

HSS



Being the best through innovation



COLD FORMING TAPS

INNENGEWINDEFORMER














- Tapping by Forming Soft Materials, HSS-E & HSS-PM
- Zum Gewindedrücken in weichen Werkstoffen, HSS-E und HSS-PM

SELECTION GUIDE

COLD FORMING TAPS

Tapping by Forming Soft Materials, HSS-E & HSS-PM

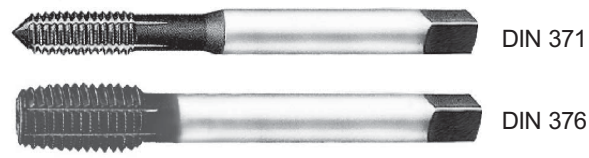
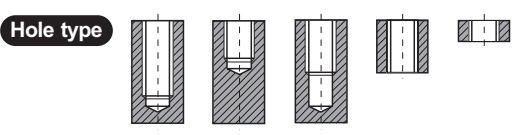
COLD FORMING TAPS

EDP No.	MODEL	Tool Material	Standard	Work Material	Dimensions	Tolerance	Chamfer	Surface Treatment	PAGE
TQ703		HSS-PM	M	GV	DIN 371/376	ISO 2X/6HX	C	vap	449
TQ723		HSS-PM	M	GV	DIN 371/376	ISO 2X/6HX	C	vap	450
TE703		HSS-E	M	GV	DIN 371/376	ISO 2X/6HX	C	NI	451
TE713		HSS-E	M	GV	DIN 371/376	ISO 3X/6GX	C	NI	452
TE723		HSS-E	M	GV	DIN 371/376	ISO 2X/6HX	C	NI	453
TD713		HSS-E	M	GV	DIN 371/376	ISO 3X/6GX	C	TiN	454
TD723		HSS-E	M	GV	DIN 371/376	ISO 2X/6HX	C	TiN	455
TD703		HSS-E	M	GV	DIN 371/376	ISO 2X/6HX	C	TiN	456
TY703		HSS-E	M	GV	DIN 371/376	ISO 2X/6HX	C	TiAlN	457
TE733		HSS-E	MF	GV	DIN 374	ISO 2X/6HX	C	NI	458
TD733		HSS-E	MF	GV	DIN 374	ISO 2X/6HX	C	TiN	459
TE704		HSS-E	UNC	GV	DIN 371/376	2BX	C	NI	460
TD704		HSS-E	UNC	GV	DIN 371/376	2BX	C	TiN	461

M ISO metric coarse threads DIN 13 Metrisches ISO-Gewinde DIN 13

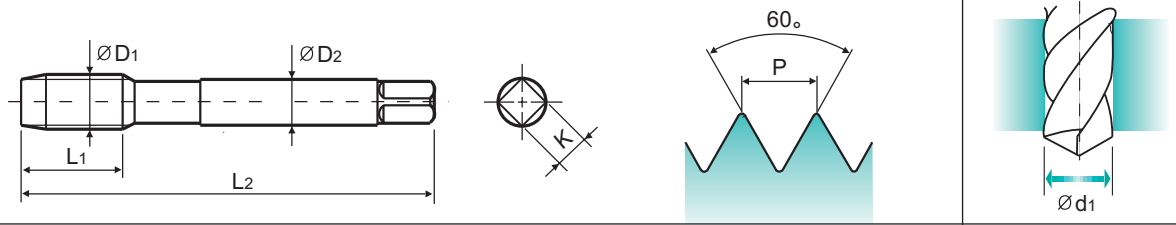
- ▶ Suitable for threading soft materials with at least 8-10% elongation in the best substrate.
- ▶ The pre-drilling holes are bigger than normal sized holes.

- ▶ Aus bestem Werkstoff geeignet zum Gewindeformen weicher Werkstoffe mit mindestens 8 - 10% Dehnung.
- ▶ Die Kernlochbohrungen sind größer als normale Kernlöcher.



Material groups: **GV** HSS-PM DIN 371/376 6HX 60° C Vap

Cold forming taps with oil grooves
Gewindeformer mit Schmiernuten



SIZE	Pitch	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping drill diameter
Ø D1	P		L1	L2	Ø D2	K	Ø d1
M2	× 0.4	TQ703136	8	45	2.8	2.1	1.83
M2.2	× 0.45	TQ703156	8	45	2.8	2.1	2
#d M2.3	× 0.4	TQ703196	8	45	2.8	2.1	2.1
M2.5	× 0.45	TQ703176	9	50	2.8	2.1	2.3
#d M2.6	× 0.45	TQ703496	9	50	2.8	2.1	2.4
M3	× 0.5	TQ703206	11	56	3.5	2.7	2.8
M3.5	× 0.6	TQ703226	12	56	4	3	3.25
M4	× 0.7	TQ703246	13	63	4.5	3.4	3.7
M4.5	× 0.75	TQ703266	14	70	6	4.9	4.15
M5	× 0.8	TQ703286	15	70	6	4.9	4.65
M6	× 1	TQ703316	17	80	6	4.9	5.55
M7	× 1	TQ703346	17	80	7	5.5	6.55
M8	× 1.25	TQ703366	20	90	8	6.2	7.4
M9	× 1.25	TQ703396	20	90	9	7	8.4
M10	× 1.5	TQ703426	22	100	10	8	9.3
M11	× 1.5	TQ703466	22	100	8	6.2	10.3
M12	× 1.75	TQ703506	24	110	9	7	11.2
M14	× 2	TQ703546	26	110	11	9	13
M16	× 2	TQ703606	27	110	12	9	15
M18	× 2.5	TQ703656	30	125	14	11	16.8
M20	× 2.5	TQ703706	32	140	16	12	18.8

- ▶ DIN 371(M2~M10) and DIN 376(M11~M20)
- ▶ #d DIN profile not ISO

Unit : N/mm²

⊙ Z @ e □ □ □ □ □ □ □ □ @ @ @ @ @ ⊙ Z @ g □

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP

- HSS
- CARBIDE
- COMBO TAPS
- SPIRAL POINT TAPS
- SPIRAL FLUTE TAPS
- STRAIGHT FLUTE TAPS
- COLD FORMING TAPS
- NUT TAPS
- STI TAPS
- HAND TAPS
- PIPE TAPS
- CARBIDE TAPS
- THREAD MILLS
- TECHNICAL DATA

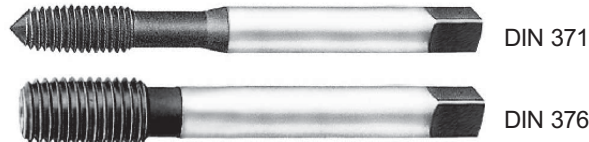
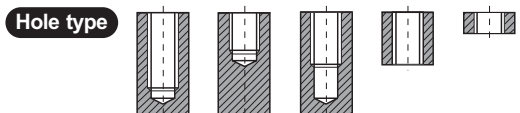
TG COLD FORMING TAPS

TQ723 SERIES

M ISO metric coarse threads DIN 13
Metrisches ISO-Gewinde DIN 13

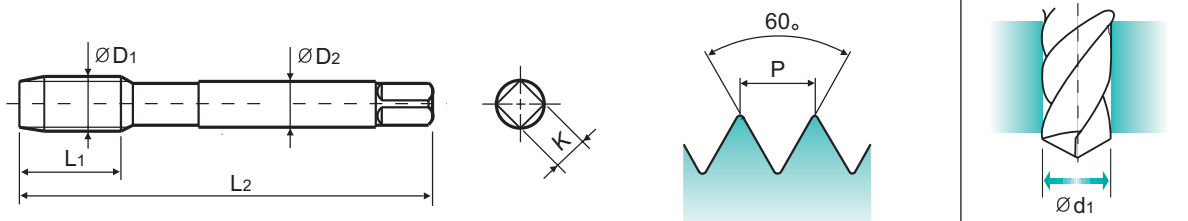
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- The pre-drilling holes are bigger than normal sized holes.

- Aus bestem Werkstoff geeignet zum Gewindeformen weicher Werkstoffe mit mindestens 8 - 10% Dehnung.
- Die Kernlochbohrungen sind größer als normale Kernlöcher.



Material groups: **GV** HSS-PM DIN 371/376 6HX 60° C Vap

Cold forming taps
 Gewindeformer



SIZE	Pitch	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping drill diameter
Ø D1	P		L1	L2	Ø D2	K	Ø d1
M2	× 0.4	TQ723136	8	45	2.8	2.1	1.83
M2.2	× 0.45	TQ723156	8	45	2.8	2.1	2
#d M2.3	× 0.4	TQ723196	8	45	2.8	2.1	2.1
M2.5	× 0.45	TQ723176	9	50	2.8	2.1	2.3
#d M2.6	× 0.45	TQ723496	9	50	2.8	2.1	2.4
M3	× 0.5	TQ723206	11	56	3.5	2.7	2.8
M3.5	× 0.6	TQ723226	12	56	4	3	3.25
M4	× 0.7	TQ723246	13	63	4.5	3.4	3.7
M4.5	× 0.75	TQ723266	14	70	6	4.9	4.15
M5	× 0.8	TQ723286	15	70	6	4.9	4.65
M6	× 1	TQ723316	17	80	6	4.9	5.55
M7	× 1	TQ723346	17	80	7	5.5	6.55
M8	× 1.25	TQ723366	20	90	8	6.2	7.4
M9	× 1.25	TQ723396	20	90	9	7	8.4
M10	× 1.5	TQ723426	22	100	10	8	9.3
M11	× 1.5	TQ723466	22	100	8	6.2	10.3
M12	× 1.75	TQ723506	24	110	9	7	11.2
M14	× 2	TQ723546	26	110	11	9	13
M16	× 2	TQ723606	27	110	12	9	15
M18	× 2.5	TQ723656	30	125	14	11	16.8
M20	× 2.5	TQ723706	32	140	16	12	18.8

- DIN 371(M2~M10) and DIN 376(M11~M20)
- #d DIN profile not ISO

Unit : N/mm²

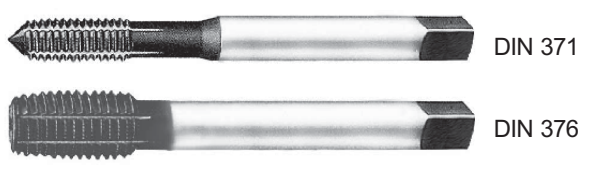
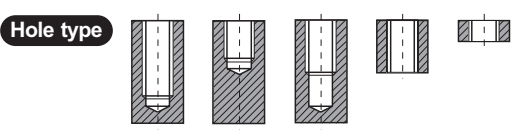
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◉	◉	◉	◉										◉	
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
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M ISO metric coarse threads DIN 13 Metrisches ISO-Gewinde DIN 13

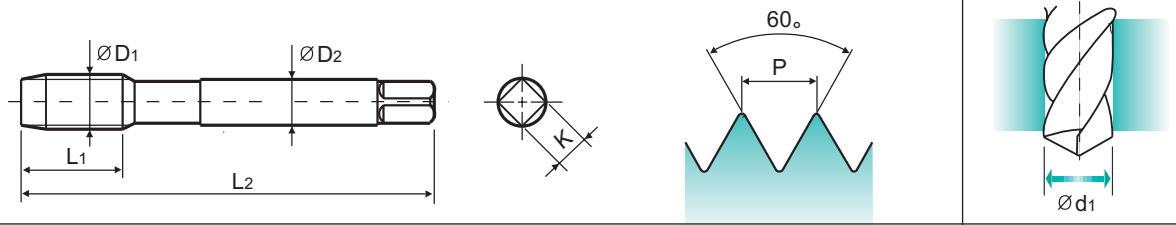
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Material groups: **GV** HSS-E DIN 371/376 6HX 60° C NI

Cold forming taps with oil grooves
Gewindeformer mit Schmiernuten



SIZE	Pitch	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping drill diameter
Ø D1	P		L1	L2	Ø D2	K	Ø d1
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M2.2	× 0.45	TE703156	8	45	2.8	2.1	2
#d M2.3	× 0.4	TE703196	8	45	2.8	2.1	2.1
M2.5	× 0.45	TE703176	9	50	2.8	2.1	2.3
#d M2.6	× 0.45	TE703496	9	50	2.8	2.1	2.4
M3	× 0.5	TE703206	11	56	3.5	2.7	2.8
M3.5	× 0.6	TE703226	12	56	4	3	3.25
M4	× 0.7	TE703246	13	63	4.5	3.4	3.7
M4.5	× 0.75	TE703266	14	70	6	4.9	4.15
M5	× 0.8	TE703286	15	70	6	4.9	4.65
M6	× 1	TE703316	17	80	6	4.9	5.55
M7	× 1	TE703346	17	80	7	5.5	6.55
M8	× 1.25	TE703366	20	90	8	6.2	7.4
M9	× 1.25	TE703396	20	90	9	7	8.4
M10	× 1.5	TE703426	22	100	10	8	9.3
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M12	× 1.75	TE703506	24	110	9	7	11.2
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M16	× 2	TE703606	27	110	12	9	15
M18	× 2.5	TE703656	30	125	14	11	16.8
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- TECHNICAL DATA

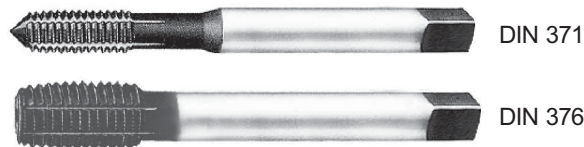
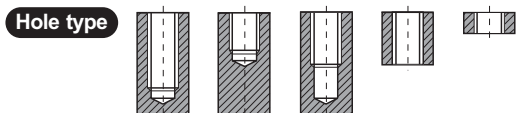
W/G COLD FORMING TAPS

TE713 SERIES

M ISO metric coarse threads DIN 13
Metrisches ISO-Gewinde DIN 13

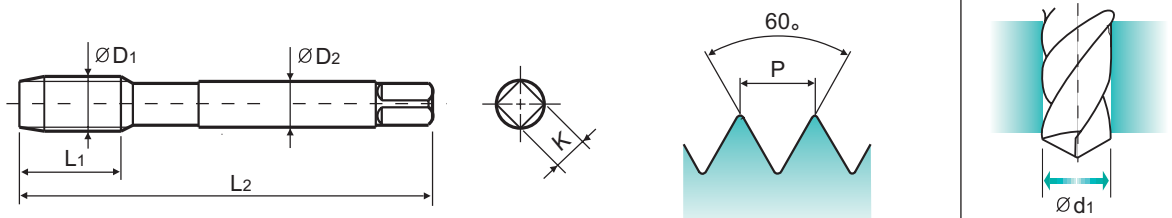
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Material groups: **GV** HSS-E DIN 371/376 6GX 60° C NI

Cold forming taps with oil grooves
 Gewindeformer mit Schmiernuten



SIZE	Pitch	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping drill diameter
Ø D1	P		L1	L2	Ø D2	K	Ø d1
M2	× 0.4	TE713136	8	45	2.8	2.1	1.83
M2.2	× 0.45	TE713156	8	45	2.8	2.1	2
#d M2.3	× 0.4	TE713196	8	45	2.8	2.1	2.1
M2.5	× 0.45	TE713176	9	50	2.8	2.1	2.3
#d M2.6	× 0.45	TE713496	9	50	2.8	2.1	2.4
M3	× 0.5	TE713206	11	56	3.5	2.7	2.8
M3.5	× 0.6	TE713226	12	56	4	3	3.25
M4	× 0.7	TE713246	13	63	4.5	3.4	3.7
M4.5	× 0.75	TE713266	14	70	6	4.9	4.15
M5	× 0.8	TE713286	15	70	6	4.9	4.65
M6	× 1	TE713316	17	80	6	4.9	5.55
M7	× 1	TE713346	17	80	7	5.5	6.55
M8	× 1.25	TE713366	20	90	8	6.2	7.4
M9	× 1.25	TE713396	20	90	9	7	8.4
M10	× 1.5	TE713426	22	100	10	8	9.3
M11	× 1.5	TE713466	22	100	8	6.2	10.3
M12	× 1.75	TE713506	24	110	9	7	11.2
M14	× 2	TE713546	26	110	11	9	13
M16	× 2	TE713606	27	110	12	9	15
M18	× 2.5	TE713656	30	125	14	11	16.8
M20	× 2.5	TE713706	32	140	16	12	18.8

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Unit : N/mm²

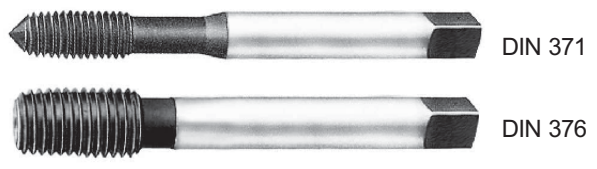
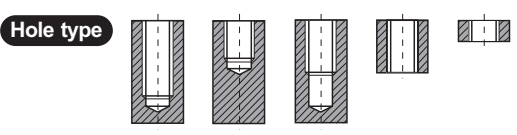
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◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉
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◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉

M ISO metric coarse threads DIN 13 Metrisches ISO-Gewinde DIN 13

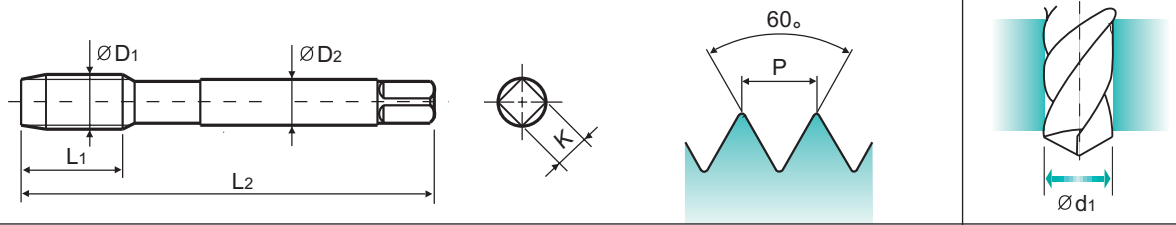
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Material groups: **GV** HSS-E DIN 371/376 6HX 60° C NI

Cold forming taps
Gewindeformer



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M4.5	× 0.75	TE723266	14	70	6	4.9	4.15
M5	× 0.8	TE723286	15	70	6	4.9	4.65
M6	× 1	TE723316	17	80	6	4.9	5.55
M7	× 1	TE723346	17	80	7	5.5	6.55
M8	× 1.25	TE723366	20	90	8	6.2	7.4
M9	× 1.25	TE723396	20	90	9	7	8.4
M10	× 1.5	TE723426	22	100	10	8	9.3
M11	× 1.5	TE723466	22	100	8	6.2	10.3
M12	× 1.75	TE723506	24	110	9	7	11.2
M14	× 2	TE723546	26	110	11	9	13
M16	× 2	TE723606	27	110	12	9	15
M18	× 2.5	TE723656	30	125	14	11	16.8
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Unit : N/mm²

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◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

- HSS
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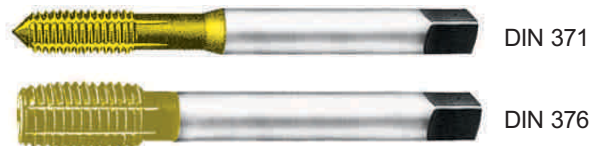
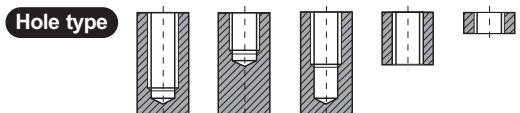
W/G COLD FORMING TAPS

TD713 SERIES

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Metrisches ISO-Gewinde DIN 13

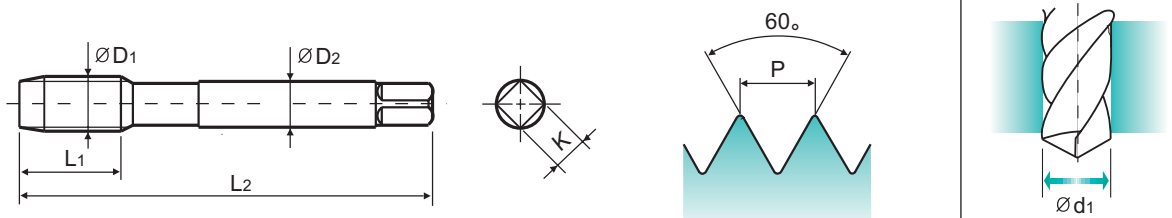
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Material groups: **GV** **HSS-E** **DIN 371/376** **6GX** **60°** **C** **TiN**

Cold forming taps with oil grooves
 Gewindeformer mit Schmiernuten



SIZE	Pitch	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping drill diameter
Ø D1	P		L1	L2	Ø D2	K	Ø d1
M2	× 0.4	TD713136	8	45	2.8	2.1	1.83
M2.2	× 0.45	TD713156	8	45	2.8	2.1	2
#d M2.3	× 0.4	TD713196	8	45	2.8	2.1	2.1
M2.5	× 0.45	TD713176	9	50	2.8	2.1	2.3
#d M2.6	× 0.45	TD713496	9	50	2.8	2.1	2.4
M3	× 0.5	TD713206	11	56	3.5	2.7	2.8
M3.5	× 0.6	TD713226	12	56	4	3	3.25
M4	× 0.7	TD713246	13	63	4.5	3.4	3.7
M4.5	× 0.75	TD713266	14	70	6	4.9	4.15
M5	× 0.8	TD713286	15	70	6	4.9	4.65
M6	× 1	TD713316	17	80	6	4.9	5.55
M7	× 1	TD713346	17	80	7	5.5	6.55
M8	× 1.25	TD713366	20	90	8	6.2	7.4
M9	× 1.25	TD713396	20	90	9	7	8.4
M10	× 1.5	TD713426	22	100	10	8	9.3
M11	× 1.5	TD713466	22	100	8	6.2	10.3
M12	× 1.75	TD713506	24	110	9	7	11.2
M14	× 2	TD713546	26	110	11	9	13
M16	× 2	TD713606	27	110	12	9	15
M18	× 2.5	TD713656	30	125	14	11	16.8
M20	× 2.5	TD713706	32	140	16	12	18.8

- ▶ DIN 371(M2~M10) and DIN 376(M11~M20)
- ▶ #d DIN profile not ISO

Unit : N/mm²

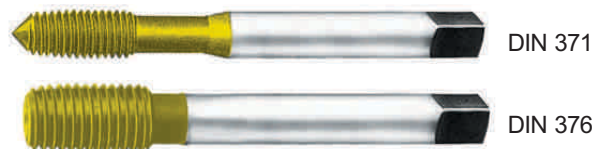
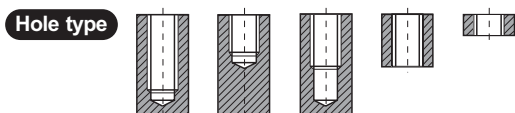
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Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

M ISO metric coarse threads DIN 13 Metrisches ISO-Gewinde DIN 13

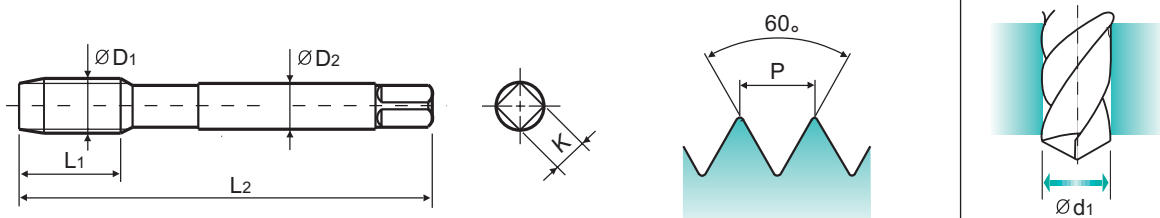
- Suitable for threading soft materials with at least 8-10% elongation.
- The pre-drilling holes are bigger than normal sized holes.

- Geeignet zum Gewindeformen weicher Werkstoffe mit mindestens 8 - 10% Dehnung.
- Die Kernlochbohrungen sind größer als normale Kernlöcher.



Material groups: **GV** HSS-E DIN 371/376 6HX 60° C TiN

Cold forming taps
Gewindeformer



SIZE	Pitch	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping drill diameter
Ø D1	P		L1	L2	Ø D2	K	Ø d1
M2	× 0.4	TD723136	8	45	2.8	2.1	1.83
M2.2	× 0.45	TD723156	8	45	2.8	2.1	2
#d M2.3	× 0.4	TD723196	8	45	2.8	2.1	2.1
M2.5	× 0.45	TD723176	9	50	2.8	2.1	2.3
#d M2.6	× 0.45	TD723496	9	50	2.8	2.1	2.4
M3	× 0.5	TD723206	11	56	3.5	2.7	2.8
M3.5	× 0.6	TD723226	12	56	4	3	3.25
M4	× 0.7	TD723246	13	63	4.5	3.4	3.7
M4.5	× 0.75	TD723266	14	70	6	4.9	4.15
M5	× 0.8	TD723286	15	70	6	4.9	4.65
M6	× 1	TD723316	17	80	6	4.9	5.55
M7	× 1	TD723346	17	80	7	5.5	6.55
M8	× 1.25	TD723366	20	90	8	6.2	7.4
M9	× 1.25	TD723396	20	90	9	7	8.4
M10	× 1.5	TD723426	22	100	10	8	9.3
M11	× 1.5	TD723466	22	100	8	6.2	10.3
M12	× 1.75	TD723506	24	110	9	7	11.2
M14	× 2	TD723546	26	110	11	9	13
M16	× 2	TD723606	27	110	12	9	15
M18	× 2.5	TD723656	30	125	14	11	16.8
M20	× 2.5	TD723706	32	140	16	12	18.8

- DIN 371(M2~M10) and DIN 376(M11~M20)
- #d DIN profile not ISO

Unit : N/mm²

◎ Z @ e □ □ □ □ □ □ □ □ □ □ @ @ @ @ @ □ □ Z @ g □ □

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP

- HSS
- CARBIDE
- COMBO TAPS
- SPIRAL POINT TAPS
- SPIRAL FLUTE TAPS
- STRAIGHT FLUTE TAPS
- COLD FORMING TAPS
- NUT TAPS
- STI TAPS
- HAND TAPS
- PIPE TAPS
- CARBIDE TAPS
- THREAD MILLS
- TECHNICAL DATA

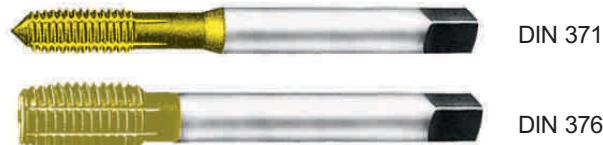
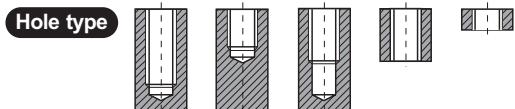
W/G COLD FORMING TAPS

TD703 SERIES

M ISO metric coarse threads DIN 13 Metrisches ISO-Gewinde DIN 13

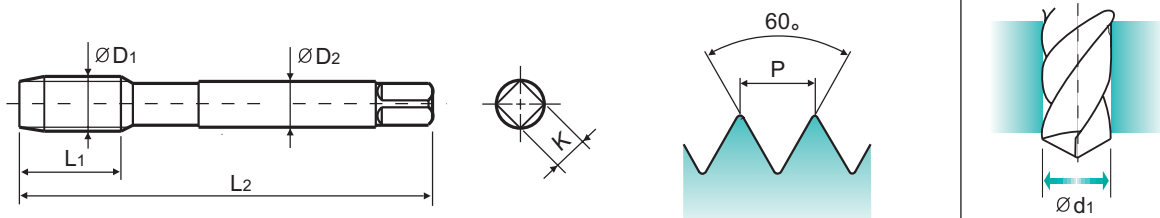
- Suitable for threading soft materials with at least 8-10% elongation.
- The pre-drilling holes are bigger than normal sized holes.

- Geeignet zum Gewindeformen weicher Werkstoffe mit mindestens 8 - 10% Dehnung.
- Die Kernlochbohrungen sind größer als normale Kernlöcher.



Material groups: **GV** HSS-E DIN 371/376 6HX 60° C TiN

Cold forming taps with oil grooves
Gewindeformer mit Schmiernuten



SIZE	Pitch	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping drill diameter
Ø D1	P		L1	L2	Ø D2	K	Ø d1
M2	× 0.4	TD703136	8	45	2.8	2.1	1.83
M2.2	× 0.45	TD703156	8	45	2.8	2.1	2
#d M2.3	× 0.4	TD703196	8	45	2.8	2.1	2.1
M2.5	× 0.45	TD703176	9	50	2.8	2.1	2.3
#d M2.6	× 0.45	TD703496	9	50	2.8	2.1	2.4
M3	× 0.5	TD703206	11	56	3.5	2.7	2.8
M3.5	× 0.6	TD703226	12	56	4	3	3.25
M4	× 0.7	TD703246	13	63	4.5	3.4	3.7
M4.5	× 0.75	TD703266	14	70	6	4.9	4.15
M5	× 0.8	TD703286	15	70	6	4.9	4.65
M6	× 1	TD703316	17	80	6	4.9	5.55
M7	× 1	TD703346	17	80	7	5.5	6.55
M8	× 1.25	TD703366	20	90	8	6.2	7.4
M9	× 1.25	TD703396	20	90	9	7	8.4
M10	× 1.5	TD703426	22	100	10	8	9.3
M11	× 1.5	TD703466	22	100	8	6.2	10.3
M12	× 1.75	TD703506	24	110	9	7	11.2
M14	× 2	TD703546	26	110	11	9	13
M16	× 2	TD703606	27	110	12	9	15
M18	× 2.5	TD703656	30	125	14	11	16.8
M20	× 2.5	TD703706	32	140	16	12	18.8

- DIN 371(M2~M10) and DIN 376(M11~M20)
- #d DIN profile not ISO

Unit : N/mm²

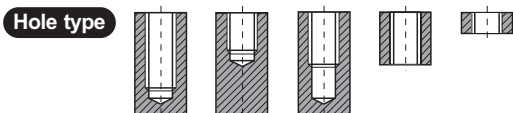
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Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉

M ISO metric coarse threads DIN 13 Metrisches ISO-Gewinde DIN 13

- ▶ Suitable for threading soft materials with at least 8-10% elongation.
- ▶ The pre-drilling holes are bigger than normal sized holes.

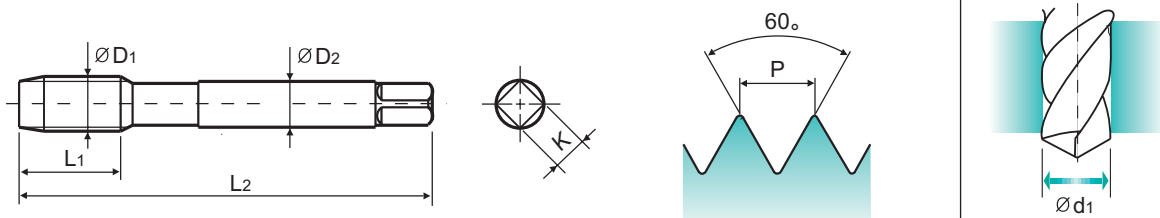
- ▶ Geeignet zum Gewindeformen weicher Werkstoffe mit mindestens 8 - 10% Dehnung.
- ▶ Die Kernlochbohrungen sind größer als normale Kernlöcher.



Material groups

GV HSS-E DIN 371/376 6HX 60° C TiAlN

Cold forming taps with oil grooves
Gewindeformer mit Schmiernuten



SIZE	Pitch	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping drill diameter
Ø D1	P		L1	L2	Ø D2	K	Ø d1
M2	× 0.4	TY703136	8	45	2.8	2.1	1.83
M2.2	× 0.45	TY703156	8	45	2.8	2.1	2
#d M2.3	× 0.4	TY703196	8	45	2.8	2.1	2.1
M2.5	× 0.45	TY703176	9	50	2.8	2.1	2.3
#d M2.6	× 0.45	TY703496	9	50	2.8	2.1	2.4
M3	× 0.5	TY703206	11	56	3.5	2.7	2.8
M3.5	× 0.6	TY703226	12	56	4	3	3.25
M4	× 0.7	TY703246	13	63	4.5	3.4	3.7
M4.5	× 0.75	TY703266	14	70	6	4.9	4.15
M5	× 0.8	TY703286	15	70	6	4.9	4.65
M6	× 1	TY703316	17	80	6	4.9	5.55
M7	× 1	TY703346	17	80	7	5.5	6.55
M8	× 1.25	TY703366	20	90	8	6.2	7.4
M9	× 1.25	TY703396	20	90	9	7	8.4
M10	× 1.5	TY703426	22	100	10	8	9.3
M11	× 1.5	TY703466	22	100	8	6.2	10.3
M12	× 1.75	TY703506	24	110	9	7	11.2
M14	× 2	TY703546	26	110	11	9	13
M16	× 2	TY703606	27	110	12	9	15
M18	× 2.5	TY703656	30	125	14	11	16.8
M20	× 2.5	TY703706	32	140	16	12	18.8

Unit : mm

- ▶ DIN 371(M2~M10) and DIN 376(M11~M20)
- ▶ #d DIN profile not ISO

Unit : N/mm²

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Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP

- HSS
- CARBIDE
- COMBO TAPS
- SPIRAL POINT TAPS
- SPIRAL FLUTE TAPS
- STRAIGHT FLUTE TAPS
- COLD FORMING TAPS
- NUT TAPS
- STI TAPS
- HAND TAPS
- PIPE TAPS
- CARBIDE TAPS
- THREAD MILLS
- TECHNICAL DATA

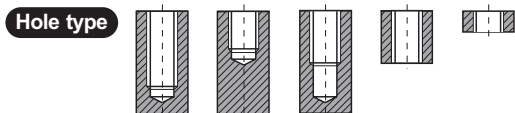
W/G COLD FORMING TAPS

TE733 SERIES

MF ISO metric fine threads DIN 13
Metrisches ISO-Feingewinde DIN 13

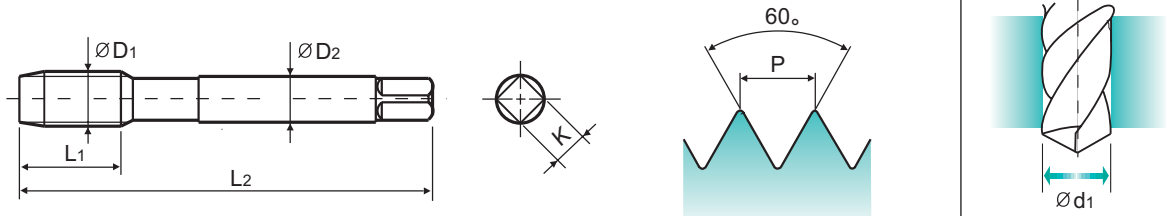
- ▶ Suitable for threading soft materials with at least 8-10% elongation.
- ▶ The pre-drilling holes are bigger than normal sized holes.

- ▶ Geeignet zum Gewindeformen weicher Werkstoffe mit mindestens 8 - 10% Dehnung.
- ▶ Die Kernlochbohrungen sind größer als normale Kernlöcher.



Material groups: **GV** **HSS-E** **DIN 374** **6HX** **60°** **C** **NI**

Cold forming taps with oil grooves
 Gewindeformer mit Schmiernuten



SIZE	Pitch	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping drill diameter
Ø D1	P		L1	L2	Ø D2	K	Ø d1
M4	× 0.5	TE733256	10	63	2.8	2.1	3.75
M5	× 0.5	TE733296	11	70	3.5	2.7	4.75
M6	× 0.75	TE733326	13	80	4.5	3.4	5.65
M6	× 0.5	TE733336	13	80	4.5	3.4	5.75
M7	× 0.75	TE733356	14	80	5.5	4.3	6.65
M8	× 1	TE733376	17	90	6	4.9	7.50
M8	× 0.75	TE733386	14	80	6	4.9	7.65
M10	× 1.25	TE733436	22	100	7	5.5	9.4
M10	× 1	TE733446	18	90	7	5.5	9.5
M10	× 0.75	TE733456	18	90	7	5.5	9.65
M12	× 1.5	TE733516	22	100	9	7	11.25
M12	× 1.25	TE733526	22	100	9	7	11.4
M12	× 1	TE733536	18	100	9	7	11.5
M14	× 1.5	TE733556	22	100	11	9	13.25
M14	× 1.25	TE733566	22	100	11	9	13.4
M16	× 1.5	TE733616	22	100	12	9	15.25
M18	× 1.5	TE733676	25	110	14	11	17.25
M20	× 1.5	TE733726	25	125	16	12	19.25

Unit : mm

Unit : N/mm²

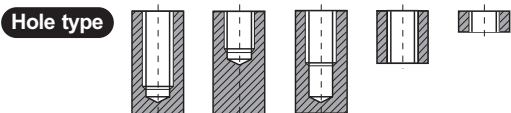
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Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

MF ISO metric fine threads DIN 13
Metrisches ISO-Feingewinde DIN 13

- ▶ Suitable for threading soft materials with at least 8-10% elongation.
- ▶ The pre-drilling holes are bigger than normal sized holes.

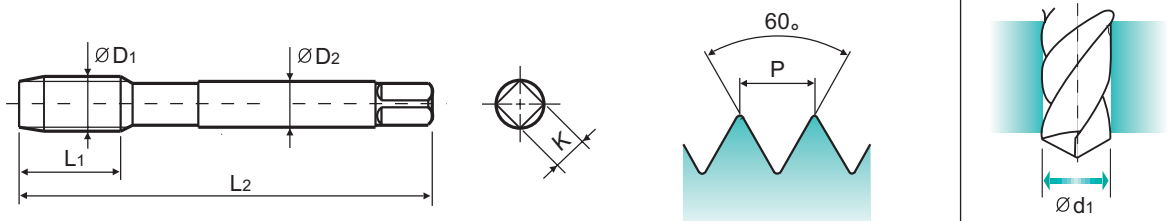
- ▶ Geeignet zum Gewindeformen weicher Werkstoffe mit mindestens 8 - 10% Dehnung.
- ▶ Die Kernlochbohrungen sind größer als normale Kernlöcher.



Material groups

GV HSS-E DIN 374 6HX 60° C TiN

Cold forming taps with oil grooves
 Gewindeformer mit Schmiernuten



SIZE	Pitch	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping drill diameter
Ø D1	P		L1	L2	Ø D2	K	Ø d1
M4	× 0.5	TD733256	10	63	2.8	2.1	3.75
M5	× 0.5	TD733296	11	70	3.5	2.7	4.75
M6	× 0.75	TD733326	13	80	4.5	3.4	5.65
M6	× 0.5	TD733336	13	80	4.5	3.4	5.75
M7	× 0.75	TD733356	14	80	5.5	4.3	6.65
M8	× 1	TD733376	17	90	6	4.9	7.50
M8	× 0.75	TD733386	14	80	6	4.9	7.65
M10	× 1.25	TD733436	22	100	7	5.5	9.4
M10	× 1	TD733446	18	90	7	5.5	9.5
M10	× 0.75	TD733456	18	90	7	5.5	9.65
M12	× 1.5	TD733516	22	100	9	7	11.25
M12	× 1.25	TD733526	22	100	9	7	11.4
M12	× 1	TD733536	18	100	9	7	11.5
M14	× 1.5	TD733556	22	100	11	9	13.25
M14	× 1.25	TD733566	22	100	11	9	13.4
M16	× 1.5	TD733616	22	100	12	9	15.25
M18	× 1.5	TD733676	25	110	14	11	17.25
M20	× 1.5	TD733726	25	125	16	12	19.25

Unit : mm

Unit : N/mm²

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Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP

- HSS
- CARBIDE
- COMBO TAPS
- SPIRAL POINT TAPS
- SPIRAL FLUTE TAPS
- STRAIGHT FLUTE TAPS
- COLD FORMING TAPS
- NUT TAPS
- STI TAPS
- HAND TAPS
- PIPE TAPS
- CARBIDE TAPS
- THREAD MILLS
- TECHNICAL DATA

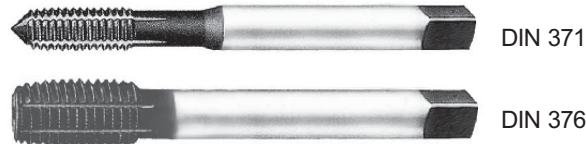
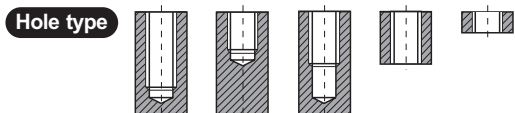
W/G COLD FORMING TAPS

TE704 SERIES

UNC Unified coarse threads
Unified Grobgewinde

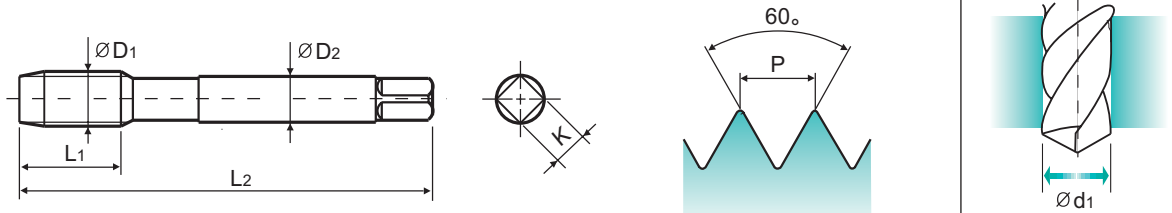
- Suitable for threading soft materials with at least 8-10% elongation.
- The pre-drilling holes are bigger than normal sized holes.

- Geeignet zum Gewindeformen weicher Werkstoffe mit mindestens 8 - 10% Dehnung.
- Die Kernlochbohrungen sind größer als normale Kernlöcher.



Material groups: **GV** HSS-E DIN 371/376 2BX 60° C NI

Cold forming taps with oil grooves
Gewindeformer mit Schmiernuten



SIZE	TPI	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping drill diameter
Ø D1			L1	L2	Ø D2	K	Ø d1
#5	M 40 UNC	TE704202	11	56	3.5	2.7	2.87
#6	M 32 UNC	TE704242	12	56	4	3	3.1
#8	M 32 UNC	TE704282	13	63	4.5	3.4	3.8
#10	M 24 UNC	TE704322	15	70	6	4.9	4.3
#12	M 24 UNC	TE704362	16	80	6	4.9	4.95
1/4"	M 20 UNC	TE704402	17	80	7	5.5	5.75
5/16"	M 18 UNC	TE704442	20	90	8	6.2	7.25
3/8"	M 16 UNC	TE704482	22	100	9	7	8.75
7/16"	M 14 UNC	TE704522	22	100	8	6.2	10.2
1/2"	M 13 UNC	TE704562	25	110	9	7	11.7
9/16"	M 12 UNC	TE704602	26	110	11	9	13.2
5/8"	M 11 UNC	TE704642	27	110	12	9	14.7
3/4"	M 10 UNC	TE704702	30	125	14	11	17.8

► DIN 371(#4~3/8") and DIN 376(7/16"~3/4")

Unit : N/mm²

◎ Z @ e □ □ □ □ □ □ □ □ □ □ @ @ @ @ @ ○ ○ ○ ○

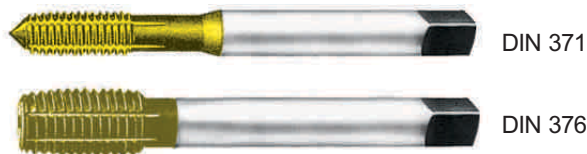
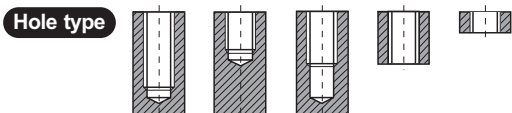
Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

UNC Unified coarse threads

Unified Grobgewinde

- ▶ Suitable for threading soft materials with at least 8-10% elongation.
- ▶ The pre-drilling holes are bigger than normal sized holes.

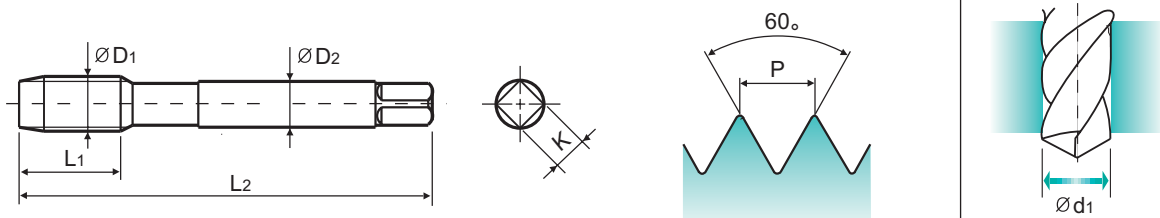
- ▶ Geeignet zum Gewindeformen weicher Werkstoffe mit mindestens 8 - 10% Dehnung.
- ▶ Die Kernlochbohrungen sind größer als normale Kernlöcher.



Material groups

GV HSS-E DIN 371/376 2BX 60° C TiN

Cold forming taps with oil grooves
Gewindeformer mit Schmiernuten



SIZE	TPI	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping drill diameter
Ø D1			L1	L2	Ø D2	K	Ø d1
#5	M 40 UNC	TD704202	11	56	3.5	2.7	2.87
#6	M 32 UNC	TD704242	12	56	4	3	3.1
#8	M 32 UNC	TD704282	13	63	4.5	3.4	3.8
#10	M 24 UNC	TD704322	15	70	6	4.9	4.3
#12	M 24 UNC	TD704362	16	80	6	4.9	4.95
1/4"	M 20 UNC	TD704402	17	80	7	5.5	5.75
5/16"	M 18 UNC	TD704442	20	90	8	6.2	7.25
3/8"	M 16 UNC	TD704482	22	100	9	7	8.75
7/16"	M 14 UNC	TD704522	22	100	8	6.2	10.2
1/2"	M 13 UNC	TD704562	25	110	9	7	11.7
9/16"	M 12 UNC	TD704602	26	110	11	9	13.2
5/8"	M 11 UNC	TD704642	27	110	12	9	14.7
3/4"	M 10 UNC	TD704702	30	125	14	11	17.8

Unit : mm

▶ DIN 371(#4~3/8") and DIN 376(7/16"~3/4")

Unit : N/mm²

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Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP

- HSS
- CARBIDE
- COMBO TAPS
- SPIRAL POINT TAPS
- SPIRAL FLUTE TAPS
- STRAIGHT FLUTE TAPS
- COLD FORMING TAPS
- NUT TAPS
- STI TAPS
- HAND TAPS
- PIPE TAPS
- CARBIDE TAPS
- THREAD MILLS
- TECHNICAL DATA