 - M12	tap hole	08333320



MEASURING



THREAD IDENTIFICATION

In order to identify an unknown thread, two specifications are necessary: the pitch and outer diameter of a bolt thread as well as the inner diameter of the female thread. A thread's pitch is the distance from one flank to another in mm and used for metric systems. Imperial systems use the measuring unit threads per inch (TPI).

External threads

First, you have to measure the diameter of the thread with a calliper. The digital calliper enables the user to switch between metric and imperial units. The diameter will tell you whether the thread is a metric or an imperial thread. Next, you have to use a thread gauge. Please test each leaf of the thread gauge until one leaf exactly matches the threads. Now the thread pitch stamped onto the leaf can be read off. Now the thread slide is used, as it contains all information about different thread types. The measuring results can be compared with the thread data and the correct thread type be chosen. On the following pages, all measuring tools are described in detail.

Internal threads

While it is relatively easy to determine an external thread with the help of a thread gauge, it is more complicated for internal threads. If the workpiece should not be broken and great technical expenditure avoided, one can only roughly measure and try out. Proceed as follows: Use the outer large jaws of the calliper. This should correspond to the tap hole that has been drilled prior to the tapping. In our example, we measure a diameter of 23mm. The formula to determine the tap hole diameter is:

dk = D – P (Tap hole-Ø = Nominal-Ø – Pitch)
or: Nominal-Ø = Tap hole-Ø + Pitch

Now a proper tap hole size can be chosen from the tap hole table of the calliper. One have to keep in mind that tap holed usually do not meet the specifications, but indicated as being bigger. According to the formula, the example is a metric thread M 24 x 1 or M 25 x 2, or an imperial thread G 5/8 threads/inch. A decision can be made through testing with appropriate screws.

MEASURING TOOLS

THREAD IDENTIFICATION

In order to identify an unknown thread, two specifications are necessary: the pitch and outer diameter of a bolt thread as well as the inner diameter of the female thread. A thread's pitch is the distance from one flank to another in mm and used for metric systems. Imperial systems use the measuring unit threads per inch (TPI). First, you have to measure the diameter of the thread with a calliper.

With the conversion table below, you can determine the imperial measuring unit as a metric unit and thus convert. An inch equals 25,4 mm. The diameter will identify the thread as metric or imperial. Please test all leafs of the thread gauge until one leaf exactly matches the thread. Read off the imprinted pitch.

DIGITAL CALLIPER

The callipers have cross-tips, depth gauge and a locking screw. The precision mechanics is made from stainless steel and hardened.

Batteries for operating the digital LCD screen are interchangeable. They have an additional data output RS232. They are packed with a spare battery in a sturdy plastic case.

THREAD GAUGE LEAFS

6 / 10 / 12 / 20 / 22 / 24 / 28 / 48 / 52 / 58 Leaf

THREAD GAUGES

Thread gauges are used for measuring an internal and external thread's pitch. They work according to the light-gap method. The gauge is placed onto the thread and tested whether the thread's pitch and the gauge match or not.

Each leaf represents one possible thread pitch. They are collected fan-like in a holding device. Different combinations of leafs for metric and imperial threads, from 6 leafs up to 58 leafs in one tool, are available.

DIGITAL CALLIPERS

TECHNICAL INFORMATION

- Tolerance: 0,01mm / 0,0005 inch
- with large steel display
- with depth gauge and locking screw
- fine adjustment wheel

Measuring range	Reading	Switch	Art.-No.
100 mm / 4 inch	0,01 / 0,001	manual	05010100
150 mm / 6 inch	0,01 / 0,001	manual	05010110

DIGITAL CALLIPERS DIN862

TECHNICAL INFORMATION

- Tolerance: 0,01mm / 0,0005 inch
- with large display
- with depth gauge and locking screw
- fine adjustment wheel

Measuring range	Reading	Switch	Art.-No.
100 mm / 4 inch	0,01 / 0,001	manual	05010000
150 mm / 6 inch	0,01 / 0,001	manual	05010010

DIGITAL PLASTIC CALLIPER

TECHNICAL INFORMATION

- 0,01mm / 0,0005 inch
- with large display

Measuring range	Reading	Switch	Art.-No.
100 mm / 4 inch	0,01 / 0,001	manual	05010200

ANALOGUE CALLIPER

TECHNICAL INFORMATION

- Tolerance: 0,02 mm
- with depth gauge and locking screw
- fine adjustment wheel

Measuring range	Art.-No.
150 mm / 6 inch	05012020

THREAD GAUGES

TECHNICAL INFORMATION

for internal and external measurements

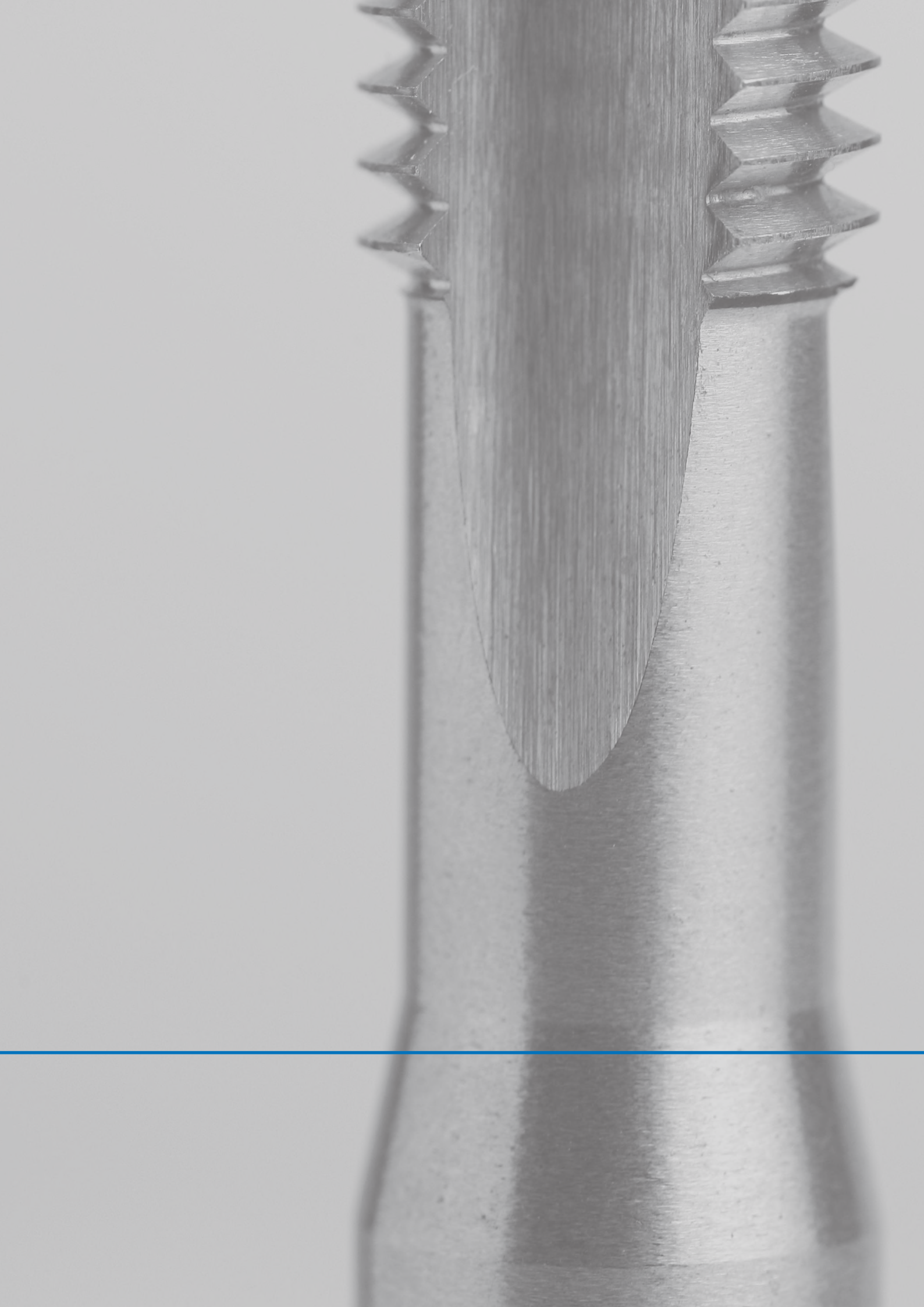
Thread type	Pitch		Number of leafs	Art.-No.
M	0,5 - 1,75	0,5 - 0,6 - 0,7 - 0,75 - 0,8 - 0,9 - 1,0 - 1,25 - 1,5 - 1,75 - 27 - 28	12	05001010
M	0,25 - 6,0	0,25 - 0,3 - 0,35 - 0,4 - 0,45 - 0,5 - 0,6 - 0,7 - 0,75 - 0,8 - 0,9 - 1,0 - 1,25 - 1,5 - 1,75 - 2,0 - 2,5 - 3,0 - 3,5 - 4,0 - 4,5 - 5,0 - 5,5 - 6,0	24	05001020
M / Ww	0,25 - 6,0 / 4 - 62	"M: 0,25 - 0,3 - 0,35 - 0,4 - 0,45 - 0,5 - 0,6 - 0,7 - 0,75 - 0,8 - 0,9 - 1,0 - 1,25 - 1,5 - 1,75 - 2,0 - 2,5 - 3,0 - 3,5 - 4,0 - 4,5 - 5,0 - 5,5 - 6,0 Ww: 4 - 4,5 - 5 - 6 - 7 - 8 - 9 - 10 - 11 - 12 - 13 - 14 - 16 - 18 - 19 - 20 - 22 - 24 - 25 - 26 - 28 - "	52	05001030
M / Ww 55° / Ww-pipe 55°	0,25 - 6,0 / 4 - 62 / 8 - 28	"M: 0,25 - 0,3 - 0,35 - 0,4 - 0,45 - 0,5 - 0,6 - 0,7 - 0,75 - 0,8 - 0,9 - 1,0 - 1,25 - 1,5 - 1,75 - 2,0 - 2,5 - 3,0 - 3,5 - 4,0 - 4,5 - 5,0 - 5,5 - 6,0 Ww: 4 - 4,5 - 5 - 6 - 7 - 8 - 9 - 10 - 11 - 12 - 13 - 14 - 16 - 18 - 19 - 20 - 22 - 24 - 25 - 26 - 28 - "	58	05001040
Ww 55°	4 - 30	4 - 4,5 - 5 - 6 - 7 - 8 - 9 - 10 - 11 - 12 - 13 - 14 - 16 - 18 - 19 - 22 - 24 - 26 - 28 - 30	20	05001050
Ww 55°	4 - 62	4 - 4,5 - 5 - 6 - 7 - 8 - 9 - 10 - 11 - 12 - 13 - 14 - 16 - 18 - 19 - 20 - 22 - 24 - 25 - 26 - 28 - 30 - 32 - 36 - 40 - 48 - 60 - 62	28	05001060
Ww-pipe 55°	8 - 28	8 - 10 - 11 - 14 - 19 - 28	6	05001070
UNC 60°	4 - 64	4 - 4,5 - 5 - 6 - 7 - 8 - 9 - 10 - 11 - 12 - 13 - 14 - 16 - 18 - 20 - 24 - 32 - 40 - 48 - 56 - 64	22	05001080
UNF 60°	12 - 80	12 - 14 - 16 - 18 - 20 - 24 - 28 - 32 - 36 - 40 - 44 - 48 - 56 - 64 - 72 - 80	16	05001090
US 60°	4 - 42	4 - 4,5 - 5 - 5,5 - 6 - 7 - 8 - 9 - 10 - 11 - 11,5 - 12 - 13 - 14 - 15 - 16 - 18 - 20 - 22 - 24 - 26 - 27 - 28 - 30 - 32 - 34 - 36 - 38 - 40 - 42	30	05001100
US 60°	10 - 40	10 - 11 - 12 - 13 - 14 - 16 - 18 - 20 - 24 - 27 - 28 - 32 - 36 - 40	14	05001110

COMBINED THREAD GAUGES

TECHNICAL INFORMATION

thread gauge with 7 leafs for measuring internal and external threads
and 7 sheets for measuring internal threads

Thread type	Pitch		Number of leafs	Art.-No.
M	0,5 - 1,75	0,5 - 0,7 - 0,8 - 1,0 - 1,25 - 1,5 - 1,75	14	05001120



APPENDIX

THREAD COMPARISON CHART

Nominal diam-eter	BSW (W)	UNC	UNF	UNEF	BSF	Thread diameter	Nominal diameter	BSP (G)	Thread diameter
Inch	TPI	TPI	TPI	TPI	TPI	mm	Inch	TPI	mm
No. 0	—	--	80	—	—	1,52	G 1/8"	28	9,728
No. 1	—	64	72	—	—	1,85	G 1/4"	19	13,157
No. 2	—	56	64	—	—	2,18	G 3/8"	19	16,662
No. 3	—	48	56	—	—	2,52	G 1/2"	14	20,955
No. 4	—	40	48	—	—	2,85	G 5/8"	14	22,911
No. 5	—	40	44	—	—	3,17	G 3/4"	14	26,441
No. 6	—	32	40	—	—	3,5	G 7/8"	14	30,201
No. 8	—	32	36	—	—	4,16	G 1"	11	33,249
No. 10	—	24	32	—	—	4,83	G 1 1/8"	11	37,897
No. 12	—	24	28	32	—	5,49	G 1 1/4"	11	41,91
1/16"	60	—	—	—	—	1,587	G 1 3/8"	11	44,323
3/32"	48	—	—	—	—	2,381	G 1 1/2"	11	47,803
1/8"	40	—	—	—	—	3,175	G 1 3/4"	11	53,746
5/32"	32	—	—	—	—	3,969	G 2"	11	59,614
3/16"	24	—	—	—	32	4,762	G 2 1/4"	11	65,71
7/32"	24	—	—	—	28	5,556	G 2 1/2"	11	75,184
1/4"	20	20	28	32	26	6,35	G 2 3/4"	11	81,534
5/16"	18	18	24	32	22	7,938	G 3"	11	87,884
3/8"	16	16	24	32	20	9,525	G 3 1/4"	11	93,98
7/16"	14	14	20	28	18	11,113	G 3 1/2"	11	100,33
1/2"	12	13	20	28	16	12,7	G 3 3/4"	11	106,68
9/16"	12	12	18	24	16	14,288	G 4"	11	113,03
5/8"	11	11	18	24	14	15,876			
11/16"	—	—	—	24	14	17,463			
3/4"	10	10	16	20	12	19,051			
13/16"	—	—	—	20	12	20,638			
7/8"	9	9	14	20	11	22,226			
15/16"	—	—	—	20	11	23,813			
1"	8	8	12	20	10	25,401			
1 1/16"	—	—	—	18	—	26,988			
1 1/8"	7	7	12	18	9	28,576			
1 3/16"	—	—	—	18	—	30,163			
1 1/4"	7	7	12	18	9	31,751			
1 5/16"	—	—	—	18	—	33,338			
1 3/8"	6	6	12	18	8	34,926			
1 7/16"	—	—	—	18	—	36,512			
1 1/2"	6	6	12	18	8	38,101			
1 5/8"	5	5	—	18	8	41,277			
1 3/4"	5	5	—	18	7	44,452			
1 7/8"	4,5	4,5	—	18	—	47,627			

THREAD COMPARISON CHART

Nominal diam-eter	BSW (W)	UNC	UNF	UNEF	BSF	Thread diameter
Inch	TPI	TPI	TPI	TPI	TPI	mm
2"	4,5	4,5	—	18	7	50,802
2 1/4"	4	4,5	—	—	—	57,152
2 1/2"	4	4	—	—	—	63,502
2 3/4"	3,5	4	—	—	—	69,853
3"	3,5	4	—	—	—	76,203

SPEED / CUTTING SPEED

Drill ø	1	2	3	4	5	6	7	8	9	10	11	12	13
RPM	Cutting speed												
100	0,3	0,6	0,9	1,3	1,6	1,9	2,3	2,5	2,8	3,1	3,5	3,8	4,1
200	0,6	1,3	1,9	2,5	3,1	3,8	4,6	5,0	5,7	6,3	6,9	7,5	8,2
300	0,9	1,9	2,8	3,8	4,7	5,7	6,9	7,5	8,5	9,4	10,4	11,3	12,3
400	1,3	2,5	3,8	5,0	6,3	7,5	9,2	10,1	11,3	12,6	13,8	15,1	16,3
500	1,6	3,1	4,7	6,3	7,9	9,4	11,5	12,6	14,1	15,7	17,3	18,9	20,4
600	1,9	3,8	5,7	7,5	9,4	11,3	13,8	15,1	17,0	18,9	20,7	22,6	24,5
700	2,2	4,4	6,6	8,8	11,0	13,2	16,1	17,6	19,8	22,0	24,2	26,4	28,6
800	2,5	5,0	7,5	10,1	12,6	15,1	18,3	20,1	22,6	25,1	27,6	30,2	32,7
900	2,8	5,7	8,5	11,3	14,1	17,0	19,8	22,6	25,5	28,3	31,1	33,9	36,8
1000	3,1	6,3	9,4	12,6	15,7	18,9	22,0	25,1	28,3	31,4	34,6	37,7	40,8
1100	3,5	6,9	10,4	13,8	17,3	20,7	24,2	27,6	31,1	34,6	38,0	41,5	44,9
1200	3,8	7,5	11,3	15,1	18,9	22,6	26,4	30,2	33,9	37,7	41,5	45,2	49,0
1300	4,1	8,2	12,3	16,3	20,4	24,5	28,6	32,7	36,8	40,8	44,9	49,0	53,1
1400	4,4	8,8	13,2	17,6	22,0	26,4	30,8	35,2	39,6	44,0	48,4	52,8	57,2
1500	4,7	9,4	14,1	18,9	23,6	28,3	33,0	37,7	42,4	47,1	51,8	56,6	61,3
1600	5,0	10,1	15,1	20,1	25,1	30,2	35,2	40,2	45,2	50,3	55,3	60,3	65,4
1700	5,3	10,7	16,0	21,4	26,7	32,0	37,4	42,7	48,1	53,4	58,8	64,1	69,4
1800	5,7	11,3	17,0	22,6	28,3	33,9	39,6	45,2	50,9	56,6	62,2	67,9	73,5
1900	6,0	11,9	17,9	23,9	29,8	35,8	41,8	47,8	53,7	59,7	65,7	71,6	77,6
2000	6,3	12,6	18,9	25,1	31,4	37,7	44,0	50,3	56,6	62,8	69,1	75,4	81,7
2100	6,6	13,2	19,8	26,4	33,0	39,6	46,2	52,8	59,4	66,0	72,6	79,2	85,8
2200	6,9	13,8	20,7	27,6	34,6	41,5	48,4	55,3	62,2	69,1	76,0	82,9	89,9
2300	7,2	14,5	21,7	28,9	36,1	43,4	50,6	57,8	65,0	72,3	79,5	86,7	93,9
2400	7,5	15,1	22,6	30,2	37,7	45,2	52,8	60,3	67,9	75,4	82,9	90,5	98,0
2500	7,9	15,7	23,6	31,4	39,3	47,1	55,0	62,8	70,7	78,6	86,4	94,3	102,1

DIAMETER / CUTTING SPEED

Tool ø	2	3	4	5	6	7	8	10	12	15	18	20	22
	Rotation speed - row RPM												
1	637	955	1273	1591	1910	2228	2546	3183	3819	4774	5729	6365	7002
1,6	398	597	796	995	1194	1392	1591	1989	2387	2984	3581	3978	4376
1,8	354	530	707	884	1061	1238	1415	1768	2122	2652	3183	3536	3890
2	318	477	637	796	955	1114	1273	1591	1910	2387	2864	3183	3501
2,2	289	434	579	723	868	1013	1157	1447	1736	2170	2604	2893	3183
2,5	255	382	509	637	764	891	1018	1273	1528	1910	2292	2546	2801
3	212	318	424	530	637	743	849	1061	1273	1591	1910	2122	2334
3,5	182	273	364	455	546	637	727	909	1091	1364	1637	1819	2001
4	159	239	318	398	477	557	637	796	955	1194	1432	1591	1750
5	127	191	255	318	382	446	509	637	764	955	1146	1273	1400
6	106	159	212	265	318	371	424	530	637	796	955	1061	1167
7	91	136	182	227	273	318	364	455	546	682	818	909	1000
8	80	119	159	199	239	278	318	398	477	597	716	796	875
9	71	106	141	177	212	248	283	354	424	530	637	707	778
10	64	95	127	159	191	223	255	318	382	477	573	637	700
11	58	87	116	145	174	203	231	289	347	434	521	579	637
12	53	80	106	133	159	186	212	265	318	398	477	530	583
14	45	68	91	114	136	159	182	227	273	341	409	455	500
16	40	60	80	99	119	139	159	199	239	298	358	398	438
18	35	53	71	88	106	124	141	177	212	265	318	354	389
20	32	48	64	80	1899	111	127	159	191	239	286	318	350
22	29	43	58	72	87	101	116	145	174	217	260	289	318
24	27	40	53	66	80	93	106	133	159	199	239	265	292
27	24	35	47	59	71	83	94	118	141	177	212	236	259
30	21	32	42	53	64	74	85	106	127	159	191	212	233

FORMULA

$$\text{Speed} = \frac{\text{Cutting speed} \times 1000}{\text{Diameter} \times 3{,}14} = n \frac{v \times 1000}{d \times \pi} = \text{rpm}$$

CUTTING SPEED / MATERIALS

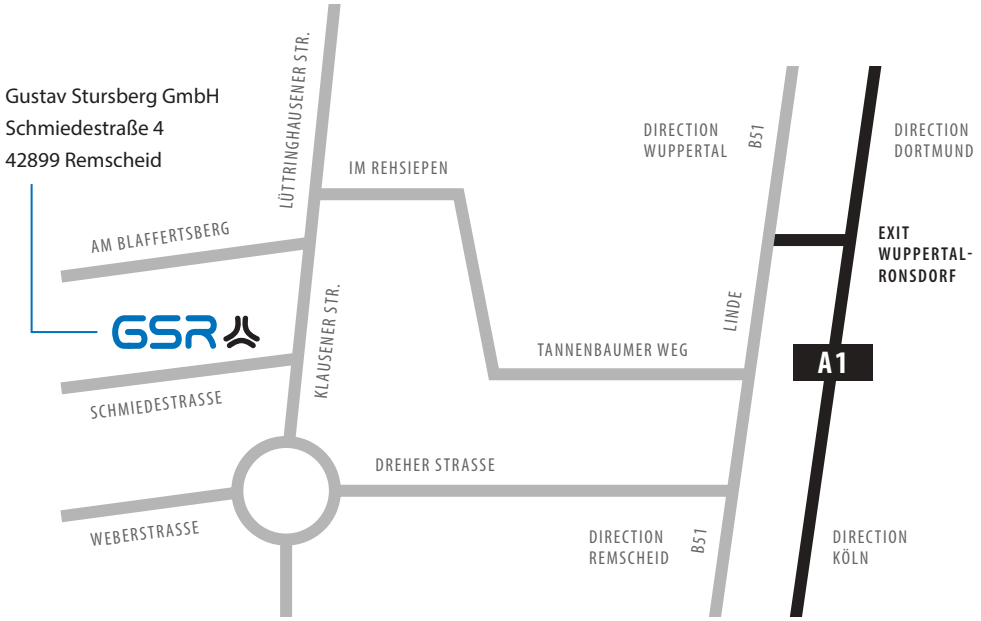
Material	Example	Cutting material	Cutting speed (m/min)		
			Drilling	Reaming	Tapping
Unalloyed construction steel	St 37	HSS HSS coated Carbide	25 28 100	10 12 30	10 12 —
Construction steel	C 45	HSS HSS coated Carbide	18 20 60	6 8 20	8 10 —
Stainless steel	V 2 A	HSS HSS coated Carbide	8 10 30	4 6 12	5 5 —
Grey cast iron	GG25	HSS HSS coated Carbide	18 22 60	6 8 20	10 12 —
Aluminium alloy	AlCuSi	HSS HSS coated Carbide	40 50 —	20 25 —	15 18 —
Brass	Ms57	HSS HSS coated Carbide	40 50 —	20 25 —	15 18 —

—

Those are reference points that can differ in practice.

HOW TO FIND US...

You have a question about our product range or are interested in a particular product? Please feel free to contact us or visit us at our headquarter in Remscheid, Germany. We will advise you personally and competently.



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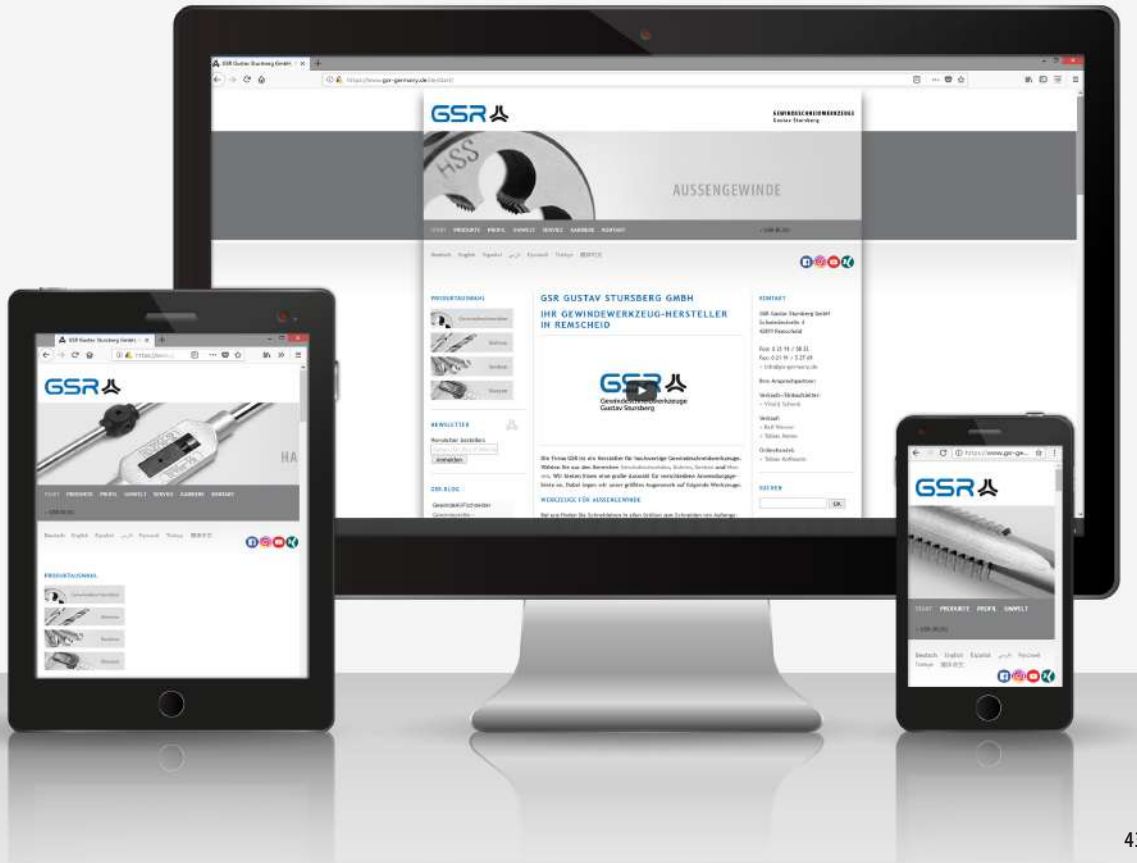

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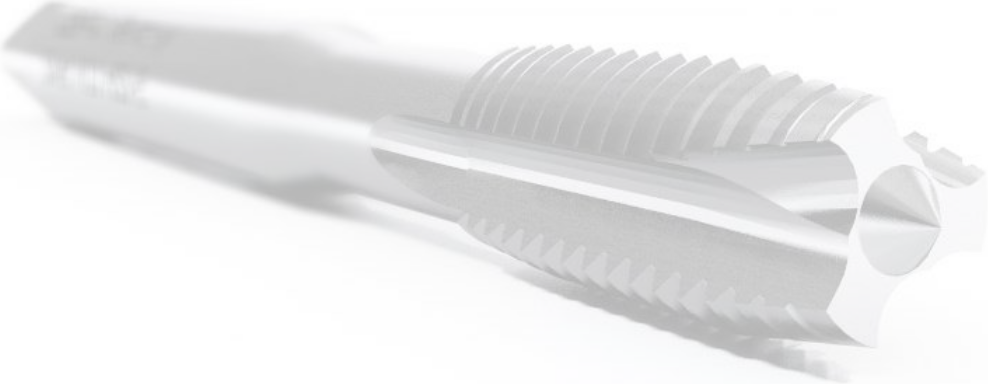

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