



100TH ANNIVERSARY • 1923-2023

1923 · 100 YEARS

Tanoi Manufacturing will celebrate its 100th anniversary on November 11, 2023.



Ms. Yumi Tanoi
(President)

Mr. Yoshimasa Tanoi
(Chairman of the board)

We would like to express our deepest gratitude for the fact that our company has developed to this day and was able to celebrate its 100th anniversary thanks to our customers and partners who have supported and patronized our company so far, as well as the challenges and efforts of our seniors to overcome numerous difficulties.

Since our founding, we have consistently continued our production activities as a manufacturer specializing in tap and dies with a focus on quality and reliable manufacturing.

We will not be afraid of change, we will enjoy change, to develop our future with change.

One of the major elements that we think is important for this purpose is *"human resource development"*.

We believe that achieving this task cannot be achieved overnight, and that it is important to steadily advance step by step from a long-term perspective.

With our founder's words "The manufacturing industry is wonderful because it creates 'existence' from "nothing", firmly engraved in our hearts, we will continue to strive to be useful to everyone while developing wonderful human resources.

We would like to express our sincere gratitude to everyone who has supported our company and ask for your continued guidance and encouragement.

Ms. Yumi Tanoi



Tanoi Management

1923 · 100 YEARS

TANOI strives to improve thread manufacturing by making maximum use of the human potential to create a benefit for all.

TANOI company was founded in 1923 and is currently managed in 3rd generation by Ms. Yumi Tanoi. Since the start we have accumulated and developed an abundance of technical experience, problem-solving techniques and understanding of human communication. We have understood that besides technology, successful manufacturing requires awareness, ingenuity, welcoming of new concepts and strong relationship of trust with customers. All are qualities of people, not of machines.

Tokyo
"Production site"
1923



As TANOI concentrates completely on thread manufacturing, our expertise acquired throughout the years focusses on this field of thread manufacturing exclusively. Consequently, our understanding of this technology is very profound and backed by very many years of everyday

experience. We have managed to pass this rich pool of experience to our sales staff from year to year by intense communication. Very close cooperation between R&D, manufacturing and sales enables us to share the know-how of all sections and to interactively reach the best level of skills of all, because there are so many troubles on tapping process at our customers. TANOI people promote not only sales but also learns about the specific situation of each customer to develop the optimal solution for each thread manufacturing situation.



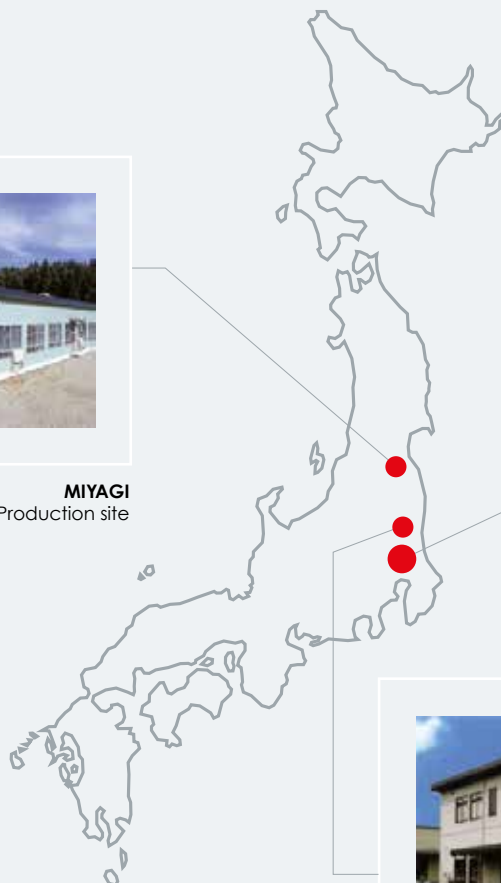
TOKYO
Headquarter



MIYAGI
Production site

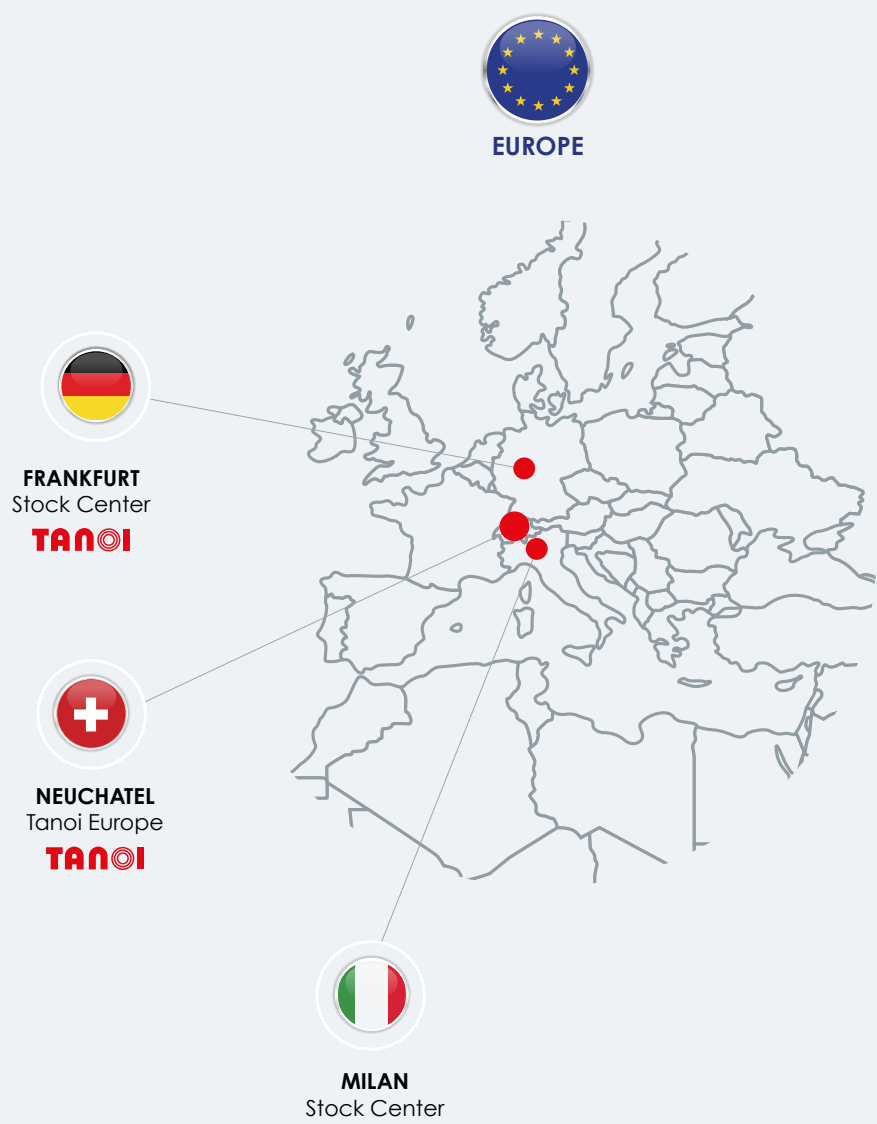


JAPAN



SAITAMA
Production site

1923 · 100 YEARS



CERTIFICATE



Certificate of Assessment

Tanoi Mfg.Co.,Ltd.

Head office/Factory: 953 Okaizumi Shiraoka-shi Saitama, Japan

EQA's certification is hereby granted to the above company's
Quality Management System conforming to the standard
and scope below

ISO 9001:2015 & JIS Q 9001:2015

Scope

Design, Development and Manufacture of Taps and Dies

Registration No. QA190353

First issued on 28 March, 2006 (JIA-QA Center)

Re-issued on 16 December, 2020

This certificate is valid from 16 December 2020 to 27 March, 2024

Appendix for multisites are QA190353-01



The Chief Executive

Further clarifications regarding the scope of this certificate and the applicability
of ISO 9001:2015 requirements may be obtained by consulting EQA.
The certificate written in the local language is the original.
#903, 9F, 5B, Digital-ro 23-gil, Oaro-gu, Seoul, Korea, 152-742
URL: www.eqa-world.com

AQ 24888

CERTIFICATION ISO 9001:2015-JIS Q 9001:2015

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0.113.626	107	B
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0.123.929-ZC	98	B
0.213.423	99	B
0.213.929-ZC	90	B
0.223.929-ZC	82	B
1.112.120	96	B
1.112.620	94	B
1.113.923-MLT	120	B
1.113.980-MLT-C	124	B
1.114.923-MLT-SP	100	B
1.116.120	86	B
1.116.620	104	B
1.153.323-SL	116	B
1.183.323-SL	108	B
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3.112.122	138	B
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3.183.323-IT	73	B
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A



TANOI

Multifunction Taps



Section Index

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PRODUCT FOCUS

"MLT"
"SL TAFLET"

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A⁰²

TOOL SELECTION GUIDE

(M) THREADING

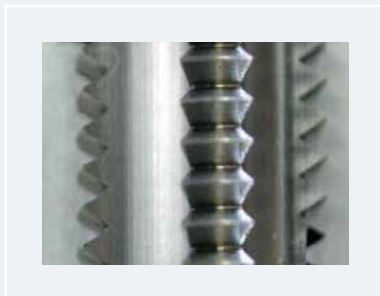
For Cast Iron and ADC

XX

PATENTED

Multifunction taps

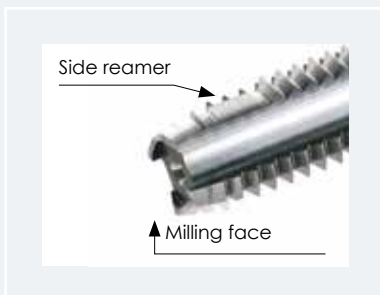
Highlights • MLT



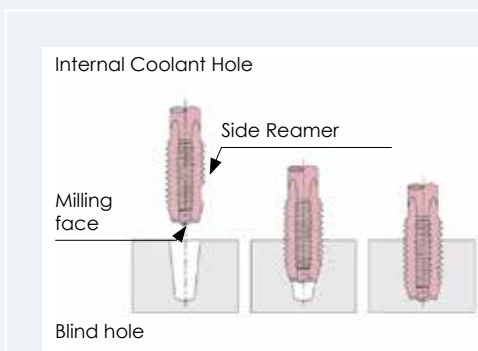
(1.1)



(1.2)



(2.1)



• TECHNICAL FEATURES

MLT Taps are designed for working die cast parts such as motor housings, carburetor housings, and the like.

They combine three functions into one single operation (Pictures 1.1/1.2):

- Removing the cast surface from the die cast hole.
- Tapping the thread.
- Reaming the minor diameter of the thread to the required one.

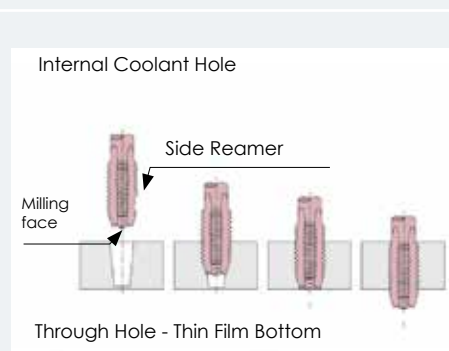
To achieve this the cutting section of the MLT tap has been combined with a special drilling/milling face and a side reamer (Picture 2.1).

MLT Taps can be used in blind holes and through holes. In through holes with thin film bottoms, these bottoms are removed by MLT taps creating a clean, burr-less exit of the hole.

From size M6 on MLT Taps are designed with internal cooling, side reamer (Picture 2.1).

• MLT TAPS ARE PATENTED:

- Japanese patent n. 3457178
- American patent n. 6499920
- European patent n. 0953396

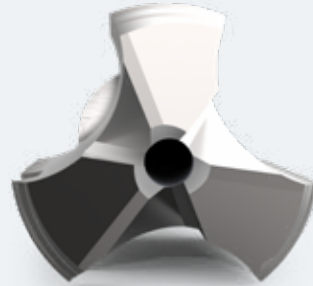


• ADVANTAGES IN PRODUCTION

The operations, drilling, chamfering and tapping are combined into one tool. This reduces production time, tool cost and reduces overall production cost.

The combination of mill, reamer and tap creates best cutting conditions for the tapping process and avoids problems with cast surfaces since these are completely removed.

As the hole is created in one operation with the tapping, deformations and location errors in molded holes are corrected in the process. The side reamer reduces the thread crests to the required internal diameter of the thread. This guarantees perfect concentricity of the hole and the thread.



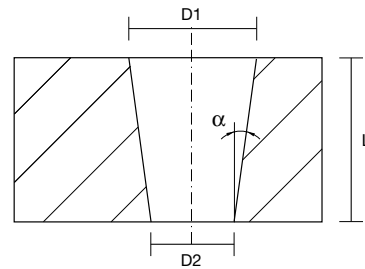
• APPLICATIONS

All MLT taps should be used with synchronized tapping spindles only.

Rigid tool holders without compensation should be used. Because MLT taps generate more chips than conventional taps internal cooling is recommended. From size M6 all MLT taps feature centre cooling through the shank. For smaller sizes the TANOI "Side-Through-System" is strongly recommended for cooling.

The molded holes need to meet the minimum requirements for use of MLT taps.

- The diameter of the hole at the entry should be according to the normal drill diameter for cutting taps. This is approximately the nominal diameter minus the pitch. For a tap M6 the hole's diameter should therefore be 5.0 mm.
- The minimum diameter of the hole should be 0.6 x the nominal diameter of the thread. For a tap M6 it should therefore be 0.6 x 6 mm = 3.6 mm.
- From these two values the incline of the molded hole may be calculated as shown in the picture below.



$$\alpha = \arctan \left(\frac{D1 - D2}{2L} \right)$$

$$L = \frac{D1 - D2}{2 \tan (\alpha)}$$

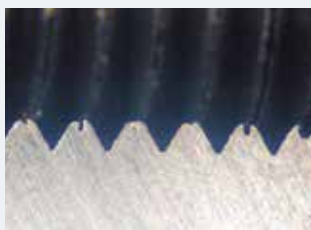


MLT 1.113.923-MLT

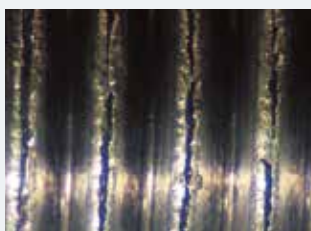
PATENTED

Multifunction taps

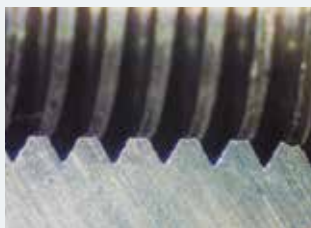
Highlights • SL TAFLET



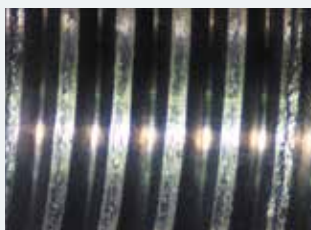
Conventional forming tap (1.1)



Conventional forming tap (1.2)



SL-TAFLET (2.1)



SL-TAFLET (2.2)

• TECHNICAL FEATURES

SL-Taflet forming taps feature a unique combination of thread forming and removing the seams typical for thread forming.

After forming the threads (Pictures 1.1/1.2) SL-Taflet's side reamer cuts the crests of the formed thread thus partially or fully removing the two seams created during the forming process (Pictures 2.1/2.2). Compared to conventional forming taps the forming torque is reduced by approximately 20%.

• ADVANTAGES IN PRODUCTION

By removing the seams on the thread a smooth thread crest is created. The internal thread diameter is constant according to the diameter of the side reamer. This process also achieves improved concentricity of the hole and the thread.

Since the seams are removed plating or other fluids cannot remain between the seams thus avoiding rust or other problems.

No burrs or chips from the thread seams remain in the thread making it safe for applications in the hydraulic or medical fields.

• SL-TAFLET TAPS ARE PATENTED:

- Japanese patent n. 2880122
- American Patent n. 5797710
- European Patent n. 0767024



PATENTED

Multifunction taps

• APPLICATIONS

SL-Taplets require special consideration when choosing the drill hole diameters depending on the degree of thread engagement SL-Taplets can only remove the thread crest if a minimum of thread engagement is reached. Therefore the drill hole diameter should be chosen to be at least 95% of thread engagement. This ensures full removal of the thread seams by the side reamer.

Please refer to the table 3.1 to choose the appropriate drill hole diameter. It is possible to choose lower thread

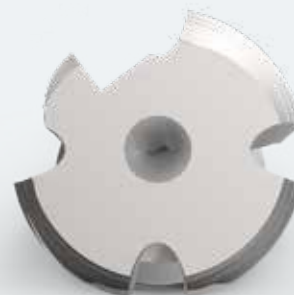


Table 3.1

Size	Pitch	Reamer Diameter D_1	Hole diameter [mm] by % of thread engagement			
			105%	100%	95%	90%
M2	0.40	1.62	1.76	1.77	1.78	1.80
M2.2	0.45	1.77	1.93	1.94	1.96	1.97
M2.5	0.45	2.07	2.23	2.24	2.26	2.27
M2.6	0.45	2.17	2.33	2.34	2.36	2.37
M3	0.50	2.53	2.70	2.72	2.73	2.74
M3.5	0.60	2.93	3.14	3.16	3.18	3.19
M4	0.70	3.34	3.58	3.60	3.62	3.64
M5	0.80	4.24	4.52	4.55	4.57	4.59
M6	1.00	5.05	5.40	5.43	5.46	5.49
M8	1.25	6.82	7.26	7.29	7.33	7.36
M10	1.50	8.58	9.11	9.15	9.19	9.23

engagements than 95%. In such a case some thread seams may remain on the threads crest because they are lower than the internal diameter of the required thread.

However, choosing low thread engagements reduces tapping torque and increases tool life.

Choosing thread engagements above 95% increases cutting torque but also creates better compacted threads making the produced thread stronger.



SL-TAFLET 1.183.323-SL

MULTIFUNCTION TAPS

Hole type	Threading type	Catalog number Size range	DIN	Helix angle	Tolerance	Chamfer form	Material and coating	Taps reference page
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● **FOR CAST IRON AND ADC** Short chipping materials such as GG or Aluminum Die Cast

	M	 1.113.923-MLT M4 - M10			6HX			26
	M	 1.113.980-MLT-C M4 - M10			6HX			27
	M	 1.114.923-MLT-SP M4 - M10			6HX			28
	M	 1.153.323-SL M3 - M10			6HX			30
	M	 1.183.323-SL M2 - M2.6			5HX			85

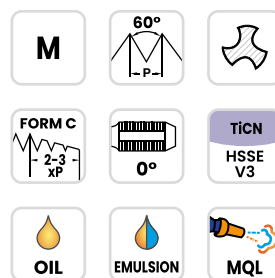
Steel						Cast		Copper			Aluminum and Zinc			Titanium	Nickel	
< 500 N/mm ²	< 800 N/mm ²	< 1'200 N/mm ²	< 1'300 N/mm ²	Stainless / Inox < 1'200 N/mm ²	HRC 50-63 Hardened steels	Cast Iron	Cast Iron long chipping	CU	Copper alloys 200-300 HB	Copper alloys short chipping	AL	AL Si < 10%	AL Si > 10% ADC / ZDC	Ti	Ni	Nickel alloys 900-1'500 N/mm ²

						● ● ●				● ● ●			● ● ●			
						● ●				● ● ●			● ● ●			
						● ●				● ● ●			● ● ●			
								● ● ●	● ● ●		● ● ●	● ● ●	● ● ●			
								● ● ●	● ● ●		● ● ●	● ● ●	● ● ●			

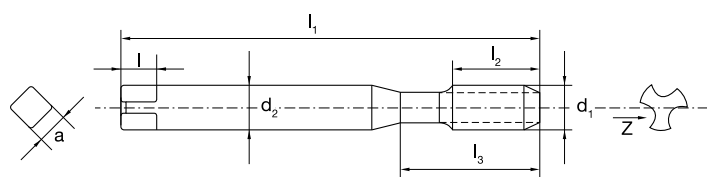
● ● ● Recommended | ● ● Suitable | ○ Possible

MULTIFUNCTION TAPS

For Cast Iron and ADC For short chipping material such as GG or ADC



● Technical details



MLT

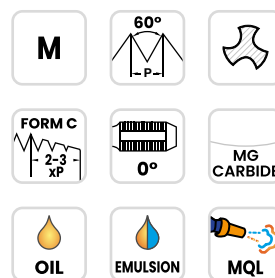
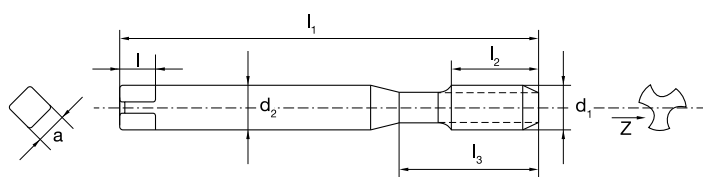
6HX

d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Order code
M4	0.7	63	13	21	4.5	6	3.4	3	951.095
M5	0.8	70	16	25	6	8	4.9	3	951.120
M6	1	80	19	30	6	8	4.9	3	951.130
M8	1.25	90	22	35	8	8	4.9	4	951.155
M10	1.5	100	24	39	10	8	5.5	4	951.185

● Cutting parameters

V _c m/min	GG/ADC CAST	CU SHORT	ZDC ADC
	● ● ● 10 - 40	● ● ● 10 - 40	● ● ● 10 - 40
	● ● 10 - 40	● ● ● 10 - 40	● ● ● 10 - 40
	● ● 15 - 25	● ● ● 20 - 50	● ● ● 20 - 50

● ● ● Recommended | ● ● Suitable | ○ Possible

MULTIFUNCTION TAPS
For Cast Iron and ADC For short chipping material such as GG or ADC

Technical details

MLT
6HX

d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Order code
M4	0.7	63	13	21	4.5	6	3.4	3	952.095
M5	0.8	70	16	25	6	8	4.9	3	952.120
M6	1	80	19	30	6	8	4.9	3	952.130
M8	1.25	90	22	35	8	8	4.9	4	952.155
M10	1.5	100	24	39	10	8	5.6	4	952.185

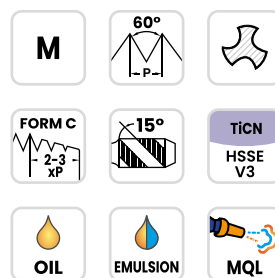
Cutting parameters

V _c m/min	GG/G CAST	CU SHORT	ZDC ADC
	● ● 10 - 40	● ● ● 10 - 40	● ● ● 10 - 40
	● ● 15 - 25	● ● ● 30 - 60	● ● ● 20 - 50
	● ● 15 - 25	● ● ● 20 - 50	● ● ● 20 - 50

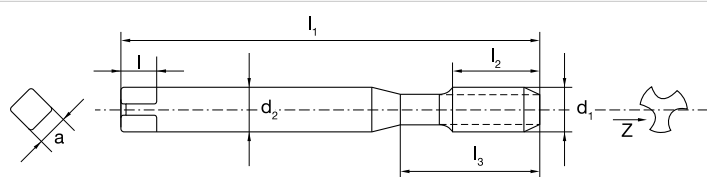
●●● Recommended | ●● Suitable | ○ Possible

MULTIFUNCTION TAPS

For Cast Iron and ADC For short chipping material such as GG or ADC



● Technical details



MLT

6HX

d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Order code
M4	0.7	63	13	21	4.5	6	3.4	3	953.095
M5	0.8	70	16	25	6	8	4.9	3	953.120
M6	1	80	19	30	6	8	4.9	3	953.130
M8	1.25	90	22	36	6	8	4.9	4	953.155
M10	1.5	100	24	40	7	8	5.6	4	953.185

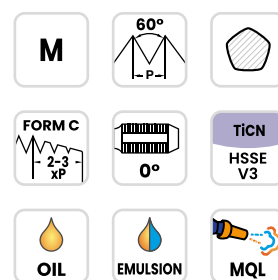
● Cutting parameters

V _c m/min	GG/ADC CAST	CU SHORT	ZDC ADC
	● ● 10 - 40	● ● ● ● 10 - 40	● ● ● ● 10 - 40
	● ● 15 - 25	● ● ● ● 30 - 60	● ● ● ● 20 - 50
	● ● 15 - 25	● ● ● ● 20 - 50	● ● ● ● 20 - 50

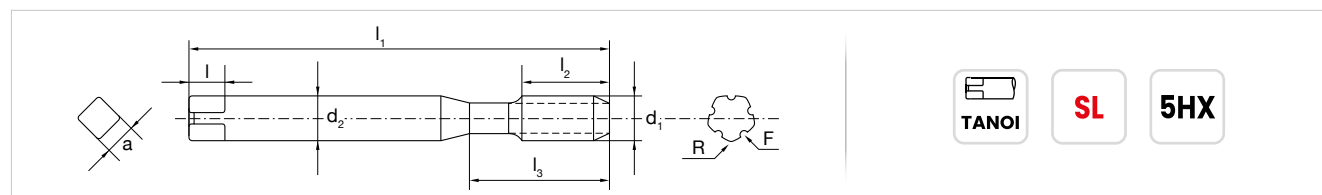
● ● ● Recommended | ● ● Suitable | ○ Possible

MULTIFUNCTION TAPS

For Cast Iron and ADC For short chipping material such as GG or ADC



● Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	R	F	Ø mm	Order code
M2	0.4	45	8	10	2.8	5	2.1	8	4	1.78	810.065
M2.2	0.45	45	9	11	2.8	5	2.1	8	4	1.96	810.070
M2.5	0.45	50	9	12.5	2.8	5	2.1	8	4	2.26	810.080
M2.6	0.45	50	9	12.5	2.8	5	2.1	8	4	2.36	810.085

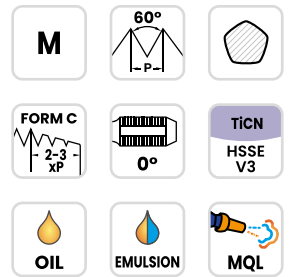
● Cutting parameters

V _c m/min	CU 200-300 HB	CU	ZDC ADC	ALU Si >10%	ALU Si <10%	ALU
	● ● ● 3 - 24	● ● ● 3 - 24	● ● ● 7 - 48	● ● ● 7 - 48	● ● 7 - 48	● ● ● 10 - 48
	● ● ● 4 - 24	● ● ● 4 - 24	● ● ● 9 - 32	● ● ● 9 - 32	● ● 9 - 32	● ● ● 13 - 48
	● ● ● 5 - 20	● ● ● 5 - 20	● ● ● 5 - 30	● ● ● 5 - 30	● ● 5 - 30	● ● ● 10 - 45

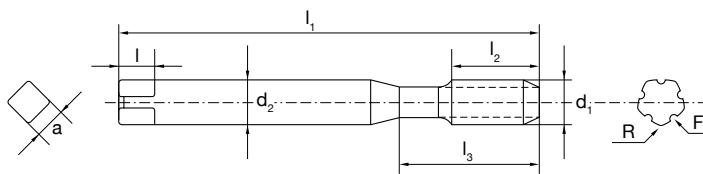
● ● ● Recommended | ● ● Suitable | ○ Possible

MULTIFUNCTION TAPS

For Cast Iron and ADC For short chipping material such as GG or ADC



Technical details


SL
6HX

d_1	P	l_1	l_2	l_3	d_2	l	a	R	F	$\frac{\phi}{mm}$	Order code
M3	0.5	56	11	18	3.5	6	2.7	8	4	2.73	810.090
M3.5	0.6	56	12	20	4	6	3	8	4	3.18	810.095
M4	0.7	63	13	21	4.5	6	3.4	8	4	3.62	810.100
M5	0.8	70	16	25	6	8	4.9	8	4	4.57	810.110
M6	1	80	19	30	6	8	4.9	8	4	5.46	810.115
M8	1.25	90	22	35	8	9	6.2	5	6	7.33	810.125
M10	1.5	100	24	39	10	11	8	5	6	9.19	810.135

Cutting parameters

V_c m/min	CU 200-300 HB	CU	ZDC ADC	ALU Si >10%	ALU Si <10%	ALU
	● ● ● 3 - 24	● ● ● 3 - 24	● ● ● 7 - 48	● ● ● 7 - 48	● ● 7 - 48	● ● ● 10 - 48
$\leq 2 \times d$	● ● ● 4 - 24	● ● ● 4 - 24	● ● ● 9 - 32	● ● ● 9 - 32	● ● 9 - 32	● ● ● 13 - 48
$> 2 \times d$	● ● ● 5 - 20	● ● ● 5 - 20	● ● ● 5 - 30	● ● ● 5 - 30	● ● ● 5 - 30	● ● ● 10 - 45

● ● ● Recommended | ● ● Suitable | ○ Possible

B



TANOI

Cutting Taps



Section Index

B⁰¹

PRODUCT FOCUS

"PM ALLROUND"	XX-XX
"ZERO CHIP"	XX-XX

B⁰²

TOOL SELECTION GUIDE

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	For Mild Steels < 500 N/mm ²	XX-XX
	For Mild and Low Alloy Steels < 800 N/mm ²	XX-XX
	For High Alloy Steels < 1300 N/mm ²	XX-XX
	For Stainless Steels < 1200 N/mm ²	XX-XX
	For Titanium and Nickel Alloys	XX-XX
	For General Use	XX-XX
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	For Mild and Low Alloy Steels < 800 N/mm ²	XX
	For Stainless Steels < 1200 N/mm ²	XX-XX
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(UNC) THREADING	For Mild and Low Alloy Steels < 800 N/mm ²	XX
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(UNF) THREADING	For Mild and Low Alloy Steels < 800 N/mm ²	XX
	For Stainless Steels < 1200 N/mm ²	XX
(NPT) THREADING	For Mild and Low Alloy Steels < 800 N/mm ²	XX
(G) THREADING	For Mild and Low Alloy Steels < 800 N/mm ²	XX
	For Stainless Steels < 1200 N/mm ²	XX
	For Tempered Steels < 62 HRC	XX
(PG) THREADING	For Mild and Low Alloy Steels < 800 N/mm ²	XX

PLUS

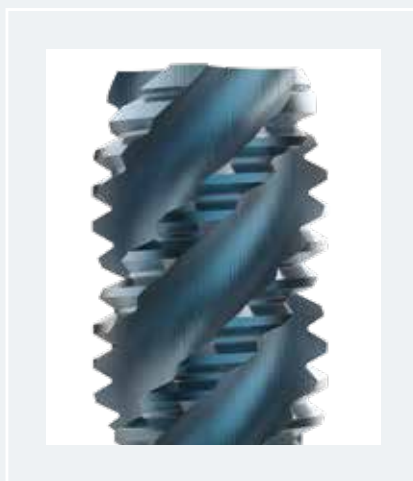
Maschi ad Asportazione

Highlights • PM ALLROUND

• TECHNICAL FEATURES

PM Allround taps feature true universal capabilities. They perform just as well in the entire range of abrasive, brittle materials like cast iron as they do in stainless steels.

The specially developed micro grain powder metal assures superior hardness combined with a maximum of toughness. This allows the machining of hard materials and at the same time makes the tool resistant to shocks and impacts.



NEW TANOI TEC coating

The new TANOI TEC coating adds outstanding wear resistance and heat insulation allowing the tap to machine cast iron or similarly abrasive materials.

- TEC coating prevents wear and rounding of the cutting edges.
- The thermal insulation capacity of TEC coating protects the tap from the process heat by diverting it into the chips.
- On top of this, the smooth surface of TEC coating eases the chip flow and prevents chips attaching to the tap's flutes.



PLUS

• ADVANTAGES IN PRODUCTION

In production environments, working primarily one material the choice of the correct tool is fairly easy. TANOI carries a wide range of taps optimized to the requirements for different work materials. **Many companies however, face the challenge of working small and medium size production lots of very different work materials that would require a multitude of different taps.**

TANOI has designed a solution for just this manufacturing situation. The new **PM Allround tap** unites the features of several specialized taps into one tool. It works in cast iron as well as in stainless steels and most steel-based work materials in this range.

- This allows customers to reduce the quantity of tools they need for their daily work.
- It reduces cost by minimizing the variety of tools needed in production.
- It simplifies processes and makes production more efficient.

The unique combination of cutting material with specially developed coating and a carefully adapted cutting geometry do the trick.



Cutting Taps



PM ALLROUND 9.112.153



PM ALLROUND 9.116.653

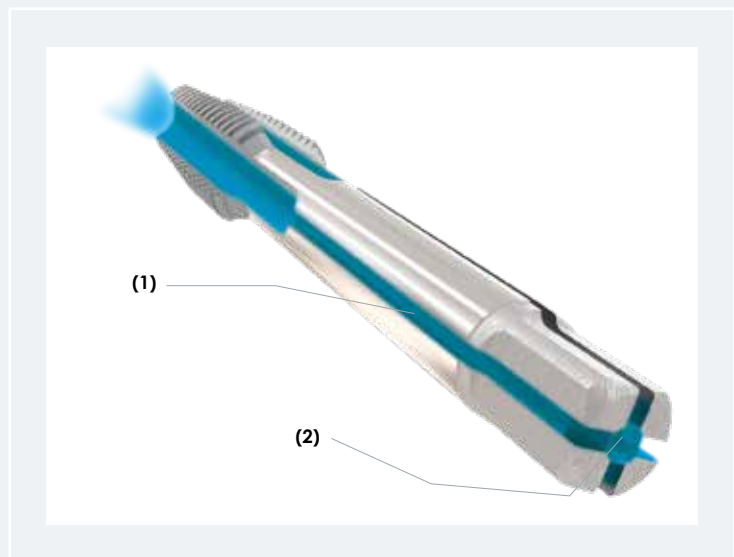
PLUS

Cutting Taps

Highlights • ZERO CHIP

• TECHNICAL FEATURES

Zero Chip taps introduce a new way of providing coolant from the machines internal cooling system to the cutting edges. The system consists of a coolant circulator in the back end of the tap and oil grooves along the tap's shank. The coolant circulator distributes the flow of coolant from the machine spindle equally into the oil grooves. The oil grooves carry the coolant along the shank directly to the cutting edges of the tap.



(1)
oil grooves along
the tap's shank

(2)
Cross cut for better
lubrication flow

Zero Chip taps can be used in through holes on all materials. The system can be applied to all flute geometries that allow reaching the cutting edges along the shank. In general these are straight flutes and left hand spiral flutes with spiral angles up to 15°.

In blind holes the use of **Zero Chip** taps focusses on short chipping materials. On three flute taps the coolant is provided through one flute which allows the coolant to enter the hole, reach the bottom of the hole and carry the chips through the two remaining flutes out of the hole. On four flute taps the distribution is two flutes in and two flutes out.

Zero Chip taps have earned renowned prizes such as the 6th Monozukuri Nippon Grand Award and the Special Recognition Prize of the Japanese Ministry of Economy, Trade and Industry (METI).



• ADVANTAGES IN PRODUCTION

The direct flow of the coolant onto the cutting edges not only gives optimal lubrication to the cutting process but also mechanically pushes the chips forward, away from the cutting edge. This allows better access of coolant to the cutting edges because they are immediately cleared from any chips. This mechanism prevents welding on the cutting edges and breakage due to chip congestion. It also directly cools and lubricates the cutting edges reducing heat buildup in the tap significantly.

In many applications Zero Chip straight flute taps can be used, thus taking advantage of the strong cutting edges of these taps compared to spiral point or spiral flute taps. **The chip transport is controlled by the coolant flow, not the flute geometry.**

Zero Chip taps can be reground several times as the cooling remains intact, even if the tap chamfer is displaced towards the shank by the grinding process. This gives them a significant advantage over oil hole taps with flute exits that cannot be reground in many cases.

In blind holes the flow direction of the coolant clears the bottom of the hole from remaining chips, thus making an additional cleaning process obsolete.

• APPLICATIONS

Zero Chip taps can be widely used on all short chipping materials in blind holes, all materials in through holes and on all machines with internal cooling.

The range of applications vary from automotive to aerospace to energy technology and many more. ZC Taps are universal taps that make tapping in most cases more productive by increasing cutting speed and tool life significantly.



ZERO CHIP 0.113.929-ZC

CUTTING TAPS

Hole type	Threading type	Catalog number Size range	DIN	Helix angle	Tolerance	Chamfer form	Material and coating	Taps reference page
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● **FOR CAST IRON AND ADC** Short chipping materials such as GG or Aluminum Die Cast

	M	 0.113.122 M4 - M8	 DIN 371	 0°	6HX	 FORM C 2-3 xP	 TiN HSSE V3	xxx
	M	 0.113.123 M4 - M10	 DIN 371	 0°	6HX	 FORM C 2-3 xP	 TiCN HSSE V3	xxx
	M	 0.113.622 M5 - M16	 DIN 376	 0°	6HX	 FORM C 2-3 xP	 TiN HSSE V3	72
	M	 0.113.623 M5 - M16	 DIN 376	 0°	6HX	 FORM C 2-3 xP	 TiCN HSSE V3	73
	M	 0.113.626 M4 - M30	 DIN 376	 0°	6HX	 FORM C 2-3 xP	 Ni OX HSSE V3	74
	M	 0.113.929-ZC M3 - M12	 TANOI	 0°	6HX	 FORM C 2-3 xP	 TiCN HSSE V3	76
	M	 0.123.929-ZC M3 - M12	 TANOI	 0°	6GX	 FORM C 2-3 xP	 TiCN HSSE V3	77

● **FOR ALUMINIUM** Aluminums and long chipping materials

	M	 1.112.120 M3 - M10	 DIN 371	 B	ISO 2 (6H)	 FORM B 3.5-5 xP	 HSSE V3	78
	M	 1.112.123 M3 - M10	 DIN 371	 B	ISO 2 (6H)	 FORM B 3.5-5 xP	 TiCN HSSE V3	79
	M	 1.112.620 M12 - M20	 DIN 376	 B	ISO 2 (6H)	 FORM B 3.5-5 xP	 HSSE V3	xxx
	M	 1.116.120 M2 - M10	 DIN 371	 45°	ISO 2 (6H)	 FORM C 2-3 xP	 HSSE V3	80

Steel						Cast		Copper			Aluminum and Zinc			Titanium	Nickel	
< 500 N/mm ²	< 800 N/mm ²	< 1'200 N/mm ²	< 1'300 N/mm ²	Stainless / Inox < 1'200 N/mm ²	HRC 50-63 Hardened steels	Cast Iron	Cast Iron long chipping	CU	Copper alloys 200-300 HB	Copper alloys short chipping	AL	ALSi < 10%	ALSi > 10% ADC / ZDC	Ti	Ni	Nickel alloys 900-1'500 N/mm ²

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● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

Hole type	Threading type	Catalog number Size range	DIN	Helix angle	Tolerance	Chamfer form	Material and coating	Taps reference page
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● **FOR ALUMINIUM** Aluminums and long chipping materials

	M	 1.116.123 M2 - M10			ISO 2 (6H)			81
	M	 1.116.620 M12 - M20			ISO 2 (6H)			xxx
	M	 1.116.623 M12 - M20			ISO 2 (6H)			xxx

● **FOR MILD STEELS** < 500 N/mm²

	M	 2.112.121 M3 - M10			ISO 2 (6H)			31
	M	 2.112.621 M12 - M36			ISO 2 (6H)			82
	M	 2.115.121 M3 - M10			ISO 2 (6H)			83
	M	 2.115.621 M3 - M36			ISO 2 (6H)			84

● **FOR MILD AND LOW ALLOY STEELS** < 800 N/mm²

	M	 3.111.120 M1 - M10			ISO 2 (6H)			86
	M	 3.111.620 M2.5 - M30			ISO 2 (6H)			87
	M	 3.112.120 M1.4 - M12			ISO 2 (6H)			88

Steel						Cast		Copper			Aluminum and Zinc			Titanium	Nickel	
< 500 N/mm ²	< 800 N/mm ²	< 1'200 N/mm ²	< 1'300 N/mm ²	Stainless / Inox < 1'200 N/mm ²	HRC 50-63 Hardened steels	Cast Iron	Cast Iron long chipping	CU	Copper alloys 200-300 HB	Copper alloys short chipping	AL	ALSI < 10%	ALSI > 10% ADC / ZDC	Ti	Ni	Nickel alloys 900-1'500 N/mm ²

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● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

Hole type	Threading type	Catalog number Size range	DIN	Helix angle	Tolerance	Chamfer form	Material and coating	Taps reference page
	M LH	 3.112.120-LH M3 - M10	 DIN 371	 B	ISO 2 (6H)	 FORM B -3.5-5 XP	 HSSE V3	90
	M	 3.112.122 M3 - M10	 DIN 371	 B	ISO 2 (6H)	 FORM B -3.5-5 XP	 TiN HSSE V3	91
	M	 3.112.126-WF M2 - M10	 DIN 371	 B	ISO 2 (6H)	 FORM B -3.5-5 XP	 Ni OX HSSE V3	94
	M	 3.112.129 M2 - M10	 DIN 371	 B	ISO 2 (6H)	 FORM B -3.5-5 XP	 TiN HSSE V3	95
	M	 3.112.220 M2 - M20	 DIN 352	 B	ISO 2 (6H)	 FORM B -3.5-5 XP	 HSSE V3	93
	M	 3.112.620 M2 - M52	 DIN 376	 B	ISO 2 (6H)	 FORM B -3.5-5 XP	 HSSE V3	96
	M LH	 3.112.620-LH M12 - M20	 DIN 376	 B	ISO 2 (6H)	 FORM B -3.5-5 XP	 HSSE V3	97
	M	 3.112.622 M3 - M36	 DIN 376	 B	ISO 2 (6H)	 FORM B -3.5-5 XP	 TiN HSSE V3	98
	M	 3.112.920-LS M3 - M16	 TANOI LS	 B	ISO 2 (6H)	 FORM B -3.5-5 XP	 HSSE V3	99
	M	 3.113.120 M1.4 - M10	 DIN 371	 0°	ISO 2 (6H)	 FORM C 2-3 XP	 HSSE V3	100
	M	 3.113.620 M3 - M52	 DIN 376	 0°	ISO 2 (6H)	 FORM C 2-3 XP	 HSSE V3	101
 ≤2xd	M	 3.114.120 M2 - M10	 DIN 371	 15°	ISO 2 (6H)	 FORM C 2-3 XP	 HSSE V3	103

Steel						Cast		Copper			Aluminum and Zinc			Titanium	Nickel	
< 500 N/mm ²	< 800 N/mm ²	< 1'200 N/mm ²	< 1'300 N/mm ²	Stainless / Inox < 1'200 N/mm ²	HRC 50-63 Hardened steels	Cast Iron	Cast Iron long chipping	CU	Copper alloys 200-300 HB	Copper alloys short chipping	AL	ALSI < 10%	ALSI > 10% ADC / ZDC	Ti	Ni	Nickel alloys 900-1'500 N/mm ²

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●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

Hole type	Threading type	Catalog number Size range	DIN	Helix angle	Tolerance	Chamfer form	Material and coating	Taps reference page
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● FOR MILD AND LOW ALLOY STEELS < 800 N/mm²

	M	 3.114.220 M3 - M20			ISO 2 (6H)			104
	M	 3.114.620 M3 - M36			ISO 2 (6H)			105
	M	 3.114.920-LS M3 - M16			ISO 2 (6H)			106
	M	 3.115.120 M2 - M12			ISO 2 (6H)			107
	M LH	 3.115.120-LH M3 - M10			ISO 2 (6H)			108
	M	 3.115.220 M2 - M20			ISO 2 (6H)			109
	M	 3.115.620 M3 - M36			ISO 2 (6H)			110
	M LH	 3.115.620-LH M12 - M20			ISO 2 (6H)			111
	M	 3.115.920-LS M3 - M16			ISO 2 (6H)			112
	M	 3.115.952-SC M3 - M12			6HX			xxx
	M	 3.116.122 M3 - M10			ISO 2 (6H)			xxx
	M	 3.116.622 M3 - M36			ISO 2 (6H)			114

Steel						Cast		Copper			Aluminum and Zinc			Titanium	Nickel	
< 500 N/mm ²	< 800 N/mm ²	< 1'200 N/mm ²	< 1'300 N/mm ²	Stainless / Inox < 1'200 N/mm ²	HRC 50-63 Hardened steels	Cast Iron	Cast Iron long chipping	CU	Copper alloys 200-300 HB	Copper alloys short chipping	AL	ALSI < 10%	ALSI > 10% ADC / ZDC	Ti	Ni	Nickel alloys 900-1'500 N/mm ²

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●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

Hole type	Threading type	Catalog number Size range	DIN	Helix angle	Tolerance	Chamber form	Material and coating	Taps reference page
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● FOR MILD AND LOW ALLOY STEELS < 800 N/mm²

	M	 3.117.120-LSP M3 - M10	 DIN 371	 15° LSP	ISO 2 (6H)	 FORM D -3.5-5-XP	 HSSE V3	115
	M	 3.117.620-LSP M12 - M16	 DIN 376	 15° LSP	ISO 2 (6H)	 FORM D -3.5-5-XP	 HSSE V3	116
	M	 3.118.120 M3 - M10	 DIN 371	 40°	ISO 2 (6H)	 FORM E -1.5-2-XP	 HSSE V3	117
	M	 3.118.620 M12 - M16	 DIN 376	 40°	ISO 2 (6H)	 FORM E -1.5-2-XP	 HSSE V3	118
	M	 3.119.952-SC M3 - M12	 DIN 18358 ISO 3338	 17°	6HX	 FORM C -2-3-XP	 TiN HSSE V3	316
	M	 3.122.120 M2 - M10	 DIN 371	 B	ISO 3 (6G)	 FORM B -3.5-5-XP	 HSSE V3	120
	M	 3.122.620 M12 - M20	 DIN 376	 B	ISO 3 (6G)	 FORM B -3.5-5-XP	 HSSE V3	121
	M	 3.125.120 M3 - M12	 DIN 371	 40°	ISO 3 (6G)	 FORM C -2-3-XP	 HSSE V3	122
	M	 3.125.620 M12 - M20	 DIN 376	 40°	ISO 3 (6G)	 FORM C -2-3-XP	 HSSE V3	123
	M	 3.142.120 M3 - M10	 DIN 371	 B	7G	 FORM B -3.5-5-XP	 HSSE V3	124
	M	 3.142.620 M12 - M20	 DIN 376	 B	7G	 FORM B -3.5-5-XP	 HSSE V3	xxx
	M	 3.145.120 M3 - M10	 DIN 371	 40°	7G	 FORM C -2-3-XP	 HSSE V3	125

Steel						Cast		Copper			Aluminum and Zinc			Titanium	Nickel	
< 500 N/mm ²	< 800 N/mm ²	< 1'200 N/mm ²	< 1'300 N/mm ²	Stainless / Inox < 1'200 N/mm ²	HRC 50-63 Hardened steels	Cast Iron	Cast Iron long chipping	CU	Copper alloys 200-300 HB	Copper alloys short chipping	AL	ALSI < 10%	ALSI > 10% ADC / ZDC	Ti	Ni	Nickel alloys 900-1'500 N/mm ²

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CUTTING TAPS

Hole type	Threading type	Catalog number Size range	DIN	Helix angle	Tolerance	Chamfer form	Material and coating	Taps reference page
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● FOR MILD AND LOW ALLOY STEELS < 800 N/mm²

	M	 3.145.620 M12 - M20			7G			xxx
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● FOR HIGH ALLOY STEELS < 1'300 N/mm²

	M	 5.112.150 M2.5 - M10			ISO 2 (6H)			126
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	M	 5.112.153 M2.5 - M10			ISO 2 (6H)			127
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	M	 5.112.650 M12 - M30			ISO 2 (6H)			128
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	M	 5.112.653 M12 - M30			ISO 2 (6H)			129
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	M	 5.114.150 M2.5 - M10			ISO 2 (6H)			130
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	M	 5.114.153 M2.5 - M10			ISO 2 (6H)			131
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	M	 5.114.650 M12 - M30			ISO 2 (6H)			132
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	M	 5.114.653 M12 - M30			ISO 2 (6H)			133
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● FOR STAINLESS STEELS < 1'200 N/mm²

	M	 6.112.120-AT M2 - M10			ISO 2 (6H)			134
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Steel						Cast		Copper			Aluminum and Zinc			Titanium	Nickel	
< 500 N/mm ²	< 800 N/mm ²	< 1'200 N/mm ²	< 1'300 N/mm ²	Stainless / Inox < 1'200 N/mm ²	HRC 50-63 Hardened steels	Cast Iron	Cast Iron long chipping	CU	Copper alloys 200-300 HB	Copper alloys short chipping	AL	ALSi < 10%	ALSi > 10% ADC / ZDC	Ti	Ni	Nickel alloys 900-1'500 N/mm ²

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CUTTING TAPS

Hole type	Threading type	Catalog number Size range	DIN	Helix angle	Tolerance	Chamber form	Material and coating	Taps reference page
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● FOR STAINLESS STEELS < 1'200 N/mm²

	M	 6.112.121 M2 - M12			ISO 2 (6H)			135
	M	 6.112.122 M3 - M10			ISO 2 (6H)			136
	M	 6.112.123 M3 - M10			ISO 2 (6H)			137
	M	 6.112.153 M3 - M10			ISO 2 (6H)			138
	M	 6.112.620-AT M12 - M20			ISO 2 (6H)			139
	M	 6.112.621 M3 - M36			ISO 2 (6H)			140
	M	 6.112.622 M3 - M36			ISO 2 (6H)			141
	M	 6.112.623 M12 - M36			ISO 2 (6H)			142
	M	 6.112.653 M12 - M20			ISO 2 (6H)			143
	M	 6.113.121 M2 - M10			ISO 2 (6H)			144
	M	 6.113.621 M12 - M24			ISO 2 (6H)			145
	M	 6.114.121 M3 - M10			ISO 2 (6H)			146

Steel						Cast		Copper			Aluminum and Zinc			Titanium	Nickel	
< 500 N/mm ²	< 800 N/mm ²	< 1'200 N/mm ²	< 1'300 N/mm ²	Stainless / Inox < 1'200 N/mm ²	HRC 50-63 Hardened steels	Cast Iron	Cast Iron long chipping	CU	Copper alloys 200-300 HB	Copper alloys short chipping	AL	ALSI < 10%	ALSI > 10% ADC / ZDC	Ti	Ni	Nickel alloys 900-1'500 N/mm ²

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CUTTING TAPS

Hole type	Threading type	Catalog number Size range	DIN	Helix angle	Tolerance	Chamfer form	Material and coating	Taps reference page
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● FOR STAINLESS STEELS < 1'200 N/mm2

	M	 6.114.621 M12 - M36			ISO 2 (6H)			147
	M	 6.115.120-AT M3 - M10			ISO 2 (6H)			148
	M	 6.115.121 M2 - M12			ISO 2 (6H)			149
	M	 6.115.121-BT M3 - M10			ISO 2 (6H)			150
	M	 6.115.122 M3 - M10			ISO 2 (6H)			151
	M	 6.115.123 M3 - M10			ISO 2 (6H)			152
	M	 6.115.620-AT M12 - M20			ISO 2 (6H)			153
	M	 6.115.621 M3 - M36			ISO 2 (6H)			154
	M	 6.115.621-BT M12 - M20			ISO 2 (6H)			155
	M	 6.115.622 M3 - M36			ISO 2 (6H)			156
	M	 6.115.623 M12 - M36			ISO 2 (6H)			157
	M	 6.116.121 M3 - M10			ISO 2 (6H)			158

Steel						Cast		Copper			Aluminum and Zinc			Titanium	Nickel	
< 500 N/mm ²	< 800 N/mm ²	< 1'200 N/mm ²	< 1'300 N/mm ²	Stainless / Inox < 1'200 N/mm ²	HRC 50-63 Hardened steels	Cast Iron	Cast Iron long chipping	CU	Copper alloys 200-300 HB	Copper alloys short chipping	AL	ALSI < 10%	ALSI > 10% ADC / ZDC	Ti	Ni	Nickel alloys 900-1'500 N/mm ²

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CUTTING TAPS

Hole type	Threading type	Catalog number Size range	DIN	Helix angle	Tolerance	Chamber form	Material and coating	Taps reference page
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● FOR STAINLESS STEELS < 1'200 N/mm²

	M	 6.116.153 M3 - M10			ISO 2 (6H)			160
	M	 6.116.153-OH M6 - M10			ISO 2 (6H)			161
	M	 6.116.221 M2 - M6			ISO 2 (6H)			162
	M	 6.116.621 M12 - M20			ISO 2 (6H)			163
	M	 6.116.653 M12 - M30			ISO 2 (6H)			164
	M	 6.116.653-OH M12 - M30			ISO 2 (6H)			165
	M	 6.118.121 M2 - M10			ISO 2 (6H)			166
	M	 6.118.621 M12 - M16			ISO 2 (6H)			167
	M	 6.122.121 M2 - M10			ISO 2 (6H)			168
	M	 6.122.123 M2 - M10			ISO 3 (6G)			169
	M	 6.122.621 M12 - M20			ISO 3 (6G)			170
	M	 6.122.623 M12 - M20			ISO 3 (6G)			171

Steel						Cast		Copper			Aluminum and Zinc			Titanium	Nickel	
< 500 N/mm ²	< 800 N/mm ²	< 1'200 N/mm ²	< 1'300 N/mm ²	Stainless / Inox < 1'200 N/mm ²	HRC 50-63 Hardened steels	Cast Iron	Cast Iron long chipping	CU	Copper alloys 200-300 HB	Copper alloys short chipping	AL	ALSI < 10%	ALSI > 10% ADC / ZDC	Ti	Ni	Nickel alloys 900-1'500 N/mm ²

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CUTTING TAPS

Hole type	Threading type	Catalog number Size range	DIN	Helix angle	Tolerance	Chamfer form	Material and coating	Taps reference page
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● FOR STAINLESS STEELS < 1'200 N/mm²

	M	 6.125.121 M2 - M10			ISO 3 (6G)			172
	M	 6.125.123 M2 - M10			ISO 3 (6G)			173
	M	 6.125.621 M12 - M30			ISO 3 (6G)			174
	M	 6.125.623 M12 - M20			ISO 3 (6G)			175

● FOR TITANIUM AND NICKEL ALLOYS

	M	 7.112.150 M3 - M10			ISO 2 (6H)			176
	M	 7.112.151 M3 - M10			ISO 2 (6H)			177
	M	 7.112.650 M12			ISO 2 (6H)			178
	M	 7.112.651 M12 - M20			ISO 2 (6H)			179
	M	 7.114.150 M3 - M10			ISO 2 (6H)			180
	M	 7.114.151 M3 - M10			ISO 2 (6H)			181
	M	 7.114.650 M12			ISO 2 (6H)			182

Steel						Cast		Copper			Aluminum and Zinc			Titanium	Nickel	
< 500 N/mm ²	< 800 N/mm ²	< 1'200 N/mm ²	< 1'300 N/mm ²	Stainless / Inox < 1'200 N/mm ²	HRC 50-63 Hardened steels	Cast Iron	Cast Iron long chipping	CU	Copper alloys 200-300 HB	Copper alloys short chipping	AL	AL Si < 10%	AL Si > 10% ADC / ZDC	Ti	Ni	Nickel alloys 900-1'500 N/mm ²

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CUTTING TAPS

Hole type	Threading type	Catalog number Size range	DIN	Helix angle	Tolerance	Chamfer form	Material and coating	Taps reference page
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● FOR TITANIUM AND NICKEL ALLOYS

	M	 7.114.651 M12 - M22			ISO 2 (6H)			183
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● FOR GENERAL USE Cast Iron, Aluminium, Aluminium Die Cast, Steels and Stainless Steels < 1'200 N/mm2

	M	 9.112.153 M3 - M10			6HX			184
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	M	 9.112.155 M3 - M10			6HX			185
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	M	 9.112.155-OH M6 - M10			6HX			186
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	M	 9.112.653 M12 - M20			6HX			187
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	M	 9.112.655 M12 - M20			4HX			188
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	M	 9.112.655-OH M12 - M20			6HX			189
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	M	 9.116.153 M3 - M10			6HX			190
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	M	 9.116.155 M3 - M10			6HX			191
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	M	 9.116.155-OH M6 - M10			6HX			192
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	M	 9.116.159 M3 - M10			ISO 2 (6H)			193
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Steel						Cast		Copper			Aluminum and Zinc			Titanium	Nickel	
< 500 N/mm ²	< 800 N/mm ²	< 1'200 N/mm ²	< 1'300 N/mm ²	Stainless / Inox < 1'200 N/mm ²	HRC 50-63 Hardened steels	Cast Iron	Cast Iron long chipping	CU	Copper alloys 200-300 HB	Copper alloys short chipping	AL	ALSi < 10%	ALSi > 10% ADC / ZDC	Ti	Ni	Nickel alloys 900-1'500 N/mm ²

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CUTTING TAPS

Hole type	Threading type	Catalog number Size range	DIN	Helix angle	Tolerance	Chamfer form	Material and coating	Taps reference page
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● **FOR GENERAL USE** Cast Iron, Aluminium, Aluminium Die Cast, Steels and Stainless Steels < 1'200 N/mm2

	M	 9.116.653 M12 - M20			6HX			194
	M	 9.116.655 M12 - M20			6HX			xxx
	M	 9.116.655-OH M12 - M20			6HX			196
	M	 9.116.659 M12 - M20			ISO 2 (6H)			197

● **FOR TEMPERED STEELS** < 62 HRC

	M	 9.113.983 M3 - M20			6HX			198
	M	 9.117.983 M3 - M20			6HX			199

● **FOR CAST IRON AND ADC** Short chipping materials such as GG or Aluminum Die Cast

	MF	 0.213.423 M8 - M16			6HX			200
	MF	 0.213.929-ZC M8 - M12			6HX			202
	MF	 0.223.929-ZC M8 - M12			6GX			203

Steel						Cast		Copper			Aluminum and Zinc			Titanium	Nickel	
< 500 N/mm ²	< 800 N/mm ²	< 1'200 N/mm ²	< 1'300 N/mm ²	Stainless / Inox < 1'200 N/mm ²	HRC 50-63 Hardened steels	Cast Iron	Cast Iron long chipping	CU	Copper alloys 200-300 HB	Copper alloys short chipping	AL	AL Si < 10%	AL Si > 10% ADC / ZDC	Ti	Ni	Nickel alloys 900-1'500 N/mm ²

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CUTTING TAPS

Hole type	Threading type	Catalog number Size range	DIN	Helix angle	Tolerance	Chamfer form	Material and coating	Taps reference page
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● FOR MILD AND LOW ALLOY STEELS < 800 N/mm²

	MF	 3.212.420 M3 - M52			ISO 2 (6H)			204
	MF	 3.212.422 M6 - M16			ISO 2 (6H)			206
	MF	 3.213.420 M3 - M52			ISO 2 (6H)			207
	MF	 3.214.420 M4 - M30			ISO 2 (6H)			209
	MF	 3.215.420 M3 - M30			ISO 2 (6H)			211
	MF	 3.216.422 M6 - M16			ISO 2 (6H)			213
	MF	 3.222.420 M6 - M20			ISO 3 (6G)			214
	MF	 3.225.420 M6 - M20			ISO 3 (6G)			215

● FOR STAINLESS STEELS < 1'200 N/mm²

	MF	 6.212.421 M3 - M24			ISO 2 (6H)			216
	MF	 6.212.423 M8 - M20			ISO 2 (6H)			217
	MF	 6.215.421 M3 - M30			ISO 2 (6H)			218

Steel						Cast		Copper			Aluminum and Zinc			Titanium	Nickel	
< 500 N/mm ²	< 800 N/mm ²	< 1'200 N/mm ²	< 1'300 N/mm ²	Stainless / Inox < 1'200 N/mm ²	HRC 50-63 Hardened steels	Cast Iron	Cast Iron long chipping	CU	Copper alloys 200-300 HB	Copper alloys short chipping	AL	ALSI < 10%	ALSI > 10% ADC / ZDC	Ti	Ni	Nickel alloys 900-1'500 N/mm ²

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●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

Hole type	Threading type	Catalog number Size range	DIN	Helix angle	Tolerance	Chamfer form	Material and coating	Taps reference page
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● FOR STAINLESS STEELS < 1'200 N/mm²

	MF	 6.215.423 M8 - M20			ISO 2 (6H)		TiCN HSSE V3	219
	MF	 6.222.421 M6 - M20			ISO 3 (6G)		OX HSSE V3	220
	MF	 6.222.423 M8 - M20			ISO 3 (6G)		TiCN HSSE V3	221
	MF	 6.225.421 M6 - M20			ISO 3 (6G)		OX HSSE V3	222
	MF	 6.225.423 M8 - M20			ISO 3 (6G)		TiCN HSSE V3	223

● FOR GENERAL USE Cast Iron, Aluminium, Aluminium Die Cast, Steels and Stainless Steels < 1'200 N/mm²

	MF	 9.212.455 M8 - M20			6HX		HARD LUBE PM 38	224
	MF	 9.216.455 M8 - M20			6HX		HARD LUBE PM 38	225

● FOR TEMPERED STEELS < 62 HRC

	MF	 9.213.983 M8 - M20	TANOI		6HX		TiCN CARBIDE	226
	MF	 9.217.983 M8 - M20	TANOI		6HX		TiCN CARBIDE	227

Steel						Cast		Copper			Aluminum and Zinc			Titanium	Nickel	
< 500 N/mm ²	< 800 N/mm ²	< 1'200 N/mm ²	< 1'300 N/mm ²	Stainless / Inox < 1'200 N/mm ²	HRC 50-63 Hardened steels	Cast Iron	Cast Iron long chipping	CU	Copper alloys 200-300 HB	Copper alloys short chipping	AL	AL Si < 10%	AL Si > 10% ADC / ZDC	Ti	Ni	Nickel alloys 900-1'500 N/mm ²

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●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

Hole type	Threading type	Catalog number Size range	DIN	Helix angle	Tolerance	Chamfer form	Material and coating	Taps reference page
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● FOR MILD AND LOW ALLOY STEELS < 800 N/mm²

	UNC	 3.392.120 No.1 - 3/8	 DIN 2182	 B	2B B1.1	 FORM B -3.5-5-XP	 HSSE V3	228
	UNC	 3.392.620 7/16 - 1	 DIN 2183	 B	2B B1.1	 FORM B -3.5-5-XP	 HSSE V3	229
	UNC	 3.395.120 No.2 - 3/8	 DIN 2182	 40°	2B B1.1	 FORM C -2-3-XP	 HSSE V3	230
	UNC	 3.395.620 7/16 - 1	 DIN 2183	 40°	2B B1.1	 FORM C -2-3-XP	 HSSE V3	231

● FOR STAINLESS STEELS < 1'200 N/mm²

	UNC	 6.392.121 No.4 - 3/8	 DIN 2182	 B	2B B1.1	 FORM B -3.5-5-XP	 OX HSSE V3	232
	UNC	 6.392.621 1/2 - 1	 DIN 2183	 B	2B B1.1	 FORM B -3.5-5-XP	 OX HSSE V3	233
	UNC	 6.395.121 No.6 - 3/8	 DIN 2182	 40°	2B B1.1	 FORM C -2-3-XP	 OX HSSE V3	234
	UNC	 6.395.621 1/2 - 1	 DIN 2182	 40°	2B B1.1	 FORM C -2-3-XP	 OX HSSE V3	235

● FOR MILD AND LOW ALLOY STEELS < 800 N/mm²

	UNF	 3.492.620 No.0 - 1 1/2	 DIN 2183	 B	2B B1.1	 FORM B -3.5-5-XP	 HSSE V3	236
	UNF	 3.495.620 No.3 - 1	 DIN 2183	 40°	2B B1.1	 FORM C -2-3-XP	 HSSE V3	238

Steel						Cast		Copper			Aluminum and Zinc			Titanium	Nickel	
< 500 N/mm ²	< 800 N/mm ²	< 1'200 N/mm ²	< 1'300 N/mm ²	Stainless / Inox < 1'200 N/mm ²	HRC 50-63 Hardened steels	Cast Iron	Cast Iron long chipping	CU	Copper alloys 200-300 HB	Copper alloys short chipping	AL	ALSI < 10%	ALSI > 10% ADC / ZDC	Ti	Ni	Nickel alloys 900-1'500 N/mm ²

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●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

Hole type	Threading type	Catalog number Size range	DIN	Helix angle	Tolerance	Chamfer form	Material and coating	Taps reference page
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● FOR STAINLESS STEELS < 1'200 N/mm²

	UNF	 6.492.621 No.6 - 1	 DIN 2183	 B	2B B1.1	 FORM B -3.5-5-XP	 OX HSSE V3	239
	UNF	 6.495.621 No.6 - 1	 DIN 2183	 40°	2B B1.1	 FORM C -2-3-XP	 OX HSSE V3	240

● FOR MILD AND LOW ALLOY STEELS < 800 N/mm²

	NPT	 3.793.920 1/6 - 1	 DIN 40432	 0°	ANSI B1.1	 FORM C -2-3-XP	 HSSE V3	241
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● FOR MILD AND LOW ALLOY STEELS < 800 N/mm²

	G	 3.692.520 1/8 - 1 1/2	 DIN 5156	 B	ISO 228	 FORM B -3.5-5-XP	 HSSE V3	242
	G	 3.693.520 1/8 - 2	 DIN 5156	 0°	ISO 228	 FORM C -2-3-XP	 HSSE V3	243
	G	 3.694.520 1/8 - 1	 DIN 5156	 15°	ISO 228	 FORM C -2-3-XP	 HSSE V3	244
	G	 3.695.520 1/8 - 1 1/2	 DIN 5156	 40°	ISO 228	 FORM C -2-3-XP	 HSSE V3	245

● FOR STAINLESS STEELS < 1'200 N/mm²

	G	 6.692.521 1/8 - 1	 DIN 5156	 B	ISO 228	 FORM B -3.5-5-XP	 OX HSSE V3	246
	G	 6.695.521 1/8 - 1 1/2	 DIN 5156	 40°	ISO 228	 FORM C -2-3-XP	 OX HSSE V3	247

Steel						Cast		Copper			Aluminum and Zinc			Titanium	Nickel	
< 500 N/mm ²	< 800 N/mm ²	< 1'200 N/mm ²	< 1'300 N/mm ²	Stainless / Inox < 1'200 N/mm ²	HRC 50-63 Hardened steels	Cast Iron	Cast Iron long chipping	CU	Copper alloys 200-300 HB	Copper alloys short chipping	AL	AL Si < 10%	AL Si > 10% ADC / ZDC	Ti	Ni	Nickel alloys 900-1'500 N/mm ²

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●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

Hole type	Threading type	Catalog number Size range	DIN	Helix angle	Tolerance	Chamfer form	Material and coating	Taps reference page
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● FOR TEMPERED STEELS < 62 HRC

	G	 9.613.983 1/8 - 1/4			ISO 228			248
	G	 9.617.983 1/8 - 1/4			ISO 228			249

● FOR MILD AND LOW ALLOY STEELS < 800 N/mm²

	PG	 3.893.920 21 - 16						250
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Steel						Cast		Copper			Aluminum and Zinc			Titanium	Nickel	
< 500 N/mm ²	< 800 N/mm ²	< 1'200 N/mm ²	< 1'300 N/mm ²	Stainless / Inox < 1'200 N/mm ²	HRC 50-63 Hardened steels	Cast Iron	Cast Iron long chipping	CU	Copper alloys 200-300 HB	Copper alloys short chipping	AL	AL Si < 10%	AL Si > 10% ADC / ZDC	Ti	Ni	Nickel alloys 900-1'500 N/mm ²

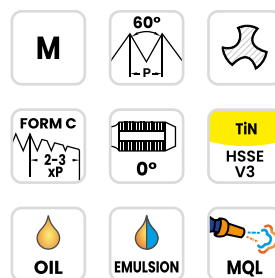
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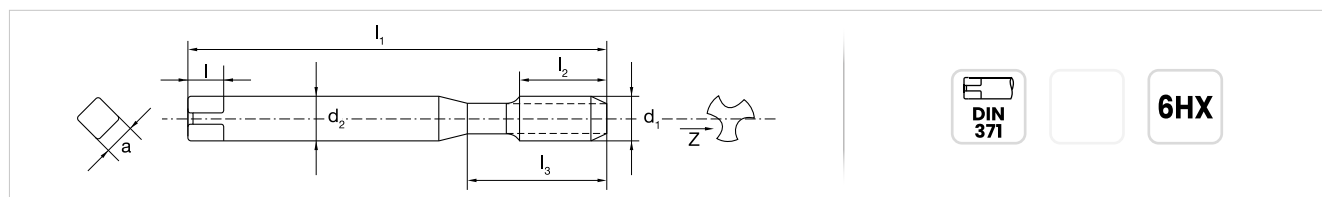
● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Cast Iron and ADC For short chipping material such as GG or ADC



● Technical details



d_1	P	l_1	l_2	l_3	d_2	l	α	Z	$\varnothing$ mm	Order code
M4	0.7	63	13	21	4.5	6	3.4	3	3.30	220.075
M8	1.25	90	22	35	8	9	6.2	4	6.80	220.100

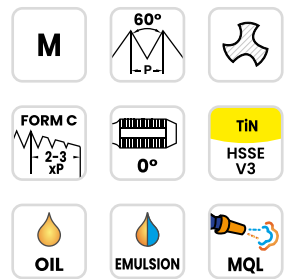
● Cutting parameters

V_c m/min	GG/6 CAST	CU SHORT	ZDC ADC	ALU Si <10%
	● ● ● 10 - 32	● ● 3 - 24	● ● ● 10 - 32	● ● 10 - 32
	● ● ● 13 - 32	● ● 4 - 24	● ● ● 13 - 32	● ● 13 - 32
	● ● ● 10 - 30	● ● 5 - 20	● ● ● 10 - 30	● ● 10 - 30

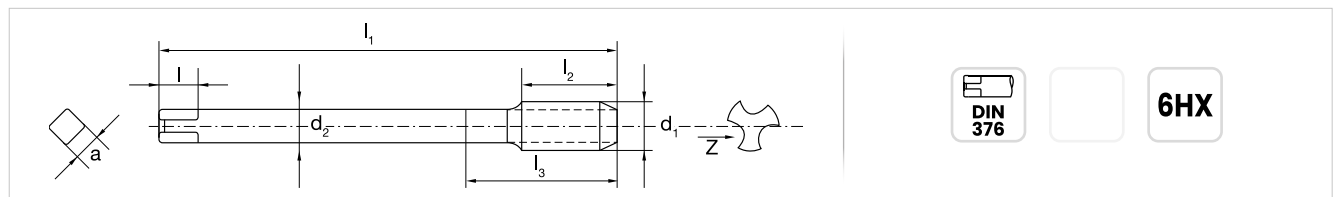
● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Cast Iron and ADC For short chipping material such as GG or ADC



● Technical details

DIN
376

6HX

d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	Z	Ø mm	Order code
M5	0.8	70	16	28	3.5	6	2.7	3	4.20	420.025
M6	1	80	19	32	4.5	6	3.4	3	5.00	420.030
M8	1.25	90	22	36	6	8	4.9	4	6.80	420.040
M12	1.75	110	28	44	9	10	7	4	8.50	420.060
M14	2	110	30	44	11	12	9	4	10.20	420.065
M16	2	110	32	44	12	12	9	4	12.00	420.070

● Cutting parameters

V _c m/min	GG/CAST	CU SHORT	ZDC ADC	ALU Si <10%
	●●●● 10 - 32	●● 3 - 24	●●●● 10 - 32	●● 10 - 32
	●●●● 13 - 32	●● 4 - 24	●●●● 13 - 32	●● 13 - 32
	●●●● 10 - 30	●● 5 - 20	●●●● 10 - 30	●● 10 - 30

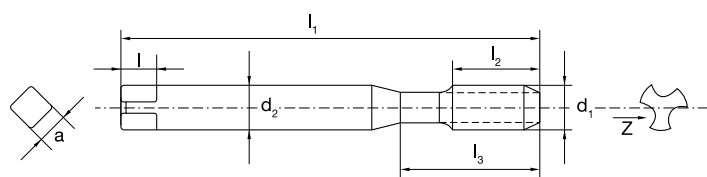
●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Cast Iron and ADC For short chipping material such as GG or ADC



● Technical details



6HX

d_1	P	l_1	l_2	l_3	d_2	l	α	Z	$\varnothing$ mm	Order code
M4	0.7	63	13	21	4.5	6	3.4	3	3.30	225.075
M5	0.8	70	16	25	6	8	4.9	3	4.20	225.085
M6	1	80	19	30	6	8	4.9	3	5.00	225.090
M8	1.25	90	22	35	8	9	6.2	4	6.80	225.100
M10	1.5	100	24	39	10	11	8	4	8.50	225.110

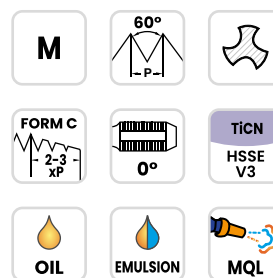
● Cutting parameters

V_c m/min	GG/G CAST	CU SHORT	ZDC ADC	ALU Si ≤10%
	● ● ● 10 - 32	● ● 3 - 24	● ● ● 10 - 32	● ● 10 - 32
	● ● ● 13 - 32	● ● 4 - 24	● ● ● 13 - 32	● ● 13 - 32
	● ● ● 10 - 30	● ● 5 - 20	● ● ● 10 - 30	● ● 10 - 30

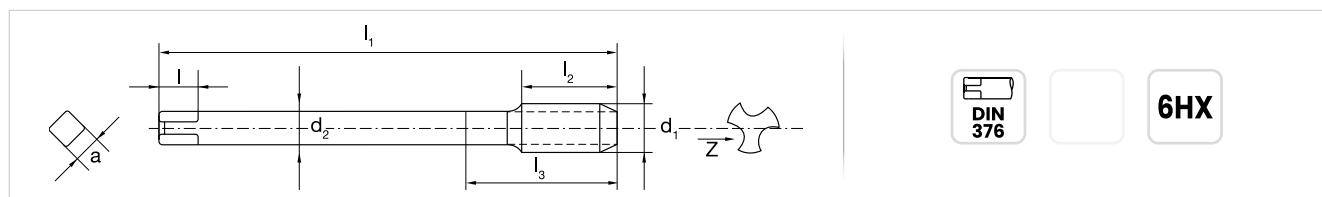
● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Cast Iron and ADC For short chipping material such as GG or ADC



● Technical details

DIN
376

6HX

d_1	P	l_1	l_2	l_3	d_2	l	α	Z	$\emptyset$ mm	Order code
M5	0.8	70	16	28	3.5	6	2.7	3	4.20	425.025
M6	1	80	19	32	4.5	6	3.4	3	5.00	425.030
M8	1.25	90	22	36	6	8	4.9	4	6.80	425.040
M10	1.5	100	24	40	7	8	5.5	4	8.50	425.050
M12	1.75	110	28	44	9	10	7	4	10.20	425.060
M14	2	110	30	44	11	12	9	4	12.00	425.065
M16	2	110	32	44	12	12	9	4	14.00	425.070

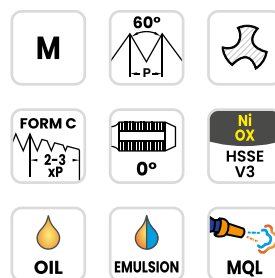
● Cutting parameters

V_c m/min	GG/Fe CAST	CU SHORT	ZDC ADC	ALU Si <10%
	●●●● 10 - 32	●● 3 - 24	●●●● 10 - 32	●● 10 - 32
	●●●● 13 - 32	●● 4 - 24	●●●● 13 - 32	●● 13 - 32
	●●●● 10 - 30	●● 5 - 20	●●●● 10 - 30	●● 10 - 30

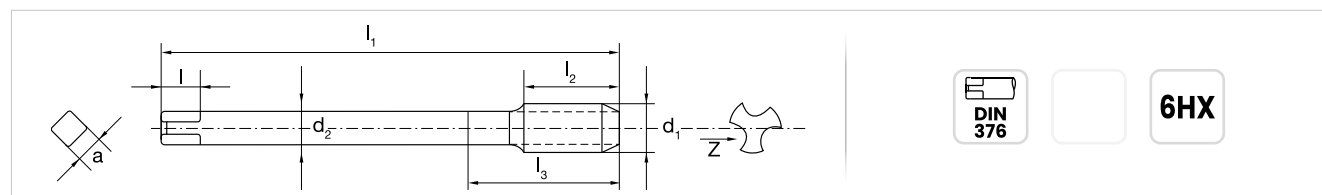
●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Cast Iron and ADC For short chipping material such as GG or ADC



● Technical details



DIN 376

6HX

d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	Z	Ø mm	Order code
M4	0.7	63	13	25.2	2.8	5	2.1	3	3.30	415.015
M5	0.8	70	16	28	3.5	6	2.7	3	4.20	415.025
M6	1	80	19	32	4.5	6	3.4	3	5.00	415.030
M8	1.25	90	22	36	6	8	4.9	4	6.80	415.040
M10	1.5	100	24	40	7	8	5.5	4	8.50	415.050
M12	1.75	110	28	44	9	10	7	4	10.20	415.060
M14	2	110	30	44	11	12	9	4	12.00	415.065
M16	2	110	32	44	12	12	9	4	14.00	415.070
M18	2.5	125	34	50	14	14	11	4	15.50	415.075
M20	2.5	140	34	56	16	15	12	4	17.50	415.080
M22	2.5	140	34	56	18	17	14.5	4	19.50	415.085
M24	3	160	38	64	18	17	14.5	4	21.00	415.090
M27	3	160	38	64	20	19	16	4	24.00	415.095
M30	3.5	180	45	72	22	21	18	4	26.50	415.100

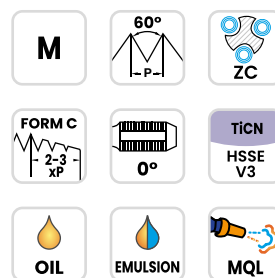
● Cutting parameters

V _c m/min	GG/G CAST	CU SHORT	ZDC ADC	ALU Si ≤10%
	● ● ● 10 - 32	● ● 3 - 24	● ● ● 10 - 32	● ● 10 - 32
	● ● ● 13 - 32	● ● 4 - 24	● ● ● 13 - 32	● ● 13 - 32
	● ● ● 10 - 30	● ● 5 - 20	● ● ● 10 - 30	● ● 10 - 30

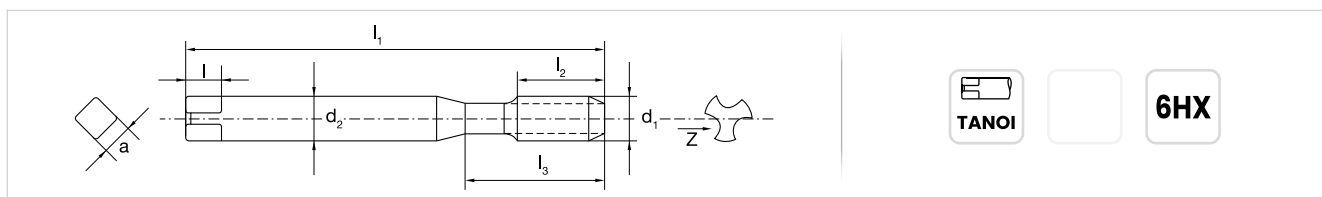
● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Cast Iron and ADC For short chipping material such as GG or ADC



Technical details


6HX

d_1	P	l_1	l_2	l_3	d_2	l	α	Z	$\varnothing$ mm	Order code
M3	0.5	100	11	18	4	6	3.2	3	2.50	980.005
M4	0.7	100	13	20	5	7	4	3	3.30	980.015
M5	0.8	100	16	25	5.5	7	4.5	3	4.20	980.025
M6	1	100	19	30	6	7	4.5	3	5.00	980.030
M8	1.25	100	22	40	8	9	3	3	6.80	980.040
M10	1.5	100	24	39	8	9	4	4	8.50	980.050
M12	1.75	100	29	43	10	11	4	4	10.20	980.060

Cutting parameters

V_c m/min	GG/6 CAST	CU SHORT	ZDC ADC	ALU Si <10%
	● ● ● 10 - 32	● ● 3 - 24	● ● ● 3 - 24	● ● ● 10 - 32

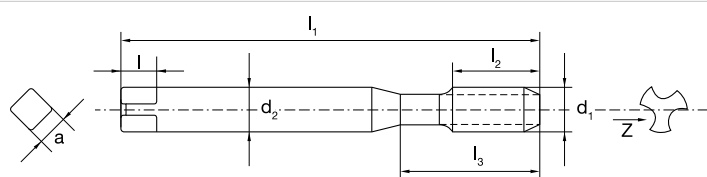
● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Cast Iron and ADC For short chipping material such as GG or ADC



● Technical details



6GX

d_1	P	l_1	l_2	l_3	d_2	l	α	Z	ϕ mm	Order code
M3	0.5	100	11	18	4	6	3.2	3	2.50	981.005
M4	0.7	100	13	20	5	7	4	3	3.30	981.015
M5	0.8	100	16	25	5.5	7	4.5	3	4.20	981.025
M6	1	100	19	30	6	7	4.5	3	5.00	981.030
M8	1.25	100	22	40	8	9	3	3	6.80	981.040
M10	1.5	100	24	39	8	9	4	4	8.50	981.050
M12	1.75	100	29	43	10	11	4	4	10.20	981.060

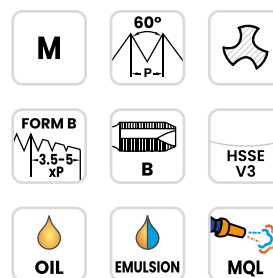
● Cutting parameters

V_c m/min	GG/G CAST	CU SHORT	ZDC ADC	ALU Si ≤10%
	● ● ● 13 - 36	● ● 4 - 27	● ● ● 3 - 24	● ● ● 10 - 32

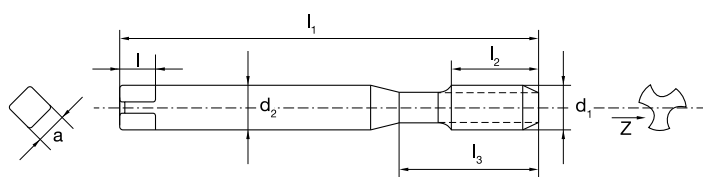
● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Aluminium



Technical details



d_1	P	l_1	l_2	l_3	d_2	l	α	Z	$\varnothing$ mm	Order code
M3	0.5	56	11	18	3.5	6	2.7	3	2.50	205.065
M4	0.7	63	13	21	4.5	6	3.4	3	3.30	205.075
M5	0.8	70	16	25	6	8	4.9	3	4.20	205.085
M6	1	80	19	30	6	8	4.9	3	5.00	205.090
M8	1.25	90	22	35	8	9	6.2	3	6.80	205.100
M10	1.5	100	24	39	10	11	8	3	8.50	205.110

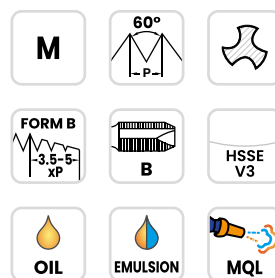
Cutting parameters

V_c m/min	STEEL 500-800 N/mm ²	CU 200-300 HB	CU	ALU Si >10%	ALU Si <10%	ALU	STEEL ≤500 N/mm ²
	○ 10 - 20	●●● 5 - 30	●●● 5 - 30	●●● 10 - 60	●● 10 - 60	●●● 15 - 60	●● 10 - 20

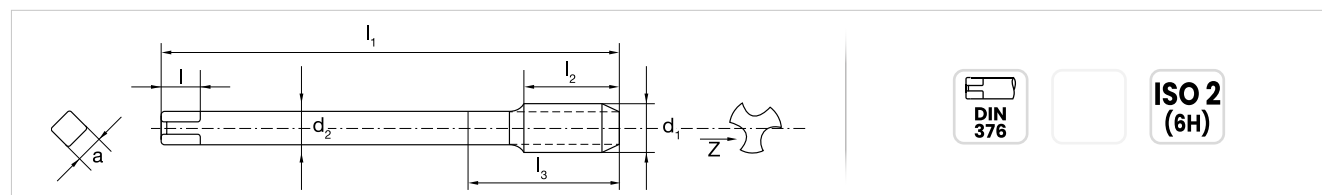
●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Aluminium



● Technical details



d_1	P	l_1	l_2	l_3	d_2	l	α	Z	$\varnothing$ mm	Order code
M12	1.75	110	28	44	9	10	7	3	10.20	405.060
M16	2	110	32	44	12	12	9	3	14.00	405.070
M20	2.5	140	34	56	16	15	12	3	17.50	405.080

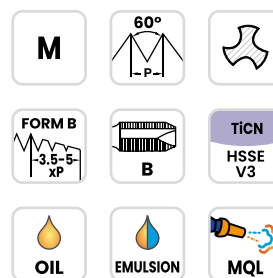
● Cutting parameters

V_c m/min	STEEL 500-800 N/mm ²	CU 200-300 HB	CU	ALU Si >10%	ALU Si <10%	ALU	STEEL ≤500 N/mm ²
	○ 10 - 20	● ● ● 5 - 30	● ● ● 5 - 30	● ● ● 10 - 60	● ● 10 - 60	● ● ● 15 - 60	● ● 10 - 20

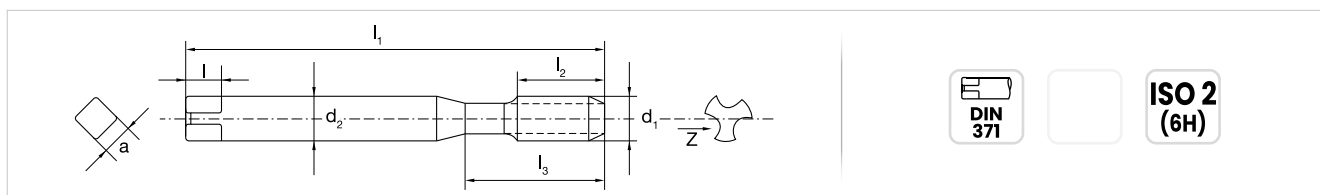
● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Aluminium



● Technical details



d_1	P	l_1	l_2	l_3	d_2	l	α	Z	$\varnothing$ mm	Order code
M3	0.5	56	11	18	3.5	6	2.7	3	2.50	206.065
M4	0.7	63	13	21	4.5	6	3.4	3	3.30	206.075
M5	0.8	70	16	25	6	8	4.9	3	4.20	206.085
M6	1	80	19	30	6	8	4.9	3	5.00	206.090
M8	1.25	90	22	35	8	9	6.2	3	6.80	206.100
M10	1.5	100	24	39	10	11	8	3	8.50	206.110

● Cutting parameters

V_c m/min	STEEL 500-800 N/mm ²	CU 200-300 HB	CU	ALU Si >10%	ALU Si <10%	ALU	STEEL ≤500 N/mm ²
	○ 10 - 20	●●● 5 - 30	●●● 5 - 30	●●● 10 - 60	●● 10 - 60	●●● 15 - 60	●● 10 - 20

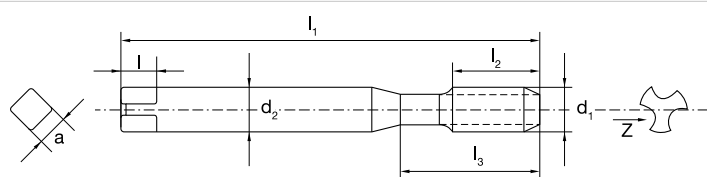
●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Aluminium



● Technical details



d_1	P	l_1	l_2	l_3	d_2	l	α	Z	ϕ mm	Order code
M2	0.4	45	8	10	2.8	5	2.1	2	1.60	210.040
M2.5	0.45	50	9	12.5	2.8	5	2.1	2	2.05	210.055
M3	0.5	56	5	18	3.5	6	2.7	3	2.50	210.065
M3.5	0.6	56	6	20	4	6	3	3	2.90	210.070
M4	0.7	63	7	21	4.5	6	3.4	3	3.30	210.075
M5	0.8	70	8	25	6	8	4.9	3	4.20	210.085
M6	1	80	10	30	6	8	4.9	3	5.00	210.090
M8	1.25	90	13	35	8	9	6.2	3	6.80	210.100
M10	1.5	100	15	39	10	11	8	3	8.50	210.110

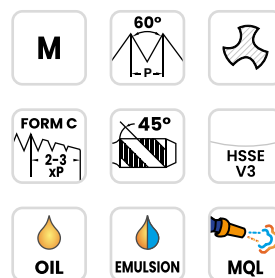
● Cutting parameters

V_c m/min	STEEL 500-800 N/mm ²	CU 200-300 HB	CU	ALU Si >10%	ALU Si <10%	ALU	STEEL ≤500 N/mm ²
	○ 9 - 18	● ● ● 4 - 27	● ● ● 4 - 27	● ● ● 9 - 54	● ● 9 - 54	● ● ● 13 - 54	● ● 9 - 18
	○ 10 - 18	● ● ● 5 - 27	● ● ● 5 - 27	● ● ● 10 - 36	● ● 10 - 36	● ● ● 15 - 54	● ● 10 - 18
	○ 8 - 15	● ● ● 5 - 20	● ● ● 5 - 20	● ● ● 5 - 30	● ● 5 - 30	● ● ● 10 - 45	● ● 8 - 15

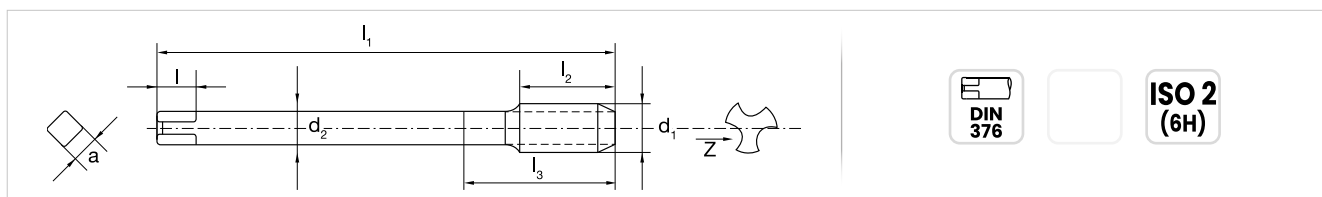
● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Aluminium



Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	Z	Ø mm	Order code
M12	1.75	110	18	44	9	10	7	3	10.20	410.060
M16	2	110	20	44	12	12	9	3	14.00	410.070
M20	2.5	140	25	56	16	15	12	4	17.50	410.080

Cutting parameters

V _c m/min	STEEL 500-800 N/mm ²	CU 200-300 HB	CU	ALU Si >10%	ALU Si <10%	ALU	STEEL ≤500 N/mm ²
	○ 9 - 18	● ● ● ● 4 - 27	● ● ● ● 4 - 27	● ● ● ● 9 - 54	● ● ● ● 9 - 54	● ● ● ● 13 - 54	● ● ● ● 9 - 18
	○ 10 - 18	● ● ● ● 5 - 27	● ● ● ● 5 - 27	● ● ● ● 10 - 36	● ● ● ● 10 - 36	● ● ● ● 15 - 54	● ● ● ● 10 - 18
	○ 8 - 15	● ● ● ● 5 - 20	● ● ● ● 5 - 20	● ● ● ● 5 - 30	● ● ● ● 5 - 30	● ● ● ● 10 - 45	● ● ● ● 8 - 15

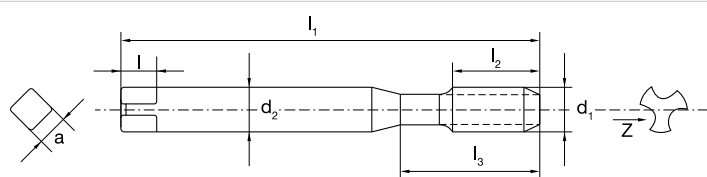
● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Aluminium



● Technical details



d_1	P	l_1	l_2	l_3	d_2	l	α	Z	ϕ mm	Order code
M2	0.4	45	8	10	2.8	5	2.1	2	1.60	211.040
M2.5	0.45	50	9	12.5	2.8	5	2.1	2	2.05	211.055
M3	0.5	56	5	18	3.5	6	2.7	3	2.50	211.065
M3.5	0.6	56	6	20	4	6	3	3	2.90	211.070
M4	0.7	63	7	21	4.5	6	3.4	3	3.30	211.075
M5	0.8	70	8	25	6	8	4.9	3	4.20	211.085
M6	1	80	10	30	6	8	4.9	3	5.00	211.090
M8	1.25	90	13	35	8	9	6.2	3	6.80	211.100
M10	1.5	100	15	39	10	11	8	3	8.50	211.110

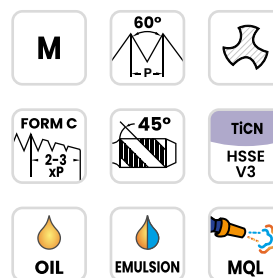
● Cutting parameters

V_c m/min	STEEL 500-800 N/mm ²	CU 200-300 HB	CU	ALU Si >10%	ALU Si <10%	ALU	STEEL ≤500 N/mm ²
	○ 9 - 18	● ● ● 4 - 27	● ● ● 4 - 27	● ● ● 9 - 54	● ● 9 - 54	● ● ● 13 - 54	● ● 9 - 18
	○ 10 - 18	● ● ● 5 - 27	● ● ● 5 - 27	● ● ● 10 - 36	● ● 10 - 36	● ● ● 15 - 54	● ● 10 - 18
	○ 8 - 15	● ● ● 5 - 20	● ● ● 5 - 20	● ● ● 5 - 30	● ● 5 - 30	● ● ● 10 - 45	● ● 8 - 15

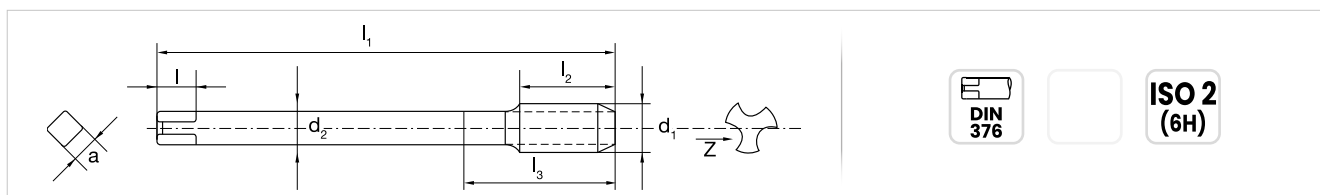
● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Aluminium



Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	Z	Ø mm	Order code
M12	1.75	110	18	44	9	10	7	3	10.20	411.060
M16	2	110	20	44	12	12	9	3	14.00	411.070
M20	2.5	140	25	56	16	15	12	4	17.50	411.080

Cutting parameters

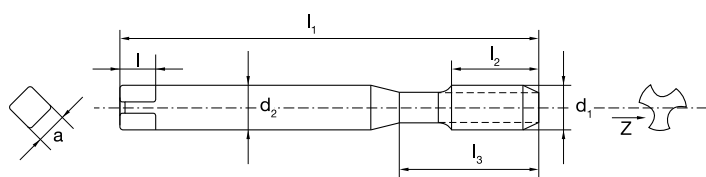
V _c m/min	STEEL 500-800 N/mm ²	CU 200-300 HB	CU 200-300 HB	ALU Si >10%	ALU Si <10%	ALU Si <10%	STEEL ≤500 N/mm ²
	○ 9 - 18	● ● ● ● 4 - 27	● ● ● ● 4 - 27	● ● ● ● 9 - 54	● ● ● ● 9 - 54	● ● ● ● 13 - 54	● ● ● ● 9 - 18
	○ 10 - 18	● ● ● ● 5 - 27	● ● ● ● 5 - 27	● ● ● ● 10 - 36	● ● ● ● 10 - 36	● ● ● ● 15 - 54	● ● ● ● 10 - 18
	○ 8 - 15	● ● ● ● 5 - 20	● ● ● ● 5 - 20	● ● ● ● 5 - 30	● ● ● ● 5 - 30	● ● ● ● 10 - 45	● ● ● ● 8 - 15

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Mild Steels < 500 N/mm²

● Technical details

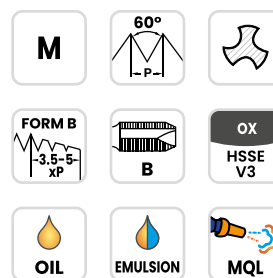
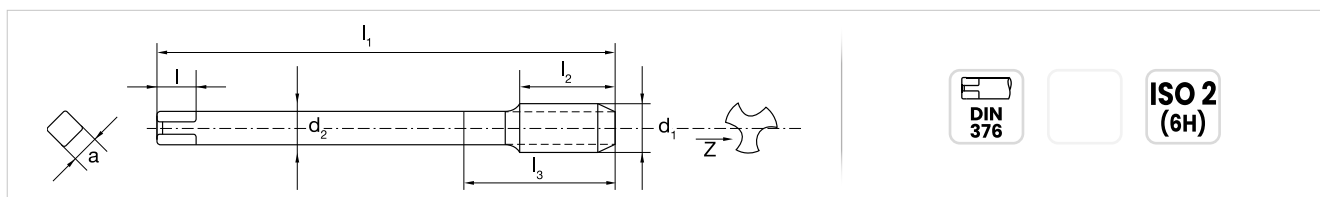


d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M3	0.5	56	11	18	3.5	6	2.7	3	2.50	040.065
M4	0.7	63	13	21	4.5	6	3.4	3	3.30	040.075
M5	0.8	70	16	25	6	8	4.9	3	4.20	040.085
M6	1	80	19	30	6	8	4.9	3	5.00	040.090
M8	1.25	90	22	35	8	9	6.2	3	6.80	040.100
M10	1.5	100	24	39	10	11	8	3	8.50	040.110

● Cutting parameters

V _c m/min	STEEL 500-800 N/mm ²	GG/G LONG CHIP	CU 200-300 HB	CU SHORT	CU	ALU	STEEL ≤500 N/mm ²
	● ● ● 15 - 30	● ● 15 - 30	○ 5 - 30	○ 5 - 30	○ 5 - 30	○ 15 - 40	● ● ● 15 - 30

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS
For Mild Steels < 500 N/mm²

Technical details


d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M12	1.75	110	28	44	9	10	7	3	10.20	240.060
M14	2	110	30	44	11	12	9	3	12.00	240.065
M16	2	110	32	44	12	12	9	3	14.00	240.070
M18	2.5	125	34	50	14	14	11	3	15.50	240.075
M20	2.5	140	34	56	16	15	12	3	17.50	240.080
M22	2.5	140	34	56	18	17	14.5	3	19.50	240.085
M24	3	160	38	64	18	17	14.5	3	21.00	240.090
M27	3	160	38	64	20	19	16	4	24.00	240.095
M30	3.5	180	45	72	22	21	18	4	26.50	240.100
M33	3.5	180	50	72	25	23	20	4	29.50	240.105
M36	4	200	56	80	28	25	22	4	32.00	240.110

Cutting parameters

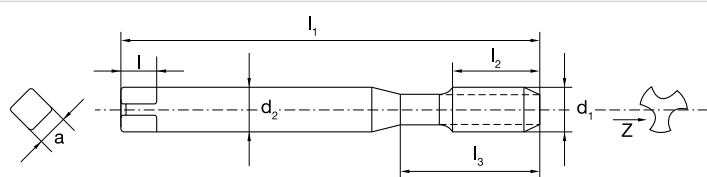
V _c m/min	STEEL 500-800 N/mm ²	GG/G LONG CHIP	CU 200-300 HB	CU SHORT	CU	ALU	STEEL ≤500 N/mm ²
	●●● 15 - 30	●● 15 - 30	○ 5 - 30	○ 5 - 30	○ 5 - 30	○ 15 - 40	●●● 15 - 30

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Mild Steels < 500 N/mm²

● Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M3	0.5	56	5	18	3.5	6	2.7	3	2.50	090.065
M3.5	0.6	56	6	20	4	6	3	3	2.90	090.070
M4	0.7	63	7	21	4.5	6	3.4	3	3.30	090.075
M5	0.8	70	8	25	6	8	4.9	3	4.20	090.085
M6	1	80	10	30	6	8	4.9	3	5.00	090.090
M8	1.25	90	13	35	8	9	6.2	3	6.80	090.100
M10	1.5	100	15	39	10	11	8	3	8.50	090.110

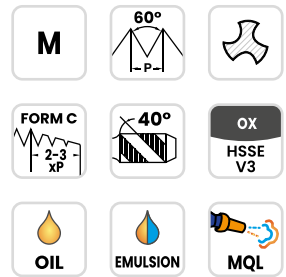
● Cutting parameters

V _c m/min	STEEL 500-800 N/mm ²	GG/G LONG CHIP	CU 200-300 HB	CU SHORT	CU	ALU	STEEL ≤500 N/mm ²
	● ● 13 - 27	● ● 4 - 27	○ 4 - 27	○ 4 - 27	○ 4 - 27	○ 13 - 36	● ● ● 13 - 27
	● ● 9 - 18	● ● 4 - 27	○ 4 - 27	○ 4 - 27	○ 4 - 27	○ 13 - 36	● ● ● 9 - 18
	● ● 10 - 15	● ● 5 - 20	○ 5 - 20	○ 5 - 20	○ 5 - 20	○ 10 - 25	● ● ● 10 - 15

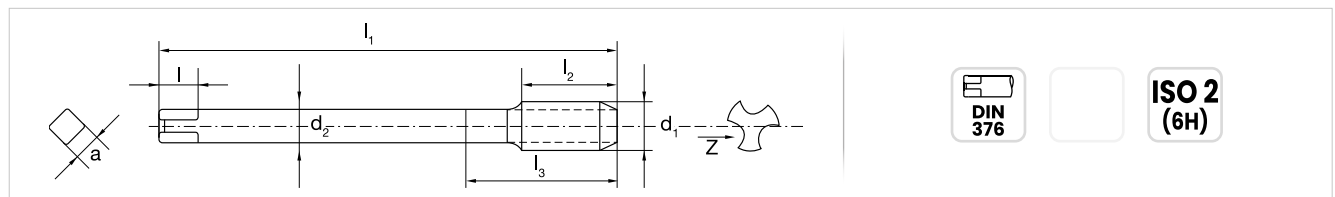
● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Mild Steels < 500 N/mm²



Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M3	0.5	56	5	22	2.2	5	2.5	3	2.50	290.005
M4	0.7	63	7	25.2	2.8	5	2.1	3	3.30	290.015
M5	0.8	70	8	28	3.5	6	2.7	3	4.20	290.025
M6	1	80	10	32	4.5	6	3.4	3	5.00	290.030
M8	1.25	90	13	36	6	8	4.9	3	6.80	290.040
M10	1.5	100	15	40	7	8	5.5	3	8.50	290.050
M12	1.75	110	18	44	9	10	7	3	10.20	290.060
M14	2	110	20	44	11	12	9	3	12.00	290.065
M16	2	110	20	44	12	12	9	3	14.00	290.070
M18	2.5	125	25	50	14	14	11	4	15.50	290.075
M20	2.5	140	25	56	16	15	12	4	17.50	290.080
M22	2.5	140	25	56	18	17	14.5	4	19.50	290.085
M24	3	160	30	64	18	17	14.5	4	21.00	290.090
M27	3	160	30	64	20	19	16	4	24.00	290.095
M30	3.5	180	35	72	22	21	18	4	26.50	290.100
M33	3.5	180	35	72	25	23	20	4	29.50	290.105
M36	4	200	40	80	28	25	22	4	32.00	290.110

Cutting parameters

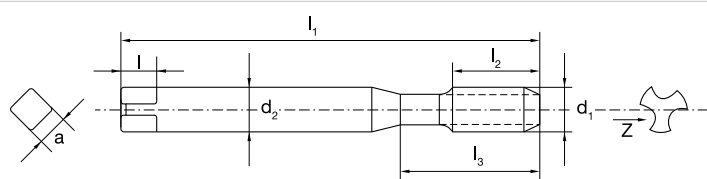
V _c m/min	STEEL 500-800 N/mm ²	66/6 LONG CHIP	CU 200-300 HB	CU SHORT	CU	ALU	STEEL ≤500 N/mm ²
	● ● 13 - 27	● ● 4 - 27	○ 4 - 27	○ 4 - 27	○ 4 - 27	○ 13 - 36	● ● ● ● 13 - 27
	● ● 9 - 18	● ● 4 - 27	○ 4 - 27	○ 4 - 27	○ 4 - 27	○ 13 - 36	● ● ● ● 9 - 18
	● ● 10 - 15	● ● 5 - 20	○ 5 - 20	○ 5 - 20	○ 5 - 20	○ 10 - 25	● ● ● ● 10 - 15

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Steels < 800 N/mm²

● Technical details

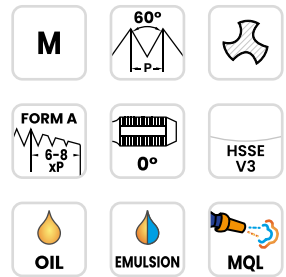
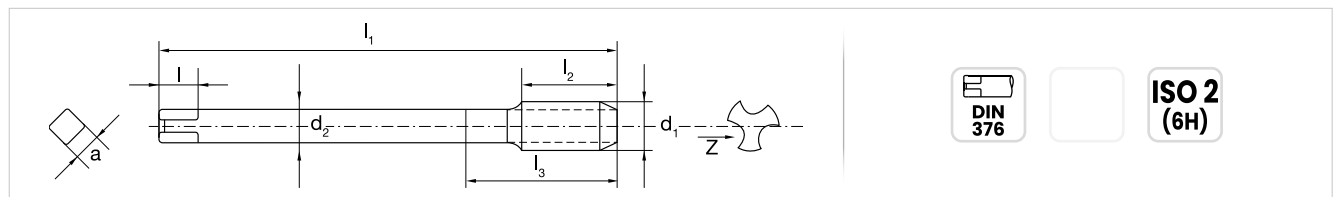


d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M1	0.25	40	5.5	7	2.5	5	2.1	3	0.75	070.005
M2	0.4	45	8	10	2.8	5	2.1	3	1.60	070.040
M2.5	0.45	50	9	12.5	2.8	5	2.1	3	2.05	070.055
M3	0.5	56	11	18	3.5	6	2.7	3	2.50	070.065
M3.5	0.6	56	12	20	4	6	3	3	2.90	070.070
M4	0.7	63	13	21	4.5	6	3.4	3	3.30	070.075
M5	0.8	70	16	25	6	8	4.9	3	4.20	070.085
M6	1	80	19	30	6	8	4.9	3	5.00	070.090
M8	1.25	90	22	35	8	9	6.2	4	6.80	070.100
M10	1.5	100	24	39	10	11	8	4	8.50	070.110

● Cutting parameters

V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 8 - 15	● ● ● 15 - 30	○ 15 - 40	● ● 5 - 30	● ● 5 - 30	● ● 5 - 30	● ● 15 - 30
	○ 5 - 15	● ● ● 10 - 20	○ 15 - 40	● ● 5 - 30	● ● 5 - 30	● ● 5 - 30	● ● 10 - 20
	○ 5 - 10	● ● ● 10 - 15	○ 15 - 40	● ● 5 - 20	● ● 5 - 20	● ● 5 - 20	● ● 10 - 15

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS
For Steels < 800 N/mm²

Technical details


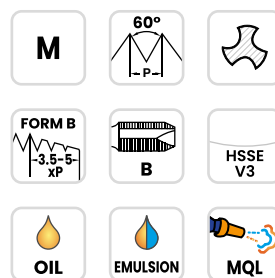
d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M2.5	0.45	50	9		1.8			3	2.05	270.004
M3	0.5	56	11		2.2			3	2.50	270.005
M3.5	0.6	56	12		2.5	5	2.1	3	2.90	270.010
M4	0.7	63	13	25	2.8	5	2.1	3	3.30	270.015
M5	0.8	70	16	28	3.5	6	2.7	3	4.20	270.025
M6	1	80	19	32	4.5	6	3.4	3	5.00	270.030
M8	1.25	90	22	36	6	8	4.9	4	6.80	270.040
M10	1.5	100	24	40	7	8	5.5	4	8.50	270.050
M12	1.75	110	28	44	9	10	7	4	10.20	270.060
M14	2	110	30	44	11	12	9	4	12.00	270.065
M16	2	110	32	44	12	12	9	4	14.00	270.070
M18	2.5	125	34	50	14	14	11	4	15.50	270.075
M20	2.5	140	34	56	16	15	12	4	17.50	270.080
M22	2.5	140	34	56	18	17	14.5	4	19.50	270.085
M24	3	160	38	64	18	17	14.5	4	21.00	270.090
M27	3	160	38	64	20	19	16	4	24.00	270.095
M30	3.5	180	45	72	22	21	18	4	26.50	270.100

Cutting parameters

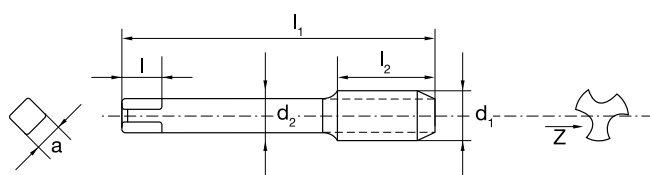
V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 8 - 15	●●●● 15 - 30	○ 15 - 40	●● 5 - 30	●● 5 - 30	●● 5 - 30	●● 15 - 30
	○ 5 - 15	●●●● 10 - 20	○ 15 - 40	●● 5 - 30	●● 5 - 30	●● 5 - 30	●● 10 - 20
	○ 5 - 10	●●●● 10 - 15	○ 15 - 40	●● 5 - 20	●● 5 - 20	●● 5 - 20	●● 10 - 15

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Steels < 800 N/mm²

● Technical details

ISO 2
(6H)

d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M2	0.4	36	8	10	2.8	5	2.1	2	1.60	005.040
M2.5	0.45	40	9	11	2.8	5	2.1	2	2.05	005.055
M3	0.5	40	11	13	3.5	6	2.7	3	2.50	005.065
M3.5	0.6	45	12		4.5	6	3.4	3	2.90	005.070
M4	0.7	45	13	14	4.5	6	3.4	3	3.30	005.075
M5	0.8	50	16	18	6	8	4.9	3	4.20	005.085
M6	1	56	19	21	6	8	4.9	3	5.00	005.090
M8	1.25	63	22	30	6	8	4.9	3	6.80	005.100
M10	1.5	70	24	37	7	8	5.5	3	8.50	005.110
M12	1.75	75	28	40	9	10	7	3	10.20	005.120
M16	2	80	32	43	12	12	9	3	14.00	005.130
M20	2.5	95	34	51	16	15	12	3	17.50	005.140

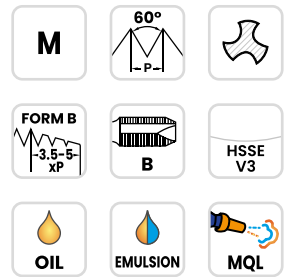
● Cutting parameters

V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 8 - 15	● ● ● 15 - 30	○ 15 - 40	● ● 5 - 30	● ● 5 - 30	● ● 5 - 30	● ● 15 - 30

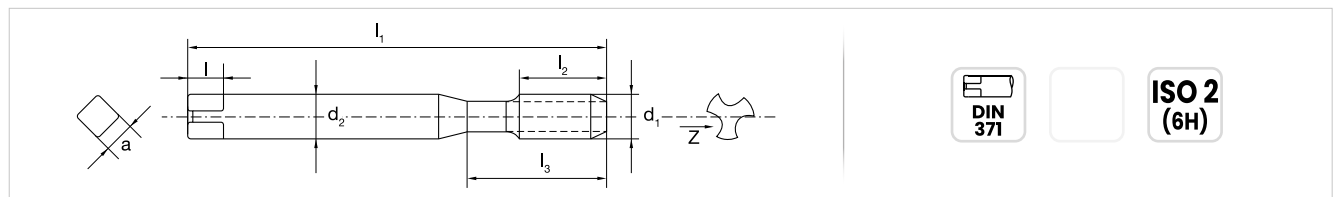
● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Steels < 800 N/mm²



Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	Z	Ø mm	Order code
M1.4	0.3	40	7	9	2.5	5	2.1	2	1.10	035.020
M1.6	0.35	40	8	9.5	2.5	5	2.1	2	1.25	035.025
M1.7	0.35	40	8	10	2.5	5	2.1	2	1.35	035.030
M1.8	0.35	40	8	10.5	2.5	5	2.1	2	1.45	035.035
M2	0.4	45	8	10	2.8	5	2.1	2	1.60	035.040
M2.2	0.45	45	9	11	2.8	5	2.1	2	1.75	035.045
M2.3	0.4	45	9	11.5	2.8	5	2.1	2	1.90	035.050
M2.5	0.45	50	9	12.5	2.8	5	2.1	2	2.05	035.055
M2.6	0.45	50	9	13	2.8	5	2.1	2	2.15	035.060
M3	0.5	56	11	18	3.5	6	2.7	3	2.50	035.065
M3.5	0.6	56	12	20	4	6	3	3	2.90	035.070
M4	0.7	63	13	21	4.5	6	3.4	3	3.30	035.075
M5	0.8	70	16	25	6	8	4.9	3	4.20	035.085
M6	1	80	19	30	6	8	4.9	3	5.00	035.090
M8	1.25	90	22	35	8	9	6.2	3	6.80	035.100
M10	1.5	100	24	39	10	11	8	3	8.50	035.110
M12	1.75	110	28	45	12	12	9	3	10.20	035.120

Cutting parameters

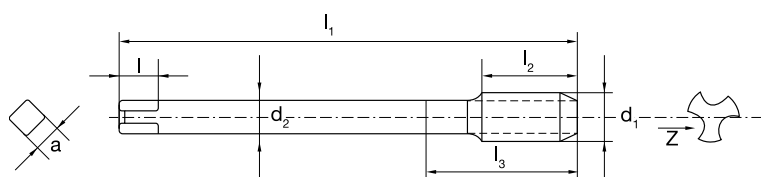
V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 8 - 15	●●● 15 - 30	○ 15 - 40	●● 5 - 30	●● 5 - 30	●● 5 - 30	●● 15 - 30

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Steels < 800 N/mm²

● Technical details



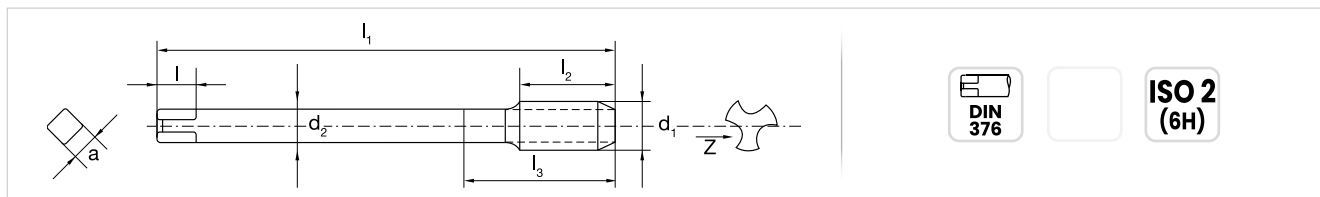
d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M2	0.4	45	8		1.4			3	1.60	235.003
M2.5	0.45	50	9		1.8			3	2.05	235.004
M3	0.5	56	11	22	2.2	5	2.5	3	2.50	235.005
M3.5	0.6	56	12	22	2.5	5	2.1	3	2.90	235.010
M4	0.7	63	13	25.2	2.8	5	2.1	3	3.30	235.015
M5	0.8	70	16	28	3.5	6	2.7	3	4.20	235.025
M6	1	80	19	32	4.5	6	3.4	3	5.00	235.030
M8	1.25	90	22	36	6	8	4.9	3	6.80	235.040
M10	1.5	100	24	40	7	8	5.5	3	8.50	235.050
M12	1.75	110	28	44	9	10	7	3	10.20	235.060
M14	2	110	30	44	11	12	9	3	12.00	235.065
M16	2	110	32	44	12	12	9	3	14.00	235.070
M18	2.5	125	34	50	14	14	11	3	15.50	235.075
M20	2.5	140	34	56	16	15	12	3	17.50	235.080
M22	2.5	140	34	56	18	17	14.5	3	19.50	235.085
M24	3	160	38	64	18	17	14.5	3	21.00	235.090
M27	3	160	38	64	20	19	16	4	24.00	235.095
M30	3.5	180	45	72	22	21	18	4	26.50	235.100

● Cutting parameters

V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 8 - 15	● ● ● 15 - 30	○ 15 - 40	● ● 5 - 30	● ● 5 - 30	● ● 5 - 30	● ● 15 - 30

● ● ● Recommended | ● ● Suitable | ○ Possible

- Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	Z		Order code
M33	3.5	180	50	72	25	23	20	4	29.50	235.105
M36	4	200	56	80	28	25	22	4	32.00	235.110
M39	4	200	60	80	32	27	24	4	35.00	235.115
M42	4.5	200	60	80	32	27	24	4	37.50	235.120
M45	4.5	220	65	88	36	32	29	4	40.50	235.125
M48	5	250	70	100	36	32	29	4	43.00	235.130
M52	5	250	70	100	40	35	32	4	47.00	235.135

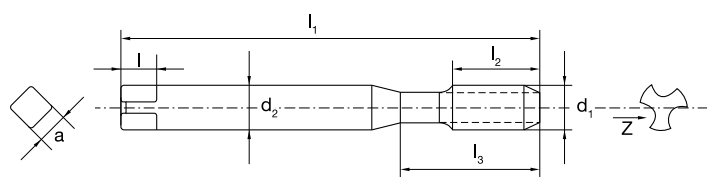
Cutting Taps

● Note

CUTTING TAPS

For Steels < 800 N/mm²

● Technical details

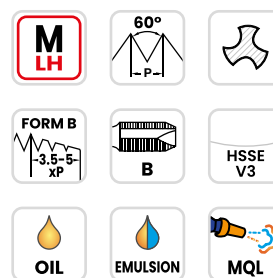
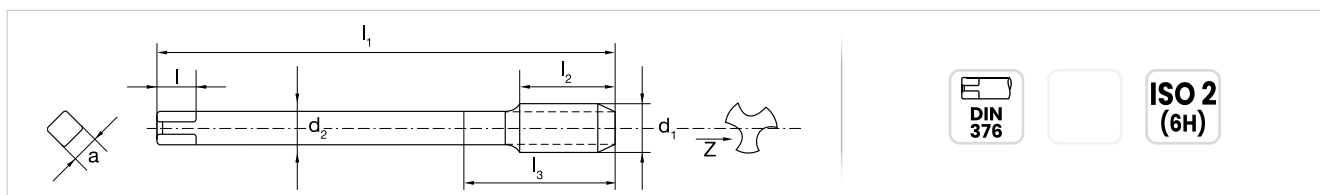


d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M3	0.5	56	11	18	3.5	6	2.7	3	2.50	050.065
M4	0.7	63	13	21	4.5	6	3.4	3	3.30	050.075
M5	0.8	70	16	25	6	8	4.9	3	4.20	050.085
M6	1	80	19	30	6	8	4.9	3	5.00	050.090
M8	1.25	90	22	35	8	9	6.2	3	6.80	050.100
M10	1.5	100	24	39	10	11	8	3	8.50	050.110

● Cutting parameters

V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 8 - 15	● ● ● 15 - 30	○ 15 - 40	● ● 5 - 30	● ● 5 - 30	● ● 5 - 30	● ● 15 - 30

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS
For Steels < 800 N/mm²

Technical details

DIN 376
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d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M12	1.75	110	28	44	9	10	7	3	10.20	250.060
M16	2	110	32	44	12	12	9	3	14.00	250.070
M20	2.5	140	34	56	16	15	12	3	17.50	250.080

Cutting parameters

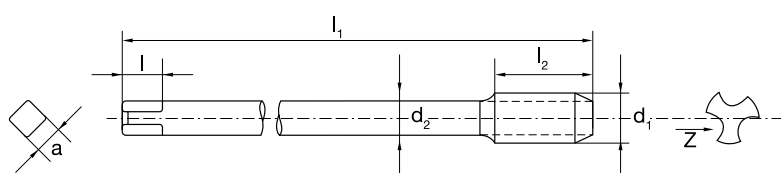
V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 8 - 15	●●● 15 - 30	○ 15 - 40	●● 5 - 30	●● 5 - 30	●● 5 - 30	●● 15 - 30

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Steels < 800 N/mm²

● Technical details

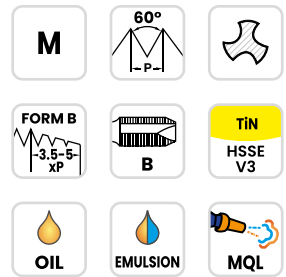
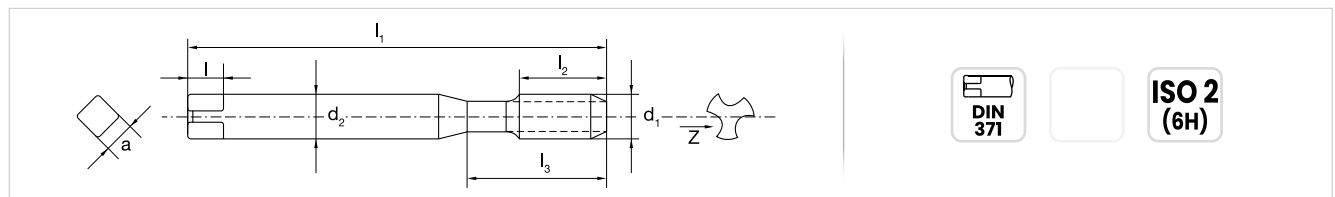


d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M3	0.5	112	11	56	2.2	5	2.5	3	2.50	440.005
M4	0.7	126	13	63	2.8	5	2.1	3	3.30	440.010
M5	0.8	140	16	70	3.5	6	2.7	3	4.20	440.015
M6	1	160	19	80	4.5	6	3.4	3	5.00	440.020
M8	1.25	180	22	90	6	8	4.9	3	6.80	440.025
M10	1.5	200	24	100	7	8	5.5	3	8.50	440.030
M12	1.75	220	28	110	9	10	7	3	10.20	440.035
M14	2	220	30	110	11	12	9	3	12.00	440.040
M16	2	220	32	110	12	12	9	3	14.00	440.045

● Cutting parameters

V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 8 - 15	● ● ● 15 - 30	○ 15 - 40	● ● 5 - 30	● ● 5 - 30	● ● 5 - 30	● ● 15 - 30

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS
For Steels < 800 N/mm²

Technical details

DIN 371
ISO 2 (6H)

d_1	P	l_1	l_2	l_3	d_2	l	α	Z	$\varnothing$ mm	Order code
M3	0.5	56	11	18	3.5	6	2.7	3	2.50	045.065
M4	0.7	63	13	21	4.5	6	3.4	3	3.30	045.075
M5	0.8	70	16	25	6	8	4.9	3	4.20	045.085
M6	1	80	19	30	6	8	4.9	3	5.00	045.090
M8	1.25	90	22	35	8	9	6.2	3	6.80	045.100
M10	1.5	100	24	39	10	11	8	3	8.50	045.110

Cutting parameters

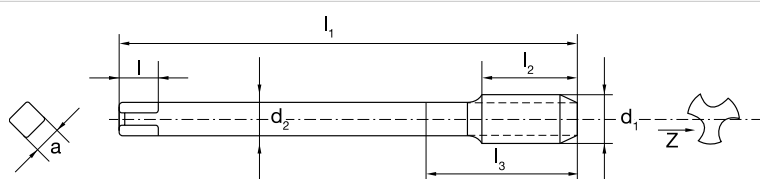
V_c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 8 - 15	●●● 15 - 30	○ 15 - 40	●● 5 - 30	●● 5 - 30	●● 5 - 30	●● 15 - 30

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Steels < 800 N/mm²

● Technical details

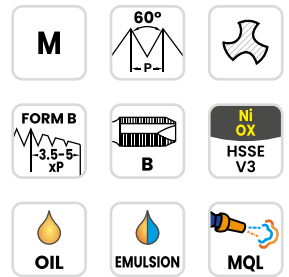
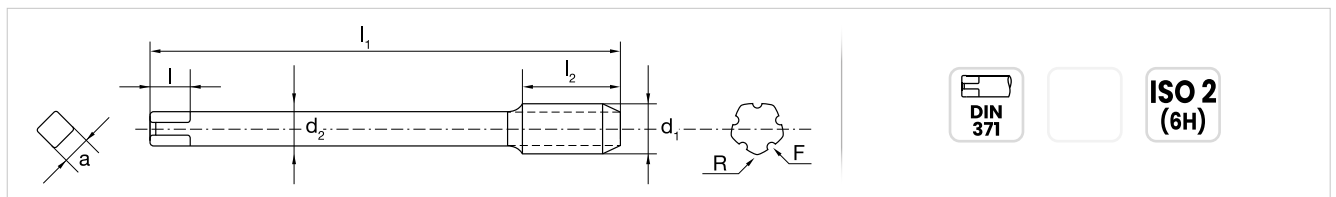


d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M3	0.5	56	11	22	2.2	5	2.5	3	2.50	245.005
M4	0.7	63	13	25.2	2.8	5	2.1	3	3.30	245.015
M5	0.8	70	16	28	3.5	6	2.7	3	4.20	245.025
M6	1	80	19	32	4.5	6	3.4	3	5.00	245.030
M8	1.25	90	22	36	6	8	4.9	3	6.80	245.040
M10	1.5	100	24	40	7	8	5.5	3	8.50	245.050
M12	1.75	110	28	44	9	10	7	3	10.20	245.060
M14	2	110	30	44	11	12	9	3	12.00	245.065
M16	2	110	32	44	12	12	9	3	14.00	245.070
M18	2.5	125	34	50	14	14	11	3	15.50	245.075
M20	2.5	140	34	56	16	15	12	3	17.50	245.080
M22	2.5	140	34	56	18	17	14.5	3	19.50	245.085
M24	3	160	38	64	18	17	14.5	3	21.00	245.090
M27	3	160	38	64	20	19	16	4	24.00	245.095
M30	3.5	180	45	72	22	21	18	4	26.50	245.100
M33	3.5	180	50	72	25	23	20	4	29.50	245.105
M36	4	200	56	80	28	25	22	4	32.00	245.110

● Cutting parameters

V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 8 - 15	● ● ● 15 - 30	○ 15 - 40	● ● 5 - 30	● ● 5 - 30	● ● 5 - 30	● ● 15 - 30

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS
For Steels < 800 N/mm²

Technical details


d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Ø mm	Order code
M2	0.4	45	8	10	2.8	5	2.1	1.60	025.040
M3	0.5	56	11	18	3.5	6	2.7	2.50	025.065
M3.5	0.6	56	12	20	4	6	3	2.90	025.070
M4	0.7	63	13	21	4.5	6	3.4	3.30	025.075
M5	0.8	70	16	25	6	8	4.9	4.20	025.085
M6	1	80	19	30	6	8	4.9	5.00	025.090
M8	1.25	90	22	35	8	9	6.2	6.80	025.100
M10	1.5	100	24	39	10	11	8	8.50	025.110

Cutting parameters

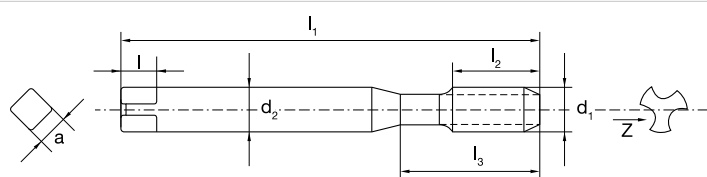
V _c m/min	STEEL 500-800 N/mm ²	GG/G LONG CHIP	CU 200-300 HB	CU SHORT	CU	ZDC ADC	STEEL ≤500 N/mm ²
	●●● 15 - 30	●●● 15 - 30	●● 5 - 30	●● 5 - 30	●● 5 - 30	●● 20 - 40	●● 15 - 30

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Steels < 800 N/mm²

● Technical details

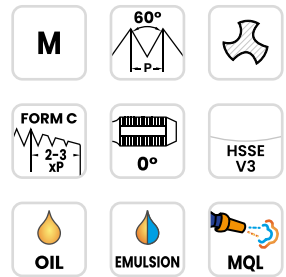
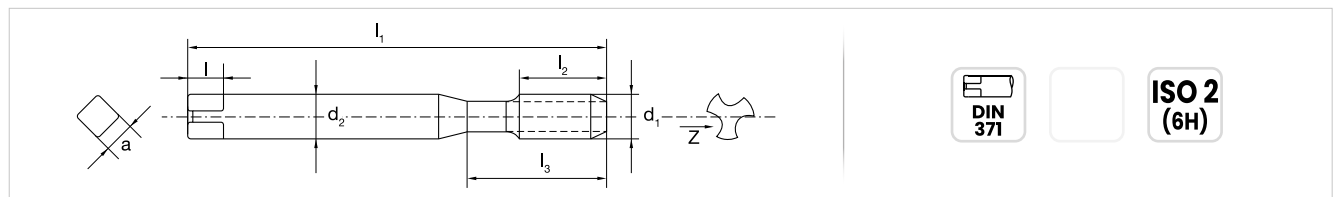


d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M2	0.4	45	8	10	2.8	5	2.1	2	1.60	031.040
M3	0.5	56	11	18	3.5	6	2.7	2	2.50	031.065
M4	0.7	63	13	21	4.5	6	3.4	2	3.30	031.075
M5	0.8	70	16	25	6	8	4.9	2	4.20	031.085
M6	1	80	19	30	6	8	4.9	2	5.00	031.090
M8	1.25	90	22	35	8	9	6.2	3	6.80	031.100
M10	1.5	100	24	39	10	11	8	3	8.50	031.110

● Cutting parameters

V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 8 - 15	● ● ● 15 - 30	○ 15 - 40	● ● 5 - 30	● ● 5 - 30	● ● 5 - 30	● ● 15 - 30

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS
For Steels < 800 N/mm²

Technical details


d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	Z	Ø/mm	Order code
M1.4	0.3	40	7	9	2.5	5	2.1	3	1.10	065.020
M1.6	0.35	40	8	9.5	2.5	5	2.1	3	1.25	065.025
M1.7	0.35	40	8	10	2.5	5	2.1	3	1.35	065.030
M1.8	0.35	40	8	10.51	2.5	5	2.1	3	1.45	065.035
M2	0.4	45	8	10	2.8	5	2.1	3	1.60	065.040
M2.5	0.45	50	9	12.5	2.8	5	2.1	3	2.05	065.055
M3	0.5	56	11	18	3.5	6	2.7	3	2.50	065.065
M3.5	0.6	56	112	20	4	6	3	3	2.90	065.070
M4	0.7	63	13	21	4.5	6	3.4	3	3.30	065.075
M5	0.8	70	16	25	6	8	4.9	3	4.20	065.085
M6	1	80	19	30	6	8	4.9	3	5.00	065.090
M8	1.25	90	22	35	8	9	6.2	4	6.80	065.100
M10	1.5	100	24	39	10	11	8	4	8.50	065.110

Cutting parameters

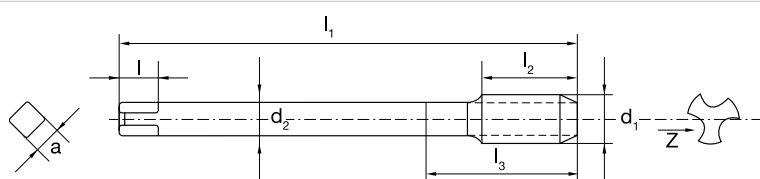
V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 5 - 12	●●● 10 - 24	○ 10 - 32	●● 3 - 24	●● 3 - 24	●● 3 - 24	●● 10 - 24
	○ 4 - 12	●● 9 - 16	○ 13 - 32	●● 4 - 24	●● 4 - 24	●● 4 - 24	●● 9 - 16
	○ 5 - 10	●● 10 - 15	○ 15 - 40	●● 5 - 20	●● 5 - 20	●● 5 - 20	●● 10 - 15

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Steels < 800 N/mm²

● Technical details



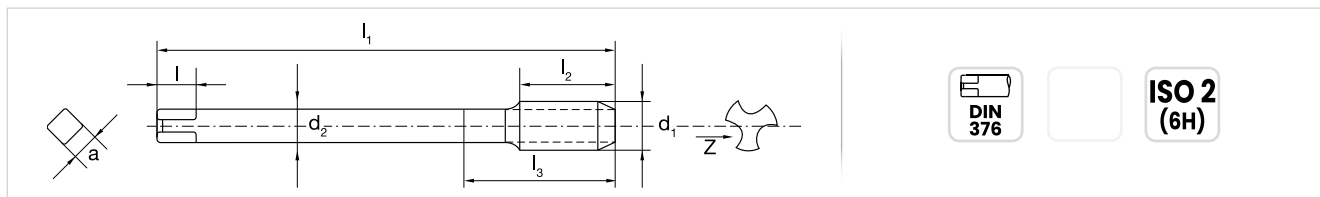
d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M3	0.5	56	11	22	2.2	5	2.5	3	2.50	956.005
M4	0.7	63	13	25.2	2.8	5	2.1	3	3.30	956.015
M5	0.8	70	16	28	3.5	6	2.7	3	4.20	956.025
M6	1	80	19	32	4.5	6	3.4	3	5.00	956.030
M8	1.25	90	22	36	6	8	4.9	4	6.80	956.040
M10	1.5	100	24	40	7	8	5.5	4	8.50	956.050
M12	1.75	110	28	44	9	10	7	4	10.20	956.060
M14	2	110	30	44	11	12	9	4	12.00	956.065
M16	2	110	32	44	12	12	9	4	14.00	956.070
M18	2.5	125	34	50	14	14	11	4	15.50	956.075
M20	2.5	140	34	56	16	15	12	4	17.50	956.080
M22	2.5	140	34	56	18	17	14.5	4	19.50	956.085
M24	3	160	38	64	18	17	14.5	4	21.00	956.090
M27	3	160	38	64	20	19	16	4	24.00	956.095
M30	3.5	180	45	72	22	21	18	4	26.50	956.100
M33	3.5	180	50	72	25	23	20	4	29.50	956.105
M36	4	200	56	80	28	25	22	4	32.00	956.110
M39	4	200	60	80	32	27	24	4	35.00	956.115

● Cutting parameters

V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 5 - 12	● ● ● 10 - 24	○ 10 - 32	● ● 3 - 24	● ● 3 - 24	● ● 3 - 24	● ● 10 - 24
	○ 4 - 12	● ● 9 - 16	○ 13 - 32	● ● 4 - 24	● ● 4 - 24	● ● 4 - 24	● ● 9 - 16
	○ 5 - 10	● ● 10 - 15	○ 15 - 40	● ● 5 - 20	● ● 5 - 20	● ● 5 - 20	● ● 10 - 15

● ● ● Recommended | ● ● Suitable | ○ Possible

- Technical details



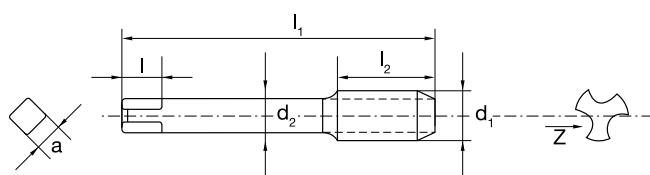
d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	Z		Order code
M42	4.5	200	60	80	32	27	24	4	37.50	956.120
M45	4.5	220	65	88	36	32	29	4	40.50	956.125
M48	5	250	70	100	36	32	29	4	43.00	956.130
M52	5	250	70	100	40	35	32	4	47.00	956.135

● Note

CUTTING TAPS

For Steels < 800 N/mm²

● Technical details

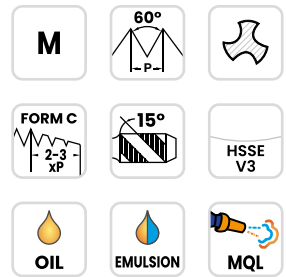
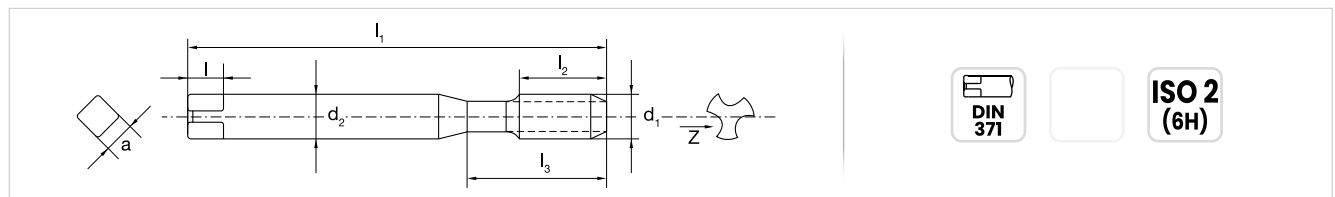


d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M3	0.5	40	5	13	3.5	6	2.7	3	2.50	010.065
M4	0.7	45	7	14	4.5	6	3.4	3	3.30	010.075
M5	0.8	50	8	18	6	8	4.9	3	4.20	010.085
M6	1	56	10	21	6	8	4.9	3	5.00	010.090
M8	1.25	63	13	30	6	8	4.9	3	6.80	010.100
M10	1.5	70	15	37	7	8	5.5	3	8.50	010.110
M12	1.75	75	18	40	9	10	7	3	10.20	010.120
M14	2	80	20	43	11	12	8	3	12.00	010.125
M16	2	80	20	43	12	12	9	3	14.00	010.130
M18	2.5	95	25	51	14	14	11	4	15.50	010.135
M20	2.5	95	25	51	16	15	12	4	17.50	010.140

● Cutting parameters

V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 7 - 13	●● 13 - 27	○ 13 - 36	●● 4 - 27	●● 4 - 27	●● 4 - 27	●● 13 - 27
	○ 4 - 13	●●● 9 - 18	○ 13 - 36	●● 4 - 27	●● 4 - 27	●● 4 - 27	●● 9 - 18
	○ 5 - 10	●●● 10 - 15	○ 15 - 40	●● 5 - 20	●● 5 - 20	●● 5 - 20	●● 10 - 15

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS
For Steels < 800 N/mm²

Technical details

DIN 371
ISO 2 (6H)

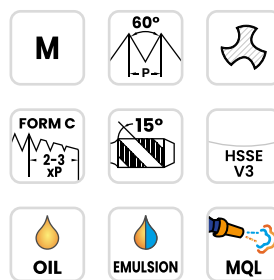
d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	Z	Ø mm	Order code
M2	0.4	45	8	10	2.8	5	2.1	2	1.60	075.040
M2.5	0.45	50	9	12.5	2.8	5	2.1	2	2.05	075.055
M3	0.5	56	5	18	3.5	6	2.7	3	2.50	075.065
M4	0.7	63	7	21	4.5	6	3.4	3	3.30	075.075
M5	0.8	70	8	25	6	8	4.9	3	4.20	075.085
M6	1	80	10	30	6	8	4.9	3	5.00	075.090
M8	1.25	90	13	35	8	9	6.2	3	6.80	075.100
M10	1.5	100	15	39	10	11	8	3	8.50	075.110

Cutting parameters

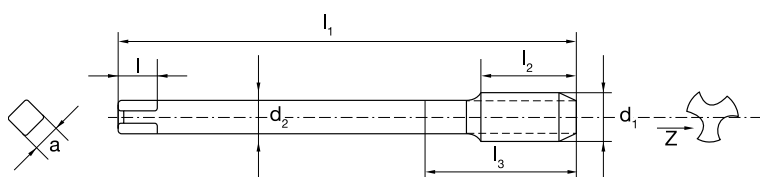
V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 7 - 13	● ● 13 - 27	○ 13 - 36	● ● 4 - 27	● ● 4 - 27	● ● 4 - 27	● ● 13 - 27
	○ 4 - 13	● ● ● 9 - 18	○ 13 - 36	● ● 4 - 27	● ● 4 - 27	● ● 4 - 27	● ● 9 - 18
	○ 5 - 10	● ● ● 10 - 15	○ 15 - 40	● ● 5 - 20	● ● 5 - 20	● ● 5 - 20	● ● 10 - 15

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Steels < 800 N/mm²

● Technical details

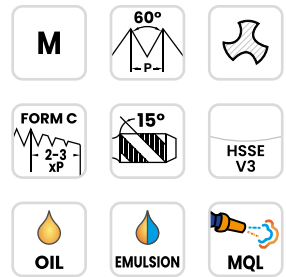
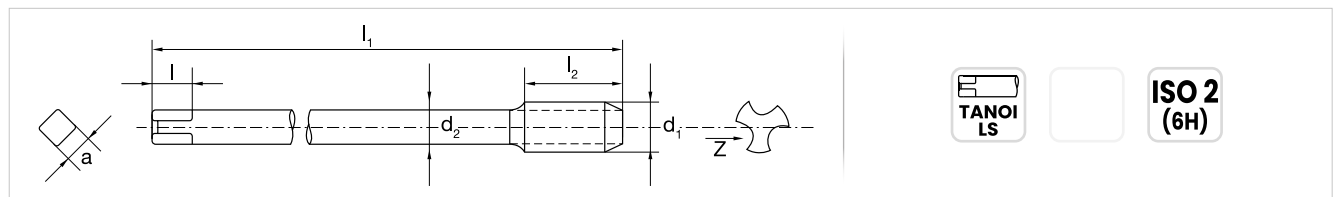
ISO 2
(6H)

d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M3	0.5	56	5	22	2.2	5	2.5	3	2.50	280.005
M3.5	0.6	56	6	22	2.5	5	2.1	3	2.90	280.010
M4	0.7	63	7	25.2	2.8	5	2.1	3	3.30	280.015
M5	0.8	70	8	28	3.5	6	2.7	3	4.20	280.025
M6	1	80	10	32	4.5	6	3.4	3	5.00	280.030
M8	1.25	90	13	36	6	8	4.9	3	6.80	280.040
M10	1.5	100	15	40	7	8	5.5	3	8.50	280.050
M12	1.75	110	18	44	9	10	7	3	10.20	280.060
M14	2	110	20	44	11	12	9	3	12.00	280.065
M16	2	110	2	44	12	12	9	3	14.00	280.070
M18	2.5	125	25	50	14	14	11	4	15.50	280.075
M20	2.5	140	25	56	16	15	12	4	17.50	280.080
M22	2.5	140	25	56	18	17	14.5	4	19.50	280.085
M24	3	160	30	64	18	17	14.5	4	21.00	280.090
M27	3	160	30	64	20	19	16	4	24.00	280.095
M30	3.5	180	35	72	22	21	18	4	26.50	280.100
M33	3.5	180	35	72	25	23	20	4	29.50	280.105
M36	4	200	40	80	28	25	22	4	32.00	280.110

● Cutting parameters

V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 7 - 13	●● 13 - 27	○ 13 - 36	●● 4 - 27	●● 4 - 27	●● 4 - 27	●● 13 - 27
	○ 4 - 13	●●● 9 - 18	○ 13 - 36	●● 4 - 27	●● 4 - 27	●● 4 - 27	●● 9 - 18
	○ 5 - 10	●●● 10 - 15	○ 15 - 40	●● 5 - 20	●● 5 - 20	●● 5 - 20	●● 10 - 15

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS
For Steels < 800 N/mm²

Technical details


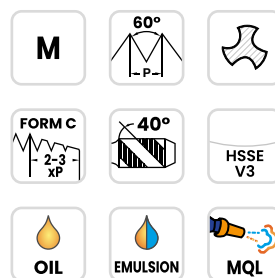
d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	Z	Ø mm	Order code
M3	0.5	112	5	56	2.2			3	2.50	445.050
M4	0.7	126	7	63	2.8	5	2.1	3	3.30	445.055
M5	0.8	140	8	70	3.5	6	2.7	3	4.20	445.060
M6	1	160	10	80	4.5	6	3.4	3	5.00	445.065
M8	1.25	180	13	90	6	8	4.9	3	6.80	445.070
M10	1.5	200	15	100	7	8	5.5	3	8.50	445.075
M12	1.75	220	18	110	9	10	7	3	10.20	445.080
M14	2	220	20	110	11	12	9	3	12.00	445.085
M16	2	220	20	110	12	12	9	3	14.00	445.090

Cutting parameters

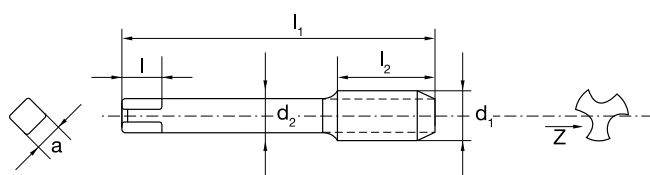
V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 7 - 13	● ● 13 - 27	○ 13 - 36	● ● 4 - 27	● ● 4 - 27	● ● 4 - 27	● ● 13 - 27
	○ 4 - 13	● ● ● 9 - 18	○ 13 - 36	● ● 4 - 27	● ● 4 - 27	● ● 4 - 27	● ● 9 - 18
	○ 5 - 10	● ● ● 10 - 15	○ 15 - 40	● ● 5 - 20	● ● 5 - 20	● ● 5 - 20	● ● 10 - 15

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Steels < 800 N/mm²

● Technical details

ISO 2
(6H)

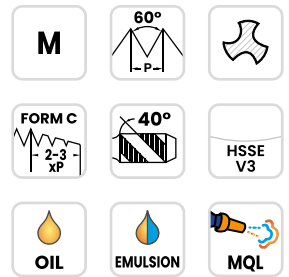
d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M2	0.4	36	8	10	2.8	5	2.1	2	1.60	015.040
M3	0.5	40	5	13	3.5	6	2.7	3	2.50	015.065
M4	0.7	45	7	14	4.5	6	3.4	3	3.30	015.075
M5	0.8	50	8	18	6	8	4.9	3	4.20	015.085
M6	1	56	10	21	6	8	4.9	3	5.00	015.090
M8	1.25	63	13	30	6	8	4.9	3	6.80	015.100
M10	1.5	70	15	37	7	8	5.5	3	8.50	015.110
M12	1.75	75	18	40	9	10	7	3	10.20	015.120
M14	2	80	20	43	11	12	9	3	12.00	015.125
M16	2	80	20	43	12	12	9	3	14.00	015.130
M18	2.5	95	25	51	14	14	11	4	15.50	015.135
M20	2.5	95	25	51	16	15	12	4	17.50	015.140

● Cutting parameters

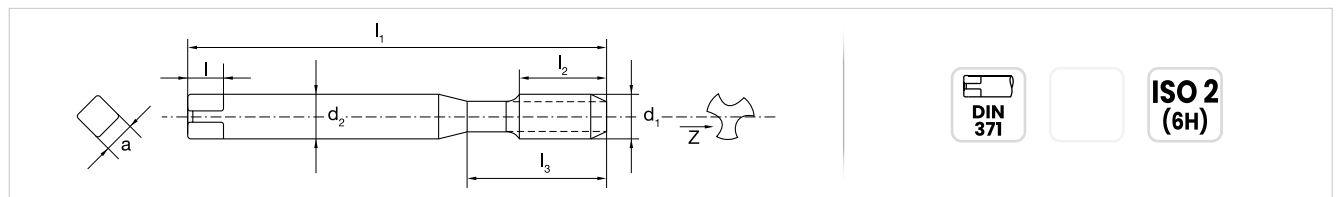
V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 7 - 13	●● 13 - 27	○ 13 - 36	●● 4 - 27	●● 4 - 27	●● 4 - 27	●● 13 - 27
	○ 4 - 13	●●● 9 - 18	○ 13 - 36	●● 4 - 27	●● 4 - 27	●● 4 - 27	●● 9 - 18
	○ 5 - 10	●●● 10 - 15	○ 15 - 40	●● 5 - 20	●● 5 - 20	●● 5 - 20	●● 10 - 15

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Steels < 800 N/mm²

● Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	Z	Ø/mm	Order code
M2	0.4	45	8	10	2.8	5	2.1	2	1.60	085.040
M2.2	0.45	45	9	11	2.8	5	2.1	2	1.75	085.045
M2.3	0.4	45	9	11.5	2.8	5	2.1	2	1.90	085.050
M2.5	0.45	50	9	12.5	2.8	5	2.1	2	2.05	085.055
M2.6	0.45	50	9	13	2.8	5	2.1	2	2.15	085.060
M3	0.5	56	5	18	3.5	6	2.7	3	2.50	085.065
M3.5	0.6	56	6	20	4	6	3	3	2.90	085.070
M4	0.7	63	7	21	4.5	6	3.4	3	3.30	085.075
M5	0.8	70	8	25	6	8	4.9	3	4.20	085.085
M6	1	80	10	30	6	8	4.9	3	5.00	085.090
M8	1.25	90	13	35	8	9	6.2	3	6.80	085.100
M10	1.5	100	15	39	10	11	8	3	8.50	085.110
M12	1.75	110	18	45	12	12	9	3	10.20	085.120

● Cutting parameters

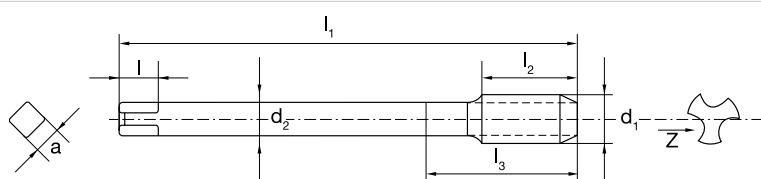
V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 7 - 13	● ● 13 - 27	○ 13 - 36	● ● 4 - 27	● ● 4 - 27	● ● 4 - 27	● ● 13 - 27
	○ 4 - 13	● ● ● 9 - 18	○ 13 - 36	● ● 4 - 27	● ● 4 - 27	● ● 4 - 27	● ● 9 - 18
	○ 5 - 10	● ● ● 10 - 15	○ 15 - 40	● ● 5 - 20	● ● 5 - 20	● ● 5 - 20	● ● 10 - 15

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Steels < 800 N/mm²

● Technical details

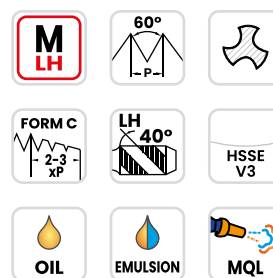
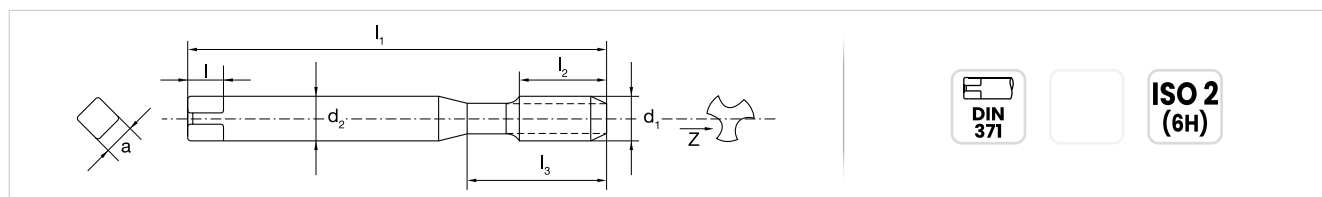


d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M3	0.5	56	5	22	2.2	5	2.5	3	2.50	285.005
M3.5	0.6	56	6	22	2.5	5	2.1	3	2.90	285.010
M4	0.7	63	7	25.2	2.8	5	2.1	3	3.30	285.015
M5	0.8	70	8	28	3.5	6	2.7	3	4.20	285.025
M6	1	80	10	32	4.5	6	3.4	3	5.00	285.030
M8	1.25	90	13	36	6	8	4.9	3	6.80	285.040
M10	1.5	100	15	40	7	8	5.5	3	8.50	285.050
M12	1.75	110	18	44	9	10	7	3	10.20	285.060
M14	2	110	20	44	11	12	9	3	12.00	285.065
M16	2	110	20	44	12	12	9	3	14.00	285.070
M18	2.5	125	25	50	14	14	11	4	15.50	285.075
M20	2.5	140	25	56	16	15	12	4	17.50	285.080
M22	2.5	140	25	56	18	17	14.5	4	19.50	285.085
M24	3	160	30	64	18	17	14.5	4	21.00	285.090
M27	3	160	30	64	20	19	16	4	24.00	285.095
M30	3.5	180	35	72	22	21	18	4	26.50	285.100
M33	3.5	180	35	72	25	23	20	4	29.50	285.105
M36	4	200	40	80	28	25	22	4	32.00	285.110

● Cutting parameters

V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 7 - 13	●● 13 - 27	○ 13 - 36	●● 4 - 27	●● 4 - 27	●● 4 - 27	●● 13 - 27
	○ 4 - 13	●●● 9 - 18	○ 13 - 36	●● 4 - 27	●● 4 - 27	●● 4 - 27	●● 9 - 18
	○ 5 - 10	●●● 10 - 15	○ 15 - 40	●● 5 - 20	●● 5 - 20	●● 5 - 20	●● 10 - 15

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS
For Steels < 800 N/mm²

Technical details

DIN 371
ISO 2 (6H)

d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø/mm	Order code
M3	0.5	56	5	18	3.5	6	2.7	3	2.50	105.065
M4	0.7	63	7	21	4.5	6	3.4	3	3.30	105.075
M5	0.8	70	8	25	6	8	4.9	3	4.20	105.085
M6	1	80	10	30	6	8	4.9	3	5.00	105.090
M8	1.25	90	13	35	8	9	6.2	3	6.80	105.100
M10	1.5	100	15	39	10	11	8	3	8.50	105.110

Cutting parameters

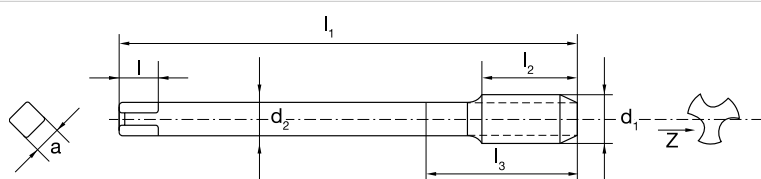
V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 7 - 13	● ● 13 - 27	○ 13 - 36	● ● 4 - 27	● ● 4 - 27	● ● 4 - 27	● ● 13 - 27
	○ 4 - 13	● ● ● 9 - 18	○ 13 - 36	● ● 4 - 27	● ● 4 - 27	● ● 4 - 27	● ● 9 - 18
	○ 5 - 10	● ● ● 10 - 15	○ 15 - 40	● ● 5 - 20	● ● 5 - 20	● ● 5 - 20	● ● 10 - 15

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Steels < 800 N/mm²

● Technical details



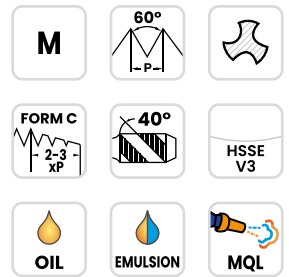
d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M12	1.75	110	18	44	9	10	7	3	10.20	305.060
M16	2	110	20	44	12	12	9	3	14.00	305.070
M20	2.5	140	25	56	16	15	12	4	17.50	305.080

● Cutting parameters

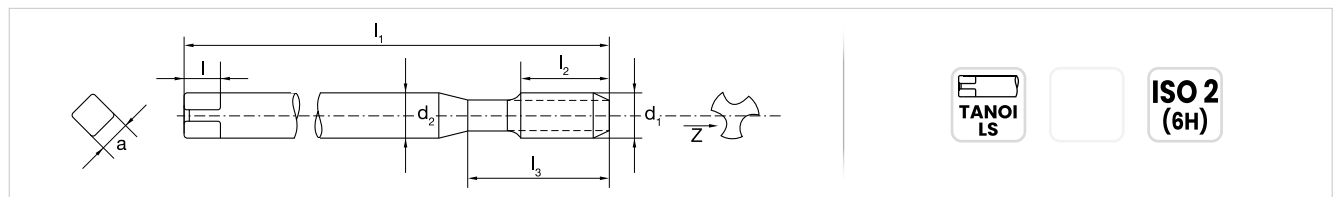
V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 7 - 13	●● 13 - 27	○ 13 - 36	●● 4 - 27	●● 4 - 27	●● 4 - 27	●● 13 - 27
	○ 4 - 13	●●● 9 - 18	○ 13 - 36	●● 4 - 27	●● 4 - 27	●● 4 - 27	●● 9 - 18
	○ 5 - 10	●●● 10 - 15	○ 15 - 40	●● 5 - 20	●● 5 - 20	●● 5 - 20	●● 10 - 15

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Steels < 800 N/mm²

● Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	Z	Ø mm	Order code
M3	0.5	112	5	56	3.5	6	2.7	3	2.50	450.095
M4	0.7	126	7	63	4.5	6	3.4	3	3.30	450.100
M5	0.8	140	8	70	6	8	4.9	3	4.20	450.105
M6	1	160	10	80	6	8	4.9	3	5.00	450.110
M8	1.25	180	13	90	6	8	4.9	3	6.80	450.115
M10	1.5	200	15	100	7	8	5.5	3	8.50	450.120
M12	1.75	220	18	110	9	10	7	3	10.20	450.125
M14	2	220	20	110	11	12	9	3	12.00	450.130
M16	2	220	20	110	12	12	9	3	14.00	450.135

● Cutting parameters

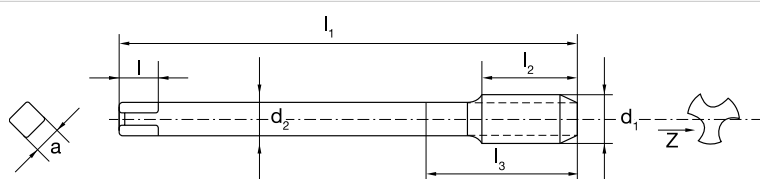
V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 7 - 13	● ● 13 - 27	○ 13 - 36	● ● 4 - 27	● ● 4 - 27	● ● 4 - 27	● ● 13 - 27
	○ 4 - 13	● ● ● 9 - 18	○ 13 - 36	● ● 4 - 27	● ● 4 - 27	● ● 4 - 27	● ● 9 - 18
	○ 5 - 10	● ● ● 10 - 15	○ 15 - 40	● ● 5 - 20	● ● 5 - 20	● ● 5 - 20	● ● 10 - 15

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Steels < 800 N/mm²

● Technical details

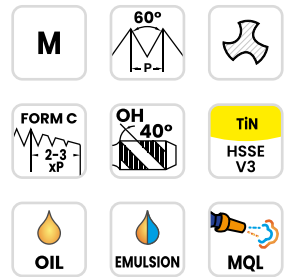
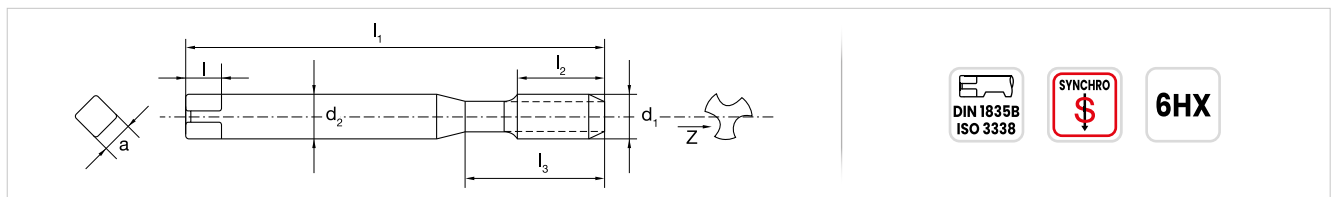


d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M3	0.5	70	5	18	6	8	4.9	3	2.50	975.075
M4	0.7	70	7	21	6	8	4.9	3	3.30	975.095
M5	0.8	70	8	25	6	8	4.9	3	4.20	975.120
M6	1	80	10	30	6	8	4.9	3	5.00	975.130
M8	1.25	90	13	35	8	9	6.2	3	6.80	975.155
M10	1.5	100	15	39	10	11	8	3	8.50	975.185
M12	1.75	110	17	45	12	12	9	3	10.20	975.215

● Cutting parameters

V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 7 - 13	● ● ● 13 - 27	○ 13 - 36	● ● 4 - 27	● ● 4 - 27	● ● 4 - 27	● ● 13 - 27

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS
For Steels < 800 N/mm²

Technical details


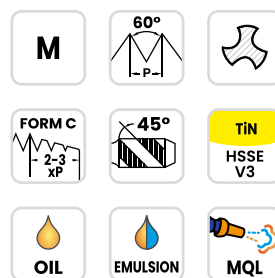
d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	Z	Ø/mm	Order code
M3	0.5	70	3	18	6	8	4.9	3	2.50	977.075
M4	0.7	70	4.2	21	6	8	4.9	3	3.70	977.095
M5	0.8	70	4.8	25	6	8	4.9	3	4.20	977.120
M6	1	80	6	30	6	8	4.9	3	5.00	977.130
M8	1.25	90	7.5	35	8	9	6.2	3	6.80	977.155
M10	1.5	100	9	39	10	11	8	3	8.50	977.185
M12	1.75	110	10.5	45	12	12	9	3	10.20	977.215

Cutting parameters

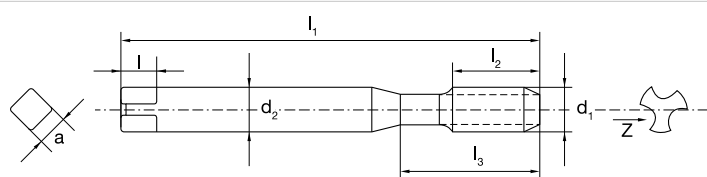
V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 7 - 13	● ● 13 - 27	○ 13 - 36	● ● 4 - 27	● ● 4 - 27	● ● 4 - 27	● ● 13 - 27
	○ 4 - 13	● ● ● 9 - 18	○ 13 - 36	● ● 4 - 27	● ● 4 - 27	● ● 4 - 27	● ● 9 - 18
	○ 5 - 10	● ● ● 10 - 15	○ 15 - 40	● ● 5 - 20	● ● 5 - 20	● ● 5 - 20	● ● 10 - 15

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Steels < 800 N/mm²

● Technical details

ISO 2
(6H)

d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	Z	Ø mm	Order code
M3	0.5	56	5	18	3.5	6	2.7	3	2.50	100.065
M4	0.7	63	7	21	4.5	6	3.4	3	3.30	100.075
M5	0.8	70	8	25	6	8	4.9	3	4.20	100.085
M6	1	80	10	30	6	8	4.9	3	5.00	100.090
M8	1.25	90	13	35	8	9	6.2	3	6.80	100.100
M10	1.5	100	15	39	10	11	8	3	8.50	100.110

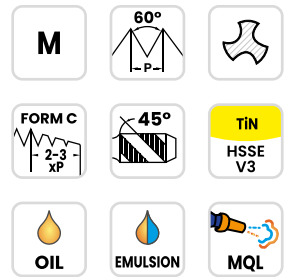
● Cutting parameters

V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 7 - 13	●● 13 - 27	○ 13 - 36	●● 4 - 27	●● 4 - 27	●● 4 - 27	●● 13 - 27
	○ 5 - 13	●●● 10 - 18	○ 15 - 36	●● 5 - 27	●● 5 - 27	●● 5 - 27	●● 10 - 18
	○ 5 - 10	●●● 10 - 15	○ 15 - 40	●● 5 - 20	●● 5 - 20	●● 5 - 20	●● 10 - 15

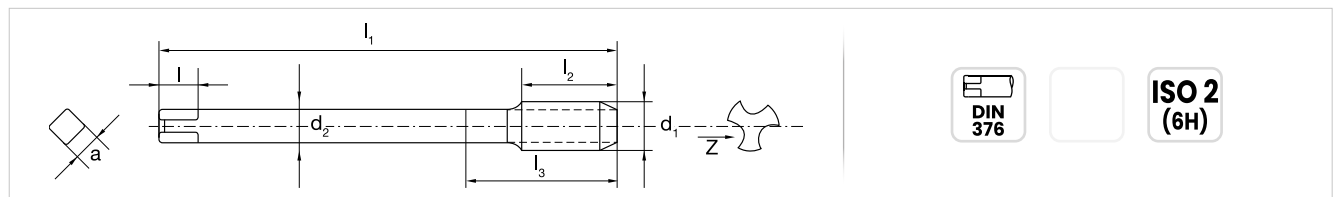
●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Steels < 800 N/mm²



Technical details



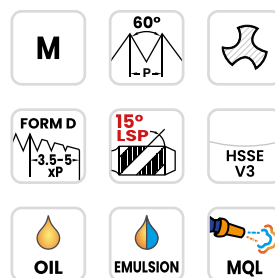
d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	Z	Ø mm	Order code
M3	0.5	56	5	22	2.2	5	2.5	3	2.50	300.005
M4	0.7	63	7	25.2	2.8	5	2.1	3	3.30	300.015
M5	0.8	70	8	28	3.5	6	2.7	3	4.20	300.025
M6	1	80	10	32	4.5	6	3.4	3	5.00	300.030
M8	1.25	90	13	36	6	8	4.9	3	6.80	300.040
M10	1.5	100	15	40	7	8	5.5	3	8.50	300.050
M12	1.75	110	18	44	9	10	7	3	10.20	300.060
M14	2	110	20	44	11	12	9	3	12.00	300.065
M16	2	110	20	44	12	12	9	3	14.00	300.070
M18	2.5	125	25	50	14	14	11	4	15.50	300.075
M20	2.5	140	25	56	16	15	12	4	17.50	300.080
M22	2.5	140	25	56	18	17	14.5	4	19.50	300.085
M24	3	160	30	64	18	17	14.5	4	21.00	300.090
M27	3	160	30	64	20	19	16	4	24.00	300.095
M30	3.5	180	35	72	22	21	18	4	26.50	300.100
M33	3.5	180	35	72	25	23	20	4	29.50	300.105
M36	4	200	40	80	28	25	22	4	32.00	300.110

Cutting parameters

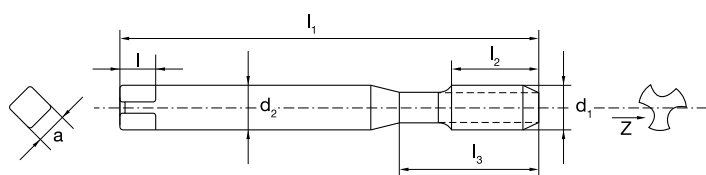
V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 7 - 13	● ● 13 - 27	○ 13 - 36	● ● 4 - 27	● ● 4 - 27	● ● 4 - 27	● ● 13 - 27
	○ 5 - 13	● ● ● 10 - 18	○ 15 - 36	● ● 5 - 27	● ● 5 - 27	● ● 5 - 27	● ● 10 - 18
	○ 5 - 10	● ● ● 10 - 15	○ 15 - 40	● ● 5 - 20	● ● 5 - 20	● ● 5 - 20	● ● 10 - 15

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Steels < 800 N/mm²

● Technical details

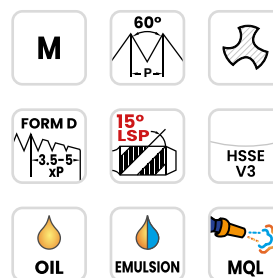
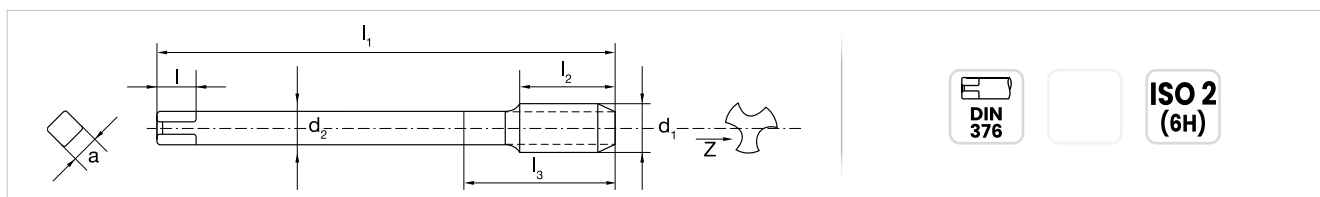
ISO 2
(6H)

d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M3	0.5	56	11	18	3.5	6	2.7	3	2.50	080.065
M4	0.7	63	13	21	4.5	6	3.4	3	3.30	080.075
M5	0.8	70	16	25	6	8	4.9	3	4.20	080.085
M6	1	80	19	30	6	8	4.9	3	5.00	080.090
M8	1.25	90	22	35	8	9	6.2	3	6.80	080.100
M10	1.5	100	24	39	10	11	8	3	8.50	080.110

● Cutting parameters

V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 6 - 10	● ● ● 12 - 20	○ 12 - 27	● ● 4 - 20	● ● 4 - 20	● ● 4 - 20	● ● 12 - 20

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS
For Steels < 800 N/mm²

Technical details

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ISO 2 (6H)

d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M12	1.75	110	28	44	9	10	7	3	10.20	275.060
M16	2	110	32	44	12	12	9	3	14.00	275.070

Cutting parameters

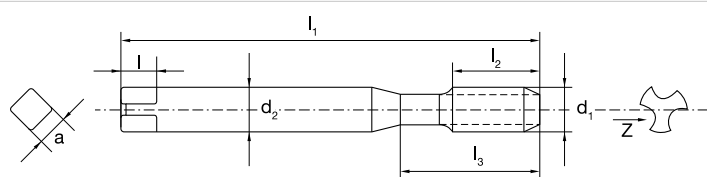
V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 6 - 10	●●● 12 - 20	○ 12 - 27	●● 4 - 20	●● 4 - 20	●● 4 - 20	●● 12 - 20

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Steels < 800 N/mm²

● Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M3	0.5	56	5	18	3.5	6	2.7	3	2.50	095.065
M4	0.7	63	7	21	4.5	6	3.4	3	3.30	095.075
M5	0.8	70	8	25	6	8	4.9	3	4.20	095.085
M6	1	80	10	30	6	8	4.9	3	5.00	095.090
M8	1.25	90	13	35	8	9	6.2	3	6.80	095.100
M10	1.5	100	15	39	10	11	8	3	8.50	095.110

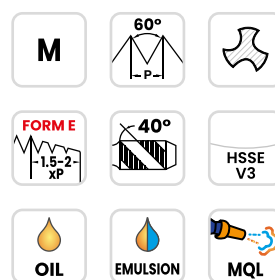
● Cutting parameters

V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 7 - 13	○ 13 - 27	○ 13 - 36	○ 4 - 27	○ 4 - 27	○ 4 - 27	○ 13 - 27
	○ 4 - 13	●●● 9 - 18	○ 13 - 36	●● 4 - 27	●● 4 - 27	●● 4 - 27	●● 9 - 18
	○ 5 - 10	●●● 10 - 15	○ 15 - 40	●● 5 - 20	●● 5 - 20	●● 5 - 20	●● 10 - 15

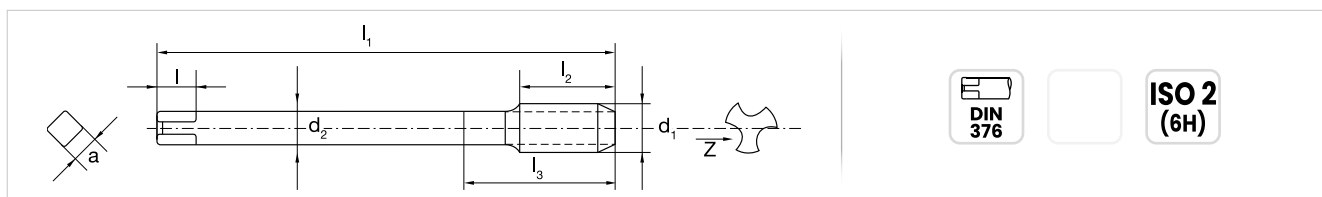
●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Steels < 800 N/mm²



Technical details



DIN 376

ISO 2 (6H)

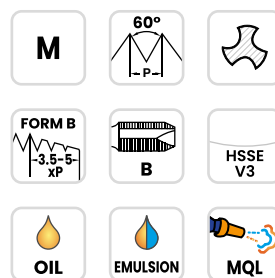
d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M12	1.75	110	18	44	9	10	7	3	10.20	295.060
M16	2	110	20	44	12	12	9	3	14.00	295.070

Cutting parameters

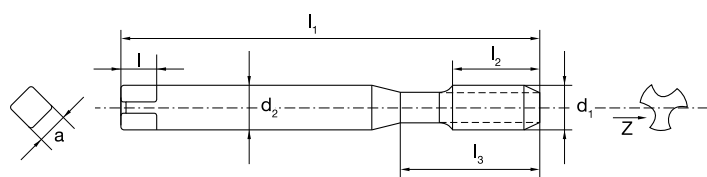
V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 7 - 13	○ 13 - 27	○ 13 - 36	○ 4 - 27	○ 4 - 27	○ 4 - 27	○ 13 - 27
	○ 4 - 13	●●● 9 - 18	○ 13 - 36	●● 4 - 27	●● 4 - 27	●● 4 - 27	●● 9 - 18
	○ 5 - 10	●●● 10 - 15	○ 15 - 40	●● 5 - 20	●● 5 - 20	●● 5 - 20	●● 10 - 15

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Steels < 800 N/mm²

● Technical details

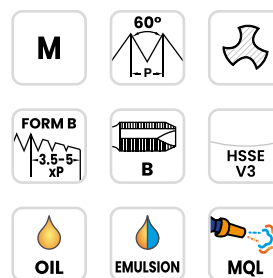
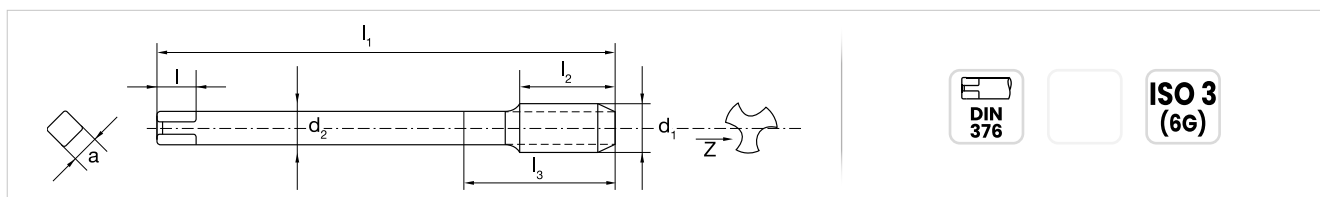


d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M2	0.4	45	8	10	2.8	5	2.1	2	1.60	055.040
M2.5	0.45	50	9	12	2.8	5	2.1	2	2.05	055.055
M3	0.5	56	11	18	3.5	6	2.7	3	2.50	055.065
M4	0.7	63	13	21	4.5	6	3.4	3	3.30	055.075
M5	0.8	70	16	25	6	8	4.9	3	4.20	055.085
M6	1	80	19	30	6	8	4.9	3	5.00	055.090
M8	1.25	90	22	35	8	9	6.2	3	6.80	055.100
M10	1.5	100	24	39	10	11	8	3	8.50	055.110

● Cutting parameters

V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 8 - 15	● ● ● 15 - 30	○ 15 - 40	● ● 5 - 30	● ● 5 - 30	● ● 5 - 30	● ● 15 - 30

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS
For Steels < 800 N/mm²

Technical details

DIN 376
ISO 3 (6G)

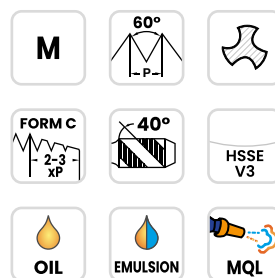
d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M12	1.75	110	28	44	9	10	7	3	10.20	255.060
M16	2	110	32	44	12	12	9	3	14.00	255.070
M20	2.5	140	34	56	16	15	12	3	17.50	255.080

Cutting parameters

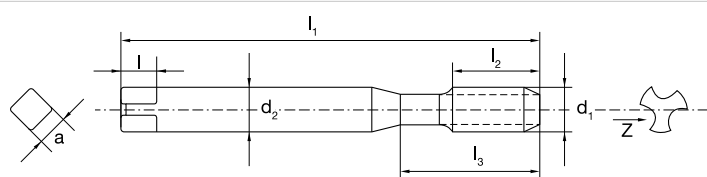
V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 8 - 15	●●● 15 - 30	○ 15 - 40	●● 5 - 30	●● 5 - 30	●● 5 - 30	●● 15 - 30

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Steels < 800 N/mm²

● Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M3	0.5	56	5	18	3.5	6	2.7	3	2.50	110.065
M4	0.7	63	7	21	4.5	6	3.4	3	3.30	110.075
M5	0.8	70	8	25	6	8	4.9	3	4.20	110.085
M6	1	80	10	30	6	8	4.9	3	5.00	110.090
M8	1.25	90	13	35	8	9	6.2	3	6.80	110.100
M10	1.5	100	15	39	10	11	8	3	8.50	110.110
M12	1.75	110	18	45	12	12	9	3	10.20	110.120

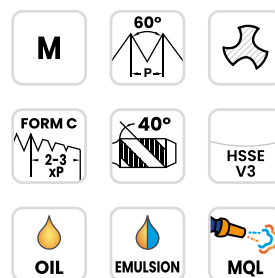
● Cutting parameters

V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 7 - 13	●● 13 - 27	○ 13 - 36	●● 4 - 27	●● 4 - 27	●● 4 - 27	●● 13 - 27
	○ 4 - 13	●●● 9 - 18	○ 13 - 36	●● 4 - 27	●● 4 - 27	●● 4 - 27	●● 9 - 18
	○ 5 - 10	●●● 10 - 15	○ 15 - 40	●● 5 - 20	●● 5 - 20	●● 5 - 20	●● 10 - 15

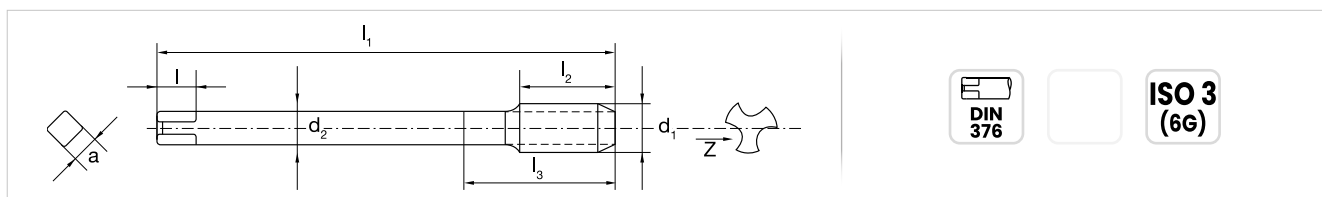
●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Steels < 800 N/mm²



Technical details



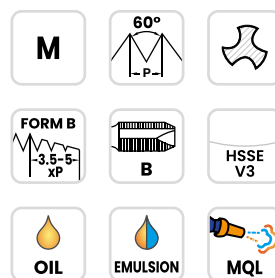
d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	Z	Ø mm	Order code
M12	1.75	110	18	44	9	10	7	3	10.20	310.060
M14	2	110	20	44	11	12	9	3	12.00	310.065
M16	2	110	20	44	12	12	9	3	14.00	310.070
M18	2.5	125	25	50	14	14	11	4	15.50	310.075
M20	2.5	140	25	56	16	15	12	4	17.50	310.080

Cutting parameters

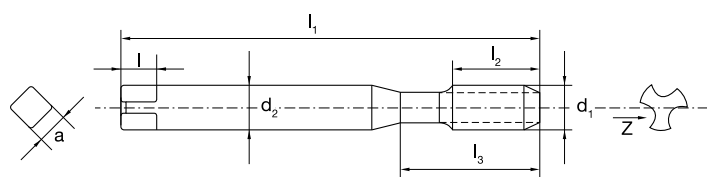
V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 7 - 13	● ● 13 - 27	○ 13 - 36	● ● 4 - 27	● ● 4 - 27	● ● 4 - 27	● ● 13 - 27
	○ 4 - 13	● ● ● 9 - 18	○ 13 - 36	● ● 4 - 27	● ● 4 - 27	● ● 4 - 27	● ● 9 - 18
	○ 5 - 10	● ● ● 10 - 15	○ 15 - 40	● ● 5 - 20	● ● 5 - 20	● ● 5 - 20	● ● 10 - 15

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Steels < 800 N/mm²

● Technical details



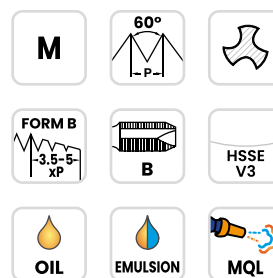
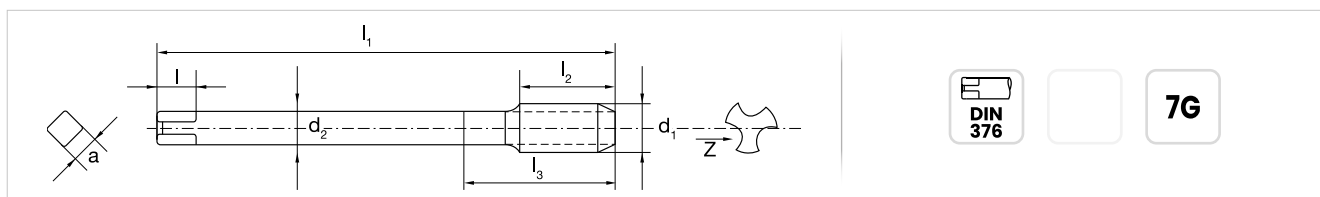
7G

d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M3	0.5	56	11	18	3.5	6	2.7	3	2.50	060.065
M4	0.7	63	13	21	4.5	6	3.4	3	3.30	060.075
M5	0.8	70	16	25	6	8	4.9	3	4.20	060.085
M6	1	80	19	30	6	8	4.9	3	5.00	060.090
M8	1.25	90	22	35	8	9	6.2	3	6.80	060.100
M10	1.5	100	24	39	10	11	8	3	8.50	060.110

● Cutting parameters

V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 8 - 15	● ● ● 15 - 30	○ 15 - 40	● ● 5 - 30	● ● 5 - 30	● ● 5 - 30	● ● 15 - 30

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS
For Steels < 800 N/mm²

Technical details

DIN 376
7G

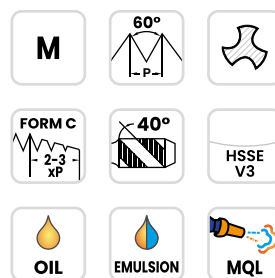
d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	Z	Ø mm	Order code
M12	1.75	110	28	44	9	10	7	3	10.20	260.060
M16	2	110	32	44	12	12	9	3	14.00	260.070
M20	2.5	140	34	56	16	15	12	3	17.50	260.080

Cutting parameters

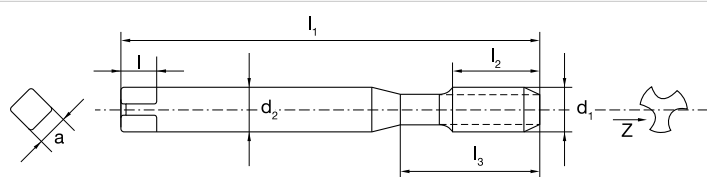
V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 8 - 15	●●● 15 - 30	○ 15 - 40	●● 5 - 30	●● 5 - 30	●● 5 - 30	●● 15 - 30

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Steels < 800 N/mm²

● Technical details



7G

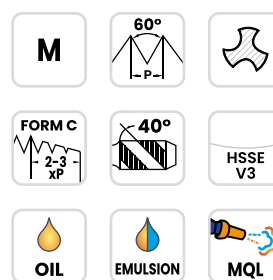
d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M3	0.5	56	5	18	3.5	6	2.7	3	2.50	115.065
M4	0.7	63	7	21	4.5	6	3.4	3	3.30	115.075
M5	0.8	70	8	25	6	8	4.9	3	4.20	115.085
M6	1	80	10	30	6	8	4.9	3	5.00	115.090
M8	1.25	90	13	35	8	9	6.2	3	6.80	115.100
M10	1.5	100	15	39	10	11	8	3	8.50	115.110

● Cutting parameters

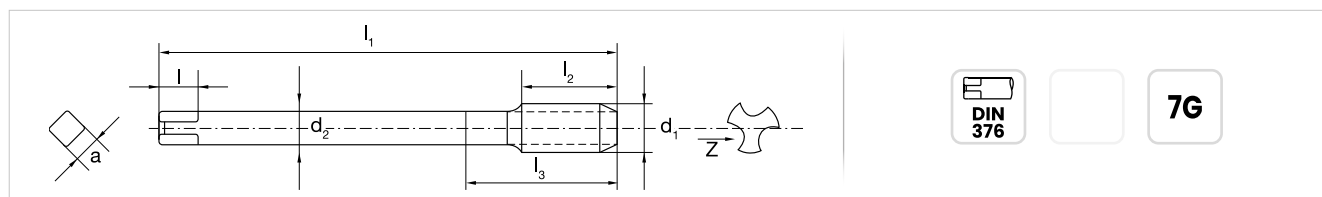
V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 7 - 13	●● 13 - 27	○ 13 - 36	●● 4 - 27	●● 4 - 27	●● 4 - 27	●● 13 - 27
	○ 4 - 13	●●● 9 - 18	○ 13 - 36	●● 4 - 27	●● 4 - 27	●● 4 - 27	●● 9 - 18
	○ 5 - 10	●●● 10 - 15	○ 15 - 40	●● 5 - 20	●● 5 - 20	●● 5 - 20	●● 10 - 15

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Steels < 800 N/mm²

● Technical details

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d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M12	1.75	110	18	44	9	10	7	3	10.20	315.060
M16	2	110	20	44	12	12	9	3	14.00	315.070
M20	2.5	140	25	56	16	15	12	4	17.50	315.080

● Cutting parameters

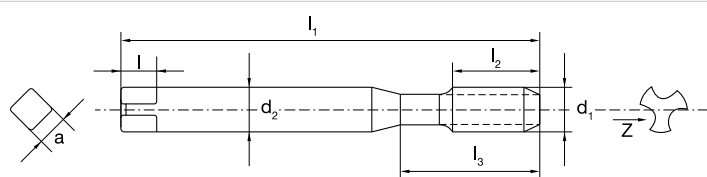
V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 7 - 13	● ● 13 - 27	○ 13 - 36	● ● 4 - 27	● ● 4 - 27	● ● 4 - 27	● ● 13 - 27
	○ 4 - 13	● ● ● 9 - 18	○ 13 - 36	● ● 4 - 27	● ● 4 - 27	● ● 4 - 27	● ● 9 - 18
	○ 5 - 10	● ● ● 10 - 15	○ 15 - 40	● ● 5 - 20	● ● 5 - 20	● ● 5 - 20	● ● 10 - 15

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Steels < 1'300 N/mm²

● Technical details



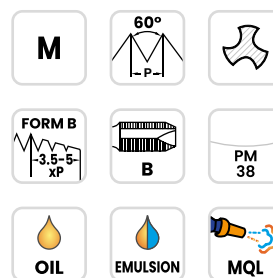
d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M2.5	0.45	50	9	12.5	2.8	5	2.1	2	2.05	830.055
M3	0.5	56	11	18	3.5	6	2.7	3	2.50	830.065
M3.5	0.6	56	12	20	4	6	3	3	2.90	830.070
M4	0.7	63	13	21	4.5	6	3.4	3	3.30	830.075
M5	0.8	70	16	25	6	8	4.9	3	4.20	830.085
M6	1	80	19	30	6	8	4.9	3	5.00	830.090
M8	1.25	90	22	35	8	9	6.2	3	6.80	830.100
M10	1.5	100	24	39	10	11	8	3	8.50	830.110

● Cutting parameters

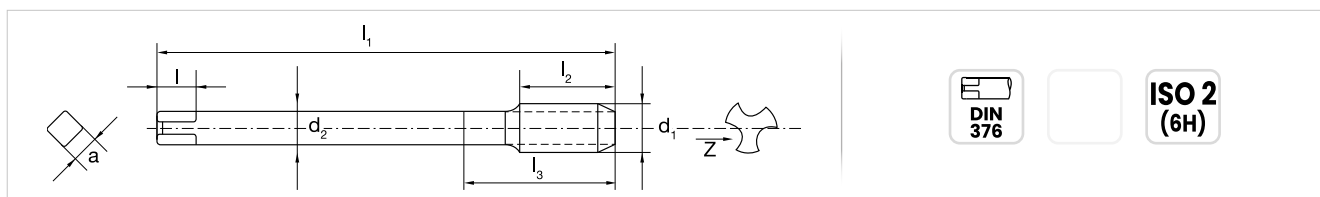
V _c m/min	Ti	Ni	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²	STEEL ≤500 N/mm ²
	○ 2 - 10	○ 2 - 10	●● 8 - 20	●●● 10 - 20	●● 10 - 20	○ 15 - 30	○ 15 - 30

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Steels < 1'300 N/mm²

● Technical details

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d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M12	1.75	110	28	44	9	10	7	3	10.20	831.060
M14	2	110	30	44	11	12	9	3	12.00	831.065
M16	2	110	32	44	12	12	9	4	14.00	831.070
M18	2.5	125	34	50	14	14	11	4	15.50	831.075
M20	2.5	140	34	56	16	15	12	4	17.50	831.080
M22	2.5	140	34	56	18	17	14.5	4	19.50	831.085
M24	3	160	38	64	18	17	14.5	4	21.00	831.090
M27	3	160	38	64	20	19	16	4	24.00	831.095
M30	3.5	180	45	72	22	21	18	4	26.50	831.100

● Cutting parameters

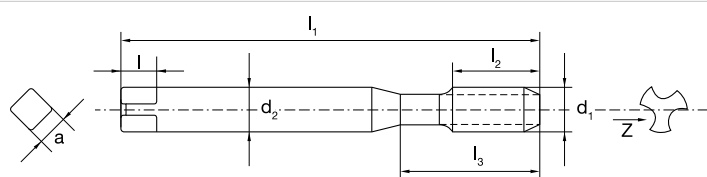
V _c m/min	Ti	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²	STEEL ≤500 N/mm ²
	○ 2 - 10	○ 2 - 10	●● 8 - 20	●●● 10 - 20	●● 10 - 20	○ 15 - 30	○ 15 - 30

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Steels < 1'300 N/mm²

● Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M2.5	0.45	50	9	12.5	2.8	5	2.1	2	2.05	835.055
M3	0.5	56	11	18	3.5	6	2.7	3	2.50	835.065
M3.5	0.6	56	12	20	4	6	3	3	2.90	835.070
M4	0.7	63	13	21	4.5	6	3.4	3	3.30	835.075
M5	0.8	70	16	25	6	8	4.9	3	4.20	835.085
M6	1	80	19	30	6	8	4.9	3	5.00	835.090
M8	1.25	90	22	35	8	9	6.2	3	6.80	835.100
M10	1.5	100	24	39	10	11	8	3	8.50	835.110

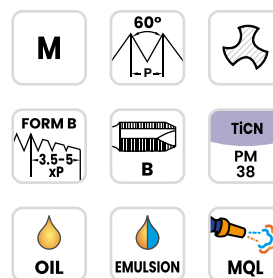
● Cutting parameters

V _c m/min	Ti	Ni	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²	STEEL ≤500 N/mm ²
	○ 2 - 10	○ 2 - 10	●● 8 - 20	●●● 10 - 20	●● 10 - 20	○ 15 - 30	○ 15 - 30

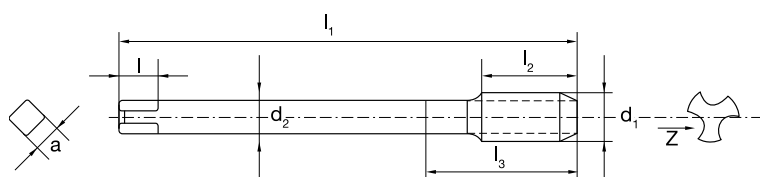
●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Steels < 1'300 N/mm²



Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M12	1.75	110	28	44	9	10	7	3	10.20	836.060
M14	2	110	30	44	11	12	9	3	12.00	836.065
M16	2	110	32	44	12	12	9	4	14.00	836.070
M18	2.5	125	34	50	14	14	11	4	15.50	836.075
M20	2.5	140	34	56	16	15	12	4	17.50	836.080
M22	2.5	140	34	56	18	17	14.5	4	19.50	836.085
M24	3	160	38	64	18	17	14.5	4	21.00	836.090
M27	3	160	38	64	20	19	16	4	24.00	836.095
M30	3.5	180	45	72	22	21	18	4	26.50	836.100

Cutting parameters

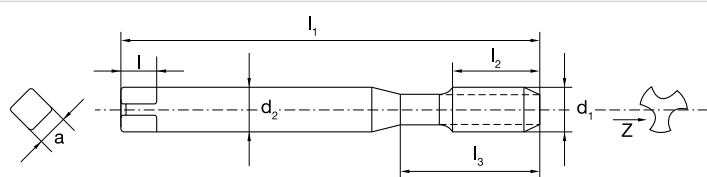
V _c m/min	Ti	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²	STEEL ≤500 N/mm ²
	○ 2 - 10	○ 2 - 10	●● 8 - 20	●●● 10 - 20	●● 10 - 20	○ 15 - 30	○ 15 - 30

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Steels < 1'300 N/mm²

● Technical details



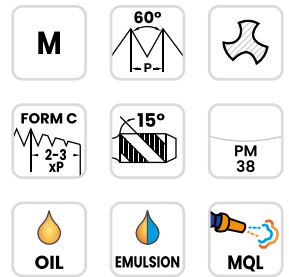
d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M2.5	0.45	50	9	12.5	2.8	5	2.1	2	2.05	840.055
M3	0.5	56	5	18	3.5	6	2.7	3	2.50	840.065
M3.5	0.6	56	6	20	4	6	3	3	2.90	840.070
M4	0.7	63	7	21	4.5	6	3.4	3	3.30	840.075
M5	0.8	70	8	25	6	8	4.9	3	4.20	840.085
M6	1	80	10	30	6	8	4.9	3	5.00	840.090
M8	1.25	90	13	35	8	9	6.2	3	6.80	840.100
M10	1.5	100	15	39	10	11	8	3	8.50	840.110

● Cutting parameters

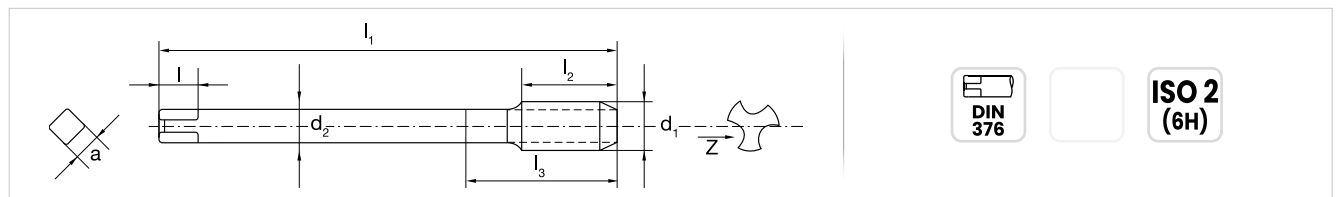
V _c m/min	Ti	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²	STEEL ≤500 N/mm ²
	○ 1 - 9	○ 1 - 9	●● 7 - 18	●●●● 9 - 18	●● 9 - 18	○ 13 - 27	○ 13 - 27
	○ 1 - 6	○ 1 - 6	●● 4 - 13	●●●● 9 - 18	●● 9 - 18	○ 9 - 18	○ 9 - 18
	○ 2 - 7	○ 2 - 5	●● 5 - 10	●●●● 8 - 15	●● 8 - 15	○ 10 - 20	○ 10 - 20

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Steels < 1'300 N/mm²

● Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	Z	Ø mm	Order code
M12	1.75	110	18	44	9	10	7	3	10.20	841.060
M14	2	110	20	44	11	12	9	3	12.00	841.065
M16	2	110	20	44	12	12	9	3	14.00	841.070
M18	2.5	125	25	50	14	14	11	4	15.50	841.075
M20	2.5	140	25	56	16	15	12	4	17.50	841.080
M22	2.5	140	25	56	18	17	14.5	4	19.50	841.085
M24	3	160	30	64	18	17	14.5	4	21.00	841.090
M27	3	160	30	64	20	19	16	4	24.00	841.095
M30	3.5	180	35	72	22	21	18	4	26.50	841.100

● Cutting parameters

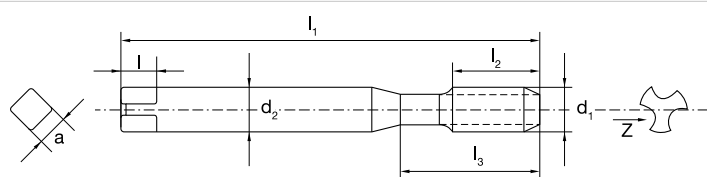
V _c m/min	Ti	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²	STEEL ≤500 N/mm ²
	○ 1 - 9	○ 1 - 9	●● 7 - 18	●●● 9 - 18	●● 9 - 18	○ 13 - 27	○ 13 - 27
	○ 1 - 6	○ 1 - 6	●● 4 - 13	●●● 9 - 18	●● 9 - 18	○ 9 - 18	○ 9 - 18
	○ 2 - 7	○ 2 - 5	●● 5 - 10	●●● 8 - 15	●● 8 - 15	○ 10 - 20	○ 10 - 20

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Steels < 1'300 N/mm²

● Technical details



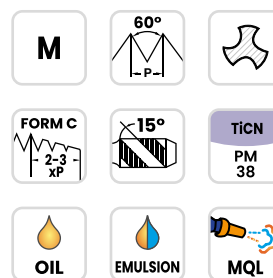
d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M2.5	0.45	50	9	12.5	2.8	5	2.1	2	2.05	845.055
M3	0.5	56	5	18	3.5	6	2.7	3	2.50	845.065
M3.5	0.6	56	6	20	4	6	3	3	2.90	845.070
M4	0.7	63	7	21	4.5	6	3.4	3	3.30	845.075
M5	0.8	70	8	25	6	8	4.9	3	4.20	845.085
M6	1	80	10	30	6	8	4.9	3	5.00	845.090
M8	1.25	90	13	35	8	9	6.2	3	6.80	845.100
M10	1.5	100	15	39	10	11	8	3	8.50	845.110

● Cutting parameters

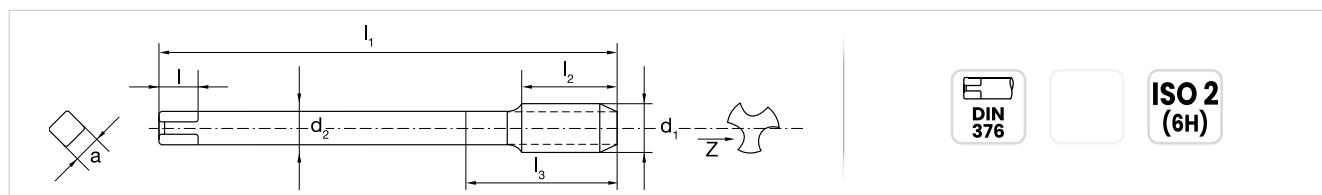
V _c m/min	Ti	Ni	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²	STEEL ≤500 N/mm ²
	○ 1 - 9	○ 1 - 9	●● 7 - 18	●●●● 9 - 18	●● 9 - 18	○ 13 - 27	○ 13 - 27
	○ 1 - 6	○ 1 - 6	●● 4 - 13	●●●● 9 - 18	●● 9 - 18	○ 9 - 18	○ 9 - 18
	○ 2 - 7	○ 2 - 5	●● 5 - 10	●●●● 8 - 15	●● 8 - 15	○ 10 - 20	○ 10 - 20

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Steels < 1'300 N/mm²

● Technical details



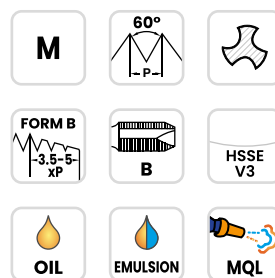
d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	Z	Ø mm	Order code
M12	1.75	110	18	44	9	10	7	3	10.20	846.060
M14	2	110	20	44	11	12	9	3	12.00	846.065
M16	2	110	20	44	12	12	9	3	14.00	846.070
M18	2.5	125	25	50	14	14	11	4	15.50	846.075
M20	2.5	140	25	56	16	15	12	4	17.50	846.080
M22	2.5	140	25	56	18	17	14.5	4	19.50	846.085
M24	3	160	30	64	18	17	14.5	4	21.00	846.090
M27	3	160	30	64	20	19	16	4	24.00	846.095
M30	3.5	180	35	72	22	21	18	4	26.50	846.100

● Cutting parameters

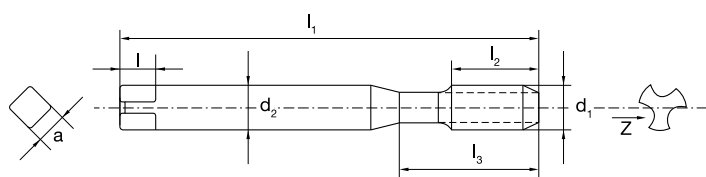
V _c m/min	Ti	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²	STEEL ≤500 N/mm ²
	○ 1 - 9	○ 1 - 9	●● 7 - 18	●●● 9 - 18	●● 9 - 18	○ 13 - 27	○ 13 - 27
	○ 1 - 6	○ 1 - 6	●● 4 - 13	●●● 9 - 18	●● 9 - 18	○ 9 - 18	○ 9 - 18
	○ 2 - 7	○ 2 - 5	●● 5 - 10	●●● 8 - 15	●● 8 - 15	○ 10 - 20	○ 10 - 20

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²

● Technical details



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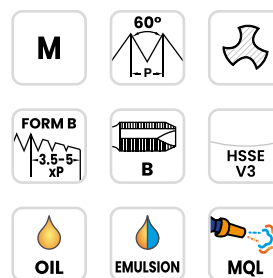
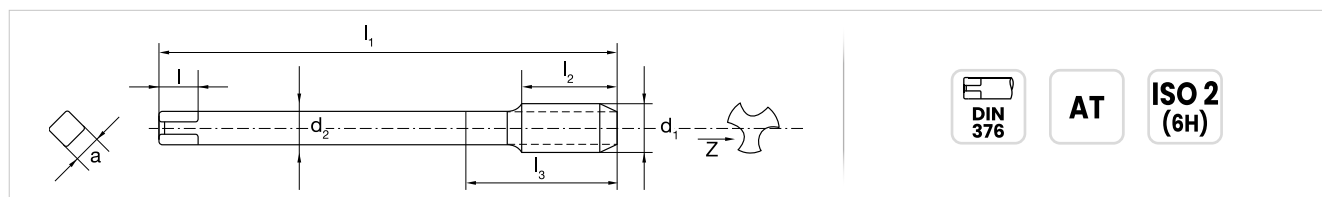
ISO 2
(6H)

d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M2	0.4	45	8	10	2.8	5	2.1	2	1.60	150.040
M2.5	0.45	50	9	12.5	2.8	5	2.1	2	2.05	150.055
M3	0.5	56	11	18	3.5	6	2.7	3	2.50	150.065
M4	0.7	63	13	21	4.5	6	3.4	3	3.30	150.075
M5	0.8	70	16	25	6	8	4.9	3	4.20	150.085
M6	1	80	19	30	6	8	4.9	3	5.00	150.090
M8	1.25	90	22	35	8	9	6.2	3	6.80	150.100
M10	1.5	100	24	39	10	11	8	3	8.50	150.110

● Cutting parameters

V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 2 - 10	● ● 2 - 4	● ● 2 - 10	● ● ● ● 8 - 20	○ 10 - 20	● ● 10 - 20	● ● 15 - 30

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS
For Stainless Steels < 1'200 N/mm²

Technical details


d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	Z	Ø mm	Order code
M12	1.75	110	28	44	9	10	7	3	10.20	350.060
M14	2	110	30	44	11	12	9	3	12.00	350.065
M16	2	110	32	44	12	12	9	3	14.00	350.070
M18	2.5	125	34	50	14	14	11	3	15.50	350.075
M20	2.5	140	34	56	16	15	12	3	17.50	350.080

Cutting parameters

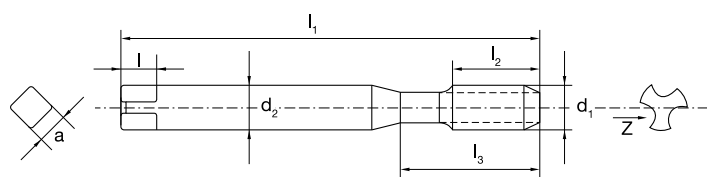
V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 2 - 10	● ● 2 - 4	● ● 2 - 10	● ● ● ● 8 - 20	○ 10 - 20	● ● 10 - 20	● ● 15 - 30

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²

● Technical details



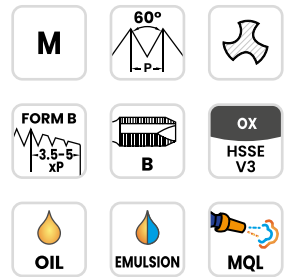
d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M2	0.4	45	8	10	2.8	5	2.1	2	1.60	120.040
M2.5	0.45	50	9	12.5	2.8	5	2.1	2	2.05	120.055
M3	0.5	56	11	18	3.5	6	2.7	3	2.50	120.065
M3.5	0.6	56	12	20	4	6	3	3	2.90	120.070
M4	0.7	63	13	21	4.5	6	3.4	3	3.30	120.075
M5	0.8	70	16	25	6	8	4.9	3	4.20	120.085
M6	1	80	19	30	6	8	4.9	3	5.00	120.090
M8	1.25	90	22	35	8	9	6.2	3	6.80	120.100
M10	1.5	100	24	39	10	11	8	3	8.50	120.110
M12	1.75	110	28	45	12	12	9	3	10.20	120.120

● Cutting parameters

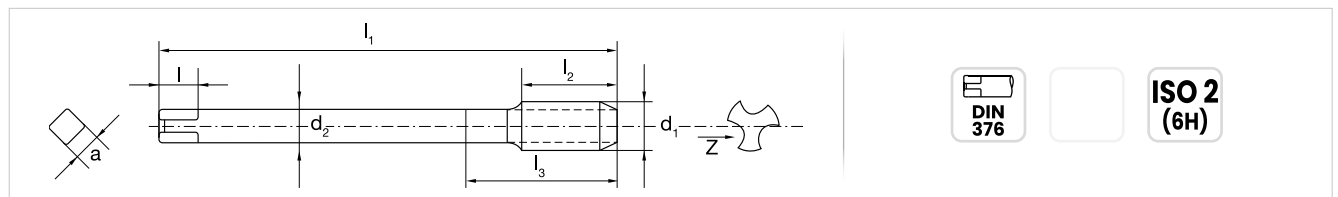
V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 2 - 10	● ● 2 - 4	● ● 2 - 10	● ● ● ● 8 - 20	○ 10 - 20	● ● 10 - 20	● ● 15 - 30

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²

● Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø  mm	Order code
M3	0.5	56	11	56	11	5	2.5	3	2.50	320.005
M3.5	0.6	56	12	56	2.5	5	2.1	3	2.90	320.010
M4	0.7	63	13	25.2	2.8	5	2.1	3	3.30	320.015
M5	0.8	70	16	28	3.5	6	2.7	3	4.20	320.025
M6	1	80	19	32	4.5	6	3.4	3	5.00	320.030
M8	1.25	90	22	36	6	8	4.9	3	6.80	320.040
M10	1.5	100	24	40	7	8	5.5	3	8.50	320.050
M12	1.75	110	28	44	9	10	7	3	10.20	320.060
M14	2	110	30	44	11	12	9	3	12.00	320.065
M16	2	110	32	44	12	12	9	3	14.00	320.070
M18	2.5	125	34	50	14	14	11	3	15.50	320.075
M20	2.5	140	34	56	16	15	12	3	17.50	320.080
M22	2.5	140	34	56	18	17	14.5	3	19.50	320.085
M24	3	160	38	64	18	17	14.5	3	21.00	320.090
M27	3	160	38	64	20	19	16	4	24.00	320.095
M30	3.5	180	45	72	22	21	18	4	26.50	320.100
M33	3.5	180	50	72	25	23	20	4	29.50	320.105
M36	4	200	56	80	28	25	22	4	32.00	320.110

● Cutting parameters

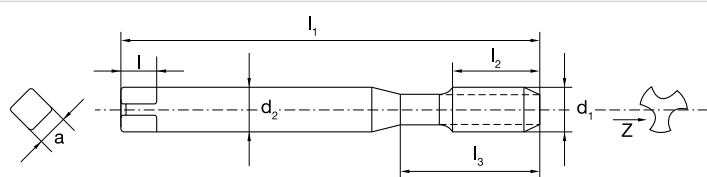
V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 2 - 10	● ● 2 - 4	● ● 2 - 10	● ● ● ● 8 - 20	○ 10 - 20	● ● 10 - 20	● ● 15 - 30

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²

● Technical details



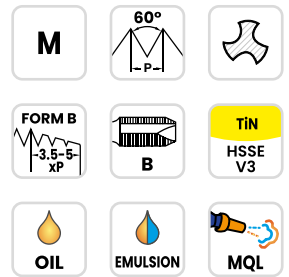
d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M3	0.5	56	11	18	3.5	6	2.7	3	2.50	130.065
M4	0.7	63	13	21	4.5	6	3.4	3	3.30	130.075
M5	0.8	70	16	25	6	8	4.9	3	4.20	130.085
M6	1	80	19	30	6	8	4.9	3	5.00	130.090
M8	1.25	90	22	35	8	9	6.2	3	6.80	130.100
M10	1.5	100	24	39	10	11	8	3	8.50	130.110

● Cutting parameters

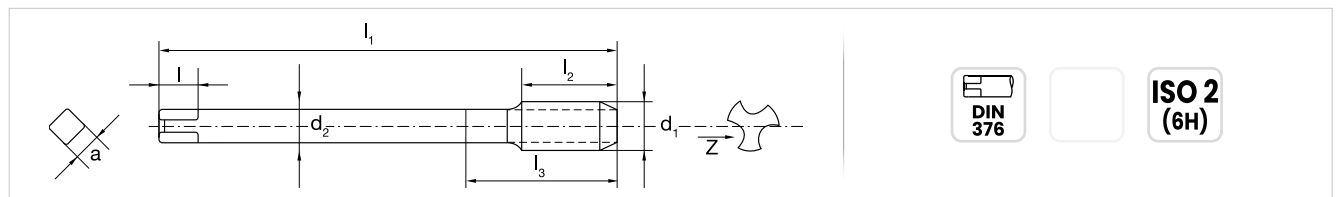
V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 2 - 10	● ● 2 - 4	● ● 2 - 10	● ● ● ● 8 - 20	○ 10 - 20	● ● 10 - 20	● ● 15 - 30

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²

● Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø/mm	Order code
M3	0.5	56	11	22	2.2	5	2.5	3	2.50	330.005
M4	0.7	63	13	25.2	2.8	5	2.1	3	3.30	330.015
M5	0.8	70	16	28	3.5	6	2.7	3	4.20	330.025
M6	1	80	19	32	4.5	6	3.4	3	5.00	330.030
M8	1.25	90	22	36	6	8	4.9	3	6.80	330.040
M10	1.5	100	24	40	7	8	5.5	3	8.50	330.050
M12	1.75	110	28	44	9	10	7	3	10.20	330.060
M14	2	110	30	44	11	12	9	3	12.00	330.065
M16	2	110	32	44	12	12	9	3	14.00	330.070
M18	2.5	125	34	50	14	14	11	3	15.50	330.075
M20	2.5	140	34	56	16	15	12	3	17.50	330.080
M22	2.5	140	34	56	18	17	14.5	3	19.50	330.085
M24	3	160	38	64	18	17	14.5	3	21.00	330.090
M27	3	160	38	64	20	19	16	4	24.00	330.095
M30	3.5	180	45	72	22	21	18	4	26.50	330.100
M33	3.5	180	50	72	25	23	20	4	29.50	330.105
M36	4	200	56	80	28	25	22	4	32.00	330.110

● Cutting parameters

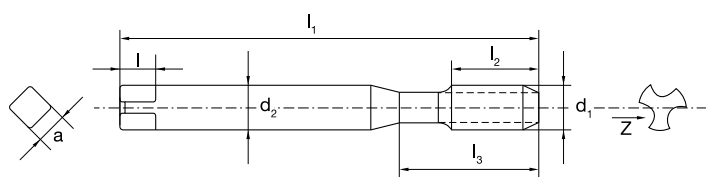
V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 2 - 10	● ● 2 - 4	● ● 2 - 10	● ● ● ● 8 - 20	○ 10 - 20	● ● 10 - 20	● ● 15 - 30

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²

● Technical details



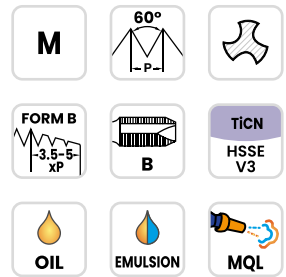
d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M3	0.5	56	11	18	3.5	6	2.7	3	2.50	135.065
M4	0.7	63	13	21	4.5	6	3.4	3	3.30	135.075
M5	0.8	70	16	25	6	8	4.9	3	4.20	135.085
M6	1	80	19	30	6	8	4.9	3	5.00	135.090
M8	1.25	90	22	35	8	9	6.2	3	6.80	135.100
M10	1.5	100	24	39	10	11	8	3	8.50	135.110

● Cutting parameters

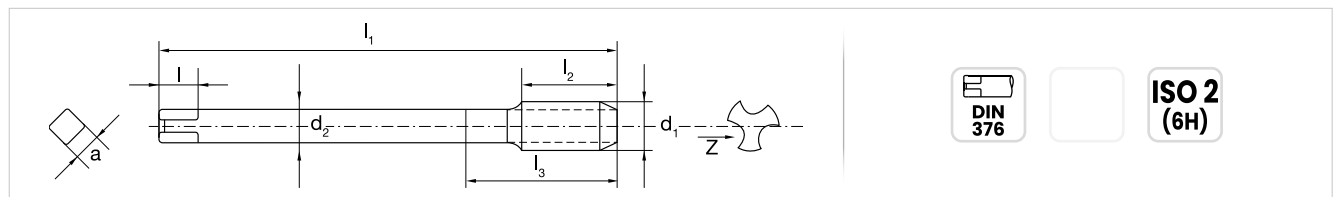
V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 2 - 10	● ● 2 - 4	● ● 2 - 10	● ● ● ● 8 - 20	○ 10 - 20	● ● 10 - 20	● ● 15 - 30

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²

● Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M12	1.75	110	28	44	9	10	7	3	10.20	335.060
M14	2	110	30	44	11	12	9	3	12.00	335.065
M16	2	110	32	44	12	12	9	3	14.00	335.070
M18	2.5	125	34	50	14	14	11	3	15.50	335.075
M20	2.5	140	34	56	16	15	12	3	17.50	335.080
M22	2.5	140	34	56	18	17	14.5	3	19.50	335.085
M24	3	160	38	64	18	17	14.5	3	21.00	335.090
M27	3	160	38	64	20	19	16	4	24.00	335.095
M30	3.5	180	45	72	22	21	18	4	26.50	335.100
M33	3.5	180	50	72	25	23	20	4	29.50	335.105
M36	4	200	56	80	28	25	22	4	32.00	335.110

● Cutting parameters

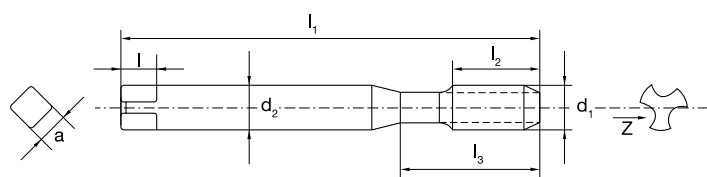
V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 2 - 10	● ● 2 - 4	● ● 2 - 10	● ● ● ● 8 - 20	○ 10 - 20	● ● 10 - 20	● ● 15 - 30

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²

● Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M3	0.5	56	11	18	3.5	6	2.7	3	2.50	870.065
M4	0.7	63	13	21	4.5	6	3.4	3	3.30	870.075
M5	0.8	70	16	25	6	8	4.9	3	4.20	870.085
M6	1	80	19	30	6	8	4.9	3	5.00	870.090
M8	1.25	90	22	35	8	9	6.2	3	6.80	870.100
M10	1.5	100	24	39	10	11	8	3	8.50	870.110

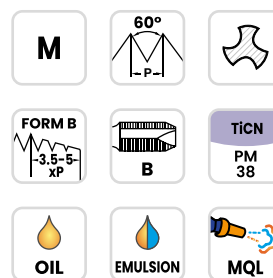
● Cutting parameters

V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 2 - 10	● ● 2 - 4	● ● 2 - 10	● ● ● ● 8 - 20	○ 10 - 20	● ● 10 - 20	● ● 15 - 30

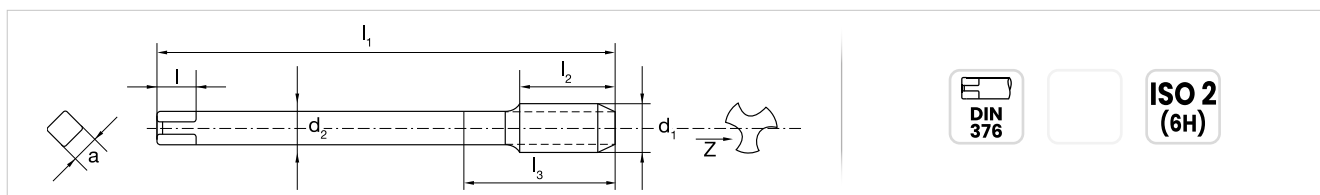
● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²



Technical details



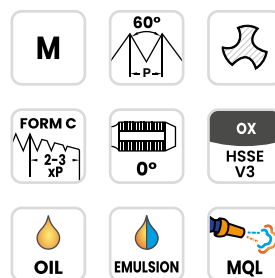
d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M12	1.75	110	28	44	9	10	7	3	10.20	871.060
M16	2	110	32	44	12	12	9	4	14.00	871.070
M20	2.5	140	34	56	16	15	12	4	17.50	871.080

Cutting parameters

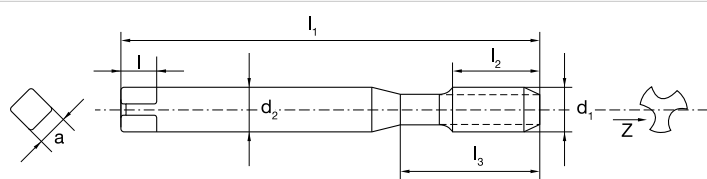
V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 2 - 10	● ● 2 - 4	● ● 2 - 10	● ● ● ● 8 - 20	○ 10 - 20	● ● 10 - 20	● ● 15 - 30

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²

● Technical details

ISO 2
(6H)

d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M2	0.4	45	8	10	2.8	5	2.1	3	1.60	125.040
M2.5	0.45	50	9	12.5	2.8	5	2.1	3	2.05	125.055
M3	0.5	56	11	18	3.5	6	2.7	3	2.50	125.065
M4	0.7	63	13	21	4.5	6	3.4	3	3.30	125.075
M5	0.8	70	16	25	6	8	4.9	3	4.20	125.085
M6	1	80	19	30	6	8	4.9	3	5.00	125.090
M8	1.25	90	22	35	8	9	6.2	4	6.80	125.100
M10	1.5	100	24	39	10	11	8	4	8.50	125.110

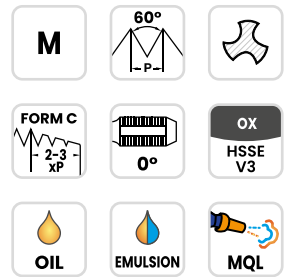
● Cutting parameters

V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 1 - 8	● ● 1 - 3	● ● 1 - 8	● ● ● ● 5 - 16	○ 7 - 16	● ● 7 - 16	● ● 10 - 24
	● ● 1 - 5	● ● 1 - 3	● ● 1 - 5	● ● ● ● 4 - 12	○ 9 - 16	● ● 9 - 16	● ● 9 - 16
	● ● 2 - 7	● ● 2 - 4	● ● 2 - 5	● ● ● ● 5 - 15	○ 8 - 15	● ● 8 - 15	● ● 10 - 20

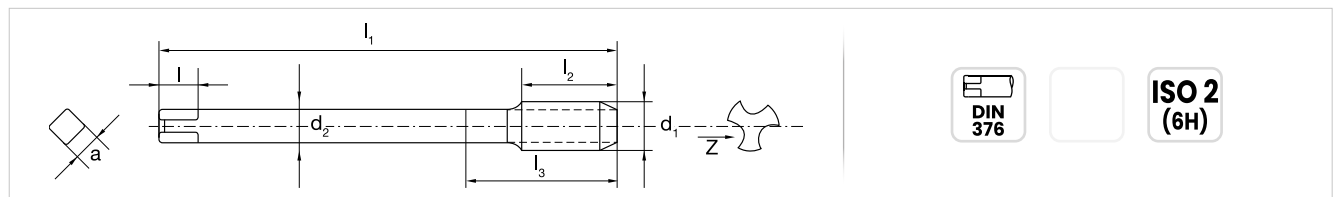
● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²



Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø/mm	Order code
M12	1.75	110	28	44	9	10	7	4	10.20	325.060
M14	2	110	30	44	11	12	9	4	12.00	325.065
M16	2	110	32	44	12	12	9	4	14.00	325.070
M18	2.5	125	34	50	14	14	11	4	15.50	325.075
M20	2.5	140	34	56	16	15	12	4	17.50	325.080
M22	2.5	140	34	56	18	17	14.5	4	19.50	325.085
M24	3	160	38	64	18	17	14.5	4	21.00	325.090

Cutting parameters

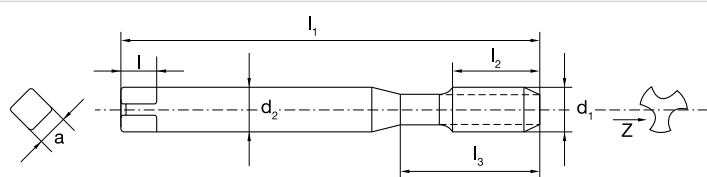
V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 1 - 8	● ● 1 - 3	● ● 1 - 8	● ● ● 5 - 16	○ 7 - 16	● ● 7 - 16	● ● 10 - 24
	● ● 1 - 5	● ● 1 - 3	● ● 1 - 5	● ● ● 4 - 12	○ 9 - 16	● ● 9 - 16	● ● 9 - 16
	● ● 2 - 7	● ● 2 - 4	● ● 2 - 5	● ● ● 5 - 15	○ 8 - 15	● ● 8 - 15	● ● 10 - 20

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²

● Technical details



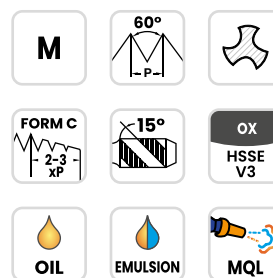
d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M3	0.5	56	5	18	3.5	6	2.7	3	2.50	155.065
M4	0.7	63	7	21	4.5	6	3.4	3	3.30	155.075
M5	0.8	70	8	25	6	8	4.9	3	4.20	155.085
M6	1	80	10	30	6	8	4.9	3	5.00	155.090
M8	1.25	90	13	35	8	9	6.2	3	6.80	155.100
M10	1.5	100	15	39	10	11	8	3	8.50	155.110

● Cutting parameters

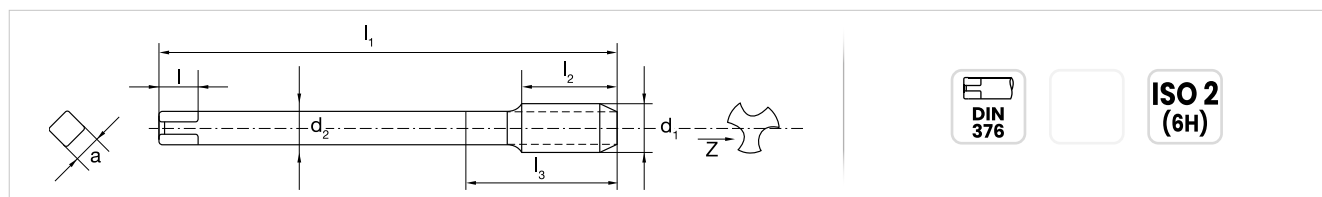
V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 1 - 9	● ● 1 - 3	● ● 1 - 9	● ● ● ● 7 - 18	○ 9 - 18	● ● 9 - 18	● ● 13 - 27
	● ● 1 - 6	● ● 1 - 3	● ● 1 - 6	● ● ● ● 4 - 13	○ 9 - 18	● ● 9 - 18	● ● 9 - 18
	● ● 2 - 7	● ● 2 - 4	● ● 2 - 5	● ● ● ● 5 - 15	○ 8 - 15	● ● 8 - 15	● ● 10 - 20

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²

● Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M12	1.75	110	18	44	9	10	7	3	10.20	355.060
M14	2	110	20	44	11	12	9	3	12.00	355.065
M16	2	110	20	44	12	12	9	3	14.00	355.070
M18	2.5	125	25	50	14	14	11	4	15.50	355.075
M20	2.5	140	25	56	16	15	12	4	17.50	355.080
M22	2.5	140	25	56	18	17	14.5	4	19.50	355.085
M24	3	160	30	64	18	17	14.5	4	21.00	355.090
M27	3	160	30	64	20	19	16	4	24.00	355.095
M30	3.5	180	35	72	22	21	18	4	26.50	355.100
M33	3.5	180	35	72	25	23	20	4	29.50	355.105
M36	4	200	40	80	28	25	22	4	32.00	355.110

● Cutting parameters

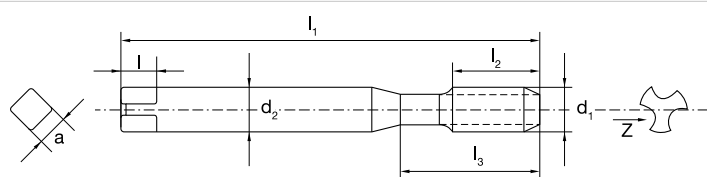
V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 1 - 9	● ● 1 - 3	● ● 1 - 9	● ● ● ● 7 - 18	○ 9 - 18	● ● 9 - 18	● ● 13 - 27
	● ● 1 - 6	● ● 1 - 3	● ● 1 - 6	● ● ● ● 4 - 13	○ 9 - 18	● ● 9 - 18	● ● 9 - 18
	● ● 2 - 7	● ● 2 - 4	● ● 2 - 5	● ● ● ● 5 - 15	○ 8 - 15	● ● 8 - 15	● ● 10 - 20

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²

● Technical details



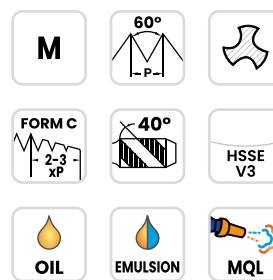
d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M3	0.5	56	5	18	3.5	6	2.7	3	2.50	180.065
M4	0.7	63	7	21	4.5	6	3.4	3	3.30	180.075
M5	0.8	70	8	25	6	8	4.9	3	4.20	180.085
M6	1	80	10	30	6	8	4.9	3	5.00	180.090
M8	1.25	90	13	35	8	9	6.2	3	6.80	180.100
M10	1.5	100	15	39	10	11	8	3	8.50	180.110

● Cutting parameters

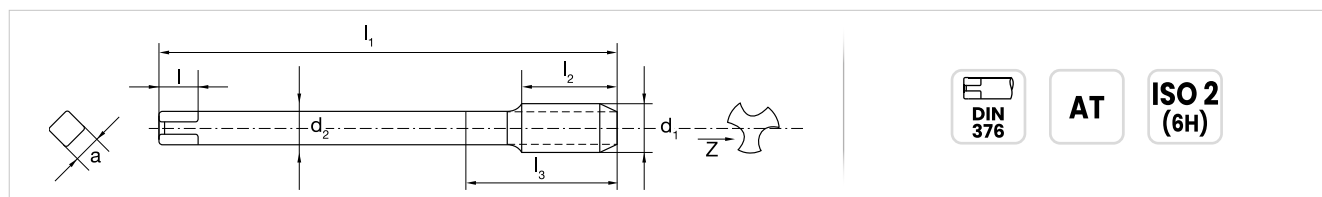
V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 1 - 9	● ● 1 - 3	● ● 1 - 9	● ● 7 - 18	○ 9 - 18	● ● 9 - 18	● ● 13 - 27
	● ● 1 - 6	● ● 1 - 3	● ● 1 - 6	● ● ● 4 - 13	○ 9 - 18	● ● 9 - 18	● ● 9 - 18
	● ● 2 - 7	● ● 2 - 4	● ● 2 - 5	● ● ● 5 - 15	○ 8 - 15	● ● 8 - 15	● ● 10 - 20

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²

● Technical details

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d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M12	1.75	110	18	44	9	10	7	4	10.20	380.060
M16	2	110	20	44	12	12	9	4	14.00	380.070
M20	2.5	140	25	56	16	15	12	4	17.50	380.080

● Cutting parameters

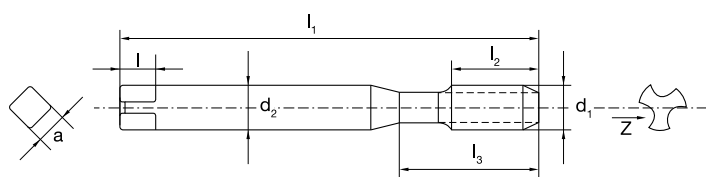
V _c m/min	Ti 900-1500 N/mm ²	NI 900-1500 N/mm ²	NI 900-1500 N/mm ²	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 1 - 9	● ● 1 - 3	● ● 1 - 9	● ● 7 - 18	○ 9 - 18	● ● 9 - 18	● ● 13 - 27
	● ● 1 - 6	● ● 1 - 3	● ● 1 - 6	● ● ● 4 - 13	○ 9 - 18	● ● 9 - 18	● ● 9 - 18
	● ● 2 - 7	● ● 2 - 4	● ● 2 - 5	● ● ● 5 - 15	○ 8 - 15	● ● 8 - 15	● ● 10 - 20

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²

● Technical details



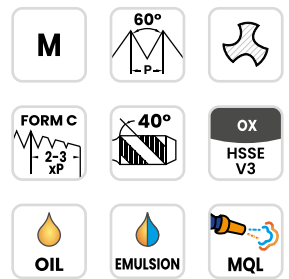
d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M2	0.4	45	8	10	2.8	5	2.1	2	1.60	160.040
M2.5	0.45	50	9	12.5	2.8	5	2.1	2	2.05	160.055
M3	0.5	56	5	18	3.5	6	2.7	3	2.50	160.065
M3.5	0.6	56	6	20	4	6	3	3	2.90	160.070
M4	0.7	63	7	21	4.5	6	3.4	3	3.30	160.075
M5	0.8	70	8	25	6	8	4.9	3	4.20	160.085
M6	1	80	10	30	6	8	4.9	3	5.00	160.090
M8	1.25	90	13	35	8	9	6.2	3	6.80	160.100
M10	1.5	100	15	39	10	11	8	3	8.50	160.110
M12	1.75	110	18	45	12	12	9	4	10.20	160.120

● Cutting parameters

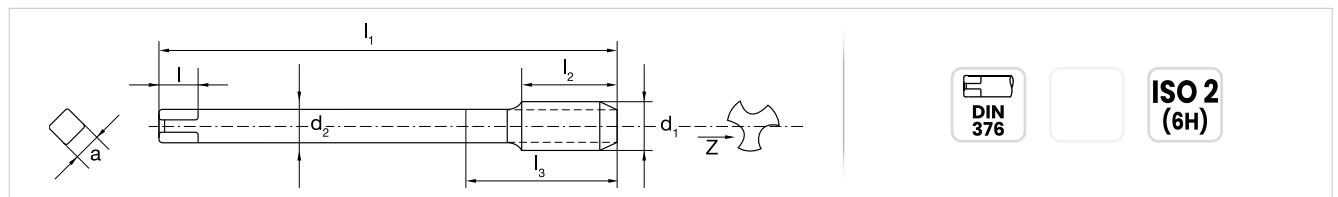
V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 1 - 9	● ● 1 - 3	● ● 1 - 9	● ● 7 - 18	○ 9 - 18	● ● 9 - 18	● ● 13 - 27
	● ● 1 - 6	● ● 1 - 3	● ● 1 - 6	● ● ● 4 - 13	○ 9 - 18	● ● 9 - 18	● ● 9 - 18
	● ● 2 - 7	● ● 2 - 4	● ● 2 - 5	● ● ● 5 - 15	○ 8 - 15	● ● 8 - 15	● ● 10 - 20

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²

● Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø/mm	Order code
M3	0.5	56	5	22	2.2	5	5	3	2.50	360.005
M3.5	0.6	56	6	22	2.5	5	2.1	3	2.90	360.010
M4	0.7	63	7	25.2	2.8	5	2.1	3	3.30	360.015
M5	0.8	70	8	28	3.5	6	2.7	3	4.20	360.025
M6	1	80	10	32	4.5	6	3.4	3	5.00	360.030
M8	1.25	90	13	36	6	8	4.9	3	6.80	360.040
M10	1.5	100	15	40	7	8	5.5	3	8.50	360.050
M12	1.75	110	18	44	9	10	7	4	10.20	360.060
M14	2	110	20	44	11	12	9	4	12.00	360.065
M16	2	110	20	44	12	12	9	4	14.00	360.070
M18	2.5	125	25	50	14	14	11	4	15.50	360.075
M20	2.5	140	25	56	16	15	12	4	17.50	360.080
M22	2.5	140	25	56	18	17	14.5	4	19.50	360.085
M24	3	160	30	64	18	17	14.5	4	21.00	360.090
M27	3	160	30	64	20	19	16	4	24.00	360.095
M30	3.5	180	35	72	22	21	18	5	26.50	360.100
M33	3.5	180	35	72	25	23	20	5	29.50	360.105
M36	4	200	40	80	28	25	22	5	32.00	360.110

● Cutting parameters

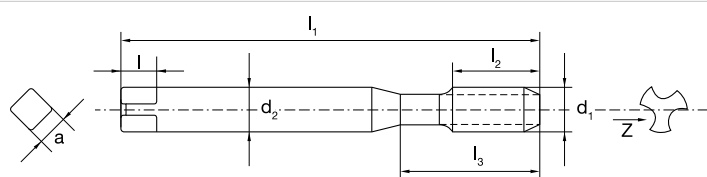
V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 1 - 9	● ● 1 - 3	● ● 1 - 9	● ● 7 - 18	○ 9 - 18	● ● 9 - 18	● ● 13 - 27
	● ● 1 - 6	● ● 1 - 3	● ● 1 - 6	● ● ● 4 - 13	○ 9 - 18	● ● 9 - 18	● ● 9 - 18
	● ● 2 - 7	● ● 2 - 4	● ● 2 - 5	● ● ● 5 - 15	○ 8 - 15	● ● 8 - 15	● ● 10 - 20

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²

● Technical details

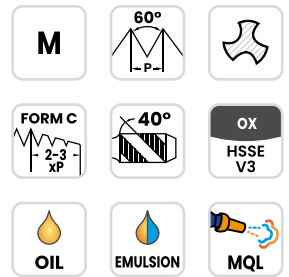
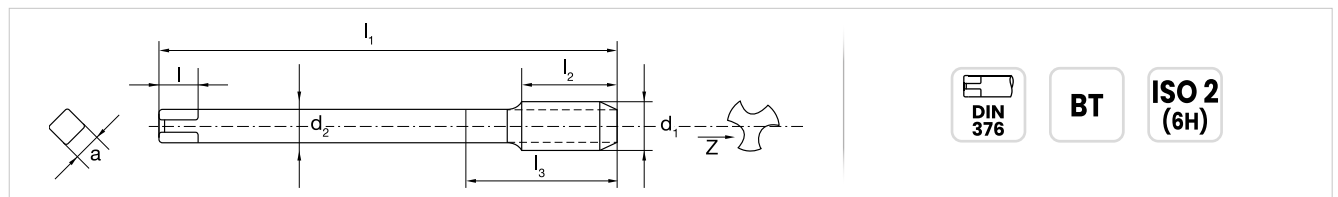


d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M3	0.5	56	5	18	3.5	6	2.7	3	2.50	165.065
M4	0.7	63	7	21	4.5	6	3.4	3	3.30	165.075
M5	0.8	70	8	25	6	8	4.9	3	4.20	165.085
M6	1	80	10	30	6	8	4.9	3	5.00	165.090
M8	1.25	90	13	35	8	9	6.2	3	6.80	165.100
M10	1.5	100	15	39	10	11	8	3	8.50	165.110

● Cutting parameters

V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 1 - 9	● ● 1 - 3	● ● 1 - 9	● ● 7 - 18	○ 9 - 18	● ● 9 - 18	● ● 13 - 27
	● ● 1 - 6	● ● 1 - 3	● ● 1 - 6	● ● ● 4 - 13	○ 9 - 18	● ● 9 - 18	● ● 9 - 18
	● ● 2 - 7	● ● 2 - 4	● ● 2 - 5	● ● ● 5 - 15	○ 8 - 15	● ● 8 - 15	● ● 10 - 20

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS
For Stainless Steels < 1'200 N/mm²

Technical details


d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M12	1.75	110	18	44	9	10	7	4	10.20	365.060
M14	2	110	20	44	11	12	9	4	12.00	365.065
M16	2	110	20	44	12	12	9	4	14.00	365.070
M20	2.5	140	25	56	16	15	12	4	17.50	365.080

Cutting parameters

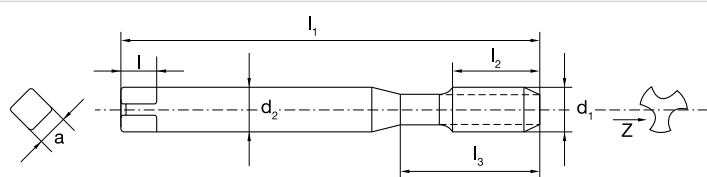
V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 1 - 9	● ● 1 - 3	● ● 1 - 9	● ● 7 - 18	○ 9 - 18	● ● 9 - 18	● ● 13 - 27
	● ● 1 - 6	● ● 1 - 3	● ● 1 - 6	● ● ● 4 - 13	○ 9 - 18	● ● 9 - 18	● ● 9 - 18
	● ● 2 - 7	● ● 2 - 4	● ● 2 - 5	● ● ● 5 - 15	○ 8 - 15	● ● 8 - 15	● ● 10 - 20

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²

● Technical details

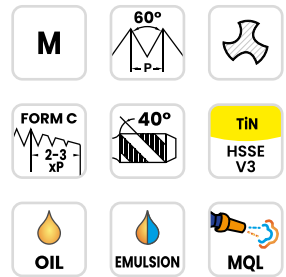
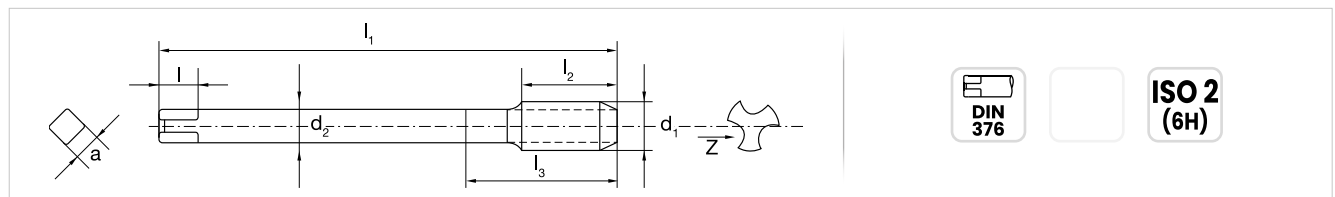


d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M3	0.5	56	5	18	3.5	6	2.7	3	2.50	185.065
M4	0.7	63	7	21	4.5	6	3.4	3	3.30	185.075
M5	0.8	70	8	25	6	8	4.9	3	4.20	185.085
M6	1	80	10	30	6	8	4.9	3	5.00	185.090
M8	1.25	90	13	35	8	9	6.2	3	6.80	185.100
M10	1.5	100	15	39	10	11	8	3	8.50	185.110

● Cutting parameters

V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 1 - 9	● ● 1 - 3	● ● 1 - 9	● ● 7 - 18	○ 9 - 18	● ● 9 - 18	● ● 13 - 27
	● ● 1 - 6	● ● 1 - 3	● ● 1 - 6	● ● ● 4 - 13	○ 9 - 18	● ● 9 - 18	● ● 9 - 18
	● ● 2 - 7	● ● 2 - 4	● ● 2 - 5	● ● ● 5 - 15	○ 8 - 15	● ● 8 - 15	● ● 10 - 20

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS
For Stainless Steels < 1'200 N/mm²

Technical details


d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	Z	Ø/mm	Order code
M3	0.5	56	5	22	2.2	5	2.5	3	2.50	385.005
M4	0.7	63	7	25.2	2.8	5	2.1	3	3.30	385.015
M5	0.8	70	8	28	3.5	6	2.7	3	4.20	385.025
M6	1	80	10	32	4.5	6	3.4	3	5.00	385.030
M8	1.25	90	13	36	6	8	4.9	3	6.80	385.040
M10	1.5	100	15	40	7	8	5.5	3	8.50	385.050
M12	1.75	110	18	44	9	10	7	4	10.20	385.060
M14	2	110	20	44	11	12	9	4	12.00	385.065
M16	2	110	20	44	12	12	9	4	14.00	385.070
M18	2.5	125	25	50	14	14	11	4	15.50	385.075
M20	2.5	140	25	56	16	15	12	4	17.50	385.080
M22	2.5	140	25	56	18	17	14.5	4	19.50	385.085
M24	3	160	30	64	18	17	14.5	4	21.00	385.090
M27	3	160	30	64	20	19	16	4	24.00	385.095
M30	3.5	180	35	72	22	21	18	5	26.50	385.100
M33	3.5	180	35	72	25	23	20	5	29.50	385.105
M36	4	200	40	80	28	25	22	5	32.00	385.110

Cutting parameters

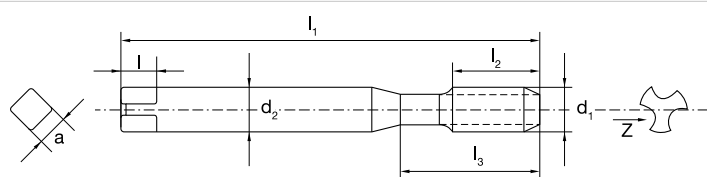
V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 1 - 9	● ● 1 - 3	● ● 1 - 9	● ● 7 - 18	○ 9 - 18	● ● 9 - 18	● ● 13 - 27
	● ● 1 - 6	● ● 1 - 3	● ● 1 - 6	● ● ● 4 - 13	○ 9 - 18	● ● 9 - 18	● ● 9 - 18
	● ● 2 - 7	● ● 2 - 4	● ● 2 - 5	● ● ● 5 - 15	○ 8 - 15	● ● 8 - 15	● ● 10 - 20

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²

● Technical details



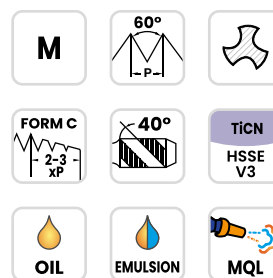
d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M3	0.5	56	5	18	3.5	6	2.7	3	2.50	190.065
M4	0.7	63	7	21	4.5	6	3.4	3	3.30	190.075
M5	0.8	70	8	25	6	8	4.9	3	4.20	190.085
M6	1	80	10	30	6	8	4.9	3	5.00	190.090
M8	1.25	90	13	35	8	9	6.2	3	6.80	190.100
M10	1.5	100	15	39	10	11	8	3	8.50	190.110

● Cutting parameters

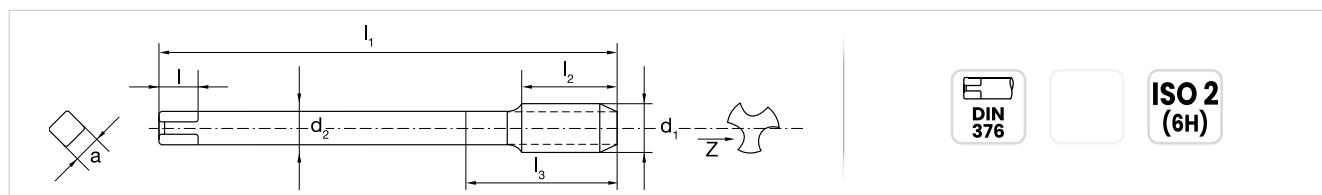
V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 1 - 9	● ● 1 - 3	● ● 1 - 9	● ● 7 - 18	○ 9 - 18	● ● 9 - 18	● ● 13 - 27
	● ● 1 - 6	● ● 1 - 3	● ● 1 - 6	● ● ● 4 - 13	○ 9 - 18	● ● 9 - 18	● ● 9 - 18
	● ● 2 - 7	● ● 2 - 4	● ● 2 - 5	● ● ● 5 - 15	○ 8 - 15	● ● 8 - 15	● ● 10 - 20

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²

● Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	Z	Ø/mm	Order code
M12	1.75	110	18	44	9	10	7	4	10.20	390.060
M14	2	110	20	44	11	12	9	4	12.00	390.065
M16	2	110	20	44	12	12	9	4	14.00	390.070
M18	2.5	125	25	50	14	14	11	4	15.50	390.075
M20	2.5	140	25	56	16	15	12	4	17.50	390.080
M22	2.5	140	25	56	18	17	14.5	4	19.50	390.085
M24	3	160	30	64	18	17	14.5	4	21.00	390.090
M27	3	160	30	64	20	19	16	5	24.00	390.095
M30	3.5	180	35	72	22	21	18	5	26.50	390.100
M33	3.5	180	35	72	25	23	20	5	29.50	390.105
M36	4	200	40	80	28	25	22	4	32.00	390.110

● Cutting parameters

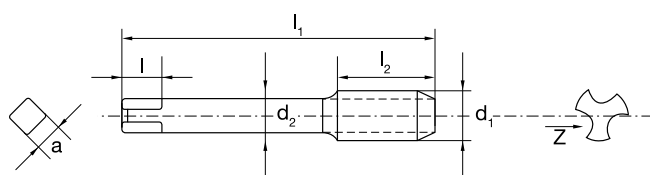
V _c m/min	Ti 900-1500 N/mm ²	NI 900-1500 N/mm ²	NI 900-1500 N/mm ²	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 500-800 N/mm ²
	● ● 1 - 9	● ● 1 - 3	● ● 1 - 9	● ● 7 - 18	○ 9 - 18	● ● 9 - 18	● ● 13 - 27
	● ● 1 - 6	● ● 1 - 3	● ● 1 - 6	● ● ● 4 - 13	○ 9 - 18	● ● 9 - 18	● ● 9 - 18
	● ● 2 - 7	● ● 2 - 4	● ● 2 - 5	● ● ● 5 - 15	○ 8 - 15	● ● 8 - 15	● ● 10 - 20

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²

● Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M2	0.4	36	8	10	2.8	5	2.1	2	1.60	020.040
M2.5	0.45	40	9	11	2.8	5	2.1	2	2.05	020.055
M3	0.5	40	5	13	3.5	6	2.7	3	2.50	020.065
M4	0.7	45	7	14	4.5	6	3.4	3	3.30	020.075
M5	0.8	50	8	18	6	8	4.9	3	4.20	020.085
M6	1	56	10	21	6	8	4.9	3	5.00	020.090

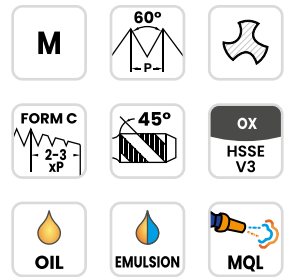
● Cutting parameters

V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 1 - 9	● ● 1 - 3	● ● 1 - 9	● ● 7 - 18	○ 9 - 18	● ● 9 - 18	● ● 13 - 27
	● ● 2 - 6	● ● 2 - 3	● ● 2 - 6	● ● ● 5 - 13	○ 10 - 18	● ● 10 - 18	● ● 10 - 18
	● ● 2 - 7	● ● 2 - 4	● ● 2 - 5	● ● ● 5 - 15	○ 8 - 15	● ● 8 - 15	● ● 10 - 20

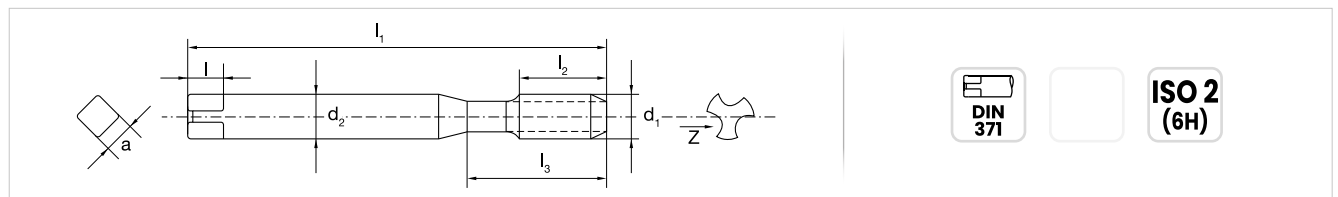
● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²



Technical details



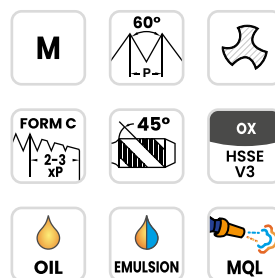
d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M3	0.5	56	5	18	3.5	6	2.7	3	2.50	175.065
M4	0.7	63	7	21	4.5	6	3.4	3	3.30	175.075
M5	0.8	70	8	25	6	8	4.9	3	4.20	175.085
M6	1	80	10	30	6	8	4.9	3	5.00	175.090
M8	1.25	90	13	35	8	9	6.2	3	6.80	175.100
M10	1.5	100	15	39	10	11	8	3	8.50	175.110

Cutting parameters

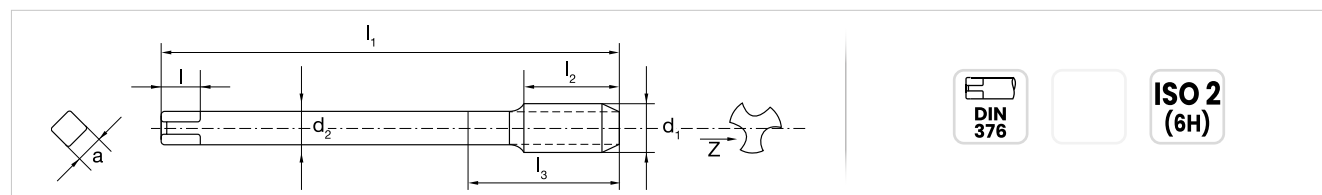
V _c m/min	Ti 900-1500 N/mm ²	NI 900-1500 N/mm ²	NI 900-1500 N/mm ²	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 1 - 9	● ● 1 - 3	● ● 1 - 9	● ● 7 - 18	○ 9 - 18	● ● 9 - 18	● ● 13 - 27
	● ● 2 - 6	● ● 2 - 3	● ● 2 - 6	● ● ● 5 - 13	○ 10 - 18	● ● 10 - 18	● ● 10 - 18
	● ● 2 - 7	● ● 2 - 4	● ● 2 - 5	● ● ● 5 - 15	○ 8 - 15	● ● 8 - 15	● ● 10 - 20

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²

● Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	Z	Ø mm	Order code
M12	1.75	110	18	44	9	10	7	4	10.20	375.060
M16	2	110	20	44	12	12	9	4	14.00	375.070
M20	2.5	140	25	56	16	15	12	4	17.50	375.080

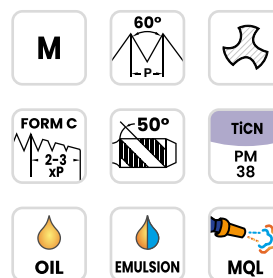
● Cutting parameters

V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 1 - 9	● ● 1 - 3	● ● 1 - 9	● ● 7 - 18	○ 9 - 18	● ● 9 - 18	● ● 13 - 27
	● ● 2 - 6	● ● 2 - 3	● ● 2 - 6	● ● ● 5 - 13	○ 10 - 18	● ● 10 - 18	● ● 10 - 18
	● ● 2 - 7	● ● 2 - 4	● ● 2 - 5	● ● ● 5 - 15	○ 8 - 15	● ● 8 - 15	● ● 10 - 20

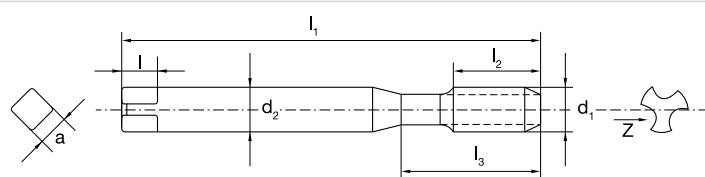
● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²



Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	Z	Ø mm	Order code
M3	0.5	56	5	18	3.5	6	2.7	3	2.50	875.065
M4	0.7	63	7	21	4.5	6	3.4	3	3.30	875.075
M5	0.8	70	8	25	6	8	4.9	3	4.20	875.085
M6	1	80	10	30	6	8	4.9	3	5.00	875.090
M8	1.25	90	13	35	8	9	6.2	3	6.80	875.100
M10	1.5	100	15	39	10	11	8	3	8.50	875.110

Cutting parameters

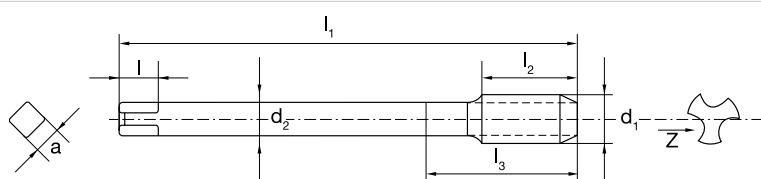
V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 1 - 9	● ● 1 - 3	● ● 1 - 9	● ● 7 - 18	○ 9 - 18	● ● 9 - 18	● ● 13 - 27
	● ● 2 - 6	● ● 2 - 3	● ● 2 - 6	● ● ● 5 - 13	○ 10 - 18	● ● 10 - 18	● ● 10 - 18
	● ● 2 - 7	● ● 2 - 4	● ● 2 - 5	● ● ● 5 - 15	○ 8 - 15	● ● 8 - 15	● ● 10 - 20

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²

● Technical details

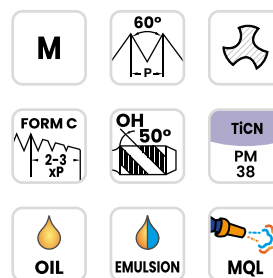
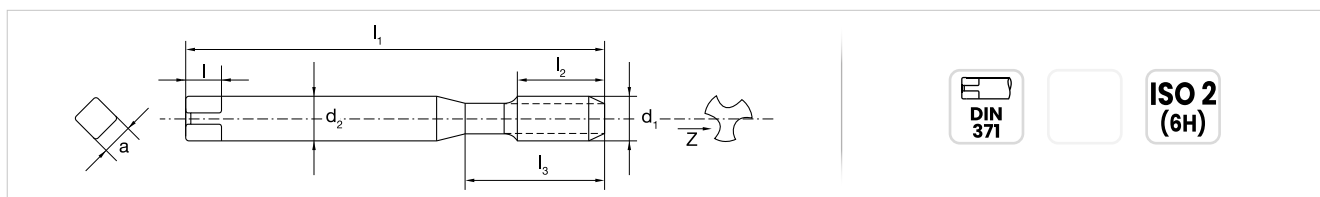


d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M12	1.75	110	18	44	9	10	7	4	10.20	876.060
M14	2	110	20	44	11	12	9	4	12.00	876.065
M16	2	110	20	44	12	12	9	4	14.00	876.070
M18	2.5	125	25	50	14	14	11	4	15.50	876.075
M20	2.5	140	25	56	16	15	12	4	17.50	876.080
M22	2.5	140	25	56	18	17	14.5	4	19.50	876.085
M24	3	160	30	64	18	17	14.5	4	21.00	876.090
M27	3	160	30	64	20	19	16	4	24.00	876.095
M30	3.5	180	35	72	22	21	18	4	26.50	876.100

● Cutting parameters

V _c m/min	Ti 900-1500 N/mm ²	NI 900-1500 N/mm ²	NI 900-1500 N/mm ²	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 1 - 9	● ● 1 - 3	● ● 1 - 9	● ● 7 - 18	○ 9 - 18	● ● 9 - 18	● ● 13 - 27
	● ● 2 - 6	● ● 2 - 3	● ● 2 - 6	● ● ● 5 - 13	○ 10 - 18	● ● 10 - 18	● ● 10 - 18
	● ● 2 - 7	● ● 2 - 4	● ● 2 - 5	● ● ● 5 - 15	○ 8 - 15	● ● 8 - 15	● ● 10 - 20

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS
For Stainless Steels < 1'200 N/mm²

Technical details


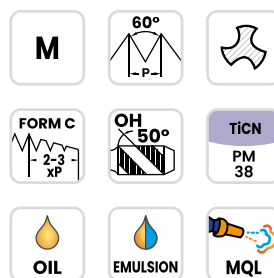
d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	Z	Ø mm	Order code
M6	1	80	10	30	6	8	4.9	3	5.00	880.090
M8	1.25	90	13	35	8	9	6.2	3	6.80	880.100
M10	1.5	100	15	39	10	11	8	3	8.50	880.110

Cutting parameters

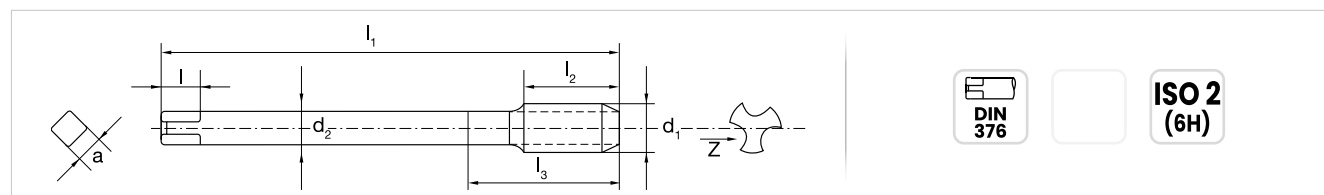
V _c m/min	Ti 900-1500 N/mm ²	NI 900-1500 N/mm ²	NI 900-1500 N/mm ²	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 500-800 N/mm ²
	● ● 1 - 9	● ● 1 - 3	● ● 1 - 9	● ● 7 - 18	○ 9 - 18	● ● 9 - 18	● ● 13 - 27
	● ● 2 - 6	● ● 2 - 3	● ● 2 - 6	● ● ● 5 - 13	○ 10 - 18	● ● 10 - 18	● ● 10 - 18
	● ● 2 - 7	● ● 2 - 4	● ● 2 - 5	● ● ● 5 - 15	○ 8 - 15	● ● 8 - 15	● ● 10 - 20

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²

● Technical details



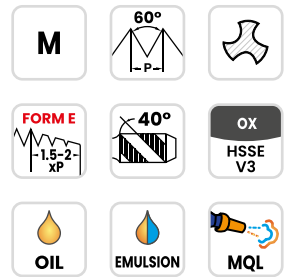
d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	Z	Ø mm	Order code
M12	1.75	110	18	44	9	10	7	4	10.20	881.060
M14	2	110	20	44	11	12	9	4	12.00	881.065
M16	2	110	20	44	12	12	9	4	14.00	881.070
M18	20	125	25	50	14	14	11	4	15.50	881.075
M20	2.5	140	25	56	16	15	12	4	17.50	881.080
M22	2.5	140	25	56	18	17	14.5	4	19.50	881.085
M24	3	160	30	64	18	17	14.5	4	21.00	881.090
M27	3	160	30	64	20	19	16	4	24.00	881.095
M30	3.5	180	35	72	22	21	18	4	26.50	881.100

● Cutting parameters

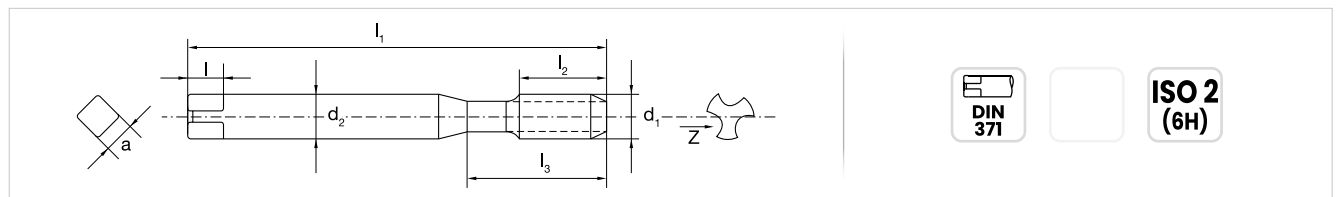
V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 1 - 9	● ● 1 - 3	● ● 1 - 9	● ● 7 - 18	○ 9 - 18	● ● 9 - 18	● ● 13 - 27
	● ● 2 - 6	● ● 2 - 3	● ● 2 - 6	● ● ● 5 - 13	○ 10 - 18	● ● 10 - 18	● ● 10 - 18
	● ● 2 - 7	● ● 2 - 4	● ● 2 - 5	● ● ● 5 - 15	○ 8 - 15	● ● 8 - 15	● ● 10 - 20

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²

● Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M2	0.4	45	8	10	2.8	5	2.1	2	1.60	170.040
M2.5	0.45	50	9	12	2.8	5	2.1	2	2.05	170.055
M3	0.5	56	5	18	3.5	6	2.7	3	2.50	170.065
M3.5	0.6	56	6	20	4	6	3	3	2.90	170.070
M4	0.7	63	7	21	4.5	6	3.4	3	3.30	170.075
M5	0.8	70	8	25	6	8	4.9	3	4.20	170.085
M6	1	80	10	30	6	8	4.9	3	5.00	170.090
M8	1.25	90	13	35	8	9	6.2	3	6.80	170.100
M10	1.5	100	15	39	10	11	8	3	8.50	170.110

● Cutting parameters

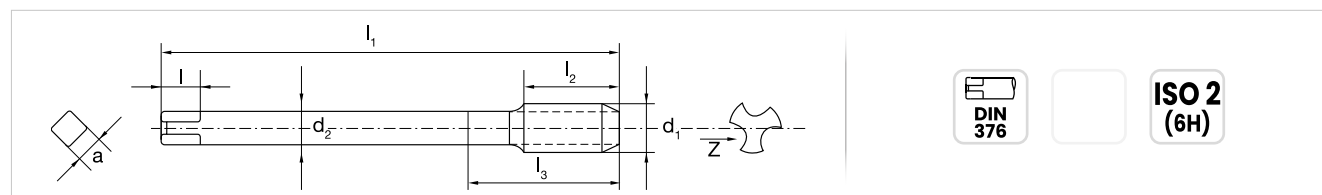
V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 1 - 9	● ● 1 - 3	● ● 1 - 9	● ● ● 7 - 18	○ 9 - 18	● ● 9 - 18	● ● 13 - 27
	● ● 1 - 6	● ● 1 - 36	● ● 1 - 6	● ● ● 4 - 13	○ 9 - 18	● ● 9 - 18	● ● 9 - 18
	● ● 2 - 7	● ● 2 - 4	● ● 2 - 5	● ● ● 5 - 15	○ 8 - 15	● ● 8 - 15	● ● 10 - 20

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²

● Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M12	1.75	110	18	44	9	10	7	4	10.20	370.060
M14	2	110	20	44	11	12	9	4	12.00	370.065
M16	2	110	20	44	12	12	9	4	14.00	370.070

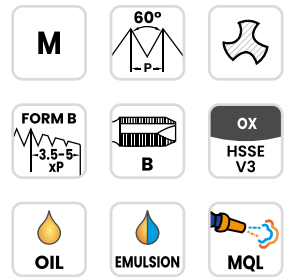
● Cutting parameters

V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 1 - 9	● ● 1 - 3	● ● 1 - 9	● ● ● ● 7 - 18	○ 9 - 18	● ● 9 - 18	● ● 13 - 27
	● ● 1 - 6	● ● 1 - 36	● ● 1 - 6	● ● ● ● 4 - 13	○ 9 - 18	● ● 9 - 18	● ● 9 - 18
	● ● 2 - 7	● ● 2 - 4	● ● 2 - 5	● ● ● ● 5 - 15	○ 8 - 15	● ● 8 - 15	● ● 10 - 20

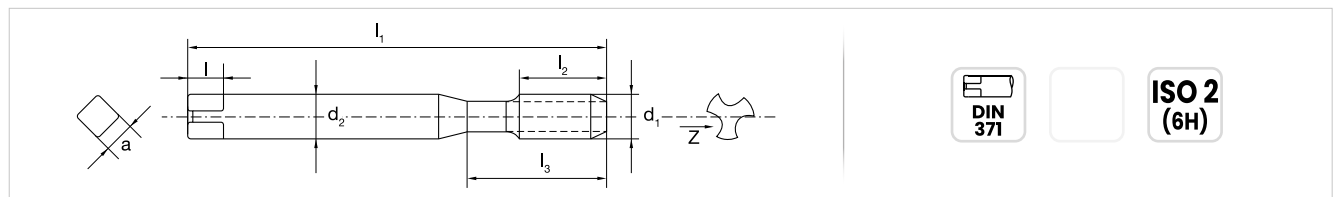
● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²



Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M2	0.4	45	8	10	2.8	5	2.1	2	1.60	140.040
M2.5	0.45	50	9	12.5	2.8	5	2.1	2	2.05	140.055
M3	0.5	56	11	18	3.5	6	2.7	3	2.50	140.065
M3.5	0.6	56	12	20	4	6	3	3	2.90	140.070
M4	0.7	63	13	21	4.5	6	3.4	3	3.30	140.075
M5	0.8	70	16	25	6	8	4.9	3	4.20	140.085
M6	1	80	19	30	6	8	4.9	3	5.00	140.090
M8	1.25	90	22	35	8	9	6.2	3	6.80	140.100
M10	1.5	100	24	39	10	11	8	3	8.50	140.110

Cutting parameters

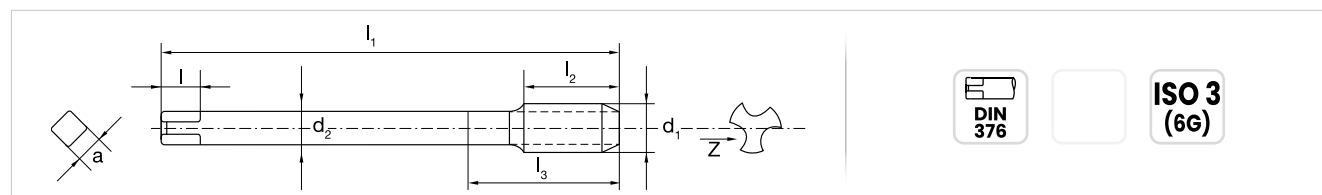
V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 2 - 10	● ● 2 - 4	● ● 2 - 10	● ● ● ● 8 - 20	○ 10 - 20	● ● 10 - 20	● ● 15 - 30

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²

● Technical details



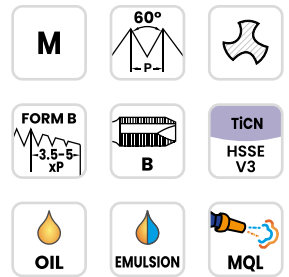
d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	Z	Ø mm	Order code
M12	1.75	110	28	44	9	10	7	3	10.20	340.060
M14	2	110	30	44	11	12	9	3	12.00	340.065
M16	2	110	32	44	12	12	9	3	14.00	340.070
M18	2.5	125	34	50	14	14	11	3	15.50	340.075
M20	2.5	140	34	56	16	15	12	3	17.50	340.080

● Cutting parameters

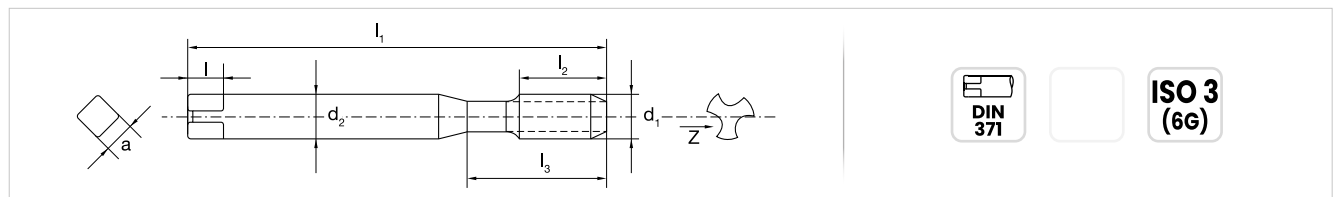
V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 2 - 10	● ● 2 - 4	● ● 2 - 10	● ● ● ● 8 - 20	○ 10 - 20	● ● 10 - 20	● ● 15 - 30

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²

● Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M2	0.4	45	8	10	2.8	5	2.1	2	1.60	145.040
M3	0.5	56	11	18	3.5	6	2.7	3	2.50	145.065
M4	0.7	63	13	21	4.5	6	3.4	3	3.30	145.075
M5	0.8	70	16	25	6	8	4.9	3	4.20	145.085
M6	1	80	19	30	6	8	4.9	3	5.00	145.090
M8	1.25	90	22	35	8	9	6.2	3	6.80	145.100
M10	1.5	100	24	39	10	11	8	3	8.50	145.110

● Cutting parameters

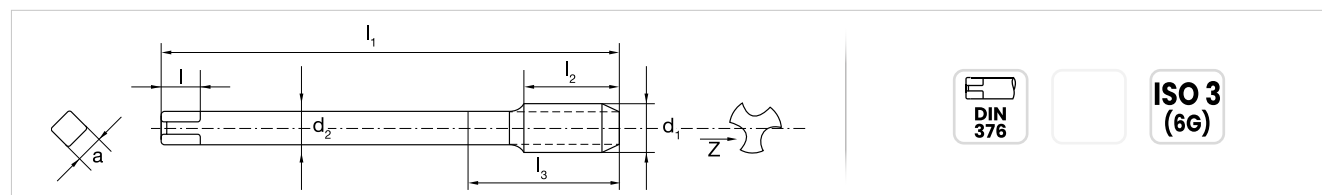
V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 2 - 10	● ● 2 - 4	● ● 2 - 10	● ● ● ● 8 - 20	○ 10 - 20	● ● 10 - 20	● ● 15 - 30

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²

● Technical details



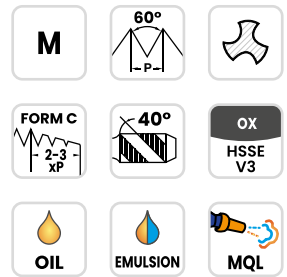
d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	Z	Ø mm	Order code
M12	1.75	110	28	44	9	10	7	3	10.20	345.060
M16	2	110	32	44	12	12	9	3	14.00	345.070
M20	2.5	140	34	56	16	15	12	3	17.50	345.080

● Cutting parameters

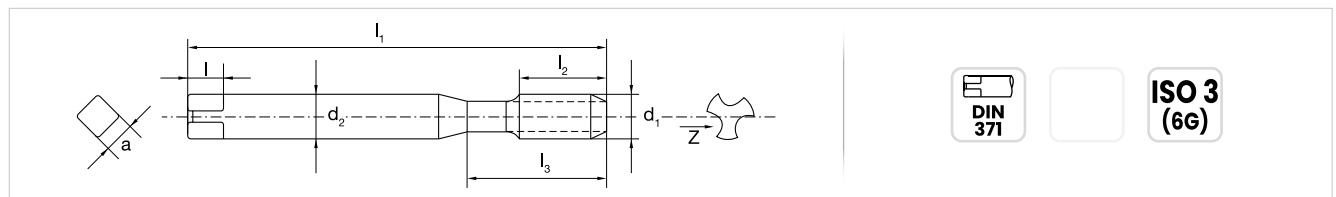
V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 2 - 10	● ● 2 - 4	● ● 2 - 10	● ● ● ● 8 - 20	○ 10 - 20	● ● 10 - 20	● ● 15 - 30

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²

● Technical details



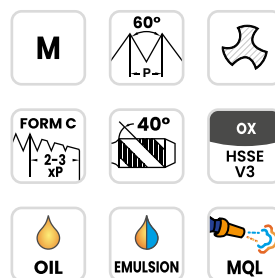
d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M2	0.4	45	8	10	2.8	5	2.1	2	1.60	195.040
M2.5	0.45	50	9	12.5	2.8	5	2.1	2	2.05	195.055
M3	0.5	56	5	18	3.5	6	2.7	3	2.50	195.065
M3.5	0.6	56	6	20	4	6	3	3	2.90	195.070
M4	0.7	63	7	21	4.5	6	3.4	3	3.30	195.075
M5	0.8	70	8	25	6	8	4.9	3	4.20	195.085
M6	1	80	10	30	6	8	4.9	3	5.00	195.090
M8	1.25	90	13	35	8	9	6.2	3	6.80	195.100
M10	1.5	100	15	39	10	11	8	3	8.50	195.110

● Cutting parameters

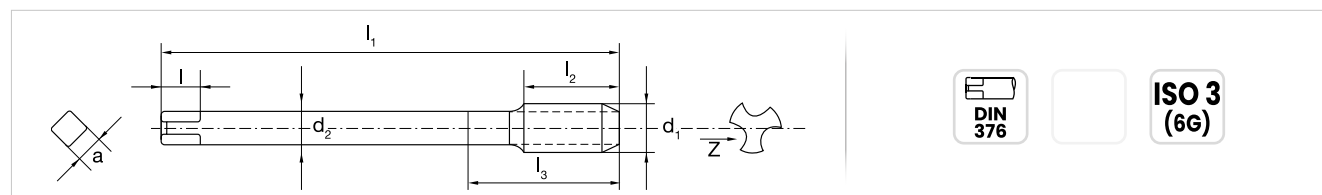
V _c m/min	Ti 900-1500 N/mm ²	NI 900-1500 N/mm ²	NI 900-1500 N/mm ²	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 1 - 9	● ● 1 - 3	● ● 1 - 9	● ● 7 - 18	○ 9 - 18	● ● 9 - 18	● ● 13 - 27
	● ● 1 - 6	● ● 1 - 3	● ● 1 - 6	● ● ● 4 - 13	○ 9 - 18	● ● 9 - 18	● ● 9 - 18
	● ● 2 - 7	● ● 2 - 4	● ● 2 - 5	● ● ● 5 - 15	○ 8 - 15	● ● 8 - 15	● ● 10 - 20

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²

● Technical details



DIN 376

ISO 3
(6G)

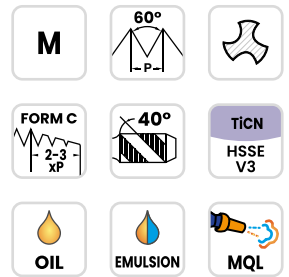
d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M12	1.75	110	18	44	9	10	7	4	10.20	395.060
M14	2	110	20	44	11	12	9	4	12.00	395.065
M16	2	110	20	44	12	12	9	4	14.00	395.070
M18	2.5	125	25	50	14	14	11	4	15.50	395.075
M20	2.5	140	25	56	16	15	12	4	17.50	395.080
M24	3	160	30	64	18	17	14.5	4	21.00	395.090
M27	3	160	30	64	20	19	16	4	24.00	395.095
M30	3.5	180	35	72	22	21	18	5	26.50	395.100

● Cutting parameters

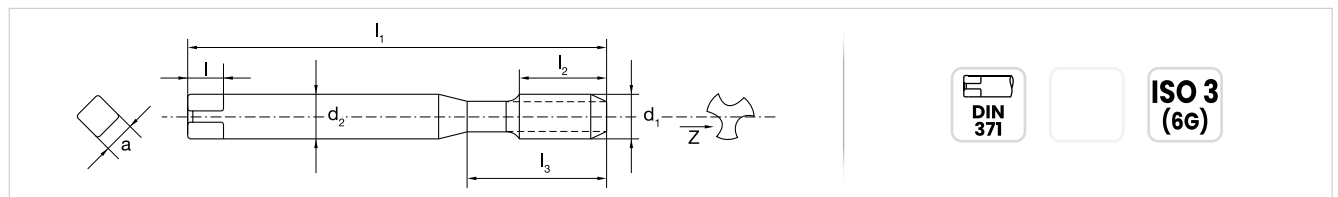
V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 1 - 9	● ● 1 - 3	● ● 1 - 9	● ● 7 - 18	○ 9 - 18	● ● 9 - 18	● ● 13 - 27
	● ● 1 - 6	● ● 1 - 3	● ● 1 - 6	● ● ● 4 - 13	○ 9 - 18	● ● ● 9 - 18	● ● ● 9 - 18
	● ● 2 - 7	● ● 2 - 4	● ● 2 - 5	● ● ● 5 - 15	○ 8 - 15	● ● ● 8 - 15	● ● ● 10 - 20

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²

● Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	Z	Ø mm	Order code
M2	0.4	45	8	10	2.8	5	2.1	2	1.60	200.040
M3	0.5	56	5	18	3.5	6	2.7	3	2.50	200.065
M4	0.7	63	7	21	4.5	6	3.4	3	3.30	200.075
M5	0.8	70	8	25	6	8	4.9	3	4.20	200.085
M6	1	80	10	30	6	8	4.9	3	5.00	200.090
M8	1.25	90	13	35	8	9	6.2	3	6.80	200.100
M10	1.5	100	15	39	10	11	8	3	8.50	200.110

● Cutting parameters

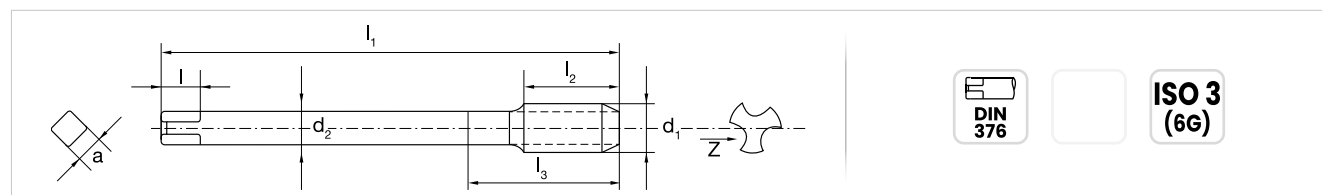
V _c m/min	Ti 900-1500 N/mm ²	NI 900-1500 N/mm ²	NI 900-1500 N/mm ²	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 1 - 9	● ● 1 - 3	● ● 1 - 9	● ● 7 - 18	○ 9 - 18	● ● 9 - 18	● ● 13 - 27
	● ● 1 - 6	● ● 1 - 3	● ● 1 - 6	● ● ● 4 - 13	○ 9 - 18	● ● 9 - 18	● ● 9 - 18
	● ● 2 - 7	● ● 2 - 4	● ● 2 - 5	● ● ● 5 - 15	○ 8 - 15	● ● 8 - 15	● ● 10 - 20

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²

● Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M12	1.75	110	18	44	9	10	7	4	10.20	400.060
M16	2	110	20	44	12	12	9	4	14.00	400.070
M20	2.5	140	25	56	16	15	12	4	17.50	400.080

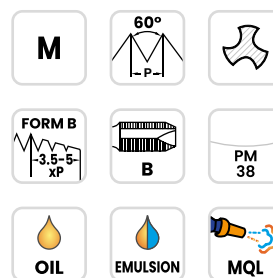
● Cutting parameters

V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 1 - 9	● ● 1 - 3	● ● 1 - 9	● ● 7 - 18	○ 9 - 18	● ● 9 - 18	● ● 13 - 27
	● ● 1 - 6	● ● 1 - 3	● ● 1 - 6	● ● ● 4 - 13	○ 9 - 18	● ● 9 - 18	● ● 9 - 18
	● ● 2 - 7	● ● 2 - 4	● ● 2 - 5	● ● ● 5 - 15	○ 8 - 15	● ● 8 - 15	● ● 10 - 20

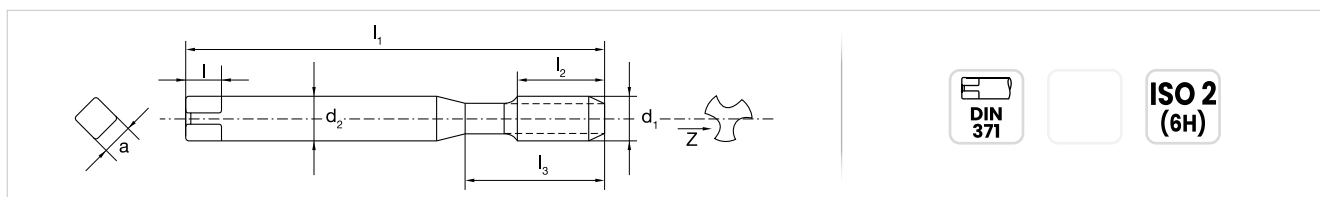
● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Titanium and Nickel Alloys



● Technical details



d_1	P	l_1	l_2	d_2	l	a	Z	$\varnothing$ mm	Order code
M3	0.5	56	12	3.5	6	2.7	3	2.50	860.065
M4	0.7	63	16	4.5	6	3.4	3	3.30	860.075
M5	0.8	70	19	6	8	4.9	3	4.20	860.085
M6	1	80	23	6	8	4.9	3	5.00	860.090
M8	1.25	90	30	8	9	6.2	3	6.80	860.100
M10	1.5	100	38	10	11	8	3	8.50	860.110

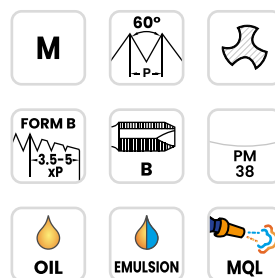
● Cutting parameters

V_c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²
	● ● ● 2 - 10	● ● ● 2 - 4	● ● ● 2 - 10	● ● 8 - 20	○ 10 - 20

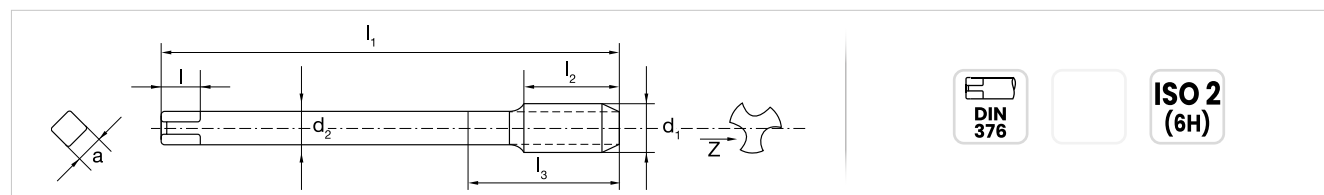
●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Titanium and Nickel Alloys



● Technical details



DIN 376

ISO 2
(6H)

d_1	P	l_1	l_2	l_3	d_2	l	α	Z	$\varnothing$ mm	Order code
M12	1.75	110	28	44	9	10	7	3	10.20	861.060

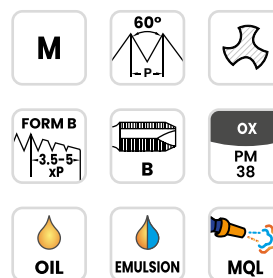
● Cutting parameters

V_c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²
	● ● ● 2 - 10	● ● ● 2 - 4	● ● ● 2 - 10	● ● 8 - 20	○ 10 - 20

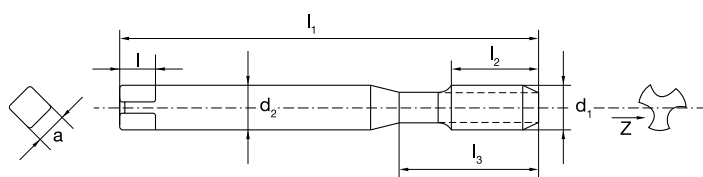
● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Titanium and Nickel Alloys



● Technical details

DIN
371ISO 2
(6H)

d_1	P	l_1	l_2	l_3	d_2	l	α	Z	$\varnothing$ mm	Order code
M3	0.5	56	11	18	3.5	6	2.7	3	2.50	850.065
M4	0.7	63	13	21	4.5	6	3.4	3	3.30	850.075
M5	0.8	70	16	25	6	8	4.9	3	4.20	850.085
M6	1	80	19	30	6	8	4.9	3	5.00	850.090
M8	1.25	90	22	35	8	9	6.2	3	6.80	850.100
M10	1.5	100	24	39	10	11	8	3	8.50	850.110

● Cutting parameters

V_c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²
	● ● ● 2 - 10	● ● ● 2 - 4	● ● ● 2 - 10	● ● 8 - 20	○ 10 - 20

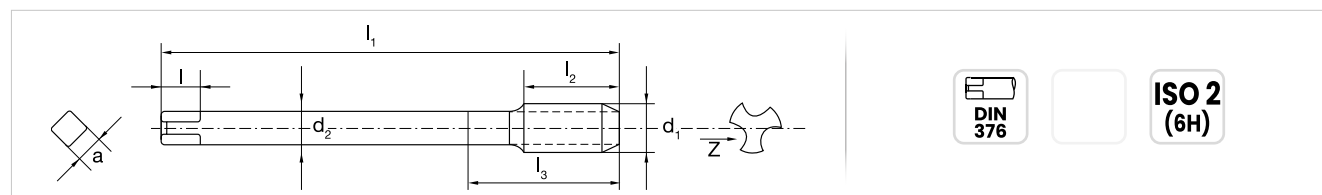
● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Titanium and Nickel Alloys



● Technical details



d_1	P	l_1	l_2	l_3	d_2	l	α	Z	$\varnothing$ mm	Order code
M12	1.75	110	28	44	9	10	7	3	10.20	851.060
M16	2	110	32	44	12	12	9	3	14.00	851.070
M20	2.5	140	34	56	16	15	12	3	17.50	851.080

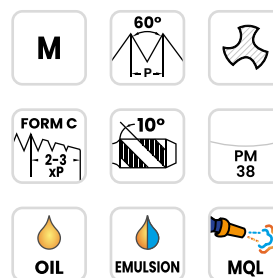
● Cutting parameters

V_c m/min	Ti	NI 900-1500 N/mm²	NI	INOX ≤1200 N/mm²	STEEL 800-1300 N/mm²
	● ● ● 2 - 10	● ● ● 2 - 4	● ● ● 2 - 10	● ● 8 - 20	○ 10 - 20

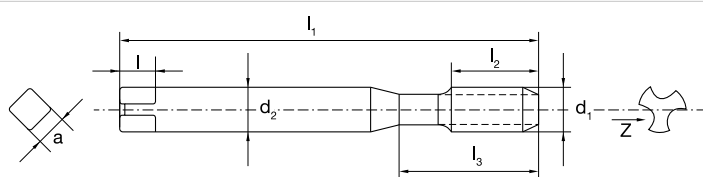
● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Titanium and Nickel Alloys



Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M3	0.5	56	11	18	3.5	6	2.7	3	2.50	865.065
M4	0.7	63	14	21	4.5	6	3.4	3	3.30	865.075
M5	0.8	70	17	25	6	8	4.9	3	4.20	865.085
M6	1	80	21	30	6	8	4.9	3	5.00	865.090
M8	1.25	90	28	35	8	9	6.2	3	6.80	865.100
M10	1.5	100	35	39	10	11	8	3	8.50	865.110

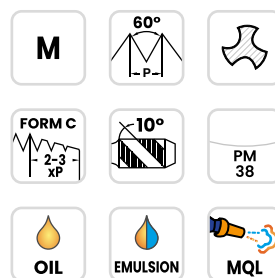
Cutting parameters

V _c m/min	Ti	NI 900-1500 N/mm²	NI 900-1500 N/mm²	INOX ≤1200 N/mm²	STEEL 800-1300 N/mm²
	● ● ● 1 - 9	● ● ● 1 - 3	● ● ● 1 - 9	● ● 7 - 18	○ 9 - 18
	● ● ● 1 - 6	● ● ● 1 - 3	● ● ● 1 - 6	● ● 4 - 13	○ 9 - 18
	● ● ● 2 - 7	● ● ● 2 - 4	● ● ● 2 - 7	● ● 5 - 15	○ 8 - 15

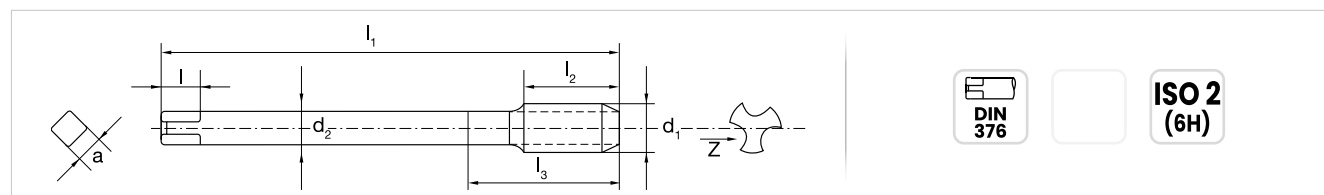
● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Titanium and Nickel Alloys



● Technical details



d_1	P	l_1	l_2	l_3	d_2	l	α	Z	$\varnothing$ mm	Order code
M12	1.75	110	18	44	9	10	7	3	10.20	866.060

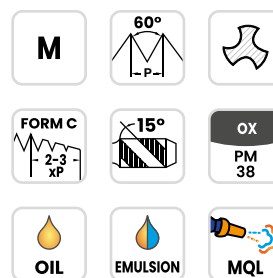
● Cutting parameters

V_c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²
	● ● ● 1 - 9	● ● ● 1 - 3	● ● ● 1 - 9	● ● 7 - 18	○ 9 - 18
	● ● ● 1 - 6	● ● ● 1 - 3	● ● ● 1 - 6	● ● 4 - 13	○ 9 - 18
	● ● ● 2 - 7	● ● ● 2 - 4	● ● ● 2 - 7	● ● 5 - 15	○ 8 - 15

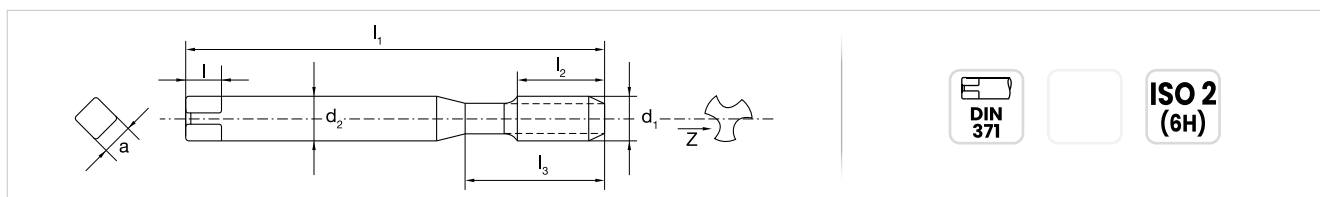
● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Titanium and Nickel Alloys



● Technical details



d_1	P	l_1	l_2	l_3	d_2	l	α	Z	$\varnothing$ mm	Order code
M3	0.5	56	5	18	3.5	6	2.7	3	2.50	855.065
M4	0.7	63	7	21	4.5	6	3.4	3	3.30	855.075
M5	0.8	70	8	25	6	8	4.9	3	4.20	855.085
M6	1	80	10	30	6	8	4.9	3	5.00	855.090
M8	1.25	90	13	35	8	9	6.2	3	6.80	855.100
M10	1.5	100	15	39	10	11	8	3	8.50	855.110

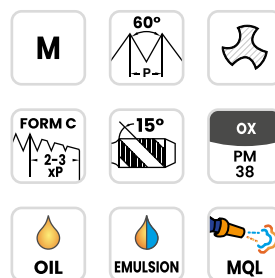
● Cutting parameters

V_c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²
	● ● ● 1 - 9	● ● ● 1 - 3	● ● ● 1 - 9	● ● 7 - 18	○ 9 - 18
	● ● ● 1 - 6	● ● ● 1 - 3	● ● ● 1 - 6	● ● 4 - 13	○ 9 - 18
	● ● ● 2 - 7	● ● ● 2 - 4	● ● ● 2 - 7	● ● 5 - 15	○ 8 - 15

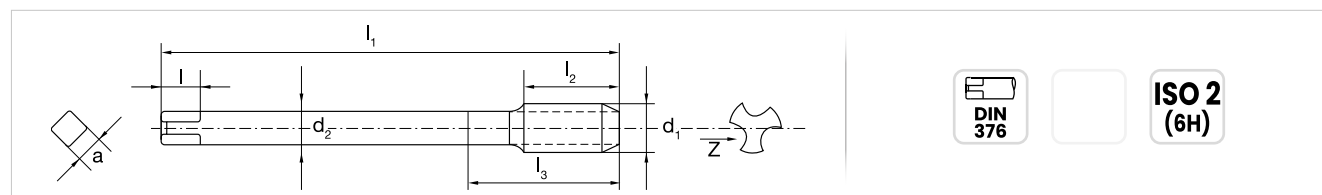
●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Titanium and Nickel Alloys



● Technical details



d_1	P	l_1	l_2	l_3	d_2	l	α	Z	ϕ mm	Order code
M12	1.75	110	18	44	9	10	7	3	10.20	856.060
M16	2	110	20	44	12	12	9	3	14.00	856.070
M20	2.5	140	25	56	16	15	12	4	17.50	856.080
M22	2.5	140	25	56	18	17	14.5	4	19.50	856.085

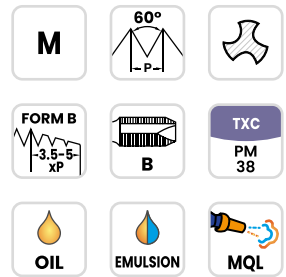
● Cutting parameters

V_c m/min	Ti	NI 900-1500 N/mm²	NI	INOX ≤1200 N/mm²	STEEL 800-1300 N/mm²
	● ● ● 1 - 9	● ● ● 1 - 3	● ● ● 1 - 9	● ● 7 - 18	○ 9 - 18
	● ● ● 1 - 6	● ● ● 1 - 3	● ● ● 1 - 6	● ● 4 - 13	○ 9 - 18
	● ● ● 2 - 7	● ● ● 2 - 4	● ● ● 2 - 7	● ● 5 - 15	○ 8 - 15

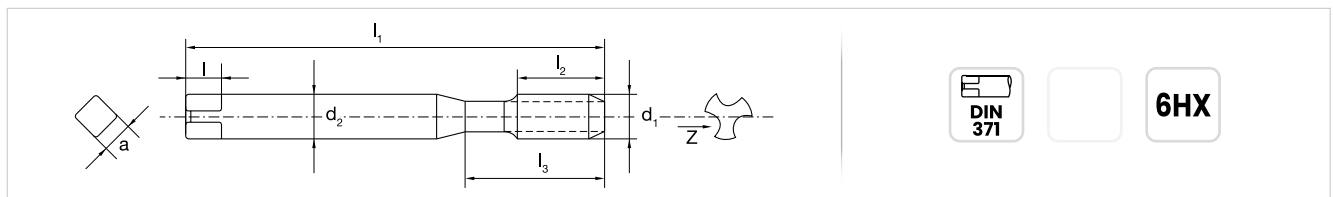
● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For General Use Cast Iron, Aluminium, Aluminium Die Cast, Steels and Stainless Steels < 1'200 N/mm²



Technical details


DIN 371
6HX

d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	Z	Ø mm	Order code
M3	0.5	56	18	18	3.5	6	2.7	3	2.50	883.065
M4	0.7	63	21	21	4.5	6	3.4	3	3.30	883.075
M5	0.8	70	25	25	6	8	4.9	3	4.20	883.085
M6	1	80	30	30	6	8	4.9	3	5.00	883.090
M8	1.25	90	35	35	8	9	6.2	3	6.80	883.100
M10	1.5	100	39	39	10	11	8	3	8.50	883.110

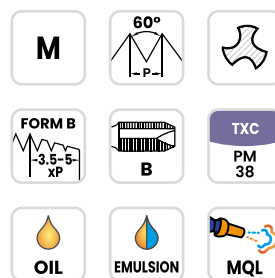
Cutting parameters

V _c m/min	Ti	NI 900-1500 N/mm ²	INOX ≤1200 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU SHORT
	● ● 2 - 10	● ● 2 - 4	● ● ● ● 8 - 20	● ● 10 - 20	● ● 15 - 30	● ● ● ● 10 - 32	● ● 3 - 24
						● ● ● ● 13 - 32	● ● 4 - 24
						● ● ● ● 10 - 30	● ● 5 - 20

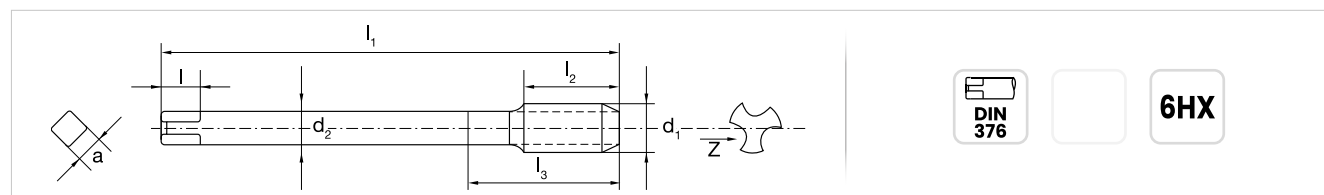
● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For General Use Cast Iron, Aluminium, Aluminium Die Cast, Steels and Stainless Steels < 1'200 N/mm²



● Technical details



DIN 376

6HX

d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M12	1.75	110	44	44	9	10	7	3	10.20	884.060
M14	2	110	44	44	11	12	9	3	12.00	884.065
M16	2	110	44	44	12	12	9	3	14.00	884.070
M18	2.5	125	50	50	14	14	11	3	15.50	884.075
M20	2.5	140	56	56	16	15	12	4	17.50	884.080

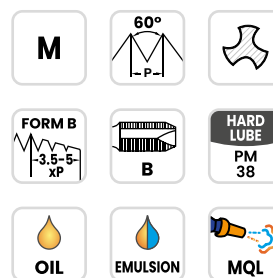
● Cutting parameters

V _c m/min	Ti	NI 900-1500 N/mm ²	INOX ≤1200 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²	Ge/e CAST	CU SHORT
	● ● 2 - 10	● ● 2 - 4	● ● ● ● 8 - 20	● ● 10 - 20	● ● 15 - 30	● ● ● ● 10 - 32	● ● 3 - 24
						● ● ● ● 13 - 32	● ● 4 - 24
						● ● ● ● 10 - 30	● ● 5 - 20

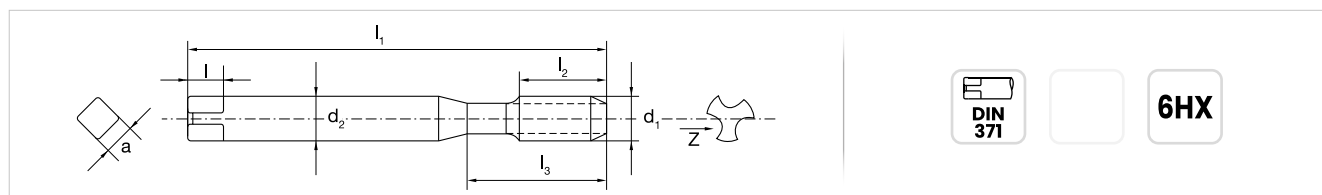
● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For General Use Cast Iron, Aluminium, Aluminium Die Cast, Steels and Stainless Steels < 1'200 N/mm²



● Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	Z	Ø mm	Order code
M3	0.5	56	11	18	3.5	6	2.7	3	2.50	885.065
M4	0.7	63	13	21	4.5	6	3.4	3	3.30	885.075
M5	0.8	70	16	25	6	8	4.9	3	4.20	885.085
M6	1	80	19	30	6	8	4.9	3	5.00	885.090
M8	1.25	90	22	35	8	9	6.2	3	6.80	885.100
M10	1.5	100	24	39	10	11	8	3	8.50	885.110

● Cutting parameters

V _c m/min	Ti	NI 900-1500 N/mm ²	INOX ≤1200 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU SHORT
	● ● 2 - 10	● ● 2 - 4	● ● ● ● 8 - 20	● ● 10 - 20	● ● 15 - 30	● ● ● ● 10 - 32	● ● 3 - 24
						● ● ● ● 13 - 32	● ● 4 - 24
						● ● ● ● 10 - 30	● ● 5 - 20

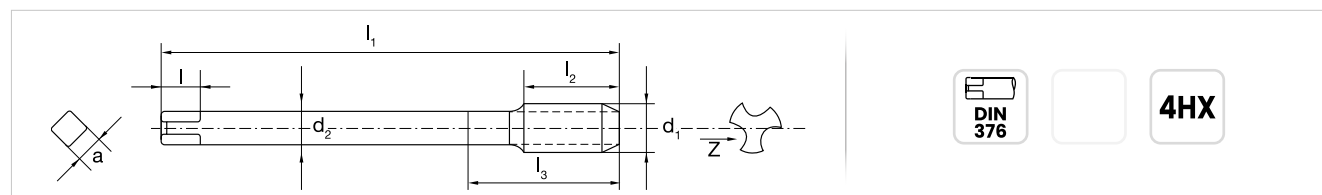
● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For General Use Cast Iron, Aluminium, Aluminium Die Cast, Steels and Stainless Steels < 1'200 N/mm²



● Technical details



4HX

d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M12	1.75	110	28	44	9	10	7	3	10.20	886.060
M14	2	110	30	44	11	12	9	4	12.00	886.065
M16	2	110	32	44	12	12	9	4	14.00	886.070
M20	2.5	140	34	56	16	15	12	4	17.50	886.080

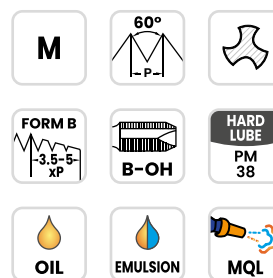
● Cutting parameters

V _c m/min	Ti	NI 900-1500 N/mm ²	INOX ≤1200 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²	Ge/e CAST	CU SHORT
	● ● 2 - 10	● ● 2 - 4	● ● ● ● 8 - 20	● ● 10 - 20	● ● 15 - 30	● ● ● ● 10 - 32	● ● 3 - 24
						● ● ● ● 13 - 32	● ● 4 - 24
						● ● ● ● 10 - 30	● ● 5 - 20

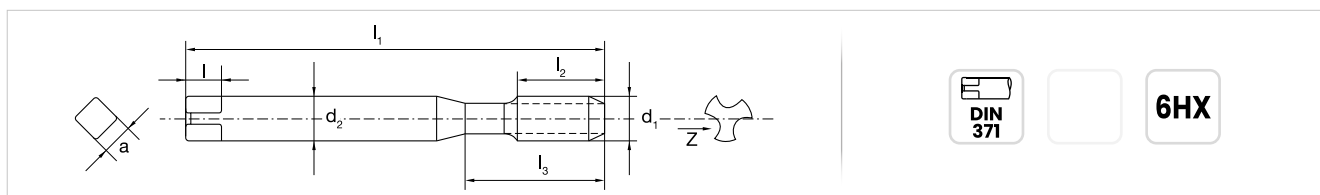
● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For General Use Cast Iron, Aluminium, Aluminium Die Cast, Steels and Stainless Steels < 1'200 N/mm²



● Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M6	1	80	19	30	6	8	4.9	3	5.00	890.090
M8	1.25	90	22	35	8	9	6.2	3	6.80	890.100
M10	1.5	100	24	39	10	11	8	3	8.50	890.110

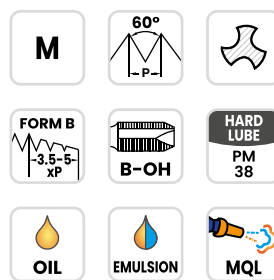
● Cutting parameters

V _c m/min	Ti	NI 900-1500 N/mm ²	INOX ≤1200 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU SHORT
	● ● 2 - 13	● ● 2 - 5	● ● ● ● 8 - 25	● ● 10 - 25	● ● 15 - 40	● ● ● ● 10 - 40	● ● 3 - 30
						● ● ● ● 13 - 40	● ● 4 - 30
						● ● ● ● 10 - 40	● ● 5 - 25

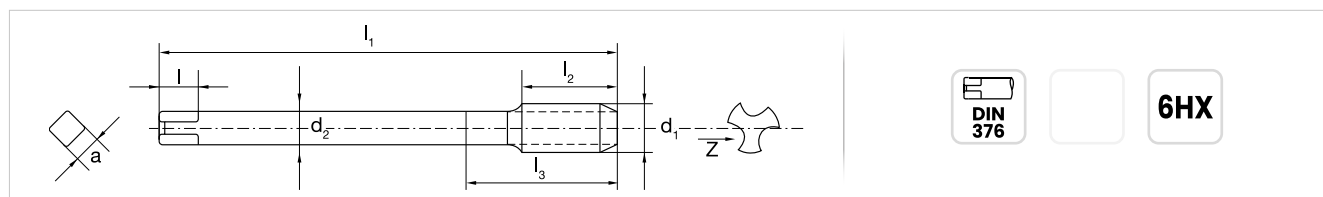
● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For General Use Cast Iron, Aluminium, Aluminium Die Cast, Steels and Stainless Steels < 1'200 N/mm²



● Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M12	1.75	110	28	44	9	10	7	3	10.20	891.060
M16	2	110	32	44	12	12	9	4	14.00	891.070
M20	2.5	140	34	56	16	15	12	4	17.50	891.080

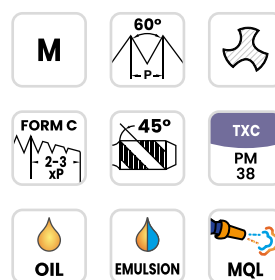
● Cutting parameters

V _c m/min	Ti	NI 900-1500 N/mm ²	INOX ≤1200 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²	Ge/e CAST	CU SHORT
	● ● 2 - 13	● ● 2 - 5	● ● ● ● 8 - 25	● ● 10 - 25	● ● 15 - 40	● ● ● ● 10 - 40	● ● 3 - 30
						● ● ● ● 13 - 40	● ● 4 - 30
						● ● ● ● 10 - 40	● ● 5 - 25

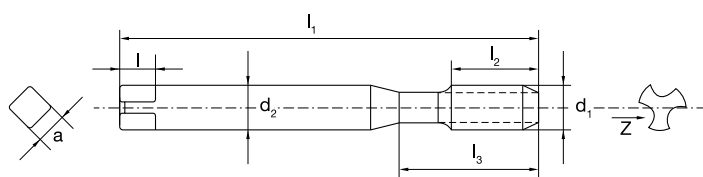
● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For General Use



Technical details



DIN
371

6HX

d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	Z	Ø mm	Order code
M3	0.5	56	4	25	3.5	6	2.7	3	2.50	898.065
M4	0.7	63	6	30	4.5	6	3.4	3	3.30	898.075
M5	0.8	70	6	35	6	8	4.9	3	4.20	898.085
M6	1	80	8	39	6	8	4.9	3	5.00	898.090
M8	1.25	90	10	18	8	9	6.2	3	6.80	898.100
M10	1.5	100	12	21	10	11	8	3	8.50	898.110

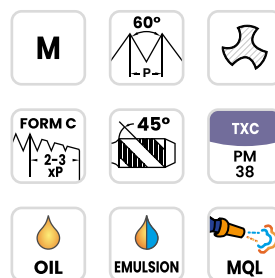
Cutting parameters

V _c m/min	Ti	NI 900-1500 N/mm²	INOX ≤1200 N/mm²	STEEL 800-1200 N/mm²	STEEL 500-800 N/mm²	GG/G CAST	CU SHORT
	● ● 1 - 9	● ● 1 - 3	● ● 7 - 18	● ● 9 - 18	● ● 13 - 27	● ● ● 10 - 32	● ● 3 - 24
	● ● 2 - 6	● ● 2 - 3	● ● ● 5 - 13	● ● 10 - 18	● ● 10 - 18	● ● ● 13 - 32	● ● 4 - 24
	● ● 2 - 7	● ● 2 - 4	● ● ● 5 - 15	● ● 8 - 15	● ● 10 - 20	● ● ● 10 - 30	● ● 5 - 20

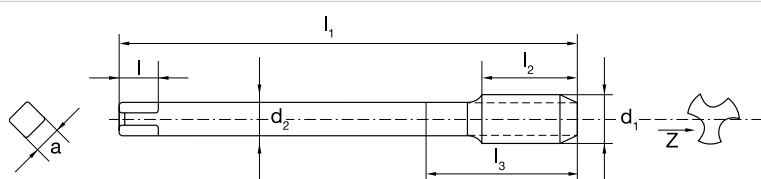
● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For General Use



Technical details



6HX

d_1	P	l_1	l_2	l_3	d_2	l	α	Z	$\varnothing$ mm	Order code
M12	1.75	110	14	25	9	10	7	3	10.20	899.060
M14	2	110	16	30	11	12	9	3	12.00	899.065
M16	2	110	16	35	12	12	9	3	14.00	899.070
M18	2.5	125	20	39	14	14	11	3	15.50	899.075
M20	2.5	140	20	18	16	15	12	4	17.50	899.080

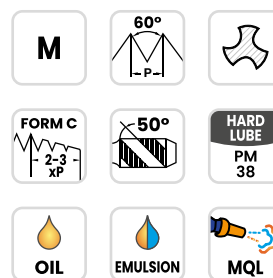
Cutting parameters

V_c m/min	Ti	INOX ≤ 1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 1 - 9	● ● 7 - 18	○ 9 - 18	● ● 9 - 18	● ● 13 - 27
	● ● 2 - 6	● ● ● 5 - 13	○ 10 - 18	● ● 10 - 18	● ● 10 - 18
	● ● 2 - 7	● ● ● 5 - 15	○ 8 - 15	● ● 8 - 15	● ● 10 - 20

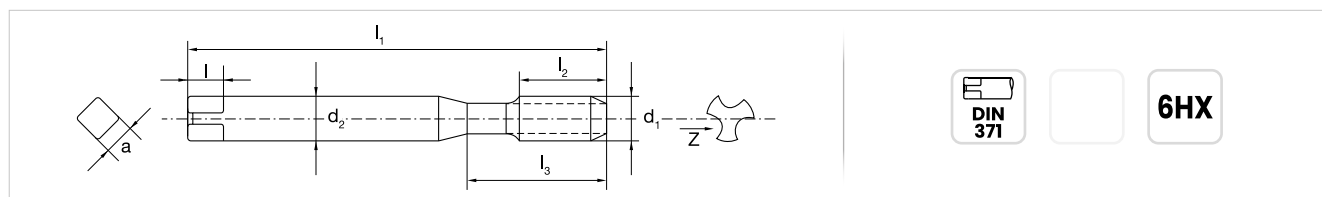
● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For General Use Cast Iron, Aluminium, Aluminium Die Cast, Steels and Stainless Steels < 1'200 N/mm²



● Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	Z	Ø mm	Order code
M3	0.5	56	5	18	3.5	6	2.7	3	2.50	900.065
M4	0.7	63	7	21	4.5	6	3.4	3	3.30	900.075
M5	0.8	70	8	25	6	8	4.9	3	4.20	900.085
M6	1	80	10	30	6	8	4.9	3	5.00	900.090
M8	1.25	90	13	35	8	9	6.2	3	6.80	900.100
M10	1.5	100	15	39	10	11	8	3	8.50	900.110

● Cutting parameters

V _c m/min	Ti	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 1 - 9	● ● 7 - 18	○ 9 - 18	● ● 9 - 18	● ● 13 - 27
	● ● 2 - 6	● ● ● 5 - 13	○ 10 - 18	● ● 10 - 18	● ● 10 - 18
	● ● 2 - 7	● ● ● 5 - 15	○ 8 - 15	● ● 8 - 15	● ● 10 - 20

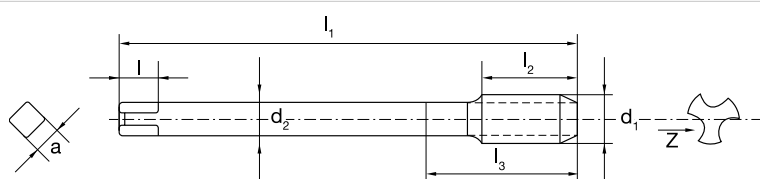
● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For General Use Cast Iron, Aluminium, Aluminium Die Cast, Steels and Stainless Steels < 1'200 N/mm²



● Technical details



6HX

d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M12	1.75	110	18	44	9	10	7	4	10.20	901.060
M14	2	110	20	44	11	12	9	4	12.00	901.065
M16	2	110	20	44	12	12	9	4	14.00	901.070
M20	2.5	140	25	56	16	15	12	4	17.50	901.080

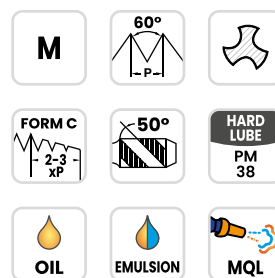
● Cutting parameters

V _c m/min	Ti	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 1 - 9	● ● 7 - 18	○ 9 - 18	● ● 9 - 18	● ● 13 - 27
	● ● 2 - 6	● ● ● 5 - 13	○ 10 - 18	● ● 10 - 18	● ● 10 - 18
	● ● 2 - 7	● ● ● 5 - 15	○ 8 - 15	● ● 8 - 15	● ● 10 - 20

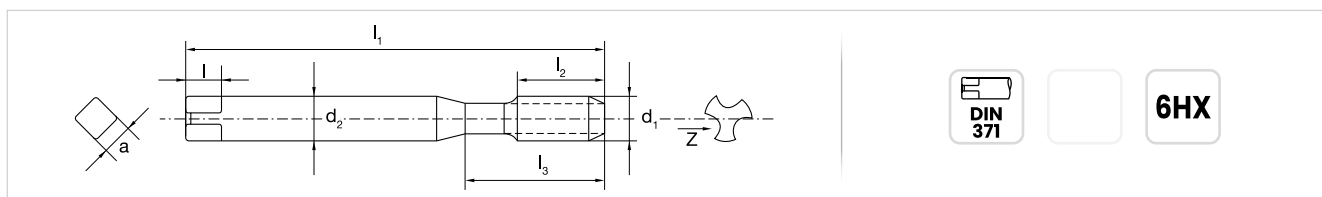
● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For General Use Cast Iron, Aluminium, Aluminium Die Cast, Steels and Stainless Steels < 1'200 N/mm²



Technical details



DIN 371

6HX

d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	Z	Ø mm	Order code
M6	1	80	10	30	6	8	4.9	3	5.00	905.090
M8	1.25	90	13	35	8	9	6.2	3	6.80	905.100
M10	1.5	100	15	39	10	11	8	3	8.50	905.110

Cutting parameters

V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 1 - 9	● ● 1 - 3	● ● 1 - 9	● ● 7 - 18	○ 9 - 18	● ● 9 - 18	● ● 13 - 27
	● ● 2 - 6	● ● 2 - 3	● ● 2 - 6	● ● ● 5 - 13	○ 10 - 18	● ● 10 - 18	● ● 10 - 18
	● ● 2 - 7	● ● 2 - 4	● ● 2 - 5	● ● ● 5 - 15	○ 8 - 15	● ● 8 - 15	● ● 10 - 20

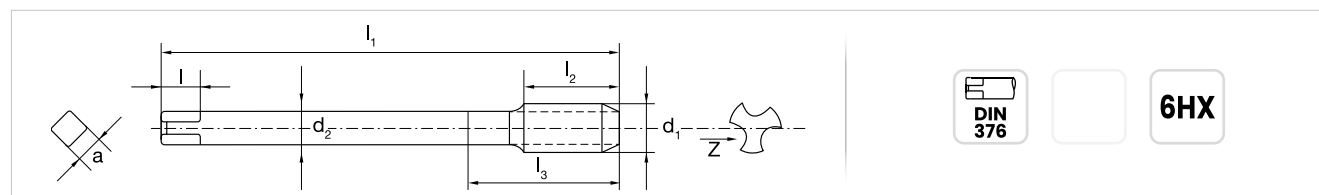
● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For General Use Cast Iron, Aluminium, Aluminium Die Cast, Steels and Stainless Steels < 1'200 N/mm²



● Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M12	1.75	110	18	44	9	10	7	4	10.20	906.060
M16	2	110	20		12	12	9	4	14.00	906.070
M20	2.5	140	25	56	16	15	12	4	17.50	906.080

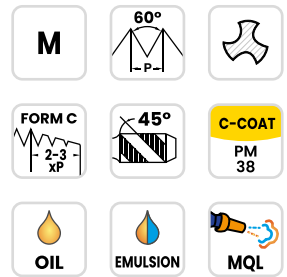
● Cutting parameters

V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 1 - 9	● ● 1 - 3	● ● 1 - 9	● ● 7 - 18	○ 9 - 18	● ● 9 - 18	● ● 13 - 27
	● ● 2 - 6	● ● 2 - 3	● ● 2 - 6	● ● ● 5 - 13	○ 10 - 18	● ● 10 - 18	● ● 10 - 18
	● ● 2 - 7	● ● 2 - 4	● ● 2 - 5	● ● ● 5 - 15	○ 8 - 15	● ● 8 - 15	● ● 10 - 20

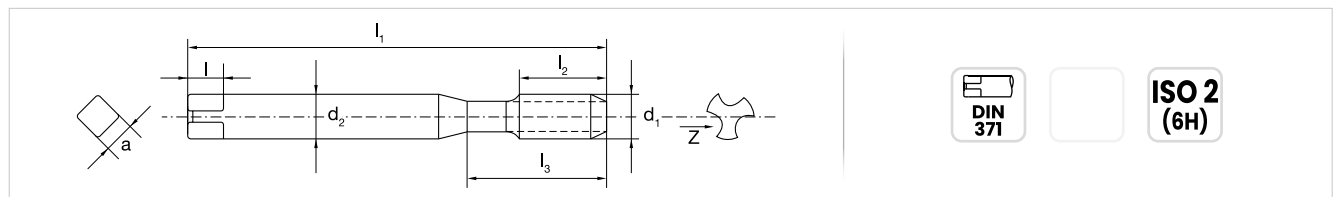
● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For General Use Cast Iron, Aluminium, Aluminium Die Cast, Steels and Stainless Steels < 1'200 N/mm²



● Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	Z	Ø mm	Order code
M3	0.5	56	5	18	3.5	6	2.7	3	2.50	895.065
M4	0.7	63	7	21	4.5	6	3.4	3	3.30	895.075
M5	0.8	70	8	25	6	8	4.9	3	4.20	895.085
M6	1	80	10	30	6	8	4.9	3	5.00	895.090
M8	1.25	90	13	35	8	9	6.2	3	6.80	895.100
M10	1.5	100	15	39	10	11	8	3	8.50	895.110

● Cutting parameters

V _c m/min	Ti	NI 900-1500 N/mm ²	INOX ≤1200 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU SHORT
	● ● 1 - 9	● ● 1 - 3	● ● 7 - 18	● ● 9 - 18	● ● 13 - 27	● ● ● 10 - 32	● ● 3 - 24
	● ● 2 - 6	● ● 2 - 3	● ● ● 5 - 13	● ● 10 - 18	● ● 10 - 18	● ● ● 13 - 32	● ● 4 - 24
	● ● 2 - 7	● ● 2 - 4	● ● ● 5 - 15	● ● 8 - 15	● ● 10 - 20	● ● ● 10 - 30	● ● 5 - 20

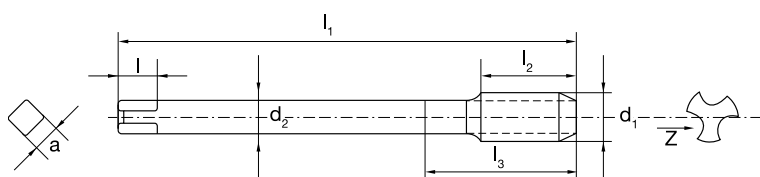
● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For General Use Cast Iron, Aluminium, Aluminium Die Cast, Steels and Stainless Steels < 1'200 N/mm²



● Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M12	1.75	110	18	39	9	10	7	4	10.20	896.060
M16	2	110	20	18	12	12	9	4	14.00	896.070
M20	2.5	140	25	21	16	15	12	4	17.50	896.080

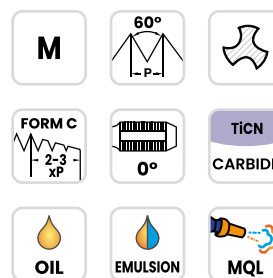
● Cutting parameters

V _c m/min	Ti	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 1 - 9	● ● 7 - 18	○ 9 - 18	● ● 9 - 18	● ● 13 - 27
	● ● 2 - 6	● ● ● 5 - 13	○ 10 - 18	● ● 10 - 18	● ● 10 - 18
	● ● 2 - 7	● ● ● 5 - 15	○ 8 - 15	● ● 8 - 15	● ● 10 - 20

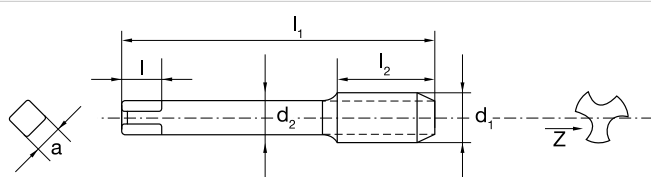
● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Tempered Steels < 62 HRC



Technical details



6HX

d ₁	P	l ₁	l ₂	d ₂	l	a	Z	Ø mm	Order code
M3	0.5	46	11	3.5	2.7	6	4	2.50	960.075
M4	0.7	52	13	4.5	3.4	6	4	3.30	960.095
M5	0.8	60	16	6	4.9	8	4	4.20	960.120
M6	1	62	19	6	4.9	8	5	5.00	960.130
M8	1.25	70	22	6	4.9	8	5	6.80	960.155
M10	1.5	75	24	7	5.5	8	5	8.50	960.185
M12	1.75	82	29	9	7	10	5	10.20	960.215
M14	2	88	30	11	9	12	6	12.00	960.240
M16	2	95	32	12	9	12	6	14.00	960.270
M20	2.5	105	37	16	12	15	6	17.50	960.305

Cutting parameters

V _c m/min	STEEL 50-63 HRC
	●● 2 - 3
	●● 1.5 - 3
	●● 1.5 - 3

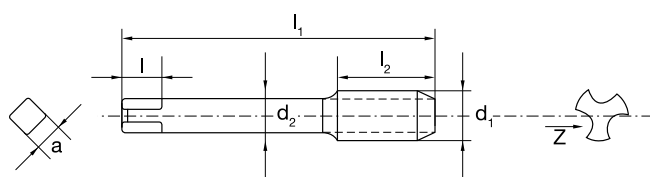
●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Tempered Steels < 62 HRC



● Technical details



6HX

d_1	P	l_1	l_2	d_2	l	α	Z	$\varnothing$ mm	Order code
M3	0.5	46	11	3.5	2.7	6	4	2.50	965.075
M4	0.7	52	13	4.5	3.4	6	4	3.30	965.095
M5	0.8	60	16	6	4.9	8	4	4.20	965.120
M6	1	62	19	6	4.9	8	5	5.00	965.130
M8	1.25	70	22	6	4.9	8	5	6.80	965.155
M10	1.5	75	24	7	5.5	8	5	8.50	965.185
M12	1.75	82	29	9	7	10	5	10.20	965.215
M14	2	88	30	11	9	12	6	12.00	965.240
M16	2	95	32	12	9	12	6	14.00	965.270
M20	2.5	105	37	16	12	15	6	17.50	965.305

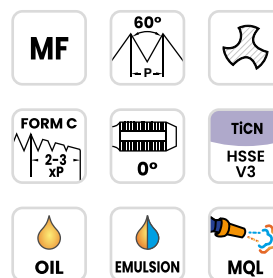
● Cutting parameters

V_c m/min	STEEL 50-63 HRC
	● ● 2 - 3
	● ● ● 1.5 - 3
	● ● 1.5 - 3

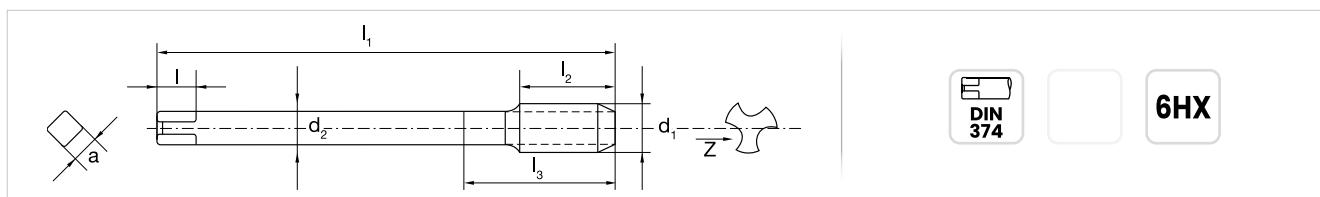
●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Cast Iron and ADC For short chipping material such as GG or ADC



● Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	Z	Ø mm	Order code
M8	1	90	22	36	6	8	4.9	4	7.00	540.070
M10	1	90	20	36	7	8	5.5	4	9.00	540.085
M12	1.5	100	22	40	9	10	7	4	10.50	540.110
M16	1.5	100	22	40	12	12	9	4	14.50	540.150

● Cutting parameters

V _c m/min	CAST	CU
	● ● ● 10 - 32	● ● 3 - 24
	● ● ● 13 - 32	● ● 4 - 24
	● ● ● 10 - 30	● ● 5 - 20

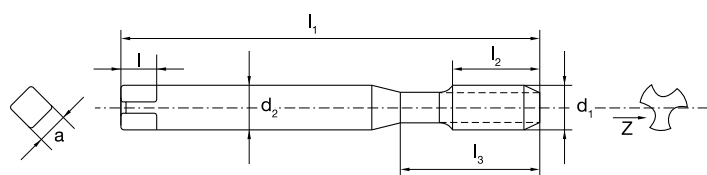
● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Cast Iron and ADC For short chipping material such as GG or ADC



● Technical details



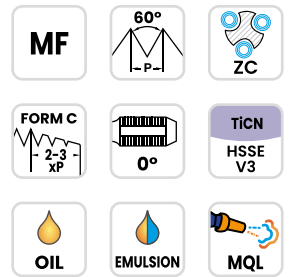
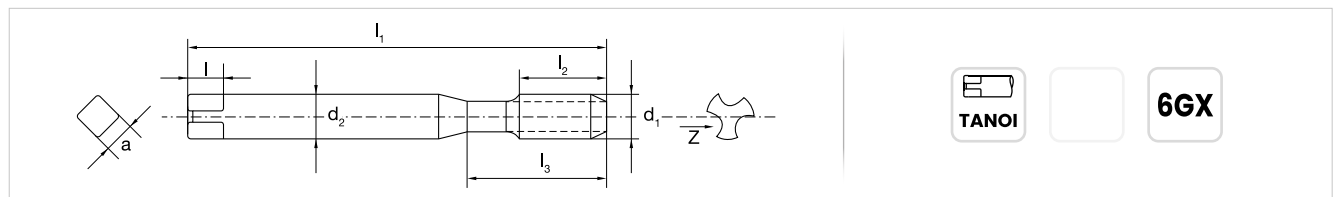
6HX

d_1	P	l_1	l_2	l_3	d_2	l	α	Z	ϕ mm	Order code
M8	1	100	22	40	8	9	6	3	7.00	982.070
M10	1	100	24	39	8	9	6	4	9.00	982.085
M10	1.25	100	24	39	8	9	6	4	8.80	982.090
M12	1	100	29	43	10	11	8	4	11.00	982.100
M12	1.25	100	29	43	10	11	8	4	10.80	982.105
M12	1.5	100	29	43	10	11	8	4	10.50	982.110

● Cutting parameters

V_c m/min	GG/G CAST	CU SHORT	ZDC ADC	ALU Si ≤10%
	● ● ● 14 - 40	● ● 7 - 32	● ● ● 7 - 32	● ● 7 - 32

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS
For Cast Iron and ADC For short chipping material such as GG or ADC

Technical details


d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	Z	Ø mm	Order code
M8	1	100	22	40	8	9	6	3	7.00	983.070
M10	1	100	24	39	8	9	6	4	9.00	983.085
M10	1.25	100	24	39	8	9	6	4	8.80	983.090
M12	1	100	29	43	10	11	8	4	11.00	983.100
M12	1.25	100	29	43	10	11	8	4	10.80	983.105
M12	1.5	100	29	43	10	11	8	4	10.50	983.110

Cutting parameters

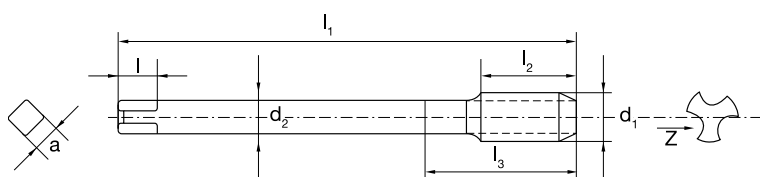
V _c m/min	GG/G CAST	CU SHORT	ZDC ADC	ALU Si <10%
	● ● ● 18 - 45	● ● 9 - 36	● ● ● 18 - 45	● ● 9 - 36

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Steels < 800 N/mm²

● Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M3	0.35	56	8	22	2.2	5	2.5	3	2.65	455.015
M3.5	0.35	56	9	22	2.5	5	2.1	3	3.15	455.020
M4	0.5	63	10	25.2	2.8	5	2.1	3	3.50	455.030
M5	0.5	70	12	28	3.5	6	2.7	3	4.50	455.040
M6	0.5	80	14	32	4.5	6	3.4	3	5.50	455.045
M6	0.75	80	14	32	4.5	6	3.4	3	5.20	455.050
M7	0.75	80	14	32	5.5	7	4.3	3	6.20	455.055
M8	0.5	80	18	32	6	8	4.9	3	7.50	455.060
M8	0.75	80	18	32	6	8	4.9	3	7.20	455.065
M8	1	90	22	36	6	8	4.9	3	7.00	455.070
M9	1	90	22	36	7	8	5.5	3	8.00	455.075
M10	0.75	90	20	36	7	8	5.5	3	9.20	455.080
M10	1	90	20	36	7	8	5.5	3	9.00	455.085
M10	1.25	100	24	40	7	8	5.5	3	8.80	455.090
M11	1	90	20	36	8	9	6.2	3	10.00	455.095
M12	1	100	22	40	9	10	7	3	11.00	455.100
M12	1.25	100	22	40	9	10	7	3	10.80	455.105
M12	1.5	100	22	40	9	10	7	3	10.50	455.110

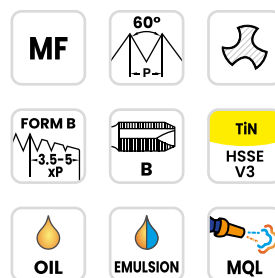
● Cutting parameters

V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 8 - 15	● ● ● 15 - 30	○ 15 - 40	● ● 5 - 30	● ● 5 - 30	● ● 5 - 30	● ● 15 - 30

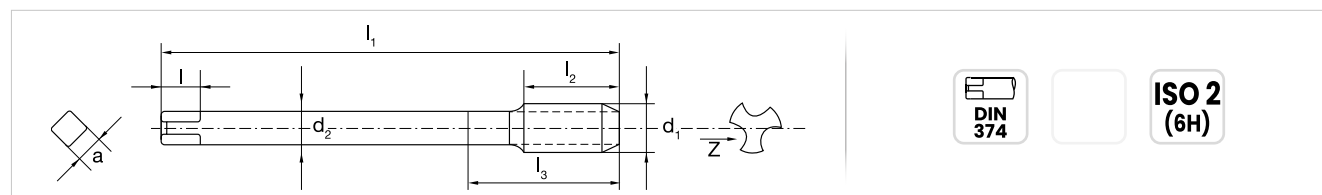
● ● ● Recommended | ● ● Suitable | ○ Possible

d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	 mm	Order code
M14	1	100	22	40	11	12	9	3	13.00	455.120
M14	1.25	100	22	40	11	12	9	3	12.80	455.125
M14	1.5	100	22	40	11	12	9	3	12.50	455.130
M15	1	100	22	40	12	12	9	3	14.00	455.135
M15	1.5	100	22	40	12	12	9	3	13.50	455.140
M16	1	100	22	40	12	12	9	3	15.00	455.145
M16	1.5	100	22	40	12	12	9	3	14.50	455.150
M18	1	110	25	44	14	14	11	3	17.00	455.155
M18	1.5	110	25	44	14	14	11	3	16.50	455.160
M18	2	125	34	50	14	14	11	3	16.00	455.165
M20	1	125	25	50	16	15	12	3	19.00	455.170
M20	1.5	125	25	50	16	15	12	3	18.50	455.175
M20	2	140	34	56	16	15	12	3	18.00	455.180
M22	1	125	25	50	18	17	14.5	3	21.00	455.185
M22	1.5	125	25	50	18	17	14.5	3	20.50	455.190
M22	2	140	34	56	18	17	14.5	3	20.00	455.195
M24	1	140	28	56	18	17	14.5	3	23.00	455.200
M24	1.5	140	28	56	18	17	14.5	3	22.50	455.205
M24	2	140	28	56	18	17	14.5	3	22.00	455.210
M25	1.5	140	28	56	18	17	14.5	3	23.50	455.215
M26	1.5	140	28	56	18	17	14.5	4	24.50	455.220
M27	1.5	140	28	56	20	19	16	4	25.50	455.225
M27	2	140	28	56	20	19	16	4	25.00	455.230
M28	1.5	140	28	56	20	19	16	4	26.50	455.235
M30	1	150	28	60	22	21	18	4	29.00	455.240
M30	1.5	150	28	60	22	21	18	4	28.50	455.245
M30	2	150	28	60	22	21	18	4	28.00	455.250
M32	1.5	150	30	60	22	21	18	4	30.50	455.255
M33	1.5	160	30	64	25	23	20	4	31.50	455.260
M34	1.5	170	30	68	28	25	22	4	32.50	455.270
M35	1.5	170	30	68	28	25	22	4	33.50	455.275
M36	1.5	170	30	68	28	25	22	4	34.50	455.280
M38	1.5	170	30	68	28	25	22	4	36.50	455.295
M40	1.5	170	30	68	32	27	24	4	38.50	455.310
M42	1.5	170	30	68	32	27	24	4	40.50	455.325
M45	1.5	180	32	72	36	32	29	4	43.50	455.340
M48	1.5	190	32	76	36	32	29	4	46.50	455.355
M50	1.5	190	32	76	36	32	29	4	48.50	455.370
M52	1.5	190	32	76	40	35	30	4	50.50	455.385

CUTTING TAPS

For Steels < 800 N/mm²

● Technical details

DIN
374ISO 2
(6H)

d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	Z	Ø mm	Order code
M6	0.75	80	14	32	4.5	6	3.4	3	5.20	465.050
M8	1	90	22	36	6	8	4.9	3	7.00	465.070
M10	1	90	20	36	7	8	5.5	3	9.00	465.085
M12	1.5	100	22	40	9	10	7	3	10.50	465.110
M16	1.5	100	22	40	12	12	9	3	14.50	465.150

● Cutting parameters

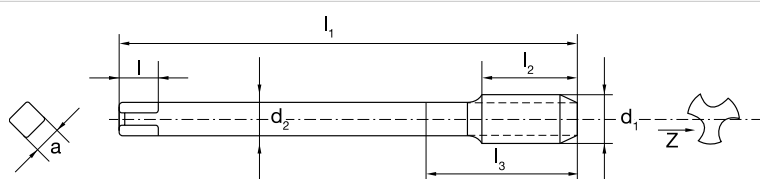
V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 8 - 15	● ● ● 15 - 30	○ 15 - 40	● ● 5 - 30	● ● 5 - 30	● ● 5 - 30	● ● 15 - 30

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Steels < 800 N/mm²

● Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	Z	Ø mm	Order code
M3	0.35	56	8		2.2	5	2.5	3	2.65	460.015
M3.5	0.35	56	9		2.2	5	2.1	3	3.15	460.020
M4	0.5	63	10	25	2.8	5	2.1	3	3.50	460.030
M5	0.5	70	12	28	3.5	6	2.7	3	4.50	460.040
M6	0.5	80	14	32	4.5	6	3.4	3	5.50	460.045
M6	0.75	80	14	32	4.5	6	3.4	4	5.20	460.050
M7	0.75	80	14	32	5.5	7	4.3	4	6.20	460.055
M8	0.5	80	18	32	6	8	4.9	4	7.50	460.060
M8	0.75	80	18	32	6	8	4.9	4	7.20	460.065
M8	1	90	22	36	6	8	4.9	4	7.00	460.070
M9	1	90	22	36	7	8	5.5	4	8.00	460.075
M10	0.75	90	20	36	7	8	5.5	4	9.20	460.080
M10	1	90	20	36	7	8	5.5	4	9.00	460.085
M10	1.25	100	24	40	7	8	5.5	4	8.80	460.090
M11	1	90	20	36	8	9	6.2	4	10.00	460.095
M12	1	100	22	40	9	10	7	4	11.00	460.100
M12	1.25	100	22	40	9	10	7	4	10.80	460.105
M12	1.5	100	22	40	9	10	7	4	10.50	460.110

● Cutting parameters

V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 5 - 12	● ● ● 10 - 24	○ 10 - 32	● ● 3 - 24	● ● 3 - 24	● ● 3 - 24	● ● 10 - 24
	○ 4 - 12	● ● ● 9 - 16	○ 13 - 32	● ● 4 - 24	● ● 4 - 24	● ● 4 - 24	● ● 9 - 16
	○ 5 - 10	● ● ● 10 - 15	○ 15 - 40	● ● 5 - 20	● ● 5 - 20	● ● 5 - 20	● ● 10 - 15

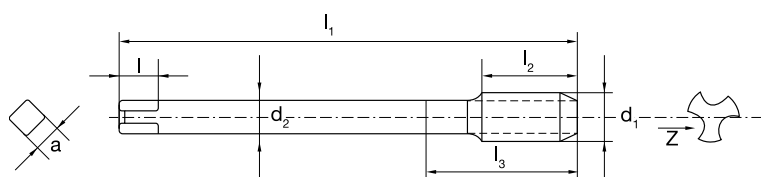
● ● ● Recommended | ● ● Suitable | ○ Possible

d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	 mm	Order code
M14	1	100	22	40	11	12	9	4	13.00	460.120
M14	1.25	100	22	40	11	12	9	4	12.80	460.125
M14	1.5	100	22	40	11	12	9	4	12.50	460.130
M15	1	100	22	40	12	12	9	4	14.00	460.135
M15	1.5	100	22	40	12	12	9	4	13.50	460.140
M16	1	100	22	40	12	12	9	4	15.00	460.145
M16	1.5	100	22	40	12	12	9	4	14.50	460.150
M18	1	110	25	44	14	14	11	4	17.00	460.155
M18	1.5	110	25	44	14	14	11	4	16.50	460.160
M18	2	125	34	50	14	14	11	4	16.00	460.165
M20	1	125	25	50	16	15	12	4	19.00	460.170
M20	1.5	125	25	50	16	15	12	4	18.50	460.175
M20	2	140	34	56	16	15	12	4	18.00	460.180
M22	1	125	25	50	18	17	14.5	4	21.00	460.185
M22	1.5	125	25	50	18	17	14.5	4	20.50	460.190
M22	2	140	34	56	18	17	14.5	4	20.00	460.195
M24	1	140	28	56	18	17	14.5	4	23.00	460.200
M24	1.5	140	28	56	18	17	14.5	4	22.50	460.205
M24	2	140	28	56	18	17	14.5	4	22.00	460.210
M25	1.5	140	28	56	18	17	14.5	4	23.50	460.215
M26	1.5	140	28	56	18	17	14.5	4	24.50	460.220
M27	1.5	140	28	56	20	19	16	4	25.50	460.225
M27	2	140	28	56	20	19	16	4	25.00	460.230
M28	1.5	140	28	56	20	19	16	4	26.50	460.235
M30	1	150	28	60	22	21	18	4	29.00	460.240
M30	1.5	150	28	60	22	21	18	4	28.50	460.245
M30	2	150	28	60	22	21	18	4	28.00	460.250
M32	1.5	150	28	60	22	21	18	6	30.50	460.255
M33	1.5	160	30	64	25	23	20	6	31.50	460.260
M34	1.5	170	30	68	28	25	22	6	32.50	460.270
M35	1.5	170	30	68	28	25	22	6	33.50	460.275
M36	1.5	170	30	68	28	25	22	6	34.50	460.280
M38	1.5	170	30	68	28	25	22	6	36.50	460.295
M40	1.5	170	30	68	32	27	24	6	38.50	460.310
M42	1.5	170	30	68	32	27	24	6	40.50	460.325
M45	1.5	180	32	72	36	32	29	6	43.50	460.340
M48	1.5	190	32	76	36	32	29	6	46.50	460.355
M50	1.5	190	32	76	36	32	29	6	48.50	460.370
M52	1.5	190	32	76	40	35	32	6	50.50	460.385

CUTTING TAPS

For Steels < 800 N/mm²

● Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M4	0.5	63	6	25.2	2.8	5	2.1	3	3.50	475.030
M5	0.5	70	7	28	3.5	6	2.7	3	4.50	475.040
M6	0.75	80	8	32	4.5	6	3.4	3	5.20	475.050
M8	0.75	80	10	32	6	8	4.9	3	7.20	475.065
M8	1	90	10	36	6	8	4.9	3	7.00	475.070
M10	1	90	12	36	7	8	5.5	3	9.00	475.085
M10	1.25	100	12	40	7	8	5.5	3	8.80	475.090
M12	1	100	14	40	9	10	7	3	11.00	475.100
M12	1.25	100	14	40	9	10	7	3	10.80	475.105
M12	1.5	100	14	40	9	10	7	3	10.50	475.110
M14	1	100	16	40	11	12	9	3	13.00	475.120
M14	1.25	100	16	40	11	12	9	3	12.80	475.125
M14	1.5	100	16	40	11	12	9	3	12.50	475.130
M16	1	100	16	40	12	12	9	3	15.00	475.145
M16	1.5	100	16	40	12	12	9	3	14.50	475.150
M18	1	110	20	44	14	14	11	4	17.00	475.155
M18	1.5	110	20	44	14	14	11	4	16.50	475.160
M20	1	125	20	50	16	15	12	4	19.00	475.170

● Cutting parameters

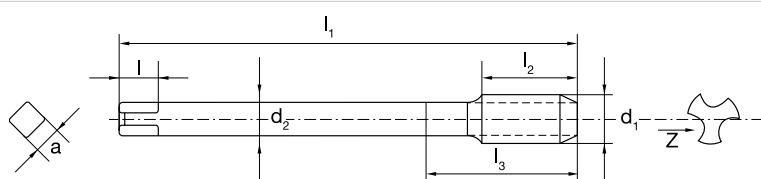
V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 7 - 13	●● 13 - 27	○ 13 - 36	●● 4 - 27	●● 4 - 27	●● 4 - 27	●● 13 - 27
	○ 4 - 13	●●● 9 - 18	○ 13 - 36	●● 4 - 27	●● 4 - 27	●● 4 - 27	●● 9 - 18
	○ 5 - 10	●●● 10 - 15	○ 15 - 40	●● 5 - 20	●● 5 - 20	●● 5 - 20	●● 10 - 15

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Steels < 800 N/mm²

● Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M3	0.35	56	4	22	2.2	5	2.5	3	2.65	480.015
M4	0.5	63	6	25.2	2.8	5	2.1	3	3.50	480.030
M5	0.5	70	7	28	3.5	6	2.7	3	4.50	480.040
M6	0.5	80	8	32	4.5	6	3.4	3	5.50	480.045
M6	0.75	80	8	32	4.5	6	3.4	3	5.20	480.050
M8	0.5	80	10	32	6	8	3.4	3	7.50	480.060
M8	0.75	80	10	32	6	8	3.4	3	7.20	480.065
M8	1	90	10	36	6	8	4.9	3	7.00	480.070
M10	1	90	12	36	7	8	5.5	3	9.00	480.085
M10	1.25	100	12	40	7	8	5.5	3	8.80	480.090
M12	1	100	14	40	9	10	7	3	11.00	480.100
M12	1.25	100	14	40	9	10	7	3	10.80	480.105
M12	1.5	100	14	40	9	10	7	3	10.50	480.110
M14	1	100	16	40	11	12	9	3	13.00	480.120
M14	1.25	100	16	40	11	12	9	3	12.80	480.125
M14	1.5	100	16	40	11	12	9	3	12.50	480.130
M16	1	100	16	40	12	12	9	3	15.00	480.145
M16	1.5	100	16	40	12	12	9	3	14.50	480.150

● Cutting parameters

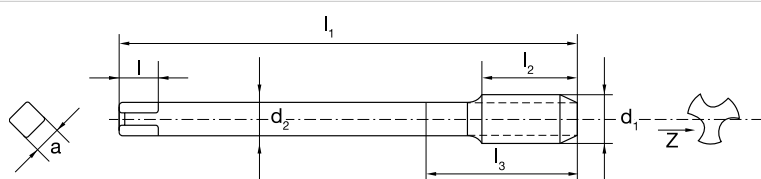
V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 7 - 13	●● 13 - 27	○ 13 - 36	●● 4 - 27	●● 4 - 27	●● 4 - 27	●● 13 - 27
	○ 4 - 13	●●● 9 - 18	○ 13 - 36	●● 4 - 27	●● 4 - 27	●● 4 - 27	●● 9 - 18
	○ 5 - 10	●●● 10 - 15	○ 15 - 40	●● 5 - 20	●● 5 - 20	●● 5 - 20	●● 10 - 15

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Steels < 800 N/mm²

● Technical details



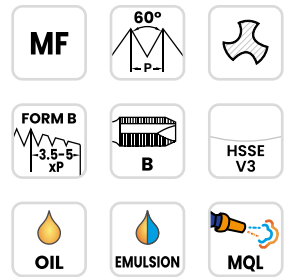
d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	Z	Ø mm	Order code
M6	0.75	80	8	32	4.5	6	3.4	3	5.20	485.050
M8	1	90	10	36	6	8	4.9	3	7.00	485.070
M10	1	90	12	36	7	8	5.5	3	9.00	485.085
M12	1.5	100	14	40	9	10	7	3	10.50	485.110
M16	1.5	100	16	40	12	12	9	3	14.50	485.150

● Cutting parameters

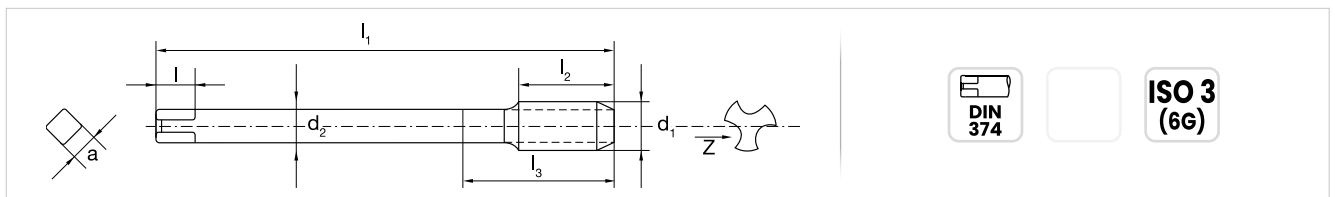
V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 7 - 13	●● 13 - 27	○ 13 - 36	●● 4 - 27	●● 4 - 27	●● 4 - 27	●● 13 - 27
	○ 5 - 13	●●● 10 - 18	○ 15 - 36	●● 5 - 27	●● 5 - 27	●● 5 - 27	●● 10 - 18
	○ 5 - 10	●●● 10 - 15	○ 15 - 40	●● 5 - 20	●● 5 - 20	●● 5 - 20	●● 10 - 15

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Steels < 800 N/mm²

● Technical details



DIN 374

ISO 3
(6G)

d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø/mm	Order code
M6	0.75	80	14	32	4.5	6	3.4	3	5.20	470.050
M8	1	90	22	36	6	8	4.9	3	7.00	470.070
M10	1	90	20	36	7	8	5.5	3	9.00	470.085
M12	1.5	100	22	40	9	10	7	3	10.50	470.110
M14	1.5	100	22	40	11	12	9	3	12.50	470.130
M16	1.5	100	22	40	12	12	9	3	14.50	470.150
M18	1.5	110	25	44	14	14	11	3	16.50	470.160
M20	1.5	125	25	50	16	15	12	3	18.50	470.175

● Cutting parameters

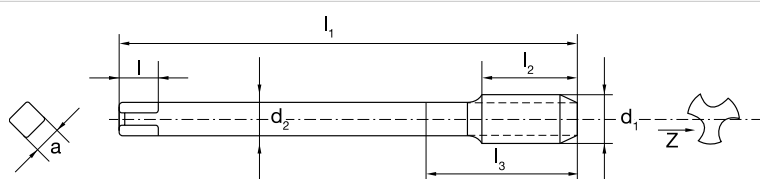
V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 8 - 15	●●● 15 - 30	○ 15 - 40	●● 5 - 30	●● 5 - 30	●● 5 - 30	●● 15 - 30

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Steels < 800 N/mm²

● Technical details



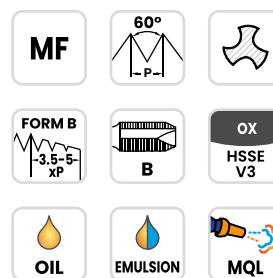
d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M6	0.75	80	8	32	4.5	6	3.4	3	5.20	490.050
M8	1	90	10	36	6	8	4.9	3	7.00	490.070
M10	1	90	12	36	7	8	5.5	3	9.00	490.085
M12	1.5	100	14	40	9	10	7	3	10.50	490.110
M14	1.5	100	16	40	11	12	9	3	12.50	490.130
M16	1.5	100	16	40	12	12	9	3	14.50	490.150
M18	1.5	110	20	44	14	14	11	4	16.50	490.160
M20	1.5	125	20	50	16	15	12	4	18.50	490.175

● Cutting parameters

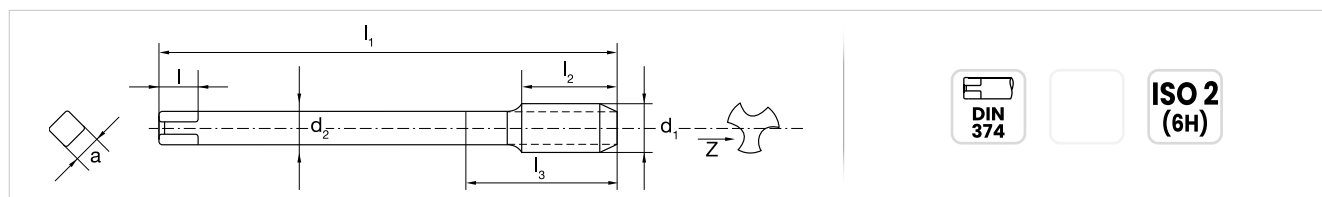
V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 7 - 13	●● 13 - 27	○ 13 - 36	●● 4 - 27	●● 4 - 27	●● 4 - 27	●● 13 - 27
	○ 4 - 13	●●● 9 - 18	○ 13 - 36	●● 4 - 27	●● 4 - 27	●● 4 - 27	●● 9 - 18
	○ 5 - 10	●●● 10 - 15	○ 15 - 40	●● 5 - 20	●● 5 - 20	●● 5 - 20	●● 10 - 15

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²

● Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	Z	Ø mm	Order code
M3	0.35	56	8	22	2.2	5	2.5	3	2.65	495.015
M4	0.5	63	10	25	2.8	5	2.1	3	3.50	495.030
M5	0.5	70	12	28	3.5	6	2.7	3	4.50	495.040
M6	0.5	80	14	32	4.5	6	3.4	3	5.50	495.045
M6	0.75	80	14	32	4.5	6	3.4	3	5.20	495.050
M8	0.75	80	18	32	6	8	4.9	3	7.20	495.065
M8	1	90	22	36	6	8	4.9	3	7.00	495.070
M10	1	90	20	36	7	8	5.5	3	9.00	495.085
M12	1	100	22	40	9	10	7	3	11.00	495.100
M12	1.5	100	22	40	9	10	7	3	10.50	495.110
M14	1.5	100	22	40	11	12	9	3	12.50	495.130
M16	1.5	100	22	40	12	12	9	3	14.50	495.150
M18	1.5	110	25	44	14	14	11	3	16.50	495.160
M20	1.5	125	25	50	16	15	12	3	18.50	495.175
M22	1.5	125	25	50	18	17	14.5	3	20.50	495.190
M24	1.5	140	28	56	18	17	14.5	3	22.50	495.205

● Cutting parameters

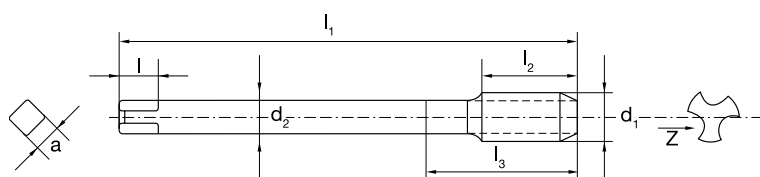
V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 2 - 10	● ● 2 - 4	● ● 2 - 10	● ● ● ● 8 - 20	○ 10 - 20	● ● 10 - 20	● ● 15 - 30

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²

● Technical details



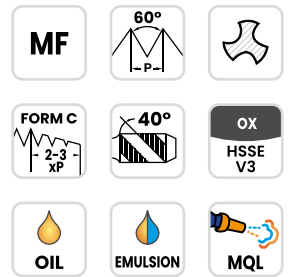
d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M8	1	90	22	36	6	8	4.9	3	7.00	500.070
M10	1	90	20	36	7	8	5.5	3	9.00	500.085
M12	1.5	100	22	40	9	10	7	3	10.50	500.110
M16	1.5	100	22	40	12	12	9	3	14.50	500.150
M20	1.5	125	25	50	16	15	12	3	18.50	500.175

● Cutting parameters

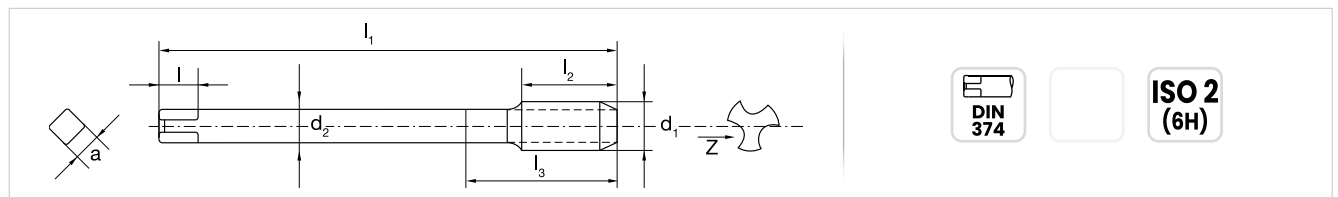
V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 2 - 10	● ● 2 - 4	● ● 2 - 10	● ● ● ● 8 - 20	○ 10 - 20	● ● 10 - 20	● ● 15 - 30

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²

● Technical details



DIN 374

ISO 2
(6H)

d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	Z	Ø/mm	Order code
M3	0.35	56	4	22	2.2	5	2.5	3	2.65	515.015
M4	0.5	63	6	25.2	2.8	5	2.1	3	3.50	515.030
M5	0.5	70	7	28	3.5	6	2.7	3	4.50	515.040
M6	0.5	80	8	32	4.5	6	3.4	3	5.50	515.045
M6	0.75	80	8	32	4.5	6	3.4	3	5.20	515.050
M8	0.75	80	10	32	6	8	4.9	3	7.20	515.065
M8	1	90	10	36	6	8	4.9	3	7.00	515.070
M10	1	90	12	36	7	8	5.5	4	9.00	515.085
M12	1	100	14	40	9	10	7	4	11.00	515.100
M12	1.5	100	14	40	9	10	7	4	10.50	515.110
M14	1.5	100	16	40	11	12	9	4	12.50	515.130
M16	1.5	100	16	40	12	12	9	5	14.50	515.150
M18	1.5	110	20	44	14	14	11	5	16.50	515.160
M20	1.5	125	20	50	16	15	12	5	18.50	515.175
M22	1.5	125	20	50	18	17	14.5	5	20.50	515.190
M24	1.5	140	24	56	18	17	14.5	5	22.50	515.205
M27	1.5	140	24	56	20	19	16	5	25.50	515.225
M30	1.5	150	28	60	22	21	18	5	28.50	515.245

● Cutting parameters

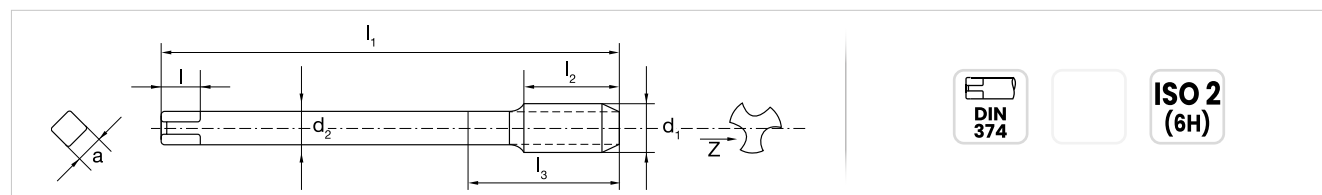
V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 1 - 9	● ● 1 - 3	● ● 1 - 9	● ● 7 - 18	○ 9 - 18	● ● 9 - 18	● ● 13 - 27
	● ● 1 - 6	● ● 1 - 3	● ● 1 - 6	● ● ● 4 - 13	○ 9 - 18	● ● 9 - 18	● ● 9 - 18
	● ● 2 - 7	● ● 2 - 4	● ● 2 - 5	● ● ● 5 - 15	○ 8 - 15	● ● 8 - 15	● ● 10 - 20

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²

● Technical details



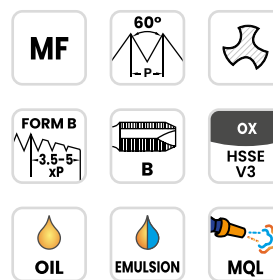
d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M8	1	90	10	36	6	8	4.9	3	7.00	520.070
M10	1	90	12	36	7	8	5.5	4	9.00	520.085
M12	1.5	100	14	40	9	10	7	4	10.50	520.110
M16	1.5	100	16	40	12	12	9	5	14.50	520.150
M20	1.5	125	20	50	16	15	12	5	18.50	520.175

● Cutting parameters

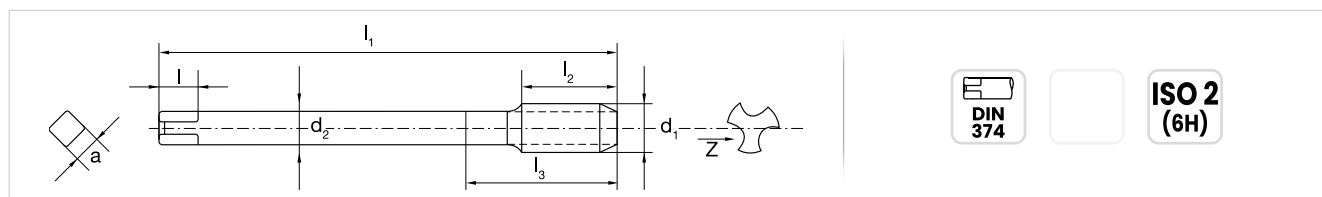
V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 1 - 9	● ● 1 - 3	● ● 1 - 9	● ● 7 - 18	○ 9 - 18	● ● 9 - 18	● ● 13 - 27
	● ● 1 - 6	● ● 1 - 3	● ● 1 - 6	● ● ● 4 - 13	○ 9 - 18	● ● 9 - 18	● ● 9 - 18
	● ● 2 - 7	● ● 2 - 4	● ● 2 - 5	● ● ● 5 - 15	○ 8 - 15	● ● 8 - 15	● ● 10 - 20

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²

● Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M6	0.75	80	14	32	4.5	6	3.4	3	5.20	505.050
M8	1	90	22	36	6	8	4.9	3	7.00	505.070
M10	1	90	20	36	7	8	5.5	3	9.00	505.085
M12	1.5	100	22	40	9	10	7	3	10.50	505.110
M14	1.5	100	22	40	11	12	9	3	12.50	505.130
M16	1.5	100	22	40	12	12	9	3	14.50	505.150
M18	1.5	110	25	44	14	14	11	3	16.50	505.160
M20	1.5	125	25	50	16	15	12	3	18.50	505.175

● Cutting parameters

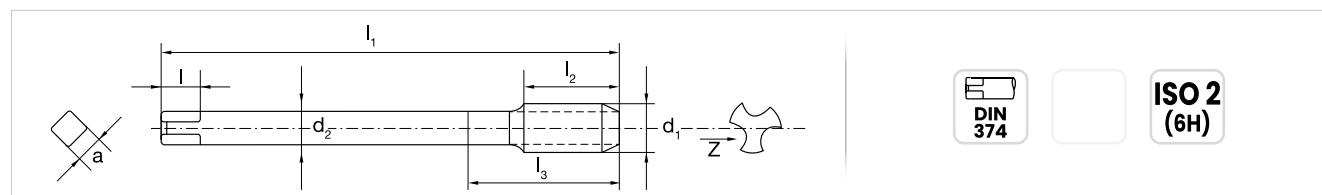
V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 2 - 10	● ● 2 - 4	● ● 2 - 10	● ● ● ● 8 - 20	○ 10 - 20	● ● 10 - 20	● ● 15 - 30

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²

● Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	Z	Ø mm	Order code
M8	1	90	22	36	6	8	4.9	3	7.00	510.070
M10	1	90	20	36	7	8	5.5	3	9.00	510.085
M12	1.5	100	22	40	9	10	7	3	10.50	510.110
M16	1.5	100	22	40	12	12	9	3	14.50	510.150
M20	1.5	125	25	50	16	15	12	3	18.50	510.175

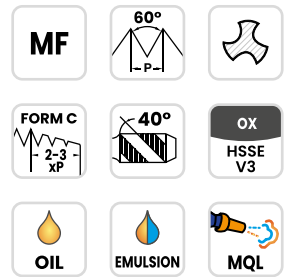
● Cutting parameters

V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 2 - 10	● ● 2 - 4	● ● 2 - 10	● ● ● ● 8 - 20	○ 10 - 20	● ● 10 - 20	● ● 15 - 30

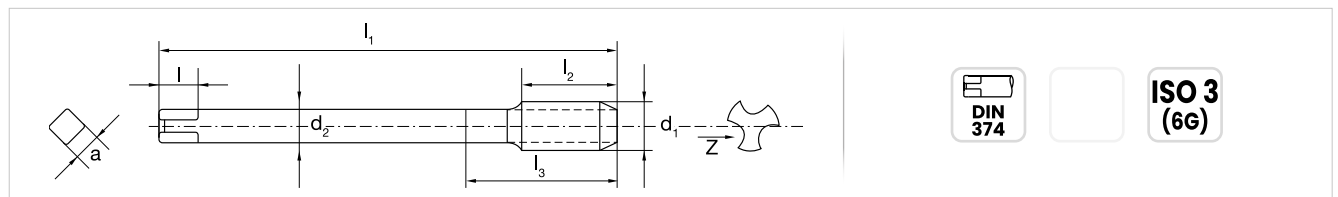
● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²



Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	Z	Ø/mm	Order code
M6	0.75	80	8	32	4.5	6	3.4	3	5.20	525.050
M8	1	90	10	36	6	8	4.9	3	7.00	525.070
M10	1	90	12	36	7	8	5.5	4	9.00	525.085
M12	1.5	100	14	40	9	10	7	4	10.50	525.110
M14	1.5	100	16	40	11	12	9	4	12.50	525.130
M16	1.5	100	16	40	12	12	9	5	14.50	525.150
M18	1.5	110	20	44	14	14	11	5	16.50	525.160
M20	1.5	125	20	50	16	15	12	5	18.50	525.175

Cutting parameters

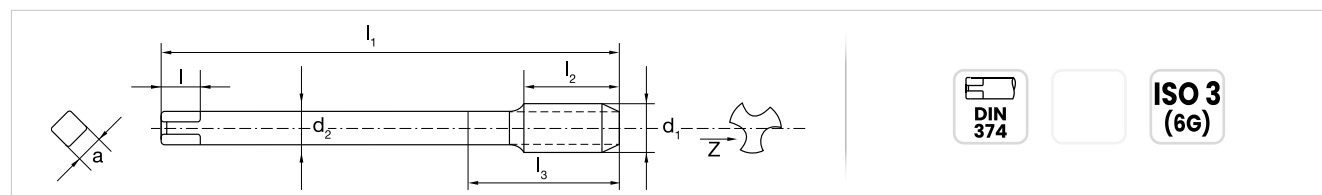
V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 1 - 9	● ● 1 - 3	● ● 1 - 9	● ● 7 - 18	○ 9 - 18	● ● 9 - 18	● ● 13 - 27
	● ● 1 - 6	● ● 1 - 3	● ● 1 - 6	● ● ● 4 - 13	○ 9 - 18	● ● 9 - 18	● ● 9 - 18
	● ● 2 - 7	● ● 2 - 4	● ● 2 - 5	● ● ● 5 - 15	○ 8 - 15	● ● 8 - 15	● ● 10 - 20

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²

● Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M8	1	90	10	36	6	8	4.9	3	7.00	530.070
M10	1	90	12	36	7	8	5.5	4	9.00	530.085
M12	1.5	100	14	40	9	10	7	4	10.50	530.110
M16	1.5	100	16	40	12	12	9	5	14.50	530.150
M20	1.5	125	20	50	16	15	12	5	18.50	530.175

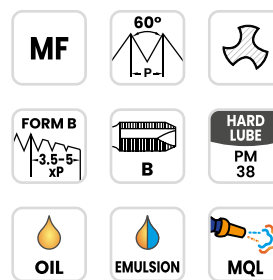
● Cutting parameters

V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 1 - 9	● ● 1 - 3	● ● 1 - 9	● ● 7 - 18	○ 9 - 18	● ● 9 - 18	● ● 13 - 27
	● ● 1 - 6	● ● 1 - 3	● ● 1 - 6	● ● ● 4 - 13	○ 9 - 18	● ● 9 - 18	● ● 9 - 18
	● ● 2 - 7	● ● 2 - 4	● ● 2 - 5	● ● ● 5 - 15	○ 8 - 15	● ● 8 - 15	● ● 10 - 20

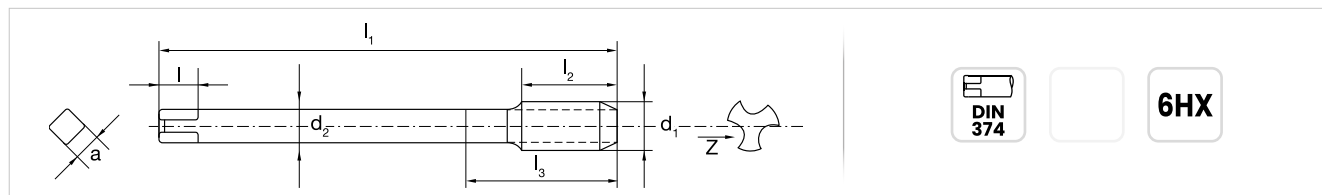
● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For General Use Cast Iron, Aluminium, Aluminium Die Cast, Steels and Stainless Steels < 1'200 N/mm²



● Technical details



d ₁	P	l ₁	l ₂	d ₂	l	a	Z	Ø mm	Order code
M8	1	90	22	6	8	4.9	3	7.00	887.070
M10	1	90	20	7	8	5.5	3	9.00	887.085
M10	1.25	100	24	7	8	5.5	3	8.80	887.090
M12	1	100	22	9	10	7	4	11.00	887.100
M12	1.25	100	22	9	10	7	4	10.80	887.105
M12	1.5	100	22	9	10	7	4	10.50	887.110
M14	1.5	100	22	11	12	9	4	12.50	887.130
M16	1.5	100	22	12	12	9	4	14.50	887.150
M18	1.5	110	25	14	14	11	4	16.50	887.160
M20	1.5	125	25	16	15	12	4	18.50	887.175

● Cutting parameters

V _c m/min	Ti	NI 900-1500 N/mm ²	INOX ≤1200 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU SHORT
	● ● 2 - 10	● ● 2 - 4	● ● ● ● 8 - 20	● ● 10 - 20	● ● 15 - 30	● ● ● ● 10 - 32	● ● 3 - 24
						● ● ● ● 13 - 32	● ● 4 - 24
						● ● ● ● 10 - 30	● ● 5 - 20

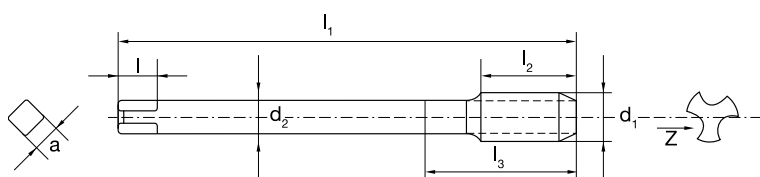
●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For General Use Cast Iron, Aluminium, Aluminium Die Cast, Steels and Stainless Steels < 1'200 N/mm²



● Technical details



6HX

d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
M8	1	90	10	36	6	8	4.9	3	7.00	902.070
M10	1	90	12	36	7	8	5.5	3	9.00	902.085
M10	1.25	100	12	40	7	8	5.5	3	8.80	902.090
M12	1	100	14	40	9	10	7	4	11.00	902.100
M12	1.25	100	14	40	9	10	7	4	10.80	902.105
M12	1.5	100	14	40	9	10	7	4	10.50	902.110
M14	1.5	100	16	40	11	12	9	4	12.50	902.130
M16	1.5	100	16	40	12	12	9	4	14.50	902.150
M18	1.5	110	20	44	14	14	11	4	16.50	902.160
M20	1.5	125	20	50	16	15	12	4	18.50	902.175

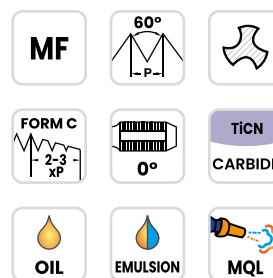
● Cutting parameters

V _c m/min	Ti	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 1 - 9	● ● 7 - 18	○ 9 - 18	● ● 9 - 18	● ● 13 - 27
	● ● 2 - 6	● ● ● 5 - 13	○ 10 - 18	● ● 10 - 18	● ● 10 - 18
	● ● 2 - 7	● ● ● 5 - 15	○ 8 - 15	● ● 8 - 15	● ● 10 - 20

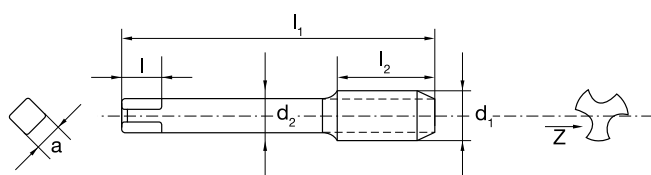
● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Tempered Steels < 62 HRC



● Technical details



6HX

d_1	P	l_1	l_2	d_2	l	a	Z	$\emptyset$ mm	Order code
M8	1	70	22	6	4.9	8	5	7.00	960.170
M10	1	75	24	7	5.5	8	5	9.00	960.195
M12	1	82	29	9	7	10	5	11.00	960.220
M12	1.5	82	29	9	7	10	5	10.50	960.230
M14	1.5	88	30	11	9	12	6	12.50	960.255
M16	1.5	95	32	12	9	12	6	14.50	960.280
M20	1.5	105	37	12	12	15	6	18.50	960.315

● Cutting parameters

V_c m/min	STEEL 50-63 HRC
	● ● 2 - 3
	● ● 1.5 - 3
	● ● 1.5 - 3

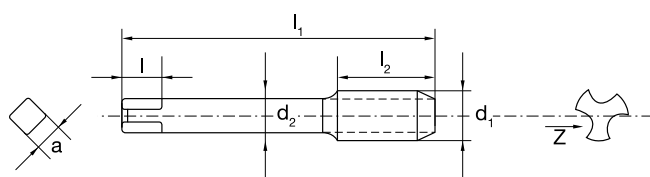
● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Tempered Steels < 62 HRC



● Technical details



6HX

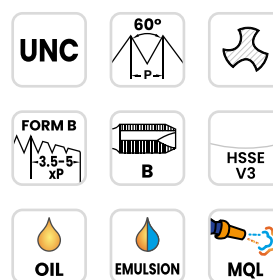
d_1	P	l_1	l_2	d_2	l	α	Z	$\varnothing$ mm	Order code
M8	1	70	22	6	4.9	8	5	7.00	965.170
M10	1	75	24	7	5.5	8	5	9.00	965.195
M12	1	82	29	9	7	10	5	11.00	965.220
M12	1.5	82	29	9	7	10	5	10.50	965.230
M14	1.5	88	30	11	9	12	6	12.50	965.255
M16	1.5	95	32	12	9	12	6	14.50	965.280
M20	1.5	105	37	12	12	15	6	18.50	965.315

● Cutting parameters

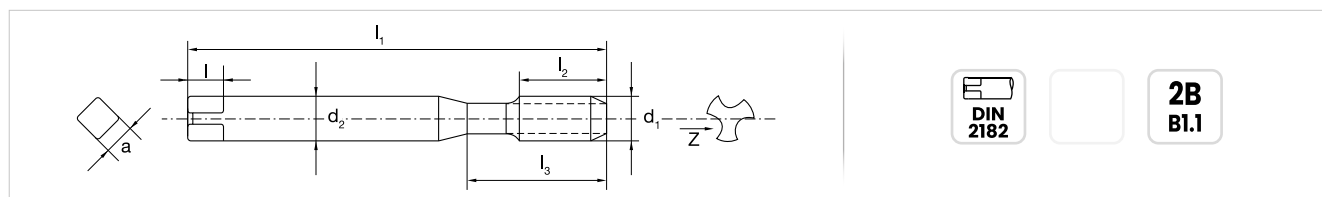
V_c m/min	STEEL 50-63 HRC
	● ● 2 - 3
	● ● ● 1.5 - 3
	● ● 1.5 - 3

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Steels < 800 N/mm²

● Technical details

DIN
21822B
B1.1

d ₁	TPI	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
No.1	64	50	8	9	2.8	5	2.1	2	1.55	580.005
No.2	56	50	9	10	2.8	5	2.1	2	1.85	580.010
No.3	48	50	9	10	2.8	5	2.1	2	2.10	580.015
No.4	40	56	11	18	3.5	6	2.7	2	2.35	580.020
No.5	40	56	11	18	3.5	6	2.7	3	2.65	580.025
No.6	32	56	13	19	4	6	3	3	2.85	580.030
No.8	32	63	13	19	4.5	6	3.4	3	3.50	580.035
No.10	24	70	16	20	6	8	4.9	3	3.90	580.040
No.12	24	80	17	29	6	8	4.9	3	4.50	580.045
1/4	20	80	19	30	7	8	5.5	3	5.10	580.050
5/16	18	90	22	34	8	9	6.2	3	6.60	580.055
3/8	16	90	22	35	9	10	7	3	8.00	580.060

● Cutting parameters

V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 8 - 15	●●● 15 - 30	○ 15 - 40	●● 5 - 30	●● 5 - 30	●● 5 - 30	●● 15 - 30

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Steels < 800 N/mm²

UNC

60°

FORM B
-3.5-5-
XP

B

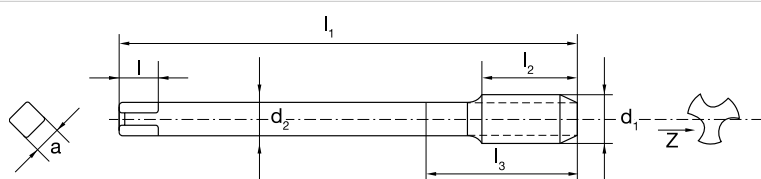
HSSE
V3

OIL

EMULSION

MQL

● Technical details

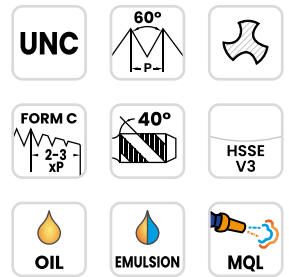
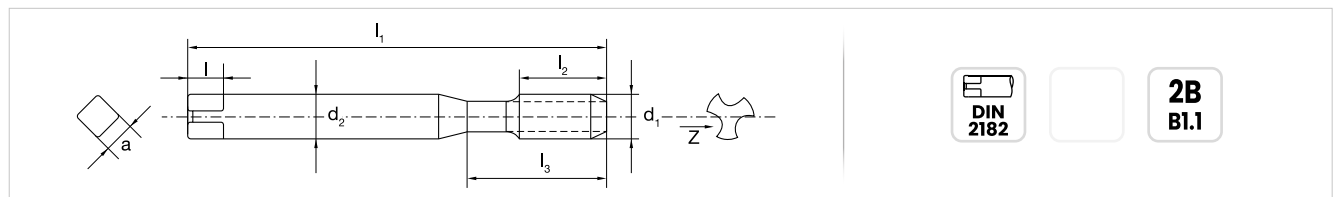
DIN
21832B
B1.1

d ₁	TPI	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
7/16	14	100	24	40	8	8	6.2	3	9.40	585.065
1/2	13	110	29	44	9	10	7	3	10.80	585.070
9/16	12	110	30	44	11	12	9	3	12.20	585.075
5/8	11	110	32	44	12	12	9	3	13.50	585.080
3/4	10	125	34	50	14	14	11	3	16.50	585.085
7/8	9	140	34	56	18	17	14.5	3	19.50	585.090
1	8	160	38	64	18	17	14.5	3	22.25	585.095

● Cutting parameters

V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 8 - 15	● ● ● 15 - 30	○ 15 - 40	● ● 5 - 30	● ● 5 - 30	● ● 5 - 30	● ● 15 - 30

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS
For Steels < 800 N/mm²

Technical details


d ₁	TPI	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
No.2	56	50	9	10	2.8	5	2.1	2	1.85	590.010
No.3	48	50	9	10	2.8	5	2.1	2	2.10	590.015
No.4	40	56	11	18	3.5	6	2.7	2	2.35	590.020
No.5	40	56	7	18	3.5	6	2.7	3	2.65	590.025
No.6	32	56	8	19	4	6	3	3	2.85	590.030
No.8	32	63	8	19	4.5	6	3.4	3	3.50	590.035
No.10	24	70	11	20	6	8	4.9	3	3.90	590.040
No.12	24	80	11	29	6	8	4.9	3	4.50	590.045
1/4	20	80	13	30	7	8	5.5	3	5.10	590.050
5/16	18	90	15	34	8	9	6.2	3	6.60	590.055
3/8	16	90	16	35	9	10	7	3	8.00	590.060

Cutting parameters

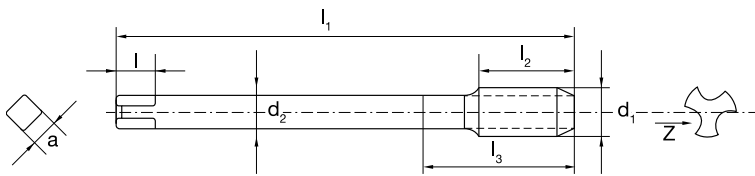
V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 7 - 13	● ● 13 - 27	○ 13 - 36	● ● 4 - 27	● ● 4 - 27	● ● 4 - 27	● ● 13 - 27
	○ 4 - 13	● ● ● 9 - 18	○ 13 - 36	● ● 4 - 27	● ● 4 - 27	● ● 4 - 27	● ● 9 - 18
	○ 5 - 10	● ● ● 10 - 15	○ 15 - 40	● ● 5 - 20	● ● 5 - 20	● ● 5 - 20	● ● 10 - 15

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Steels < 800 N/mm²

● Technical details

2B
B1.1

d ₁	TPI	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
7/16	14	100	22	40	8	8	6.2	3	9.40	595.065
1/2	13	110	23	44	9	10	7	3	10.80	595.070
9/16	12	110	25	44	11	12	9	3	12.20	595.075
5/8	11	110	28	44	12	12	9	3	13.50	595.080
3/4	10	125	30	50	14	14	11	4	16.50	595.085
7/8	9	140	34	56	18	17	14.5	4	19.50	595.090
1	8	160	38	64	18	17	14.5	4	22.25	595.095

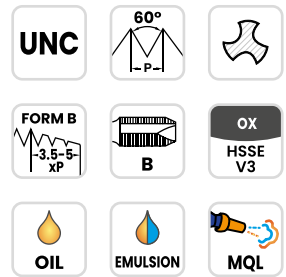
● Cutting parameters

V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 7 - 13	●● 13 - 27	○ 13 - 36	●● 4 - 27	●● 4 - 27	●● 4 - 27	●● 13 - 27
	○ 4 - 13	●●● 9 - 18	○ 13 - 36	●● 4 - 27	●● 4 - 27	●● 4 - 27	●● 9 - 18
	○ 5 - 10	●●● 10 - 15	○ 15 - 40	●● 5 - 20	●● 5 - 20	●● 5 - 20	●● 10 - 15

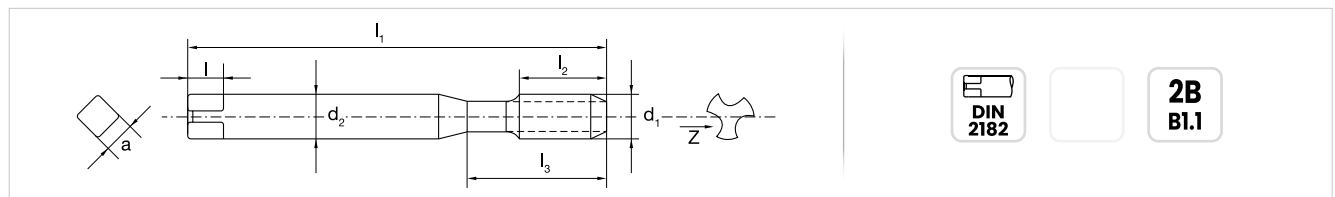
●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²



Technical details



d ₁	TPI	l ₁	l ₂	l ₃	d ₂	l	a	Z	Ø mm	Order code
No.4	40	56	11	18	3.5	6	2.7	2	2.35	600.020
No.5	40	56	11	18	3.5	6	2.7	3	2.65	600.025
No.6	32	56	13	19	4	6	3	3	2.85	600.030
No.8	32	63	13	19	4.5	6	3.4	3	3.50	600.035
No.10	24	70	16	20	6	8	4.9	3	3.90	600.040
1/4	20	80	19	30	7	8	5.5	3	5.10	600.050
5/16	18	90	22	34	8	9	6.2	3	6.60	600.055
3/8	16	90	22	35	9	10	7	3	8.00	600.060

Cutting parameters

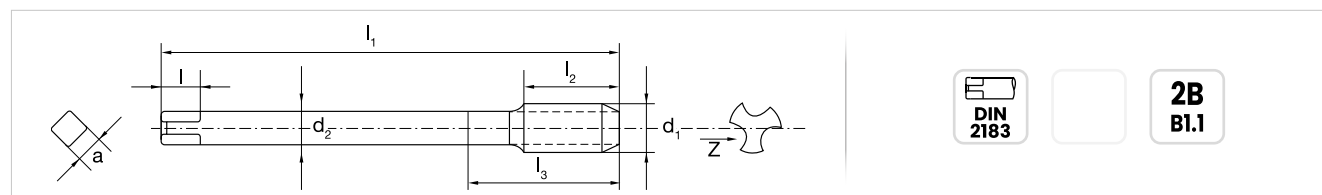
V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 2 - 10	● ● 2 - 4	● ● 2 - 10	● ● ● ● 8 - 20	○ 10 - 20	● ● 10 - 20	● ● 15 - 30

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²

● Technical details



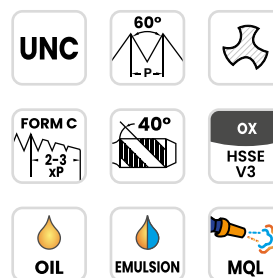
d ₁	TPI	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
1/2	13	110	29	44	9	10	7	3	10.80	605.070
5/8	11	110	32	44	12	12	9	3	13.50	605.080
3/4	10	125	34	50	14	14	11	3	16.50	605.085
7/8	9	140	34	56	18	17	14.5	3	19.50	605.090
1	8	160	38	64	18	17	14.5	3	22.25	605.095

● Cutting parameters

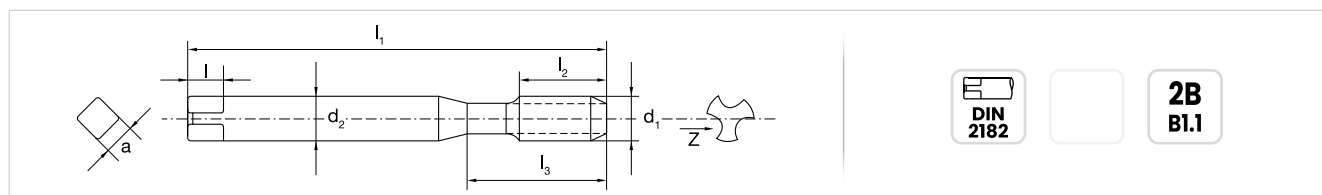
V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 2 - 10	● ● 2 - 4	● ● 2 - 10	● ● ● ● 8 - 20	○ 10 - 20	● ● 10 - 20	● ● 15 - 30

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²

● Technical details



d ₁	TPI	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
No.6	32	56	8	19	4	6	3	3	2.85	610.030
No.8	32	63	8	19	4.5	6	3.4	3	3.50	610.035
No.10	24	70	11	20	6	8	4.9	3	3.90	610.040
1/4	20	80	13	30	7	8	5.5	3	5.10	610.050
5/16	18	90	15	34	8	9	6.2	3	6.60	610.055
3/8	16	90	16	35	9	10	7	3	8.00	610.060

● Cutting parameters

V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 1 - 9	● ● 1 - 3	● ● 1 - 9	● ● 7 - 18	○ 9 - 18	● ● 9 - 18	● ● 13 - 27
	● ● 1 - 6	● ● 1 - 3	● ● 1 - 6	● ● ● 4 - 13	○ 9 - 18	● ● 9 - 18	● ● 9 - 18
	● ● 2 - 7	● ● 2 - 4	● ● 2 - 5	● ● ● 5 - 15	○ 8 - 15	● ● 8 - 15	● ● 10 - 20

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²

UNC

60°

FORM C
2-3
XP

40°

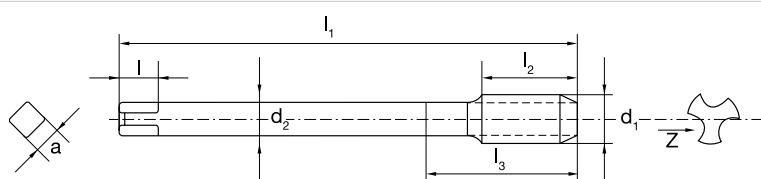
OX
HSSE
V3

OIL

EMULSION

MQL

● Technical details

DIN
21822B
B1.1

d ₁	TPI	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
1/2	13	110	23	44	9	10	7	4	10.80	615.070
5/8	11	110	28	44	12	12	9	4	13.50	615.080
3/4	10	125	30	50	14	14	11	4	16.50	615.085
7/8	9	140	34	56	18	17	14.5	4	19.50	615.090
1	8	160	38	64	18	17	14.5	5	22.25	615.095

● Cutting parameters

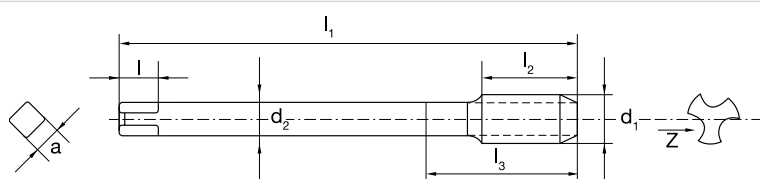
V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 1 - 9	● ● 1 - 3	● ● 1 - 9	● ● 7 - 18	○ 9 - 18	● ● 9 - 18	● ● 13 - 27
	● ● 1 - 6	● ● 1 - 3	● ● 1 - 6	● ● ● 4 - 13	○ 9 - 18	● ● 9 - 18	● ● 9 - 18
	● ● 2 - 7	● ● 2 - 4	● ● 2 - 5	● ● ● 5 - 15	○ 8 - 15	● ● 8 - 15	● ● 10 - 20

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Steels < 800 N/mm²

● Technical details



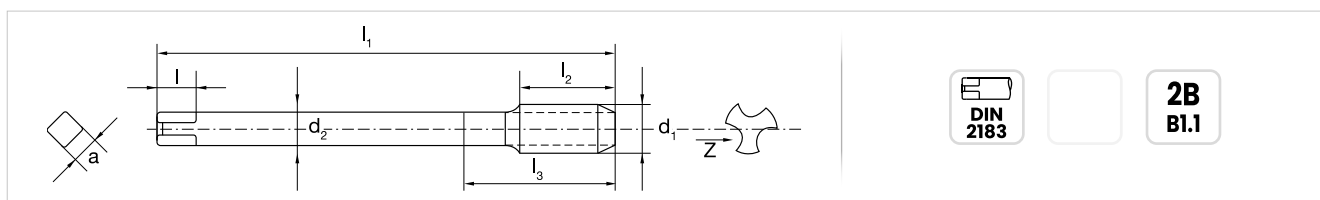
d ₁	TPI	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
No.0	80	40	8		1.2			3	1.25	620.005
No.1	72	50	8		1.4			3	1.55	620.010
No.2	64	50	9		1.6			3	1.85	620.015
No.3	56	50	9		1.8			3	2.15	620.020
No.4	48	56	11	22	2.2	5	2.5	3	2.40	620.025
No.5	44	56	11	22	2.2	5	2.5	3	2.70	620.030
No.6	40	56	13	22	2.5	5	2.1	3	2.95	620.035
No.8	36	63	13	25	2.8	5	2.1	3	3.50	620.040
No.10	32	70	16	28	3.5	6	2.7	3	4.10	620.045
No.12	28	80	17	32	4	6	3	3	4.60	620.050
1/4	28	80	19	32	4.5	6	3.4	3	5.50	620.055
5/16	24	90	22	36	6	8	4.9	3	6.90	620.060
3/8	24	90	22	36	7	8	5.5	3	8.50	620.065
7/16	20	100	20	40	8	9	6.2	3	9.90	620.070
1/2	20	100	22	40	9	10	7	3	11.50	620.075
9/16	18	100	22	40	11	12	9	3	12.90	620.080
5/8	18	100	22	40	12	12	9	3	14.50	620.085
3/4	16	110	25	44	14	14	11	3	17.50	620.090

● Cutting parameters

V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 8 - 15	● ● ● 15 - 30	○ 15 - 40	● ● 5 - 30	● ● 5 - 30	● ● 5 - 30	● ● 15 - 30

● ● ● Recommended | ● ● Suitable | ○ Possible

- Technical details



d ₁	TPI	I ₁	I ₂	I ₃	d ₂	l	a	Z	 mm	Order code
7/8	14	125	25	50	18	17	14.5	3	20.50	620.095
1	12	125	25	50	18	17	14.5	3	23.25	620.100
1 1/8	12	150	28	60	22	21	18	3	26.50	620.105
1 1/4	12	150	28	60	22	21	18	3	29.50	620.110
1 3/8	12	170	30	68	28	25	22	3	32.75	620.115
1 1/2	12	170	30	68	32	27	24	3	36.00	620.120

Cutting Taps

● Note

CUTTING TAPS

For Steels < 800 N/mm²

UNF

60°

FORM C
2-3
XP

40°

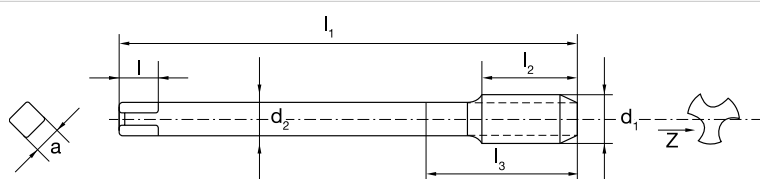
HSSE
V3

OIL

EMULSION

MQL

● Technical details

DIN
21832B
B1.1

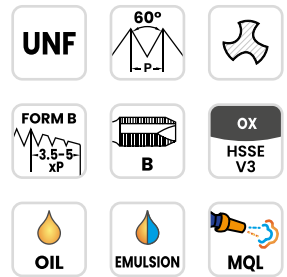
d ₁	TPI	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
No.3	56	50	7		1.8			2	2.15	625.020
No.4	48	56	7		2.2			2	2.40	625.025
No.5	44	56	7		2.2			3	2.70	625.030
No.6	40	56	7	22	2.5	5	2.1	3	2.95	625.035
No.8	36	63	7	25	2.8	5	2.1	3	3.50	625.040
No.10	32	70	9	28	3.5	6	2.7	3	4.10	625.045
No.12	28	80	9	32	4	6	3	3	4.60	625.050
1/4	28	80	11	32	4.5	6	3.4	3	5.50	625.055
5/16	24	90	12	36	6	8	4.9	3	6.90	625.060
3/8	24	90	13	36	7	8	5.5	3	8.50	625.065
7/16	20	100	15	40	8	9	6.2	3	9.90	625.070
1/2	20	100	16	40	9	10	7	3	11.50	625.075
9/16	18	100	17	40	11	12	9	3	12.90	625.080
5/8	18	100	19	40	12	12	9	3	14.50	625.085
3/4	16	110	21	44	14	14	11	4	17.50	625.090
7/8	14	125	23	50	18	17	14.5	4	20.50	625.095
1	12	125	25	50	18	17	14.5	4	23.25	625.100

● Cutting parameters

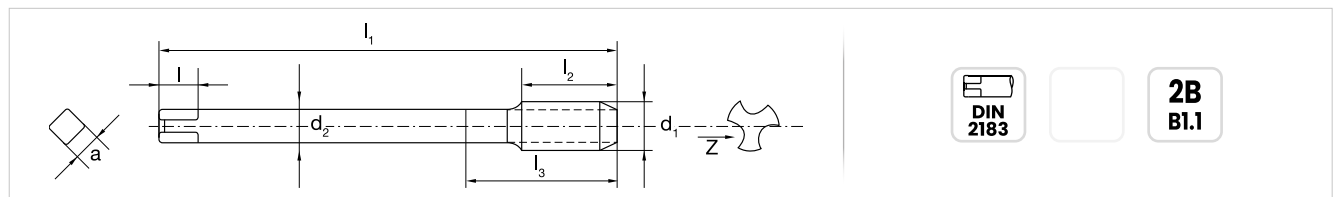
V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 7 - 13	●● 13 - 27	○ 13 - 36	●● 4 - 27	●● 4 - 27	●● 4 - 27	●● 13 - 27
	○ 4 - 13	●●● 9 - 18	○ 13 - 36	●● 4 - 27	●● 4 - 27	●● 4 - 27	●● 9 - 18
	○ 5 - 10	●●● 10 - 15	○ 15 - 40	●● 5 - 20	●● 5 - 20	●● 5 - 20	●● 10 - 15

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²

● Technical details



d ₁	TPI	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
No.6	40	56	13	22	2.5	5	2.1	3	2.95	630.035
No.10	32	70	16	28	3.5	6	2.7	3	4.10	630.045
1/4	28	80	19	32	4.5	6	3.4	3	5.50	630.055
5/16	24	90	22	36	6	8	4.9	3	6.90	630.060
3/8	24	90	22	36	7	8	5.5	3	8.50	630.065
7/16	20	100	20	40	8	9	6.2	3	9.90	630.070
1/2	20	100	22	40	9	10	7	3	11.50	630.075
5/8	18	100	22	40	12	12	9	3	14.50	630.085
3/4	16	110	25	44	14	14	11	3	17.50	630.090
7/8	14	125	25	50	18	17	14.5	3	20.50	630.095
1	12	125	25	50	18	17	14.5	3	23.25	630.100

● Cutting parameters

V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 2 - 10	● ● 2 - 4	● ● 2 - 10	● ● ● ● 8 - 20	○ 10 - 20	● ● 10 - 20	● ● 15 - 30

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²

UNF

60°

FORM C
2-3
XP

40°

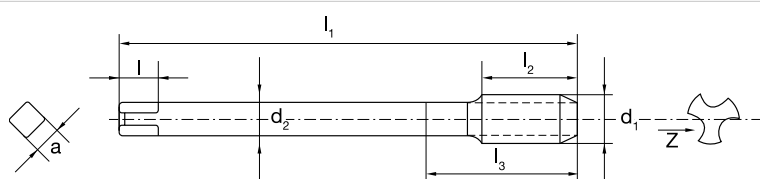
OX
HSSE
V3

OIL

EMULSION

MQL

● Technical details

DIN
21832B
B1.1

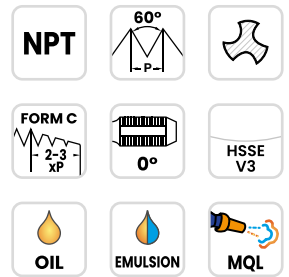
d ₁	TPI	l ₁	l ₂	l ₃	d ₂	l	a	Z	Ø mm	Order code
No.6	40	56	7	22	2.5	5	2.1	3	2.95	635.035
No.10	32	70	9	28	3.5	6	2.7	3	4.10	635.045
1/4	28	80	11	32	4.5	6	3.4	3	5.50	635.055
5/16	24	90	12	36	6	8	4.9	3	6.90	635.060
3/8	24	90	13	36	7	8	5.5	3	8.50	635.065
7/16	20	100	15	40	8	9	6.2	4	9.90	635.070
1/2	20	100	16	40	9	10	7	4	11.50	635.075
5/8	18	100	19	40	12	12	9	4	14.50	635.085
3/4	16	110	21	44	14	14	11	4	17.50	635.090
7/8	14	125	23	50	18	17	14.5	4	20.50	635.095
1	12	125	25	50	18	17	14.5	5	23.25	635.100

● Cutting parameters

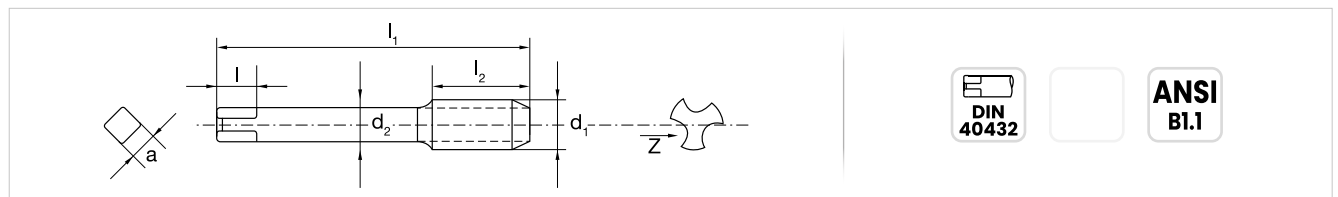
V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 1 - 9	● ● 1 - 3	● ● 1 - 9	● ● 7 - 18	○ 9 - 18	● ● 9 - 18	● ● 13 - 27
	● ● 1 - 6	● ● 1 - 3	● ● 1 - 6	● ● ● 4 - 13	○ 9 - 18	● ● 9 - 18	● ● 9 - 18
	● ● 2 - 7	● ● 2 - 4	● ● 2 - 5	● ● ● 5 - 15	○ 8 - 15	● ● 8 - 15	● ● 10 - 20

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Steels < 800 N/mm²

● Technical details



d ₁	TPI	l ₁	l ₂	l ₃	d ₂	l	a	Z	Order code
1/6	27	56	14	23	6	8	4.9	4	645.005
1/8	27	63	15	25	7	8	5.5	4	645.010
1/4	18	63	21	31	11	12	9	4	645.015
3/8	18	70	21	32	12	12	9	4	645.020
1/2	14	80	27	41	16	15	12	4	645.025
3/4	14	100	27	41	20	19	16	5	645.030
1	11.5	110	32	47	25	23	20	5	645.035

● Cutting parameters

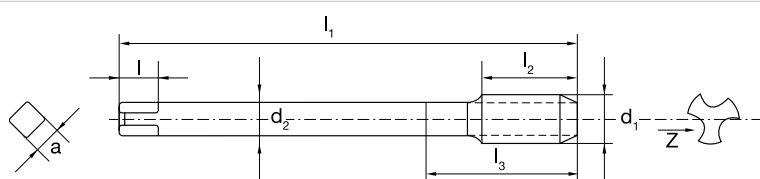
V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 5 - 12	●●● 10 - 24	○ 10 - 32	●● 3 - 24	●● 3 - 24	●● 3 - 24	●● 10 - 24
	○ 4 - 12	●●● 9 - 16	○ 13 - 32	●● 4 - 24	●● 4 - 24	●● 4 - 24	●● 9 - 16
	○ 5 - 10	●●● 10 - 15	○ 15 - 40	●● 5 - 20	●● 5 - 20	●● 5 - 20	●● 10 - 15

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Steels < 800 N/mm²

● Technical details



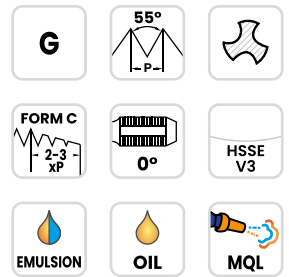
d ₁	TPI	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
1/8	28	90	20	36	7	8	5.5	3	8.80	545.005
1/4	19	100	22	40	11	12	9	3	11.80	545.010
3/8	19	100	22	40	12	12	9	3	15.25	545.015
1/2	14	125	25	50	16	15	12	3	19.00	545.020
5/8	14	125	25	50	18	17	14.5	4	21.00	545.025
3/4	14	140	28	56	20	19	16	4	24.50	545.030
7/8	14	150	28	60	22	21	18	4	28.25	545.035
1	11	160	30	64	25	23	20	4	30.75	545.040
1 1/8	11	170	30	68	28	25	22	4	35.50	545.045
1 1/4	11	170	30	68	32	27	24	4	39.50	545.050
1 3/8	11	180	32	72	36	32	29	4	41.50	545.055
1 1/2	11	190	32	76	36	32	29	4	45.25	545.060

● Cutting parameters

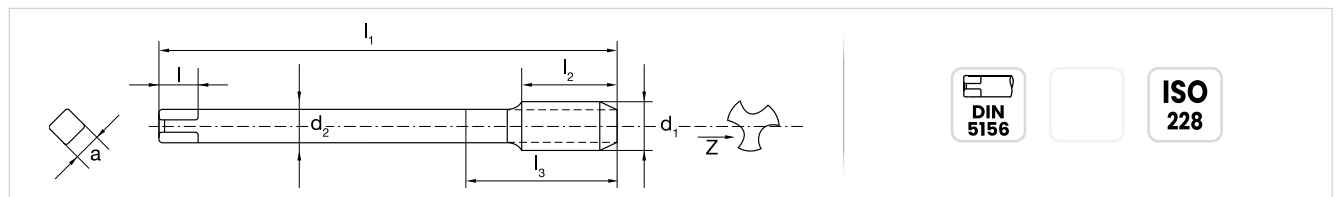
V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 8 - 15	● ● ● 15 - 30	○ 15 - 40	● ● 5 - 30	● ● 5 - 30	● ● 5 - 30	● ● 15 - 30

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Steels < 800 N/mm²

● Technical details



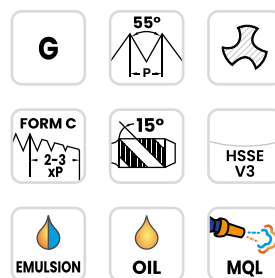
d ₁	TPI	l ₁	l ₂	d ₂	l	a	Z	Ø mm	Order code
1/8	28	90	20	7	8	5.5	4	8.80	550.005
1/4	19	100	22	11	12	9	4	11.80	550.010
3/8	19	100	22	12	12	9	4	15.25	550.015
1/2	14	125	25	16	15	12	4	19.00	550.020
5/8	14	125	25	18	17	14.5	4	21.00	550.025
3/4	14	140	28	20	19	16	4	24.50	550.030
7/8	14	150	28	22	21	18	4	28.25	550.035
1	11	160	30	25	23	20	4	30.75	550.040
1 1/8	11	170	30	28	25	22	4	35.50	550.045
1 1/4	11	170	30	32	27	24	6	39.50	550.050
1 3/8	11	180	32	36	32	29	6	41.50	550.055
1 1/2	11	190	32	36	32	29	6	45.25	550.060
1 3/4	11	200	40	40	35	32	6	51.00	550.065
2	11	220	40	45	38	35	6	57.00	550.070

● Cutting parameters

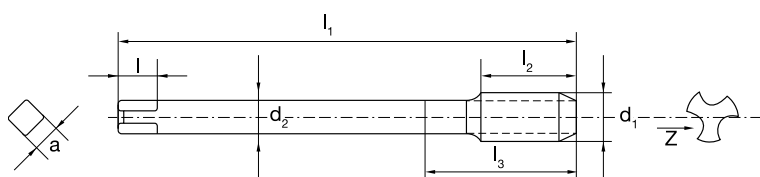
V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 5 - 12	●●● 10 - 24	○ 10 - 32	●● 3 - 24	●● 3 - 24	●● 3 - 24	●● 10 - 24
	○ 4 - 12	●●● 9 - 16	○ 13 - 32	●● 4 - 24	●● 4 - 24	●● 4 - 24	●● 9 - 16
	○ 5 - 10	●●● 10 - 15	○ 15 - 40	●● 5 - 20	●● 5 - 20	●● 5 - 20	●● 10 - 15

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Steels < 800 N/mm²

● Technical details

DIN
5156ISO
228

d ₁	TPI	l ₁	l ₂	d ₂	l	a	Z	Ø mm	Order code
1/8	28	90	20	7	8	5.5	3	8.80	555.005
1/4	19	100	22	11	12	9	3	11.80	555.010
3/8	19	100	22	12	12	9	3	15.25	555.015
1/2	14	125	25	16	15	12	4	19.00	555.020
5/8	14	125	25	18	17	14.5	4	21.00	555.025
3/4	14	140	28	20	19	16	4	24.50	555.030
7/8	14	150	28	22	21	18	4	28.25	555.035
1	11	160	30	25	23	20	4	30.75	555.040

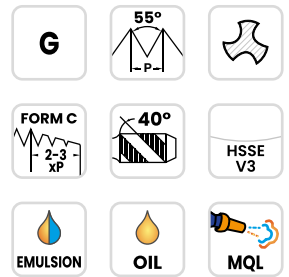
● Cutting parameters

V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 7 - 13	●● 13 - 27	○ 13 - 36	●● 4 - 27	●● 4 - 27	●● 4 - 27	●● 13 - 27
	○ 4 - 13	●●● 9 - 18	○ 13 - 36	●● 4 - 27	●● 4 - 27	●● 4 - 27	●● 9 - 18
	○ 5 - 10	●●● 10 - 15	○ 15 - 40	●● 5 - 20	●● 5 - 20	●● 5 - 20	●● 10 - 15

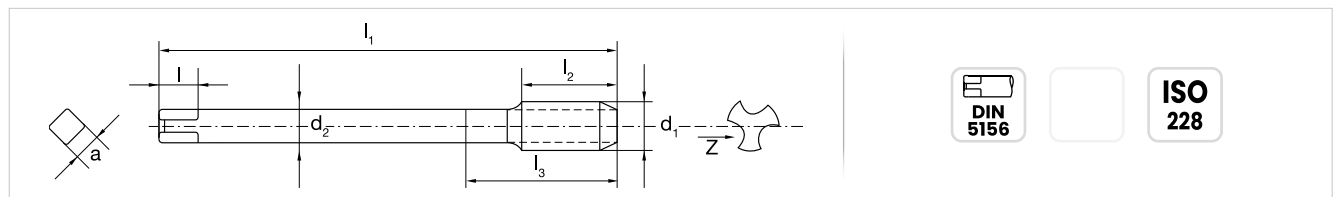
●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Steels < 800 N/mm²



Technical details



d ₁	TPI	l ₁	l ₂	d ₂	l	a	Z	Ø mm	Order code
1/8	28	90	20	7	8	5.5	4	8.80	560.005
1/4	19	100	22	11	12	9	4	11.80	560.010
3/8	19	100	22	12	12	9	4	15.25	560.015
1/2	14	125	25	16	15	12	4	19.00	560.020
5/8	14	125	25	18	17	14.5	4	21.00	560.025
3/4	14	140	28	20	19	16	4	24.50	560.030
7/8	14	150	28	22	21	18	4	28.25	560.035
1	11	160	30	25	23	20	4	30.75	560.040
1 1/8	11	170	30	28	25	22	4	35.50	560.045
1 1/4	11	170	30	32	27	24	4	39.50	560.050
1 3/8	11	180	32	36	32	29	4	41.50	560.055
1 1/2	11	190	32	36	32	29	4	45.25	560.060

Cutting parameters

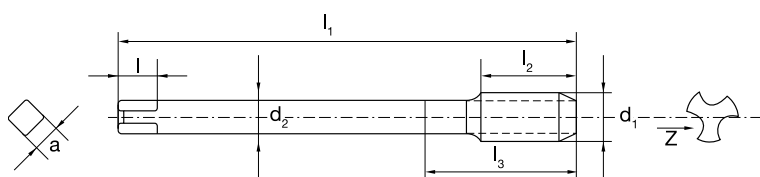
V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 7 - 13	● ● 13 - 27	○ 13 - 36	● ● 4 - 27	● ● 4 - 27	● ● 4 - 27	● ● 13 - 27
	○ 4 - 13	● ● ● 9 - 18	○ 13 - 36	● ● 4 - 27	● ● 4 - 27	● ● 4 - 27	● ● 9 - 18
	○ 5 - 10	● ● ● 10 - 15	○ 15 - 40	● ● 5 - 20	● ● 5 - 20	● ● 5 - 20	● ● 10 - 15

● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²

● Technical details



d ₁	TPI	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
1/8	28	90	20	36	7	8	5.5	3	8.80	565.005
1/4	19	100	22	40	11	12	9	3	11.80	565.010
3/8	19	100	22	40	12	12	9	3	15.25	565.015
1/2	14	125	25	50	16	15	12	3	19.00	565.020
5/8	14	125	25	50	18	17	14.5	4	21.00	565.025
3/4	14	140	28	56	20	19	16	4	24.50	565.030
7/8	14	150	28	60	22	21	18	4	28.25	565.035
1	11	160	30	64	25	23	20	4	30.75	565.040

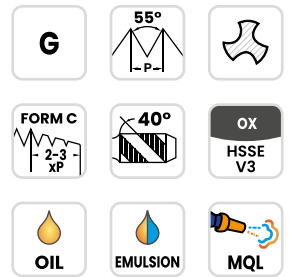
● Cutting parameters

V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 2 - 10	● ● 2 - 4	● ● 2 - 10	● ● ● ● 8 - 20	○ 10 - 20	● ● 10 - 20	● ● 15 - 30

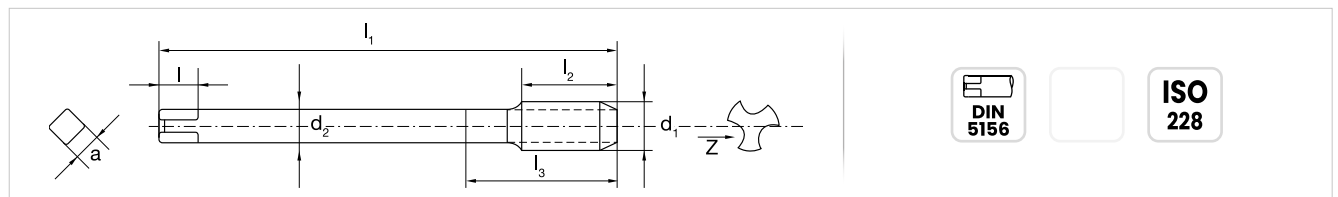
● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Stainless Steels < 1'200 N/mm²



Technical details



d ₁	TPI	l ₁	l ₂	d ₂	l	a	Z	Ø mm	Order code
1/8	28	90	20	7	8	5.5	3	8.80	570.005
1/4	19	100	22	11	12	9	3	11.80	570.010
3/8	19	100	22	12	12	9	3	15.25	570.015
1/2	14	125	25	16	15	12	4	19.00	570.020
5/8	14	125	25	18	17	14.5	4	21.00	570.025
3/4	14	140	28	20	19	16	4	24.50	570.030
7/8	14	150	28	22	21	18	4	28.25	570.035
1	11	160	30	25	23	20	4	30.75	570.040
1 1/8	11	170	30	28	25	22	4	35.50	570.045
1 1/4	11	170	30	32	27	24	4	39.50	570.050
1 3/8	11	180	32	36	32	29	4	41.50	570.055
1 1/2	11	190	32	36	32	29	4	45.25	570.060

Cutting parameters

V _c m/min	Ti	NI 900-1500 N/mm ²	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²
	● ● 1 - 9	● ● 1 - 3	● ● 1 - 9	● ● 7 - 18	○ 9 - 18	● ● 9 - 18	● ● 13 - 27
	● ● 1 - 6	● ● 1 - 3	● ● 1 - 6	● ● ● 4 - 13	○ 9 - 18	● ● 9 - 18	● ● 9 - 18
	● ● 2 - 7	● ● 2 - 4	● ● 2 - 5	● ● ● 5 - 15	○ 8 - 15	● ● 8 - 15	● ● 10 - 20

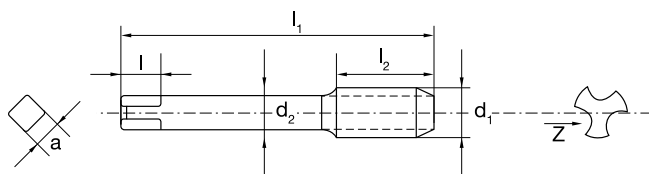
● ● ● Recommended | ● ● Suitable | ○ Possible

CUTTING TAPS

For Tempered Steels < 62 HRC



● Technical details

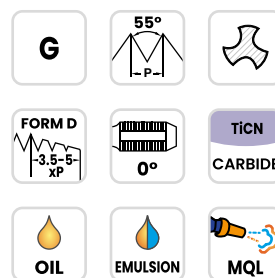
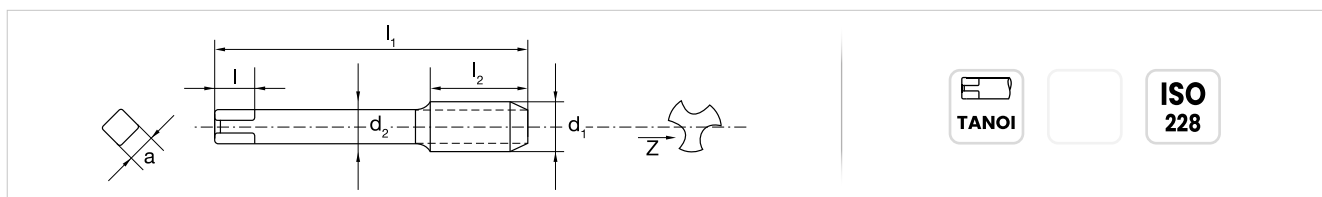


d_1	TPI	l_1	l_2	d_2	l	α	Z	$\emptyset$ mm	Order code
1/8	28	63	18	7	5.5	8	5	8.80	960.010
1/4	19	70	20	11	9	12	5	11.80	960.015

● Cutting parameters

V_c m/min	STEEL 50-63 HRC
	● ● 2 - 3
	● ● 1.5 - 3
	● ● 1.5 - 3

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS
For Tempered Steels < 62 HRC

Technical details


d_1	TPI	l_1	l_2	d_2	l	a	Z	$\emptyset$ mm	Order code
1/8	28	63	18	7	5.5	8	5	8.80	965.010
1/4	19	70	20	11	9	12	5	11.80	965.015

Cutting parameters

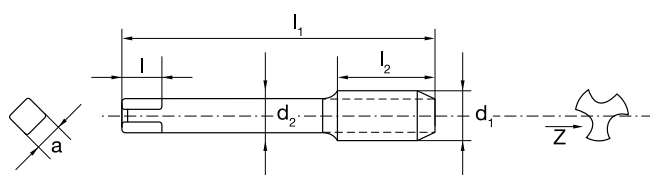
V_c m/min	STEEL 50-63 HRC
	● ● 2 - 3
	● ● ● 1.5 - 3
	● ● 1.5 - 3

●●● Recommended | ●● Suitable | ○ Possible

CUTTING TAPS

For Steels < 800 N/mm²

● Technical details



d ₁	TPI	l ₁	l ₂	l ₃	d ₂	l	α	Z	Ø mm	Order code
21	16	90	22	36	22	21	18	4	26.95	640.005
29	16	100	25	40	28	25	22	4	35.60	640.010
7	20	70	22	28	9	10	7	4	11.35	640.015
9	18	70	22	28	12	12	9	4	13.95	640.020
11	18	80	22	32	14	14	11	4	17.35	640.025
13.5	18	80	22	32	16	15	12	4	19.15	640.030
16	18	80	22	32	18	17	14.5	4	21.25	640.035

● Cutting parameters

V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 5 - 12	● ● ● 10 - 24	○ 10 - 32	● ● 3 - 24	● ● 3 - 24	● ● 3 - 24	● ● 10 - 24
	○ 4 - 12	● ● ● 9 - 16	○ 13 - 32	● ● 4 - 24	● ● 4 - 24	● ● 4 - 24	● ● 9 - 16
	○ 5 - 10	● ● ● 10 - 15	○ 15 - 40	● ● 5 - 20	● ● 5 - 20	● ● 5 - 20	● ● 10 - 15

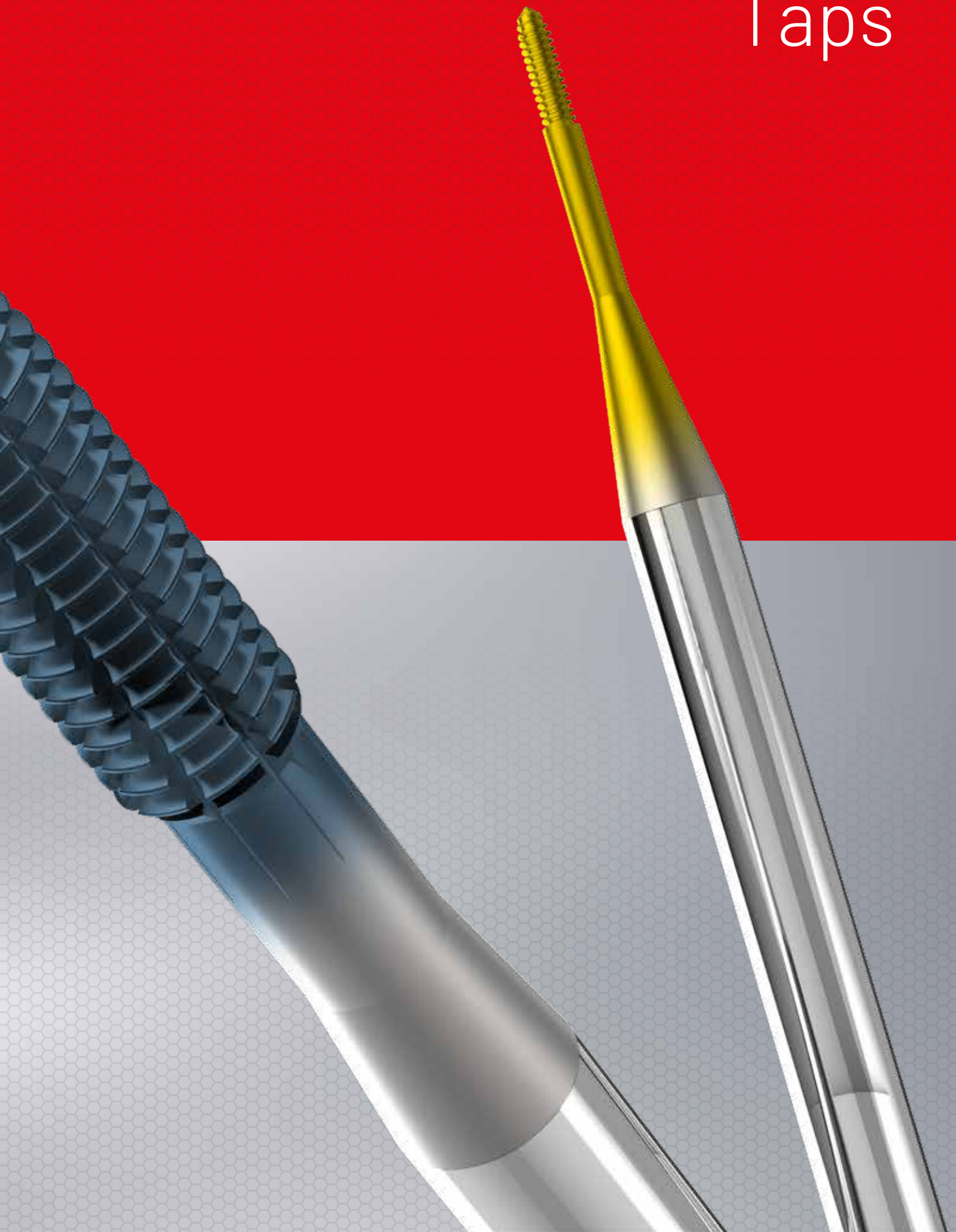
● ● ● Recommended | ● ● Suitable | ○ Possible

C

TANOI



Forming Taps



Section Index



PRODUCT FOCUS

"IT TAFLET"
"W-TF"

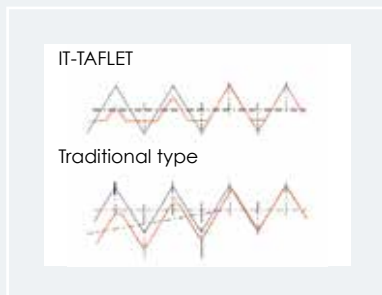
XX-XX
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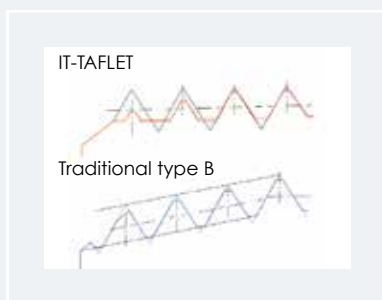
TOOL SELECTION GUIDE

(M) THREADING	For General Use	XX-XX
(MF) THREADING	For General Use	XX-XX
(G) THREADING	For General Use	XX

PATENTED



(1)



(2)



(3)

• TECHNICAL FEATURES

IT-Taflet forming taps have a unique chamfer section with reduced full profile threads (Picture 1.1). Unlike common forming taps the pitch between all chamfer threads is constant. All threads have symmetric profile. These features eliminate axial forces on the work piece (Picture 2.1). The thread root is designed to create a rounded thread crest on the formed thread (Picture 2.2).

• ADVANTAGES IN PRODUCTION

Tool life is dramatically increased because of the reduced forming torque.

Burrs at the entry and exit of holes are nearly completely avoided due to the largely reduced axial forces.

IT-Taflet may be used on thin work pieces as well as very small threads down to S0.5 due to the low torque generated.

• AVAILABLE IN 3 EXECUTIONS

- MICRO: S0.5 ÷ S0.9
- MINI: M1 ÷ M1.8
- STANDARD: > M2

• IT-TAFLET TAPS ARE PATENTED:

- Japanes patent n. 3457248
- American patent n. 6386954
- European patent n. 0953396



IT TAFLET 3.178.323-IT



Highlights • IT-TAFLET

• APPLICATIONS

IT-Taflets are also available in sizes from S0.5. These are used for manufacturing miniature screw threads in clocks, watches, optical instruments, measuring instruments and similar products requiring very small size threads of highest precision.

The application of miniature IT-Taflets requires spindle speeds of 3'000 rpm. Both executions TICN and C-Coating are suitable for these speeds and should be applied according to the work material.

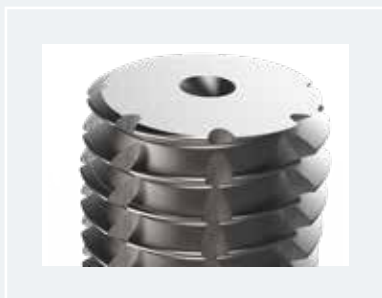
For tapping at speeds below 1'000 rpm - as may be required on automatic machines - TANOI offers a special steam oxide treatment (OX).

Size	Pitch	Drill Hole diameter [mm]			
		4H5		4H6	
		Min.	Max.	Min.	Max.
S0.5	0.125	0.437	0.455	0.437	0.466
S0.6	0.150	0.525	0.549	0.525	0.559
S0.7	0.175	0.612	0.640	0.612	0.650
S0.8	0.200	0.699	0.729	0.699	0.740
S0.9	0.225	0.787	0.819	0.787	0.829



IT TAFLET 6.183.329-IT

PLUS



(1)



(2)

Highlights • W-TF

Forming Taps

• TECHNICAL FEATURES

W-TF are a completely new development in thread forming taps.

Compared to Tanoi's conventional forming taps, W-TF taps feature a more aggressive geometry with sharper lobes and improved cooling capacities.

These features are enhanced by Tanoi's new TEC coating giving the tap surface the heat and wear resistance necessary to operate at higher speeds.

• ADVANTAGES IN PRODUCTION

The new W-TF design allows to **increase tapping speeds from 50% to 100%** depending on the work materials. The TEC coating protects the taps surface from the very high heat stress caused by the high tapping speeds. Together these features allow faster tapping with a significantly higher tool life.

• APPLICATIONS

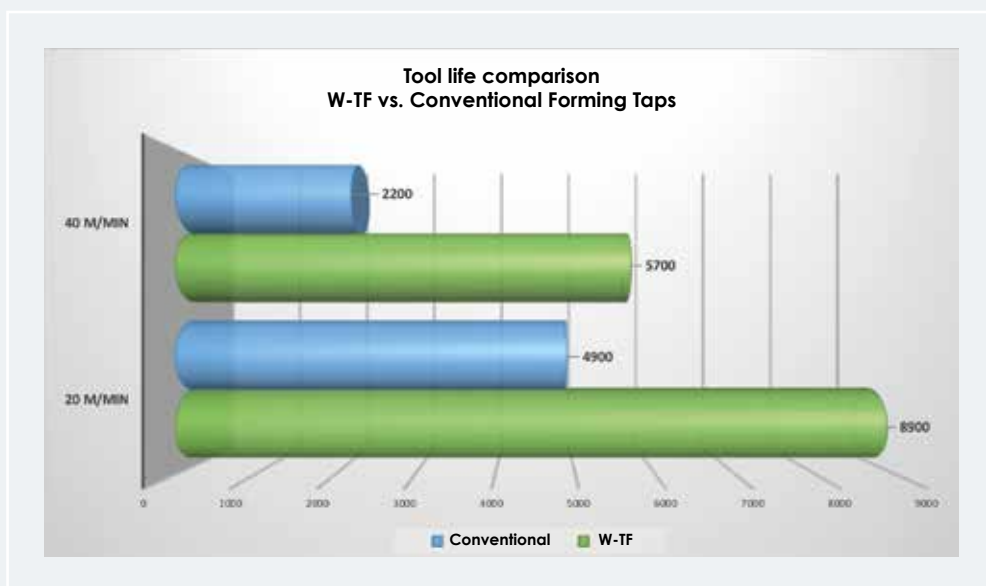
W-TF forming taps can be used in a very wide range of applications. From automotive & aero technologies, energy technologies, machine building to heavy industries, W-TF taps increase productivity in all areas where tapping by forming is admissible.

In all these cases W-TF taps make the most of the existing machining environment by either reducing machining time through high machining speed or simply reducing tool cost by longer tool life or by a combination of both.

This allows each user to find the optimal setup and most cost effective parameters for his machining needs.



• W-TF TEST



Tool	W-TF M6x1	
Workmaterial	S50C / CK50 / 1.1206	
Speed	20 m/min	40 m/min
W-TF	8900	5700
Conventional	4900	2200



W-TF 3.153.323-WTF

FORMING TAPS

Hole type	Threading type	Catalog number Size range	DIN	Coolant grooves	Tolerance	Chamfer form	Material and coating	Taps reference page
	M	 3.153.320 M2 - M16	 DIN 2174		6HX			266
	M	 3.153.320-WF M2 - M16	 DIN 2174		6HX			267
	M	 3.153.321-WF M2 - M16	 DIN 2174		6HX			268
	M	 3.153.322 M2 - M16	 DIN 2174		6HX			269
	M	 3.153.322-WF M2 - M16	 DIN 2174		6HX			270
	M	 3.153.323 M2 - M16	 DIN 2174		6HX			271
	M	 3.153.323-IT M2 - M10	 DIN 2174		6HX			272
	M	 3.153.323-WF M2 - M16	 DIN 2174		6HX			273
	M	 3.153.323-WTF M3 - M16	 DIN 2174		6HX			274
	M	 3.163.320 M2 - M10	 DIN 2174		6GX			275
	M	 3.163.320-WF M2 - M10	 DIN 2174		6GX			276
	M	 3.163.321-WF M2 - M10	 DIN 2174		6GX			277

Steel						Cast		Copper			Aluminum and Zinc			Titanium	Nickel	
< 500 N/mm ²	< 800 N/mm ²	< 1'200 N/mm ²	< 1'300 N/mm ²	Stainless / Inox < 1'200 N/mm ²	HRC 50-63 Hardened steels	Cast Iron	Cast Iron long chipping	CU	Copper alloys 200-300 HB	Copper alloys short chipping	AL	ALSI < 10%	ALSI > 10% ADC / ZDC	Ti	Ni	Nickel alloys 900-1'500 N/mm ²

● ● ●	● ● ●			○			● ●	● ●	● ●	● ●						
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● ● ● Recommended | ● ● Suitable | ○ Possible

FORMING TAPS

Hole type	Threading type	Catalog number Size range	DIN	Coolant grooves	Tolerance	Chamfer form	Material and coating	Taps reference page
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● **FOR GENERAL USE** Cast Iron, Aluminium, Aluminium Die Cast, Steels and Stainless Steels < 1'200 N/mm2

	M	 3.163.322 M2 - M10			6GX			278
	M	 3.163.322-WF M2 - M10			6GX			279
	M	 3.163.323 M2 - M10			6GX			280
	M	 3.163.323-WF M2 - M10			6GX			281
	M	 3.163.323-WTF M3 - M16			6GX			282
	S MINI	 3.178.323-IT S0.5 - S0.9			4HX			283
	M	 3.183.323-IT M1 - M1.8			5HX			284
	M	 6.153.329-IT M2 - M10			6HX			285
	S MINI	 6.178.329-IT S0.5 - S0.9			4HX			286
	M	 6.183.329-IT M1 - M1.8			5HX			287

● **FOR GENERAL USE** Aluminum, Aluminum Die Cast, Copper, Steels and Stainless Steels < 1'200 N/mm2

	MF	 3.253.320 M3 - M16			6HX			288
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Steel						Cast		Copper			Aluminum and Zinc			Titanium	Nickel	
< 500 N/mm ²	< 800 N/mm ²	< 1'200 N/mm ²	< 1'300 N/mm ²	Stainless / Inox < 1'200 N/mm ²	HRC 50-63 Hardened steels	Cast Iron	Cast Iron long chipping	CU	Copper alloys 200-300 HB	Copper alloys short chipping	AL	ALSi < 10%	ALSi > 10% ADC / ZDC	Ti	Ni	Nickel alloys 900-1'500 N/mm ²

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●●● Recommended | ●● Suitable | ○ Possible

FORMING TAPS

Hole type	Threading type	Catalog number Size range	DIN	Coolant grooves	Tolerance	Chamfer form	Material and coating	Taps reference page
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● **FOR GENERAL USE** Aluminum, Aluminum Die Cast, Copper, Steels and Stainless Steels < 1'200 N/mm²

	MF	 3.253.320-WF M3 - M16			6HX			289
	MF	 3.253.321-WF M3 - M16			6HX			290
	MF	 3.253.322 M3 - M16			6HX			291
	MF	 3.253.322-WF M3 - M16			6HX			292
	MF	 3.253.323 M3 - M16			6HX			293
	MF	 3.253.323-WF M3 - M16			6HX			294
	MF	 3.253.323-WTF M8 - M16			6HX			295

● **FOR GENERAL USE** Aluminum, Aluminum Die Cast, Copper, Steels and Stainless Steels < 1'200 N/mm²

	G	 3.693.920-WF 1/8 - 3/8			ISO 228			296
	G	 3.693.922-WF 1/8 - 3/8			ISO 228			297
	G	 3.693.923-WF 1/8 - 3/8			ISO 228			298

Steel						Cast		Copper			Aluminum and Zinc			Titanium	Nickel	
< 500 N/mm ²	< 800 N/mm ²	< 1'200 N/mm ²	< 1'300 N/mm ²	Stainless / Inox < 1'200 N/mm ²	HRC 50-63 Hardened steels	Cast Iron	Cast Iron long chipping	CU	Copper alloys 200-300 HB	Copper alloys short chipping	AL	ALSi < 10%	ALSi > 10% ADC / ZDC	Ti	Ni	Nickel alloys 900-1'500 N/mm ²

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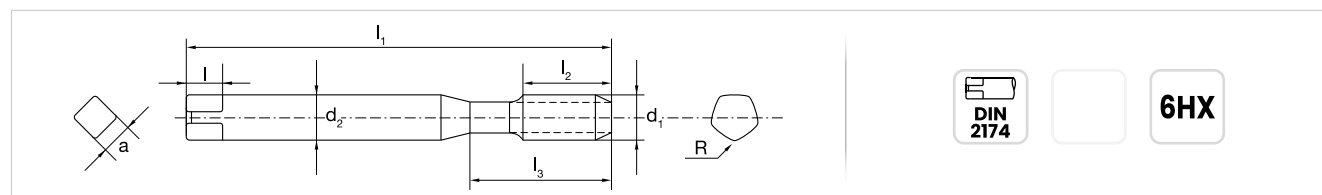
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●●● Recommended | ●● Suitable | ○ Possible

FORMING TAPS

For General Use Aluminum, Aluminum Die Cast, Copper, Steels and Stainless Steels < 1'200 N/mm²

● Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	R	Ø mm	Order code
M2	0.4	45	8	10	2.8	5	2.1	4	1.83	650.065
M2.5	0.45	50	9	12.5	2.8	5	2.1	4	2.30	650.080
M3	0.5	56	11	18	3.5	6	2.7	4	2.80	650.090
M3.5	0.6	56	12	20	4	6	3	4	3.25	650.095
M4	0.7	63	13	21	4.5	6	3.4	4	3.70	650.100
M5	0.8	70	16	25	6	8	4.9	4	4.65	650.110
M6	1	80	19	30	6	8	4.9	4	5.55	650.115
M8	1.25	90	22	35	8	9	6.2	6	7.40	650.125
M10	1.5	100	24	39	10	11	8	8	9.30	650.135
M12	1.75	110	28	44	9	10	7	8	11.20	650.145
M14	2	110	30	44	11	12	9	8	13.00	650.150
M16	2	110	32	44	12	12	9	8	15.00	650.155

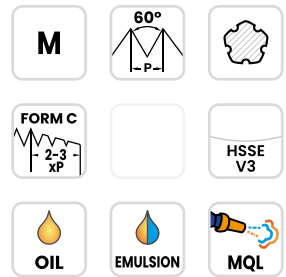
● Cutting parameters

V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G LONG CHIP	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 5 - 12	● ● ● 10 - 24	● ● 10 - 32	● ● 3 - 24	● ● 3 - 24	● ● 3 - 24	● ● ● 10 - 24
	○ 4 - 12	● ● ● 9 - 16	● ● 13 - 32	● ● 4 - 24	● ● 4 - 24	● ● 4 - 24	● ● ● 9 - 16
	○ 5 - 10	● ● ● 10 - 15	● ● 15 - 40	● ● 5 - 20	● ● 5 - 20	● ● 5 - 20	● ● ● 10 - 15

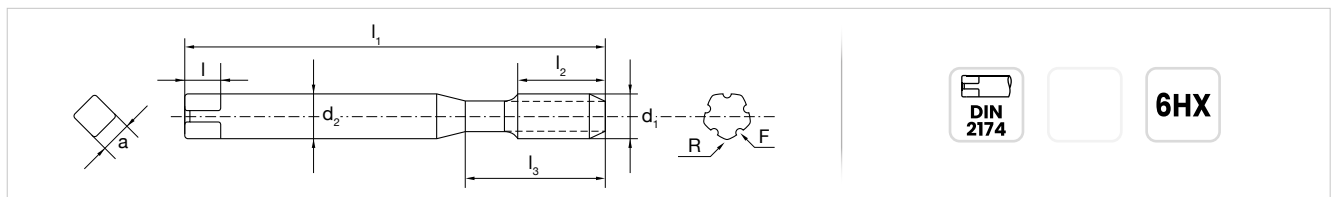
● ● ● Recommended | ● ● Suitable | ○ Possible

FORMING TAPS

For General Use Aluminum, Aluminum Die Cast, Copper, Steels and Stainless Steels < 1'200 N/mm²



Technical details



DIN 2174

6HX

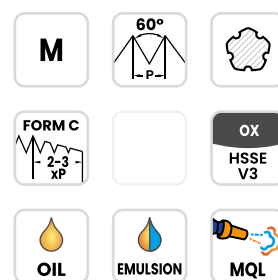
d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	R	F	Ø mm	Order code
M2	0.4	45	8	10	2.8	5	2.1	4	2	1.83	655.065
M2.5	0.45	50	9	12.5	2.8	5	2.1	4	2	2.30	655.080
M3	0.5	56	11	18	3.5	6	2.7	4	2	2.80	655.090
M3.5	0.6	56	12	20	4	6	3	4	2	3.25	655.095
M4	0.7	63	13	21	4.5	6	3.4	4	2	3.70	655.100
M5	0.8	70	16	25	6	8	4.9	4	2	4.65	655.110
M6	1	80	19	30	6	8	4.9	4	2	5.55	655.115
M8	1.25	90	22	35	8	9	6.2	6	3	7.40	655.125
M10	1.5	100	24	39	10	11	8	8	4	9.30	655.135
M12	1.75	110	28	44	9	10	7	8	4	11.20	655.145
M14	2	110	30	44	11	12	9	8	4	13.00	655.150
M16	2	110	32	44	12	12	9	8	4	15.00	655.155

Cutting parameters

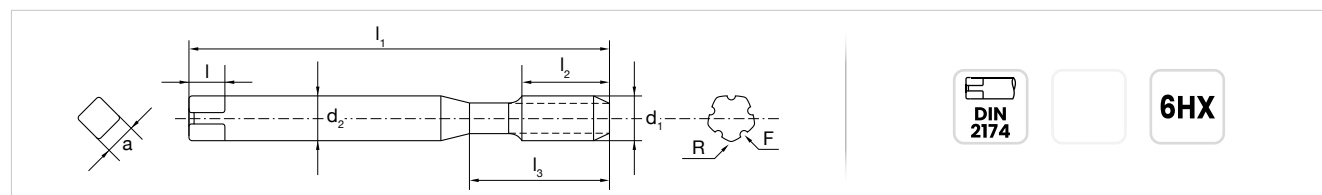
V _c m/min	STEEL 500-800 N/mm ²	66/6 LONG CHIP	CU 200-300 HB	CU SHORT	CU	ALU	STEEL ≤500 N/mm ²
	●●● 10 - 24	●● 10 - 32	●● 3 - 24	●● 3 - 24	●● 3 - 24	●● 10 - 32	●●● 10 - 24
	●●● 9 - 16	●● 13 - 32	●● 4 - 24	●● 4 - 24	●● 4 - 24	●● 13 - 32	●●● 9 - 16
	●●● 10 - 15	●● 15 - 40	●● 5 - 20	●● 5 - 20	●● 5 - 20	●● 15 - 30	●●● 10 - 15

●●● Recommended | ●● Suitable | ○ Possible

FORMING TAPS

For General Use Aluminum, Aluminum Die Cast, Copper, Steels and Stainless Steels < 1'200 N/mm²

● Technical details



6HX

d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	R	F	Ø mm	Order code
M2	0.4	45	8	10	2.8	5	2.1	4	2	1.83	656.065
M2.5	0.45	50	9	12.5	2.8	5	2.1	4	2	2.30	656.080
M3	0.5	56	11	18	3.5	6	2.7	4	2	2.80	656.090
M3.5	0.6	56	12	20	4	6	3	4	2	3.25	656.095
M4	0.7	63	13	21	4.5	6	3.4	4	2	3.70	656.100
M5	0.8	70	16	25	6	8	4.9	4	2	4.65	656.110
M6	1	80	19	30	6	8	4.9	4	2	5.55	656.115
M8	1.25	90	22	35	8	9	6.2	6	3	7.40	656.125
M10	1.5	100	24	39	10	11	8	8	4	9.30	656.135
M12	1.75	110	28	44	9	10	7	8	4	11.20	656.145
M14	2	110	30	44	11	12	9	8	4	13.00	656.150
M16	2	110	32	44	12	12	9	8	4	15.00	656.155

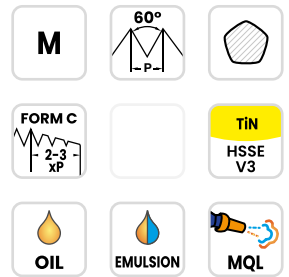
● Cutting parameters

V _c m/min	STEEL 500-800 N/mm ²	GG/G LONG CHIP	CU 200-300 HB	CU SHORT	CU	ALU	STEEL ≤500 N/mm ²
	● ● ● 10 - 24	● ● 10 - 32	● ● 3 - 24	● ● 3 - 24	● ● 3 - 24	● ● 10 - 32	● ● ● 10 - 24
	● ● ● 9 - 16	● ● 13 - 32	● ● 4 - 24	● ● 4 - 24	● ● 4 - 24	● ● 13 - 32	● ● ● 9 - 16
	● ● ● 10 - 15	● ● 15 - 40	● ● 5 - 20	● ● 5 - 20	● ● 5 - 20	● ● 15 - 30	● ● ● 10 - 15

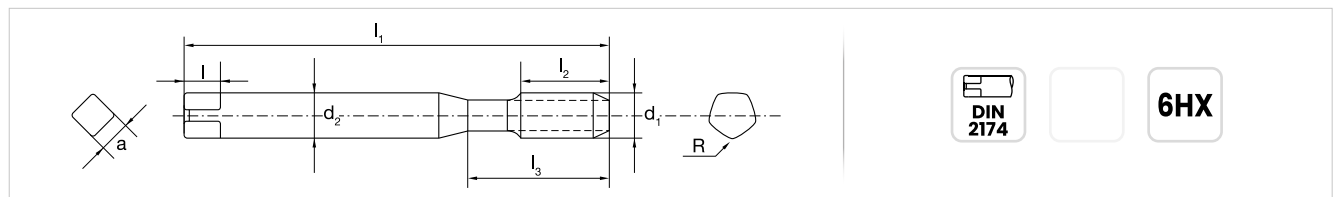
● ● ● Recommended | ● ● Suitable | ○ Possible

FORMING TAPS

For General Use Aluminum, Aluminum Die Cast, Copper, Steels and Stainless Steels < 1'200 N/mm²



Technical details



DIN
2174

6HX

d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	R	Ø mm	Order code
M2	0.4	45	8	10	2.8	5	2.1	4	1.83	660.065
M2.5	0.45	50	9	12.5	2.8	5	2.1	4	2.30	660.080
M3	0.5	56	11	18	3.5	6	2.7	4	2.80	660.090
M3.5	0.6	56	12	20	4	6	3	4	3.25	660.095
M4	0.7	63	13	21	4.5	6	3.4	4	3.70	660.100
M5	0.8	70	16	25	6	8	4.9	4	4.65	660.110
M6	1	80	19	30	6	8	4.9	4	5.55	660.115
M8	1.25	90	22	35	8	9	6.2	6	7.40	660.125
M10	1.5	100	24	39	10	11	8	8	9.30	660.135
M12	1.75	110	28	44	9	10	7	8	11.20	660.145
M14	2	110	30	44	11	12	9	8	13.00	660.150
M16	2	110	32	44	12	12	9	8	15.00	660.155

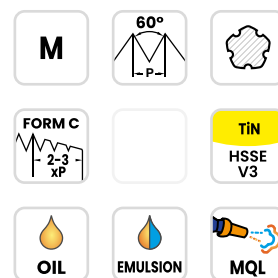
Cutting parameters

V _c m/min	STEEL 500-800 N/mm ²	66/6 LONG CHIP	CU 200-300 HB	CU SHORT	CU	ALU	STEEL ≤500 N/mm ²
	●●● 10 - 24	●● 10 - 32	●● 3 - 24	●● 3 - 24	●● 3 - 24	●● 10 - 32	●●● 10 - 24
	●●● 9 - 16	●● 13 - 32	●● 4 - 24	●● 4 - 24	●● 4 - 24	●● 13 - 32	●●● 9 - 16
	●●● 10 - 15	●● 15 - 40	●● 5 - 20	●● 5 - 20	●● 5 - 20	●● 15 - 30	●●● 10 - 15

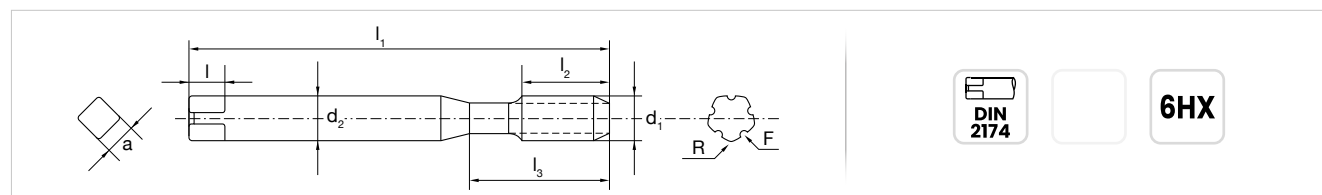
●●● Recommended | ●● Suitable | ○ Possible

FORMING TAPS

For General Use Aluminum, Aluminum Die Cast, Copper, Steels and Stainless Steels < 1'200 N/mm²



● Technical details



DIN 2174

6HX

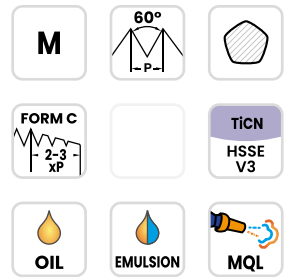
d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	R	F	Ø mm	Order code
M2	0.4	45	8	10	2.8	5	2.1	4	2	1.83	665.065
M2.5	0.45	50	9	12.5	2.8	5	2.1	4	2	2.30	665.080
M3	0.5	56	11	18	3.5	6	2.7	4	2	2.80	665.090
M3.5	0.6	56	12	20	4	6	3	4	2	3.25	665.095
M4	0.7	63	13	21	4.5	6	3.4	4	2	3.70	665.100
M5	0.8	70	16	25	6	8	4.9	4	2	4.65	665.110
M6	1	80	19	30	6	8	4.9	4	2	5.55	665.115
M8	1.25	90	22	35	8	9	6.2	6	3	7.40	665.125
M10	1.5	100	24	39	10	11	8	8	4	9.30	665.135
M12	1.75	110	28	44	9	10	7	8	4	11.20	665.145
M14	2	110	30	44	11	12	9	8	4	13.00	665.150
M16	2	110	32	44	12	12	9	8	4	15.00	665.155

● Cutting parameters

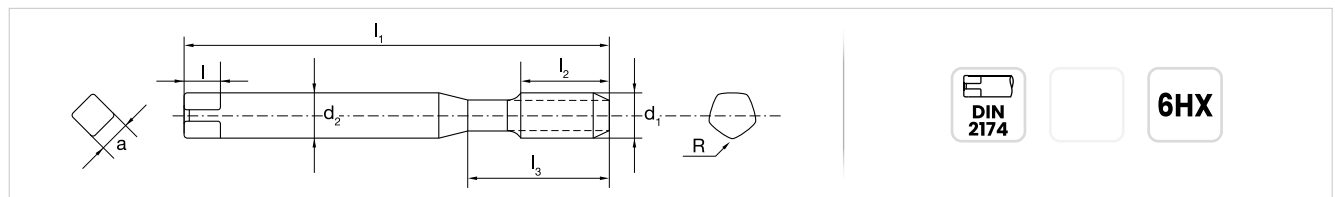
V _c m/min	STEEL 500-800 N/mm ²	GG/G LONG CHIP	CU 200-300 HB	CU SHORT	CU	ALU	STEEL ≤500 N/mm ²
	● ● ● 10 - 24	● ● 10 - 32	● ● 3 - 24	● ● 3 - 24	● ● 3 - 24	● ● 10 - 32	● ● ● 10 - 24
	● ● ● 9 - 16	● ● 13 - 32	● ● 4 - 24	● ● 4 - 24	● ● 4 - 24	● ● 13 - 32	● ● ● 9 - 16
	● ● ● 10 - 15	● ● 15 - 40	● ● 5 - 20	● ● 5 - 20	● ● 5 - 20	● ● 15 - 30	● ● ● 10 - 15

● ● ● Recommended | ● ● Suitable | ○ Possible

FORMING TAPS

For General Use Aluminum, Aluminum Die Cast, Copper, Steels and Stainless Steels < 1'200 N/mm²

● Technical details



DIN 2174

6HX

d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	R	Ø mm	Order code
M2	0.4	45	8	10	2.8	5	2.1	4	1.83	670.065
M2.5	0.45	50	9	12.5	2.8	5	2.1	4	2.30	670.080
M3	0.5	56	11	18	3.5	6	2.7	4	2.80	670.090
M3.5	0.6	56	12	20	4	6	3	4	3.25	670.095
M4	0.7	63	13	21	4.5	6	3.4	4	3.70	670.100
M5	0.8	70	16	25	6	8	4.9	4	4.65	670.110
M6	1	80	19	30	6	8	4.9	4	5.55	670.115
M8	1.25	90	22	35	8	9	6.2	6	7.40	670.125
M10	1.5	100	24	39	10	11	8	8	9.30	670.135
M12	1.75	110	28	44	9	10	7	8	11.20	670.145
M14	2	110	30	44	11	12	9	8	13.00	670.150
M16	2	110	32	44	12	12	9	8	15.00	670.155

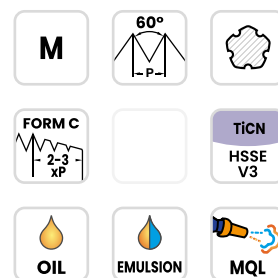
● Cutting parameters

V _c m/min	STEEL 500-800 N/mm ²	66/6 LONG CHIP	CU	ZDC ADC	ALU Si <10%	ALU	STEEL ≤500 N/mm ²
	● ● ● 10 - 24	● ● 10 - 32	● ● 3 - 24	● ● ● 7 - 32	● ● ● 7 - 32	● ● 10 - 32	● ● ● 10 - 24
	● ● ● 9 - 16	● ● 13 - 32	● ● 4 - 24	● ● ● 9 - 32	● ● ● 9 - 32	● ● 13 - 32	● ● ● 9 - 16
	● ● ● 10 - 15	● ● 15 - 40	● ● 5 - 20	● ● ● 10 - 30	● ● ● 10 - 30	● ● 15 - 30	● ● ● 10 - 15

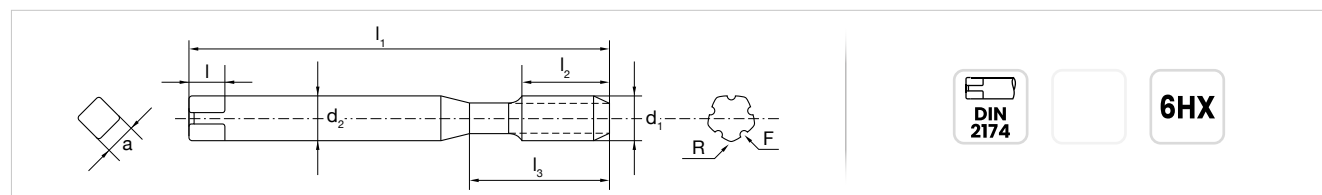
● ● ● Recommended | ● ● Suitable | ○ Possible

FORMING TAPS

For General Use Aluminum, Aluminum Die Cast, Copper, Steels and Stainless Steels < 1'200 N/mm²



● Technical details



DIN 2174

6HX

d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	R	F	Ø mm	Order code
M2	0.4	45	8	10	2.8	5	2.1	4	2	1.83	675.065
M2.5	0.45	50	9	12.5	2.8	5	2.1	4	2	2.30	675.080
M3	0.5	56	11	18	3.5	6	2.7	4	2	2.80	675.090
M3.5	0.6	56	12	20	4	6	3	4	2	3.25	675.095
M4	0.7	63	13	21	4.5	6	3.4	4	2	3.70	675.100
M5	0.8	70	16	25	6	8	4.9	4	2	4.65	675.110
M6	1	80	19	30	6	8	4.9	4	2	5.55	675.115
M8	1.25	90	22	35	8	9	6.2	6	3	7.40	675.125
M10	1.5	100	24	39	10	11	8	8	4	9.30	675.135
M12	1.75	110	28	44	9	10	7	8	4	11.20	675.145
M14	2	110	30	44	11	12	9	8	4	13.00	675.150
M16	2	110	32	44	12	12	9	8	4	15.00	675.155

Forming Taps

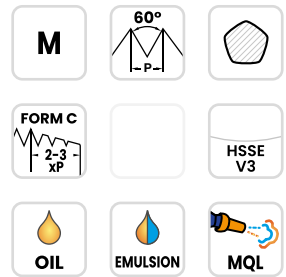
● Cutting parameters

V _c m/min	STEEL 500-800 N/mm ²	GG/G LONG CHIP	CU	ZDC ADC	ALU Si ≤10%	ALU	STEEL ≤500 N/mm ²
	● ● ● 10 - 24	● ● 10 - 32	● ● 3 - 24	● ● ● 7 - 32	● ● ● 7 - 32	● ● 10 - 32	● ● ● 10 - 24
	● ● ● 9 - 16	● ● 13 - 32	● ● 4 - 24	● ● ● 9 - 32	● ● ● 9 - 32	● ● 13 - 32	● ● ● 9 - 16
	● ● ● 10 - 15	● ● 15 - 40	● ● 5 - 20	● ● ● 10 - 30	● ● ● 10 - 30	● ● 15 - 30	● ● ● 10 - 15

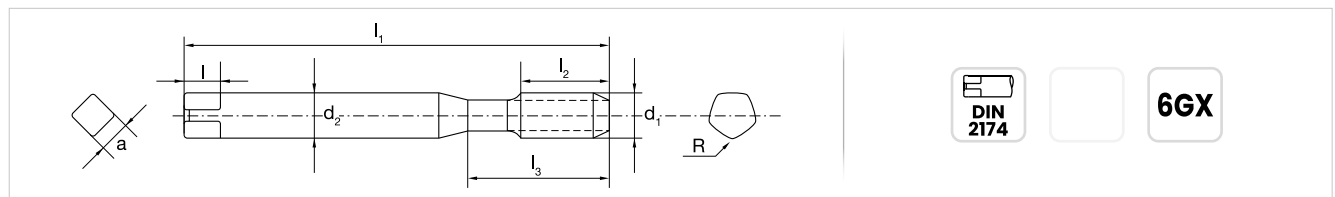
● ● ● Recommended | ● ● Suitable | ○ Possible

FORMING TAPS

For General Use Aluminum, Aluminum Die Cast, Copper, Steels and Stainless Steels < 1'200 N/mm²



Technical details



**DIN
2174**

6GX

d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	R	Ø mm	Order code
M2	0.4	45	8	10	2.8	5	2.1	3	1.83	680.065
M2.5	0.45	50	9	12.5	2.8	5	2.1	3	2.30	680.080
M3	0.5	56	11	18	3.5	6	2.7	3	2.80	680.090
M3.5	0.6	56	12	20	4	6	3	3	3.25	680.095
M4	0.7	63	13	21	4.5	6	3.4	3	3.70	680.100
M5	0.8	70	16	25	6	8	4.9	3	4.65	680.110
M6	1	80	19	30	6	8	4.9	3	5.55	680.115
M8	1.25	90	22	35	8	9	6.2	2	7.40	680.125
M10	1.5	100	24	39	10	11	8	2	9.30	680.135

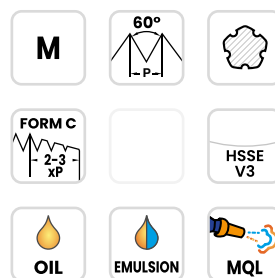
Cutting parameters

V _c m/min	STEEL 500-800 N/mm ²	66/6 LONG CHIP	CU 200-300 HB	CU SHORT	CU	ALU	STEEL ≤500 N/mm ²
	● ● ● 10 - 24	● ● 10 - 32	● ● 3 - 24	● ● 3 - 24	● ● 3 - 24	● ● 10 - 32	● ● ● 10 - 24
	● ● ● 9 - 16	● ● 13 - 32	● ● 4 - 24	● ● 4 - 24	● ● 4 - 24	● ● 13 - 32	● ● ● 9 - 16
	● ● ● 10 - 15	● ● 15 - 40	● ● 5 - 20	● ● 5 - 20	● ● 5 - 20	● ● 15 - 30	● ● ● 10 - 15

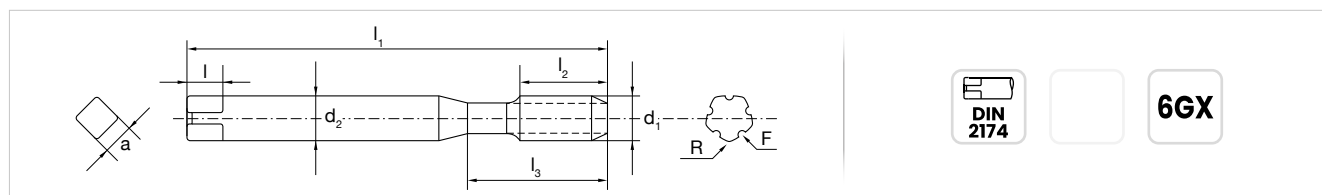
● ● ● Recommended | ● ● Suitable | ○ Possible

FORMING TAPS

For General Use Aluminum, Aluminum Die Cast, Copper, Steels and Stainless Steels < 1'200 N/mm²



● Technical details



DIN 2174

6GX

d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	R	F	Ø mm	Order code
M2	0.4	45	8	10	2.8	5	2.1	4	2	1.83	695.065
M2.5	0.45	50	9	12.5	2.8	5	2.1	4	2	2.30	695.080
M3	0.5	56	11	18	3.5	6	2.7	4	2	2.80	695.090
M3.5	0.6	56	12	20	4	6	3	4	2	3.25	695.095
M4	0.7	63	13	21	4.5	6	3.4	4	2	3.70	695.100
M5	0.8	70	16	25	6	8	4.9	4	2	4.65	695.110
M6	1	80	19	30	6	8	4.9	4	2	5.55	695.115
M8	1.25	90	22	35	8	9	6.2	6	3	7.40	695.125
M10	1.5	100	24	39	10	11	8	8	4	9.30	695.135

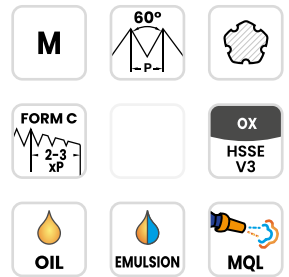
● Cutting parameters

V _c m/min	STEEL 500-800 N/mm ²	GG/G LONG CHIP	CU 200-300 HB	CU SHORT	CU	ALU	STEEL ≤500 N/mm ²
	● ● ● 10 - 24	● ● 10 - 32	● ● 3 - 24	● ● 3 - 24	● ● 3 - 24	● ● 10 - 32	● ● ● 10 - 24
	● ● ● 9 - 16	● ● 13 - 32	● ● 4 - 24	● ● 4 - 24	● ● 4 - 24	● ● 13 - 32	● ● ● 9 - 16
	● ● ● 10 - 15	● ● 15 - 40	● ● 5 - 20	● ● 5 - 20	● ● 5 - 20	● ● 15 - 30	● ● ● 10 - 15

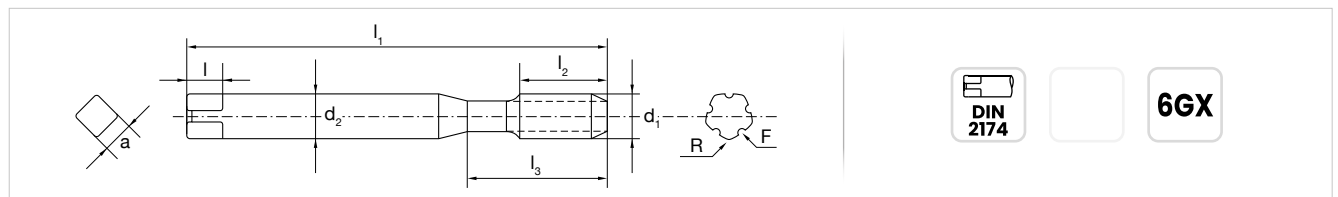
● ● ● Recommended | ● ● Suitable | ○ Possible

FORMING TAPS

For General Use Aluminum, Aluminum Die Cast, Copper, Steels and Stainless Steels < 1'200 N/mm²



Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	R	F	Ø mm	Order code
M2	0.4	45	8	10	2.8	5	2.1	4	2	1.83	696.065
M2.5	0.45	50	9	12.5	2.8	5	2.1	4	2	2.30	696.080
M3	0.5	56	11	18	3.5	6	2.7	4	2	2.80	696.090
M3.5	0.6	56	12	20	4	6	3	4	2	3.25	696.095
M4	0.7	63	13	21	4.5	6	3.4	4	2	3.70	696.100
M5	0.8	70	16	25	6	8	4.9	4	2	4.65	696.110
M6	1	80	19	30	6	8	4.9	4	2	5.55	696.115
M8	1.25	90	22	35	8	9	6.2	6	3	7.40	696.125
M10	1.5	100	24	39	10	11	8	8	4	9.30	696.135

Cutting parameters

V _c m/min	STEEL 500-800 N/mm ²	66/6 LONG CHIP	CU 200-300 HB	CU SHORT	CU	ALU	STEEL ≤500 N/mm ²
	●●● 10 - 24	●● 10 - 32	●● 3 - 24	●● 3 - 24	●● 3 - 24	●● 10 - 32	●●● 10 - 24
	●●● 9 - 16	●● 13 - 32	●● 4 - 24	●● 4 - 24	●● 4 - 24	●● 13 - 32	●●● 9 - 16
	●●● 10 - 15	●● 15 - 40	●● 5 - 20	●● 5 - 20	●● 5 - 20	●● 15 - 30	●●● 10 - 15

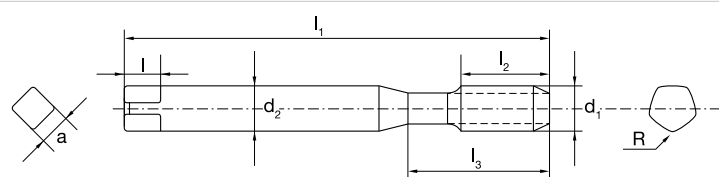
●●● Recommended | ●● Suitable | ○ Possible

FORMING TAPS

For General Use Aluminum, Aluminum Die Cast, Copper, Steels and Stainless Steels < 1'200 N/mm²



● Technical details



6GX

d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	R	Ø mm	Order code
M2	0.4	45	8	10	2.8	5	2.1	2	1.83	685.065
M2.5	0.45	50	9	12.5	2.8	5	2.1	3	2.30	685.080
M3	0.5	56	11	18	3.5	6	2.7	3	2.80	685.090
M3.5	0.6	56	12	20	4	6	3	3	3.25	685.095
M4	0.7	63	13	21	4.5	6	3.4	3	3.70	685.100
M5	0.8	70	16	25	6	8	4.9	3	4.65	685.110
M6	1	80	19	30	6	8	4.9	3	5.55	685.115
M8	1.25	90	22	35	8	9	6.2	3	7.40	685.125
M10	1.5	100	24	39	10	11	8	3	9.30	685.135

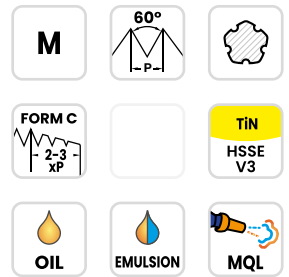
● Cutting parameters

V _c m/min	STEEL 500-800 N/mm ²	GG/G LONG CHIP	CU 200-300 HB	CU SHORT	CU	ALU	STEEL ≤500 N/mm ²
	● ● ● 10 - 24	● ● 10 - 32	● ● 3 - 24	● ● 3 - 24	● ● 3 - 24	● ● 10 - 32	● ● ● 10 - 24
	● ● ● 9 - 16	● ● 13 - 32	● ● 4 - 24	● ● 4 - 24	● ● 4 - 24	● ● 13 - 32	● ● ● 9 - 16
	● ● ● 10 - 15	● ● 15 - 40	● ● 5 - 20	● ● 5 - 20	● ● 5 - 20	● ● 15 - 30	● ● ● 10 - 15

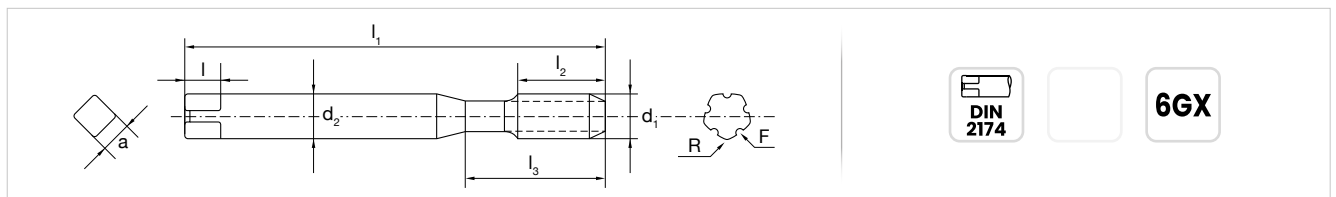
● ● ● Recommended | ● ● Suitable | ○ Possible

FORMING TAPS

For General Use Aluminum, Aluminum Die Cast, Copper, Steels and Stainless Steels < 1'200 N/mm²



Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	R	F	Ø mm	Order code
M2	0.4	45	8	10	2.8	5	2.1	4	2	1.83	700.065
M2.5	0.45	50	9	12.5	2.8	5	2.1	4	2	2.30	700.080
M3	0.5	56	11	18	3.5	6	2.7	4	2	2.80	700.090
M3.5	0.6	56	12	20	4	6	3	4	2	3.25	700.095
M4	0.7	63	13	21	4.5	6	3.4	4	2	3.70	700.100
M5	0.8	70	16	25	6	8	4.9	4	2	4.65	700.110
M6	1	80	19	30	6	8	4.9	4	2	5.55	700.115
M8	1.25	90	22	35	8	9	6.2	6	3	7.40	700.125
M10	1.5	100	24	39	10	11	8	8	4	9.30	700.135

Cutting parameters

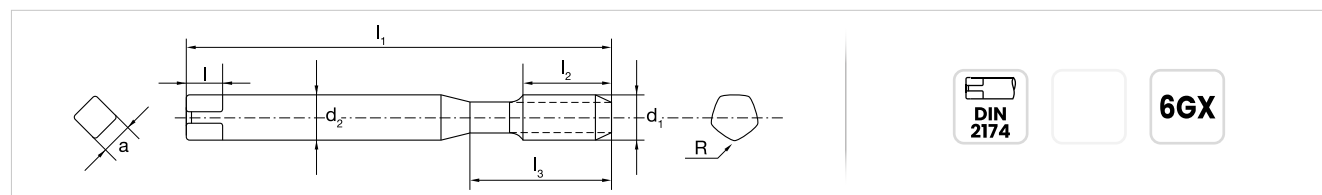
V _c m/min	STEEL 500-800 N/mm ²	66/6 LONG CHIP	CU 200-300 HB	CU SHORT	CU	ALU	STEEL ≤500 N/mm ²
	●●● 10 - 24	●● 10 - 32	●● 3 - 24	●● 3 - 24	●● 3 - 24	●● 10 - 32	●●● 10 - 24
	●●● 9 - 16	●● 13 - 32	●● 4 - 24	●● 4 - 24	●● 4 - 24	●● 13 - 32	●●● 9 - 16
	●●● 10 - 15	●● 15 - 40	●● 5 - 20	●● 5 - 20	●● 5 - 20	●● 15 - 30	●●● 10 - 15

●●● Recommended | ●● Suitable | ○ Possible

FORMING TAPS

For General Use Aluminum, Aluminum Die Cast, Copper, Steels and Stainless Steels < 1'200 N/mm²

● Technical details



6GX

d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	R	Ø mm	Order code
M2	0.4	45	8	10	2.8	5	2.1	3	1.83	690.065
M2.5	0.45	50	9	12.5	2.8	5	2.1	3	2.30	690.080
M3	0.5	56	11	18	3.5	6	2.7	3	2.80	690.090
M3.5	0.6	56	12	20	4	6	3	3	3.25	690.095
M4	0.7	63	13	21	4.5	6	3.4	4	3.70	690.100
M5	0.8	70	16	25	6	8	4.9	4	4.65	690.110
M6	1	80	19	30	6	8	4.9	4	5.55	690.115
M8	1.25	90	22	35	8	9	6.2	2	7.40	690.125
M10	1.5	100	24	39	10	11	8	3	9.30	690.135

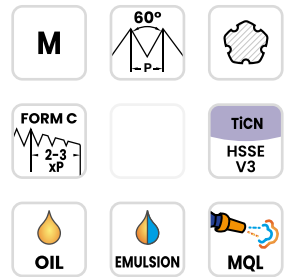
● Cutting parameters

V _c m/min	STEEL 500-800 N/mm ²	GG/G LONG CHIP	CU SHORT	CU	ALU Si ≤10%	ALU	STEEL ≤500 N/mm ²
	● ● ● 10 - 24	● ● 10 - 32	● ● 3 - 24	● ● 3 - 24	● ● ● 7 - 32	● ● 10 - 32	● ● ● 10 - 24
	● ● ● 9 - 16	● ● 13 - 32	● ● 4 - 24	● ● 4 - 24	● ● ● 9 - 32	● ● 13 - 32	● ● ● 9 - 16
	● ● ● 10 - 15	● ● 15 - 40	● ● 5 - 20	● ● 5 - 20	● ● ● 10 - 30	● ● 15 - 30	● ● ● 10 - 15

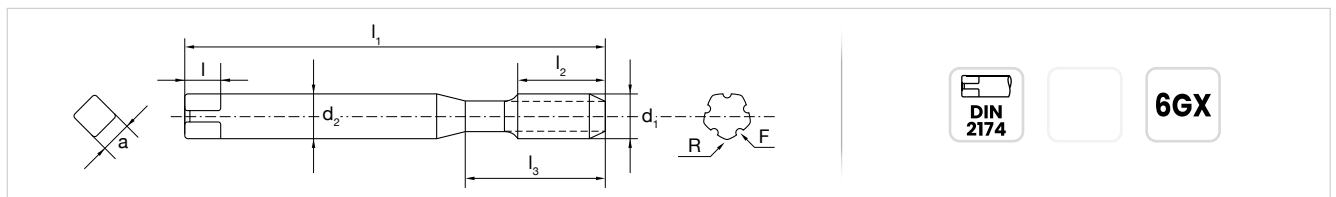
● ● ● Recommended | ● ● Suitable | ○ Possible

FORMING TAPS

For General Use Aluminum, Aluminum Die Cast, Copper, Steels and Stainless Steels < 1'200 N/mm²



Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	R	F	Ø mm	Order code
M2	0.4	45	8	10	2.8	5	2.1	4	2	1.83	676.065
M2.5	0.45	50	9	12.5	2.8	5	2.1	4	2	2.30	676.080
M3	0.5	56	11	18	3.5	6	2.7	4	2	2.80	676.090
M3.5	0.6	56	12	20	4	6	3	4	2	3.25	676.095
M4	0.7	63	13	21	4.5	6	3.4	4	2	3.70	676.100
M5	0.8	70	16	25	6	8	4.9	4	2	4.65	676.110
M6	1	80	19	30	6	8	4.9	4	2	5.55	676.115
M8	1.25	90	22	35	8	9	6.2	6	3	7.40	676.125
M10	1.5	100	24	39	10	11	8	8	4	9.30	676.135

Cutting parameters

V _c m/min	STEEL 500-800 N/mm ²	66/6 LONG CHIP	CU SHORT	CU	ALU Si <10%	ALU	STEEL ≤500 N/mm ²
	●●● 10 - 24	●● 10 - 32	●● 3 - 24	●● 3 - 24	●●● 7 - 32	●● 10 - 32	●●● 10 - 24
	●●● 9 - 16	●● 13 - 32	●● 4 - 24	●● 4 - 24	●●● 9 - 32	●● 13 - 32	●●● 9 - 16
	●●● 10 - 15	●● 15 - 40	●● 5 - 20	●● 5 - 20	●●● 10 - 30	●● 15 - 30	●●● 10 - 15

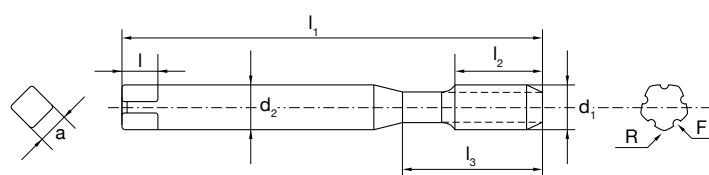
●●● Recommended | ●● Suitable | ○ Possible

FORMING TAPS

For General Use Aluminum, Aluminum Die Cast, Copper, Steels and Stainless Steels < 1'200 N/mm²



● Technical details



6HX

d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	R	F	Ø mm	Order code
M3	0.5	56	11	18	3.5	6	2.7	5	5	2.80	666.090
M4	0.7	63	13	21	4.5	6	3.4	5	5	3.70	666.100
M5	0.8	70	16	25	6	8	4.9	5	5	4.65	666.110
M6	1	80	19	30	6	8	4.9	5	5	5.55	666.115
M8	1.25	90	22	35	8	9	6.2	6	6	7.40	666.125
M10	1.5	100	24	39	10	11	8	8	8	9.30	666.135
M12	1.75	110	28	44	9	10	7	8	8	11.20	666.145
M14	2	110	30	44	11	12	9	8	8	13.00	666.150
M16	2	110	32	44	12	12	9	8	8	15.00	666.155

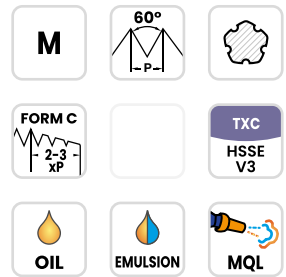
● Cutting parameters

V _c m/min	STEEL 500-800 N/mm ²	CU	ZDC ADC	ALU Si >10%	ALU Si <10%	ALU	STEEL ≤500 N/mm ²
	● ● ● 13 - 24	● ● 13 - 32	● ● ● 13 - 48	● ● 13 - 48	● ● ● 13 - 48	● ● 13 - 48	● ● ● 13 - 32
	● ● ● 10 - 20	● ● 10 - 20	● ● ● 12 - 40	● ● 12 - 40	● ● ● 12 - 40	● ● 12 - 40	● ● ● 10 - 30

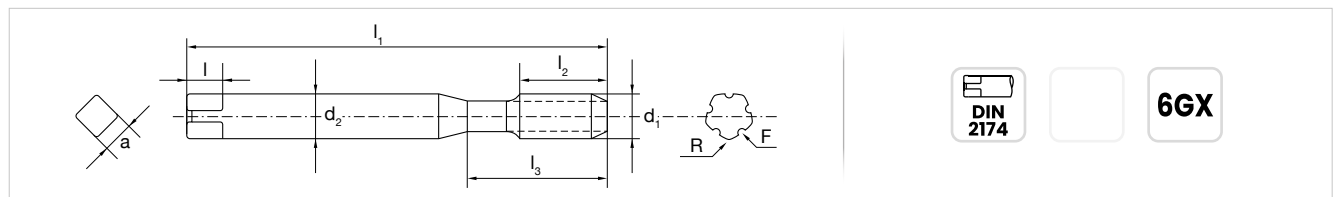
● ● ● Recommended | ● ● Suitable | ○ Possible

FORMING TAPS

For General Use Aluminum, Aluminum Die Cast, Copper, Steels and Stainless Steels < 1'200 N/mm²



Technical details


DIN 2174
6GX

d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	R	F	Ø mm	Order code
M3	0.5	56	11	18	3.5	6	2.7	5	5	2.80	677.090
M4	0.7	63	13	21	4.5	6	3.4	5	5	3.70	677.100
M5	0.8	70	16	25	6	8	4.9	5	5	4.65	677.110
M6	1	80	19	30	6	8	4.9	5	5	5.55	677.115
M8	1.25	90	22	35	8	9	6.2	6	6	7.40	677.125
M10	1.5	100	24	39	10	11	8	8	8	9.30	677.135
M12	1.75	110	28	44	9	10	7	8	8	11.20	677.145
M14	2	110	30	44	11	12	9	8	8	13.00	677.150
M16	2	110	32	44	12	12	9	8	8	15.00	677.155

Cutting parameters

V _c m/min	STEEL 500-800 N/mm ²	CU SHORT	CU	ALU Si >10%	ALU Si <10%	ALU	STEEL ≤500 N/mm ²
≤2xd	● ● ● 13 - 24	● ● 9 - 32	● ● 13 - 32	● ● 13 - 48	● ● ● 13 - 48	● ● 13 - 48	● ● ● 13 - 32
>2xd	● ● ● 10 - 20	● ● 10 - 20	● ● 10 - 20	● ● 12 - 40	● ● ● 12 - 40	● ● 12 - 40	● ● ● 10 - 30

● ● ● Recommended | ● ● Suitable | ○ Possible

FORMING TAPS

For General Use Aluminum, Aluminum Die Cast, Copper, Steels and Stainless Steels < 1'200 N/mm²



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V3

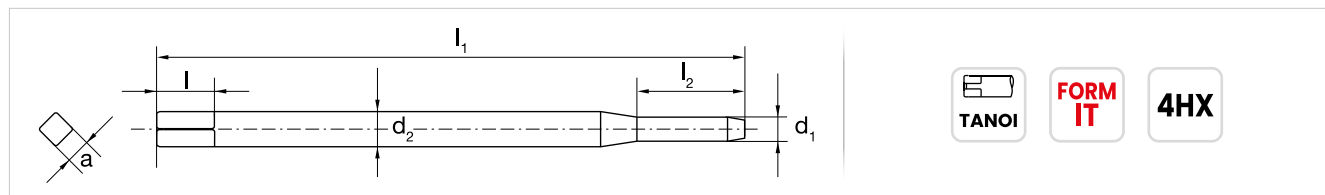


OIL

EMULSION

MQL

● Technical details



TANOI

FORM IT

4HX

d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	R	Ø mm	Order code
S0.5	0.13	50	2	7	2.8	5	2.1	4	0.45	796.005
S0.6	0.15	50	2.5	7.5	2.8	5	2.1	4	0.54	796.010
S0.7	0.17	50	2.5	7.5	2.8	5	2.1	4	0.63	796.015
S0.8	0.2	50	3	8	2.8	5	2.1	4	0.72	796.020
S0.9	0.23	50	3	8	2.8	5	2.1	4	0.81	796.025

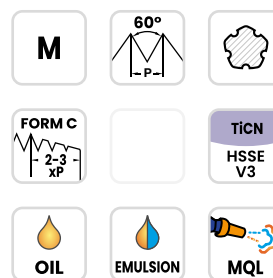
● Cutting parameters

V _c m/min	STEEL 500-800 N/mm ²	GG/G LONG CHIP	CU SHORT	CU	ALU Si ≤10%	ALU	STEEL ≤500 N/mm ²
 10 - 24	● ● ● 10 - 24	● ● 10 - 32	● ● 3 - 24	● ● 3 - 24	● ● ● 7 - 32	● ● 10 - 32	● ● ● 10 - 24
 9 - 16	● ● ● 9 - 16	● ● 13 - 32	● ● 4 - 24	● ● 4 - 24	● ● ● 9 - 32	● ● 13 - 32	● ● ● 9 - 16
 10 - 15	● ● ● 10 - 15	● ● 15 - 40	● ● 5 - 20	● ● 5 - 20	● ● ● 10 - 30	● ● 15 - 30	● ● ● 10 - 15

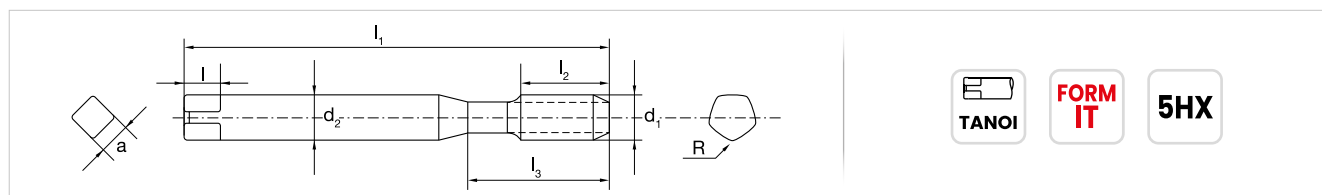
● ● ● Recommended | ● ● Suitable | ○ Possible

FORMING TAPS

For General Use Aluminum, Aluminum Die Cast, Copper, Steels and Stainless Steels < 1'200 N/mm²



Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	R	Ø mm	Order code
M1	0.25	40	5	7	2.8	5	2.1	4	0.90	796.030
M1.1	0.25	40	5	7	2.8	5	2.1	4	1.00	796.035
M1.2	0.25	40	5	7	2.8	5	2.1	4	1.10	796.040
M1.4	0.3	40	7	9	2.8	5	2.1	4	1.26	796.045
M1.6	0.35	40	8	9.5	2.8	5	2.1	4	1.45	796.050
M1.8	0.35	40	8	10.5	2.8	5	2.1	4	1.65	796.060

Cutting parameters

V _c m/min	STEEL 500-800 N/mm ²	66/6 LONG CHIP	CU SHORT	CU	ALU Si <10%	ALU	STEEL ≤500 N/mm ²
	● ● ● 10 - 24	● ● 10 - 32	● ● 3 - 24	● ● 3 - 24	● ● ● 7 - 32	● ● 10 - 32	● ● ● 10 - 24
	● ● ● 9 - 16	● ● 13 - 32	● ● 4 - 24	● ● 4 - 24	● ● ● 9 - 32	● ● 13 - 32	● ● ● 9 - 16
	● ● ● 10 - 15	● ● 15 - 40	● ● 5 - 20	● ● 5 - 20	● ● ● 10 - 30	● ● 15 - 30	● ● ● 10 - 15

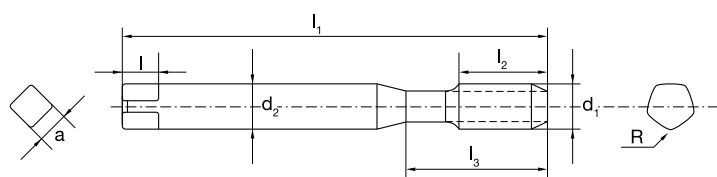
● ● ● Recommended | ● ● Suitable | ○ Possible

FORMING TAPS

For General Use Aluminum, Aluminum Die Cast, Copper, Steels and Stainless Steels < 1'200 N/mm²



● Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	R	F	Ø mm	Order code
M2	0.4	45	8	10	2.8	5	2.1	4		1.83	796.065
M2.2	0.45	45	9	11	2.8	5	2.1	4		2.00	796.070
M2.5	0.45	50	9	12.5	2.8	5	2.1	4		2.30	796.080
M3	0.5	56	11	18	3.5	6	2.7	5	1	2.80	796.090
M3.5	0.6	56	12	20	4	6	3	5	1	3.25	796.095
M4	0.7	63	13	21	4.5	6	3.4	5	1	3.70	796.100
M5	0.8	70	16	25	6	8	4.9	5	1	4.65	796.110
M6	1	80	19	30	6	8	4.9	5	1	5.55	796.115
M8	1.25	90	22	35	8	9	6.2	6	3	7.40	796.125
M10	1.5	100	24	39	10	11	8	8	4	9.30	796.135

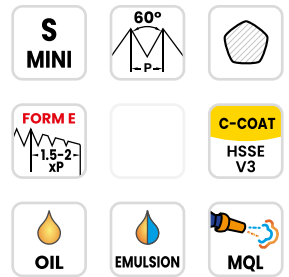
● Cutting parameters

V _c m/min	STEEL 500-800 N/mm ²	GG/G LONG CHIP	CU	ZDC ADC	ALU Si ≤10%	ALU	STEEL ≤500 N/mm ²
	● ● ● 10 - 24	● ● 10 - 32	● ● 3 - 24	● ● ● 7 - 32	● ● ● 7 - 32	● ● 10 - 32	● ● ● 10 - 24
	● ● ● 9 - 16	● ● 13 - 32	● ● 4 - 24	● ● ● 9 - 32	● ● ● 9 - 32	● ● 13 - 32	● ● ● 9 - 16
	● ● ● 10 - 15	● ● 15 - 40	● ● 5 - 20	● ● ● 10 - 30	● ● ● 10 - 30	● ● 15 - 30	● ● ● 10 - 15

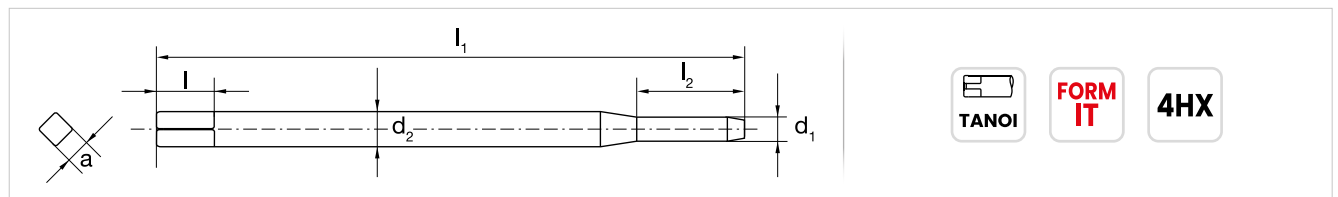
● ● ● Recommended | ● ● Suitable | ○ Possible

FORMING TAPS

For General Use Aluminum, Aluminum Die Cast, Copper, Steels and Stainless Steels < 1'200 N/mm²



● Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	R	Ø mm	Order code
S0.5	0.13	50	2	7	2.8	5	2.1	4	0.45	795.005
S0.6	0.15	50	2.5	7.5	2.8	5	2.1	4	0.54	795.010
S0.7	0.17	50	2.5	7.5	2.8	5	2.1	4	0.63	795.015
S0.8	0.2	50	3	8	2.8	5	2.1	4	0.72	795.020
S0.9	0.23	50	3	8	2.8	5	2.1	4	0.81	795.025

● Cutting parameters

V _c m/min	Ti	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²	STEEL ≤500 N/mm ²
	● ● ● 1 - 9	○ 1 - 9	● ● ● 7 - 18	○ 9 - 18	● ● 7 - 16	● ● ● 10 - 24	● ● ● 10 - 24
	● ● ● 1 - 6	○ 1 - 6	● ● ● 4 - 13	○ 9 - 18	● ● 9 - 16	● ● ● 9 - 16	● ● ● 9 - 16
	● ● ● 2 - 7	○ 2 - 5	● ● ● 5 - 15	○ 8 - 15	● ● 8 - 15	● ● ● 10 - 20	● ● ● 10 - 15

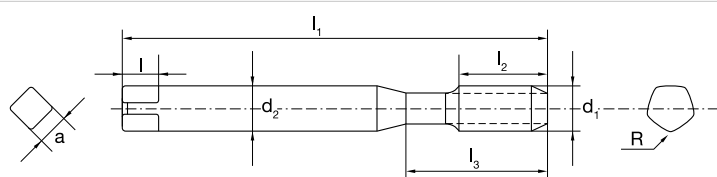
● ● ● Recommended | ● ● Suitable | ○ Possible

FORMING TAPS

For General Use Aluminum, Aluminum Die Cast, Copper, Steels and Stainless Steels < 1'200 N/mm²



● Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	R	Ø mm	Order code
M1	0.25	40	5	7	2.8	5	2.1	4	0.90	795.030
M1.1	0.25	40	5	7	2.8	5	2.1	4	1.00	795.035
M1.2	0.25	40	5	7	2.8	5	2.1	4	1.10	795.040
M1.4	0.3	40	7	9	2.8	5	2.1	4	1.26	795.045
M1.6	0.35	40	8	9.5	2.8	5	2.1	4	1.45	795.050
M1.8	0.35	40	8	10.5	2.8	5	2.1	4	1.65	795.060

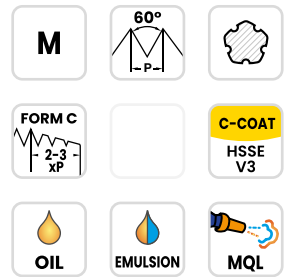
● Cutting parameters

V _c m/min	Ti	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²	STEEL ≤500 N/mm ²
 1 - 8	● ● ● 1 - 8	○ 1 - 8	● ● ● 5 - 16	○ 7 - 16	● ● 7 - 16	● ● ● 10 - 24	● ● ● 10 - 24
 1 - 5	● ● ● 1 - 5	○ 1 - 5	● ● ● 4 - 12	○ 9 - 16	● ● 9 - 16	● ● ● 9 - 16	● ● ● 9 - 16
 2 - 7	● ● ● 2 - 7	○ 2 - 5	● ● ● 5 - 15	○ 8 - 15	● ● 8 - 15	● ● ● 10 - 20	● ● ● 10 - 15

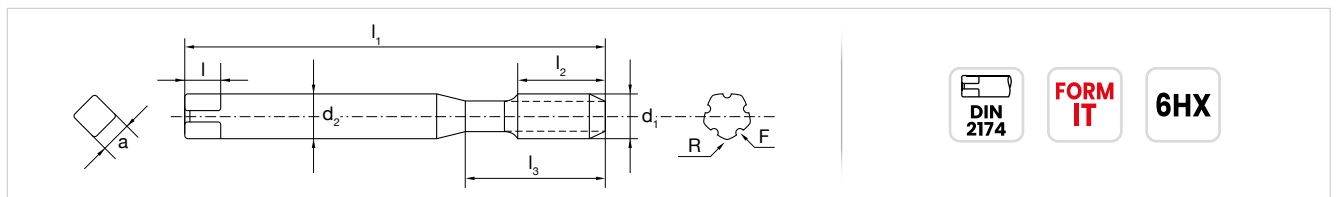
● ● ● Recommended | ● ● Suitable | ○ Possible

FORMING TAPS

For General Use Aluminum, Aluminum Die Cast, Copper, Steels and Stainless Steels < 1'200 N/mm²



● Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	R	F	Ø/mm	Order code
M2	0.4	45	8	10	2.8	5	2.1	4		1.83	795.065
M2.2	0.45	45	9	11	2.8	5	2.1	4		2.00	795.070
M2.5	0.45	50	9	12.5	2.8	5	2.1	4		2.30	795.080
M3	0.5	56	11	18	3.5	6	2.7	5	1	2.80	795.090
M3.5	0.6	56	12	20	4	6	3	5	1	3.25	795.095
M4	0.7	63	13	21	4.5	6	3.4	5	1	3.70	795.100
M5	0.8	70	16	25	6	8	4.9	5	1	4.65	795.110
M6	1	80	19	30	6	8	4.9	5	1	5.55	795.115
M8	1.25	90	22	35	8	9	6.2	6	3	7.40	795.125
M10	1.5	100	24	39	10	11	8	8	4	9.30	795.135

● Cutting parameters

V _c m/min	Ti	NI	INOX ≤1200 N/mm ²	STEEL 800-1300 N/mm ²	STEEL 800-1200 N/mm ²	STEEL 500-800 N/mm ²	STEEL ≤500 N/mm ²
	● ● ● 1 - 8	○ 1 - 8	● ● ● 5 - 16	○ 7 - 16	● ● 7 - 16	● ● ● 10 - 24	● ● ● 10 - 24
	● ● ● 1 - 5	○ 1 - 5	● ● ● 4 - 12	○ 9 - 16	● ● 9 - 16	● ● ● 9 - 16	● ● ● 9 - 16
	● ● ● 2 - 7	○ 2 - 5	● ● ● 5 - 15	○ 8 - 15	● ● 8 - 15	● ● ● 10 - 20	● ● ● 10 - 15

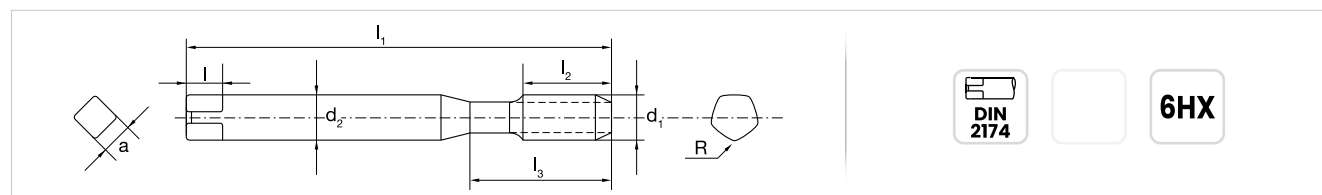
● ● ● Recommended | ● ● Suitable | ○ Possible

FORMING TAPS

For General Use Aluminum, Aluminum Die Cast, Copper, Steels and Stainless Steels < 1'200 N/mm²



● Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	R	Ø mm	Order code
M3	0.35	56	8	18	3.5	6	2.7	4	2.85	650.086
M4	0.5	63	10	21	4.5	6	3.4	4	3.80	650.097
M5	0.5	70	12	25	6	8	4.9	4	4.80	650.106
M6	0.75	80	14	30	6	8	4.9	6	5.65	650.112
M8	1	90	22	35	8	9	6.2	6	7.55	650.123
M10	1	90	20	35	10	11	8	8	9.55	650.132
M12	1.5	100	22	40	9	10	7	8	11.30	650.143
M16	1.5	100	22	40	12	12	9	8	15.30	650.152

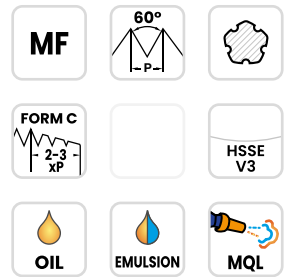
● Cutting parameters

V _c m/min	STEEL 500-800 N/mm ²	GG/G LONG CHIP	CU 200-300 HB	CU SHORT	CU	ALU	STEEL ≤500 N/mm ²
	● ● ● 10 - 24	● ● 10 - 32	● ● 3 - 24	● ● 3 - 24	● ● 3 - 24	● ● 10 - 32	● ● ● 10 - 24
	● ● ● 9 - 16	● ● 13 - 32	● ● 4 - 24	● ● 4 - 24	● ● 4 - 24	● ● 13 - 32	● ● ● 9 - 16
	● ● ● 10 - 15	● ● 15 - 40	● ● 5 - 20	● ● 5 - 20	● ● 5 - 20	● ● 15 - 30	● ● ● 10 - 15

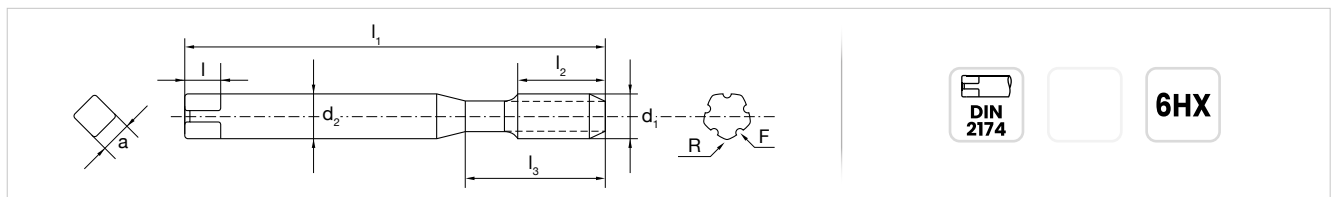
● ● ● Recommended | ● ● Suitable | ○ Possible

FORMING TAPS

For General Use Aluminum, Aluminum Die Cast, Copper, Steels and Stainless Steels < 1'200 N/mm²



Technical details


DIN 2174
6HX

d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	R	F	Ø mm	Order code
M3	0.35	56	8	18	3.5	6	2.7	4	2	2.85	655.086
M4	0.5	63	10	21	4.5	6	3.4	4	2	3.80	655.097
M5	0.5	70	12	25	6	8	4.9	4	2	4.80	655.106
M6	0.75	80	14	30	6	8	4.9	6	2	5.65	655.112
M8	1	90	22	35	8	9	6.2	6	3	7.55	655.123
M10	1	90	20	35	10	11	8	8	4	9.55	655.132
M12	1.5	100	22	40	9	10	7	8	4	11.30	655.143
M16	1.5	100	22	40	12	12	9	8	4	15.30	655.152

Cutting parameters

V _c m/min	STEEL 500-800 N/mm ²	66/6 LONG CHIP	CU 200-300 HB	CU SHORT	CU	ALU	STEEL ≤500 N/mm ²
	●●● 10 - 24	●● 10 - 32	●● 3 - 24	●● 3 - 24	●● 3 - 24	●● 10 - 32	●●● 10 - 24
≤2xd	●●● 9 - 16	●● 13 - 32	●● 4 - 24	●● 4 - 24	●● 4 - 24	●● 13 - 32	●●● 9 - 16
>2xd	●●● 10 - 15	●● 15 - 40	●● 5 - 20	●● 5 - 20	●● 5 - 20	●● 15 - 30	●●● 10 - 15

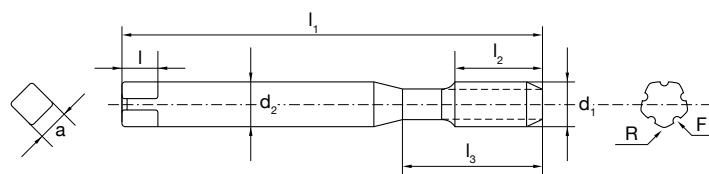
●●● Recommended | ●● Suitable | ○ Possible

FORMING TAPS

For General Use Aluminum, Aluminum Die Cast, Copper, Steels and Stainless Steels < 1'200 N/mm²



● Technical details



6HX

d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	R	F	Ø mm	Order code
M3	0.35	56	8	18	3.5	6	2.7	4	2	2.85	656.086
M4	0.5	63	10	21	4.5	6	3.4	4	2	3.80	656.097
M5	0.5	70	12	25	6	8	4.9	4	2	4.80	656.106
M6	0.75	80	14	30	6	8	4.9	4	2	5.65	656.112
M8	1	90	22	35	8	9	6.2	6	3	7.55	656.123
M10	1	90	20	35	10	11	8	8	4	9.55	656.132
M12	1.5	100	22	40	9	10	7	8	4	11.30	656.143
M16	1.5	100	22	40	12	12	9	8	4	15.30	656.152

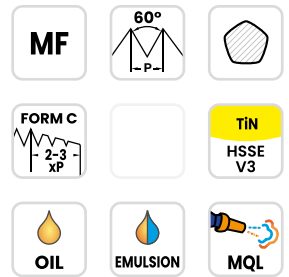
● Cutting parameters

V _c m/min	STEEL 500-800 N/mm ²	GG/G LONG CHIP	CU 200-300 HB	CU SHORT	CU	ALU	STEEL ≤500 N/mm ²
	● ● ● 10 - 24	● ● 10 - 32	● ● 3 - 24	● ● 3 - 24	● ● 3 - 24	● ● 10 - 32	● ● ● 10 - 24
	● ● ● 9 - 16	● ● 13 - 32	● ● 4 - 24	● ● 4 - 24	● ● 4 - 24	● ● 13 - 32	● ● ● 9 - 16
	● ● ● 10 - 15	● ● 15 - 40	● ● 5 - 20	● ● 5 - 20	● ● 5 - 20	● ● 15 - 30	● ● ● 10 - 15

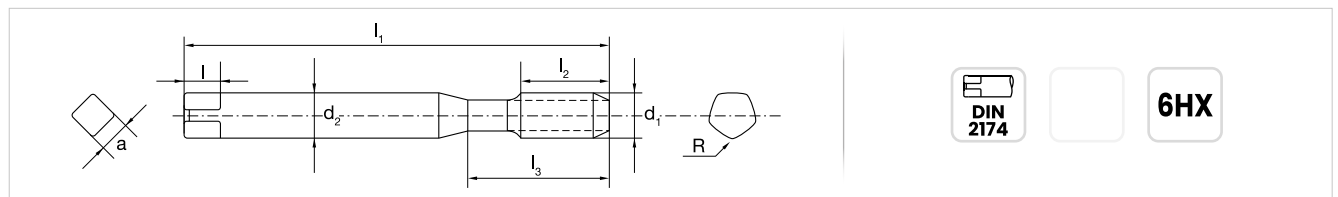
● ● ● Recommended | ● ● Suitable | ○ Possible

FORMING TAPS

For General Use Aluminum, Aluminum Die Cast, Copper, Steels and Stainless Steels < 1'200 N/mm²



Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	R	Ø mm	Order code
M3	0.35	56	8	18	3.5	6	2.7	4	2.85	660.086
M4	0.5	63	10	21	4.5	6	3.4	4	3.80	660.097
M5	0.5	70	12	25	6	8	4.9	4	4.80	660.106
M6	0.75	80	14	30	6	8	4.9	4	5.65	660.112
M8	1	90	22	35	8	9	6.2	6	7.55	660.123
M10	1	90	20	35	8	11	8	8	9.55	660.132
M12	1.5	100	22	40	9	10	7	8	11.30	660.143
M16	1.5	100	22	40	12	12	9	8	15.30	660.152

Cutting parameters

V _c m/min	STEEL 500-800 N/mm ²	66/6 LONG CHIP	CU 200-300 HB	CU SHORT	CU	ALU	STEEL ≤500 N/mm ²
	●●● 10 - 24	●● 10 - 32	●● 3 - 24	●● 3 - 24	●● 3 - 24	●● 10 - 32	●●● 10 - 24
	●●● 9 - 16	●● 13 - 32	●● 4 - 24	●● 4 - 24	●● 4 - 24	●● 13 - 32	●●● 9 - 16
	●●● 10 - 15	●● 15 - 40	●● 5 - 20	●● 5 - 20	●● 5 - 20	●● 15 - 30	●●● 10 - 15

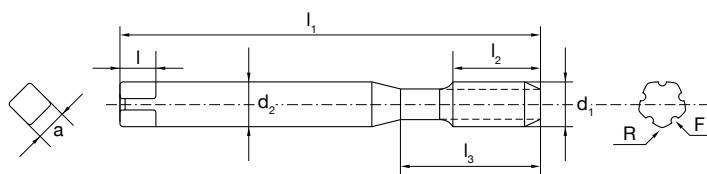
●●● Recommended | ●● Suitable | ○ Possible

FORMING TAPS

For General Use Aluminum, Aluminum Die Cast, Copper, Steels and Stainless Steels < 1'200 N/mm²



● Technical details



6HX

d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	R	F	Ø mm	Order code
M3	0.35	56	8	18	3.5	6	2.7	4	2	2.85	665.086
M4	0.5	63	10	21	4.5	6	3.4	4	2	3.80	665.097
M5	0.5	70	12	25	6	8	4.9	4	2	4.80	665.106
M6	0.75	80	14	30	6	8	4.9	4	2	5.65	665.112
M8	1	90	22	35	8	9	6.2	6	3	7.55	665.123
M10	1	90	20	35	10	11	8	8	4	9.55	665.132
M12	1.5	100	22	40	9	10	7	8	4	11.30	665.143
M16	1.5	100	22	40	12	12	9	8	4	15.30	665.152

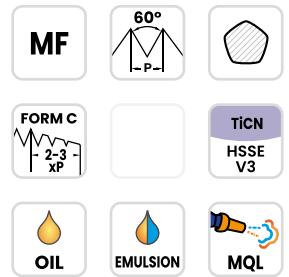
● Cutting parameters

V _c m/min	STEEL 500-800 N/mm ²	GG/G LONG CHIP	CU 200-300 HB	CU SHORT	CU	ALU	STEEL ≤500 N/mm ²
	● ● ● 10 - 24	● ● 10 - 32	● ● 3 - 24	● ● 3 - 24	● ● 3 - 24	● ● 10 - 32	● ● ● 10 - 24
	● ● ● 9 - 16	● ● 13 - 32	● ● 4 - 24	● ● 4 - 24	● ● 4 - 24	● ● 13 - 32	● ● ● 9 - 16
	● ● ● 10 - 15	● ● 15 - 40	● ● 5 - 20	● ● 5 - 20	● ● 5 - 20	● ● 15 - 30	● ● ● 10 - 15

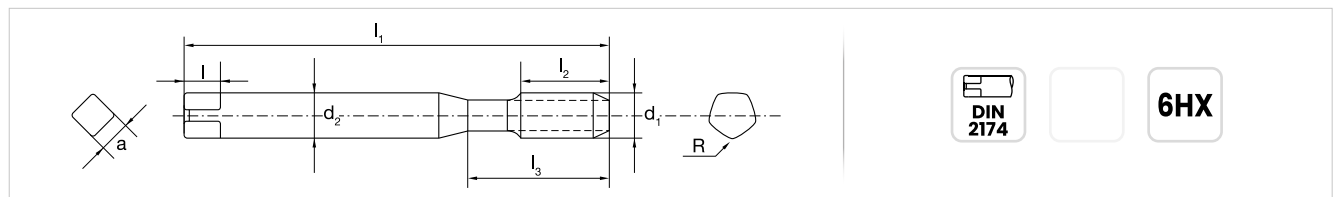
● ● ● Recommended | ● ● Suitable | ○ Possible

FORMING TAPS

For General Use Aluminum, Aluminum Die Cast, Copper, Steels and Stainless Steels < 1'200 N/mm²



Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	α	R	Ø/mm	Order code
M3	0.35	56	8	18	3.5	6	2.7	4	2.85	670.086
M4	0.5	63	10	21	4.5	6	3.4	4	3.80	670.097
M5	0.5	70	12	25	6	8	4.9	4	4.80	670.106
M6	0.75	80	14	30	6	8	4.9	4	5.65	670.112
M8	1	90	22	35	8	9	6.2	6	7.55	670.123
M10	1	90	20	35	10	11	8	8	9.55	670.132
M12	1.5	100	22	40	9	10	7	8	11.30	670.143
M16	1.5	100	22	40	12	12	9	8	15.30	670.152

Cutting parameters

V _c m/min	STEEL 500-800 N/mm ²	66/6 LONG CHIP	CU SHORT	CU	ALU Si ≤10%	ALU	STEEL ≤500 N/mm ²
	●●● 10 - 24	●● 10 - 32	●● 3 - 24	●● 3 - 24	●●● 7 - 32	●● 10 - 32	●●● 10 - 24
	●●● 9 - 16	●● 13 - 32	●● 4 - 24	●● 4 - 24	●●● 9 - 32	●● 13 - 32	●●● 9 - 16
	●●● 10 - 15	●● 15 - 40	●● 5 - 20	●● 5 - 20	●●● 10 - 30	●● 15 - 30	●●● 10 - 15

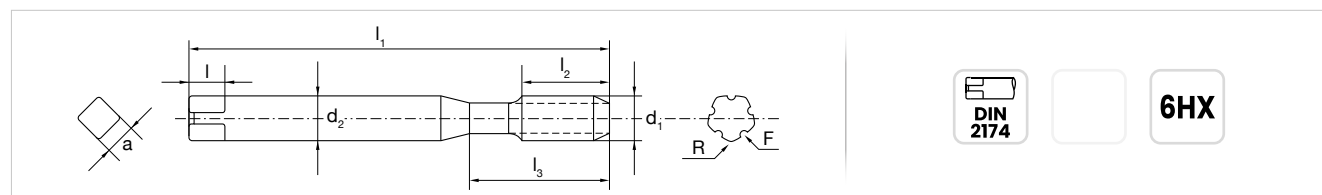
●●● Recommended | ●● Suitable | ○ Possible

FORMING TAPS

For General Use Aluminum, Aluminum Die Cast, Copper, Steels and Stainless Steels < 1'200 N/mm²



● Technical details



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	R	F	Ø mm	Order code
M3	0.35	56	8	18	3.5	6	2.7	4	2	2.85	675.086
M4	0.5	63	10	21	4.5	6	3.4	4	2	3.80	675.097
M5	0.5	70	12	25	6	8	4.9	4	2	4.80	675.106
M6	0.75	80	14	30	6	8	4.9	4	2	5.65	675.112
M8	1	90	22	35	8	9	6.2	6	3	7.55	675.123
M10	1	90	20	35	10	11	8	8	4	9.55	675.132
M12	1.5	100	22	40	9	10	7	8	4	11.30	675.143
M16	1.5	100	22	40	12	12	9	8	4	15.30	675.152

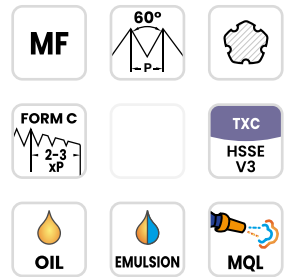
● Cutting parameters

V _c m/min	STEEL 500-800 N/mm ²	GG/G LONG CHIP	CU SHORT	CU	ALU Si ≤10%	ALU	STEEL ≤500 N/mm ²
	● ● ● 10 - 24	● ● 10 - 32	● ● 3 - 24	● ● 3 - 24	● ● ● 7 - 32	● ● 10 - 32	● ● ● 10 - 24
	● ● ● 9 - 16	● ● 13 - 32	● ● 4 - 24	● ● 4 - 24	● ● ● 9 - 32	● ● 13 - 32	● ● ● 9 - 16
	● ● ● 10 - 15	● ● 15 - 40	● ● 5 - 20	● ● 5 - 20	● ● ● 10 - 30	● ● 15 - 30	● ● ● 10 - 15

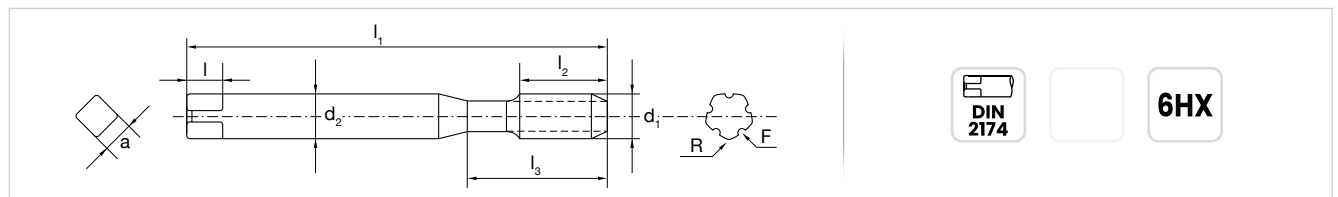
● ● ● Recommended | ● ● Suitable | ○ Possible

FORMING TAPS

For General Use Aluminum, Aluminum Die Cast, Copper, Steels and Stainless Steels < 1'200 N/mm²



Technical details



DIN 2174

6HX

d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	R	F	Ø mm	Order code
M8	1	90	22	35	8	9	6.2	6	6	7.55	666.123
M10	1	90	20	35	10	11	8	8	8	9.55	666.132
M10	1.25	100	24	39	10	11	8	8	8	9.40	666.133
M12	1.25	100	22	40	9	10	7	8	8	11.40	666.140
M12	1.5	100	22	40	9	10	7	8	8	11.30	666.143
M14	1.5	100	22	40	11	12	9	8	8	13.30	666.149
M16	1.5	100	22	40	12	12	9	8	8	15.30	666.152

Cutting parameters

V _c m/min	STEEL 500-800 N/mm ²	CU SHORT	CU	ALU Si >10%	ALU Si <10%	ALU	STEEL ≤500 N/mm ²
≤2xd	● ● ● 13 - 24	● ● 9 - 32	● ● 13 - 32	● ● 13 - 48	● ● ● 13 - 48	● ● 13 - 48	● ● ● 13 - 32
>2xd	● ● ● 10 - 20	● ● 10 - 20	● ● 10 - 20	● ● 12 - 40	● ● ● 12 - 40	● ● 12 - 40	● ● ● 10 - 30

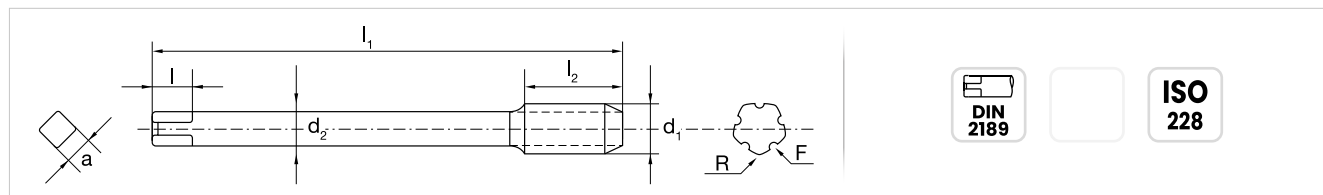
● ● ● Recommended | ● ● Suitable | ○ Possible

FORMING TAPS

For General Use Aluminum, Aluminum Die Cast, Copper, Steels and Stainless Steels < 1'200 N/mm²



● Technical details



d ₁	TPI	l ₁	l ₂	l ₃	d ₂	l	a	R	F	Ø mm	Order code
1/8	28	90	20	36	7	8	5.5	8	4	9.30	770.005
1/4	19	100	22	40	11	12	9	8	4	12.50	770.010
3/8	19	100	22	40	12	12	9	8	4	16.00	770.015

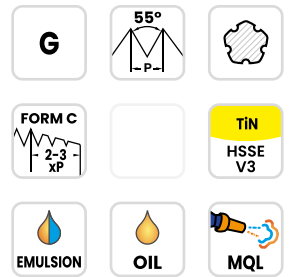
● Cutting parameters

V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 5 - 12	● ● ● 10 - 24	○ 10 - 32	● ● 3 - 24	● ● 3 - 24	● ● 3 - 24	● ● 10 - 24
	○ 4 - 12	● ● ● 9 - 16	○ 13 - 32	● ● 4 - 24	● ● 4 - 24	● ● 4 - 24	● ● 9 - 16
	○ 5 - 10	● ● ● 10 - 15	○ 15 - 40	● ● 5 - 20	● ● 5 - 20	● ● 5 - 20	● ● 10 - 15

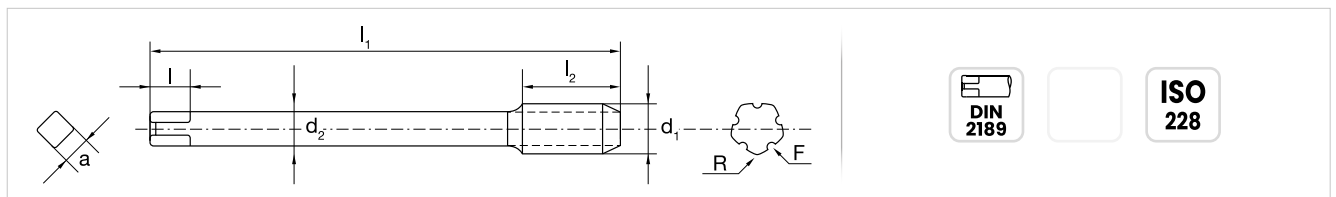
● ● ● Recommended | ● ● Suitable | ○ Possible

FORMING TAPS

For General Use Aluminum, Aluminum Die Cast, Copper, Steels and Stainless Steels < 1'200 N/mm²



● Technical details


DIN 2189
ISO 228

d ₁	TPI	l ₁	l ₂	l ₃	d ₂	l	a	R	F	Ø mm	Order code
1/8	28	90	20	36	7	8	5.5	8	4	9.30	775.005
1/4	19	100	22	40	11	12	9	8	4	12.50	775.010
3/8	19	100	22	40	12	12	9	8	4	16.00	775.015

● Cutting parameters

V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 5 - 12	●●●● 10 - 24	○ 10 - 32	●● 3 - 24	●● 3 - 24	●● 3 - 24	●● 10 - 24
	○ 4 - 12	●●●● 9 - 16	○ 13 - 32	●● 4 - 24	●● 4 - 24	●● 4 - 24	●● 9 - 16
	○ 5 - 10	●●●● 10 - 15	○ 15 - 40	●● 5 - 20	●● 5 - 20	●● 5 - 20	●● 10 - 15

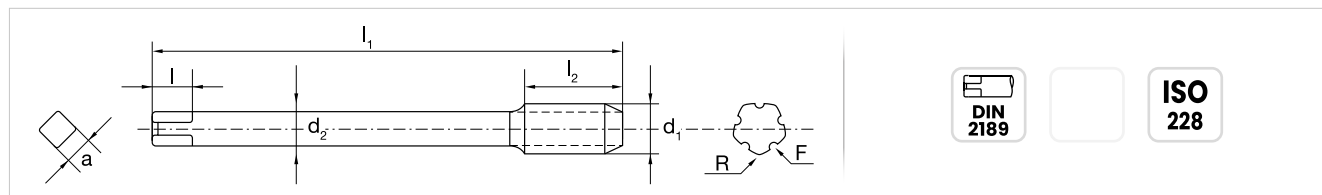
●●● Recommended | ●● Suitable | ○ Possible

FORMING TAPS

For General Use Aluminum, Aluminum Die Cast, Copper, Steels and Stainless Steels < 1'200 N/mm²



● Technical details



d ₁	TPI	l ₁	l ₂	l ₃	d ₂	l	α	R	F	Ø mm	Order code
1/8	28	90	20	36	7	8	5.5	8	4	9.30	780.005
1/4	19	100	22	40	11	12	9	8	4	12.50	780.010
3/8	19	100	22	40	12	12	9	8	4	16.00	780.015

● Cutting parameters

V _c m/min	INOX ≤1200 N/mm ²	STEEL 500-800 N/mm ²	GG/G CAST	CU 200-300 HB	CU SHORT	CU	STEEL ≤500 N/mm ²
	○ 5 - 12	● ● ● 10 - 24	○ 10 - 32	● ● 3 - 24	● ● 3 - 24	● ● 3 - 24	● ● 10 - 24
	○ 4 - 12	● ● ● 9 - 16	○ 13 - 32	● ● 4 - 24	● ● 4 - 24	● ● 4 - 24	● ● 9 - 16
	○ 5 - 10	● ● ● 10 - 15	○ 15 - 40	● ● 5 - 20	● ● 5 - 20	● ● 5 - 20	● ● 10 - 15

● ● ● Recommended | ● ● Suitable | ○ Possible

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TANOI



Hand Taps



Section Index

D⁰²

TOOL SELECTION GUIDE

(M) THREADING	For Stainless Steels < 1200 N/mm ²	XX
	For General Use	XX
(MF) THREADING	For General Use	XX
(UNC) THREADING	For General Use	XX
(UNF) THREADING	For General Use	XX
(G) THREADING	For General Use	XX

HAND TAPS

Hole type	Threading type	Catalog number Size range	DIN	Helix angle	Tolerance	Chamfer form	Material and coating	Taps reference page
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● FOR STAINLESS STEELS < 1'200 N/mm2

	M	 I	    	308
		 II		
		 III 6.119.721 M2 - M20		
	M	 I	    	310
		 II		
		 III 6.119.721-P M2 - M20		

Available as single pieces:
I, II, III and SET

Available as single pieces:
I, II, III and SET

HAND TAPS

Hole type	Threading type	Tool Code	DIN	Helix angle	Tolerance	Chamfer form	Material and coating	Taps reference page
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● FOR GENERAL USE Cast Iron, Aluminium, Aluminium Die Cast, Steels and Stainless Steels < 1'200 N/mm2

	M	 I	    	312
		 II		
		 III 3.119.710 M1 - M52		
	M_{LH}	 I	    	316
		 II		
		 III 3.119.710-LH M3 - M24		

Available as single pieces:
I, II, III and SET

Available as single pieces:
I, II, III and SET

HAND TAPS

Hole type	Threading type	Catalog number Size range	DIN	Helix angle	Tolerance	Chamfer form	Material and coating	Taps reference page
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● FOR GENERAL USE Cast Iron, Aluminium, Aluminium Die Cast, Steels and Stainless Steels < 1'200 N/mm2

	MF							318
		● I  ● II 3.219.810 M2 - M52	Available as single pieces: I, II, III and SET					

● FOR GENERAL USE Cast Iron, Aluminium, Aluminium Die Cast, Steels and Stainless Steels < 1'200 N/mm2

	UNC		 324
		● I 	
 ≤2xd		● II 	
	● III 3.399.710 No.1 - 1	Available as single pieces: I, II, III and SET	

HAND TAPS

Hole type	Threading type	Tool Code	DIN	Helix angle	Tolerance	Chamfer form	Material and coating	Taps reference page
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● FOR GENERAL USE Cast Iron, Aluminium, Aluminium Die Cast, Steels and Stainless Steels < 1'200 N/mm2

	UNF		    	326
		● I 		
 ≤2xd	● II 3.499.810 No.0 - 1			
Available as single pieces: I, II, III and SET				

● FOR GENERAL USE Cast Iron, Aluminium, Aluminium Die Cast, Steels and Stainless Steels < 1'200 N/mm2

	G		    	328
		● I 		
 s2xd		● II 3.699.510		
		1/8 - 2	Available as single pieces: I, II, III and SET	

HAND TAPS

For Stainless Steels < 1'200 N/mm²

● I



● II



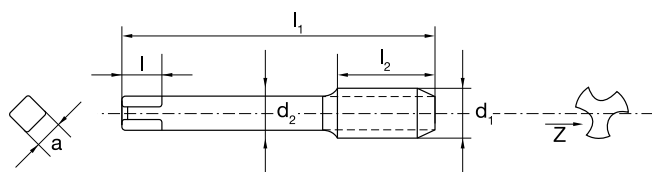
● III



M

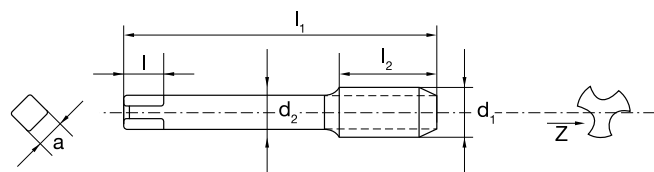


● Technical details



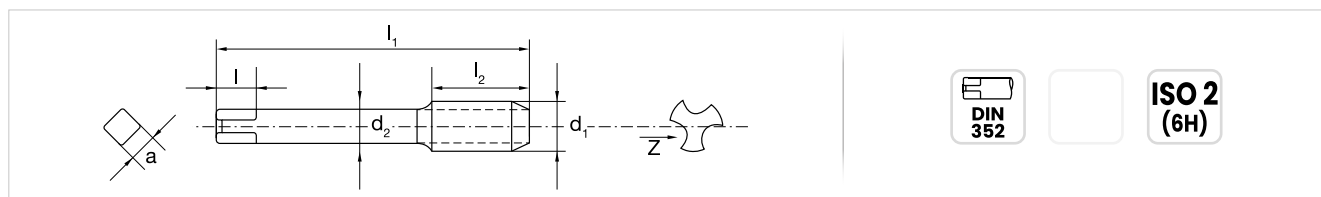
d ₁	P	Type	l ₁	l ₂	d ₂	l	a	Z	Ø mm	Order code
M2	0.4	I	36	8	2.8	5	2.1	3	1.60	920.040-I
M2	0.4	II	36	8	2.8	5	2.1	3	1.60	920.040-II
M2	0.4	III	36	8	2.8	5	2.1	3	1.60	920.040-III
M2	0.4	Set	36	8	2.8	5	2.1	3	1.60	920.040-S
M2.2	0.45	I	36	9	2.8	5	2.1	3	1.75	920.045-I
M2.2	0.45	II	36	9	2.8	5	2.1	3	1.75	920.045-II
M2.2	0.45	III	36	9	2.8	5	2.1	3	1.75	920.045-III
M2.2	0.45	Set	36	9	2.8	5	2.1	3	1.75	920.045-S
M2.3	0.4	I	36	9	2.8	5	2.1	3	1.90	920.050-I
M2.3	0.4	II	36	9	2.8	5	2.1	3	1.90	920.050-II
M2.3	0.4	III	36	9	2.8	5	2.1	3	1.90	920.050-III
M2.3	0.4	Set	36	9	2.8	5	2.1	3	1.90	920.050-S
M2.5	0.45	I	40	9	2.8	5	2.1	3	2.05	920.055-I
M2.5	0.45	II	40	9	2.8	5	2.1	3	2.05	920.055-II
M2.5	0.45	III	40	9	2.8	5	2.1	3	2.05	920.055-III
M2.5	0.45	Set	40	9	2.8	5	2.1	3	2.05	920.055-S
M2.6	0.45	I	40	9	2.8	5	2.1	3	2.15	920.060-I
M2.6	0.45	II	40	9	2.8	5	2.1	3	2.15	920.060-II
M2.6	0.45	III	40	9	2.8	5	2.1	3	2.15	920.060-III
M2.6	0.45	Set	40	9	2.8	5	2.1	3	2.15	920.060-S
M3	0.5	I	40	11	3.5	6	2.7	3	2.50	920.065-I
M3	0.5	II	40	11	3.5	6	2.7	3	2.50	920.065-II
M3	0.5	III	40	11	3.5	6	2.7	3	2.50	920.065-III
M3	0.5	Set	40	11	3.5	6	2.7	3	2.50	920.065-S

● Technical details



d ₁	P	Type	l ₁	l ₂	d ₂	l	a	Z	Ø mm	Order code
M3.5	0.6	I	45	12	4	6	3	3	2.90	920.070-I
M3.5	0.6	II	45	12	4	6	3	3	2.90	920.070-II
M3.5	0.6	III	45	12	4	6	3	3	2.90	920.070-III
M3.5	0.6	Set	45	12	4	6	3	4	2.90	920.070-S
M4	0.7	I	45	13	4.5	6	3.4	3	3.30	920.075-I
M4	0.7	II	45	13	4.5	6	3.4	3	3.30	920.075-II
M4	0.7	III	45	13	4.5	6	3.4	3	3.30	920.075-III
M4	0.7	Set	45	13	4.5	6	3.4	3	3.30	920.075-S
M5	0.8	I	50	16	6	8	4.9	3	4.20	920.085-I
M5	0.8	II	50	16	6	8	4.9	3	4.20	920.085-II
M5	0.8	III	50	16	6	8	4.9	3	4.20	920.085-III
M5	0.8	Set	50	16	6	8	4.9	3	4.20	920.085-S
M6	1	I	56	19	6	8	4.9	3	5.00	920.090-I
M6	1	II	56	19	6	8	4.9	3	5.00	920.090-II
M6	1	III	56	19	6	8	4.9	3	5.00	920.090-III
M6	1	Set	56	19	6	8	4.9	3	5.00	920.090-S
M8	1.25	I	63	22	6	8	4.9	4	6.80	920.100-I
M8	1.25	II	63	22	6	8	4.9	4	6.80	920.100-II
M8	1.25	III	63	22	6	8	4.9	4	6.80	920.100-III
M8	1.25	Set	63	22	6	8	4.9	4	6.80	920.100-S
M10	1.5	I	70	24	7	8	5.5	4	8.50	920.110-I
M10	1.5	II	70	24	7	8	5.5	4	8.50	920.110-II
M10	1.5	III	70	24	7	8	5.5	4	8.50	920.110-III
M10	1.5	Set	70	24	7	8	5.5	4	8.50	920.110-S
M12	1.75	I	75	28	9	10	7	4	10.20	920.120-I
M12	1.75	II	75	28	9	10	7	4	10.20	920.120-II
M12	1.75	III	75	28	9	10	7	4	10.20	920.120-III
M12	1.75	Set	75	28	9	10	7	4	10.20	920.120-S
M14	2	I	80	30	11	12	9	4	12.00	920.125-I
M14	2	II	80	30	11	12	9	4	12.00	920.125-II
M14	2	III	80	30	11	12	9	4	12.00	920.125-III
M14	2	Set	80	30	11	12	9	4	12.00	920.125-S
M16	2	I	80	32	12	12	9	4	14.00	920.130-I
M16	2	II	80	32	12	12	9	4	14.00	920.130-II
M16	2	III	80	32	12	12	9	4	14.00	920.130-III
M16	2	Set	80	32	12	12	9	4	14.00	920.130-S
M18	2.5	I	95	34	14	14	11	4	15.50	920.135-I
M18	2.5	II	95	34	14	14	11	4	15.50	920.135-II
M18	2.5	III	95	34	14	14	11	4	15.50	920.135-III
M18	2.5	Set	95	34	14	14	11	4	15.50	920.135-S

● Technical details



d_1	P	Type	l_1	l_2	d_2	l	a	Z	$\varnothing$ mm	Order code
M20	2.5	I	95	34	16	15	12	4	17.50	920.140-I
M20	2.5	II	95	34	16	15	12	4	17.50	920.140-II
M20	2.5	III	95	34	16	15	12	4	17.50	920.140-III
M20	2.5	Set	95	34	16	15	12	4	17.50	920.140-S

HAND TAPS

For Stainless Steels < 1'200 N/mm²

● I



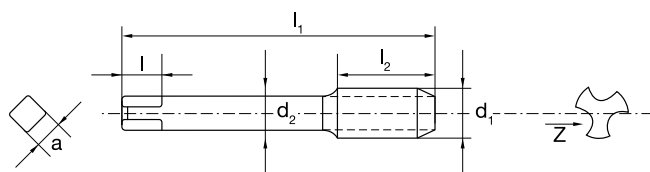
● II



● III

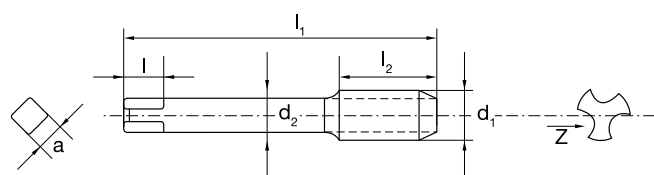


● Technical details



d ₁	P	Type	l ₁	l ₂	d ₂	l	a	Z	Ø mm	Order code
M2	0.4	I	36	8	2.8	5	2.1	3	1.60	925.040-I
M2	0.4	Set	36	8	2.8	5	2.1	3	1.60	925.040-S
M2.2	0.45	I	36	9	2.8	5	2.1	3	1.75	925.045-I
M2.2	0.45	Set	36	9	2.8	5	2.1	3	1.75	925.045-S
M2.3	0.4	I	36	9	2.8	5	2.1	3	1.90	925.050-I
M2.3	0.4	Set	36	9	2.8	5	2.1	3	1.90	925.050-S
M2.5	0.45	I	40	9	2.8	5	2.1	3	2.05	925.055-I
M2.5	0.45	Set	40	9	2.8	5	2.1	3	2.05	925.055-S
M2.6	0.45	I	40	9	2.8	5	2.1	3	2.15	925.060-I
M2.6	0.45	Set	40	9	2.8	5	2.1	3	2.15	925.060-S
M3	0.5	I	40	11	3.5	6	2.7	3	2.50	925.065-I
M3	0.5	Set	40	11	3.5	6	2.7	3	2.50	925.065-S
M3.5	0.6	I	45	12	4	6	3	3	2.90	925.070-I
M3.5	0.6	Set	45	12	4	6	3	3	2.90	925.070-S
M4	0.7	I	45	13	4.5	6	3.4	3	3.30	925.075-I
M4	0.7	Set	45	13	4.5	6	3.4	3	3.30	925.075-S
M5	0.8	I	50	16	6	8	4.9	3	4.20	925.085-I
M5	0.8	Set	50	16	6	8	4.9	3	4.20	925.085-S
M6	1	I	56	19	6	8	4.9	3	5.00	925.090-I
M6	1	Set	56	19	6	8	4.9	3	5.00	925.090-S
M8	1.25	I	63	22	6	8	4.9	4	6.80	925.100-I
M8	1.25	Set	63	22	6	8	4.9	4	6.80	925.100-S
M10	1.5	I	70	24	7	8	5.5	4	8.50	925.110-I
M10	1.5	Set	70	24	7	8	5.5	4	8.50	925.110-S

● Technical details



d_1	P	Type	l_1	l_2	d_2	l	a	Z	$\varnothing$ mm	Order code
M12	1.75	I	75	28	9	10	7	4	10.20	925.120-I
M12	1.75	Set	75	28	9	10	7	4	10.20	925.120-S
M14	2	I	80	30	11	12	9	4	12.00	925.125-I
M14	2	Set	80	30	11	12	9	4	12.00	925.125-S
M16	2	I	80	32	12	12	9	4	14.00	925.130-I
M16	2	Set	80	32	12	12	9	4	14.00	925.130-S
M18	2.5	I	95	34	14	14	11	4	15.50	925.135-I
M18	2.5	Set	95	34	14	14	11	4	15.50	925.135-S
M20	2.5	I	95	34	16	15	12	4	17.50	925.140-I
M20	2.5	Set	95	34	16	15	12	4	17.50	925.140-S

HAND TAPS

For General Use Cast Iron, Aluminium, Aluminium Die Cast, Steels and Stainless Steels < 1'200 N/mm²

● I



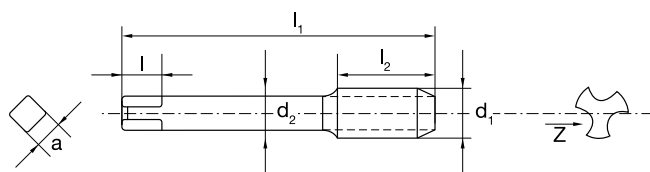
● II



● III

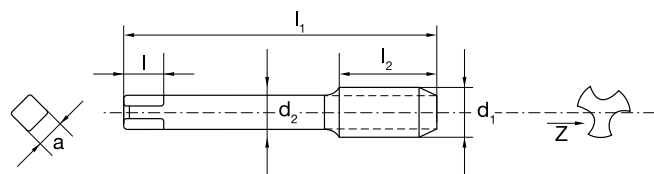


● Technical details



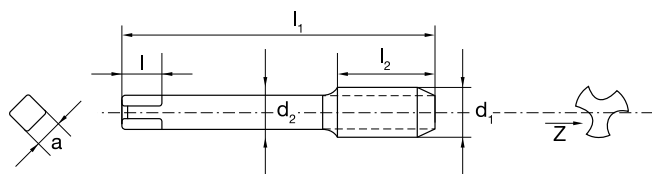
d ₁	P	Type	l ₁	l ₂	d ₂	l	a	Z	Ø mm	Order code
M1	0.25	I	32	5.5	2.5	5	2.1	3	0.75	910.005-I
M1	0.25	II	32	5.5	2.5	5	2.1	3	0.75	910.005-II
M1	0.25	III	32	5.5	2.5	5	2.1	3	0.75	910.005-III
M1	0.25	Set	32	5.5	2.5	5	2.1	3	0.75	910.005-S
M1.1	0.25	I	32	5.5	2.5	5	2.1	3	0.85	910.010-I
M1.1	0.25	II	32	5.5	2.5	5	2.1	3	0.85	910.010-II
M1.1	0.25	III	32	5.5	2.5	5	2.1	3	0.85	910.010-III
M1.1	0.25	Set	32	5.5	2.5	5	2.1	3	0.85	910.010-S
M1.2	0.25	I	32	5.5	2.5	5	2.1	3	0.95	910.015-I
M1.2	0.25	II	32	5.5	2.5	5	2.1	3	0.95	910.015-II
M1.2	0.25	III	32	5.5	2.5	5	2.1	3	0.95	910.015-III
M1.2	0.25	Set	32	5.5	2.5	5	2.1	3	0.95	910.015-S
M1.4	0.3	I	32	7	2.5	5	2.1	3	1.10	910.020-I
M1.4	0.3	II	32	7	2.5	5	2.1	3	1.10	910.020-II
M1.4	0.3	III	32	7	2.5	5	2.1	3	1.10	910.020-III
M1.4	0.3	Set	32	7	2.5	5	2.1	3	1.10	910.020-S
M1.6	0.35	I	32	8	2.5	5	2.1	3	1.25	910.025-I
M1.6	0.35	II	32	8	2.5	5	2.1	3	1.25	910.025-II
M1.6	0.35	III	32	8	2.5	5	2.1	3	1.25	910.025-III
M1.6	0.35	Set	32	8	2.5	5	2.1	3	1.25	910.025-S
M1.7	0.35	I	32	8	2.5	5	2.1	3	1.35	910.030-I
M1.7	0.35	II	32	8	2.5	5	2.1	3	1.35	910.030-II
M1.7	0.35	III	32	8	2.5	5	2.1	3	1.35	910.030-III
M1.7	0.35	Set	32	8	2.5	5	2.1	3	1.35	910.030-S

● Technical details



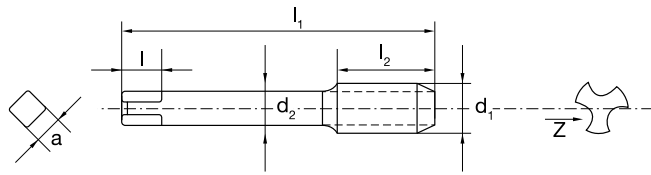
d ₁	P	Type	l ₁	l ₂	d ₂	l	a	Z	Ø mm	Order code
M1.8	0.35	I	32	8	2.5	5	2.1	3	1.45	910.035-I
M1.8	0.35	II	32	8	2.5	5	2.1	3	1.45	910.035-II
M1.8	0.35	III	32	8	2.5	5	2.1	3	1.45	910.035-III
M1.8	0.35	Set	32	8	2.5	5	2.1	3	1.45	910.035-S
M2	0.4	I	36	8	2.8	5	2.1	3	1.60	910.040-I
M2	0.4	II	36	8	2.8	5	2.1	3	1.60	910.040-II
M2	0.4	III	36	8	2.8	5	2.1	3	1.60	910.040-III
M2	0.4	Set	36	8	2.8	5	2.1	3	1.60	910.040-S
M2.2	0.45	I	36	9	2.8	5	2.1	3	1.75	910.045-I
M2.2	0.45	II	36	9	2.8	5	2.1	3	1.75	910.045-II
M2.2	0.45	III	36	9	2.8	5	2.1	3	1.75	910.045-III
M2.2	0.45	Set	36	9	2.8	5	2.1	3	1.75	910.045-S
M2.3	0.4	I	36	9	2.8	5	2.1	3	1.90	910.050-I
M2.3	0.4	II	36	9	2.8	5	2.1	3	1.90	910.050-II
M2.3	0.4	III	36	9	2.8	5	2.1	3	1.90	910.050-III
M2.3	0.4	Set	36	9	2.8	5	2.1	3	1.90	910.050-S
M2.5	0.45	I	40	9	2.8	5	2.1	3	2.05	910.055-I
M2.5	0.45	II	40	9	2.8	5	2.1	3	2.05	910.055-II
M2.5	0.45	III	40	9	2.8	5	2.1	3	2.05	910.055-III
M2.5	0.45	Set	40	9	2.8	5	2.1	3	2.05	910.055-S
M2.6	0.45	I	40	9	2.8	5	2.1	3	2.15	910.060-I
M2.6	0.45	II	40	9	2.8	5	2.1	3	2.15	910.060-II
M2.6	0.45	III	40	9	2.8	5	2.1	3	2.15	910.060-III
M2.6	0.45	Set	40	9	2.8	5	2.1	3	2.15	910.060-S
M3	0.5	I	40	11	3.5	6	2.7	3	2.50	910.065-I
M3	0.5	II	40	11	3.5	6	2.7	3	2.50	910.065-II
M3	0.5	III	40	11	3.5	6	2.7	3	2.50	910.065-III
M3	0.5	Set	40	11	3.5	6	2.7	3	2.50	910.065-S
M3.5	0.6	I	45	12	4	6	3	3	2.90	910.070-I
M3.5	0.6	II	45	12	4	6	3	3	2.90	910.070-II
M3.5	0.6	III	45	12	4	6	3	3	2.90	910.070-III
M3.5	0.6	Set	45	12	4	6	3	3	2.90	910.070-S
M4	0.7	I	45	13	4.5	6	3.4	3	3.30	910.075-I
M4	0.7	II	45	13	4.5	6	3.4	3	3.30	910.075-II
M4	0.7	III	45	13	4.5	6	3.4	3	3.30	910.075-III
M4	0.7	Set	45	13	4.5	6	3.4	3	3.30	910.075-S
M4.5	0.75	I	50	16	6	8	4.9	3	3.70	910.080-I
M4.5	0.75	II	50	16	6	8	4.9	3	3.70	910.080-II
M4.5	0.75	III	50	16	6	8	4.9	3	3.70	910.080-III
M4.5	0.75	Set	50	16	6	8	4.9	3	3.70	910.080-S

● Technical details



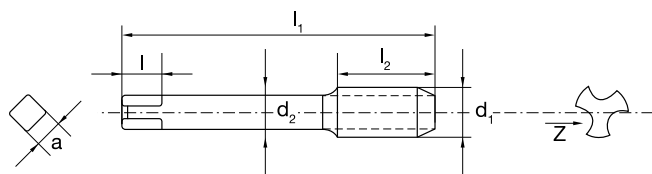
d ₁	P	Type	l ₁	l ₂	d ₂	l	a	Z	Ø mm	Order code
M5	0.8	I	50	16	6	8	4.9	3	4.20	910.085-I
M5	0.8	II	50	16	6	8	4.9	3	4.20	910.085-II
M5	0.8	III	50	16	6	8	4.9	3	4.20	910.085-III
M5	0.8	Set	50	16	6	8	4.9	3	4.20	910.085-S
M6	1	I	56	19	6	8	4.9	3	5.00	910.090-I
M6	1	II	56	19	6	8	4.9	3	5.00	910.090-II
M6	1	III	56	19	6	8	4.9	3	5.00	910.090-III
M6	1	Set	56	19	6	8	4.9	3	5.00	910.090-S
M7	1	I	56	19	6	8	4.9	4	6.00	910.095-I
M7	1	II	56	19	6	8	4.9	4	6.00	910.095-II
M7	1	III	56	19	6	8	4.9	4	6.00	910.095-III
M7	1	Set	56	19	6	8	4.9	4	6.00	910.095-S
M8	1.25	I	63	22	6	8	4.9	4	6.80	910.100-I
M8	1.25	II	63	22	6	8	4.9	4	6.80	910.100-II
M8	1.25	III	63	22	6	8	4.9	4	6.80	910.100-III
M8	1.25	Set	63	22	6	8	4.9	4	6.80	910.100-S
M9	1.25	I	63	22	7	8	5.5	4	7.80	910.105-I
M9	1.25	II	63	22	7	8	5.5	4	7.80	910.105-II
M9	1.25	III	63	22	7	8	5.5	4	7.80	910.105-III
M9	1.25	Set	63	22	7	8	5.5	4	7.80	910.105-S
M10	1.5	I	70	24	7	8	5.5	4	8.50	910.110-I
M10	1.5	II	70	24	7	8	5.5	4	8.50	910.110-II
M10	1.5	III	70	24	7	8	5.5	4	8.50	910.110-III
M10	1.5	Set	70	24	7	8	5.5	4	8.50	910.110-S
M11	1.5	I	70	24	8	9	6.2	4	9.50	910.115-I
M11	1.5	II	70	24	8	9	6.2	4	9.50	910.115-II
M11	1.5	III	70	24	8	9	6.2	4	9.50	910.115-III
M11	1.5	Set	70	24	8	9	6.2	4	9.50	910.115-S
M12	1.75	I	75	28	9	10	7	4	10.20	910.120-I
M12	1.75	II	75	28	9	10	7	4	10.20	910.120-II
M12	1.75	III	75	28	9	10	7	4	10.20	910.120-III
M12	1.75	Set	75	28	9	10	7	4	10.20	910.120-S
M14	2	I	80	30	11	12	9	4	12.00	910.125-I
M14	2	II	80	30	11	12	9	4	12.00	910.125-II
M14	2	III	80	30	11	12	9	4	12.00	910.125-III
M14	2	Set	80	30	11	12	9	4	12.00	910.125-S

● Technical details



d ₁	P	Type	l ₁	l ₂	d ₂	l	a	Z	Ø mm	Order code
M16	2	I	80	32	12	12	9	4	14.00	910.130-I
M16	2	II	80	32	12	12	9	4	14.00	910.130-II
M16	2	III	80	32	12	12	9	4	14.00	910.130-III
M16	2	Set	80	32	12	12	9	4	14.00	910.130-S
M18	2.5	I	95	34	14	14	11	4	15.50	910.135-I
M18	2.5	II	95	34	14	14	11	4	15.50	910.135-II
M18	2.5	III	95	34	14	14	11	4	15.50	910.135-III
M18	2.5	Set	95	34	14	14	11	4	15.50	910.135-S
M20	2.5	I	95	34	16	15	12	4	17.50	910.140-I
M20	2.5	II	95	34	16	15	12	4	17.50	910.140-II
M20	2.5	III	95	34	16	15	12	4	17.50	910.140-III
M20	2.5	Set	95	34	16	15	12	4	17.50	910.140-S
M22	2.5	I	100	34	18	17	14.5	4	19.50	910.145-I
M22	2.5	II	100	34	18	17	14.5	4	19.50	910.145-II
M22	2.5	III	100	34	18	17	14.5	4	19.50	910.145-III
M22	2.5	Set	100	34	18	17	14.5	4	19.50	910.145-S
M24	3	I	110	38	18	17	14.5	4	21.00	910.150-I
M24	3	II	110	38	18	17	14.5	4	21.00	910.150-II
M24	3	III	110	38	18	17	14.5	4	21.00	910.150-III
M24	3	Set	110	38	18	17	14.5	4	21.00	910.150-S
M27	3	I	110	38	20	19	16	4	24.00	910.155-I
M27	3	II	110	38	20	19	16	4	24.00	910.155-II
M27	3	III	110	38	20	19	16	4	24.00	910.155-III
M27	3	Set	110	38	20	19	16	4	24.00	910.155-S
M30	3.5	I	125	45	22	21	18	4	26.50	910.160-I
M30	3.5	II	125	45	22	21	18	4	26.50	910.160-II
M30	3.5	III	125	45	22	21	18	4	26.50	910.160-III
M30	3.5	Set	125	45	22	21	18	4	26.50	910.160-S
M33	3.5	I	125	50	25	23	20	4	29.50	910.165-I
M33	3.5	II	125	50	25	23	20	4	29.50	910.165-II
M33	3.5	III	125	50	25	23	20	4	29.50	910.165-III
M33	3.5	Set	125	50	25	23	20	4	29.50	910.165-S
M36	4	I	150	56	28	25	22	4	32.00	910.170-I
M36	4	II	150	56	28	25	22	4	32.00	910.170-II
M36	4	III	150	56	28	25	22	4	32.00	910.170-III
M36	4	Set	150	56	28	25	22	4	32.00	910.170-S

● Technical details



d_1	P	Type	l_1	l_2	d_2	l	a	Z	$\varnothing$ mm	Order code
M39	4	I	150	60	32	27	24	4	35.00	910.175-I
M39	4	II	150	60	32	27	24	4	35.00	910.175-II
M39	4	III	150	60	32	27	24	4	35.00	910.175-III
M39	4	Set	150	60	32	27	24	4	35.00	910.175-S
M42	4.5	I	150	60	32	27	24	6	37.50	910.180-I
M42	4.5	II	150	60	32	27	24	6	37.50	910.180-II
M42	4.5	III	150	60	32	27	24	6	37.50	910.180-III
M42	4.5	Set	150	60	32	27	24	6	37.50	910.180-S
M45	4.5	I	160	65	36	32	29	6	40.50	910.185-I
M45	4.5	II	160	65	36	32	29	6	40.50	910.185-II
M45	4.5	III	160	65	36	32	29	6	40.50	910.185-III
M45	4.5	Set	160	65	36	32	29	6	40.50	910.185-S
M48	5	I	180	70	36	32	29	6	43.00	910.190-I
M48	5	II	180	70	36	32	29	6	43.00	910.190-II
M48	5	III	180	70	36	32	29	6	43.00	910.190-III
M48	5	Set	180	70	36	32	29	6	43.00	910.190-S
M52	5	I	180	70	40	35	32	6	47.00	910.195-I
M52	5	II	180	70	40	35	32	6	47.00	910.195-II
M52	5	III	180	70	40	35	32	6	47.00	910.195-III
M52	5	Set	180	70	40	35	32	6	47.00	910.195-S

HAND TAPS

For General Use Cast Iron, Aluminium, Aluminium Die Cast, Steels and Stainless Steels < 1'200 N/mm²

● I



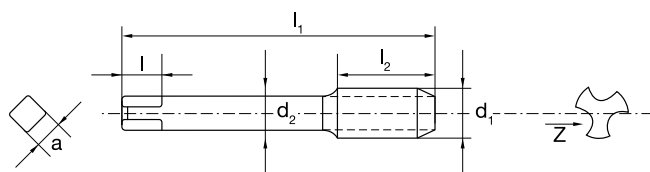
● II



● III

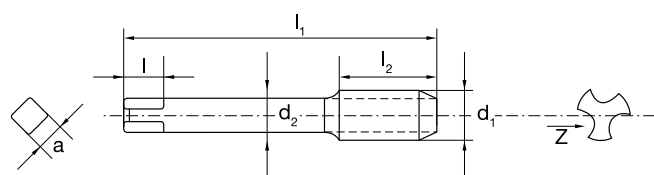


● Technical details



d ₁	P	Type	l ₁	l ₂	d ₂	l	a	Z	Ø mm	Order code
M3	0.5	I	40	11	3.5	6	2.7	3	2.50	915.065-I
M3	0.5	II	40	11	3.5	6	2.7	3	2.50	915.065-II
M3	0.5	III	40	11	3.5	6	2.7	3	2.50	915.065-III
M3	0.5	Set	40	11	3.5	6	2.7	3	2.50	915.065-S
M4	0.7	I	45	13	4.5	6	3.4	3	3.30	915.075-I
M4	0.7	II	45	13	4.5	6	3.4	3	3.30	915.075-II
M4	0.7	III	45	13	4.5	6	3.4	3	3.30	915.075-III
M4	0.7	Set	45	13	4.5	6	3.4	3	3.30	915.075-S
M5	0.8	I	50	16	6	8	4.9	3	4.20	915.085-I
M5	0.8	II	50	16	6	8	4.9	3	4.20	915.085-II
M5	0.8	III	50	16	6	8	4.9	3	4.20	915.085-III
M5	0.8	Set	50	16	6	8	4.9	3	4.20	915.085-S
M6	1	I	56	19	6	8	4.9	3	5.00	915.090-I
M6	1	II	56	19	6	8	4.9	3	5.00	915.090-II
M6	1	III	56	19	6	8	4.9	3	5.00	915.090-III
M6	1	Set	56	19	6	8	4.9	3	5.00	915.090-S
M8	1.25	I	63	22	6	8	4.9	4	6.80	915.100-I
M8	1.25	II	63	22	6	8	4.9	4	6.80	915.100-II
M8	1.25	III	63	22	6	8	4.9	4	6.80	915.100-III
M8	1.25	Set	63	22	6	8	4.9	4	6.80	915.100-S
M10	1.5	I	70	24	7	8	5.5	4	8.50	915.110-I
M10	1.5	II	70	24	7	8	5.5	4	8.50	915.110-II
M10	1.5	III	70	24	7	8	5.5	4	8.50	915.110-III
M10	1.5	Set	70	24	7	8	5.5	4	8.50	915.110-S

● Technical details



d_1	P	Type	l_1	l_2	d_2	l	a	Z	$\varnothing$ mm	Order code
M12	1.75	I	75	28	9	10	7	4	10.20	915.120-I
M12	1.75	II	75	28	9	10	7	4	10.20	915.120-II
M12	1.75	III	75	28	9	10	7	4	10.20	915.120-III
M12	1.75	Set	75	28	9	10	7	4	10.20	915.120-S
M14	2	I	80	30	11	12	9	4	12.00	915.125-I
M14	2	II	80	30	11	12	9	4	12.00	915.125-II
M14	2	III	80	30	11	12	9	4	12.00	915.125-III
M14	2	Set	80	30	11	12	9	4	12.00	915.125-S
M16	2	I	80	32	12	12	9	4	14.00	915.130-I
M16	2	II	80	32	12	12	9	4	14.00	915.130-II
M16	2	III	80	32	12	12	9	4	14.00	915.130-III
M16	2	Set	80	32	12	12	9	4	14.00	915.130-S
M18	2.5	I	95	34	14	14	11	4	15.50	915.135-I
M18	2.5	II	95	34	14	14	11	4	15.50	915.135-II
M18	2.5	III	95	34	14	14	11	4	15.50	915.135-III
M18	2.5	Set	95	34	14	14	11	4	15.50	915.135-S
M20	2.5	I	95	34	16	15	12	4	17.50	915.140-I
M20	2.5	II	95	34	16	15	12	4	17.50	915.140-II
M20	2.5	III	95	34	16	15	12	4	17.50	915.140-III
M20	2.5	Set	95	34	16	15	12	4	17.50	915.140-S
M22	2.5	I	100	34	18	17	14.5	4	19.50	915.145-I
M22	2.5	II	100	34	18	17	14.5	4	19.50	915.145-II
M22	2.5	III	100	34	18	17	14.5	4	19.50	915.145-III
M22	2.5	Set	100	34	18	17	14.5	4	19.50	915.145-S
M24	3	I	110	38	18	17	14.5	4	21.00	915.150-I
M24	3	II	110	38	18	17	14.5	4	21.00	915.150-II
M24	3	III	110	38	18	17	14.5	4	21.00	915.150-III
M24	3	Set	110	38	18	17	14.5	4	21.00	915.150-S

HAND TAPS

For General Use Cast Iron, Aluminium, Aluminium Die Cast, Steels and Stainless Steels < 1'200 N/mm²

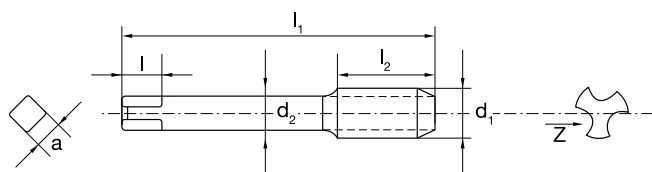
● I



● II

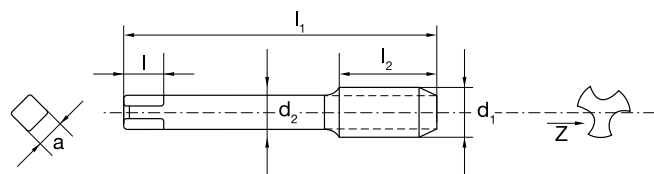


● Technical details



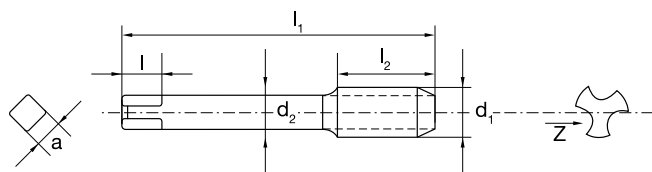
d ₁	P	Type	l ₁	l ₂	d ₂	l	a	Z	Ø mm	Order code
M2	0.25	I	36	8	2.8	5	2.1	3	1.75	930.000-I
M2	0.25	II	36	8	2.8	5	2.1	3	1.75	930.000-II
M2	0.25	Set	36	8	2.8	5	2.1	4	1.75	930.000-S
M2.2	0.25	I	36	9	2.8	5	2.1	3	1.95	930.001-I
M2.2	0.25	II	36	9	2.8	5	2.1	3	1.95	930.001-II
M2.2	0.25	Set	36	9	2.8	5	2.1	3	1.95	930.001-S
M2.3	0.25	I	36	9	2.8	5	2.1	3	2.05	930.003-I
M2.3	0.25	II	36	9	2.8	5	2.1	3	2.05	930.003-II
M2.3	0.25	Set	36	9	2.8	5	2.1	3	2.05	930.003-S
M2.5	0.35	I	40	9	2.8	5	2.1	3	2.15	930.005-I
M2.5	0.35	II	40	9	2.8	5	2.1	3	2.15	930.005-II
M2.5	0.35	Set	40	9	2.8	5	2.1	3	2.15	930.005-S
M2.6	0.35	I	40	9	2.8	5	2.1	3	2.25	930.010-I
M2.6	0.35	II	40	9	2.8	5	2.1	3	2.25	930.010-II
M2.6	0.35	Set	40	9	2.8	5	2.1	3	2.25	930.010-S
M3	0.35	I	40	8	3.5	6	2.74	3	2.65	930.015-I
M3	0.35	II	40	8	3.5	6	2.74	3	2.65	930.015-II
M3	0.35	Set	40	8	3.5	6	2.74	3	2.65	930.015-S
M3.5	0.35	I	45	9	4	6	3	3	3.15	930.020-I
M3.5	0.35	II	45	9	4	6	3	3	3.15	930.020-II
M3.5	0.35	Set	45	9	4	6	3	3	3.15	930.020-S
M4	0.35	I	45	10	4.5	6	3.4	3	3.65	930.025-I
M4	0.35	II	45	10	4.5	6	3.4	3	3.65	930.025-II
M4	0.35	Set	45	10	4.5	6	3.4	3	3.65	930.025-S

● Technical details



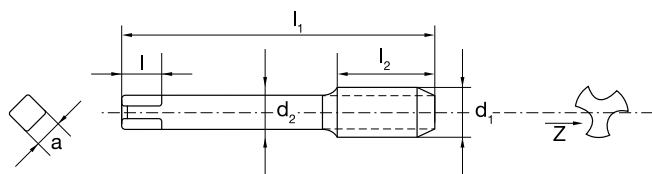
d ₁	P	Type	l ₁	l ₂	d ₂	l	a	Z	Ø mm	Order code
M4	0.5	I	45	10	4.5	6	3.4	3	3.50	930.030-I
M4	0.5	II	45	10	4.5	6	3.4	3	3.50	930.030-II
M4	0.5	Set	45	10	4.5	6	3.4	3	3.50	930.030-S
M5	0.5	I	50	12	6	8	4.9	3	4.50	930.040-I
M5	0.5	II	50	12	6	8	4.9	3	4.50	930.040-II
M5	0.5	Set	50	12	6	8	4.9	3	4.50	930.040-S
M6	0.5	I	56	14	6	8	4.9	3	5.50	930.045-I
M6	0.5	II	56	14	6	8	4.9	3	5.50	930.045-II
M6	0.5	Set	56	14	6	8	4.9	3	5.50	930.045-S
M6	0.75	I	56	14	6	8	4.9	3	5.20	930.050-I
M6	0.75	II	56	14	6	8	4.9	3	5.20	930.050-II
M6	0.75	Set	56	14	6	8	4.9	3	5.20	930.050-S
M7	0.75	I	56	14	6	8	4.9	4	6.20	930.055-I
M7	0.75	II	56	14	6	8	4.9	4	6.20	930.055-II
M7	0.75	Set	56	14	6	8	4.9	4	6.20	930.055-S
M8	0.5	I	56	18	6	8	4.9	4	7.50	930.060-I
M8	0.5	II	56	18	6	8	4.9	4	7.50	930.060-II
M8	0.5	Set	56	18	6	8	4.9	4	7.50	930.060-S
M8	0.75	I	56	18	6	8	4.9	4	7.20	930.065-I
M8	0.75	II	56	18	6	8	4.9	4	7.20	930.065-II
M8	0.75	Set	56	18	6	8	4.9	4	7.20	930.065-S
M8	1	I	63	22	6	8	4.9	4	7.00	930.070-I
M8	1	II	63	22	6	8	4.9	4	7.00	930.070-II
M8	1	Set	63	22	6	8	4.9	4	7.00	930.070-S
M9	1	I	63	22	7	8	5.5	4	8.00	930.075-I
M9	1	II	63	22	7	8	5.5	4	8.00	930.075-II
M9	1	Set	63	22	7	8	5.5	4	8.00	930.075-S
M10	0.75	I	63	20	7	8	5.5	4	9.20	930.080-I
M10	0.75	II	63	20	7	8	5.5	4	9.20	930.080-II
M10	0.75	Set	63	20	7	8	5.5	4	9.20	930.080-S
M10	1	I	63	20	7	8	5.5	4	9.00	930.085-I
M10	1	II	63	20	7	8	5.5	4	9.00	930.085-II
M10	1	Set	63	20	7	8	5.5	4	9.00	930.085-S
M10	1.25	I	70	24	7	8	5.5	4	8.80	930.090-I
M10	1.25	II	70	24	7	8	5.5	4	8.80	930.090-II
M10	1.25	Set	70	24	7	8	5.5	4	8.80	930.090-S
M11	1	I	63	20	8	9	6.2	4	10.00	930.095-I
M11	1	II	63	20	8	9	6.2	4	10.00	930.095-II
M11	1	Set	63	20	8	9	6.2	4	10.00	930.095-S
M12	1	I	70	22	9	10	7	4	11.00	930.100-I

● Technical details



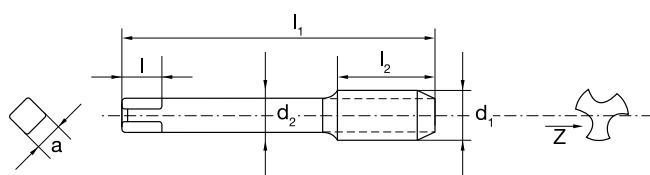
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M12	1	II	70	22	9	10	7	4	11.00	930.100-II
M12	1	Set	70	22	9	10	7	4	11.00	930.100-S
M12	1.25	I	70	22	9	10	7	4	10.80	930.105-I
M12	1.25	II	70	22	9	10	7	4	10.80	930.105-II
M12	1.25	Set	70	22	9	10	7	4	10.80	930.105-S
M12	1.5	I	70	22	9	10	7	4	10.50	930.110-I
M12	1.5	II	70	22	9	10	7	4	10.50	930.110-II
M12	1.5	Set	70	22	9	10	7	4	10.50	930.110-S
M14	1	I	70	22	11	12	9	4	13.00	930.120-I
M14	1	II	70	22	11	12	9	4	13.00	930.120-II
M14	1	Set	70	22	11	12	9	4	13.00	930.120-S
M14	1.25	I	70	22	11	12	9	4	12.80	930.125-I
M14	1.25	II	70	22	11	12	9	4	12.80	930.125-II
M14	1.25	Set	70	22	11	12	9	4	12.80	930.125-S
M14	1.5	I	70	22	11	12	9	4	12.50	930.130-I
M14	1.5	II	70	22	11	12	9	4	12.50	930.130-II
M14	1.5	Set	70	22	11	12	9	4	12.50	930.130-S
M15	1	I	80	22	12	12	9	4	14.00	930.135-I
M15	1	II	80	22	12	12	9	4	14.00	930.135-II
M15	1	Set	80	22	12	12	9	4	14.00	930.135-S
M15	1.5	I	80	22	12	12	9	4	13.50	930.140-I
M15	1.5	II	80	22	12	12	9	4	13.50	930.140-II
M15	1.5	Set	80	22	12	12	9	4	13.50	930.140-S
M16	1	I	80	22	12	12	9	4	15.00	930.145-I
M16	1	II	80	22	12	12	9	4	15.00	930.145-II
M16	1	Set	80	22	12	12	9	4	15.00	930.145-S
M16	1.5	I	80	22	12	12	9	4	14.50	930.150-I
M16	1.5	II	80	22	12	12	9	4	14.50	930.150-II
M16	1.5	Set	80	22	12	12	9	4	14.50	930.150-S
M18	1	I	80	22	14	14	11	4	17.00	930.155-I
M18	1	II	80	22	14	14	11	4	17.00	930.155-II
M18	1	Set	80	22	14	14	11	4	17.00	930.155-S
M18	1.5	I	80	22	14	14	11	4	16.50	930.160-I
M18	1.5	II	80	22	14	14	11	4	16.50	930.160-II
M18	1.5	Set	80	22	14	14	11	4	16.50	930.160-S
M18	2	I	80	22	14	14	11	4	16.00	930.165-I

● Technical details



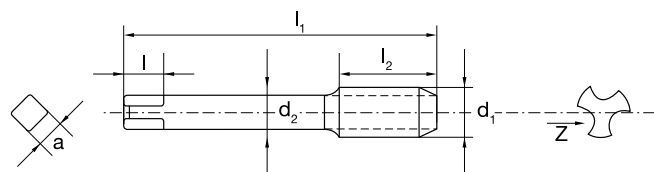
d_1	P	Type	l_1	l_2	d_2	l	α	Z	$\varnothing$ mm	Order code
M18	2	II	80	22	14	14	11	4	16.00	930.165-II
M18	2	Set	80	22	14	14	11	4	16.00	930.165-S
M20	1	I	80	22	16	15	12	4	19.00	930.170-I
M20	1	II	80	22	16	15	12	4	19.00	930.170-II
M20	1	Set	80	22	16	15	12	4	19.00	930.170-S
M20	1.5	I	80	22	16	15	12	4	18.50	930.175-I
M20	1.5	II	80	22	16	15	12	4	18.50	930.175-II
M20	1.5	Set	80	22	16	15	12	4	18.50	930.175-S
M20	2	I	80	22	16	15	12	4	18.00	930.180-I
M20	2	II	80	22	16	15	12	4	18.00	930.180-II
M20	2	Set	80	22	16	15	12	4	18.00	930.180-S
M22	1	I	80	22	18	17	14.5	4	21.00	930.185-I
M22	1	II	80	22	18	17	14.5	4	21.00	930.185-II
M22	1	Set	80	22	17	17	14.5	4	21.00	930.185-S
M22	1.5	I	80	22	18	17	14.5	4	20.50	930.190-I
M22	1.5	II	80	22	18	17	14.5	4	20.50	930.190-II
M22	1.5	Set	80	22	18	17	14.5	4	20.50	930.190-S
M22	2	I	80	22	18	17	14.5	4	20.00	930.195-I
M22	2	II	80	22	18	17	14.5	4	20.00	930.195-II
M22	2	Set	80	22	18	17	14.5	4	20.00	930.195-S
M24	1	I	90	22	18	17	14.5	4	23.00	930.200-I
M24	1	II	90	22	18	17	14.5	4	23.00	930.200-II
M24	1	Set	90	22	18	17	14.5	4	23.00	930.200-S
M24	1.5	I	90	22	18	17	14.5	4	22.50	930.205-I
M24	1.5	II	90	22	18	17	14.5	4	22.50	930.205-II
M24	1.5	Set	90	22	18	17	14.5	4	22.50	930.205-S
M24	2	I	90	22	18	17	14.5	4	22.00	930.210-I
M24	2	II	90	22	18	17	14.5	4	22.00	930.210-II
M24	2	Set	90	22	18	17	14.5	4	22.00	930.210-S
M25	1.5	I	90	22	18	17	14.5	4	23.50	930.215-I
M25	1.5	II	90	22		17	14.5	4	23.50	930.215-II
M25	1.5	Set	90	22		17	14.5	4	23.50	930.215-S
M26	1.5	I	90	22	18	17	14.5	4	24.50	930.220-I
M26	1.5	II	90	22	18	17	14.5	4	24.50	930.220-II
M26	1.5	Set	90	22	18	17	14.5	4	24.50	930.220-S
M27	1.5	I	90	22	20	19	16	4	25.50	930.225-I

● Technical details



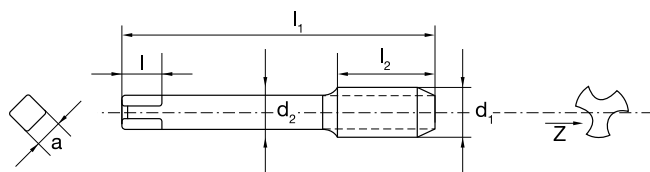
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M27	1.5	II	90	22	20	19	16	4	25.50	930.225-II
M27	1.5	Set	90	22	20	19	16	4	25.50	930.225-S
M27	2	I	90	22	20	19	16	4	25.00	930.230-I
M27	2	II	90	22	20	19	16	4	25.00	930.230-II
M27	2	Set	90	22	20	19	16	4	25.00	930.230-S
M28	1.5	I	90	22	20	19	16	4	26.50	930.235-I
M28	1.5	II	90	22	20	19	16	4	26.50	930.235-II
M28	1.5	Set	90	22	20	19	16	4	26.50	930.235-S
M30	1	I	90	22	22	21	18	4	29.00	930.240-I
M30	1	II	90	22	22	21	18	4	29.00	930.240-II
M30	1	Set	90	22	22	21	18	4	29.00	930.240-S
M30	1.5	I	90	22	22	21	18	4	28.50	930.245-I
M30	1.5	II	90	22	22	21	18	4	28.50	930.245-II
M30	1.5	Set	90	22	22	21	18	4	28.50	930.245-S
M30	2	I	90	22	22	21	18	4	28.00	930.250-I
M30	2	II	90	22	22	21	18	4	28.00	930.250-II
M30	2	Set	90	22	22	21	18	4	28.00	930.250-S
M32	1.5	I	90	22	22	21	18	4	30.50	930.255-I
M32	1.5	II	90	22	22	21	18	4	30.50	930.255-II
M32	1.5	Set	90	22	22	21	18	4	30.50	930.255-S
M33	1.5	I	100	25	25	23	20	4	31.50	930.260-I
M33	1.5	II	100	25	25	23	20	4	31.50	930.260-II
M33	1.5	Set	100	25	25	23	20	4	31.50	930.260-S
M33	2	I	100	25	25	23	20	4	31.00	930.265-I
M33	2	II	100	25	25	23	20	4	31.00	930.265-II
M33	2	Set	100	25	25	23	20	4	31.00	930.265-S
M34	1.5	I	100	25	28	25	22	4	32.50	930.270-I
M34	1.5	II	100	25		25	22	4	32.50	930.270-II
M34	1.5	Set	100	25		25	22	4	32.50	930.270-S
M35	1.5	I	100	25	28	25	22	4	33.50	930.275-I
M35	1.5	II	100	25		25	22	4	33.50	930.275-II
M35	1.5	Set	100	25		25	22	4	33.50	930.275-S
M36	1.5	I	100	25	28	25	22	4	34.50	930.280-I
M36	1.5	II	100	25	28	25	22	4	34.50	930.280-II
M36	1.5	Set	100	25	28	25	22	4	34.50	930.280-S
M36	2	I	125	40	28	25	22	4	34.00	930.285-I

● Technical details



d ₁	P	Type	l ₁	l ₂	d ₂	l	a	Z	Ø mm	Order code
M36	2	II	125	40	28	25	22	4	34.00	930.285-II
M36	2	Set	125	40	28	25	22	4	34.00	930.285-S
M36	3	I	125	40	28	25	22	4	33.00	930.290-I
M36	3	II	125	40	28	25	22	4	33.00	930.290-II
M36	3	Set	125	40	28	25	22	4	33.00	930.290-S
M38	1.5	I	100	25	28	25	22	4	36.50	930.295-I
M38	1.5	II	100	25	28	25	22	4	36.50	930.295-II
M38	1.5	Set	100	25	28	25	22	4	36.50	930.295-S
M39	2	I	125	40	32	27	24	4	37.00	930.300-I
M39	2	II	125	40	32	27	24	4	37.00	930.300-II
M39	2	Set	125	40	32	27	24	4	37.00	930.300-S
M39	3	I	125	40	32	27	24	4	36.00	930.305-I
M39	3	II	125	40	32	27	24	4	36.00	930.305-II
M39	3	Set	125	40	32	27	24	4	36.00	930.305-S
M40	1.5	I	110	25	32	27	24	4	38.50	930.310-I
M40	1.5	II	110	25	32	27	24	4	38.50	930.310-II
M40	1.5	Set	110	25	32	27	24	4	38.50	930.310-S
M40	2	I	125	40	32	27	24	4	38.00	930.315-I
M40	2	II	125	40	32	27	24	4	38.00	930.315-II
M40	2	Set	125	40	32	27	24	4	38.00	930.315-S
M40	3	I	125	40	32	27	24	4	37.00	930.320-I
M40	3	II	125	40	32	27	24	4	37.00	930.320-II
M40	3	Set	125	40	32	27	24	4	37.00	930.320-S
M42	1.5	I	110	25	32	27	24	6	40.50	930.325-I
M42	1.5	II	110	25	32	27	24	6	40.50	930.325-II
M42	1.5	Set	110	25	32	27	24	6	40.50	930.325-S
M42	2	I	125	40	32	27	24	6	40.00	930.330-I
M42	2	II	125	40	32	27	24	6	40.00	930.330-II
M42	2	Set	125	40	32	27	24	6	40.00	930.330-S
M42	3	I	125	40	32	27	24	6	39.00	930.335-I
M42	3	II	125	40	32	27	24	6	39.00	930.335-II
M42	3	Set	125	40	32	27	24	6	39.00	930.335-S
M45	1.5	I	110	25	36	32	29	6	43.50	930.340-I
M45	1.5	II	110	25		32	29	6	43.50	930.340-II
M45	1.5	Set	110	25		32	29	6	43.50	930.340-S
M45	2	I	125	40	6	32	29	6	43.00	930.345-I

● Technical details



d ₁	P	Type	l ₁	l ₂	d ₂	l	a	Z	Ø mm	Order code
M45	2	II	125	40	6	32	29	6	43.00	930.345-II
M45	2	Set	125	40	6	32	29	6	43.00	930.345-S
M45	3	I	125	40	36	32	29	6	42.00	930.350-I
M45	3	II	125	40		32	29	6	42.00	930.350-II
M45	3	Set	125	40		32	29	6	42.00	930.350-S
M48	1.5	I	140	40	36	32	29	6	46.50	930.355-I
M48	1.5	II	140	40		32	29	6	46.50	930.355-II
M48	1.5	Set	140	40		32	29	6	46.50	930.355-S
M48	2	I	140	40	36	32	29	6	45.00	930.360-I
M48	2	II	140	40		32	29	6	45.00	930.360-II
M48	2	Set	140	40		32	29	6	45.00	930.360-S
M48	3	I	140	40	36	32	29	6	45.00	930.365-I
M48	3	II	140	40		32	29	6	45.00	930.365-II
M48	3	Set	140	40		32	29	6	45.00	930.365-S
M50	1.5	I	140	40	36	32	29	6	48.50	930.370-I
M50	1.5	II	140	40	36	32	29	6	48.50	930.370-II
M50	1.5	Set	140	40	36	32	29	6	48.50	930.370-S
M50	2	I	140	40	36	32	29	6	48	930.375-I
M50	2	II	140	40	36	32	29	6	48	930.375-II
M50	2	Set	140	40	36	32	29	6	48	930.375-S
M50	3	I	140	40	36	32	29	6	47	930.380-I
M50	3	II	140	40	36	32	29	6	47	930.380-II
M50	3	Set	140	40	36	32	29	6	47	930.380-S
M52	1.5	I	140	40	40	35	32	6	50.50	930.385-I
M52	1.5	II	140	40	40	35	32	6	50.50	930.385-II
M52	1.5	Set	140	40	40	35	32	6	50.50	930.385-S
M52	2	I	140	40	40	35	32	6	50	930.390-I
M52	2	II	140	40	40	35	32	6	50	930.390-II
M52	2	Set	140	40	40	35	32	6	50	930.390-S
M52	3	I	140	40	40	35	32	6	49	930.395-I
M52	3	II	140	40	40	35	32	6	49	930.395-II
M52	3	Set	140	40	40	35	32	6	49	930.395-S

HAND TAPS

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● I



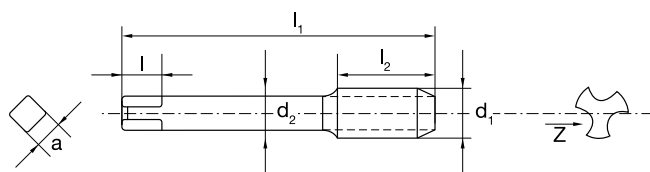
● II



● II

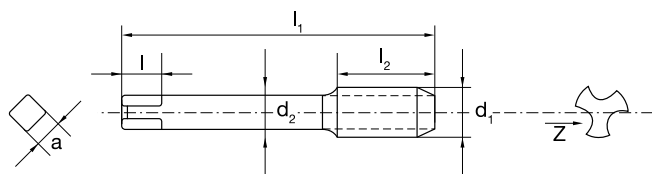


● Technical details



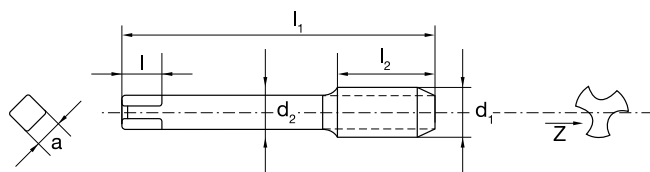
d ₁	TPI	Type	l ₁	l ₂	d ₂	l	a	Z	Ø mm	Order code
No.1	64	I	36	8	2.8	5	2.1	3	1.55	940.005-I
No.1	64	II	36	8	2.8	5	2.1	3	1.55	940.005-II
No.1	64	III	36	8	2.8	5	2.1	3	1.55	940.005-III
No.1	64	Set	36	8	2.8	5	2.1	3	1.55	940.005-S
No.2	56	I	36	9	2.8	5	2.1	3	1.85	940.010-I
No.2	56	II	36	9	2.8	5	2.1	3	1.85	940.010-II
No.2	56	III	36	9	2.8	5	2.1	3	1.85	940.010-III
No.2	56	Set	36	9	2.8	5	2.1	3	1.85	940.010-S
No.3	48	I	40	9		5	2.1	3	2.10	940.015-I
No.3	48	II	40	9		5	2.1	3	2.10	940.015-II
No.3	48	III	40	9		5	2.1	3	2.10	940.015-III
No.3	48	Set	40	9		5	2.1	3	2.10	940.015-S
No.4	40	I	40	11	3.5	6	2.7	3	2.35	940.020-I
No.4	40	II	40	11	3.5	6	2.7	3	2.35	940.020-II
No.4	40	III	40	11	3.5	6	2.7	3	2.35	940.020-III
No.4	40	Set	40	11	3.5	6	2.7	3	2.35	940.020-S
No.5	40	I	40	11	3.5	6	2.7	3	2.65	940.025-I
No.5	40	II	40	11	3.5	6	2.7	3	2.65	940.025-II
No.5	40	III	40	11	3.5	6	2.7	3	2.65	940.025-III
No.5	40	Set	40	11	3.5	6	2.7	3	2.65	940.025-S
No.6	32	I	45	12	4	6	3	3	2.85	940.030-I
No.6	32	II	45	12	4	6	3	3	2.85	940.030-II
No.6	32	III	45	12	4	6	3	3	2.85	940.030-III
No.6	32	Set	45	12	4	6	3	3	2.85	940.030-S

● Technical details



d_1	TPI	Type	l_1	l_2	d_2	l	α	Z	$\varnothing$ mm	Order code
No.8	32	I	45	13	4.5	6	3.4	3	3.50	940.035-I
No.8	32	II	45	13	4.5	6	3.4	3	3.50	940.035-II
No.8	32	III	45	13	4.5	6	3.4	3	3.50	940.035-III
No.8	32	Set	45	13	4.5	6	3.4	3	3.50	940.035-S
No.10	24	I	50	16	6	7	4.9	3	3.90	940.040-I
No.10	24	II	50	16	6	7	4.9	3	3.90	940.040-II
No.10	24	III	50	16	6	7	4.9	3	3.90	940.040-III
No.10	24	Set	50	16	6	7	4.9	3	3.90	940.040-S
No.12	24	I	50	16	6	8	4.9	3	4.50	940.045-I
No.12	24	II	50	16	6	8	4.9	3	4.50	940.045-II
No.12	24	III	50	16	6	8	4.9	3	4.50	940.045-III
No.12	24	Set	50	16	6	8	4.9	3	4.50	940.045-S
1/4	20	I	56	19	6	8	4.9	3	5.10	940.050-I
1/4	20	II	56	19	6	8	4.9	3	5.10	940.050-II
1/4	20	III	56	19	6	8	4.9	3	5.10	940.050-III
1/4	20	Set	56	19	6	8	4.9	3	5.10	940.050-S
5/16	18	I	63	22	6	8	4.9	4	6.60	940.055-I
5/16	18	II	63	22	6	8	4.9	4	6.60	940.055-II
5/16	18	III	63	22	6	8	4.9	4	6.60	940.055-III
5/16	18	Set	63	22	6	8	4.9	4	6.60	940.055-S
3/8	16	I	63	22	7	8	5.5	4	8.00	940.060-I
3/8	16	II	63	22	7	8	5.5	4	8.00	940.060-II
3/8	16	III	63	22	7	8	5.5	4	8.00	940.060-III
3/8	16	Set	63	22	7	8	5.5	4	8.00	940.060-S
7/16	14	I	70	24	8	9	6.2	4	9.40	940.065-I
7/16	14	II	70	24	8	9	6.2	4	9.40	940.065-II
7/16	14	III	70	24	8	9	6.2	4	9.40	940.065-III
7/16	14	Set	70	24	8	9	6.2	4	9.40	940.065-S
1/2	13	I	75	28	9	10	7	4	10.80	940.070-I
1/2	13	II	75	28	9	10	7	4	10.80	940.070-II
1/2	13	III	75	28	9	10	7	4	10.80	940.070-III
1/2	13	Set	75	28	9	10	7	4	10.80	940.070-S
9/16	12	I	80	30	11	12	9	4	12.20	940.075-I
9/16	12	II	80	30	11	12	9	4	12.20	940.075-II
9/16	12	III	80	30	11	12	9	4	12.20	940.075-III
9/16	12	Set	80	30	11	12	9	4	12.20	940.075-S
5/8	11	I	80	32	12	12	9	4	13.50	940.080-I
5/8	11	II	80	32	12	12	9	4	13.50	940.080-II
5/8	11	III	80	32	12	12	9	4	13.50	940.080-III
5/8	11	Set	80	32	12	12	9	4	13.50	940.080-S

● Technical details



d_1	TPI	Type	l_1	l_2	d_2	l	a	Z	$\varnothing$ mm	Order code
3/4	10	I	95	34	14	14	11	4	16.50	940.085-I
3/4	10	II	95	34	14	14	11	4	16.50	940.085-II
3/4	10	III	95	34	14	14	11	4	16.50	940.085-III
3/4	10	Set	95	34	14	14	11	4	16.50	940.085-S
7/8	9	I	100	34	18	17	14.5	4	19.50	940.090-I
7/8	9	II	100	34	18	17	14.5	4	19.50	940.090-II
7/8	9	III	100	34	18	17	14.5	4	19.50	940.090-III
7/8	9	Set	100	34	18	17	14.5	4	19.50	940.090-S
1	8	I	110	38	20	19	16	4	22.25	940.095-I
1	8	II	110	38	20	19	16	4	22.25	940.095-II
1	8	III	110	38	20	19	16	4	22.25	940.095-III
1	8	Set	110	38	20	19	16	4	22.25	940.095-S

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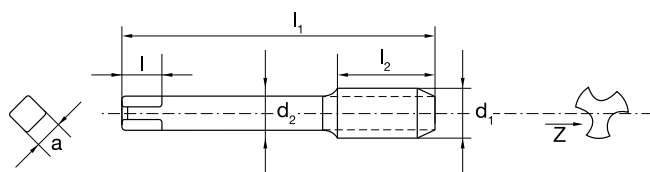
● I



● II

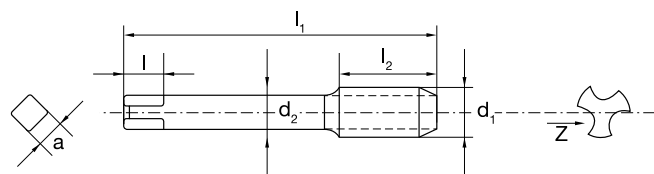


● Technical details



d ₁	TPI	Type	l ₁	l ₂	d ₂	l	a	Z	Ø mm	Order code
No.0	80	I	32	8	2.5	5	2.1	3	1.25	945.005-I
No.0	80	II	32	8	2.5	5	2.1	3	1.25	945.005-II
No.0	80	Set	32	8	2.5	5	2.1	3	1.25	945.005-S
No.1	72	I	36	8	2.8	5	2.1	3	1.55	945.010-I
No.1	72	II	36	8	2.8	5	2.1	3	1.55	945.010-II
No.1	72	Set	36	8	2.8	5	2.1	3	1.55	945.010-S
No.2	64	I	36	9	2.8	5	2.1	3	1.85	945.015-I
No.2	64	II	36	9	2.8	5	2.1	3	1.85	945.015-II
No.2	64	Set	36	9	2.8	5	2.1	3	1.85	945.015-S
No.3	56	I	40	9	2.8	5	2.1	3	2.15	945.020-I
No.3	56	II	40	9	2.8	5	2.1	3	2.15	945.020-II
No.3	56	Set	40	9	2.8	5	2.1	3	2.15	945.020-S
No.4	48	I	40	8	3.5	6	2.7	3	2.40	945.025-I
No.4	48	II	40	8	3.5	6	2.7	3	2.40	945.025-II
No.4	48	Set	40	8	3.5	6	2.7	3	2.40	945.025-S
No.5	44	I	40	8	3.5	6	2.7	3	2.70	945.030-I
No.5	44	II	40	8	3.5	6	2.7	3	2.70	945.030-II
No.5	44	Set	40	8	3.5	6	2.7	3	2.70	945.030-S
No.6	40	I	45	9	4	6	3	3	2.95	945.035-I
No.6	40	II	45	9	4	6	3	3	2.95	945.035-II
No.6	40	Set	45	9	4	6	3	3	2.95	945.035-S
No.8	36	I	45	10	4.5	6	3.4	3	3.50	945.040-I
No.8	36	II	45	10	4.5	6	3.4	3	3.50	945.040-II
No.8	36	Set	45	10	4.5	6	3.4	3	3.50	945.040-S

● Technical details



2B
B1.1

d ₁	TPI	Type	l ₁	l ₂	d ₂	l	a	Z	Ø mm	Order code
No.10	32	I	56	12	6	7	4.9	3	4.10	945.045-I
No.10	32	II	50	12	6	7	4.9	3	4.10	945.045-II
No.10	32	Set	50	12	6	7	4.9	3	4.10	945.045-S
No.12	28	I	50	12	6	8	4.9	3	4.60	945.050-I
No.12	28	II	50	12	6	8	4.9	3	4.60	945.050-II
No.12	28	Set	50	12	6	8	4.9	3	4.60	945.050-S
1/4	28	I	56	14	6	8	4.9	3	5.50	945.055-I
1/4	28	II	56	14	6	8	4.9	3	5.50	945.055-II
1/4	28	Set	56	14	6	8	4.9	3	5.50	945.055-S
5/16	24	I	63	22	6	8	4.9	4	6.90	945.060-I
5/16	24	II	63	22	6	8	4.9	4	6.90	945.060-II
5/16	24	Set	63	22	6	8	4.9	3	6.90	945.060-S
3/8	24	I	63	20	7	8	5.5	4	8.50	945.065-I
3/8	24	II	63	20	7	8	5.5	4	8.50	945.065-II
3/8	24	Set	63	20	7	8	5.5	4	8.50	945.065-S
7/16	20	I	63	20	8	9	6.2	4	9.90	945.070-I
7/16	20	II	63	20	8	9	6.2	4	9.90	945.070-II
7/16	20	Set	63	20	8	9	6.2	4	9.90	945.070-S
1/2	20	I	70	22	9	10	7	4	11.50	945.075-I
1/2	20	II	70	22	9	10	7	4	11.50	945.075-II
1/2	20	Set	70	22	9	10	7	4	11.50	945.075-S
9/16	18	I	70	22	11	12	9	4	12.90	945.080-I
9/16	18	II	70	22	11	12	9	4	12.90	945.080-II
9/16	18	Set	70	22	11	12	9	4	12.90	945.080-S
5/8	18	I	80	22	12	12	9	4	14.50	945.085-I
5/8	18	II	80	22	12	12	9	4	14.50	945.085-II
5/8	18	Set	80	22	12	12	9	4	14.50	945.085-S
3/4	16	I	80	22	14	14	11	4	17.50	945.090-I
3/4	16	II	80	22	14	14	11	4	17.50	945.090-II
3/4	16	Set	80	22	14	14	11	4	17.50	945.090-S
7/8	14	I	80	22	18	17	14.5	4	20.50	945.095-I
7/8	14	II	80	22	18	17	14.5	4	20.50	945.095-II
7/8	14	Set	80	22	18	17	14.5	4	20.50	945.095-S
1	12	I	90	22	20	19	16	4	23.25	945.100-I
1	12	II	90	22	20	19	16	4	23.25	945.100-II
1	12	Set	90	22	20	19	16	4	23.25	945.100-S

HAND TAPS

For General Use Cast Iron, Aluminium, Aluminium Die Cast, Steels and Stainless Steels < 1'200 N/mm²

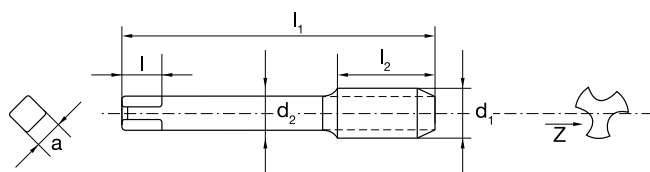
● I



● II

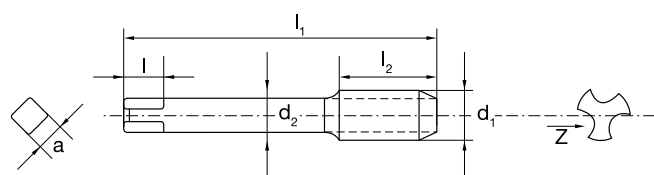


● Technical details



d ₁	TPI	Type	l ₁	l ₂	d ₂	l	a	Z	Ø mm	Order code
1/8	28	I	63	20	7	8	5.5	4	8.80	935.010-I
1/8	28	II	63	20	7	8	5.5	4	8.80	935.010-II
1/8	28	Set	63	20	7	8	5.5	4	8.80	935.010-S
1/4	19	I	70	22	11	12	9	4	11.80	935.015-I
1/4	19	II	70	22	11	12	9	4	11.80	935.015-II
1/4	19	Set	70	22	11	12	9	4	11.80	935.015-S
3/8	19	I	70	22	12	12	9	4	15.25	935.020-I
3/8	19	II	70	22	12	12	9	4	15.25	935.020-II
3/8	19	Set	70	22	12	12	9	4	15.25	935.020-S
1/2	14	I	80	22	16	15	12	4	19	935.025-I
1/2	14	II	80	22	16	15	12	4	19	935.025-II
1/2	14	Set	80	22	16	15	12	4	19	935.025-S
5/8	14	I	80	22	18	17	14.5	4	21.00	935.030-I
5/8	14	II	80	22	18	17	14.5	4	21.00	935.030-II
5/8	14	Set	80	22	18	17	14.5	4	21.00	935.030-S
3/4	14	I	90	22	20	19	16	4	24.50	935.035-I
3/4	14	II	90	22	20	19	16	4	24.50	935.035-II
3/4	14	Set	90	22	20	19	16	4	24.50	935.035-S
7/8	14	I	90	22	22	21	18	4	28.25	935.040-I
7/8	14	II	90	22	22	21	18	4	28.25	935.040-II
7/8	14	Set	90	22	22	21	18	4	28.25	935.040-S
1	11	I	100	25	25	23	20	4	30.75	935.045-I
1	11	II	100	25	25	23	20	4	30.75	935.045-II
1	11	Set	100	25	25	23	20	4	30.75	935.045-S

● Technical details



d_1	TPI	Type	l_1	l_2	d_2	l	a	Z	$\varnothing$ mm	Order code
1 1/4	11	I	125	40	32	27	24	6	39.50	935.055-I
1 1/4	11	II	125	40	32	27	24	6	39.50	935.055-II
1 1/4	11	Set	125	40	32	27	24	6	39.50	935.055-S
1 1/2	11	I	140	40	36	32	29	6	45.25	935.060-I
1 1/2	11	II	140	40	36	32	29	6	45.25	935.060-II
1 1/2	11	Set	140	40	36	32	29	6	45.25	935.060-S
1 3/4	11	I	140	40	40	35	32	6	51.00	935.065-I
1 3/4	11	II	140	40	40	35	32	6	51.00	935.065-II
1 3/4	11	Set	140	40	40	35	32	6	51.00	935.065-S
2	11	I	160	40	45	38	35	6	57.00	935.070-I
2	11	II	160	40	45	38	35	6	57.00	935.070-II
2	11	Set	160	40	45	38	35	6	57.00	935.070-S



TANOI

General Information

• TOOL SELECTION GUIDE

1 **TOOL SELECTION GUIDE** **TANOI**

2 **CUTTING TAPS**

Hole type	Threading type	Catalog number	Size range	DIN	Helix angle	Tolerance	Chamber form	Material and coating	Tap reference page
M	Standard	0.113.122	M4 - M8	DIN 371	6°	6HX	FORM C	TIN HSSE V3	XXX
		0.113.123	M4 - M10	DIN 371	0°	6HX	FORM C	TICN HSSE V3	XXX
		0.113.622	M5 - M16	DIN 376	0°	6HX	FORM C	TIN HSSE V3	72
		0.113.623	M5 - M16	DIN 376	0°	6HX	FORM C	TICN HSSE V3	73
		0.113.626	M4 - M30	DIN 376	0°	6HX	FORM C	OL HSSE V3	74
		0.113.929-ZC	M3 - M12	TANOI	0°	6HX	FORM C	TICN HSSE V3	76
		0.123.929-ZC	M3 - M12	TANOI	0°	6GX	FORM C	TICN HSSE V3	77
M	Standard	1.112.120	M3 - M10	DIN 371	ISO 2 (6H)	FORM B	HSSE V3	78	
		1.112.123	M3 - M10	DIN 371	ISO 2 (6H)	FORM B	TICN HSSE V3	79	
		1.112.620	M12 - M20	DIN 376	ISO 2 (6H)	FORM B	HSSE V3	XXX	
		1.116.120	M2 - M10	DIN 371	45°	ISO 2 (6H)	FORM C	HSSE V3	80

3 • **FOR CAST IRON AND ADC** Short chipping materials such as GG or Aluminum Die Cast

4 **Cutting Taps**

5 **FOR ALUMINIUM** Aluminums and long chipping materials

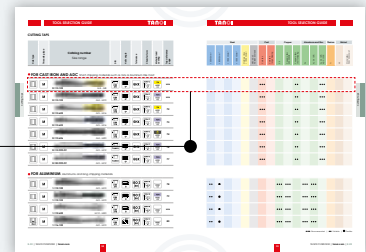
8 B-02 | TANOI OVERVIEW | tanoi.com

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LEFT PAGE:

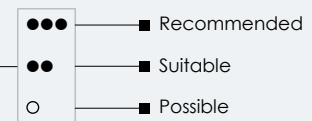
- 1 Catalog section
- 2 Tap type
- 3 Group materials reference
- 4 Main section title of the catalogue
- 5 Tool code
- 6 Diameter range
- 7 Symbols for technical details
- 8 Section and sub-section code

LAYOUT DOUBLE PAGE:



RIGHT PAGE:

- 9 Materials group
- 10 Materials group icon



• TYPES OF COSTRUCTION MATERIALS

Icon	Description	Section	
	VANADIUM HIGH SPEED STEEL: FE+C alloy added with Chromium Molybdenum, Vanadium, Tugsten and Cobalt content usually 5%. High speed steels are high alloyed steels.	A	Multifunction Taps
		B	Cutting Taps
		C	Forming Taps
		D	Hand Taps
	SOLID CARBIDE: Sintered metal carbide, a cutting material obtained by Tugsten carbide powder with the addition of Tantalum carbide, Niobio and Titanium carbide in different percentages.	A	Multifunction Taps
		B	Cutting Taps
	POWDERED HIGH SPEED STEEL: Steel obtained by powder metallurgy technology. A process similar to the production of solid carbide.	B	Cutting Taps

• TYPES OF COATING/SURFACE TREATMENT

Icon	Description	Section	
	Coating: Multi Layer Material: Vanadium High Speed Steel	C	Forming Taps
	Coating: Multi Layer Material: Powdered High Speed Steel	B	Cutting Taps
	Coating: Single-layer Titanium Nitride coating suitable for a wide range of applications in all areas of general mechanics. Material: Cobalt High Speed Steel	B	Cutting Taps
		C	Forming Taps
	Coating: Balinit Hardlube Material: Powdered High Speed Steel	B	Cutting Taps

Continue >>

• TYPES OF COATING/SURFACE TREATMENT

Icon	Description	Section	
	Nitrided + Steam-Oxide: Surface treatment that increases hardness and wear resistance, facilitates chip flow, and prevents material adhesion and tool jamming. Material: Vanadium High Speed Steel	B	Cutting Taps
	Steam Oxide: A surface treatment that reduces skid resistance, preventing sticking of the material and clamping of the tool. Material: Cobalt High Speed Steel	B	Cutting Taps
		C	Forming Taps
		D	Hand Taps
	Steam Oxide: A surface treatment that reduces skid resistance, preventing sticking of the material and clamping of the tool. Material: Powdered High Speed Steel	B	Cutting Taps
	Coating: Titanium carbonitride coating, gives greater hardness than classic TiN. Material: Micrograin Carbide	B	Cutting Taps
	Coating: Titanium carbonitride coating, gives greater hardness than classic TiN. Material: Cobalt High Speed Steel	A	Multifunction Taps
		B	Cutting Taps
		C	Forming Taps
	Coating: Titanium carbonitride coating, gives greater hardness than classic TiN. Material: Powdered High Speed Steel	B	Cutting Taps
	Coating: New generation multy layer Material: Cobalt High Speed Steel	C	Forming Taps
	Coating: New generation multy layer Material: Powdered High Speed Steel	B	Cutting Taps

• TYPES OF THREADING

Icon	Description
M	Metric Thread ISO68 / DIN13
MF	Metric Fine pitch Thread ISO68 / DIN13
M_{LH}	Metric Thread (left hand thread) DIN 13
S_{MINI}	Metric Miniature Thread ISO / DIN 1501
UNC	Unified Coarse Thread ASME / ANSI B1.1
UNF	Unified Fine Thread ASME / ANSI B1.1
G	Whitworth Pipe Thread DIN/ISO 228
NPT	National Pipe Thread Tapered ASME/ANSI B1.20.1
PG	Panzerrohr Gewinde PG According to DIN40430

• TYPES OF THREADING
"SPECIAL ESECUTION"

Icon	Description
AT	Maschio a denti alternati
BT	Maschio rastremato
FORM IT	Patented forming tap, see pages 256-257, for more information.

Continue >>

MLT

Thread tap for die-cast holes, see pages 20-21 for more information.

SL

Patented forming tap, see pages 22-23 for more information.

• TYPES OF THREADING ANGLES

Icon	Description
	55° Thread Angle (G)
	60° Thread Angle
	80° Thread Angle (PG)

• TYPES OF TOLLERANCE

Icon	Description
4HX	Tolerance 4HX
5HX	Tolerance 5HX
6HX	Tolerance 6HX
6GX	Tolerance 6GX
7G	Tolerance 7G
2B_{B1.1}	Tolerance 2B ANSI/ASME B1.1

Continue >>

ISO 228	Tolerance ISO 228
ANSI B1.1	According to ASME /ANSI B1.1 Standard
ISO 2 (6H)	Tolerance ISO 2 / 6H
ISO 3 (6G)	Tolerance ISO 3 / 6G

• TYPES OF CHAMFER

Icon	Description
	FORM A Chamfer Form A Length = 6-8 x Thread Pitch
	FORM B Chamfer Form B Length = 3.5-5.5 x Thread Pitch With Gun Nose
	FORM C Chamfer Form C Length = 2-3 x Thread Pitc
	FORM D Chamfer Form D Length = 3.5-5 x Thread Pitch
	FORM E Chamfer Form E Length = 1.5-2 x Thread Pitch

• TYPE OF FLUTES

Icon	Description
	Straight Flute with Gun Nose Form B
	Straight Flute with Gun Nose Form B - internal coolant

	Straight Flute
	Right Hand Spiral 10°
	Right Hand Spiral 15°
	Left Hand spiral 15°
	Right Hand Spiral 40°
	Left threading Left Hand spiral 40°
	Right Hand Spiral 45°
	Right Hand Spiral 50°
	Right Hand Spiral 50° internal coolant

• TYPES OF PRE HOLE

Icon	Description
	Cylindrical Through Hole
	Cylindrical Through Hole In Thin Sheet Metals
	Conical Through Hole
	Conical Blind Hole
	Cylindrical Blind Hole Deeper than 2.5 X Diameter
	Cylindrical Blind Hole Maximum Depth = 2.5 X Diameter

Continue >>

Continue >>

• TIPI DI FORO

Icon	Description
	Conical Through Hole With Thin Film Cap

• TYPES OF LUBRIFICATION

Icon	Description
	Tapping Without Cooling or Lubrification
	Tapping With Cutting Oil
	Tapping With Emulsion Favorably min. 10% Oil Content
	Minimum quantity lubrication

• TYPE OF TAPS

Icon	Description
	Cutting Taps
	Forming Tap
	(...-WF) Forming Tap with Oil Grooves (example: 3.163.323-WF)
	With newly designed oil grooves.

Continue >>

• TYPES OF SHANK

Icon	Description
	Tool shank according to DIN 352
	Tool shank according to DIN 371
	Tool shank according to DIN 374
	Tool shank according to DIN 376
	Tool shank according to DIN 2174
	Tool shank according to DIN 2181
	Tool shank according to DIN 2182
	Tool shank according to DIN 2183
	Tool shank according to DIN 2189
	Tool shank according to DIN 40432
	Tool shank according to DIN 5156
	Tool shank according to DIN 5157
	Gambo dell'utensile norme Tanoi
	Gambo dell'utensile di lunghezza doppia norme Tanoi

• TYPES OF MATERIAL

Icon	Description
	Soft Structural Steels $R_m \leq 500 \text{ N/mm}^2$
	Mild, Cast, and Carbon Steels, Alloyed & Unalloyed Steels $R_m \leq 800 \text{ N/mm}^2$
	Alloyed and Heat Treats Steels $800 \text{ N/mm}^2 < R_m < 1'200 \text{ N/mm}^2$
	Tool Steels, Unalloyed, Cold Work & Heat Resistant $800 \text{ N/mm}^2 < R_m < 1'300 \text{ N/mm}^2$
	Stainless Steels $R_m \leq 1'200 \text{ N/mm}^2$
	Hardened steels 50-63 HRC
	Copper, Copper Alloys Long Chipping $\leq 200 \text{ HB}$
	Copper Alloys 200 - 300 HB
	Copper Alloys Short Chipping

Icon	Description
	Aluminium
	Aluminium Alloys $Si < 10\%$
	Aluminium Alloys $Si > 10\%$
	Zink die Cast Aluminium die Cast
	Cast Iron, Short Chipping, Abrasive
	Cast Iron, long Chipping, Abrasive
	Titanium and Titanium alloys
	Nickel, Nickel Alloys $R_m \leq 900 \text{ N/mm}^2$
	Nickel Alloys $900 \text{ N/mm}^2 < R_m < 1'500 \text{ N/mm}^2$

Continue >>

• RESISTANCE AND HARDNESS CONVERSION

N/mm ²	Rockwell HRC	Vickers HV	Brinell HB	N/mm ²	Rockwell HRC	Vickers HV	Brinell HB
-	68	940	-	1180	38	372	353
-	67	900	-	1160	37	363	344
-	66	865	-	1115	36	354	336
-	65	832	-	1080	35	345	327
-	64	800	-	1055	34	336	319
-	63	772	-	1025	33	327	311
-	62	746	-	1000	32	318	301
-	61	720	-	980	31	310	294
-	60	697	-	950	30	302	286
-	59	674	-	930	29	294	279
-	58	653	-	910	28	286	271
-	57	633	-	880	27	279	264
-	56	613	-	860	26	272	258
2075	55	595	-	840	25	266	253
2015	54	577	-	825	24	260	247
1950	53	560	-	805	23	254	243
1880	52	544	-500	785	22	248	237
1820	51	528	-487	770	21	243	231
1760	50	513	-475	760	20	238	226
1695	49	498	-464	730	18	230	219
1635	48	484	451	705	-16	222	212
1580	47	471	442	675	-14	213	203
1530	46	458	432	650	-12	204	194
1480	45	446	421	620	-10	196	187
1435	44	434	409	600	-8	188	179
1385	43	423	400	580	-6	180	171
1340	42	412	390	550	-4	173	165
1295	41	402	381	530	-2	166	158
1250	40	392	371	515	0	160	152
1215	39	382	362				

Continue >>

• CUTTING TAPS (M)

Ø (M)	P (mm)	
M1	0.25	0.75
M1.1	0.25	0.85
M1.2	0.25	0.95
M1.4	0.30	1.10
M1.6	0.35	1.25
M1.7	0.35	1.30
M1.8	0.35	1.45
M2	0.40	1.60
M2.2	0.45	1.75
M2.3	0.40	1.90
M2.5	0.45	2.05
M2.6	0.45	2.10
M3	0.50	2.50
M3.5	0.60	2.90
M4	0.70	3.30
M4.5	0.75	3.80
M5	0.80	4.20
M6	1.00	5.00
M7	1.00	6.00
M8	1.25	6.80

Ø (M)	P (mm)	
M9	1.25	7.80
M10	1.50	8.50
M11	1.50	9.50
M12	1.75	10.20
M14	2.00	12.00
M16	2.00	14.00
M18	2.5	15.50
M20	2.5	17.50
M22	2.5	19.50
M24	3.00	21.00
M27	3.00	24.00
M30	3.50	26.50
M33	3.50	29.50
M36	4.00	32.00
M39	4.00	35.00
M42	4.50	37.50
M45	4.50	40.50
M48	5.00	43.00
M52	5.00	47.00

Continue >>

• CUTTING TAPS (MF)

Ø (MF)	P (mm)	
M2	0.25	1.75
M2.2	0.25	1.95
M2.3	0.25	2.05
M2.5	0.35	2.15
M2.6	0.35	2.25
M3	0.35	2.65
M3.5	0.35	3.15
M4	0.35	3.65
M4	0.5	3.50
M5	0.5	4.50
M6	0.5	5.50
M6	0.75	5.20
M7	0.75	6.20
M8	0.5	7.50
M8	0.75	7.20
M8	1	7.00
M9	1	8.00
M10	0.75	9.20
M10	1	9.00
M10	1.25	8.80
M11	1	10.00
M12	1	11.00
M12	1.25	10.80
M12	1.5	10.50
M14	1	13.00
M14	1.25	12.80
M14	1.5	12.50
M15	1	14.00
M15	1.5	13.50
M16	1	15.00
M16	1.5	14.50
M18	1	17.00
M18	1.5	16.50
M18	2	16.00
M20	1	19.00
M20	1.5	18.50
M20	2	18.00
M22	1	21.00
M22	1.5	20.50
M22	2	20.00

Ø (MF)	P (mm)	
M24	1	23.00
M24	1.5	22.50
M24	2	22.00
M25	1.5	23.50
M26	1.5	24.50
M27	1.5	25.50
M27	2	25.00
M28	1.5	26.50
M30	1	29.00
M30	1.5	28.50
M30	2	28.00
M32	1.5	30.50
M33	1.5	31.50
M33	2	31.00
M34	1.5	32.50
M35	1.5	33.50
M36	1.5	34.50
M36	2	34.00
M36	3	33.00
M38	1.5	36.50
M39	2	37.00
M39	3	36.00
M40	1.5	38.50
M40	2	38.00
M40	3	37.00
M42	1.5	40.50
M42	2	40.00
M42	3	39.00
M45	1.5	43.50
M45	2	43.00
M45	3	42.00
M48	1.5	46.50
M48	2	46.00
M48	3	45.00
M50	1.5	48.50
M50	2	48.00
M50	3	47.00
M52	1.5	50.50
M52	2	50.00
M52	3	49.00

Continue >>

• CUTTING TAPS (UNC)

Ø (UNC)	Filetti/1" (pollici)	
No. 1	64	1.50
No. 2	56	1.80
No. 3	48	2.10
No. 4	40	2.30
No. 5	40	2.65
No. 6	32	2.85
No. 8	32	3.50
No. 10	24	3.90
No. 12	24	4.50
1/4	20	5.10
5/16	18	6.60
3/8	16	8.00
7/16	14	9.40

Continue >>

Ø (UNC)	Filetti/1" (pollici)	
1/2	13	10.80
9/16	12	12.20
5/8	11	13.50
3/4	10	16.50
7/8	9	19.50
1"	8	22.25
1 1/8	7	25.00
1 1/4	7	28.20
1 3/8	6	31.00
1 1/2	6	34.00
1 3/4	5	39.50
2-4	4	45.20

• CUTTING TAPS (UNF)

Ø (UNF)	Filetti/1" (pollici)	
No. 0	80	1.25
No. 1	72	1.55
No. 2	64	1.85
No. 3	56	2.10
No. 4	48	2.40
No. 5	44	2.70
No. 6	40	3.00
No. 8	36	3.50
No. 10	32	4.10
No. 12	28	4.65
1/4	28	5.50
5/16	24	6.90

Continue >>

Ø (UNF)	Filetti/1" (pollici)	
3/8	24	8.50
7/16	20	9.90
1/2	20	11.50
9/16	18	12.90
5/8	18	14.50
3/4	16	17.50
7/8	14	20.50
1"	12	23.25
1 1/8	12	26.50
1 1/4	12	29.75
1 3/8	12	33.00
1 1/2	12	36.00

• CUTTING TAPS (G)

Ø (M)	Filetti/1" (pollici)	
1/8	28	8.80
1/4	19	11.80
3/8	19	15.25
1/2	14	19.00
5/8	14	21.00
3/4	14	24.50
7/8	14	28.25
1"	11	30.75
1 1/8	11	35.50

Ø (M)	Filetti/1" (pollici)	
1 1/4	11	39.50
1 3/8	11	42.00
1 1/2	11	45.00
1 3/4	11	51.00
2"	11	57.00
2 1/4	11	63.10
2 1/2	11	72.80
2 3/4	11	79.00
3"	11	85.30

Continue >>

• FORMING TAPS (M)

Ø (M)	P (mm)	Tap drill hole			
		100%	90%	80%	70%
M1	0.25	0.86	0.87	0.89	0.90
M1	0.2	0.89	0.90	0.91	0.92
M1.1	0.25	0.96	0.97	0.99	1.00
M1.1	0.2	0.99	1.00	1.01	1.02
M1.2	0.25	1.06	1.07	1.09	1.10
M1.2	0.2	1.09	1.10	1.11	1.12
M1.4	0.3	1.23	1.25	1.26	1.28
M1.4	0.2	1.29	1.30	1.31	1.32
M1.6	0.35	1.40	1.42	1.44	1.46
M1.6	0.2	1.49	1.50	1.51	1.52
M1.7	0.35	1.50	1.52	1.54	1.56
M1.7	0.2	1.59	1.60	1.61	1.62
M1.8	0.35	1.60	1.62	1.64	1.66
M1.8	0.2	1.69	1.70	1.71	1.72
M2	0.4	1.77	1.80	1.82	1.84
M2	0.25	1.86	1.87	1.89	1.91
M2.2	0.45	1.94	1.97	2.00	2.02
M2.2	0.25	2.06	2.07	2.09	2.10
M2.3	0.4	2.07	2.10	2.12	2.14
M2.3	0.25	2.16	2.17	2.19	2.20
M2.5	0.45	2.24	2.27	2.30	2.32
M2.5	0.35	2.30	2.32	2.34	2.36
M2.6	0.45	2.34	2.37	2.40	2.42
M2.6	0.35	2.40	2.42	2.44	2.46

Continue >>

Ø (M)	P (mm)	Tap drill hole			
		100%	90%	80%	70%
M3	0.6	2.66	2.69	2.73	2.76
M3	0.5	2.72	2.74	2.77	2.80
M3	0.35	2.80	2.82	2.84	2.86
M3.5	0.6	3.16	3.19	3.23	3.26
M3.5	0.35	3.30	3.32	3.34	3.36
M4	0.75	3.57	3.62	3.66	3.70
M4	0.7	3.60	3.64	3.68	3.72
M4	0.5	3.72	3.74	3.77	3.80
M4.5	0.75	4.07	4.12	4.16	4.20
M4.5	0.5	4.22	4.24	4.27	4.30
M5	0.9	4.49	4.54	4.59	4.64
M5	0.8	4.55	4.59	4.64	4.68
M5	0.5	4.72	4.74	4.77	4.80
M5.5	0.9	4.99	5.04	5.09	5.14
M5.5	0.5	5.22	5.24	5.27	5.30
M6	1	5.43	5.49	5.55	5.60
M6	0.75	5.57	5.62	5.66	5.70
M6	0.5	5.72	5.74	5.77	5.80
M7	1	6.43	6.49	6.55	6.60
M7	0.75	6.57	6.62	6.66	6.70
M7	0.5	6.72	6.74	6.77	6.80
M8	1.25	7.29	7.36	7.43	7.50
M8	1	7.43	7.49	7.55	7.60
M8	0.75	7.57	7.62	7.66	7.70

• FORMING TAPS (M)

Ø (M)	P (mm)	Tap drill hole			
		100%	90%	80%	70%
M8	0.5	7.72	7.74	7.77	7.80
M9	1.25	8.29	8.36	8.43	8.50
M9	1	8.43	8.49	8.55	8.60
M9	0.75	8.57	8.62	8.66	8.70
M9	0.5	8.72	8.74	8.77	8.80
M10	1.5	9.15	9.23	9.32	9.40
M10	1.25	9.29	9.36	9.43	9.50
M10	1	9.43	9.49	9.55	9.60
M10	0.75	9.57	9.62	9.66	9.70
M10	0.5	9.72	9.74	9.77	9.80
M11	1.5	10.15	10.23	10.32	10.40
M11	1	10.43	10.49	10.55	10.60
M11	0.75	10.57	10.62	10.66	10.70
M12	1.75	11.01	11.11	11.21	11.31
M12	1.5	11.15	11.23	11.32	11.40
M12	1.25	11.29	11.36	11.43	11.50
M12	1	11.43	11.49	11.55	11.60
M14	2	12.87	12.98	13.09	13.21
M14	1.5	13.15	13.23	13.32	13.40
M14	1.25	13.29	13.36	13.43	13.50
M14	1	13.43	13.49	13.55	13.60
M15	1.5	14.15	14.23	14.32	14.40

Ø (M)	P (mm)	Tap drill hole			
		100%	90%	80%	70%
M15	1	14.43	14.49	14.55	14.60
M16	2	14.87	14.98	15.09	15.21
M16	1.5	15.15	15.23	15.32	15.40
M16	1	15.43	15.49	15.55	15.60
M17	1.5	16.15	16.23	16.32	16.40
M17	1	16.43	16.49	16.55	16.60
M18	2.5	16.58	16.72	16.87	17.01
M18	2	16.87	16.98	17.09	17.21
M18	1.5	17.15	17.23	17.32	17.40
M18	1	17.43	17.49	17.55	17.60
M20	2.5	18.58	18.72	18.87	19.01
M20	2	18.87	18.98	19.09	19.21
M20	1.5	19.15	19.23	19.32	19.40
M20	1	19.43	19.49	19.55	19.60
M22	2.5	20.58	20.72	20.87	21.01
M22	2	20.87	20.98	21.09	21.21
M22	1.5	21.15	21.23	21.32	21.40
M22	1	21.43	21.49	21.55	21.60
M24	2	22.87	22.98	23.09	23.21
M24	1.5	23.15	23.23	23.32	23.40
M24	1	23.43	23.49	23.55	23.60

Continue >>

• FORMING TAPS (UNC)

Ø (UNC)	Tap drill hole			
	100%	90%	80%	70%
No. 1-64	1.63	1.65	1.67	1.70
No. 2-56	1.93	1.95	1.98	2.00
No. 3-48	2.21	2.24	2.27	2.30
No. 4-40	2.49	2.52	2.56	2.59
No. 5-40	2.82	2.85	2.89	2.92
No. 6-32	3.05	3.10	3.14	3.19
No. 8-32	3.72	3.76	3.81	3.85
No. 10-24	4.23	4.29	4.35	4.41
No. 12-24	4.89	4.95	5.01	5.07

Continue >>

• FORMING TAPS (UNF)

Ø (UNF)	Tap drill hole			
	100%	90%	80%	70%
No. 0-80	1.34	1.36	1.38	1.40
No. 1-72	1.65	1.67	1.69	1.71
No. 2-64	1.96	1.98	2.00	2.03
No. 3-56	2.26	2.28	2.31	2.34
No. 4-48	2.54	2.57	2.60	2.63
No. 5-44	2.85	2.88	2.91	2.95
No. 6-40	3.15	3.18	3.22	3.25
No. 8-36	3.77	3.81	3.85	3.89
No. 10-32	4.38	4.42	4.47	4.51
No. 12-28	4.97	5.02	5.07	5.13

Continue >>

• FORMING TAPS (G)

Ø (G)	P (mm)	Tap drill hole			
		100%	90%	80%	70%
1/8	28	9.17	9.22	9.28	9.33
1/4	19	12.33	12.41	12.49	12.58

Continue >>

Ø (UNC)	Tap drill hole			
	100%	90%	80%	70%
1/4-20	5.63	5.70	5.77	5.85
5/16-18	7.14	7.22	7.30	7.38
3/8-16	8.62	8.71	8.80	8.89
7/16-14	10.08	10.19	10.29	10.39
1/2-13	11.59	11.70	11.81	11.92
9/16-12	13.09	13.21	13.33	13.45
5/8-11	14.55	14.68	14.81	14.94
3/4-10	17.61	17.75	17.90	18.04

Ø (UNF)	Tap drill hole			
	100%	90%	80%	70%
1/4-28	5.84	5.89	5.94	5.99
5/16-24	7.34	7.40	7.46	7.52
3/8-24	8.92	8.98	9.04	9.10
7/16-20	10.39	10.46	10.54	10.61
1/2-20	11.98	12.05	12.12	12.20
9/16-18	13.49	13.57	13.65	13.73
5/8-18	15.06	15.14	15.22	15.30
3/4-16	18.15	18.24	18.33	18.42
7/8-14	21.20	21.30	21.40	21.50

