Machine taps

Machine taps

HSSE Machine taps for through holes:

- Form A = 6-8 Threads lead
- Form B = 4-5 Threads lead with spiral point
- Form B-AZ = 4-5 Threads lead spiral point, interrupted threads

HSSE Machine taps for blind holes:

- Form C = 2-3 Threads lead
- Form C/RSP = 2-3 Threads lead with 15° or 35° spiral flute

M (metric)

P.K.47 HSS-E Machine taps for blind holes (set of 14 pcs.) (47847) incl. drills DIN 371/376 M 3 – M 12

Type of thread	Standard	Material	Tolerance	Packing	Size
metric ISO thread DIN 13	DIN 371/376	HSS-E	ISO 2 /6H	in plastic case	Diameter M 3 - 12

Application/ for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- long chipping material
- for blind holes

Contents:	Art. -No.
1x Machine taps DIN 371 Form C 35°RSP HSS-E – M 3 x 0.5	37726
1x Machine taps DIN 371 Form C 35°RSP HSS-E – M 4 x 0.7	37730
1x Machine taps DIN 371 Form C 35°RSP HSS-E – M 5 x 0.8	37734
1x Machine taps DIN 371 Form C 35°RSP HSS-E – M 6 x 1.0	37738
1x Machine taps DIN 371 Form C 35°RSP HSS-E – M 8 x 1.25	37742
1x Machine taps DIN 371 Form C 35°RSP HSS-E – M 10 x 1.5	37746
1x Machine taps DIN 376 Form C 35°RSP HSS-E – M 12 x 1.75	38750
Twist drill 2.5 / 3.3 / 4.2 / 5.0 / 6.8 / 8.5 / 10.2 mm	

P.K.48 HSS-E TiN Machine taps for blind holes (set of 14 pcs.) (47848) incl. drills DIN 371/376 M 3 – M 12

Type of thread	Standard	Material	Tolerance	Packing	Size
metric ISO thread DIN 13	DIN 371/376	HSS-E	ISO 2 /6H	in plastic case	Diameter M 3 - 12

Application/ for general use:
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- long chipping material
- for blind holes

TIN-coating:
- improved resistance to wear and abrasion
- excellent anti-friction properties
- faster cutting speeds possible

Contents:	Art. -No.
1x Machine taps DIN 371 Form C 35°RSP HSS-E TiN – M 3 x 0.5	31726
1x Machine taps DIN 371 Form C 35°RSP HSS-E TiN – M 4 x 0.7	31730
1x Machine taps DIN 371 Form C 35°RSP HSS-E TiN – M 5 x 0.8	31734
1x Machine taps DIN 371 Form C 35°RSP HSS-E TiN – M 6 x 1.0	31738
1x Machine taps DIN 371 Form C 35°RSP HSS-E TiN – M 8 x 1.25	31742
1x Machine taps DIN 371 Form C 35°RSP HSS-E TiN – M 10 x 1.5	31746
1x Machine taps DIN 376 Form C 35°RSP HSS-E TiN – M 12 x 1.75	31750
Twist drill 2.5 / 3.3 / 4.2 / 5.0 / 6.8 / 8.5 / 10.2 mm	

P.K.31 HSS-E TiN Machine taps for blind holes (set of 7 pcs.) (47827) DIN 371/376 M 3 – M 12

Type of thread	Standard	Material	Tolerance	Packing	Size
metric ISO thread DIN 13	DIN 371/376	HSS-E	ISO 2 /6H	in plastic case	Diameter M 3 - 12

Application/ for general use:
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- long chipping material
- for blind holes

TIN-coating:
- improved resistance to wear and abrasion
- excellent anti-friction properties
- faster cutting speeds possible

Contents:	Art. -No.
1x Machine taps DIN 371 Form C 35°RSP HSS-E TiN – M 3 x 0.5	31726
1x Machine taps DIN 371 Form C 35°RSP HSS-E TiN – M 4 x 0.7	31730
1x Machine taps DIN 371 Form C 35°RSP HSS-E TiN – M 5 x 0.8	31734
1x Machine taps DIN 371 Form C 35°RSP HSS-E TiN – M 6 x 1.0	31738
1x Machine taps DIN 371 Form C 35°RSP HSS-E TiN – M 8 x 1.25	31742
1x Machine taps DIN 371 Form C 35°RSP HSS-E TiN – M 10 x 1.5	31746
1x Machine taps DIN 376 Form C 35°RSP HSS-E TiN – M 12 x 1.75	31750

P.K.30 HSS-E Machine taps for blind holes (set of 7 pcs.) (47817) DIN 371/376 M 3 – M 12

Type of thread	Standard	Material	Tolerance	Packing	Size
metric ISO thread DIN 13	DIN 371/376	HSS-E	ISO 2 /6H	in plastic case	Diameter M 3 - 12

Application/ for general use:
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- long chipping material
- for blind holes

Contents:	Art. -No.
1x Machine taps DIN 371 Form C 35°RSP HSS-E – M 3 x 0.5	37726
1x Machine taps DIN 371 Form C 35°RSP HSS-E – M 4 x 0.7	37730
1x Machine taps DIN 371 Form C 35°RSP HSS-E – M 5 x 0.8	37734
1x Machine taps DIN 371 Form C 35°RSP HSS-E – M 6 x 1.0	37738
1x Machine taps DIN 371 Form C 35°RSP HSS-E – M 8 x 1.25	37742
1x Machine taps DIN 371 Form C 35°RSP HSS-E – M 10 x 1.5	37746
1x Machine taps DIN 376 Form C 35°RSP HSS-E – M 12 x 1.75	38750

P.K.36 HSS-E TiN Machine taps (set of 14 pcs.) (47836)
incl. drills DIN 371/376 M 3 – M 12

Type of thread	Standard	Material	Tolerance	Packing	Size
metric ISO thread DIN 13	DIN 371/376	HSS-E	ISO 2 /6H	in plastic case	Diameter M 3 - 12

Application/ for general use:
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- long chipping material
- for blind holes

TIN-coating:
- improved resistance to wear and abrasion
- excellent anti-friction properties
- faster cutting speeds possible

Contents:	Art. -No.
1x Machine taps DIN 371 Form B HSS-E TiN – M 3 x 0.5	31526
1x Machine taps DIN 371 Form B HSS-E TiN – M 4 x 0.7	31530
1x Machine taps DIN 371 Form B HSS-E TiN – M 5 x 0.8	31534
1x Machine taps DIN 371 Form B HSS-E TiN – M 6 x 1.0	31538
1x Machine taps DIN 371 Form B HSS-E TiN – M 8 x 1.25	31542
1x Machine taps DIN 371 Form B HSS-E TiN – M 10 x 1.5	31546
1x Machine taps DIN 376 Form B HSS-E TiN – M 12 x 1.75	31550
Twist drill 2.5 / 3.3 / 4.2 / 5.0 / 6.8 / 8.5 / 10.2 mm	

P.K.35 HSS-E Machine taps (set of 14 pcs.) (47835)

incl. drills DIN 371/376 M 3 – M 12

Type of thread	Standard	Material	Tolerance	Packing	Size
metric ISO thread DIN 13	DIN 371/376	HSS-E	ISO 2 /6H	in plastic case	Diameter M 3 - 12

Application/ for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- long chipping material
- for blind holes

Contents:	Art. -No.
1x Machine taps DIN 371 Form B HSS-E – M 3 x 0.5	37526
1x Machine taps DIN 371 Form B HSS-E – M 4 x 0.7	37530
1x Machine taps DIN 371 Form B HSS-E – M 5 x 0.8	37534
1x Machine taps DIN 371 Form B HSS-E – M 6 x 1.0	37538
1x Machine taps DIN 371 Form B HSS-E – M 8 x 1.25	37542
1x Machine taps DIN 371 Form B HSS-E – M 10 x 1.5	37546
1x Machine taps DIN 376 Form B HSS-E – M 12 x 1.75	38550
Twist drill 2.5 / 3.3 / 4.2 / 5.0 / 6.8 / 8.5 / 10.2 mm	

P.K.29 HSS-E TiN Machine taps (set of 7 pcs.) (47825)

DIN 371/376 M 3 – M 12

Type of thread	Standard	Material	Tolerance	Packing	Size
metric ISO thread DIN 13	DIN 371/376	HSS-E	ISO 2 /6H	in plastic case	Diameter M 3 - 12

Application/ for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- long chipping material
- for through holes

TIN-coating:

- improved resistance to wear and abrasion
- excellent anti-friction properties
- faster cutting speeds possible

Contents:	Art. -No.
1x Machine taps DIN 371 Form B HSS-E TiN – M 3 x 0.5	31526
1x Machine taps DIN 371 Form B HSS-E TiN – M 4 x 0.7	31530
1x Machine taps DIN 371 Form B HSS-E TiN – M 5 x 0.8	31534
1x Machine taps DIN 371 Form B HSS-E TiN – M 6 x 1.0	31538
1x Machine taps DIN 371 Form B HSS-E TiN – M 8 x 1.25	31542
1x Machine taps DIN 371 Form B HSS-E TiN – M 10 x 1.5	31546
1x Machine taps DIN 376 Form B HSS-E TiN – M 12 x 1.75	31550

P.K.28 HSS-E Machine taps (set of 7 pcs.) (47815)

DIN 371/376 M 3 – M 12

Type of thread	Standard	Material	Tolerance	Packing	Size
metric ISO thread DIN 13	DIN 371/376	HSS-E	ISO 2 /6H	in plastic case	Diameter M 3 - 12

Application/ for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- long chipping material
- for blind holes

Contents:	Art. -No.
1x Machine taps DIN 371 Form B HSS-E – M 3 x 0.5	37526
1x Machine taps DIN 371 Form B HSS-E – M 4 x 0.7	37530
1x Machine taps DIN 371 Form B HSS-E – M 5 x 0.8	37534
1x Machine taps DIN 371 Form B HSS-E – M 6 x 1.0	37538
1x Machine taps DIN 371 Form B HSS-E – M 8 x 1.25	37542
1x Machine taps DIN 371 Form B HSS-E – M 10 x 1.5	37546
1x Machine taps DIN 376 Form B HSS-E – M 12 x 1.75	38550

P.K.41 HSS-E TiN Machine taps (set of 14 pcs.) (47912)

DIN 371/376 M 3 – M 12

Type of thread	Standard	Material	Tolerance	Packing	Size
metric ISO thread DIN 13	DIN 371/376	HSS-E	ISO 2 /6H	in plastic case	Diameter M 3 - 12

Application/ for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- long chipping material
- for through holes

TIN-coating:

- improved resistance to wear and abrasion
- excellent anti-friction properties

Contents:	Art. -No.
1x Machine taps DIN 371 Form B HSS-E TiN – M 3 x 0.5	31526
1x Machine taps DIN 371 Form B HSS-E TiN – M 4 x 0.7	31530
1x Machine taps DIN 371 Form B HSS-E TiN – M 5 x 0.8	31534
1x Machine taps DIN 371 Form B HSS-E TiN – M 6 x 1.0	31538
1x Machine taps DIN 371 Form B HSS-E TiN – M 8 x 1.25	31542
1x Machine taps DIN 371 Form B HSS-E TiN – M 10 x 1.5	31546
1x Machine taps DIN 376 Form B HSS-E TiN – M 12 x 1.75	31550
1x Machine taps DIN 371 Form C 35°RSP HSS-E TiN – M 3 x 0.5	31726
1x Machine taps DIN 371 Form C 35°RSP HSS-E TiN – M 4 x 0.7	31730
1x Machine taps DIN 371 Form C 35°RSP HSS-E TiN – M 5 x 0.8	31734
1x Machine taps DIN 371 Form C 35°RSP HSS-E TiN – M 6 x 1.0	31738
1x Machine taps DIN 371 Form C 35°RSP HSS-E TiN – M 8 x 1.25	31742
1x Machine taps DIN 371 Form C 35°RSP HSS-E TiN – M 10 x 1.5	31746
1x Machine taps DIN 376 Form C 35°RSP HSS-E TiN – M 12 x 1.75	31750

P.K.40 HSS-E Machine taps (set of 14 pcs.) (47901)

DIN 371/376 M 3 – M 12

Type of thread	Standard	Material	Tolerance	Packing	Size
metric ISO thread DIN 13	DIN 371/376	HSS-E	ISO 2 /6H	in plastic case	Diameter M 3 - 12

Application/ for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- long chipping material
- for through holes

Contents:	Art. -No.
1x Machine taps DIN 371 Form B HSS-E – M 3 x 0.5	37526
1x Machine taps DIN 371 Form B HSS-E – M 4 x 0.7	37530
1x Machine taps DIN 371 Form B HSS-E – M 5 x 0.8	37534
1x Machine taps DIN 371 Form B HSS-E – M 6 x 1.0	37538
1x Machine taps DIN 371 Form B HSS-E – M 8 x 1.25	37542
1x Machine taps DIN 371 Form B HSS-E – M 10 x 1.5	37546
1x Machine taps DIN 371 Form C 35°RSP HSS-E – M 3 x 0.5	37726
1x Machine taps DIN 371 Form C 35°RSP HSS-E – M 4 x 0.7	37730
1x Machine taps DIN 371 Form C 35°RSP HSS-E – M 5 x 0.8	37734
1x Machine taps DIN 371 Form C 35°RSP HSS-E – M 6 x 1.0	37738
1x Machine taps DIN 371 Form C 35°RSP HSS-E – M 8 x 1.25	37742
1x Machine taps DIN 371 Form C 35°RSP HSS-E – M 10 x 1.5	37746
1x Machine taps DIN 376 Form B HSS-E – M 12 x 1.75	38550
1x Machine taps DIN 376 Form C 35°RSP HSS-E – M 12 x 1.75	38750

Micro machine taps DIN 371

Form B HSS-E – M

Type of thread: metric ISO-thread DIN 13 — Tolerance: ISO 2 /6H

Variants (7):

Advantages:

- safe production process and precise cutting of micro-threads M1 - M1.8
- for all-purpose
- best industrial quality
- immediately available frostock

Application/for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- Form B for through holes

D	L1	L2	D2	Square	Art.-No.
M 1 x 0.25	40	5	2.5	2.1	37502
M 1.1 x 0.25	40	5	2.5	2.1	37504
M 1.2 x 0.25	40	5	2.5	2.1	37506
M 1.4 x 0.30	40	7	2.5	2.1	37508
M 1.6 x 0.35	40	8	2.5	2.1	37510
M 1.7 x 0.35	40	8	2.5	2.1	37512
M 1.8 x 0.35	40	8	2.5	2.1	37514

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

Micro machine taps DIN 371

Form C 35°RSP HSS-E – M

Type of thread: metric ISO-thread DIN 13 | Tolerance: ISO 2 /6H

Variants (7):

Advantages:

- safe production process and precise cutting of micro-threads M1 - M1.8
- for all-purpose
- best industrial quality
- immediately available frostock

Application/for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- Form C 35° RSP for blind holes

D		L1	L2	D2	Square	Art.-No.
M	1 x 0.25	40	4	2.5	2.1	37702
M	1.1 x 0.25	40	4	2.5	2.1	37704
M	1.2 x 0.25	40	4	2.5	2.1	37706
M	1.4 x 0.30	40	5	2.5	2.1	37708
M	1.6 x 0.35	40	6	2.5	2.1	37710
M	1.7 x 0.35	40	6	2.5	2.1	37712
M	1.8 x 0.35	40	6	2.5	2.1	37714

Machine taps DIN 371

Form B HSS-E – M + Form B HSS-E TiN – M + Form B HSS-E VAP – M

Type of thread: metric ISO-thread DIN 13 | Tolerance: ISO 2 /6H

Variants (10/6/6):

Application/ for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through holes

TIN-coating:

- improved resistance to wear and abrasion
- excellent anti-friction properties
- faster cutting speeds possible

VAP-coating:

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

D		L1	L2	D2	Square	Art.-No. B	Art.-No. TIN	Art.-No. VAP
M	2 x 0.4	45	8	2.8	2.1	37516	-	-
M	2.5 x 0.45	50	9	2.8	2.1	37522	-	-
M	3 x 0.5	56	11	3.5	2.7	37526	31526	31570
M	3.5 x 0.6	56	13	4.0	3.0	37528	-	-
M	4 x 0.7	63	13	4.5	3.4	37530	31530	31571
M	5 x 0.8	70	16	6.0	4.9	37534	31534	31572
M	6 x 1.0	80	19	6.0	4.9	37538	31538	31573
M	7 x 1.0	80	19	7.0	5.5	37540	-	-
M	8 x 1.25	90	22	8.0	6.2	37542	31542	31574
M	10 x 1.5	100	24	10.0	8.0	37546	31546	31575

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

Machine taps DIN 376

Form B HSS-E – M + Form B HSS-E TiN – M + Form B HSS-E VAP – M

Type of thread: metric ISO-thread DIN 13 | Tolerance: ISO 2 /6H

Variants (23/5/5):

Application/ for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through holes

TIN-coating:

- improved resistance to wear and abrasion
- excellent anti-friction properties
- faster cutting speeds possible

VAP-coating:

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

D		L1	L2	D2	Square	Art.-No. B	Art.-No. TIN	Art.-No. VAP
M	3 x 0.5	56	11	2.2	-	38526	-	-
M	4 x 0.7	63	13	2.8	2.1	38530	-	-
M	5 x 0.8	70	16	3.5	2.7	38534	-	-
M	6 x 1.0	80	19	4.5	3.4	38538	-	-
M	8 x 1.25	90	22	6.0	4.9	38542	-	-
M	9 x 1.25	90	22	7.0	5.5	38544	-	-
M	10 x 1.5	100	24	7.0	5.5	38546	-	-
M	12 x 1.75	110	29	9.0	7.0	38550	31550	31576
M	14 x 2.0	110	30	11.0	9.0	38554	31554	31577
M	16 x 2.0	110	32	12.0	9.0	38558	31558	31578
M	18 x 2.5	125	34	14.0	11.0	38562	31562	31579
M	20 x 2.5	140	34	16.0	12.0	38566	31566	31580
M	22 x 2.5	140	34	18.0	14.5	38570	-	-
M	24 x 3.0	160	38	18.0	14.5	38574	-	-
M	27 x 3.0	160	38	20.0	16.0	38576	-	-
M	30 x 3.5	180	45	22.0	18.0	38578	-	-
M	33 x 3.5	180	50	25.0	20.0	38580	-	-
M	36 x 4.0	200	56	28.0	22.0	38582	-	-
M	39 x 4.0	200	60	32.0	24.0	38584	-	-
M	42 x 4.5	200	60	32.0	24.0	38586	-	-
M	45 x 4.5	220	65	36.0	29.0	38588	-	-
M	48 x 5.0	250	70	36.0	29.0	38590	-	-
M	52 x 5.0	250	70	40.0	32.0	38592	-	-

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

Machine taps DIN 376

Form C 35°RSP HSS-E – M – M + Form C 35°RSP HSS-E TiN – M + Form C 35°RSP HSS-E VAP – M

Type of thread: metric ISO-thread DIN 13 | Tolerance: ISO 2 /6H

Variants (10/6/6):

Application/ for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for blind holes

TIN-coating:

- improved resistance to wear and abrasion
- excellent anti-friction properties
- faster cutting speeds possible

VAP-coating:

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

D		L1	L2	D2	Square	Art.-No. C 35°	Art.-No. TIN	Art.-No. VAP
M	2 x 0.4	45	6	2.8	2.1	37716	-	-
M	2.5 x 0.45	50	6	2.8	2.1	37722	-	-
M	3 x 0.5	56	6	3.5	2.7	37726	31726	31770
M	3.5 x 0.6	56	6	4.0	3.0	37728	-	-
M	4 x 0.7	63	7	4.5	3.4	37730	31730	31771
M	5 x 0.8	70	8	6.0	4.9	37734	31734	31772
M	6 x 1.0	80	10	6.0	4.9	37738	31738	31773
M	7 x 1.0	80	12	7.0	5.5	37740	-	-
M	8 x 1.25	90	14	8.0	6.2	37742	31742	31774
M	10 x 1.5	100	16	10.0	8.0	37746	31746	31775

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

Machine taps DIN 376

Form C 35°RSP HSS-E – M + Form C 35°RSP HSS-E TiN – M
+ Form C 35°RSP HSS-E VAP – M

Type of thread: metric ISO-thread DIN 13 | Tolerance: ISO 2 /6H

Variants (22/5/5):

Application/ for general use:

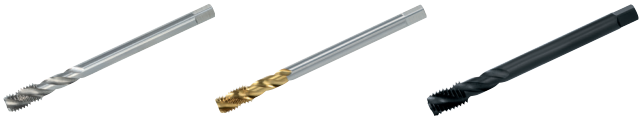
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for blind holes

TIN-coating:

- improved resistance to wear and abrasion
- excellent anti-friction properties
- faster cutting speeds possible

VAP-coating:

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



D		L1	L2	D2	Square	Art.-No. B	Art.-No. TIN	Art.-No. VAP
M	3 x 0.5	56	6	2.2	-	38726	-	-
M	4 x 0.7	63	7	2.8	2.1	38730	-	-
M	5 x 0.8	70	8	3.5	2.7	38734	-	-
M	6 x 1.0	80	10	4.5	3.4	38738	-	-
M	8 x 1.25	90	14	6.0	4.9	38742	-	-
M	10 x 1.5	100	16	7.0	5.5	38746	-	-
M	12 x 1.75	110	18	9.0	7.0	38750	31750	31776
M	14 x 2.0	110	20	11.0	9.0	38754	31754	31777
M	16 x 2.0	110	22	12.0	9.0	38758	31758	31778
M	18 x 2.5	125	25	14.0	11.0	38762	31762	31779
M	20 x 2.5	140	25	16.0	12.0	38766	31766	31780
M	22 x 2.5	140	27	18.0	14.5	38770	-	-
M	24 x 3.0	160	30	18.0	14.5	38774	-	-
M	27 x 3.0	160	30	20.0	16.0	38776	-	-
M	30 x 3.5	180	35	22.0	18.0	38778	-	-
M	33 x 3.5	180	35	25.0	20.0	38780	-	-
M	36 x 4.0	200	40	28.0	22.0	38782	-	-
M	39 x 4.0	200	40	32.0	24.0	38784	-	-
M	42 x 4.5	200	45	32.0	24.0	38786	-	-
M	45 x 4.5	220	45	36.0	29.0	38788	-	-
M	48 x 5.0	250	50	36.0	29.0	38790	-	-
M	52 x 5.0	250	50	40.0	32.0	38792	-	-

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

Machine taps DIN 371
Form B-AZ HSS-E – M

Type of thread: metric ISO-thread DIN 13 | Tolerance: ISO 2 /6H

Variants (6):

Application/for general use:
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through holes

D	L1	L2	D2	Square	Art.-No.
M 3 x 0.5	56	11	3.5	2.7	37926
M 4 x 0.7	63	13	4.5	3.4	37930
M 5 x 0.8	70	16	6.0	4.9	37934
M 6 x 1.0	80	19	6.0	4.9	37938
M 8 x 1.25	90	22	8.0	6.2	37942
M 10 x 1.5	100	24	10.0	8.0	37946

Machine taps DIN 376
Form B-AZ HSS-E – M

Type of thread: metric ISO-thread DIN 13 | Tolerance: ISO 2 /6H

Variants (13):

Application/for general use:
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through holes

D	L1	L2	D2	Square	Art.-No.
M 3 x 0.5	56	11	2.2	-	38926
M 4 x 0.7	63	13	2.8	2.1	38930
M 5 x 0.8	70	16	3.5	2.7	38934
M 6 x 1.0	80	19	4.5	3.4	38938
M 8 x 1.25	90	22	6.0	4.9	38942
M 10 x 1.5	100	24	7.0	5.5	38946
M 12 x 1.75	110	29	9.0	7.0	38950
M 14 x 2.0	110	30	11.0	9.0	38954
M 16 x 2.0	110	32	12.0	9.0	38958
M 18 x 2.5	125	34	14.0	11.0	38962
M 20 x 2.5	140	34	16.0	12.0	38966
M 22 x 2.5	140	34	18.0	14.5	38970
M 24 x 3.0	160	38	18.0	14.5	38974

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

Machine taps DIN 371
Form C 15°RSP HSS-E – M

Type of thread: metric ISO-thread DIN 13 | Tolerance: ISO 2 /6H

Variants (8):

Application/for general use:
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for blind holes

D	L1	L2	D2	Square	Art.-No.
M 3 x 0.5	56	11	3.5	2.7	37626
M 3.5 x 0.5	56	13	4.0	3.0	37628
M 4 x 0.7	63	13	4.5	3.4	37630
M 5 x 0.8	70	16	6.0	4.9	37634
M 6 x 1.0	80	19	6.0	4.9	37638
M 7 x 1.0	80	19	7.0	5.5	37640
M 8 x 1.25	90	22	8.0	6.2	37642
M 10 x 1.5	100	24	10.0	8.0	37646

Machine taps DIN 376
Form C 15°RSP HSS-E – M

Type of thread: metric ISO-thread DIN 13 | Tolerance: ISO 2 /6H

Variants (13):

Application/for general use:
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for blind holes

D	L1	L2	D2	Square	Art.-No.
M 3 x 0.5	56	11	2.2	-	38626
M 4 x 0.7	63	13	2.8	2.1	38630
M 5 x 0.8	70	16	3.5	2.7	38634
M 6 x 1.0	80	19	4.5	3.4	38638
M 8 x 1.25	90	22	6.0	4.9	38642
M 10 x 1.5	100	24	7.0	5.5	38646
M 12 x 1.75	110	29	9.0	7.0	38650
M 14 x 2.0	110	30	11.0	9.0	38654
M 16 x 2.0	110	32	12.0	9.0	38658
M 18 x 2.5	125	34	14.0	11.0	38662
M 20 x 2.5	140	34	16.0	12.0	38666
M 22 x 2.5	140	34	18.0	14.5	38670
M 24 x 3.0	160	38	18.0	14.5	38674

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

Machine taps

JIS B-4430 HSS-E – M

Type of thread: metric ISO-thread DIN 13 | Tolerance: ISO 2 /6H

Variants (2/16/19):

Application/ for general use:

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

D		L1	L2	D2	Square	Art.-No.*	Art.-No.*	Art.-No.**
M	2.5 x 0.45	44	16	3	2.5	-	-	90718
M	2.6 x 0.45	44	16	3	2.5	-	90520	90720
M	3 x 0.5	46	18	4	3.2	-	90522	90722
M	3.5 x 0.6	48	18	4	3.2	-	90524	90724
M	4 x 0.7	52	20	5	4	-	90526	90726
M	5 x 0.8	60	22	5.5	4.5	-	90530	90730
M	6 x 1.0	62	24	6	4.5	-	90538	90738
M	7 x 1.0	65	26	6.2	4.5	-	90544	90744
M	8 x 1.25	70	30	6.2	5	-	90546	90746
M	10 x 1.5	75	32	7	5.5	-	90554	90754
M	12 x 1.75	82	38	8.5	6.5	-	90560	90760
M	14 x 2.0	88	42	10.5	8	-	90566	90766
M	16 x 2.0	95	45	12.5	10	-	90572	90772
M	18 x 2.5	100	48	14	11	-	90578	90778
M	20 x 2.5	105	50	15	12	-	90584	90784
M	22 x 2.5	115	55	17	13	-	90590	90790
M	24 x 3.0	120	58	19	15	-	90596	90796
M	27	130	62	20	15	91502	-	91702
M	30	135	65	23	17	91508	-	91708

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

Machine taps DIN 371
Form A HSS-E – M

Type of thread: metric ISO-thread DIN 13 | Tolerance: ISO 2 /6H

Variants (10):

Application/for general use:
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through holes

D	L1	L2	D2	Square	Art.-No.
M 2 x 0.4	45	8	2.8	2.1	37316
M 2.3 x 0.4	45	9	2.8	2.1	37318
M 2.5 x 0.45	50	9	2.8	2.1	37322
M 2.6 x 0.45	50	9	2.8	2.1	37324
M 3 x 0.5	56	11	3.5	2.7	37326
M 4 x 0.7	63	13	4.5	3.4	37330
M 5 x 0.8	70	16	6.0	4.9	37334
M 6 x 1.0	80	19	6.0	4.9	37338
M 8 x 1.25	90	22	8.0	6.2	37342
M 10 x 1.5	100	24	10.0	8.0	37346

Machine taps DIN 376
Form A HSS-E – M

Type of thread: metric ISO-thread DIN 13 | Tolerance: ISO 2 /6H

Variants (16):

Application/for general use:
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through holes

D	L1	L2	D2	Square	Art.-No.
M 2 x 0.4	45	8	1.4	-	38316
M 3 x 0.5	56	11	2.2	-	38326
M 4 x 0.7	63	13	2.8	2.1	38330
M 5 x 0.8	70	16	3.5	2.7	38334
M 6 x 1.0	80	19	4.5	3.4	38338
M 8 x 1.25	90	22	6.0	4.9	38342
M 10 x 1.5	100	24	7.0	5.5	38346
M 12 x 1.75	110	29	9.0	7.0	38350
M 14 x 2.0	110	30	11.0	9.0	38354
M 16 x 2.0	110	32	12.0	9.0	38358
M 18 x 2.5	125	34	14.0	11.0	38362
M 20 x 2.5	140	34	16.0	12.0	38366
M 22 x 2.5	140	34	18.0	14.5	38370
M 24 x 3.0	160	38	18.0	14.5	38374
M 27 x 3.0	160	38	20.0	16.0	38376
M 30 x 3.5	180	45	22.0	18.0	38378

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

Machine taps DIN 371

Form C HSS-E – M

Type of thread: metric ISO-thread DIN 13 | Tolerance: ISO 2 /6H

Variants (12):

Application/for general use:

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

D	L1	L2	D2	Square	Art.-No.
M 2 x 0.4	45	8	2.8	2.1	37416
M 2.3 x 0.4	45	9	2.8	2.1	37418
M 2.5 x 0.45	50	9	2.8	2.1	37422
M 2.6 x 0.45	50	9	2.8	2.1	37424
M 3 x 0.5	56	11	3.5	2.7	37426
M 3.5 x 0.6	56	13	4.0	3.0	37428
M 4 x 0.7	63	13	4.5	3.4	37430
M 5 x 0.8	70	16	6.0	4.9	37434
M 6 x 1.0	80	19	6.0	4.9	37438
M 7 x 1.0	80	19	7.0	5.5	37440
M 8 x 1.25	90	22	8.0	6.2	37442
M 10 x 1.5	100	24	10.0	8.0	37446

Machine taps DIN 376

Form C HSS-E – M

Type of thread: metric ISO-thread DIN 13 | Tolerance: ISO 2 /6H

Variants (23):

Application/for general use:

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

D	L1	L2	D2	Square	Art.-No.	D	L1	L2	D2	Square	Art.-No.
M 3 x 0.5	56	11	2.2	-	38426	M 22 x 2.5	140	34	18.0	14.5	38470
M 4 x 0.7	63	13	2.8	2.1	38430	M 24 x 3.0	160	38	18.0	14.5	38474
M 5 x 0.8	70	16	3.5	2.7	38434	M 27 x 3.0	160	38	20.0	16.0	38476
M 6 x 1.0	80	19	4.5	3.4	38438	M 30 x 3.5	180	45	22.0	18.0	38478
M 8 x 1.25	90	22	6.0	4.9	38442	M 33 x 3.5	180	50	25.0	20.0	38480
M 10 x 1.5	100	24	7.0	5.5	38446	M 36 x 4.0	200	56	28.0	22.0	38482
M 11 x 1.5	100	24	8.0	6.2	38448	M 39 x 4.0	200	60	32.0	24.0	38484
M 12 x 1.75	110	29	9.0	7.0	38450	M 42 x 4.5	200	60	32.0	24.0	38486
M 14 x 2.0	110	30	11.0	9.0	38454	M 45 x 4.5	220	65	36.0	29.0	38488
M 16 x 2.0	110	32	12.0	9.0	38458	M 48 x 5.0	250	70	36.0	29.0	38490
M 18 x 2.5	125	34	14.0	11.0	38462	M 52 x 5.0	250	70	40.0	32.0	38492
M 20 x 2.5	140	34	16.0	12.0	38466						

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

TwinBox DIN 371/376

Form B HSS-E – M + Form C 35°RSP HSS-E – M

Type of thread: metric ISO-thread DIN 13 | Tolerance: ISO 2 /6H

Variants (9/9):

Application/for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- Form B for through holes
- Form C for blind holes

HSS-G Twist Drill DIN 338, Typ N
bright finish, profile ground

D	Machine Tap	Twist Drill	Art.-No. Form B	Art.-No. Form C
M 3 x 0.5	DIN 371	2.5 mm	37590	37790
M 4 x 0.7	DIN 371	3.3 mm	37591	37791
M 5 x 0.8	DIN 371	4.2 mm	37592	37792
M 6 x 1.0	DIN 371	5.0 mm	37593	37793
M 8 x 1.25	DIN 371	6.8 mm	37594	37794
M 10 x 1.5	DIN 371	8.5 mm	37595	37795
M 12 x 1.75	DIN 376	10.2 mm	38596	38796
M 14 x 2.0	DIN 376	12.0 mm	38597	38797
M 16 x 2.0	DIN 376	14.0 mm	38598	38798

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

M - extra long

Machine taps, extra long

≈ DIN 371 HSS-E – M

Type of thread: metric ISO-thread DIN 13 | Tolerance: ISO 2 /6H

Variants (7/7+6/6+6/6+6/6):

Application/ for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for thread cutting in hard to be reached places
- for through holes*
- for blind holes**

100 mm: D		L1	L2 Form B	L2 Form C	D2	Square	Art.-No.* Form B	Art.-No.** Form C
M	3 x 0.5	100	11	6	3.5	2.7	32010	32040
M	4 x 0.7	100	13	7	4.5	3.4	32011	32041
M	5 x 0.8	100	16	8	6.0	4.9	32012	32042
M	6 x 1.0	100	19	10	6.0	4.9	32013	32043
M	8 x 1.25	100	22	14	8.0	6.2	32014	32044
M	10 x 1.5	100	24	16	10.0	8.0	32015	32045
M	12 x 1.75	100	29	18	12.0	9.0	32016	32046

120 mm: D		L1	L2 Form B	L2 Form C	D2	Square	Art.-No.* Form B	Art.-No.** Form C
M	4 x 0.7	120	13	7	4.5	3.4	32021	32051
M	5 x 0.8	120	16	8	6.0	4.9	32022	32052
M	6 x 1.0	120	19	10	6.0	4.9	32023	32053
M	8 x 1.25	120	22	14	8.0	6.2	32024	32054
M	10 x 1.5	120	24	16	10.0	8.0	32025	32055
M	12 x 1.75	120	29	18	12.0	9.0	32026	32056

150 mm: D		L1	L2 Form B	L2 Form C	D2	Square	Art.-No.* Form B	Art.-No.** Form C
M	4 x 0.7	150	13	7	4.5	3.4	32031	32061
M	5 x 0.8	150	16	8	6.0	4.9	32032	32062
M	6 x 1.0	150	19	10	6.0	4.9	32033	32063
M	8 x 1.25	150	22	14	8.0	6.2	32034	32064
M	10 x 1.5	150	24	16	10.0	8.0	32035	32065
M	12 x 1.75	150	29	18	12.0	9.0	32036	32066

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

150 mm, reduced shank: D		L1	L2 Form B	L2 Form C	D2	Square	Art.-No.* Form B	Art.-No.** Form C
M	4 x 0.7	150	13	7	2.8	2.1	32071	32081
M	5 x 0.8	150	16	8	3.5	2.7	32072	32082
M	6 x 1.0	150	19	10	4.5	3.4	32073	32083
M	8 x 1.25	150	22	14	6.0	4.9	32074	32084
M	10 x 1.5	150	24	16	7.0	5.5	32075	32085
M	12 x 1.75	150	29	18	9.0	7.0	32076	32086

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

M - 6G - 7G - +0,1 - 4H

Machine taps, oversize

6G, 7G, +0,1 - DIN 371/376 HSS-E – M

Type of thread: metric ISO-thread DIN 13 | Tolerance: 6G/7G/+0,1

Variants (12/11+7/7+7/7):

Application/ for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- long chipping material
- for through holes*
- for blind holes**

6G		L1	L2 Form B	L2 Form C	D2	Square	Art.-No.* Form B	Art.-No.** Form C
		DIN 371						
M	2.5 x 0.45	50	9	-	2.8	2.1	32522	-
M	3 x 0.5	56	11	6	3.5	2.7	32526	32726
M	4 x 0.7	63	13	7	4.5	3.4	32530	32730
M	5 x 0.8	70	16	8	6.0	4.9	32534	32734
M	6 x 1.0	80	19	10	6.0	4.9	32538	32738
M	8 x 1.25	90	22	14	8.0	6.2	32542	32742
M	10 x 1.5	100	24	16	10.0	8.0	32546	32746
		DIN 376						
M	12 x 1.75	110	29	18	9.0	7.0	32550	32750
M	14 x 2.0	110	30	20	11.0	9.0	32554	32754
M	16 x 2.0	110	32	22	12.0	9.0	32558	32758
M	18 x 2.5	125	34	25	14.0	11.0	32562	32762
M	20 x 2.5	140	34	25	16.0	12.0	32566	32766

7G		L1	L2 Form B	L2 Form C	D2	Square	Art.-No.* Form B	Art.-No.** Form C
		DIN 371						
M	3 x 0.5	56	11	6	3.5	2.7	32503	32703
M	4 x 0.7	63	13	7	4.5	3.4	32504	32704
M	5 x 0.8	70	16	8	6.0	4.9	32505	32705
M	6 x 1.0	80	19	10	6.0	4.9	32506	32706
M	8 x 1.25	90	22	14	8.0	6.2	32508	32708
M	10 x 1.5	100	24	16	10.0	8.0	32510	32710
		DIN 376						
M	12 x 1.75	110	29	18	9.0	7.0	32512	32712

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

+0,1 mm		L1	L2 Form B	L2 Form C	D2	Square	Art.-No.* Form B	Art.-No.** Form C
		DIN 371						
M	3 x 0.5	56	11	6	3.5	2.7	32583	32783
M	4 x 0.7	63	13	7	4.5	3.4	32584	32784
M	5 x 0.8	70	16	8	6.0	4.9	32585	32785
M	6 x 1.0	80	19	10	6.0	4.9	32586	32786
M	8 x 1.25	90	22	14	8.0	6.2	32588	32788
M	10 x 1.5	100	24	16	10.0	8.0	32590	32790
		DIN 376						
M	12 x 1.75	110	29	18	9.0	7.0	32592	32792

Machine taps, undersize

4H - DIN 371/376 HSS-E – M

Type of thread: metric ISO-thread DIN 13 | Tolerance: 4H

Variants (9/9):

Application/ for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- long chipping material
- for through holes*
- for blind holes**

4H		L1	L2 Form B	L2 Form C	D2	Square	Art.-No.* Form B	Art.-No.** Form C
		DIN 371						
M	3 x 0.5	56	11	6	3.5	2.7	32612	32652
M	4 x 0.7	63	13	7	4.5	3.4	32614	32654
M	5 x 0.8	70	16	8	6.0	4.9	32616	32656
M	6 x 1.0	80	19	10	6.0	4.9	32618	32658
M	8 x 1.25	90	22	14	8.0	6.2	32620	32660
M	10 x 1.5	100	24	16	10.0	8.0	32622	32662
		DIN 376						
M	12 x 1.75	110	29	18	9.0	7.0	32624	32664
M	14 x 2.0	110	30	20	11.0	9.0	32625	32665
M	16 x 2.0	110	32	22	12.0	9.0	32626	32666

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

M (left hand) LH

Machine taps, left hand

DIN 371/376 Form B HSS-E – M LH
+ DIN 376 Form C 35°SP HSS-E – M LH

Type of thread: metric ISO-thread DIN 13 | Tolerance: ISO 2 /6H

Variants (7/22+6/22):

Application/ for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- long chipping material
- for through holes*
- for blind holes**

DIN 371 D		L1	L2 Form B	L2 Form C	D2	Square	Art.-No.* Form B	Art.-No.** Form C
M	3 x 0.5	56	11	6	3.5	2.7	33526	33726
M	4 x 0.7	63	13	7	4.5	3.4	33530	33730
M	5 x 0.8	70	16	8	6.0	4.9	33534	33734
M	6 x 1.0	80	19	10	6.0	4.9	33538	33738
M	7 x 1.0	80	19	-	7.0	5.5	33540	-
M	8 x 1.25	90	22	14	8.0	6.2	33542	33742
M	10 x 1.5	100	24	16	10.0	8.0	33546	33746

DIN 376 D		L1	L2 Form B	L2 Form C	D2	Square	Art.-No.* Form B	Art.-No.** Form C
M	3 x 0.5	56	11	6	2.2	-	34526	34726
M	4 x 0.7	63	13	7	2.8	2.1	34530	34730
M	5 x 0.8	70	16	8	3.5	2.7	34534	34734
M	6 x 1.0	80	19	10	4.5	3.4	34538	34738
M	8 x 1.25	90	22	14	6.0	4.9	34542	34742
M	10 x 1.5	100	24	16	7.0	5.5	34546	34746
M	12 x 1.75	110	29	18	9.0	7.0	34550	34750
M	14 x 2.0	110	30	20	11.0	9.0	34554	34754
M	16 x 2.0	110	32	22	12.0	9.0	34558	34758
M	18 x 2.5	125	34	25	14.0	11.0	34562	34762
M	20 x 2.5	140	34	25	16.0	12.0	34566	34766

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

DIN 376 D		L1	L2 Form B	L2 Form C	D2	Square	Art.-No.* Form B	Art.-No.** Form C
M	22 x 2.5	140	34		18.0	14.5	34570	34770
M	24 x 3.0	160	38		18.0	14.5	34574	34774
M	27 x 3.0	160	38		20.0	16.0	34576	34776
M	30 x 3.5	180	45		22.0	18.0	34578	34778
M	33 x 3.5	180	50		25.0	20.0	34580	34780
M	36 x 4.0	200	56		28.0	22.0	34582	34782
M	39 x 4.0	200	60		32.0	24.0	34584	34784
M	42 x 4.5	200	60		32.0	24.0	34586	34786
M	45 x 4.5	220	65		36.0	29.0	34588	34788
M	48 x 5.0	250	70		36.0	29.0	34590	34790
M	52 x 5.0	250	70		40.0	32.0	34592	34792

Machine taps, left hand

left hand DIN 371/376 Form C HSS-E – M LH

Type of thread: metric ISO-thread DIN 13 Tolerance: ISO 2 /6H

Variants (13):

Application/ for general use:

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

D		L1 DIN 371	L2	D2	Square	Art.-No.*
M	3 x 0.5	56	11	3.5	2.7	33426
M	4 x 0.7	63	13	4.5	3.4	33430
M	5 x 0.8	70	16	6.0	4.9	33434
M	6 x 1.0	80	19	6.0	4.9	33438
M	8 x 1.25	90	22	8.0	6.2	33442
M	10 x 1.5	100	24	10.0	8.0	33446
		DIN 376				
M	12 x 1.75	110	29	9.0	7.0	34450
M	14 x 2.0	110	30	11.0	9.0	34454
M	16 x 2.0	110	32	12.0	9.0	34458
M	18 x 2.5	125	34	14.0	11.0	34462
M	20 x 2.5	140	34	16.0	12.0	34466
M	22 x 2.5	140	34	18.0	14.5	34470
M	24 x 3.0	160	38	18.0	14.5	34474

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

Machine taps, left hand

ISO 529 HSS-G – M LH + ISO 529 35°SP HSS-G – M LH

Type of thread: metric ISO-thread DIN 13 | Tolerance: ISO 2 /6H

Variants (7/7):

Application/ for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel

- for thread cutting by hand and machine**
- for through holes*
- for through and blind holes**

D		L1	L2	D2	Square	Art.-No.*	Art.-No.** /SP
M	3 x 0.5	48	11	3.15	2.5	80810	80850
M	4 x 0.7	53	13	4	3.15	80812	80852
M	5 x 0.8	58	16	5	4	80814	80854
M	6 x 1.0	66	19	6.3	5	80816	80856
M	8 x 1.25	72	22	8	6.3	80818	80858
M	10 x 1.5	80	24	10	8	80820	80860
M	12 x 1.75	89	29	9	7.1	80822	80862

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

Mf (metric fine)

Machine taps

DIN 374 Form B HSS-E – Mf + Form C 35°RSP HSS-E – Mf

Type of thread: metric ISO-thread DIN 13 | Tolerance: ISO 2 /6H

Variants (103/103):

Application/ for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through holes*
- for blind holes**

D		L1	L2 Form B	L2 Form C	D2	Square	Art.-No.* Form B	Art.-No.** Form C
M	3 x 0.35	56	9	5	2.2	-	39501	39701
M	4 x 0.35	63	10	5	2.8	2.1	39502	39702
M	4 x 0.5	63	10	5	2.8	2.1	39503	39703
M	5 x 0.5	70	12	5	3.5	2.7	39504	39704
M	5 x 0.75	70	12	8	3.5	2.7	39505	39705
M	6 x 0.5	80	14	5	4.5	3.4	39506	39706
M	6 x 0.75	80	14	8	4.5	3.4	39507	39707
M	7 x 0.75	80	14	8	5.5	4.3	39508	39708
M	8 x 0.5	80	19	8	6.0	4.9	39509	39709
M	8 x 0.75	80	19	8	6.0	4.9	39510	39710
M	8 x 1.0	90	22	10	6.0	4.9	39511	39711
M	9 x 0.75	80	19	10	7.0	5.5	39512	39712
M	9 x 1.0	90	22	10	7.0	5.5	39513	39713
M	10 x 0.75	90	20	10	7.0	5.5	39514	39714
M	10 x 1.0	90	20	10	7.0	5.5	39515	39715
M	10 x 1.25	100	24	16	7.0	5.5	39516	39716
M	11 x 1.0	90	20	11	8.0	6.2	39517	39717
M	11 x 1.25	90	22	14	8.0	6.2	39518	39718
M	12 x 0.75	100	22	10	9.0	7.0	39519	39719
M	12 x 1.0	100	22	11	9.0	7.0	39520	39720
M	12 x 1.25	100	22	15	9.0	7.0	39521	39721
M	12 x 1.5	100	22	15	9.0	7.0	39522	39722
M	13 x 1.0	100	22	11	11.0	9.0	39523	39723
M	13 x 1.5	100	22	15	11.0	9.0	39524	39724
M	14 x 0.75	100	22	10	11.0	9.0	39525	39725
M	14 x 1.0	100	22	11	11.0	9.0	39526	39726
M	14 x 1.25	100	22	15	11.0	9.0	39527	39727
M	14 x 1.5	100	22	15	11.0	9.0	39528	39728

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

D		L1	L2 Form B	L2 Form C	D2	Square	Art.-No.* Form B	Art.-No.** Form C
M	15 x 1.0	100	22	12	12.0	9.0	39529	39729
M	15 x 1.5	100	22	15	12.0	9.0	39530	39730
M	16 x 1.0	100	22	12	12.0	9.0	39531	39731
M	16 x 1.25	100	22	15	12.0	9.0	39532	39732
M	16 x 1.5	100	22	15	12.0	9.0	39533	39733
M	18 x 1.0	110	25	13	14.0	11.0	39534	39734
M	18 x 1.25	110	25	15	14.0	11.0	39535	39735
M	18 x 1.5	110	25	17	14.0	11.0	39536	39736
M	18 x 2.0	125	34	20	14.0	11.0	39537	39737
M	20 x 1.0	125	25	14	16.0	12.0	39538	39738
M	20 x 1.25	125	25	17	16.0	12.0	39539	39739
M	20 x 1.5	125	25	17	16.0	12.0	39540	39740
M	20 x 2.0	140	34	20	16.0	12.0	39541	39741
M	21 x 1.5	125	25	17	16.0	12.0	39542	39742
M	22 x 1.0	125	25	14	18.0	14.5	39543	39743
M	22 x 1.25	125	25	17	18.0	14.5	39544	39744
M	22 x 1.5	125	25	17	18.0	14.5	39545	39745
M	22 x 2.0	140	34	20	18.0	14.5	39546	39746
M	23 x 1.5	125	25	17	18.0	14.5	39547	39747
M	24 x 1.0	140	28	15	18.0	14.5	39548	39748
M	24 x 1.25	140	28	17	18.0	14.5	39549	39749
M	24 x 1.5	140	28	20	18.0	14.5	39550	39750
M	24 x 2.0	140	28	20	18.0	14.5	39551	39751
M	25 x 1.0	140	28	15	18.0	14.5	39552	39752
M	25 x 1.5	140	28	20	18.0	14.5	39553	39753
M	26 x 1.0	140	28	15	18.0	14.5	3955X	3975X
M	26 x 1.5	140	28	20	18.0	14.5	39554	39754
M	26 x 2.0	140	28	20	18.0	14.5	39555	39755
M	27 x 1.0	140	28	15	20.0	16.0	39500	39700
M	27 x 1.5	140	28	20	20.0	16.0	39556	39756
M	27 x 2.0	140	28	20	20.0	16.0	39557	39757
M	28 x 1.0	140	28	15	20.0	16.0	39558	39758
M	28 x 1.5	140	28	20	20.0	16.0	39559	39759
M	28 x 2.0	140	28	20	20.0	16.0	39560	39760
M	29 x 1.5	150	28	22	22.0	18.0	39561	39761
M	30 x 1.0	150	28	17	22.0	18.0	39562	39762
M	30 x 1.5	150	28	22	22.0	18.0	39563	39763
M	30 x 2.0	150	28	22	22.0	18.0	39564	39764
M	30 x 2.5	180	45	27	22.0	18.0	3956X	3976X
M	30 x 3.0	180	45	30	22.0	18.0	39565	39765
M	32 x 1.5	150	28	22	22.0	18.0	39566	39766

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

D		L1	L2 Form B	L2 Form C	D2	Square	Art.-No.* Form B	Art.-No.** Form C
M	32 x 2.0	150	28	22	22.0	18.0	39567	39767
M	32 x 3.0	180	50	30	22.0	18.0	39592	39792
M	33 x 1.5	160	30	24	25.0	20.0	39593	39793
M	33 x 2.0	160	30	24	25.0	20.0	39568	39768
M	33 x 3.0	180	50	30	25.0	20.0	39569	39769
M	34 x 1.5	170	30	24	28.0	22.0	39570	39770
M	34 x 2.0	170	30	24	28.0	22.0	39571	39771
M	35 x 1.5	170	30	24	28.0	22.0	39572	39772
M	36 x 1.5	170	30	24	28.0	22.0	39573	39773
M	36 x 2.0	170	30	24	28.0	22.0	39574	39774
M	36 x 3.0	200	56	30	28.0	22.0	39575	39775
M	38 x 1.5	170	30	24	28.0	22.0	39576	39776
M	39 x 1.5	170	30	25	28.0	22.0	39577	39777
M	39 x 2.0	170	30	25	32.0	24.0	39578	39778
M	39 x 3.0	200	60	30	32.0	24.0	39579	39779
M	40 x 1.5	170	30	25	32.0	24.0	39580	39780
M	40 x 2.0	170	30	25	32.0	24.0	39581	39781
M	40 x 3.0	200	60	30	32.0	24.0	39582	39782
M	42 x 1.5	170	30	25	32.0	24.0	39583	39783
M	42 x 2.0	170	30	25	32.0	24.0	39584	39784
M	42 x 3.0	200	60	30	32.0	24.0	39585	39785
M	45 x 1.5	180	32	27	36.0	29.0	39586	39786
M	45 x 2.0	180	32	27	36.0	29.0	39587	39787
M	45 x 3.0	200	50	30	36.0	29.0	39588	39788
M	48 x 1.5	190	32	27	36.0	29.0	39589	39789
M	48 x 2.0	190	32	27	36.0	29.0	39590	39790
M	48 x 3.0	225	50	33	36.0	29.0	39591	39791
M	50 x 1.5	190	32	27	36.0	29.0	39594	39794
M	50 x 2.0	190	32	27	36.0	29.0	39595	39795
M	50 x 3.0	225	50	33	36.0	29.0	39596	39796
M	52 x 1.5	190	32	27	40.0	32.0	39597	39797
M	52 x 2.0	190	32	27	40.0	32.0	39598	39798
M	52 x 3.0	225	50	33	40.0	32.0	39599	39799
M	63 x 1.5	275	50	40	50.0	39.0	3959X	3979X

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

Machine taps

DIN 374 Form C HSS-E – Mf

Type of thread: metric ISO-thread DIN 13 | Tolerance: ISO 2 /6H

Variants (48):

Application/ for general use:

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

D	L1	L2	D2	Square	Art.-No.	D	L1	L2	D2	Square	Art.-No.
M 4 x 0.35	63	10	2.8	2.1	39402	M 22 x 2.0	140	34	18.0	14.5	39446
M 5 x 0.5	70	12	3.5	2.7	39404	M 24 x 1.0	140	28	18.0	14.5	39448
M 6 x 0.75	80	14	4.5	3.4	39407	M 24 x 1.5	140	28	18.0	14.5	39450
M 8 x 0.75	80	19	6.0	4.9	39410	M 24 x 2.0	140	28	18.0	14.5	39451
M 8 x 1.0	90	22	6.0	4.9	39411	M 25 x 1.0	140	28	18.0	14.5	39452
M 10 x 1.0	90	20	7.0	5.5	39415	M 26 x 1.5	140	28	18.0	14.5	39454
M 10 x 1.25	100	24	7.0	5.5	39416	M 27 x 1.5	140	28	20.0	16.0	39456
M 12 x 1.0	100	22	9.0	7.0	39420	M 27 x 2.0	140	28	20.0	16.0	39457
M 12 x 1.25	100	22	9.0	7.0	39421	M 28 x 1.5	140	28	20.0	16.0	39459
M 12 x 1.5	100	22	9.0	7.0	39422	M 30 x 1.5	150	28	22.0	18.0	39463
M 14 x 1.0	100	22	11.0	9.0	39426	M 30 x 2.0	150	28	22.0	18.0	39464
M 14 x 1.25	100	22	11.0	9.0	39427	M 32 x 1.5	150	28	22.0	18.0	39466
M 14 x 1.5	100	22	11.0	9.0	39428	M 32 x 2.0	150	28	22.0	18.0	39467
M 16 x 1.0	100	22	12.0	9.0	39431	M 33 x 2.0	160	30	25.0	20.0	39468
M 16 x 1.5	100	22	12.0	9.0	39433	M 35 x 1.5	170	30	28.0	22.0	39472
M 18 x 1.0	110	25	14.0	11.0	39434	M 36 x 1.5	170	30	28.0	22.0	39473
M 18 x 1.5	110	25	14.0	11.0	39436	M 36 x 2.0	170	30	28.0	22.0	39474
M 18 x 2.0	125	34	14.0	11.0	39437	M 38 x 1.5	170	30	28.0	22.0	39476
M 20 x 1.0	125	25	16.0	12.0	39438	M 40 x 1.5	170	30	32.0	24.0	39480
M 20 x 1.25	125	25	16.0	12.0	39439	M 42 x 1.5	170	30	32.0	24.0	39483
M 20 x 1.5	125	25	16.0	12.0	39440	M 45 x 1.5	180	32	36.0	29.0	39486
M 20 x 2.0	140	34	16.0	12.0	39441	M 48 x 1.5	190	32	36.0	29.0	39489
M 22 x 1.0	125	25	18.0	14.5	39443	M 50 x 1.5	190	32	36.0	29.0	39494
M 22 x 1.5	125	25	18.0	14.5	39445	M 52 x 1.5	190	32	40.0	32.0	39497

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

Machine taps

JIS B-4430 HSS-E – Mf

Type of thread: metric ISO-thread DIN 13 Tolerance: ISO 2 /6H - 2B

Variants (23/23):

Application/ for general use:

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

D		L1	L2	D2	Square	Art.-No.*	Art.-No.**
M	6 x 0.75	62	24	6	4.5	90540	90740
M	8 x 1.0	70	30	6.2	5	90548	90748
M	8 x 0.75	70	30	7	5	90550	90750
M	10 x 1.25	75	32	7	5.5	90555	90755
M	10 x 1.0	75	32	7	5.5	90556	90756
M	12 x 1.5	82	38	8.5	6.5	90562	90762
M	12 x 1.25	82	38	8.5	6.5	90563	90763
M	12 x 1.0	82	38	8.5	6.5	90564	90764
M	14 x 1.5	88	42	10.5	8	90568	90768
M	14 x 1.25	88	39	10.5	8	90569	90769
M	14 x 1.0	70	30	10.5	8	90570	90770
M	16 x 1.5	95	45	12.5	10	90574	90774
M	16 x 1.0	75	30	12.5	10	90576	90776
M	18 x 1.5	95	45	14	11	90580	90780
M	18 x 1.0	95	45	14	11	90582	90782
M	20 x 1.5	95	45	15	12	90586	90786
M	20 x 1.0	80	30	15	12	90588	90788
M	22 x 1.5	95	45	17	13	90592	90792
M	22 x 2.0	95	45	17	13	90593	90793
M	22 x 1.0	95	45	17	13	90594	90794
M	24 x 1.5	95	45	19	15	90598	90798
M	27 x 1.5	95	45	20	15	91506	91706
M	30 x 1.5	105	45	23	17	91509	91709

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

Machine taps

ISO 529 HSS-G – Mf

Type of thread: metric ISO-thread DIN 13 | Tolerance: ISO 2 /6H

Variants (10):

Application/ for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through holes

D		L1	L2	D2	Square	Art.-No.
M	3 x 0.35	48	11	3.15	2.5	81501
M	4 x 0.5	53	13	4	3.15	81503
M	5 x 0.5	58	16	5	4	81505
M	6 x 0.75	66	19	6.3	5	81507
M	8 x 1.0	69	19	8	6.3	81513
M	10 x 1.0	76	20	10	8	81518
M	10 x 1.25	76	20	10	8	81519
M	12 x 1.0	84	24	9	7.1	81523
M	12 x 1.25	84	24	9	7.1	81524
M	12 x 1.5	89	29	9	7.1	81525

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

Mf (left hand) LH

Machine taps, left hand

DIN 374 Form B HSS-E – Mf LH + DIN 374 Form C 35°SP HSS-E – Mf LH

Type of thread: metric ISO-thread DIN 13 | Tolerance: ISO 2 /6H

Variants (102/102):

Application/ for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through holes*
- for blind holes**

D		L1	L2 Form B	L2 Form C	D2	Square	Art.-No.* Form B	Art.-No.** Form C
M	3 x 0.35	56	9	5	2.2	-	34801	34901
M	4 x 0.35	63	10	5	2.8	2.1	34802	34902
M	4 x 0.5	63	10	5	2.8	2.1	34803	34903
M	5 x 0.5	70	12	5	3.5	2.7	34804	34904
M	5 x 0.75	70	12	8	3.5	2.7	34805	34905
M	6 x 0.5	80	14	5	4.5	3.4	34806	34906
M	6 x 0.75	80	14	8	4.5	3.4	34807	34907
M	7 x 0.75	80	14	8	5.5	4.3	34808	34908
M	8 x 0.5	80	19	8	6.0	4.9	34809	34909
M	8 x 0.75	80	19	8	6.0	4.9	34810	34910
M	8 x 1.0	90	22	10	6.0	4.9	34811	34911
M	9 x 0.75	80	19	10	7.0	5.5	34812	34912
M	9 x 1.0	90	22	10	7.0	5.5	34813	34913
M	10 x 0.75	90	20	10	7.0	5.5	34814	34914
M	10 x 1.0	90	20	10	7.0	5.5	34815	34915
M	10 x 1.25	100	24	16	7.0	5.5	34816	34916
M	11 x 1.0	90	20	11	8.0	6.2	34817	34917
M	11 x 1.25	90	22	14	8.0	6.2	34818	34918
M	12 x 0.75	100	22	10	9.0	7.0	34819	34919
M	12 x 1.0	100	22	11	9.0	7.0	34820	34920
M	12 x 1.25	100	22	15	9.0	7.0	34821	34921
M	12 x 1.5	100	22	15	9.0	7.0	34822	34922
M	13 x 1.0	100	22	11	11.0	9.0	34823	34923
M	13 x 1.5	100	22	15	11.0	9.0	34824	34924
M	14 x 0.75	100	22	10	11.0	9.0	34825	34925
M	14 x 1.0	100	22	11	11.0	9.0	34826	34926
M	14 x 1.25	100	22	15	11.0	9.0	34827	34927
M	14 x 1.5	100	22	15	11.0	9.0	34828	34928

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

D		L1	L2 Form B	L2 Form C	D2	Square	Art.-No.* Form B	Art.-No.** Form C
M	15 x 1.0	100	22	12	12.0	9.0	34829	34929
M	15 x 1.5	100	22	15	12.0	9.0	34830	34930
M	16 x 1.0	100	22	12	12.0	9.0	34831	34931
M	16 x 1.25	100	22	15	12.0	9.0	34832	34932
M	16 x 1.5	100	22	15	12.0	9.0	34833	34933
M	18 x 1.0	110	25	13	14.0	11.0	34834	34934
M	18 x 1.25	110	25	15	14.0	11.0	34835	34935
M	18 x 1.5	110	25	17	14.0	11.0	34836	34936
M	18 x 2.0	125	34	20	14.0	11.0	34837	34937
M	20 x 1.0	125	25	14	16.0	12.0	34838	34938
M	20 x 1.25	125	25	17	16.0	12.0	34839	34939
M	20 x 1.5	125	25	17	16.0	12.0	34840	34940
M	20 x 2.0	140	34	20	16.0	12.0	34841	34941
M	21 x 1.5	125	25	17	16.0	12.0	34842	34942
M	22 x 1.0	125	25	14	18.0	14.5	34843	34943
M	22 x 1.25	125	25	17	18.0	14.5	34844	34944
M	22 x 1.5	125	25	17	18.0	14.5	34845	34945
M	22 x 2.0	140	34	20	18.0	14.5	34846	34946
M	23 x 1.5	125	25	17	18.0	14.5	34847	34947
M	24 x 1.0	140	28	15	18.0	14.5	34848	34948
M	24 x 1.25	140	28	17	18.0	14.5	34849	34949
M	24 x 1.5	140	28	20	18.0	14.5	34850	34950
M	24 x 2.0	140	28	20	18.0	14.5	34851	34951
M	25 x 1.0	140	28	15	18.0	14.5	34852	34952
M	25 x 1.5	140	28	20	18.0	14.5	34853	34953
M	26 x 1.0	140	28	15	18.0	14.5	3485X	3495X
M	26 x 1.5	140	28	20	18.0	14.5	34854	34954
M	26 x 2.0	140	28	20	18.0	14.5	34855	34955
M	27 x 1.0	140	28	15	20.0	16.0	34800	34900
M	27 x 1.5	140	28	20	20.0	16.0	34856	34956
M	27 x 2.0	140	28	20	20.0	16.0	34857	34957
M	28 x 1.0	140	28	15	20.0	16.0	34858	34958
M	28 x 1.5	140	28	20	20.0	16.0	34859	34959
M	28 x 2.0	140	28	20	20.0	16.0	34860	34960
M	29 x 1.5	150	28	22	22.0	18.0	34861	34961
M	30 x 1.0	150	28	17	22.0	18.0	34862	34962
M	30 x 1.5	150	28	22	22.0	18.0	34863	34963
M	30 x 2.0	150	28	22	22.0	18.0	34864	34964
M	30 x 2.5	180	45	27	22.0	18.0	3486X	3496X
M	30 x 3.0	180	45	30	22.0	18.0	34865	34965
M	32 x 1.5	150	28	22	22.0	18.0	34866	34966

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

D		L1	L2 Form B	L2 Form C	D2	Square	Art.-No.* Form B	Art.-No.** Form C
M	32 x 2.0	150	28	22	22.0	18.0	34867	34967
M	32 x 3.0	180	50	30	22.0	18.0	34892	34992
M	33 x 1.5	160	30	24	25.0	20.0	34893	34993
M	33 x 2.0	160	30	24	25.0	20.0	34868	34968
M	33 x 3.0	180	50	30	25.0	20.0	34869	34969
M	34 x 1.5	170	30	24	28.0	22.0	34870	34970
M	34 x 2.0	170	30	24	28.0	22.0	34871	34971
M	35 x 1.5	170	30	24	28.0	22.0	34872	34972
M	36 x 1.5	170	30	24	28.0	22.0	34873	34973
M	36 x 2.0	170	30	24	28.0	22.0	34874	34974
M	36 x 3.0	200	56	30	28.0	22.0	34875	34975
M	38 x 1.5	170	30	24	28.0	22.0	34876	34976
M	39 x 1.5	170	30	25	28.0	22.0	34877	34977
M	39 x 2.0	170	30	25	32.0	24.0	34878	34978
M	39 x 3.0	200	60	30	32.0	24.0	34879	34979
M	40 x 1.5	170	30	25	32.0	24.0	34880	34980
M	40 x 2.0	170	30	25	32.0	24.0	34881	34981
M	40 x 3.0	200	60	30	32.0	24.0	34882	34982
M	42 x 1.5	170	30	25	32.0	24.0	34883	34983
M	42 x 2.0	170	30	25	32.0	24.0	34884	34984
M	42 x 3.0	200	60	30	32.0	24.0	34885	34985
M	45 x 1.5	180	32	27	36.0	29.0	34886	34986
M	45 x 2.0	180	32	27	36.0	29.0	34887	34987
M	45 x 3.0	200	50	30	36.0	29.0	34888	34988
M	48 x 1.5	190	32	27	36.0	29.0	34889	34989
M	48 x 2.0	190	32	27	36.0	29.0	34890	34990
M	48 x 3.0	225	50	33	36.0	29.0	34891	34991
M	50 x 1.5	190	32	27	36.0	29.0	34894	34994
M	50 x 2.0	190	32	27	36.0	29.0	34895	34995
M	50 x 3.0	225	50	33	36.0	29.0	34896	34996
M	52 x 1.5	190	32	27	40.0	32.0	34897	34997
M	52 x 2.0	190	32	27	40.0	32.0	34898	34998
M	52 x 3.0	225	50	33	40.0	32.0	34899	34999

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

BSW (Whitworth-thread)

Machine taps ≈ DIN 371/376 Form B HSS-E – BSW
+ ≈ DIN 371/376 Form C 35°RSP HSS-E – BSW

Type of thread: Whitworth-thread BS 84

Variants (8/13+8/13):

Application/ for general use:
› for through holes*
› for blind holes**
› non abrasive material up to 900 N/mm²
› unalloyed and low alloyed steel

DIN 371 D		L1	L2 Form B	L2 Form C	D2	Square	Art.-No.* Form B	Art.-No.** Form C
BSW	1/8 x 40	56	11	7	3.5	2.7	70506	70706
BSW	5/32 x 32	63	13	7	4.5	3.4	70508	70708
BSW	3/16 x 24	70	15	10	6.0	4.9	70510	70710
BSW	1/4 x 20	80	17	13	7.0	5.5	70514	70714
BSW	5/16 x 18	90	20	14	8.0	6.2	70516	70716
BSW	3/8 x 16	100	22	16	9.0	7.0	70518	70718
BSW	7/16 x 14	100	22	17	11.0	9.0	70520	70720
BSW	1/2 x 12	110	25	20	12.0	9.0	70522	70722

DIN 376 D		L1	L2 Form B	L2 Form C	D2	Square	Art.-No.* Form B	Art.-No.** Form C
BSW	1/4 x 20	80	17	13	4.5	3.4	71514	71714
BSW	5/16 x 18	90	20	14	6.0	4.9	71516	71716
BSW	3/8 x 16	100	22	16	7.0	5.5	71518	71718
BSW	7/16 x 14	100	22	17	8.0	6.2	71520	71720
BSW	1/2 x 12	110	25	20	9.0	7.0	71522	71722
BSW	9/16 x 12	110	26	20	11.0	9.0	71524	71724
BSW	5/8 x 11	110	27	22	12.0	9.0	71526	71726
BSW	3/4 x 10	125	30	25	14.0	11.0	71530	71730
BSW	7/8 x 9	140	32	27	18.0	14.5	71534	71734
BSW	1" x 8	160	36	30	20.0	16.0	71538	71738
BSW	1.1/4 x 7	180	40	35	22.0	18.0	71546	71746
BSW	1.3/8 x 6	200	50	40	28.0	22.0	71550	71750
BSW	1.1/2 x 6	200	50	40	32.0	24.0	71554	71754

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

Machine taps

ISO 529 HSS-G – BSW + ISO 529 35°RSP HSS-G – BSW

Type of thread: Whitworth-thread BS 84

Variants (21/16):

Application/ for general use:
- for through holes*
- for blind holes**
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for thread cutting by hand and machine*

D		L1	L2	D2	Square	Art.-No.*	Art.-No.** RSP
BSW	1/8 x 40	48	11	3.15	2.5	84506	84706
BSW	5/32 x 24	53	13	4	3.15	84508	-
BSW	3/16 x 24	58	16	5	4	84510	84710
BSW	7/32 x 24	62	17	5.6	4.5	84512	-
BSW	1/4 x 20	66	19	6.3	5	84514	84714
BSW	5/16 x 18	72	22	8	6.3	84516	84716
BSW	3/8 x 16	80	24	10	8	84518	84718
BSW	7/16 x 14	85	25	8	6.3	84520	84720
BSW	1/2 x 12	89	29	9	7.1	84522	84722
BSW	9/16 x 12	95	30	11.2	9	84524	84724
BSW	5/8 x 11	102	32	12.5	10	84526	84726
BSW	3/4 x 10	112	37	14	11.2	84530	84730
BSW	7/8 x 9	118	38	16	12.5	84534	84734
BSW	1" x 8	130	45	18	14	84538	84738
BSW	1.1/8 x 7	138	48	20	16	84540	84740
BSW	1.1/4 x 7	151	51	22.4	18	84542	84742
BSW	1.3/8 x 7	162	57	25	20	-	84744
BSW	1.1/2 x 6	170	60	28	22.4	84546	84746
BSW	1.5/8 x 5	170	60	28	22.4	84548	-
BSW	1.3/4 x 5	187	67	31.5	25	84550	-
BSW	2.1/4 x 4	221	76	40	31.5	84556	-
BSW	2.1/2 x 4	224	79	40	31.5	84558	-

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

BSF
(brit. standard fine)

Machine taps
ISO 529 HSS-G – BSF + ISO 529 35°RSP HSS-G – BSF

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

Variants (10/10):

Application/
for general use:
- for through holes*
- for blind holes**
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for thread cutting by hand and machine*

D		L1	L2	D2	Square	Art.-No.*	Art.-No.** RSP
BSF	3/16 x 32	58	16	5	4	85510	85710
BSF	1/4 x 26	66	19	6.3	5	85514	85714
BSF	5/16 x 22	69	19	8	6.3	85516	85716
BSF	3/8 x 20	76	20	10	8	85518	85718
BSF	7/16 x 18	82	22	8	6.3	85520	85720
BSF	1/2 x 16	84	24	9	7.1	85522	85722
BSF	5/8 x 14	95	25	12.5	10	85526	85726
BSF	3/4 x 12	104	29	14	11.2	85530	85730
BSF	7/8 x 11	113	33	16	12.5	85534	85734
BSF	1" x 10	120	35	18	14	85538	85738

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

UNC (Unified Coarse)

Machine taps

≈ DIN 371/376 Form B HSS-E – UNC
+ ≈ DIN 371/376 Form C 35°RSP HSS-E – UNC

Type of thread: Unified Coarse thread ANSI B 1.1 — Tolerance: 2B

Variants (9/20+9/20):

Application/ for general use:

- for through holes*
- for blind holes**
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel

DIN 371 D			L1	L2 Form B	L2 Form C	D2	Square	Art.-No.* Form B	Art.-No.** Form C
UNC	No.	4 x 40	50	10	6	3.5	2.7	74504	74704
UNC	No.	5 x 40	56	11	7	3.5	2.7	74505	74705
UNC	No.	6 x 32	56	12	7	4.0	3.0	74506	74706
UNC	No.	8 x 32	63	13	8	4.5	3.4	74508	74708
UNC	No.	10 x 24	70	15	10	6.0	4.9	74510	74710
UNC	No.	12 x 24	70	16	10	6.0	4.9	74512	74712
UNC		1/4 x 20	80	17	13	7.0	5.5	74514	74714
UNC		5/16 x 18	90	20	14	8.0	6.2	74516	74716
UNC		3/8 x 16	100	22	16	9.0	7.0	74518	74718

DIN 376 D			L1	L2 Form B	L2 Form C	D2	Square	Art.-No.* Form B	Art.-No.** Form C
UNC	No.	4 x 40	50	10	6	1.8	-	75504	75704
UNC	No.	5 x 40	56	11	7	2.2	1.8	75505	75705
UNC	No.	6 x 32	56	12	7	2.5	2.1	75506	75706
UNC	No.	8 x 32	63	13	8	2.8	2.1	75508	75708
UNC	No.	10 x 24	70	15	10	3.5	2.7	75510	75710
UNC	No.	12 x 24	70	16	10	3.5	2.7	75512	75712
UNC		1/4 x 20	80	17	13	4.5	3.4	75514	75714
UNC		5/16 x 18	90	20	14	6.0	4.9	75516	75716
UNC		3/8 x 16	100	22	16	7.0	5.5	75518	75718
UNC		7/16 x 14	100	22	17	8.0	6.2	75520	75720
UNC		1/2 x 13	110	25	20	9.0	7.0	75522	75722

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

DIN 376 D		L1	L2 Form B	L2 Form C	D2	Square	Art.-No.* Form B	Art.-No.** Form C
UNC	9/16 x 12	110	26	20	11.0	9.0	75524	75724
UNC	5/8 x 11	110	27	22	12.0	9.0	75526	75726
UNC	3/4 x 10	125	30	25	14.0	11.0	75530	75730
UNC	7/8 x 9	140	32	27	18.0	14.5	75534	75734
UNC	1" x 8	160	36	30	20.0	16.0	75538	75738
UNC	1.1/4 x 7	180	40	35	22.0	18.0	75546	75746
UNC	1.1/2 x 6	200	50	40	32.0	24.0	75554	75754
UNC	1.3/4 x 5	220	65	45	36.0	29.0	75562	75762
UNC	2" x 4.1/2	250	70	50	40.0	32.0	75570	75770

Machine taps

ISO 529 HSS-G – UNC ≈ DIN 376
+ ISO 529 35°RSP HSS-G – UNC ≈ DIN 376

Type of thread: Unified Coarse thread ANSI B 1.1 — Tolerance: 2B

Variants (19/19):

Application/ for general use:

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

D			L1	L2	D2	Square	Art.-No.*	Art.-No.** RSP
UNC	No.	10 x 24	58	16	5	4	82510	82710
UNC		1/4 x 20	66	19	6.3	5	82514	82714
UNC		5/16 x 18	72	22	8	6.3	82516	82716
UNC		3/8 x 16	80	24	10	8	82518	82718
UNC		7/16 x 14	85	25	8	6.3	82520	82720
UNC		1/2 x 13	89	29	9	7.1	82522	82722
UNC		9/16 x 12	95	30	11.2	9	82524	82724
UNC		5/8 x 11	102	32	12.5	10	82526	82726
UNC		3/4 x 10	112	37	14	11.2	82530	82730
		7/8 x 9	118	38	18	12.5	82534	82734
		1" x 8	130	45	16	14	82538	82738
		1.1/8 x 7	138	48	20	16	82540	82740
		1.1/4 x 7	151	51	22.4	18	82542	82742
UNC	No.	1.3/8 x 6	162	57	25	20	82544	82744
UNC	No.	1.1/2 x 6	170	60	28	22.4	82546	82746
UNC	No.	1.5/8 x 5	170	60	28	22.4	82547	82748
UNC	No.	1.3/4 x 5	187	67	31.5	25	82548	82750
UNC	No.	1.7/8 x 5	187	67	31.5	25	82549	82752
UNC	No.	2" x 4.5	200	70	35.5	28	82550	82754

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

Machine taps

JIS B-4430 HSS-E – UNC + JIS B-4430 HSS-E – UNC

Type of thread: Unified Coarse thread ANSI B 1.1

Variants (16/19):

Application/ for general use:

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

D			L1	L2	D2	Square	Art.-No.*	Art.-No.**
UNC	No.	4 x 40	45	10	3	2.5	93504	93704
UNC	No.	5 x 40	47	12	4	3.2	93505	93705
UNC	No.	6 x 32	49	14	4	3.2	93506	93706
UNC	No.	8 x 32	53	14	5	4	93508	93708
UNC	No.	10 x 24	61	17	5.5	4.5	93509	93709
UNC	No.	12 x 24	61	17	5.5	4.5	93510	93710
UNC		1/8 x 40	47	11	4	3.2	-	93711
UNC		5/32 x 32	53	14	5	4	-	93712
UNC		3/16 x 24	60	17	5.5	4.5	-	93713
UNC		1/4 x 20	62	20	6	4.5	93514	93714
UNC		5/16 x 18	70	23	6.1	5	93515	93715
UNC		3/8 x 16	75	25	7	5.5	93516	93716
UNC		7/16 x 14	80	24	8	6	93517	93717
UNC		1/2 x 13	85	30	9	7	93518	93718
UNC		9/16 x 12	90	30	10.5	8	93519	93719
UNC		5/8 x 11	95	32	12	9	93520	93720
UNC		3/4 x 10	105	38	14	11	93522	93722
UNC		7/8 x 9	115	38	17	13	93524	93724
UNC		1" x 8	126	45	20	15	93526	93726

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

UNF (Unified fine thread)

Machine taps

≈ DIN 371/376 Form B HSS-E – UNF
+ ≈ DIN 371/376 Form C 35°RSP HSS-E – UNF

Type of thread: Unified Fine thread ANSI B 1.1 — Tolerance: 2B

Variants (9/10+9/10):

Application/ for general use:

- for through holes*
- for blind holes**
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel

DIN 371 D		L1	L2 Form B	L2 Form C	D2	Square	Art.-No.* Form B	Art.-No.** Form C
UNF	No. 4 x 48	50	10	6	3.5	2.7	76504	76704
UNF	No. 5 x 44	56	11	7	3.5	2.7	76505	76705
UNF	No. 6 x 40	56	12	7	4.0	3.0	76506	76706
UNF	No. 8 x 36	63	13	8	4.5	3.4	76508	76708
UNF	No. 10 x 32	70	15	10	6.0	4.9	76510	76710
UNF	No. 12 x 28	70	16	10	6.0	4.9	76512	76712
UNF	1/4 x 28	80	17	10	7.0	5.5	76514	76714
UNF	5/16 x 24	90	17	10	8.0	6.2	76516	76716
UNF	3/8 x 24	100	18	10	9.0	7.0	76518	76718

DIN 376 D		L1	L2 Form B	L2 Form C	D2	Square	Art.-No.* Form B	Art.-No.** Form C
UNF	7/16 x 20	100	22	13	8.0	6.2	77520	77720
UNF	1/2 x 20	100	22	13	9.0	7.0	77522	77722
UNF	9/16 x 18	100	22	15	11.0	9.0	77524	77724
UNF	5/8 x 18	100	22	15	12.0	9.0	77526	77726
UNF	3/4 x 16	110	25	17	14.0	11.0	77530	77730
UNF	7/8 x 14	140	26	17	18.0	14.5	77534	77734
UNF	1" x 14	150	28	20	20.0	16.0	77540	77740
UNF	1" x 12	150	28	20	20.0	16.0	77538	77738
UNF	1.1/4 x 12	150	30	22	22.0	18.0	77546	77746
UNF	1.1/2 x 12	170	33	25	32.0	24.0	77554	77754

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

Machine taps

ISO 529 HSS-G – UNF ≈ DIN 371 + ISO 529 35°SP HSS-G – UNF ≈ DIN 371

Type of thread: Unified Fine thread ANSI B 1.1 Tolerance: 2B

Variants (14/14):

Application/ for general use:

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

D		L1	L2	D2	Square	Art.-No.*	Art.-No.** SP
UNF	1/4 x 28	66	19	6.3	5	83514	83714
UNF	5/16 x 24	69	19	8	6.3	83516	83716
UNF	3/8 x 24	76	20	10	8	83518	83718
UNF	7/16 x 20	82	22	8	6.3	83520	83720
UNF	1/2 x 20	84	24	9	7.1	83522	83722
UNF	9/16 x 18	90	25	11.2	9	83524	83724
UNF	5/8 x 18	95	25	12.5	10	83526	83726
UNF	3/4 x 16	104	29	14	11.2	83530	83730
UNF	7/8 x 14	113	33	16	12.5	83534	83734
UNF	1″ x 12	120	35	18	14	83538	83738
UNF	1.1/8 x 12	127	37	20	16	83540	83740
UNF	1.1/4 x 12	137	37	22.4	18	83542	83742
UNF	1.3/8 x 12	144	39	25	20	83544	83744
UNF	1.1/2 x 12	149	39	28	22.4	83546	83746

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

Machine taps

JIS B-4430 HSS-E – UNF + JIS B-4430 HSS-E – UNF

Type of thread: Unified Fine thread ANSI B 1.1

Variants (19/19):

Application/ for general use:

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

D			L1	L2	D2	Square	Art.-No.*	Art.-No.**
UNF	No.	4 x 48	45	10	3	2.5	93554	93754
UNF	No.	5 x 44	47	12	4	3.2	93555	93755
UNF	No.	6 x 40	49	14	4	3.2	93556	93756
UNF	No.	8 x 36	53	14	5	4	93558	93758
UNF	No.	10 x 32	61	17	5.5	4.5	93559	93759
UNF	No.	12 x 28	61	17	5.5	4.5	93560	93760
UNF		1/8 x 44	47	11	4	3.2	93561	93761
UNF		5/32 x 36	53	14	5	4	93562	93762
UNF		3/16 x 32	60	17	5.5	4.5	93563	93763
UNF		1/4 x 28	62	20	6	4.5	93564	93764
UNF		5/16 x 24	70	23	6.1	5	93565	93765
UNF		3/8 x 24	75	25	7	5.5	93566	93766
UNF		7/16 x 20	80	24	8	6	93567	93767
UNF		1/2 x 20	85	30	9	7	93568	93768
UNF		9/16 x 18	90	30	10.5	8	93569	93769
UNF		5/8 x 18	95	32	12	9	93570	93770
UNF		3/4 x 16	105	38	14	11	93572	93772
UNF		7/8 x 14	115	38	17	13	93574	93774
UNF		1" x 12	126	45	20	15	93576	93776

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

UNEF (Unified extra fine)

Machine taps

ISO 529 Form B HSS-E – UNEF + ISO 529 Form C 35°RSP HSS-E – UNEF

Type of thread: Unified Extra Fine thread ANSI B 1.1 | Tolerance: 2B

Variants (27/14):

Application/ for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through holes*
- for blind holes**

D		L1	L2	D2	Square	Art.-No.*	Art.-No.** SP
UNEF No.	12 x 32	62	17	5.6	4.5	83320	83370
UNEF	1/4 x 32	66	19	6.3	5.0	83321	83371
UNEF	5/16 x 32	72	22	8.0	6.3	83322	83372
UNEF	3/8 x 32	80	24	10.0	8.0	83324	83373
UNEF	7/16 x 28	85	25	8.0	6.3	83325	83374
UNEF	1/2 x 28	89	29	9.0	7.1	83326	83375
UNEF	9/16 x 24	95	30	11.2	9.0	83327	83376
UNEF	5/8 x 24	102	32	12.5	10.0	83328	83377
UNEF	11/16 x 24	112	37	14.0	11.2	83329	83378
UNEF	3/4 x 20	112	37	14.0	11.2	83330	83379
UNEF	13/16 x 20	118	38	16.0	12.5	83331	83380
UNEF	7/8 x 20	118	38	16.0	12.5	83332	83381
UNEF	15/16 x 20	130	45	18.0	14.0	83333	83382
UNEF	1" x 20	130	45	18.0	14.0	83334	83383
UNEF	1.1/16 x 18	138	48	20.0	16.0	83335	-
UNEF	1.1/8 x 18	138	48	20.0	16.0	83336	-
UNEF	1.3/16 x 18	151	51	22.4	18.0	83337	-
UNEF	1.1/4 x 18	151	51	22.4	18.0	83338	-
UNEF	1.5/16 x 18	162	57	25.0	20.0	83339	-
UNEF	1.3/8 x 18	162	57	25.0	20.0	83340	-
UNEF	1.7/16 x 18	170	60	28.0	22.4	83341	-
UNEF	1.1/2 x 18	170	60	28.0	22.4	83342	-
UNEF	1.9/16 x 18	170	60	28.0	22.4	83343	-
UNEF	1.5/8 x 18	170	60	28.0	22.4	83344	-
UNEF	1.11/16 x 18	187	67	31.5	25.0	83345	-
UNEF	1.3/4 x 18	187	67	31.5	25.0	83346	-
UNEF	2" x 18	200	70	35.5	28.0		-

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

8 - UN / 12 - UN

Machine taps

ISO 529 Form B HSS-E – UNx8/UNx12
+ ISO 529 Form C 35°RSP HSS-E – UNx8/UNx12

Type of thread: Unified thread ANSI B 1.1 | Tolerance: 2B

Variants (20/13+20/13):

Application/ for general use:

- for through holes*
- for blind holes**
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel

UNx8 D		L1	L2	D2	Square	Art.-No.* Form B	Art.-No.** Form C
UN	1.1/16 x 8	138	48	20.0	16.0	83101	83151
UN	1.1/8 x 8	138	48	20.0	16.0	83102	83152
UN	1.3/16 x 8	151	51	22.4	18.0	83103	83153
UN	1.1/4 x 8	151	51	22.4	18.0	83104	83154
UN	1.5/16 x 18	162	57	25.0	20.0	83105	83155
UN	1.3/8 x 8	162	57	25.0	20.0	83106	83156
UN	1.1/2 x 8	170	60	28.0	22.4	83107	83157
UN	1.5/8 x 8	170	60	28.0	22.4	83108	83158
UN	1.3/4 x 8	187	67	31.5	25.0	83109	83159
UN	1.7/8 x 8	187	67	31.5	25.0	83110	83160
UN	2″ x 8	200	70	35.5	28.0	83111	83161
UN	2.1/8 x 8	200	70	35.5	28.0	83112	83162
UN	2.1/4 x 8	221	76	40.0	31.5	83113	83163
UN	2.1/2 x 8	224	79	40.0	31.5	83115	83165
UN	2.3/4 x 8	234	79	45.0	35.5	83116	83166
UN	3″ x 8	258	83	50.0	40.0	83117	83167
UN	3.1/4 x 8	261	86	50.0	40.0	83118	83168
UN	3.1/2 x 8	261	86	50.0	40.0	83119	83169
UN	3.3/4 x 8	279	89	56.0	45.0	83120	83170
UN	4″ x 8	279	89	56.0	45.0	83121	83171

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


UNx12 D		L1	L2	D2	Square	Art.-No.* Form B	Art.-No.** Form C
UN	1.5/8 x 12	170	60	28.0	22.4	83301	83351
UN	1.3/4 x 12	187	67	31.5	25.0	83302	83352
UN	1.7/8 x 12	187	67	31.5	25.0	83303	83353
UN	2″ x 12	200	70	35.5	28.0	83304	83354
UN	2.1/8 x 12	200	70	35.5	28.0	83305	83355
UN	2.1/4 x 12	221	76	40.0	31.5	83306	83356
UN	2.1/2 x 12	224	79	40.0	31.5	83308	83358
UN	2.3/4 x 12	234	79	45.0	35.5	83309	83359
UN	3″ x 12	258	83	50.0	40.0	83310	83360
UN	3.1/4 x 12	261	86	50.0	40.0	83311	83361
UN	3.1/2 x 12	261	86	50.0	40.0	83312	83362
UN	3.3/4 x 12	279	89	56.0	45.0	83313	83363
UN	4″ x 12	279	89	56.0	45.0	83314	83364

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

UN / UNS

Machine taps

ISO 529 Form B HSS-E – UN/UNS

Type of thread: Unified thread ANSI B 1.1 Tolerance: 2B

Variants (13/10):

Application/ for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through holes

UN D		L1	L2	D2	Square	Art.-No. Form B
UN	5/16 x 28	72	22	8.0	6.3	83221
UN	3/8 x 20	80	24	10.0	8.0	83222
UN	3/8 x 28	80	24	10.0	8.0	83223
UN	7/16 x 32	85	25	8.0	6.3	83224
UN	1/2 x 32	89	29	9.0	7.1	83225
UN	9/16 x 20	95	30	11.2	9.0	83226
UN	9/16 x 28	95	30	11.2	9.0	83227
UN	9/16 x 32	95	30	11.2	9.0	83228
UN	5/8 x 20	102	32	12.5	10.0	83229
UN	5/8 x 28	102	32	12.5	10.0	83230
UN	11/16 x 20	112	37	14.0	11.2	83231
UN	11/16 x 16	112	37	14.0	11.2	83232
UN	1" x 32	130	45	18.0	14.0	83233

UNS D		L1	L2	D2	Square	Art.-No. Form B
UNS	1/4 x 24	66	19	6.3	5.0	83201
UNS	1/4 x 36	66	19	6.3	5.0	83202
UNS	1/4 x 40	66	19	6.3	5.0	83203
UNS	3/8 x 27	80	24	10.0	8.0	83204
UNS	7/16 x 24	85	25	8.0	6.3	83205
UNS	1/2 x 24	89	29	9.0	7.1	83206
UNS	5/8 x 27	102	32	12.5	10.0	83207
UNS	3/4 x 24	112	37	14.0	11.2	83208
UNS	7/8 x 18	118	38	16.0	12.5	83209
UNS	1" x 14	130	45	18.0	14.0	83210

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

G (BSP) Pipe-thread

Machine taps

DIN 5156 Form B HSS-E/HSS-E TiN – G (BSP)
+ DIN 5156 Form C HSS-E/HSS-E TiN – G (BSP)
+ DIN 5156 Form C 35°RSP HSS-E/HSS-E TiN – G (BSP)

Type of thread: Pipe-thread DIN ISO 228

Variants (14/6+14/6+14/6):

Application/ for general use:

- non abrasive material up to 900 N/mm²

- unalloyed and low alloyed steel
- for through holes*
- for blind holes**
- for through and blind holes***

HSS-E D		L1	L2	D2	Square	Art.-No.** Form B	Art.-No.* Form C	Art.-No.*** Form C 35°
G	1/8 x 28	90	20	7.0	5.5	78512	78412	78712
G	1/4 x 19	100	22	11.0	9.0	78514	78414	78714
G	3/8 x 19	100	22	12.0	9.0	78516	78416	78716
G	1/2 x 14	125	25	16.0	12.0	78518	78418	78718
G	5/8 x 14	125	25	18.0	14.5	78520	78420	78720
G	3/4 x 14	140	28	20.0	16.0	78522	78422	78722
G	7/8 x 14	150	28	22.0	18.0	78524	78424	78724
G	1" x 11	160	30	25.0	20.0	78526	78426	78726
G	1.1/8 x 11	170	30	28.0	22.0	78530	78430	78730
G	1.1/4 x 11	170	30	32.0	24.0	78534	78434	78734
G	1.3/8 x 11	180	32	36.0	29.0	78538	78438	78738
G	1.1/2 x 11	190	32	36.0	29.0	78542	78442	78742
G	1.3/4 x 11	190	32	40.0	32.0	78550	78450	78750
G	2" x 11	220	40	45.0	35.0	78554	78454	78754

TIN-coating:

- improved resistance to wear and abrasion
- excellent anti-friction properties
- faster cutting speeds possible

HSS-E TiN D		L1	L2	D2	Square	Art.-No.* Form B	Art.-No.* Form C	Art.-No.** Form C 35°
G	1/8 x 28	90	20	7.0	5.5	78513	78413	78713
G	1/4 x 19	100	22	11.0	9	78515	78415	78715
G	3/8 x 19	100	22	12.0	9	78517	78417	78717
G	1/2 x 14	125	25	16.0	12	78519	78419	78719
G	3/4 x 14	140	28	20.0	16	78523	78423	78723
G	1" x 11	160	30	25.0	20	78527	78427	78727

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

G
(BSP) left hand (LH)

Machine taps, left hand
DIN 5156 Form C HSS-E – G (BSP) LH

Type of thread: Pipe-thread DIN ISO 228

Variants (7):

Application/ for general use:
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes

D		L1	L2	D2	Square	Art.-No.
G	1/8 x 28	90	20	7.0	5.5	78202
G	1/4 x 19	100	22	11.0	9.0	78203
G	3/8 x 19	100	22	12.0	9.0	78204
G	1/2 x 14	125	25	16.0	12.0	78205
G	5/8 x 14	125	25	18.0	14.5	78206
G	3/4 x 14	140	28	20.0	16.0	78207
G	1" x 11	160	30	25.0	20.0	78209

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

Rc (BSPT)

Machine taps
DIN 5156 Form C HSS-E – Rc (BSPT)

Type of thread: tapered pipe thread, taper 1:16, con. 55°

Variants (6):

Application/ for general use:
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes

D		L1	L2	D2	Square	Art.-No.
Rc	1/8 x 28	90	20	7.0	5.5	73404
Rc	1/4 x 19	100	22	11.0	9.0	73406
Rc	3/8 x 19	100	22	12.0	9.0	73408
Rc	1/2 x 14	125	28	16.0	12.0	73410
Rc	3/4 x 14	140	28	20.0	16.0	73412
Rc	1" x 11	160	38	25.0	20.0	73414

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

NPT (tapered pipe thread)

Machine taps

Form C HSS-E – NPT

Type of thread: american tapered pipe thread, taper 1:16

Variants (7):

Application/ for general use:

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

D		L1	L2	D2	Square	Art.-No.
NPT	1/16 x 27	90	20	6.0	4.9	73432
NPT	1/8 x 27	90	20	7.0	5.5	73434
NPT	1/4 x 18	100	22	11.0	9.0	73436
NPT	3/8 x 18	100	22	12.0	9.0	73438
NPT	1/2 x 14	125	28	16.0	12.0	73440
NPT	3/4 x 14	140	28	20.0	16.0	73442
NPT	1" x 11.5	160	38	25.0	20.0	73444

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

Rd (knuckle thread)

The round thread is a knuckle thread, shaped to ensure it is not susceptible to dirt to ensure low maintenance. Common applications: Coupler shafts on railway vehicles, brake rods, respirators.

Machine taps for knuckle threads

Knuckle thread screw taps are suitable for materials will good machinability up to 900 N/mm², non-alloy and low-allow steels, and for through and blind holes.

- Taps for knuckle threads (Rd) acc. to DIN 374
- Machine taps Rd 8 - Rd 44

Machine taps

DIN 374 Form C HSS-E – Rd

Type of thread: Knuckled Thread DIN 405 | Tolerance: 7H

Variants (21):

Application/ for general use:

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

D		L1	L2	D2	Square	Art.-No.	D		L1	L2	D2	Square	Art.-No.
Rd	8 x 1/10	90	26	6	4.9	79440	Rd	26 x 1/8	160	36	20	16	79451
Rd	9 x 1/10	90	26	7	5.5	79441	Rd	28 x 1/8	160	36	20	16	79452
Rd	10 x 1/10	100	28	7	5.5	79442	Rd	30 x 1/8	180	36	22	18	79453
Rd	11 x 1/10	100	28	8	6.2	79443	Rd	32 x 1/8	180	36	25	20	79454
Rd	12 x 1/10	110	28	9	7	79444	Rd	34 x 1/8	200	36	28	22	79455
Rd	14 x 1/8	110	32	11	9	79445	Rd	36 x 1/8	200	36	28	22	79456
Rd	16 x 1/8	110	32	12	9	79446	Rd	38 x 1/8	200	38	28	22	79457
Rd	18 x 1/8	125	32	14	11	79447	Rd	40 x 1/6	200	50	32	24	79458
Rd	20 x 1/8	140	32	16	12	79448	Rd	42 x 1/6	200	50	32	24	79459
Rd	22 x 1/8	140	32	18	14.5	79449	Rd	44 x 1/6	200	50	36	29	79460
Rd	24 x 1/8	160	34	18	14.5	79450							

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

FG / BSC (cycle threads)

Machine taps

DIN 374 Form C HSS-E – BSC + DIN 374 Form C HSS-E – FG

Type of thread: British Cycle Thread BS 811 + Cycle Thread DIN 790012 — Tolerance: medium

Variants (6/9):

Application/ for general use:

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

BSC D		L1	L2	D2	Square	Art.-No. Form C
BSC	1/4 x 26	80	14	7.0	5.5	79420
BSC	5/16 x 26	90	16	8.0	6.2	79421
BSC	3/8 x 26	90	16	7.0	5.5	79422
BSC	9/16 x 20	100	22	11.0	9.0	79423
BSC	9/16 x 20 - LH	100	22	11.0	9.0	79424
BSC	1" x 24	140	24	18.0	14.5	79425

FG D		L1	L2	D2	Square	Art.-No. Form C
FG	2 x 56	45	8	2.8	2.1	79401
FG	2.3 x 56	45	8	2.8	2.1	79402
FG	2.6 x 56	56	8	3.5	2.7	79403
FG	6.35 x 26	80	14	7.0	5.5	79404
FG	7.9 x 26	90	16	8.0	6.2	79405
FG	9.5 x 26	90	16	7.0	5.5	79406
FG	14.3 x 20	100	22	11.0	9.0	79407
FG	14.3 x 20 - LH	100	22	11.0	9.0	79408
FG	25.4 x 24	140	24	18.0	14.5	79409

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

Vg (valve thread)

Machine taps
DIN 374 Form C HSS-E – Vg

Type of thread: Valve Thread DIN 7756 Tolerance: medium

Variants (6):

Application/ for general use:
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes

D		L1	L2	D2	Square	Art.-No.
Vg	5 x 36	70	12	6.0	4.9	79430
Vg	5.2 x 24	80	17	6.0	4.9	79431
Vg	6 x 32	80	14	7.0	5.5	79432
Vg	8 x 32	80	16	8.0	6.2	79433
Vg	10 x 28	90	18	8.0	6.2	79434
Vg	12 x 26	100	22	9.0	7.0	79435

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