



Hand taps

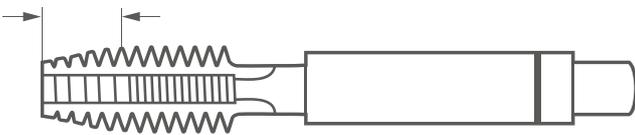




Hand taps



- Rougher = 6-8 Thread pitch
- Intermediate = 4-5 Thread pitch
- Finisher = 2-3 Thread pitch



HSS-G screw taps are suitable for machinable raw materials up to 900 N/mm². The design in HSS-E for hard to machine raw materials up to 1200 N/mm² and vapourised hand screw taps are particularly suited to wear-resistant steels up to 1400 N/mm².

The taps can be distinguished from their thread leads and marking. Pre-cutters (rougher) are marked on their shank with one and middle cutter (intermediate) with two rings. The finished cutter does not carry a ring and is generally not marked.

It is recommended that the finishing cutter should only be used for trimming damaged threads. The rougher, intermediate and finisher can be ordered separately.

M (metric)



Hand taps, metric ISO-thread DIN 13

HSS-G Hand taps for non abrasive material up to 900 N/mm². The taps made of HSS-E are suitable for abrasive steels up to 1200 N/mm² and the steam tempered hand taps are particularly suited to wear resistant steels up to 1400 N/mm² tensile strength.

Hand taps for metric right hand threads

- Hand taps acc. to DIN, ISO and JIS-B standard
- Variations from M 1 to M 100



Mini Hand taps (set of 22 pcs.) (48001)

DIN 352 M 1 - M 2.6

Type of thread	Standard	Material	Packing	Size
metric ISO thread DIN 13	DIN 352	HSS-G	in wooden case	Diameter 1 - 2,6

Application/ for general use:

- › non abrasive material up to 900 N/mm²
- › unalloyed and low alloyed steel
- › for through and blind holes
- › for thread cutting by hand

Contents:

	Art. -No.
1x Adjustable Tap Wrenches DIN 1814 Size 0	13000
1x Hand taps (set of 3 pcs.) DIN 352 HSS-G - M 1 x 0.25	27302
1x Hand taps (set of 3 pcs.) DIN 352 HSS-G - M 1.2 x 0.25	27306
1x Hand taps (set of 3 pcs.) DIN 352 HSS-G - M 1.4 x 0.3	27308
1x Hand taps (set of 3 pcs.) DIN 352 HSS-G - M 1.7 x 0.35	27312
1x Hand taps (set of 3 pcs.) DIN 352 HSS-G - M 2 x 0.4	27316
1x Hand taps (set of 3 pcs.) DIN 352 HSS-G - M 2.3 x 0.4	27320
1x Hand taps (set of 3 pcs.) DIN 352 HSS-G - M 2.6 x 0.45	27324



P.K.20 Hand taps (set of 22 pcs.) (47001)

M 3 - M 12

Type of thread	Standard	Material	Packing	Size
metric ISO thread DIN 13	DIN Standard	HSS-G	in plastic case	Diameter M 3 - 12

All threading tools, threading tool holder and accessories can also be ordered separately.

Application/for general use:

- › non abrasive material up to 900 N/mm²
- › unalloyed and low alloyed steel
- › for through and blind holes
- › for thread cutting by hand
- › small and handy problemsolver for standard application
- › the most popular dimensions in one case
- › HSS-G Hand taps acc. to DIN 352

Contents:

	Art. -No.
1x HSS-G Hand taps (set of 3 pcs.) M 3	27326
1x HSS-G Hand taps (set of 3 pcs.) M 4	27330
1x HSS-G Hand taps (set of 3 pcs.) M 5	27334
1x HSS-G Hand taps (set of 3 pcs.) M 6	27338
1x HSS-G Hand taps (set of 3 pcs.) M 8	27342
1x HSS-G Hand taps (set of 3 pcs.) M 10	27346
1x HSS-G Hand taps (set of 3 pcs.) M 12	27350
1x Adjustable tap wrench, zinc die cast No. 1.1/2	13015



Hand taps (set of 22 pcs.) (99917)

HSS-G, UNC No. 5 - UNC 1/2" + cobit BT11Neo Mix-TORSION

Material	Packing	Size
HSS-G	in plastic case	UNC No. 5 - UNC 1/2"

Application/for general use:

- › non abrasive material up to 900 N/mm²
- › unalloyed and low alloyed steel
- › for through and blind holes
- › for thread cutting by hand
- › small and handy problemsolver for standard application
- › the most popular dimensions in one case



P.K.21 Hand taps (set of 23 pcs.) (99916)

incl. ratchet M 3 - M 12 + cobit BT11Neo Mix-TORSION

Type of thread	Standard	Material	Packing	Size
metric ISO thread	DIN	HSS-G	in plastic case	Diameter
DIN 13	Standard			M 3 - 12

All threading tools, threading tool holder and accessories can also be ordered separately.

Application/for general use:

- › non abrasive material up to 900 N/mm²
- › unalloyed and low alloyed steel
- › for through and blind holes
- › for thread cutting by hand
- › small and handy problemsolver for standard application
- › the most popular dimensions in one case
- › HSS-G Hand taps acc. to DIN 352

Contents:

	Art. -No.
1x HSS-G Hand taps (set of 3 pcs.) M 3	27326
1x HSS-G Hand taps (set of 3 pcs.) M 4	27330
1x HSS-G Hand taps (set of 3 pcs.) M 5	27334
1x HSS-G Hand taps (set of 3 pcs.) M 6	27338
1x HSS-G Hand taps (set of 3 pcs.) M 8	27342
1x HSS-G Hand taps (set of 3 pcs.) M 10	27346
1x HSS-G Hand taps (set of 3 pcs.) M 12	27350
1x Adjustable tap wrench, zinc die cast No. 1.1/2	13015
1x Tap holder with ratchet, size 1	10001



P.K.21 Hand taps (set of 23 pcs.) (47005)

incl. ratchet M 3 - M 12

Type of thread	Standard	Material	Packing	Size
metric ISO thread DIN 13	DIN Standard	HSS-G	in plastic case	Diameter M 3 - 12

All threading tools, threading tool holder and accessories can also be ordered separately.

Application/for general use:

- › non abrasive material up to 900 N/mm²
- › unalloyed and low alloyed steel
- › for through and blind holes
- › for thread cutting by hand
- › small and handy problemsolver for standard application
- › the most popular dimensions in one case
- › HSS-G Hand taps acc. to DIN 352

Contents:

	Art. -No.
1x HSS-G Hand taps (set of 3 pcs.) M 3	27326
1x HSS-G Hand taps (set of 3 pcs.) M 4	27330
1x HSS-G Hand taps (set of 3 pcs.) M 5	27334
1x HSS-G Hand taps (set of 3 pcs.) M 6	27338
1x HSS-G Hand taps (set of 3 pcs.) M 8	27342
1x HSS-G Hand taps (set of 3 pcs.) M 10	27346
1x HSS-G Hand taps (set of 3 pcs.) M 12	27350
1x Adjustable tap wrench, zinc die cast No. 1.1/2	13015
1x Tap holder with ratchet, size 1	10001



Hand taps (set of 23 pcs.) (47055)

incl. ratchet HSS-E M 3 - M 12

Type of thread	Standard	Material	Packing	Size
metric ISO thread DIN 13	DIN Standard	HSS-E	in plastic case	Diameter M 3 - 12

All threading tools, threading tool holder and accessories can also be ordered separately.

Application/for general use:

- › non abrasive material up to 900 N/mm²
- › unalloyed and low alloyed steel
- › for through and blind holes
- › for thread cutting by hand
- › small and handy problemsolver for standard application
- › the most popular dimensions in one case
- › HSS-E Hand taps acc. to DIN 352

Contents:

	Art. -No.
1x HSS-E Hand taps (set of 3 pcs.) M 3	57326
1x HSS-E Hand taps (set of 3 pcs.) M 4	57330
1x HSS-E Hand taps (set of 3 pcs.) M 5	57334
1x HSS-E Hand taps (set of 3 pcs.) M 6	57338
1x HSS-E Hand taps (set of 3 pcs.) M 8	57342
1x HSS-E Hand taps (set of 3 pcs.) M 10	57346
1x HSS-E Hand taps (set of 3 pcs.) M 12	57350
1x Adjustable tap wrench, zinc die cast No. 1.1/2	13015
1x Tap holder with ratchet, size 1	10001



P.V.22 Hand taps (set of 29 pcs.) incl. drills M3 - M12 ([49510](#))

Type of thread	Material	Packing	Size
metric ISO thread DIN 13	HSS-G	in drillbox metal case	Diameter M 3 - 12

All threading tools, threading tool holder and accessories can also be ordered separately.

Application/for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand
- small and handy problemsolver for standard application
- the most popular dimensions in one case
- HSS-G Hand taps acc. to DIN 352
- HSS Round dies acc. to DIN 223 (DIN EN 22568)

Contents:

Contents:	Art. -No.	Contents:
1x HSS-G Hand taps (set of 3 pcs.) M 3	27326	1x HSS Twist drill 2,50 mm (M 3)
1x HSS-G Hand taps (set of 3 pcs.) M 4	27330	1x HSS Twist drill 3,30 mm (M 4)
1x HSS-G Hand taps (set of 3 pcs.) M 5	27334	1x HSS Twist drill 4,20 mm (M 5)
1x HSS-G Hand taps (set of 3 pcs.) M 6	27338	1x HSS Twist drill 5,00 mm (M 6)
1x HSS-G Hand taps (set of 3 pcs.) M 8	27342	1x HSS Twist drill 6,80 mm (M 8)
1x HSS-G Hand taps (set of 3 pcs.) M 10	27346	1x HSS Twist drill 8,50 mm (M 10)
1x HSS-G Hand taps (set of 3 pcs.) M 12	27350	1x HSS Twist drill 10,20 mm (M 12)
1x Adjustable tap wrench, zinc die cast No. 1.1/2	13015	



P.V.23 Hand taps (set of 30 pcs.) incl. drills M3 - M12 ([49511](#))

Type of thread	Material	Packing	Size
metric ISO thread DIN 13	HSS-G	in drillbox metal case	Diameter M 3 - 12

All threading tools, threading tool holder and accessories can also be ordered separately.

Application/for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand
- the most popular dimensions in one case
- HSS-G Hand taps acc. to DIN 352
- HSS Round dies acc. to DIN 223 (DIN EN 22568)

Contents:

Contents:	Art. -No.	Contents:
1x HSS-G Hand taps (set of 3 pcs.) M 3	27326	1x HSS Twist drill 2,50 mm (M 3)
1x HSS-G Hand taps (set of 3 pcs.) M 4	27330	1x HSS Twist drill 3,30 mm (M 4)
1x HSS-G Hand taps (set of 3 pcs.) M 5	27334	1x HSS Twist drill 4,20 mm (M 5)
1x HSS-G Hand taps (set of 3 pcs.) M 6	27338	1x HSS Twist drill 5,00 mm (M 6)
1x HSS-G Hand taps (set of 3 pcs.) M 8	27342	1x HSS Twist drill 6,80 mm (M 8)
1x HSS-G Hand taps (set of 3 pcs.) M 10	27346	1x HSS Twist drill 8,50 mm (M 10)
1x HSS-G Hand taps (set of 3 pcs.) M 12	27350	1x HSS Twist drill 10,20 mm (M 12)
1x Adjustable tap wrench, zinc die cast No. 1.1/2	13015	
1x Tap holder with ratchet, size 1	10001	



Hand taps (set of 3 pcs.)

DIN 352 HSS-G - M (hand tap taper, hand tap second, hand tap finisher)

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (54):

Application/for general use:

- > non abrasive material up to 900 N/mm²
- > unalloyed and low alloyed steel
- > for through and blind holes
- > for thread cutting by hand



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Taper	Art.-No. Second	Art.-No. Finisher
M 1 x 0.25	32	5.5	2.5	2.1	27302	27302-1	27302-2	27302-3
M 1.1 x 0.25	32	5.5	2.5	2.1	27304	27304-1	27304-2	27304-3
M 1.2 x 0.25	32	5.5	2.5	2.1	27306	27306-1	27306-2	27306-3
M 1.4 x 0.3	32	7.0	2.5	2.1	27308	27308-1	27308-2	27308-3
M 1.6 x 0.35	32	8.0	2.5	2.1	27310	27310-1	27310-2	27310-3
M 1.7 x 0.35	32	8.0	2.5	2.1	27312	27312-1	27312-2	27312-3
M 1.8 x 0.35	32	8.0	2.5	2.1	27314	27314-1	27314-2	27314-3
M 2 x 0.4	36	8.0	2.8	2.1	27316	27316-1	27316-2	27316-3
M 2.2 x 0.45	36	9.0	2.8	2.1	27318	27318-1	27318-2	27318-3
M 2.3 x 0.4	36	9.0	2.8	2.1	27320	27320-1	27320-2	27320-3
M 2.5 x 0.45	40	9.0	2.8	2.1	27322	27322-1	27322-2	27322-3
M 2.6 x 0.45	40	9.0	2.8	2.1	27324	27324-1	27324-2	27324-3
M 3 x 0.5	40	11.0	3.5	2.7	27326	27326-1	27326-2	27326-3
M 3.5 x 0.6	45	13.0	4.0	3.0	27328	27328-1	27328-2	27328-3
M 4 x 0.7	45	13.0	4.5	3.4	27330	27330-1	27330-2	27330-3
M 4.5 x 0.75	50	16.0	6.0	4.9	27332	27332-1	27332-2	27332-3
M 5 x 0.8	50	16.0	6.0	4.9	27334	27334-1	27334-2	27334-3
M 5.5 x 0.9	50	18.0	6.0	4.9	27336	27336-1	27336-2	27336-3
M 6 x 1.0	50	19.0	6.0	4.9	27338	27338-1	27338-2	27338-3
M 7 x 1.0	50	19.0	6.0	4.9	27340	27340-1	27340-2	27340-3
M 8 x 1.25	56	22.0	6.0	4.9	27342	27342-1	27342-2	27342-3
M 9 x 1.25	63	22.0	7.0	5.5	27344	27344-1	27344-2	27344-3
M 10 x 1.5	70	24.0	7.0	5.5	27346	27346-1	27346-2	27346-3
M 11 x 1.5	70	24.0	8.0	6.2	27348	27348-1	27348-2	27348-3
M 12 x 1.75	75	29.0	9.0	7.0	27350	27350-1	27350-2	27350-3
M 14 x 2.0	80	30.0	11.0	9.0	27354	27354-1	27354-2	27354-3
M 15 x 2.0	80	32.0	12.0	9.0	27356	27356-1	27356-2	27356-3
M 16 x 2.0	80	32.0	12.0	9.0	27358	27358-1	27358-2	27358-3
M 18 x 2.5	95	40.0	14.0	11.0	27362	27362-1	27362-2	27362-3
M 20 x 2.5	95	40.0	16.0	12.0	27366	27366-1	27366-2	27366-3
M 22 x 2.5	100	40.0	18.0	14.5	27370	27370-1	27370-2	27370-3
M 24 x 3.0	110	50.0	18.0	14.5	27374	27374-1	27374-2	27374-3

D = Nominal Diameter L1 = Overall Length L2 = Thread Length D2 = Shank Diameter Square = Drive Connector



D		L1	L2	D2	Square	Art.-No. Set	Art.-No. Taper	Art.-No. Second	Art.-No. Finisher
M	27 x 3.0	110	50.0	20.0	16.0	27376	27376-1	27376-2	27376-3
M	30 x 3.0	125	56.0	22.0	18.0	27378	27378-1	27378-2	27378-3
M	33 x 3.5	125	56.0	25.0	20.0	27380	27380-1	27380-2	27380-3
M	36 x 4.0	150	63.0	28.0	22.0	27382	27382-1	27382-2	27382-3
M	39 x 4.0	150	63.0	32.0	24.0	27384	27384-1	27384-2	27384-3
M	42 x 4.5	150	63.0	32.0	24.0	27386	27386-1	27386-2	27386-3
M	45 x 4.5	160	70.0	36.0	29.0	27388	27388-1	27388-2	27388-3
M	48 x 5.0	180	75.0	36.0	29.0	27390	27390-1	27390-2	27390-3
M	52 x 5.0	180	75.0	40.0	32.0	27392	27392-1	27392-2	27392-3
M	56 x 5.5	200	85.0	45.0	35.0	27394	27394-1	27394-2	27394-3
M	60 x 5.5	200	85.0	45.0	35.0	27396	27396-1	27396-2	27396-3
M	64 x 6.0	220	90.0	50.0	39.0	27398	27398-1	27398-2	27398-3
M	68 x 6.0	220	90.0	50.0	39.0	27399	27399-1	27399-2	27399-3
M	72 x 6.0	240	80.0	50.0	39.0	28130	28130-1	28130-2	28130-3
M	76 x 6.0	240	80.0	50.0	39.0	28131	28131-1	28131-2	28131-3
M	80 x 6.0	260	85.0	50.0	39.0	28132	28132-1	28132-2	28132-3
M	84 x 6.0	260	85.0	50.0	39.0	28133	28133-1	28133-2	28133-3
M	88 x 6.0	260	85.0	50.0	39.0	28134	28134-1	28134-2	28134-3
M	90 x 6.0	260	85.0	50.0	39.0	28135	28135-1	28135-2	28135-3
M	92 x 6.0	280	90.0	56.0	44.0	28136	28136-1	28136-2	28136-3
M	96 x 6.0	280	90.0	56.0	44.0	28137	28137-1	28137-2	28137-3
M	100 x 6.0	280	90.0	56.0	44.0	28138	28138-1	28138-2	28138-3

D = Nominal Diameter

L1 = Overall Length

L2 = Thread Length

D2 = Shank Diameter

Square = Drive Connector



Hand taps (set of 3 pcs.)

DIN 352 HSS-E - M

(hand tap rougher, hand tap intermediate, hand tap finisher)

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (15):

Advantages:

- > high cutting ability

Application:

- > abrasive material
- > Steel up to 1200 N/mm²
- > and for general use



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Intermediate	Art.-No. Finisher
M 3 x 0.5	40	11	3.5	2.7	57326	57326-1	57326-2	57326-3
M 4 x 0.7	45	13	4.5	3.4	57330	57330-1	57330-2	57330-3
M 5 x 0.8	50	16	6.0	4.9	57334	57334-1	57334-2	57334-3
M 6 x 1.0	50	19	6.0	4.9	57338	57338-1	57338-2	57338-3
M 8 x 1.25	56	22	6.0	4.9	57342	57342-1	57342-2	57342-3
M 10 x 1.5	70	24	7.0	5.5	57346	57346-1	57346-2	57346-3
M 12 x 1.75	75	29	9.0	7.0	57350	57350-1	57350-2	57350-3
M 14 x 2.0	80	30	11.0	9.0	57354	57354-1	57354-2	57354-3
M 16 x 2.0	80	32	12.0	9.0	57358	57358-1	57358-2	57358-3
M 18 x 2.5	95	40	14.0	11.0	57362	57362-1	57362-2	57362-3
M 20 x 2.5	95	40	16.0	12.0	57366	57366-1	57366-2	57366-3
M 22 x 2.5	100	40	18.0	14.5	57370	57370-1	57370-2	57370-3
M 24 x 3.0	110	50	18.0	14.5	57374	57374-1	57374-2	57374-3
M 27 x 3.0	110	50	20.0	16.0	57376	57376-1	57376-2	57376-3
M 30 x 3.5	125	56	22.0	18.0	57378	57378-1	57378-2	57378-3

D = Nominal Diameter

L1 = Overall Length

L2 = Thread Length

D2 = Shank Diameter

Square = Drive Connector



Hand taps (set of 3 pcs.)

non-serial ISO 529, HSS-G - M

(hand tap taper, hand tap second, hand tap finisher)

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 / 6H

Variants (35/18):

Application/ for general use:

- > non abrasive material up to 900 N/mm²
- > unalloyed and low alloyed steel
- > for through and blind holes
- > for thread cutting by hand



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Taper	Art.-No. Second	Art.-No. Finisher
M 1.6 x 0.35	41	8	2.5	2.0	80410	-	-	-
M 2 x 0.4	41	8	2.5	2.0	80416	80416-1	80416-2	80416-3
M 2.2 x 0.45	44.5	9.5	2.8	2.24	80418	-	-	-
M 2.5 x 0.45	44.5	9.5	2.8	2.24	80422	80422-1	80422-2	80422-3
M 3 x 0.5	48	11	3.15	2.5	80426	80426-1	80426-2	80426-3
M 3.5 x 0.6	50	13	3.55	2.8	80428	80428-1	80428-2	80428-3
M 4 x 0.7	53	13	4.0	3.15	80430	80430-1	80430-2	80430-3
M 4.5 x 0.75	53	13	4.5	3.55	80432	-	-	-
M 5 x 0.8	58	16	5.0	4.0	80434	80434-1	80434-2	80434-3
M 6 x 1.0	66	19	6.3	5.0	80438	80438-1	80438-2	80438-3
M 7 x 1.0	66	19	7.1	5.6	80440	-	-	-
M 8 x 1.25	72	22	8.0	6.3	80442	80442-1	80442-2	80442-3
M 9 x 1.25	72	22	9.0	7.1	80444	-	-	-
M 10 x 1.5	80	24	10.0	8.0	80446	80446-1	80446-2	80446-3
M 11 x 1.5	85	25	8.0	6.3	80448	-	-	-
M 12 x 1.75	89	29	9.0	7.1	80450	80450-1	80450-2	80450-3
M 14 x 2.0	95	30	11.2	9.0	80454	80454-1	80454-2	80454-3
M 16 x 2.0	102	32	12.5	10.0	80458	80458-1	80458-2	80458-3
M 18 x 2.5	110	37	14.0	11.2	80462	80462-1	80462-2	80462-3
M 20 x 2.5	112	37	14.0	11.2	80466	80466-1	80466-2	80466-3
M 22 x 2.5	118	38	16.0	12.5	80470	80470-1	80470-2	80470-3
M 24 x 3.0	130	45	18.0	14.0	80474	80474-1	80474-2	80474-3
M 27 x 3.0	135	45	20.0	16.0	80476	80476-1	80476-2	80476-3
M 30 x 3.5	138	48	20.0	16.0	80478	80478-1	80478-2	80478-3
M 33 x 3.5	151	51	22.4	18.0	80480	-	-	-
M 36 x 4.0	162	57	25.0	20.0	80482	-	-	-
M 39 x 4.0	170	60	28.0	22.4	80484	-	-	-
M 42 x 4.5	170	60	28.0	22.4	80486	-	-	-
M 45 x 4.5	187	67	31.5	25.0	80488	-	-	-
M 48 x 5.0	187	67	31.5	25.0	80490	-	-	-
M 52 x 5.0	200	70	35.5	28.0	80492	-	-	-



D		L1	L2	D2	Square	Art.-No. Set	Art.-No. Taper	Art.-No. Second	Art.-No. Finisher
M	56 x 5.5	200	70	35.5	28.0	80494	-	-	-
M	60 x 5.5	221	76	40.0	31.5	80496	-	-	-
M	64 x 6.0	224	79	40.0	31.5	80498	-	-	-
M	68 x 6.0	234	79	45.0	35.5	80499	-	-	-



Hand taps (set of 3 pcs.)

DIN 352 HSS-E VAP - M

(hand tap rougher, hand tap intermediate, hand tap finisher)

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (7):

Application: wear resistant steel up to 1400 N/mm²

- > high alloy steel
- > heat resistant steel
- > stainless steel
- > alloy tool steel
- > cast iron

VAP-coating:

- > improved adhesion of the coolant and Lubricant
- > reduces tearing of the lubricating fill and the formation of cold welding

Rougher piloted



D		L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Intermediate	Art.-No. Finisher
M	3 x 0.5	40	11	3.5	2.7	57726	57726-1	57726-2	57726-3
M	4 x 0.7	45	13	4.5	3.4	57730	57730-1	57730-2	57730-3
M	5 x 0.8	50	16	6.0	4.9	57734	57734-1	57734-2	57734-3
M	6 x 1.0	50	19	6.0	4.9	57738	57738-1	57738-2	57738-3
M	8 x 1.25	56	22	6.0	4.9	57742	57742-1	57742-2	57742-3
M	10 x 1.5	70	24	7.0	5.5	57746	57746-1	57746-2	57746-3
M	12 x 1.75	75	29	9.0	7.0	57750	57750-1	57750-2	57750-3

D = Nominal Diameter

L1 = Overall Length

L2 = Thread Length

D2 = Shank Diameter

Square = Drive Connector



Hand taps (set of 3 pcs.)

non-serial DIN 352 HSS-G - M

(hand tap rougher, hand tap intermediate, hand tap finisher)

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (28):

Application/ for general use:

- > non abrasive material up to 900 N/mm²
- > unalloyed and low alloyed steel
- > for through and blind holes
- > for thread cutting by hand



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Intermediate	Art.-No. Finisher
M 2 x 0.4	36	8	2.8	2.1	27616	27616-1	27616-2	27616-3
M 2.5 x 0.45	40	9	2.8	2.1	27622	27622-1	27622-2	27622-3
M 3 x 0.5	40	11	3.5	2.7	27626	27626-1	27626-2	27626-3
M 3 x 0.6	40	11	3.5	2.7	27627	27627-1	27627-2	27627-3
M 4 x 0.7	45	13	4.5	3.4	27630	27630-1	27630-2	27630-3
M 4 x 0.75	45	13	4.5	3.4	27631	27631-1	27631-2	27631-3
M 5 x 0.8	50	16	6.0	4.9	27634	27634-1	27634-2	27634-3
M 5 x 0.9	50	16	6.0	4.9	27635	27635-1	27635-2	27635-3
M 6 x 1.0	50	19	6.0	4.9	27638	27638-1	27638-2	27638-3
M 8 x 1.25	56	22	6.0	4.9	27642	27642-1	27642-2	27642-3
M 9 x 1.25	63	22	7.0	5.5	27644	27644-1	27644-2	27644-3
M 10 x 1.5	70	24	7.0	5.5	27646	27646-1	27646-2	27646-3
M 11 x 1.5	70	24	8.0	6.2	27648	27648-1	27648-2	27648-3
M 12 x 1.75	75	29	9.0	7.0	27650	27650-1	27650-2	27650-3
M 13 x 1.75	75	29	9.0	7.0	27652	27652-1	27652-2	27652-3
M 14 x 2.0	80	30	11.0	9.0	27654	27654-1	27654-2	27654-3
M 16 x 2.0	80	32	12.0	9.0	27658	27658-1	27658-2	27658-3
M 18 x 2.5	95	40	14.0	11.0	27662	27662-1	27662-2	27662-3
M 19 x 2.5	95	40	14.0	11.0	27664	27664-1	27664-2	27664-3
M 20 x 2.5	95	40	16.0	12.0	27666	27666-1	27666-2	27666-3
M 22 x 2.5	100	40	18.0	14.5	27670	27670-1	27670-2	27670-3
M 24 x 3.0	110	50	18.0	14.5	27674	27674-1	27674-2	27674-3
M 27 x 3.0	110	50	20.0	16.0	27676	27676-1	27676-2	27676-3
M 30 x 3.5	125	56	22.0	18.0	27678	27678-1	27678-2	27678-3
M 33 x 3.5	125	56	25.0	20.0	27680	27680-1	27680-2	27680-3
M 36 x 4.0	150	63	28.0	22.0	27682	27682-1	27682-2	27682-3
M 39 x 4.0	150	63	32.0	24.0	27684	27684-1	27684-2	27684-3
M 42 x 4.5	150	63	32.0	24.0	27686	27686-1	27686-2	27686-3

D = Nominal Diameter

L1 = Overall Length

L2 = Thread Length

D2 = Shank Diameter

Square = Drive Connector



Hand taps (set of 3 pcs.)

JIS B-4430 HSS-G - M

(hand tap rougher, hand tap intermediate, hand tap finisher)

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Application/ for general use:

- > non abrasive material up to 900 N/mm²
- > unalloyed and low alloyed steel
- > for through and blind holes
- > for thread cutting by hand

Variants (21):



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Intermediate	Art.-No. Finisher
M 2 x 0.4	42	15	3.0	2.5	90414	90414-1	90414-2	90414-3
M 2.3 x 0.4	42	15	3.0	2.5	90416	90416-1	90416-2	90416-3
M 2.5 x 0.45	44	16	3.0	2.5	90418	90418-1	90418-2	90418-3
M 2.6 x 0.45	44	16	3.0	2.5	90420	90420-1	90420-2	90420-3
M 3 x 0.5	46	18	4.0	3.2	90422	90422-1	90422-2	90422-3
M 3.5 x 0.6	48	18	4.0	3.2	90424	90424-1	90424-2	90424-3
M 4 x 0.7	52	20	5.0	4.0	90426	90426-1	90426-2	90426-3
M 5 x 0.8	60	22	5.5	4.5	90430	90430-1	90430-2	90430-3
M 6 x 1.0	62	24	6.0	4.5	90438	90438-1	90438-2	90438-3
M 7 x 1.0	65	26	6.2	4.5	90444	90444-1	90444-2	90444-3
M 8 x 1.25	70	30	6.2	5.0	90446	90446-1	90446-2	90446-3
M 10 x 1.5	75	32	7.0	5.5	90454	90454-1	90454-2	90454-3
M 12 x 1.75	82	38	8.5	6.5	90460	90460-1	90460-2	90460-3
M 14 x 2.0	88	42	10.5	8.0	90466	90466-1	90466-2	90466-3
M 16 x 2.0	95	45	12.5	10.0	90472	90472-1	90472-2	90472-3
M 18 x 2.5	100	48	14.0	11.0	90478	90478-1	90478-2	90478-3
M 20 x 2.5	105	50	15.0	12.0	90484	90484-1	90484-2	90484-3
M 22 x 2.5	115	55	17.0	13.0	90490	90490-1	90490-2	90490-3
M 24 x 3.0	120	58	19.0	15.0	90496	90496-1	90496-2	90496-3
M 27 x 3.0	130	62	20.0	15.0	91402	91402-1	91402-2	91402-3
M 30 x 3.5	135	65	23.0	17.0	91408	91408-1	91408-2	91408-3

D = Nominal Diameter

L1 = Overall Length

L2 = Thread Length

D2 = Shank Diameter

Square = Drive Connector



Hand taps (set of 3 pcs.)

JIS B-4430 HSS-G - Mf

(hand tap rougher, hand tap intermediate, hand tap finisher)

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (24):

Application/ for general use:

- > non abrasive material up to 900 N/mm²
- > unalloyed and low alloyed steel
- > for through and blind holes
- > for thread cutting by hand



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Intermediate	Art.-No. Finisher
M 5 x 0.75	-	-	-	-	90431	90431-1	90431-2	90431-3
M 6 x 0.75	-	-	-	-	90440	90440-1	90440-2	90440-3
M 8 x 1.0	-	-	-	-	90448	90448-1	90448-2	90448-3
M 8 x 0.75	-	-	-	-	90450	90450-1	90450-2	90450-3
M 10 x 1.25	-	-	-	-	90455	90455-1	90455-2	90455-3
M 10 x 1.0	-	-	-	-	90456	90456-1	90456-2	90456-3
M 12 x 1.5	-	-	-	-	90462	90462-1	90462-2	90462-3
M 12 x 1.25	-	-	-	-	90463	90463-1	90463-2	90463-3
M 12 x 1.0	-	-	-	-	90464	90464-1	90464-2	90464-3
M 14 x 1.5	-	-	-	-	90468	90468-1	90468-2	90468-3
M 14 x 1.25	-	-	-	-	90469	90469-1	90469-2	90469-3
M 14 x 1.0	-	-	-	-	90470	90470-1	90470-2	90470-3
M 16 x 1.5	-	-	-	-	90474	90474-1	90474-2	90474-3
M 16 x 1.0	-	-	-	-	90476	90476-1	90476-2	90476-3
M 18 x 1.5	-	-	-	-	90480	90480-1	90480-2	90480-3
M 18 x 1.0	-	-	-	-	90482	90482-1	90482-2	90482-3
M 20 x 1.5	-	-	-	-	90486	90486-1	90486-2	90486-3
M 20 x 1.0	-	-	-	-	90488	90488-1	90488-2	90488-3
M 22 x 1.5	-	-	-	-	90492	90492-1	90492-2	90492-3
M 22 x 2.0	-	-	-	-	90493	90493-1	90493-2	90493-3
M 22 x 1.0	-	-	-	-	90494	90494-1	90494-2	90494-3
M 24 x 1.5	-	-	-	-	90498	90498-1	90498-2	90498-3
M 27 x 1.5	-	-	-	-	91406	91406-1	91406-2	91406-3
M 30 x 1.5	-	-	-	-	91409	91409-1	91409-2	91409-3



M (metric) left hand

Hand taps, metric ISO-thread DIN 13

HSS-G Hand taps for non abrasive materials up to 900 N/mm² and for thread cutting in through or blind holes.



Hand taps for metric left hand threads

- Hand taps acc. to DIN 352 and ISO 529 standard
- Variations from M 3 LH to M 52 LH



Hand taps, left hand (set of 23 pcs.) (47075)

incl. ratchet M 3 LH - M 12 LH

Type of thread	Standard	Material	Packing	Size
metric ISO thread DIN 13	DIN Standard	HSS-G	in plastic case	Diameter M 3 - 12

Application/for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand
- small and handy problemsolver for standard application
- the most popular dimensions in one case
- HSS-G Hand taps acc. to DIN 352

All threading tools, threading tool holder and accessories can also be ordered separately.

Contents:

	Art. -No.
1x HSS-G Hand taps (set of 3 pcs.) M 3 LH	27026
1x HSS-G Hand taps (set of 3 pcs.) M 4 LH	27030
1x HSS-G Hand taps (set of 3 pcs.) M 5 LH	27034
1x HSS-G Hand taps (set of 3 pcs.) M 6 LH	27038
1x HSS-G Hand taps (set of 3 pcs.) M 8 LH	27042
1x HSS-G Hand taps (set of 3 pcs.) M 10 LH	27046
1x HSS-G Hand taps (set of 3 pcs.) M 12 LH	27050
1x Adjustable tap wrench, zinc die cast No. 1.1/2	13015
1x Tap holder with ratchet, size 1	10001



Hand taps (set of 3 pcs.) left hand

DIN 352 HSS-G - M LH

(hand tap taper, hand tap second, hand tap finisher)

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Application/ for general use:

- > non abrasive material up to 900 N/mm²
- > unalloyed and low alloyed steel
- > for through and blind holes
- > for thread cutting by hand

Variants (22):



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Intermediate	Art.-No. Finisher
M 3 x 0.5	40	11	3.5	2.7	27026	27026-1	27026-2	27026-3
M 4 x 0.7	45	13	4.5	3.4	27030	27030-1	27030-2	27030-3
M 5 x 0.8	50	16	6.0	4.9	27034	27034-1	27034-2	27034-3
M 6 x 1.0	50	19	6.0	4.9	27038	27038-1	27038-2	27038-3
M 8 x 1.25	56	22	6.0	4.9	27042	27042-1	27042-2	27042-3
M 10 x 1.5	70	24	7.0	5.5	27046	27046-1	27046-2	27046-3
M 12 x 1.75	75	29	9.0	7.0	27050	27050-1	27050-2	27050-3
M 14 x 2.0	80	30	11.0	9.0	27054	27054-1	27054-2	27054-3
M 16 x 2.0	80	32	12.0	9.0	27058	27058-1	27058-2	27058-3
M 18 x 2.5	95	40	14.0	11.0	27062	27062-1	27062-2	27062-3
M 20 x 2.5	95	40	16.0	12.0	27066	27066-1	27066-2	27066-3
M 22 x 2.5	100	40	18.0	14.5	27070	27070-1	27070-2	27070-3
M 24 x 3.0	110	50	18.0	14.5	27074	27074-1	27074-2	27074-3
M 27 x 3.0	110	50	20.0	16.0	27076	27076-1	27076-2	27076-3
M 30 x 3.5	125	56	22.0	18.0	27078	27078-1	27078-2	27078-3
M 33 x 3.5	125	56	25.0	20.0	27080	27080-1	27080-2	27080-3
M 36 x 4.0	150	63	28.0	22.0	27082	27082-1	27082-2	27082-3
M 39 x 4.0	150	63	32.0	24.0	27084	27084-1	27084-2	27084-3
M 42 x 4.5	150	63	32.0	24.0	27086	27086-1	27086-2	27086-3
M 45 x 4.5	160	70	36.0	29.0	27088	27088-1	27088-2	27088-3
M 48 x 5.0	180	75	36.0	29.0	27090	27090-1	27090-2	27090-3
M 52 x 5.0	180	75	40.0	32.0	27092	27092-1	27092-2	27092-3

D = Nominal Diameter

L1 = Overall Length

L2 = Thread Length

D2 = Shank Diameter

Square = Drive Connector



Hand taps (set of 3 pcs.) left hand

ISO 529 HSS-G - M LH

(hand tap taper, hand tap second, hand tap finisher)

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (15):

Application/ for general use:

- > non abrasive material up to 900 N/mm²
- > unalloyed and low alloyed steel
- > for through and blind holes
- > for thread cutting by hand

D	L1	L2	D2	Square	Art.-No. Set
M 3 x 0.5	48	11	3.15	2.5	80326
M 4 x 0.7	53	13	4.0	3.15	80330
M 5 x 0.8	58	16	5.0	4.0	80334
M 6 x 1.0	66	19	6.3	5.0	80338
M 8 x 1.25	72	22	8.0	6.3	80342
M 10 x 1.5	80	24	10.0	8.0	80346
M 12 x 1.75	89	29	9.0	7.1	80350
M 14 x 2.0	95	30	11.2	9.0	80354
M 16 x 2.0	102	32	12.5	10.0	80358
M 18 x 2.5	110	37	14.0	11.2	80362
M 20 x 2.5	112	37	14.0	11.2	80366
M 22 x 2.5	118	35	16.0	12.5	80370
M 24 x 3.0	130	45	18.0	14.0	80374
M 27 x 3.0	135	45	20.0	16.0	80376
M 30 x 3.5	138	48	20.0	18.0	80378



Mf (metric fine)



Hand taps, metric ISO-thread DIN 13

HSS-G Hand taps for non abrasive material up to 900 N/mm² tensile strength. The taps made of HSS-E are suitable for abrasive steels up to 1200 N/mm². All taps are also suitable for through and blind holes.

Hand taps for right hand threads, metric fine

- Hand taps acc. to DIN 2181 and ISO 529
- Variations from M 2x0.35 to M 110x4.0



Hand taps (set of 2 pcs.)

DIN 2181 HSS-G - Mf
(hand tap rougher, hand tap finisher)

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (268):

Application/ for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Finisher
M 2.5 x 0.35	40	9	2.8	2.1	26304	26304-1	26304-2
M 2.6 x 0.35	40	9	2.8	2.1	26305	26305-1	26305-2
M 3 x 0.35	40	9	3.5	2.7	26308	26308-1	26308-2
M 3.5 x 0.35	45	10	4.0	3.0	26309	26309-1	26309-2
M 4 x 0.35	45	10	4.5	3.4	26310	26310-1	26310-2
M 4 x 0.5	45	10	4.5	3.4	26312	26312-1	26312-2
M 4.5 x 0.5	50	12	6.0	4.9	26313	26313-1	26313-2
M 5 x 0.5	50	12	6.0	4.9	26314	26314-1	26314-2
M 5.5 x 0.5	50	12	6.0	4.9	26315	26315-1	26315-2
M 5 x 0.75	50	12	6.0	4.9	26316	26316-1	26316-2
M 6 x 0.5	50	14	6.0	4.9	26317	26317-1	26317-2
M 6 x 0.75	50	14	6.0	4.9	26318	26318-1	26318-2
M 7 x 0.5	50	14	6.0	4.9	26319	26319-1	26319-2
M 7 x 0.75	50	14	6.0	4.9	26320	26320-1	26320-2
M 8 x 0.5	50	19	6.0	4.9	26322	26322-1	26322-2
M 8 x 0.75	50	19	6.0	4.9	26324	26324-1	26324-2
M 8 x 1.0	56	22	6.0	4.9	26326	26326-1	26326-2

D = Nominal Diameter L1 = Overall Length L2 = Thread Length D2 = Shank Diameter Square = Drive Connector



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Finisher
M 9 x 0.5	56	19	7.0	5.5	26327	26327-1	26327-2
M 9 x 0.75	56	19	7.0	5.5	26328	26328-1	26328-2
M 9 x 1.0	63	20	7.0	5.5	26330	26330-1	26330-2
M 10 x 0.5	63	20	7.0	5.5	26331	26331-1	26331-2
M 10 x 0.75	63	20	7.0	5.5	26332	26332-1	26332-2
M 10 x 1.0	63	20	7.0	5.5	26336	26336-1	26336-2
M 10 x 1.25	70	24	7.0	5.5	26338	26338-1	26338-2
M 11 x 0.75	63	20	8.0	6.2	26339	26339-1	26339-2
M 11 x 1.0	63	20	8.0	6.2	26340	26340-1	26340-2
M 11 x 1.25	63	22	8.0	6.2	26342	26342-1	26342-2
M 12 x 0.5	70	22	9.0	7.0	26345	26345-1	26345-2
M 12 x 0.75	70	22	9.0	7.0	26343	26343-1	26343-2
M 12 x 1.0	70	22	9.0	7.0	26344	26344-1	26344-2
M 12 x 1.25	70	22	9.0	7.0	26346	26346-1	26346-2
M 12 x 1.5	70	22	9.0	7.0	26348	26348-1	26348-2
M 13 x 0.5	70	22	11.0	9.0	26347	26347-1	26347-2
M 13 x 0.75	70	22	11.0	9.0	26349	26349-1	26349-2
M 13 x 1.0	70	22	11.0	9.0	26350	26350-1	26350-2
M 13 x 1.5	70	22	11.0	9.0	26351	26351-1	26351-2
M 14 x 0.5	70	22	11.0	9.0	26355	26355-1	26355-2
M 14 x 0.75	70	22	11.0	9.0	26352	26352-1	26352-2
M 14 x 1.0	70	22	11.0	9.0	26353	26353-1	26353-2
M 14 x 1.25	70	22	11.0	9.0	26354	26354-1	26354-2
M 14 x 1.5	70	22	11.0	9.0	26356	26356-1	26356-2
M 15 x 0.75	70	22	12.0	9.0	26357	26357-1	26357-2
M 15 x 1.0	70	22	12.0	9.0	26358	26358-1	26358-2
M 15 x 1.5	70	22	12.0	9.0	26360	26360-1	26360-2
M 16 x 0.5	70	22	12.0	9.0	26361	26361-1	26361-2
M 16 x 0.75	70	22	12.0	9.0	26363	26363-1	26363-2
M 16 x 1.0	70	22	12.0	9.0	26362	26362-1	26362-2
M 16 x 1.25	70	22	12.0	9.0	26364	26364-1	26364-2
M 16 x 1.5	70	22	12.0	9.0	26366	26366-1	26366-2
M 17 x 1.0	70	22	12.0	9.0	26368	26368-1	26368-2
M 17 x 1.5	70	22	12.0	9.0	26369	26369-1	26369-2
M 18 x 0.5	80	22	14.0	11.0	26367	26367-1	26367-2
M 18 x 0.75	80	22	14.0	11.0	26373	26373-1	26373-2
M 18 x 1.0	80	22	14.0	11.0	26370	26370-1	26370-2
M 18 x 1.25	80	22	14.0	11.0	26371	26371-1	26371-2
M 18 x 1.5	80	22	14.0	11.0	26372	26372-1	26372-2
M 18 x 2.0	80	22	14.0	11.0	26374	26374-1	26374-2
M 19 x 1.0	80	22	14.0	11.0	26375	26375-1	26375-2
M 19 x 1.5	80	22	14.0	11.0	26376	26376-1	26376-2



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Finisher
M 20 x 0.5	80	22	16.0	12.0	26377	26377-1	26377-2
M 20 x 0.75	80	22	16.0	12.0	26379	26379-1	26379-2
M 20 x 1.0	80	22	16.0	12.0	26378	26378-1	26378-2
M 20 x 1.25	80	22	16.0	12.0	26380	26380-1	26380-2
M 20 x 1.5	80	22	16.0	12.0	26384	26384-1	26384-2
M 20 x 2.0	80	22	16.0	12.0	26386	26386-1	26386-2
M 21 x 1.0	80	22	16.0	12.0	26387	26387-1	26387-2
M 21 x 1.5	80	22	16.0	12.0	26388	26388-1	26388-2
M 22 x 0.5	80	22	18.0	14.5	26389	26389-1	26389-2
M 22 x 0.75	80	22	18.0	14.5	26391	26391-1	26391-2
M 22 x 1.0	80	22	18.0	14.5	26390	26390-1	26390-2
M 22 x 1.25	80	22	18.0	14.5	26392	26392-1	26392-2
M 22 x 1.5	80	22	18.0	14.5	26394	26394-1	26394-2
M 22 x 2.0	80	22	18.0	14.5	26396	26396-1	26396-2
M 23 x 1.0	80	22	18.0	14.5	26397	26397-1	26397-2
M 23 x 1.5	80	22	18.0	14.5	26398	26398-1	26398-2
M 24 x 0.5	90	22	18.0	14.5	26501	26501-1	26501-2
M 24 x 0.75	90	22	18.0	14.5	26503	26503-1	26503-2
M 24 x 1.0	90	22	18.0	14.5	26500	26500-1	26500-2
M 24 x 1.25	90	22	18.0	14.5	26502	26502-1	26502-2
M 24 x 1.5	90	22	18.0	14.5	26504	26504-1	26504-2
M 24 x 2.0	90	22	18.0	14.5	26506	26506-1	26506-2
M 25 x 1.0	90	22	18.0	14.5	26507	26507-1	26507-2
M 25 x 1.5	90	22	18.0	14.5	26508	26508-1	26508-2
M 26 x 1.0	90	22	18.0	14.5	26510	26510-1	26510-2
M 26 x 1.5	90	22	18.0	14.5	26512	26512-1	26512-2
M 26 x 2.0	90	22	18.0	14.5	26514	26514-1	26514-2
M 27 x 1.0	90	22	18.0	16.0	26516	26516-1	26516-2
M 27 x 1.5	90	22	20.0	16.0	26517	26517-1	26517-2
M 27 x 2.0	90	22	20.0	16.0	26518	26518-1	26518-2
M 28 x 1.0	90	22	20.0	16.0	26520	26520-1	26520-2
M 28 x 1.5	90	22	20.0	16.0	26522	26522-1	26522-2
M 28 x 2.0	90	22	20.0	16.0	26524	26524-1	26524-2
M 29 x 1.5	90	22	22.0	18.0	26526	26526-1	26526-2
M 30 x 1.0	90	22	22.0	18.0	26528	26528-1	26528-2
M 30 x 1.5	90	22	22.0	18.0	26530	26530-1	26530-2
M 30 x 2.0	90	22	22.0	18.0	26532	26532-1	26532-2
M 30 x 2.5	125	56	22.0	18.0	26533	26533-1	26533-2
M 30 x 3.0	125	56	22.0	18.0	26534	26534-1	26534-2
M 32 x 1.0	90	22	22.0	18.0	26539	26539-1	26539-2
M 32 x 1.5	90	22	22.0	18.0	26536	26536-1	26536-2
M 32 x 2.0	90	22	22.0	18.0	26535	26535-1	26535-2



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Finisher
M 32 x 3.0	125	56	22.0	18.0	26537	26537-1	26537-2
M 33 x 1.5	100	25	25.0	20.0	26538	26538-1	26538-2
M 33 x 2.0	100	25	25.0	20.0	26540	26540-1	26540-2
M 33 x 3.0	125	56	25.0	20.0	26542	26542-1	26542-2
M 34 x 1.0	100	25	28.0	22.0	26543	26543-1	26543-2
M 34 x 1.5	100	25	28.0	22.0	26544	26544-1	26544-2
M 34 x 2.0	125	40	28.0	22.0	26546	26546-1	26546-2
M 35 x 1.0	100	25	28.0	22.0	26547	26547-1	26547-2
M 35 x 1.5	100	25	28.0	22.0	26548	26548-1	26548-2
M 35 x 2.0	125	40	28.0	22.0	26549	26549-1	26549-2
M 36 x 1.0	100	25	28.0	22.0	26551	26551-1	26551-2
M 36 x 1.5	100	25	28.0	22.0	26550	26550-1	26550-2
M 36 x 2.0	125	40	28.0	22.0	26552	26552-1	26552-2
M 36 x 3.0	125	40	28.0	22.0	26554	26554-1	26554-2
M 37 x 1.5	100	25	28.0	22.0	26553	26553-1	26553-2
M 38 x 1.0	100	25	28.0	22.0	26555	26555-1	26555-2
M 38 x 1.5	100	25	28.0	22.0	26556	26556-1	26556-2
M 38 x 2.0	125	40	28.0	22.0	26557	26557-1	26557-2
M 38 x 3.0	125	40	28.0	22.0	26559	26559-1	26559-2
M 39 x 1.5	110	25	32.0	24.0	26558	26558-1	26558-2
M 39 x 2.0	125	40	32.0	24.0	26560	26560-1	26560-2
M 39 x 3.0	125	40	32.0	24.0	26562	26562-1	26562-2
M 40 x 1.0	110	25	32.0	24.0	26563	26563-1	26563-2
M 40 x 1.5	110	25	32.0	24.0	26564	26564-1	26564-2
M 40 x 2.0	125	40	32.0	24.0	26566	26566-1	26566-2
M 40 x 3.0	125	40	32.0	24.0	26568	26568-1	26568-2
M 42 x 1.0	110	25	32.0	24.0	26569	26569-1	26569-2
M 42 x 1.5	110	25	32.0	24.0	26570	26570-1	26570-2
M 42 x 2.0	125	40	32.0	24.0	26572	26572-1	26572-2
M 42 x 3.0	125	40	32.0	24.0	26574	26574-1	26574-2
M 44 x 1.5	110	25	36.0	29.0	26571	26571-1	26571-2
M 44 x 2.0	125	40	36.0	29.0	26573	26573-1	26573-2
M 45 x 1.0	110	25	36.0	29.0	26575	26575-1	26575-2
M 45 x 1.5	110	25	36.0	29.0	26576	26576-1	26576-2
M 45 x 2.0	125	40	36.0	29.0	26578	26578-1	26578-2
M 45 x 3.0	125	40	36.0	29.0	26580	26580-1	26580-2
M 46 x 1.5	140	40	36.0	29.0	26581	26581-1	26581-2
M 48 x 1.0	140	40	36.0	29.0	26583	26583-1	26583-2
M 48 x 1.5	140	40	36.0	29.0	26582	26582-1	26582-2
M 48 x 2.0	140	40	36.0	29.0	26584	26584-1	26584-2
M 48 x 3.0	140	40	36.0	29.0	26586	26586-1	26586-2
M 50 x 1.5	140	40	36.0	29.0	26588	26588-1	26588-2



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Finisher
M 50 x 2.0	140	40	36.0	29.0	26590	26590-1	26590-2
M 50 x 3.0	140	40	36.0	29.0	26592	26592-1	26592-2
M 52 x 1.5	140	40	40.0	32.0	26594	26594-1	26594-2
M 52 x 2.0	140	40	40.0	32.0	26596	26596-1	26596-2
M 52 x 3.0	140	40	40.0	32.0	26598	26598-1	26598-2
M 54 x 1.0	140	32	40.0	32.0	28118	28118-1	28118-2
M 54 x 1.5	140	32	40.0	32.0	28001	28001-1	28001-2
M 54 x 2.0	140	36	40.0	32.0	28002	28002-1	28002-2
M 54 x 3.0	140	40	40.0	32.0	28003	28003-1	28003-2
M 54 x 4.0	180	50	40.0	32.0	28004	28004-1	28004-2
M 55 x 1.5	140	32	40.0	32.0	28005	28005-1	28005-2
M 55 x 2.0	140	36	40.0	32.0	28006	28006-1	28006-2
M 55 x 3.0	140	40	40.0	32.0	28007	28007-1	28007-2
M 55 x 4.0	180	50	40.0	32.0	28008	28008-1	28008-2
M 56 x 1.0	140	32	40.0	32.0	28119	28119-1	28119-2
M 56 x 1.5	140	32	40.0	32.0	28009	28009-1	28009-2
M 56 x 2.0	140	36	40.0	32.0	28010	28010-1	28010-2
M 56 x 3.0	140	40	40.0	32.0	28011	28011-1	28011-2
M 56 x 4.0	180	50	40.0	32.0	28012	28012-1	28012-2
M 58 x 1.0	160	32	45.0	35.0	28120	28120-1	28120-2
M 58 x 1.5	160	32	45.0	35.0	28013	28013-1	28013-2
M 58 x 2.0	160	36	45.0	35.0	28014	28014-1	28014-2
M 58 x 3.0	160	40	45.0	35.0	28015	28015-1	28015-2
M 58 x 4.0	200	55	45.0	35.0	28016	28016-1	28016-2
M 60 x 1.5	160	34	45.0	35.0	28017	28017-1	28017-2
M 60 x 2.0	160	36	45.0	35.0	28018	28018-1	28018-2
M 60 x 3.0	160	40	45.0	35.0	28019	28019-1	28019-2
M 60 x 4.0	200	55	45.0	35.0	28020	28020-1	28020-2
M 62 x 1.5	160	34	50.0	39.0	28021	28021-1	28021-2
M 62 x 2.0	160	36	50.0	39.0	28022	28022-1	28022-2
M 62 x 3.0	180	45	50.0	39.0	28023	28023-1	28023-2
M 62 x 4.0	220	55	50.0	39.0	28024	28024-1	28024-2
M 63 x 1.5	160	32	50.0	39.0	28025	28025-1	28025-2
M 64 x 1.5	160	34	50.0	39.0	28026	28026-1	28026-2
M 64 x 2.0	160	36	50.0	39.0	28027	28027-1	28027-2
M 64 x 3.0	180	45	50.0	39.0	28028	28028-1	28028-2
M 64 x 4.0	220	60	50.0	39.0	28029	28029-1	28029-2
M 65 x 1.5	160	34	50.0	39.0	28030	28030-1	28030-2
M 65 x 2.0	160	36	50.0	39.0	28031	28031-1	28031-2
M 65 x 3.0	180	45	50.0	39.0	28032	28032-1	28032-2
M 65 x 4.0	220	60	50.0	39.0	28033	28033-1	28033-2
M 68 x 1.5	160	36	50.0	39.0	28034	28034-1	28034-2



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Finisher
M 68 x 2.0	160	40	50.0	39.0	28035	28035-1	28035-2
M 68 x 3.0	180	50	50.0	39.0	28036	28036-1	28036-2
M 68 x 4.0	220	60	50.0	39.0	28037	28037-1	28037-2
M 70 x 1.5	160	36	50.0	39.0	28038	28038-1	28038-2
M 70 x 2.0	160	40	50.0	39.0	28039	28039-1	28039-2
M 70 x 3.0	200	50	50.0	39.0	28040	28040-1	28040-2
M 70 x 4.0	240	60	50.0	39.0	28041	28041-1	28041-2
M 72 x 1.5	160	36	50.0	39.0	28042	28042-1	28042-2
M 72 x 2.0	160	40	50.0	39.0	28043	28043-1	28043-2
M 72 x 3.0	200	50	50.0	39.0	28044	28044-1	28044-2
M 72 x 4.0	240	60	50.0	39.0	28045	28045-1	28045-2
M 74 x 1.5	160	36	50.0	39.0	28046	28046-1	28046-2
M 74 x 2.0	160	40	50.0	39.0	28047	28047-1	28047-2
M 74 x 3.0	200	50	50.0	39.0	28048	28048-1	28048-2
M 74 x 4.0	240	60	50.0	39.0	28049	28049-1	28049-2
M 75 x 1.5	160	36	50.0	39.0	28050	28050-1	28050-2
M 75 x 2.0	160	40	50.0	39.0	28051	28051-1	28051-2
M 75 x 3.0	200	50	50.0	39.0	28052	28052-1	28052-2
M 75 x 4.0	240	60	50.0	39.0	28053	28053-1	28053-2
M 76 x 1.5	160	36	50.0	39.0	28054	28054-1	28054-2
M 76 x 2.0	160	40	50.0	39.0	28055	28055-1	28055-2
M 76 x 3.0	220	50	50.0	39.0	28056	28056-1	28056-2
M 76 x 4.0	260	60	50.0	39.0	28057	28057-1	28057-2
M 78 x 1.5	160	36	50.0	39.0	28058	28058-1	28058-2
M 78 x 2.0	160	40	50.0	39.0	28059	28059-1	28059-2
M 78 x 3.0	220	55	50.0	39.0	28060	28060-1	28060-2
M 78 x 4.0	260	65	50.0	39.0	28061	28061-1	28061-2
M 80 x 1.5	160	36	50.0	39.0	28062	28062-1	28062-2
M 80 x 2.0	160	40	50.0	39.0	28063	28063-1	28063-2
M 80 x 3.0	220	55	50.0	39.0	28064	28064-1	28064-2
M 80 x 4.0	260	65	50.0	39.0	28065	28065-1	28065-2
M 82 x 1.5	160	36	50.0	39.0	28066	28066-1	28066-2
M 82 x 2.0	160	40	50.0	39.0	28067	28067-1	28067-2
M 82 x 3.0	220	55	50.0	39.0	28068	28068-1	28068-2
M 82 x 4.0	260	65	50.0	39.0	28069	28069-1	28069-2
M 84 x 1.5	160	36	50.0	39.0	28070	28070-1	28070-2
M 84 x 2.0	160	40	50.0	39.0	28071	28071-1	28071-2
M 84 x 3.0	220	55	50.0	39.0	28072	28072-1	28072-2
M 84 x 4.0	260	65	50.0	39.0	28073	28073-1	28073-2
M 85 x 1.5	160	36	50.0	39.0	28074	28074-1	28074-2
M 85 x 2.0	160	40	50.0	39.0	28075	28075-1	28075-2
M 85 x 3.0	220	55	50.0	39.0	28076	28076-1	28076-2



D		L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Finisher
M	85 x 4.0	260	65	50.0	39.0	28077	28077-1	28077-2
M	86 x 1.5	160	36	50.0	39.0	28078	28078-1	28078-2
M	86 x 2.0	160	40	50.0	39.0	28079	28079-1	28079-2
M	86 x 3.0	220	55	50.0	39.0	28080	28080-1	28080-2
M	86 x 4.0	260	65	50.0	39.0	28081	28081-1	28081-2
M	88 x 1.5	160	38	50.0	39.0	28082	28082-1	28082-2
M	88 x 2.0	160	40	50.0	39.0	28083	28083-1	28083-2
M	88 x 3.0	220	55	50.0	39.0	28084	28084-1	28084-2
M	88 x 4.0	260	65	50.0	39.0	28085	28085-1	28085-2
M	90 x 1.5	160	38	50.0	39.0	28086	28086-1	28086-2
M	90 x 2.0	160	40	50.0	39.0	28087	28087-1	28087-2
M	90 x 3.0	220	55	50.0	39.0	28088	28088-1	28088-2
M	90 x 4.0	260	65	50.0	39.0	28089	28089-1	28089-2
M	92 x 1.5	180	40	56.0	44.0	28090	28090-1	28090-2
M	92 x 2.0	180	45	56.0	44.0	28091	28091-1	28091-2
M	92 x 3.0	240	60	56.0	44.0	28092	28092-1	28092-2
M	92 x 4.0	280	70	56.0	44.0	28093	28093-1	28093-2
M	95 x 1.5	180	40	56.0	44.0	28094	28094-1	28094-2
M	95 x 2.0	180	45	56.0	44.0	28095	28095-1	28095-2
M	95 x 3.0	240	60	56.0	44.0	28096	28096-1	28096-2
M	95 x 4.0	280	70	56.0	44.0	28097	28097-1	28097-2
M	96 x 1.5	180	40	56.0	44.0	28098	28098-1	28098-2
M	96 x 2.0	180	45	56.0	44.0	28099	28099-1	28099-2
M	96 x 3.0	240	60	56.0	44.0	28100	28100-1	28100-2
M	96 x 4.0	280	70	56.0	44.0	28101	28101-1	28101-2
M	98 x 1.5	180	40	56.0	44.0	28102	28102-1	28102-2
M	98 x 2.0	180	45	56.0	44.0	28103	28103-1	28103-2
M	98 x 3.0	240	60	56.0	44.0	28104	28104-1	28104-2
M	98 x 4.0	280	70	56.0	44.0	28105	28105-1	28105-2
M	100 x 1.5	180	45	56.0	44.0	28106	28106-1	28106-2
M	100 x 2.0	180	50	56.0	44.0	28107	28107-1	28107-2
M	100 x 3.0	240	65	56.0	44.0	28108	28108-1	28108-2
M	100 x 4.0	280	75	56.0	44.0	28109	28109-1	28109-2
M	105 x 1.5	180	45	56.0	44.0	28110	28110-1	28110-2
M	105 x 2.0	180	50	56.0	44.0	28111	28111-1	28111-2
M	105 x 3.0	240	65	56.0	44.0	28112	28112-1	28112-2
M	105 x 4.0	280	75	56.0	44.0	28113	28113-1	28113-2
M	110 x 1.5	180	45	56.0	44.0	28114	28114-1	28114-2
M	110 x 2.0	180	50	56.0	44.0	28115	28115-1	28115-2
M	110 x 3.0	240	65	56.0	44.0	28116	28116-1	28116-2
M	110 x 4.0	280	75	56.0	44.0	28117	28117-1	28117-2



Hand taps (set of 2 pcs.)

DIN 2181 HSS-E - Mf

(hand tap rougher, hand tap finisher)

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (18):

Advantages:

- > high cutting ability

Application:

- > abrasive material
- > Steel up to 1200 N/mm²
- > fard for general use



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Finisher
M 6 x 0.75	50	14	6.0	4.9	56318	56318-1	56318-2
M 8 x 0.75	50	19	6.0	4.9	56324	56324-1	56324-2
M 8 x 1.0	56	22	6.0	4.9	56326	56326-1	56326-2
M 10 x 1.0	63	20	7.0	5.5	56336	56336-1	56336-2
M 10 x 1.25	70	24	7.0	5.5	56338	56338-1	56338-2
M 12 x 1.0	70	22	9.0	7.0	56344	56344-1	56344-2
M 12 x 1.25	70	22	9.0	7.0	56346	56346-1	56346-2
M 12 x 1.5	70	22	9.0	7.0	56348	56348-1	56348-2
M 14 x 1.25	70	22	11.0	9.0	56354	56354-1	56354-2
M 14 x 1.5	70	22	11.0	9.0	56356	56356-1	56356-2
M 16 x 1.5	70	22	12.0	9.0	56366	56366-1	56366-2
M 18 x 1.5	80	22	14.0	11.0	56372	56372-1	56372-2
M 18 x 2.0	80	22	14.0	11.0	56374	56374-1	56374-2
M 20 x 1.5	80	22	16.0	12.0	56384	56384-1	56384-2
M 20 x 2.0	80	22	16.0	12.0	56386	56386-1	56386-2
M 22 x 1.5	80	22	18.0	14.5	56394	56394-1	56394-2
M 22 x 2.0	80	22	18.0	14.5	56396	56396-1	56396-2
M 24 x 1.5	90	22	18.0	14.5	56504	56504-1	56504-2

D = Nominal Diameter

L1 = Overall Length

L2 = Thread Length

D2 = Shank Diameter

Square = Drive Connector



Mf (metric fine) left hand



Hand taps, metric ISO-thread DIN 13

HSS-G Hand taps for non abrasive materials up to 900 N/mm² and for thread cutting in through or blind holes.

Hand taps for left hand threads, metric fine

- Hand taps acc. to DIN 2181 standard
- Variations from M 6x0.75 LH to M 30x2.0 LH



Hand taps (set of 2 pcs.)

DIN 2181 HSS-G - Mf LH
(hand tap rougher, hand tap finisher)

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (19):



Application/

for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Finisher
M 6 x 0.75	50	14	6.0	4.9	26007	26007-1	26007-2
M 8 x 0.75	50	19	6.0	4.9	26010	26010-1	26010-2
M 8 x 1.0	56	22	6.0	4.9	26011	26011-1	26011-2
M 10 x 1.0	63	20	7.0	5.5	26015	26015-1	26015-2
M 10 x 1.25	70	24	7.0	5.5	26016	26016-1	26016-2
M 12 x 1.0	70	22	9.0	7.0	26020	26020-1	26020-2
M 12 x 1.25	70	22	9.0	7.0	26021	26021-1	26021-2
M 12 x 1.5	70	22	9.0	7.0	26022	26022-1	26022-2
M 14 x 1.25	70	22	11.0	9.0	26027	26027-1	26027-2
M 14 x 1.5	70	22	11.0	9.0	26028	26028-1	26028-2
M 16 x 1.0	70	22	12.0	9.0	26031	26031-1	26031-2
M 16 x 1.5	70	22	12.0	9.0	26033	26033-1	26033-2
M 18 x 1.5	80	22	14.0	11.0	26036	26036-1	26036-2
M 20 x 1.5	80	22	16.0	12.0	26040	26040-1	26040-2
M 22 x 1.5	80	22	18.0	14.5	26045	26045-1	26045-2
M 24 x 1.5	90	22	18.0	14.5	26050	26050-1	26050-2
M 24 x 2.0	90	22	18.0	14.5	26051	26051-1	26051-2
M 30 x 1.5	90	22	22.0	18.0	26063	26063-1	26063-2
M 30 x 2.0	90	22	22.0	18.0	26064	26064-1	26064-2



BSW (Whitworth)



Hand taps, Whitworth-thread BS 84

Hand taps for BSW Whitworth threads made of HSS-G are suitable for machinable non abrasive materials up to 900 N/mm², for through and blind holes. Available in cylindrical and conical (non-serial) form.

Hand taps for BSW (Whitworth) right hand threads

- Hand taps (BSW) acc. to ≈ DIN 352 und ISO 529
- Variations from BSW 1/16 to BSW 3"



Hand taps (set of 3 pcs.)

≈ DIN DIN 352 HSS-G - BSW
(hand tap rougher, hand tap intermediate, hand tap finisher)

Type of thread: Whitworth-thread BS 84

Variants (28):

Application/ for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Intermediate	Art.-No. Finisher
BSW 1/16 x 60	36	10	2.5	2.1	22302	22302-1	22302-2	22302-3
BSW 3/32 x 48	36	10	2.8	2.1	22304	22304-1	22304-2	22304-3
BSW 1/8 x 40	40	12	3.5	2.7	22306	22306-1	22306-2	22306-3
BSW 5/32 x 32	45	14	5.6	3.4	22308	22308-1	22308-2	22308-3
BSW 3/16 x 24	50	18	6.0	4.9	22310	22310-1	22310-2	22310-3
BSW 7/32 x 24	50	18	6.0	4.9	22312	22312-1	22312-2	22312-3
BSW 1/4 x 20	50	19	6.0	4.9	22314	22314-1	22314-2	22314-3
BSW 5/16 x 18	56	22	6.0	4.9	22316	22316-1	22316-2	22316-3
BSW 3/8 x 16	70	24	7.0	5.5	22318	22318-1	22318-2	22318-3
BSW 7/16 x 14	70	24	8.0	6.2	22320	22320-1	22320-2	22320-3
BSW 1/2 x 12	75	29	9.0	7.0	22322	22322-1	22322-2	22322-3
BSW 9/16 x 12	80	30	11.0	9.0	22324	22324-1	22324-2	22324-3
BSW 5/8 x 11	80	32	12.0	9.0	22326	22326-1	22326-2	22326-3
BSW 3/4 x 10	95	40	14.0	11.0	22330	22330-1	22330-2	22330-3
BSW 7/8 x 9	100	40	18.0	14.5	22334	22334-1	22334-2	22334-3
BSW 1" x 8	110	50	18.0	14.5	22338	22338-1	22338-2	22338-3

D = Nominal Diameter L1 = Overall Length L2 = Thread Length D2 = Shank Diameter Square = Drive Connector



D		L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Intermediate	Art.-No. Finisher
BSW	1.1/8 x 7	132	56	22.0	18.0	22342	22342-1	22342-2	22342-3
BSW	1.1/4 x 7	132	56	22.0	18.0	22346	22346-1	22346-2	22346-3
BSW	1.3/8 x 6	150	63	28.0	22.0	22350	22350-1	22350-2	22350-3
BSW	1.1/2 x 6	150	63	32.0	24.0	22354	22354-1	22354-2	22354-3
BSW	1.5/8 x 5	160	70	32.0	24.0	22358	22358-1	22358-2	22358-3
BSW	1.3/4 x 5	160	70	36.0	29.0	22362	22362-1	22362-2	22362-3
BSW	1.7/8 x 4.1/2	190	80	36.0	29.0	22366	22366-1	22366-2	22366-3
BSW	2" x 4.1/2	190	80	40.0	32.0	22370	22370-1	22370-2	22370-3
BSW	2.1/4 x 4	220	80	45.0	35.0	22372	22372-1	22372-2	22372-3
BSW	2.1/2 x 4	220	80	50.0	39.0	22374	22374-1	22374-2	22374-3
BSW	2.3/4 x 3.1/2	240	80	50.0	39.0	22376	22376-1	22376-2	22376-3
BSW	3" x 3.1/2	260	80	50.0	39.0	22378	22378-1	22378-2	22378-3



Hand taps (set of 3 pcs.)

ISO 529 HSS-G - BSW

(hand tap rougher, hand tap intermediate, hand tap finisher)

Type of thread: Whitworth-thread BS 84

Variants (27):

Application/

for general use:

- > non abrasive material up to 900 N/mm²
- > unalloyed and low alloyed steel
- > for through and blind holes
- > for thread cutting by hand

D		L1	L2	D2	Square	Art.-No. Set
BSW	1/16 x 60	41	8	2.5	2.0	84402
BSW	3/32 x 48	44.5	9.5	2.8	2.24	84404
BSW	1/8 x 40	48	11	3.15	2.5	84406
BSW	5/32 x 32	53	13	4.0	3.15	84408
BSW	3/16 x 24	58	16	5.0	4.0	84410
BSW	7/32 x 24	62	17	5.6	4.5	84412
BSW	1/4 x 20	66	19	6.3	5.0	84414
BSW	9/32 x 20	72	22	8.0	6.3	84415
BSW	5/16 x 18	72	22	8.0	6.3	84416
BSW	3/8 x 16	82	24	10.0	8.0	84418
BSW	7/16 x 14	85	25	8.0	6.3	84420
BSW	1/2 x 12	89	29	9.0	7.1	84422
BSW	9/16 x 12	95	30	11.2	9.0	84424
BSW	5/8 x 11	102	32	12.5	10.0	84426

D = Nominal Diameter

L1 = Overall Length

L2 = Thread Length

D2 = Shank Diameter

Square = Drive Connector



D		L1	L2	D2	Square	Art.-No. Set
BSW	3/4 x 10	112	37	14.0	11.2	84430
BSW	7/8 x 9	118	38	16.0	12.5	84434
BSW	1" x 8	130	45	18.0	14.0	84438
BSW	1.1/8 x 7	138	48	20.0	16.0	84440
BSW	1.1/4 x 7	151	51	22.4	18.0	84442
BSW	1.3/8 x 6	162	57	25.0	20.0	84444
BSW	1.1/2 x 6	170	60	28.0	22.4	84446
BSW	1.5/8 x 5	170	60	28.0	22.4	84448
BSW	1.3/4 x 5	187	67	31.5	25.0	84450
BSW	1.7/8 x 4.1/2	187	67	31.5	25.0	84452
BSW	2" x 4.1/2	200	70	35.5	28.0	84454
BSW	2.1/4 x 4	221	76	40.0	31.5	84456
BSW	2.1/2 x 4	224	79	40.0	31.5	84458

D = Nominal Diameter

L1 = Overall Length

L2 = Thread Length

D2 = Shank Diameter

Square = Drive Connector



BSW (Whitworth) left hand



Hand taps, Whitworth-thread BS 84

Hand taps for BSW Whitworth left hand threads made of HSS-G are suitable for machinable non abrasive materials up to 900 N/mm² and for through and blind holes. Available in cylindrical and conical (non-serial) form.

Hand taps for BSW (Whitworth) left hand threads

- Hand taps (BSW) acc. to ≈ DIN 352 und ISO 529
- Variations from BSW 1/8 LH to BSW 1" LH



Hand taps (set of 3 pcs.) left hand

≈ DIN 352 HSS-G - BSW LH

(hand tap rougher, hand tap intermediate, hand tap finisher)

Type of thread: Whitworth-thread BS 84

Variants (13):

Application/ for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Intermediate	Art.-No. Finisher
BSW 1/8 x 40	40	12	3.5	2.7	22006	22006-1	22006-2	22006-3
BSW 5/32 x 32	45	14	4.5	3.4	22008	22008-1	22008-2	22008-3
BSW 3/16 x 24	50	18	6.0	4.9	22010	22010-1	22010-2	22010-3
BSW 1/4 x 20	50	19	6.0	4.9	22014	22014-1	22014-2	22014-3
BSW 5/16 x 18	56	22	6.0	4.9	22016	22016-1	22016-2	22016-3
BSW 3/8 x 16	70	24	7.0	5.5	22018	22018-1	22018-2	22018-3
BSW 7/16 x 14	70	24	8.0	6.2	22020	22020-1	22020-2	22020-3
BSW 1/2 x 12	75	29	9.0	7.0	22022	22022-1	22022-2	22022-3
BSW 9/16 x 12	80	30	11.0	9.0	22024	22024-1	22024-2	22024-3
BSW 5/8 x 11	80	32	12.0	9.0	22026	22026-1	22026-2	22026-3
BSW 3/4 x 10	95	40	14.0	11.0	22030	22030-1	22030-2	22030-3
BSW 7/8 x 9	100	40	18.0	14.5	22034	22034-1	22034-2	22034-3
BSW 1" x 8	110	50	18.0	14.5	22038	22038-1	22038-2	22038-3

D = Nominal Diameter

L1 = Overall Length

L2 = Thread Length

D2 = Shank Diameter

Square = Drive Connector



Hand taps (set of 3 pcs.) left hand

ISO 529 HSS-G - BSW LH

(hand tap rougher, hand tap intermediate, hand tap finisher)

Type of thread: Whitworth-thread BS 84

Variants (13):

Application/ for general use:

- > non abrasive material up to 900 N/mm²
- > unalloyed and low alloyed steel
- > for through and blind holes
- > for thread cutting by hand



D	L1	L2	D2	Square	Art.-No. Set
BSW 1/8 x 40	48	11	3.15	2.5	84307
BSW 5/32 x 32	53	13	4.0	3.15	84308
BSW 3/16 x 24	58	16	5.0	4.0	84309
BSW 1/4 x 20	66	19	6.3	5.0	84310
BSW 5/16 x 18	72	22	8.0	6.3	84311
BSW 3/8 x 16	80	24	10.0	8.0	84312
BSW 7/16 x 14	85	25	8.0	6.3	84313
BSW 1/2 x 12	89	29	9.0	7.1	84314
BSW 9/16 x 12	95	30	11.2	9.0	84315
BSW 5/8 x 11	102	32	12.5	10.0	84316
BSW 3/4 x 10	112	37	14.0	11.2	84317
BSW 7/8 x 9	118	38	16.0	12.5	84318
BSW 1" x 8	130	45	18.0	14.0	84319

D = Nominal Diameter

L1 = Overall Length

L2 = Thread Length

D2 = Shank Diameter

Square = Drive Connector



BSF (brit. standard fine)



Hand taps, British-Standard-Fine-thread BS 84

Hand taps for BSF threads made of HSS-G are suitable for machinable non abrasive materials up to 900 N/mm² and for through and blind holes. Available in cylindrical and conical (non-serial) form.

Hand taps for BSF right hand threads

- Hand taps (BSF) acc. to ≈ DIN 2181 und ISO 529
- Variations from BSF 3/16 to BSF 2.1/2"



Hand taps (set of 2 pcs.)

≈ DIN 2181 HSS-G - BSF (hand tap rougher, hand tap finisher)

Type of thread: British-Standard-Fine-thread BS 84

Variants (11):

Application/ for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Finisher
BSF 3/16 x 32	50	14	6.0	4.9	22710	22710-1	22710-3
BSF 1/4 x 26	50	18	6.0	4.9	22714	22714-1	22714-3
BSF 5/16 x 22	56	22	6.0	4.9	22716	22716-1	22716-3
BSF 3/8 x 20	63	22	7.0	5.5	22718	22718-1	22718-3
BSF 7/16 x 18	63	22	8.0	6.2	22720	22720-1	22720-3
BSF 1/2 x 16	75	24	9.0	7.0	22722	22722-1	22722-3
BSF 9/16 x 16	80	28	11.0	9.0	22724	22724-1	22724-3
BSF 5/8 x 14	80	28	12.0	9.0	22726	22726-1	22726-3
BSF 3/4 x 12	95	32	14.0	11.0	22730	22730-1	22730-3
BSF 7/8 x 11	100	36	18.0	14.5	22734	22734-1	22734-3
BSF 1" x 10	110	40	18.0	14.5	22738	22738-1	22738-3



Hand taps (set of 3 pcs.)

ISO 529 HSS-G - BSF

Type of thread: British-Standard-Fine-thread BS 84

Variants (21):

Application/ for general use:

- > non abrasive material up to 900 N/mm²
- > unalloyed and low alloyed steel
- > for through and blind holes
- > for thread cutting by hand

D		L1	L2	D2	Square	Art.-No. Set
BSF	3/16 x 32	58	16	5.0	4.0	85410
BSF	1/4 x 26	66	19	6.3	5.0	85414
BSF	5/16 x 22	69	19	8.0	6.3	85416
BSF	3/8 x 20	76	20	10.0	8.0	85418
BSF	7/16 x 18	82	22	8.0	6.3	85420
BSF	1/2 x 16	84	24	9.0	7.1	85422
BSF	9/16 x 16	90	25	11.2	9.0	85424
BSF	5/8 x 14	95	25	12.5	10.0	85426
BSF	3/4 x 12	104	29	14.0	11.2	85430
BSF	7/8 x 11	113	33	16.0	12.5	85434
BSF	1" x 10	120	35	18.0	14.0	85438
BSF	1.1/8 x 9	127	37	20.0	16.0	85440
BSF	1.1/4 x 9	137	37	22.4	18.0	85442
BSF	1.3/8 x 8	144	39	25.0	20.0	85444
BSF	1.1/2 x 8	149	45	28.0	22.4	85446
BSF	1.5/8 x 8	164	45	28.0	22.4	85448
BSF	1.3/4 x 7	164	45	31.5	25.0	85450
BSF	1.7/8 x 7	164	45	31.5	25.0	85452
BSF	2" x 7	175	47	35.5	28.0	85454
BSF	2.1/4 x 6	221	76	40.0	31.5	85456
BSF	2.1/2 x 6	224	79	40.0	31.5	85458



BA (brit. assn. thread)



Hand taps, BA-thread BS 93

Hand taps for BA-threads are suitable for machinable non abrasive material up to 900 N/mm² tensile strength, for through and blind holes and for threading in unalloyed and low alloyed steels.

Hand taps in conical (non-serial) form.

- Hand taps for BA-threads acc. to ISO 529
- Variations from BA 0 to BA 6



Hand taps (set of 3 pcs.) non-serial

ISO 529 HSS-G – BA

(hand tap rougher, hand tap intermediate, hand tap finisher)

Type of thread: BA-thread BS 93

Variants (7):

Application/ for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Intermediate	Art.-No. Finisher
BA 0	66	19	6.3	5.0	89400	89400-1	89400-2	89400-3
BA 1	62	17	5.6	4.5	89401	89401-1	89401-2	89401-3
BA 2	58	16	5.0	4.0	89402	89402-1	89402-2	89402-3
BA 3	53	13	4.5	3.55	89403	89403-1	89403-2	89403-3
BA 4	50	13	3.55	2.8	89404	89404-1	89404-2	89404-3
BA 5	48	11	3.15	2.5	89405	89405-1	89405-2	89405-3
BA 6	45	9.5	2.8	2.24	89406	89406-1	89406-2	89406-3



UNC (Unified Coarse)



Hand taps, Unified Coarse thread ANSI B 1.1

Hand taps for UNC threads suitable for non abrasive materials up to 900 N/mm² and for threading in through or blind holes.

Available in cylindrical and conical (non-serial) form.

Hand taps for american UNC right hand threads

- Hand taps (UNC) acc. to DIN, ISO and JIS-B standard
- Variations from UNC No. 1 to UNC 3"



Hand taps (set of 3 pcs.)

JIS B-4430 HSS-G - UNC

(hand tap rougher, hand tap intermediate, hand tap finisher)

Type of thread: Unified Coarse thread ANSI B 1.1

Tolerance: 2B

Variants (10):

Application/ for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Intermediate	Art.-No. Finisher
UNC 3/16	60	17	5.5	4.5	93413	93413-1	93413-2	93413-3
UNC 1/4	62	20	6.0	4.5	93414	93414-1	93414-2	93414-3
UNC 5/16	70	23	6.1	5.5	93415	93415-1	93415-2	93415-3
UNC 3/8	75	25	7.0	5.5	93416	93416-1	93416-2	93416-3
UNC 7/16	80	24	8.0	6.0	93417	93417-1	93417-2	93417-3
UNC 1/2	85	30	9.0	7.0	93418	93418-1	93418-2	93418-3
UNC 5/8	95	32	12.0	9.0	93420	93420-1	93420-2	93420-3
UNC 3/4	105	38	14.0	11.0	93422	93422-1	93422-2	93422-3
UNC 7/8	115	38	17.0	13.0	93424	93424-1	93424-2	93424-3
UNC 1"	126	45	20.0	15.0	93426	93426-1	93426-2	93426-3

D = Nominal Diameter

L1 = Overall Length

L2 = Thread Length

D2 = Shank Diameter

Square = Drive Connector



Hand taps (set of 3 pcs.)

ISO 529 HSS-G - UNC

Type of thread: Unified Coarse thread ANSI B 1.1

Tolerance: 2B

Variants (24):

Application/ for general use:

- > non abrasive material up to 900 N/mm²
- > unalloyed and low alloyed steel
- > for through and blind holes
- > for thread cutting by hand

D		L1	L2	D2	Square	Art.-No. Set
UNC	No. 4 x 40	48	11	3.2	2.5	82404
UNC	No. 5 x 40	48	11	3.2	2.5	82405
UNC	No. 6 x 32	50	13	3.6	2.8	82406
UNC	No. 8 x 32	53	13	4.5	2.8	82408
UNC	No. 10 x 24	58	16	5.0	4.0	82410
UNC	No. 12 x 24	62	17	5.6	4.5	82412
UNC	1/4 x 20	66	19	6.3	5.0	82414
UNC	5/16 x 18	72	22	8.0	6.3	82416
UNC	3/8 x 16	80	24	10.0	8.0	82418
UNC	7/16 x 14	85	25	8.0	6.3	82420
UNC	1/2 x 13	89	29	9.0	7.1	82422
UNC	9/16 x 12	95	30	11.2	9.0	82424
UNC	5/8 x 11	102	32	12.5	10.0	82426
UNC	3/4 x 10	112	37	14.0	11.2	82430
UNC	7/8 x 9	118	38	16.0	12.5	82434
UNC	1" x 8	130	45	18.0	14.0	82438
UNC	1.1/8 x 7	138	48	20.0	16.0	82440
UNC	1.1/4 x 7	151	51	22.4	18.0	82442
UNC	1.3/8 x 6	162	57	25.0	20.0	82444
UNC	1.1/2 x 6	170	60	28.0	22.4	82446
UNC	1.5/8 x 5	170	60	28.0	22.4	82447
UNC	1.3/4 x 5	187	67	31.5	25.0	82448
UNC	1.7/8 x 5	187	67	31.5	25.0	82449
UNC	2" x 4.5	200	70	35.5	28.0	82450

D = Nominal Diameter

L1 = Overall Length

L2 = Thread Length

D2 = Shank Diameter

Square = Drive Connector



Hand taps (set of 3 pcs.)

≈ DIN 352 HSS-G - UNC

(hand tap rougher, hand tap intermediate, hand tap finisher)

Type of thread: Unified Coarse thread ANSI B 1.1

Tolerance: 2B

Variants (31):

Application/ for general use:

- > non abrasive material up to 900 N/mm²
- > unalloyed and low alloyed steel
- > for through and blind holes
- > for thread cutting by hand



D		L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Intermediate	Art.-No. Finisher
UNC	No. 1 x 64	32	10	2.5	2.1	23301	23301-1	23301-2	23301-3
UNC	No. 2 x 56	36	11	2.8	2.1	23302	23302-1	23302-2	23302-3
UNC	No. 3 x 48	36	11	2.8	2.1	23303	23303-1	23303-2	23303-3
UNC	No. 4 x 40	40	12	3.5	2.7	23304	23304-1	23304-2	23304-3
UNC	No. 5 x 40	40	12	3.5	2.7	23305	23305-1	23305-2	23305-3
UNC	No. 6 x 32	45	14	4.0	3.0	23306	23306-1	23306-2	23306-3
UNC	No. 8 x 32	45	14	4.5	3.4	23308	23308-1	23308-2	23308-3
UNC	No. 10 x 24	50	16	6.0	4.9	23310	23310-1	23310-2	23310-3
UNC	No. 12 x 24	50	18	6.0	4.9	23312	23312-1	23312-2	23312-3
UNC	1/4 x 20	50	19	6.0	4.9	23314	23314-1	23314-2	23314-3
UNC	5/16 x 18	56	22	6.0	4.9	23316	23316-1	23316-2	23316-3
UNC	3/8 x 16	70	24	7.0	5.5	23318	23318-1	23318-2	23318-3
UNC	7/16 x 14	70	24	8.0	6.2	23320	23320-1	23320-2	23320-3
UNC	1/2 x 13	75	29	9.0	7.0	23322	23322-1	23322-2	23322-3
UNC	9/16 x 12	80	30	11.0	9.0	23324	23324-1	23324-2	23324-3
UNC	5/8 x 11	80	32	12.0	9.0	23326	23326-1	23326-2	23326-3
UNC	3/4 x 10	95	40	14.0	11.0	23330	23330-1	23330-2	23330-3
UNC	7/8 x 9	100	40	18.0	14.5	23334	23334-1	23334-2	23334-3
UNC	1" x 8	110	50	18.0	14.5	23338	23338-1	23338-2	23338-3
UNC	1.1/8 x 7	132	56	22.0	18.0	23342	23342-1	23342-2	23342-3
UNC	1.1/4 x 7	132	56	22.0	18.0	23346	23346-1	23346-2	23346-3
UNC	1.3/8 x 6	150	63	28.0	22.0	23350	23350-1	23350-2	23350-3
UNC	1.1/2 x 6	150	63	32.0	24.0	23354	23354-1	23354-2	23354-3
UNC	1.5/8 x 5	160	70	32.0	24.0	23358	23358-1	23358-2	23358-3
UNC	1.3/4 x 5	160	70	36.0	29.0	23362	23362-1	23362-2	23362-3
UNC	1.7/8 x 4.1/2	190	80	36.0	29.0	23366	23366-1	23366-2	23366-3
UNC	2" x 4.1/2	190	80	40.0	32.0	23370	23370-1	23370-2	23370-3
UNC	2.1/4 x 4.1/2	220	80	45.0	35.0	23372	23372-1	23372-2	23372-3
UNC	2.1/2 x 4	220	80	50.0	39.0	23374	23374-1	23374-2	23374-3
UNC	2.3/4 x 4	240	80	50.0	39.0	23376	23376-1	23376-2	23376-3
UNC	3" x 4	260	80	50.0	39.0	23378	23378-1	23378-2	23378-3

D = Nominal Diameter

L1 = Overall Length

L2 = Thread Length

D2 = Shank Diameter

Square = Drive Connector



UNC (Unified Coarse) left hand



Hand taps, Unified Coarse thread ANSI B 1.1

Hand taps for UNC left hand threads suitable for non abrasive materials up to 900 N/mm² and for threading in through or blind holes.

Available in cylindrical and conical (non-serial) form.

Hand taps for american UNC left hand threads

- Hand taps (UNC) acc. to DIN and ISO standard
- Variations from UNC No. 6 LH to UNC 1" LH



Hand taps (set of 3 pcs.) left hand

ISO 529 HSS-G - UNC LH

Type of thread: Unified Coarse thread ANSI B 1.1

Tolerance: 2B

Variants (10):

Application/ for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

D		L1	L2	D2	Square	Art.-No. Set
UNC	1/4 x 20	66	19	6.3	5.0	82310
UNC	5/16 x 18	72	22	8.0	6.3	82311
UNC	3/8 x 16	80	24	10.0	8.0	82312
UNC	7/16 x 14	85	25	8.0	6.3	82313
UNC	1/2 x 13	89	29	9.0	7.1	82314
UNC	9/16 x 12	95	30	11.2	9.0	82315
UNC	5/8 x 11	102	32	12.5	10.0	82316
UNC	3/4 x 10	112	37	14.0	11.2	82317
UNC	7/8 x 9	118	38	16.0	12.5	82318
UNC	1" x 8	130	45	18.0	14.0	82319

D = Nominal Diameter

L1 = Overall Length

L2 = Thread Length

D2 = Shank Diameter

Square = Drive Connector



Hand taps (set of 3 pcs.) left hand

≈ DIN 352 HSS-G - UNC LH

(hand tap rougher, hand tap intermediate, hand tap finisher)

Type of thread: Unified Coarse thread ANSI B 1.1

Tolerance: 2B

Application/ for general use:

- > non abrasive material up to 900 N/mm²
- > unalloyed and low alloyed steel
- > for through and blind holes
- > for thread cutting by hand

Variants (14):



D		L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Intermediate	Art.-No. Finisher
UNC	No. 6 x 32	45	14	4.0	3.0	23006	23006-1	23006-2	23006-3
UNC	No. 8 x 32	45	14	4.5	3.4	23008	23008-1	23008-2	23008-3
UNC	No. 10 x 24	50	16	6.0	4.9	23010	23010-1	23010-2	23010-3
UNC	No. 12 x 24	50	18	6.0	4.9	23012	23012-1	23012-2	23012-3
UNC	1/4 x 20	50	19	6.0	4.9	23014	23014-1	23014-2	23014-3
UNC	5/16 x 18	56	22	6.0	4.9	23016	23016-1	23016-2	23016-3
UNC	3/8 x 16	70	24	7.0	5.5	23018	23018-1	23018-2	23018-3
UNC	7/16 x 14	70	24	8.0	6.2	23020	23020-1	23020-2	23020-3
UNC	1/2 x 13	75	29	9.0	7.0	23022	23022-1	23022-2	23022-3
UNC	9/16 x 12	80	30	11.0	9.0	23024	23024-1	23024-2	23024-3
UNC	5/8 x 11	80	32	12.0	9.0	23026	23026-1	23026-2	23026-3
UNC	3/4 x 10	95	40	14.0	11.0	23030	23030-1	23030-2	23030-3
UNC	7/8 x 9	100	40	18.0	14.5	23034	23034-1	23034-2	23034-3
UNC	1" x 8	110	50	18.0	14.5	23038	23038-1	23038-2	23038-3

D = Nominal Diameter

L1 = Overall Length

L2 = Thread Length

D2 = Shank Diameter

Square = Drive Connector



UNF (Unified fine)



Hand taps, Unified fine thread ANSI B 1.1

Hand taps for UNF threads suitable for non abrasive materials up to 900 N/mm² and for threading in through or blind holes.

Available in cylindrical and conical (non-serial) form.

Hand taps for american UNF right hand threads

- Hand taps (UNF) acc. to DIN, ISO and JIS-B standard
- Variations from UNF No. 0 to UNF 2.1/2"



Hand taps (set of 3 pcs.)

JIS B-4430 HSS-G - UNF

(hand tap rougher, hand tap intermediate, hand tap finisher)

Type of thread: Unified Fine thread ANSI B 1.1

Tolerance: 2B

Variants (10):

Application/ for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Intermediate	Art.-No. Finisher
UNF 3/16	60	17	5.5	4.5	93463	93463-1	93463-2	93463-3
UNF 1/4	62	20	6.0	4.5	93464	93464-1	93464-2	93464-3
UNF 5/16	70	23	6.1	5.0	93465	93465-1	93465-2	93465-3
UNF 3/8	75	25	7.0	5.5	93466	93466-1	93466-2	93466-3
UNF 7/16	80	24	8.0	6.0	93467	93467-1	93467-2	93467-3
UNF 1/2	85	30	9.0	7.0	93468	93468-1	93468-2	93468-3
UNF 5/8	95	32	12.0	9.0	93470	93470-1	93470-2	93470-3
UNF 3/4	105	38	14.0	11.0	93472	93472-1	93472-2	93472-3
UNF 7/8	115	38	17.0	13.0	93474	93474-1	93474-2	93474-3
UNF 1"	126	45	20.0	15.0	93476	93476-1	93476-2	93476-3

D = Nominal Diameter

L1 = Overall Length

L2 = Thread Length

D2 = Shank Diameter

Square = Drive Connector



Hand taps (set of 2 pcs.)

≈ DIN 2181 HSS-G - UNF

(hand tap rougher, hand tap finisher)

Type of thread: Unified Fine thread ANSI B 1.1

Tolerance: 2B

Variants (25):

Application/ for general use:

- > non abrasive material up to 900 N/mm²
- > unalloyed and low alloyed steel
- > for through and blind holes
- > for thread cutting by hand



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Finisher
UNF 0 x 80	28	8	2.5	2.1	24300	24300-1	24300-3
UNF 1 x 72	32	9	2.8	2.1	24301	24301-1	24301-3
UNF 2 x 64	32	10	2.8	2.1	24302	24302-1	24302-3
UNF 3 x 56	32	10	2.8	2.1	24303	24303-1	24303-3
UNF 4 x 48	36	11	3.5	2.7	24304	24304-1	24304-3
UNF 5 x 44	36	11	3.5	2.7	24305	24305-1	24305-3
UNF 6 x 40	40	12	4.5	3.4	24306	24306-1	24306-3
UNF 8 x 36	40	12	4.5	3.4	24308	24308-1	24308-3
UNF 10 x 32	45	14	6.0	4.9	24310	24310-1	24310-3
UNF 12 x 28	50	14	6.0	4.9	24312	24312-1	24312-3
UNF 1/4 x 28	50	18	6.0	4.9	24314	24314-1	24314-3
UNF 5/16 x 24	56	22	6.0	4.9	24316	24316-1	24316-3
UNF 3/8 x 24	63	22	7.0	5.5	24318	24318-1	24318-3
UNF 7/16 x 20	63	22	8.0	6.2	24320	24320-1	24320-3
UNF 1/2 x 20	75	24	9.0	7.0	24322	24322-1	24322-3
UNF 9/16 x 18	80	28	11.0	9.0	24324	24324-1	24324-3
UNF 5/8 x 18	80	28	12.0	9.0	24326	24326-1	24326-3
UNF 3/4 x 16	95	32	14.0	11.0	24330	24330-1	24330-3
UNF 7/8 x 14	100	36	18.0	14.5	24334	24334-1	24334-3
UNF 1" x 12	110	40	18.0	14.5	24338	24338-1	24338-3
UNF 1" x 14	110	40	18.0	14.5	24340	24340-1	24340-3
UNF 1.1/8 x 12	110	50	22.0	18.0	24342	24342-1	24342-3
UNF 1.1/4 x 12	132	56	22.0	18.0	24346	24346-1	24346-3
UNF 1.3/8 x 12	132	56	28.0	22.0	24350	24350-1	24350-3
UNF 1.1/2 x 12	150	63	32.0	24.0	24354	24354-1	24354-3

D = Nominal Diameter

L1 = Overall Length

L2 = Thread Length

D2 = Shank Diameter

Square = Drive Connector



Hand taps (set of 3 pcs.)

ISO 529 HSS-G - UNF

Type of thread: Unified Fine thread ANSI B 1.1

Tolerance: 2B

Variants (27):

Application/ for general use:

- > non abrasive material up to 900 N/mm²
- > unalloyed and low alloyed steel
- > for through and blind holes
- > for thread cutting by hand

D		L1	L2	D2	Square	Art.-No. Set
UNF	No. 4 x 48	48	11	3.15	2.5	83405
UNF	No. 5 x 44	48	11	3.15	2.5	83406
UNF	No. 6 x 40	50	13	3.55	2.8	83407
UNF	No. 8 x 36	53	13	4.5	3.55	83408
UNF	No. 10 x 32	58	16	5.0	4.0	83410
UNF	No. 12 x 28	62	17	5.6	4.5	83412
UNF	1/4 x 28	66	19	6.3	5.0	83414
UNF	5/16 x 24	69	19	8.0	6.3	83416
UNF	3/8 x 24	76	20	10.0	8.0	83418
UNF	7/16 x 20	82	22	8.0	6.3	83420
UNF	1/2 x 20	84	24	9.0	7.1	83422
UNF	9/16 x 18	90	25	11.2	9.0	83424
UNF	5/8 x 18	95	25	12.5	10.0	83426
UNF	3/4 x 16	104	29	14.0	11.2	83430
UNF	7/8 x 14	113	33	16.0	12.5	83434
UNF	1" x 12	120	35	18.0	14.0	83438
UNF	1.1/8 x 12	127	37	20.0	16.0	83440
UNF	1.1/4 x 12	137	37	22.4	18.0	83442
UNF	1.3/8 x 12	144	39	25.0	20.0	83444
UNF	1.1/2 x 12	149	39	28.0	22.4	83446
UNF	1.5/8 x 12	164	45	28.0	22.4	83447
UNF	1.3/4 x 12	164	45	31.5	25.0	83448
UNF	1.7/8 x 12	164	45	31.5	25.0	83449
UNF	2" x 12	175	47	35.5	28.0	83454
UNF	2.1/8 x 12	200	70	35.5	28.0	83455
UNF	2.1/4 x 12	221	76	40.0	31.5	83456
UNF	2.1/2 x 12	224	79	40.0	31.5	83458

D = Nominal Diameter

L1 = Overall Length

L2 = Thread Length

D2 = Shank Diameter

Square = Drive Connector



UNF (Unified fine) left hand



Hand taps, Unified fine thread ANSI B 1.1

Hand taps for UNF left hand threads suitable for non abrasive materials up to 900 N/mm² and for threading in through or blind holes.

Available in cylindrical and conical (non-serial) form.

Hand taps for american UNF left hand threads

- Hand taps (UNF) acc. to DIN and ISO standard
- Variations from UNF No. 10 LH to UNF 1" LH



Hand taps (set of 3 pcs.) left hand

JIS B-4430 HSS-G - UNF

Type of thread: Unified Fine thread ANSI B 1.1

Tolerance: 2B

Variants (10):

Application/ for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

D		L1	L2	D2	Square	Art.-No. Set
UNF	1/4 x 28	66	19	6.3	5.0	82350
UNF	5/16 x 24	69	19	8.0	6.3	82351
UNF	3/8 x 24	76	20	10.0	8.0	82352
UNF	7/16 x 20	83	22	8.0	6.3	82353
UNF	1/2 x 20	84	24	9.0	7.1	82354
UNF	9/16 x 18	90	25	11.2	9.0	82355
UNF	5/8 x 18	95	25	12.5	10.0	82356
UNF	3/4 x 16	104	29	14.0	11.2	82357
UNF	7/8 x 14	113	33	16.0	12.5	82358
UNF	1" x 12	120	35	18.0	14.0	82359

D = Nominal Diameter

L1 = Overall Length

L2 = Thread Length

D2 = Shank Diameter

Square = Drive Connector



Hand taps (set of 2 pcs.) left hand

≈ DIN 2181 HSS-G - UNF LH
(hand tap rougher, hand tap finisher)

Type of thread: Unified Fine thread ANSI B 1.1

Tolerance: 2B

Application/ for general use:

- > non abrasive material up to 900 N/mm²
- > unalloyed and low alloyed steel
- > for through and blind holes
- > for thread cutting by hand

Variants (10):



D		L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Finisher
UNF	No. 10 x 32	45	14	6.0	4.9	24010	24010-1	24010-3
UNF	1/4 x 28	50	18	6.0	4.9	24014	24014-1	24014-3
UNF	5/16 x 24	56	22	6.0	4.9	24016	24016-1	24016-3
UNF	3/8 x 24	63	22	7.0	5.5	24018	24018-1	24018-3
UNF	7/16 x 20	63	22	8.0	6.2	24020	24020-1	24020-3
UNF	1/2 x 20	75	24	9.0	7.0	24022	24022-1	24022-3
UNF	9/16 x 18	80	28	11.0	9.0	24024	24024-1	24024-3
UNF	5/8 x 18	80	28	12.0	9.0	24026	24026-1	24026-3
UNF	3/4 x 16	95	32	14.0	11.0	24030	24030-1	24030-3
UNF	7/8 x 14	100	36	18.0	14.5	24034	24034-1	24034-3
UNF	1" 12	110	40	18.0	14.5	24038	24038-1	24038-3



UNEF (Unified extra fine)



Hand taps, Unified extra fine thread ANSI B 1.1

Hand taps for UNEF threads in conical (non-serial) form suitable for non abrasive materials up to 900 N/mm² and for threading in through or blind holes.

Hand taps for american UENF threads

- Hand taps (UNEF) acc. to ISO 529
- Variations from UNEF 1/4 to UNEF 1"



Hand taps (set of 3 pcs.) non-serial

ISO 529 HSS-G - UNEF

(hand tap rougher, hand tap intermediate, hand tap finisher)

Type of thread: Unified Extra Fine thread ANSI B 1.1

Tolerance: 2B

Variants (10):

Application/

for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Intermediate	Art.-No. Finisher
UNEF 1/4 x 32	66	19	6.3	5.0	83821	83821-1	83821-2	83821-3
UNEF 5/16 x 32	72	22	8.0	6.3	83822	83822-1	83822-2	83822-3
UNEF 3/8 x 32	80	24	10.0	8.0	83823	83823-1	83823-2	83823-3
UNEF 7/16 x 28	85	25	8.0	6.3	83824	83824-1	83824-2	83824-3
UNEF 1/2 x 28	89	29	9.0	7.1	83825	83825-1	83825-2	83825-3
UNEF 9/16 x 24	95	30	11.2	9.0	83826	83826-1	83826-2	83826-3
UNEF 5/8 x 24	102	32	12.5	10.0	83827	83827-1	83827-2	83827-3
UNEF 3/4 x 20	112	37	14.0	11.2	83829	83829-1	83829-2	83829-3
UNEF 7/8 x 20	118	38	16.0	12.5	83831	83831-1	83831-2	83831-3
UNEF 1" x 20	130	45	16.0	14.0	83833	83833-1	83833-2	83833-3

D = Nominal Diameter

L1 = Overall Length

L2 = Thread Length

D2 = Shank Diameter

Square = Drive Connector



G (BSP) Pipe-thread



Hand taps, Pipe thread DIN ISO 228

G (BSP) Hand taps in cylindrical and conical (non-serial) form for non abrasive material up to 900 N/mm².

- Hand taps G (BSP) acc. to DIN 5157 and ISO 529
- Taps for through and blind holes
- Hand taps for right- and left-handed threads (LH)
- G (BSP) rougher and finisher can be ordered separately
- Variations: G (BSP) 1/8 to G (BSP) 4"



Hand taps (set of 2 pcs.)

DIN 5157 HSS-E - G (BSP)
(hand tap rougher, hand tap finisher)

Type of thread: Pipe-thread DIN ISO 228

Variants (6):

Advantages:

- high cutting ability

Application:

- abrasive material
- Steel up to 1200 N/mm²
- and for general use



D		L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Finisher
G	1/8 x 28	63	20	7.0	5.5	55312	55312-1	55312-2
G	1/4 x 19	70	22	11.0	9.0	55314	55314-1	55314-2
G	3/8 x 19	70	22	12.0	9.0	55316	55316-1	55316-2
G	1/2 x 14	80	22	16.0	12.0	55318	55318-1	55318-2
G	3/4 x 14	90	22	20.0	16.0	55322	55322-1	55322-2
G	1" x 11	100	25	25.0	20.0	55326	55326-1	55326-2



Hand taps (set of 2 pcs.)

DIN 5157 HSS-G - G (BSP)
(hand tap rougher, hand tap finisher)

Type of thread: Pipe-thread DIN ISO 228

Variants (21):

Application/ for general use:

- > non abrasive material up to 900 N/mm²
- > unalloyed and low alloyed steel
- > for through and blind holes
- > for thread cutting by hand



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Finisher
G 1/8 x 28	63	20	7.0	5.5	25312	25312-1	25312-2
G 1/4 x 19	70	22	11.0	9.0	25314	25314-1	25314-2
G 3/8 x 19	70	22	12.0	9.0	25316	25316-1	25316-2
G 1/2 x 14	80	22	16.0	12.0	25318	25318-1	25318-2
G 5/8 x 14	80	22	18.0	14.5	25320	25320-1	25320-2
G 3/4 x 14	90	22	20.0	16.0	25322	25322-1	25322-2
G 7/8 x 14	90	22	22.0	18.0	25324	25324-1	25324-2
G 1" x 11	100	25	25.0	20.0	25326	25326-1	25326-2
G 1.1/8 x 11	125	40	28.0	22.0	25330	25330-1	25330-2
G 1.1/4 x 11	125	40	32.0	24.0	25334	25334-1	25334-2
G 1.3/8 x 11	140	40	36.0	29.0	25338	25338-1	25338-2
G 1.1/2 x 11	140	40	36.0	29.0	25342	25342-1	25342-2
G 1.5/8 x 11	140	40	40.0	32.0	25345	25345-1	25345-2
G 1.3/4 x 11	140	40	40.0	32.0	25350	25350-1	25350-2
G 2" x 11	160	40	45.0	35.0	25354	25354-1	25354-2
G 2.1/4 x 11	160	40	50.0	39.0	25358	25358-1	25358-2
G 2.1/2 x 11	160	40	50.0	39.0	25362	25362-1	25362-2
G 2.3/4 x 11	160	40	50.0	39.0	25366	25366-1	25366-2
G 3" x 11	160	40	50.0	39.0	25370	25370-1	25370-2
G 3.1/2 x 11	180	45	56.0	44.0	25374	25374-1	25374-2
G 4" x 11	180	45	56.0	44.0	25378	25378-1	25378-2



Hand taps (set of 2 pcs.) left hand

DIN 5157 HSS-G - G (BSP) LH

(hand tap rougher, hand tap finisher)

Type of thread: Pipe-thread DIN ISO 228

Variants (13):

Application/ for general use:

- > non abrasive material up to 900 N/mm²
- > unalloyed and low alloyed steel
- > for through and blind holes
- > for thread cutting by hand



D		L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Finisher
G	1/8 x 28	63	20	7.0	5.5	25012	25012-1	25012-2
G	1/4 x 19	70	22	11.0	9.0	25014	25014-1	25014-2
G	3/8 x 19	70	22	12.0	9.0	25016	25016-1	25016-2
G	1/2 x 14	80	22	16.0	12.0	25018	25018-1	25018-2
G	5/8 x 14	80	22	18.0	14.5	25020	25020-1	25020-2
G	3/4 x 14	90	22	20.0	16.0	25022	25022-1	25022-2
G	1" x 11	100	25	25.0	20.0	25026	25026-1	25026-2
G	1.1/8 x 11	125	40	28.0	22.0	25030	25030-1	25030-2
G	1.1/4 x 11	125	40	32.0	24.0	25034	25034-1	25034-2
G	1.3/8 x 11	140	40	36.0	29.0	25038	25038-1	25038-2
G	1.1/2 x 11	140	40	36.0	29.0	25042	25042-1	25042-2
G	1.3/4 x 11	140	40	40.0	32.0	25050	25050-1	25050-2
G	2" x 11	160	40	45.0	35.0	25054	25054-1	25054-2



Hand taps (set of 3 pcs.)

ISO 529 HSS-G - G (BSP)

(hand tap rougher, hand tap intermediate, hand tap finisher)

Type of thread: Pipe-thread DIN ISO 228

Variants (17):

Application/ for general use:

- > non abrasive material up to 900 N/mm²
- > unalloyed and low alloyed steel
- > for through and blind holes
- > for thread cutting by hand

D		L1	L2	D2	Square	Art.-No. Set
G	1/8 x 28	59	15	8.0	6.3	86412
G	1/4 x 19	67	19	10.0	8.0	86414
G	3/8 x 19	75	21	12.5	10.0	86416
G	1/2 x 14	87	26	16.0	12.5	86418
G	5/8 x 14	91	26	18.0	14.0	86421
G	3/4 x 14	96	28	20.0	16.0	86422
G	7/8 x 14	102	29	22.4	18.0	86424
G	1" x 11	109	33	25.0	20.0	86426
G	1.1/8 x 11	115	34	28.0	22.4	86430
G	1.1/4 x 11	119	36	31.5	25.0	86434
G	1.1/2 x 11	125	37	35.5	28.0	86442
G	1.3/4 x 11	132	39	35.5	28.0	86448
G	2" x 11	140	41	40.0	31.5	86454
G	2.1/4 x 11	142	42	40.0	31.5	86458
G	2.1/2 x 11	153	45	45.0	35.5	86460
G	3"	164	48	50.0	40.0	86464
G	4"	185	53	71.0	56.0	86478



PG (Armoured tube thread)



Hand taps, armoured tube thread DIN 40 430

Hand taps for PG threads are suitable for non abrasive materials up to 900 N/mm², for unalloyed and low alloyed steel and for threading in through or blind holes.

Hand taps for PG threads

- Hand taps (PG-threads) acc. to DIN 40 432
- Variations from PG 7 to PG 48



Hand taps (set of 2 pcs.)

DIN 40432 HSS-G - PG
(hand tap rougher, hand tap finisher)

Type of thread: armoured tube thread DIN 40 430

Variants (10):

Application/

for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand



D		L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Finisher
PG	7 x 20	70	22	9.0	7.0	25707	25707-1	25707-2
PG	9 x 18	70	22	12.0	9.0	25709	25709-1	25709-2
PG	11 x 18	80	22	14.0	11.0	25711	25711-1	25711-2
PG	13.5 x 18	80	22	16.0	12.0	25713	25713-1	25713-2
PG	16 x 18	80	22	18.0	14.5	25716	25716-1	25716-2
PG	21 x 16	90	22	22.0	18.0	25721	25721-1	25721-2
PG	29 x 16	100	25	28.0	22.0	25729	25729-1	25729-2
PG	36 x 16	140	40	36.0	29.0	25736	25736-1	25736-2
PG	42 x 16	140	40	40.0	32.0	25742	25742-1	25742-2
PG	48 x 16	160	40	45.0	35.0	25748	25748-1	25748-2



Tr (trapezoidal thread)



Hand taps, trapezoidal thread DIN103

Hand taps for trapezoidal threads made of HSS-G are suitable for non abrasive material up to 900 N/mm² and for thread cutting in unalloyed and low alloyed materials.

- Taps for thread cutting in through and blind holes
- Variations from Tr 10x2 to Tr 32x6

Please note that for thread cutting of trapezoidal threads by hand it is recommended to use the complete set with rougher, intermediate and finisher. The finisher should be used in single only for **re-cutting** of an existing thread.



Hand taps (set of 3 pcs.)

HSS-G - Tr

(hand tap rougher, hand tap intermediate, hand tap finisher)

Type of thread: trapezoidal thread DIN 103

Tolerance: 7H

Variants (14):

Application/ for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Intermediate	Art.-No. Finisher
Tr 10 x 2	90	34	7.0	5.5	25108	25108-1	25108-2	25108-3
Tr 10 x 3	100	40	7.0	5.5	25112	25112-1	25112-2	25112-3
Tr 12 x 3	110	40	8.0	6.2	25116	25116-1	25116-2	25116-3
Tr 14 x 3	130	45	10.0	8.0	25120	25120-1	25120-2	25120-3
Tr 14 x 4	130	55	10.0	8.0	25124	25124-1	25124-2	25124-3
Tr 16 x 4	140	55	11.0	9.0	25128	25128-1	25128-2	25128-3
Tr 18 x 4	150	55	12.0	9.0	25132	25132-1	25132-2	25132-3
Tr 20 x 4	160	55	14.0	11.0	25136	25136-1	25136-2	25136-3
Tr 22 x 5	175	65	16.0	12.0	25140	25140-1	25140-2	25140-3
Tr 24 x 5	190	65	18.0	14.5	25144	25144-1	25144-2	25144-3
Tr 26 x 5	210	70	20.0	16.0	25148	25148-1	25148-2	25148-3
Tr 28 x 5	220	70	22.0	18.0	25152	25152-1	25152-2	25152-3
Tr 30 x 6	240	80	22.0	18.0	25156	25156-1	25156-2	25156-3
Tr 32 x 6	255	80	25.0	20.0	25160	25160-1	25160-2	25160-3

D = Nominal Diameter

L1 = Overall Length

L2 = Thread Length

D2 = Shank Diameter

Square = Drive Connector



American UNx8 thread



Hand taps, Unified thread ANSI B 1.1

American UN Thread-series with constant 8 pitches per inch. Hand taps for UNx8 threads suitable for non abrasive material up to 900 N/mm², for thread cutting in through or blind holes and for unalloyed and low alloyed steels.

Hand taps for american UNx8 threads

- Hand taps UNx8 acc. to ISO 529
- Variations from UN 1.1/8 x8 to UN 4" x8



Hand taps (set of 3 pcs.)

ISO 529 HSS-G - UN

(hand tap rougher, hand tap intermediate, hand tap finisher)

Type of thread: Unified thread ANSI B 1.1

Tolerance: 2B

Variants (16):

Application/

for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

D	L1	L2	D2	Square	Art.-No. Set
UNS 1.1/8 x 8	138	48	20.0	16.0	82940
UNS 1.1/4 x 8	151	51	22.4	18.0	82942
UNS 1.3/8 x 8	162	57	25.0	20.0	82944
UNS 1.1/2 x 8	170	60	28.0	22.4	82946
UNS 1.5/8 x 8	170	60	28.0	22.4	82947
UNS 1.3/4 x 8	187	67	31.5	25.0	82948
UNS 1.7/8 x 8	187	67	31.5	25.0	82949
UNS 2" x 8	200	70	35.5	28.0	82950
UNS 2.1/8 x 8	200	70	35.5	28.0	82951
UNS 2.1/4 x 8	221	76	40.0	31.5	82952
UNS 2.3/8 x 8	224	79	40.0	31.5	82953
UNS 2.1/2 x 8	224	79	40.0	31.5	82954
UNS 2.3/4 x 8	234	79	45.0	35.5	82956
UNS 3" x 8	258	83	50.0	40.0	82958
UNS 3.1/2 x 8	261	86	50.0	40.0	82960
UNS 4" x 8	279	89	56.0	45.0	82962

D = Nominal Diameter

L1 = Overall Length

L2 = Thread Length

D2 = Shank Diameter

Square = Drive Connector



Whitworth screw thread for gas cylinders



Hand taps, tapered Whitworth screw thread BS 84

Whitworth-taps for screw threads for cylinder valves are suitable for non abrasive materials up to 900 N/mm² as well as for low unalloyed and low alloyed steels.

Whitworth hand taps for gas cylinder valves 3:25

- Hand taps acc. to Japanese standard JIS-B 4430
- Variations from W 1/8 to W 1.1/4



Hand taps (set of 3 pcs.)

JIS B-4430 HSS-G - W

(hand tap rougher, hand tap intermediate, hand tap finisher)

Type of thread: tapered Whitworth screw thread for gas cylinders taper 3.25

Variants (14):

Application/ for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Intermediate	Art.-No. Finisher
W 1/8	47	11	4.0	3.2	94406	94406-1	94406-2	94406-3
W 5/32	53	14	5.0	4.0	94408	94408-1	94408-2	94408-3
W 3/16	60	17	5.5	4.5	94410	94410-1	94410-2	94410-3
W 1/4	62	20	6.0	4.5	94414	94414-1	94414-2	94414-3
W 5/16	70	23	6.1	5.0	94416	94416-1	94416-2	94416-3
W 3/8	75	25	7.0	5.5	94418	94418-1	94418-2	94418-3
W 7/16	80	24	8.0	6.0	94420	94420-1	94420-2	94420-3
W 1/2	85	30	9.0	7.0	94422	94422-1	94422-2	94422-3
W 9/16	90	30	10.5	8.0	94424	94424-1	94424-2	94424-3
W 5/8	95	32	12.0	9.0	94426	94426-1	94426-2	94426-3
W 3/4	105	38	14.0	11.0	94430	94430-1	94430-2	94430-3
W 7/8	115	38	17.0	13.0	94434	94434-1	94434-2	94434-3
W 1"	126	45	20.0	15.0	94438	94438-1	94438-2	94438-3
W 1.1/4	145	51	24.0	19.0	94440	94440-1	94440-2	94440-3