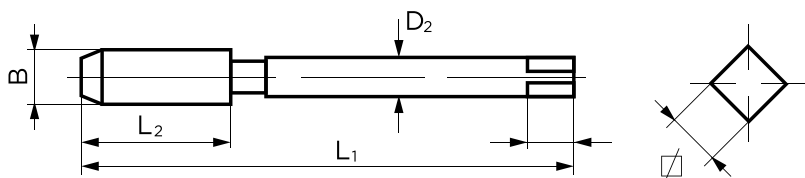
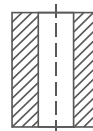




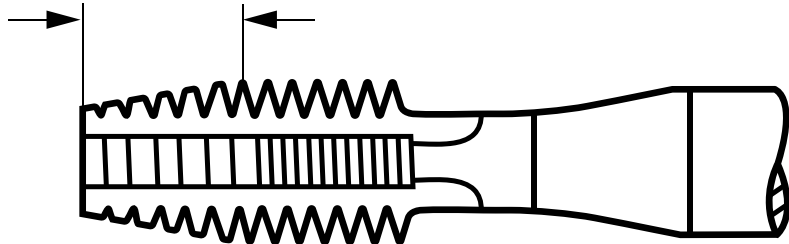
TECHNICAL INFORMATION



Through hole

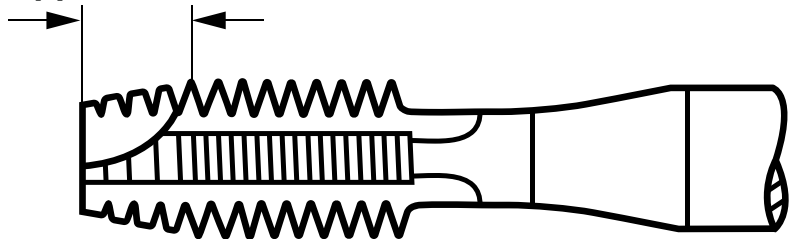


Approx. 6-8 threads



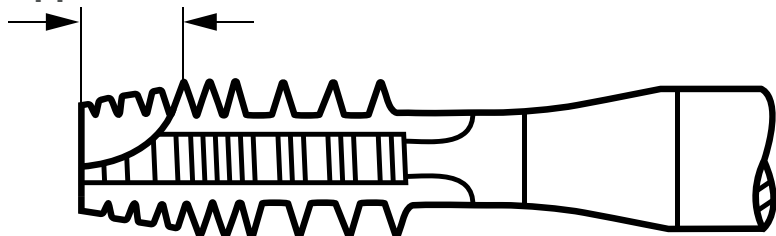
Form A
6-8 Threads Lead

Approx. 4-5 threads



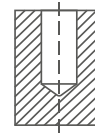
Form B
4-5 Threads Lead with Spiral Point

Approx. 4-5 threads

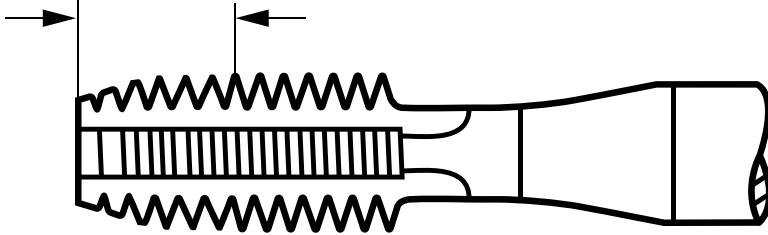


Form B-AZ
4-5 Threads Lead with Spiral Point
and interrupted threads

Blind hole

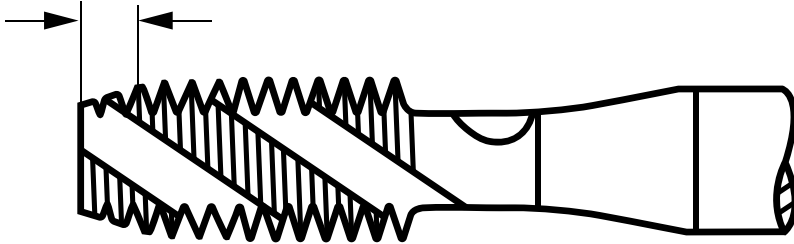


Approx. 2-3 threads



Form C
2-3 Threads Lead

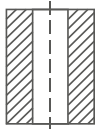
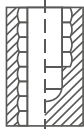
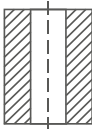
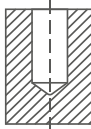
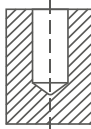
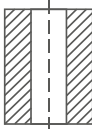
Approx. 2-3 threads



Form C/RSP
2-3 Threads Lead,
15° or 35° Spiral Flute

Recommended Cutting Speed for machine taps

Art-No. M	373/383	374/384	375/385	376/386	377/387	379/389
Art-No. Mf		394	395		397	
Art-No. BSW			705/715		707/717	
Art-No. UNC			745/755		747/757	
Art-No. UNF			765/775		767/777	
Art-No. G (BSP)		784	785		787	
Form	A	C	B	15°RSP	35°RSP	B-AZ
Hole type						
Material						
Structural Steel up to 500 N/mm	A	C	B	15°RSP	35°RSP	B-AZ
Structural Steel up to 500 N/mm	A	C	B	15°RSP	35°RSP	
Free Cutting Steel			B		35°RSP	
Cementation Steel, heat treatable Steel			B		35°RSP	B-AZ
Tool Steel			B		35°RSP	
Stainless Steel			B		35°RSP	B-AZ
Cast Steel			B	15°RSP	35°RSP	
Cast Iron, spheroidal graphite Iron		C				

Art-No. M	373/383	374/384	375/385	376/386	377/387	379/389
Art-No. Mf		394	395		397	
Art-No. BSW			705/715		707/717	
Art-No. UNC			745/755		747/757	
Art-No. UNF			765/775		767/777	
Art-No. G (BSP)		784	785		787	
Form	A	C	B	15°RSP	35°RSP	B-AZ
Hole type						
Material						
Malleable Cast Iron	A	C	B	15°RSP	35°RSP	
Brass, Short-chipping		C				
Brass, Long-chipping			B	15°RSP	35°RSP	
Bronzes			B		35°RSP	
Copper			B	15°RSP	35°RSP	
Al-alloys, Short-chipping		C	B		35°RSP	
Al-alloys, Long-chipping			B	15°RSP	35°RSP	B-AZ
Zinc Alloys			B	15°RSP	35°RSP	
Magnesium Alloys		C	B		35°RSP	B-AZ
Thermoplastics			B		35°RSP	
Thermosetting Plastics		C				

