

HSS



Being the best through innovation



NUT TAPS

MUTTERGEWINDEBOHRER

- Nut Tapping Machines
- Zum Gewindeschneiden von Muttern

M ISO metric coarse threads DIN 13

Metrisches ISO-Gewinde DIN 13

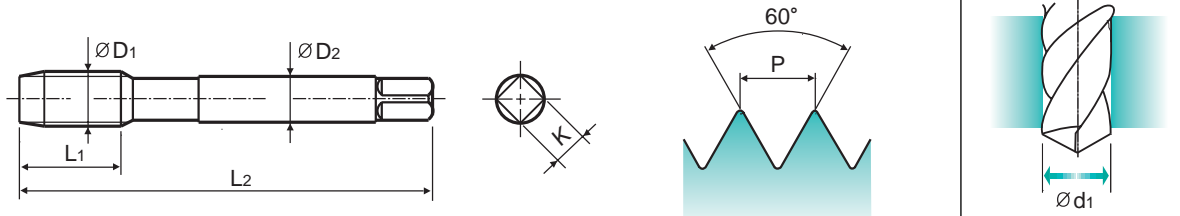
- ▶ For making nuts on machines.
- ▶ The work pieces can be taken out from shank side only.

- ▶ Zur Herstellung von Muttern auf Sondermaschinen.
- ▶ Die fertigen Muttern können nur über das Schaftende entnommen werden.



Material groups **GS** **HSS-E** **DIN 357** **6H** **60°** **LONG** **Bright**

Nut taps
Muttergewindebohrer



SIZE	Pitch	EDP No.	Thread Length		Shank Diameter	Square Size	Tapping drill diameter
			L1	L2			
M4	× 0.7	TC803246	25	90	ØD2	K	Ød1
M5	× 0.8	TC803286	28	100	3.5	2.7	4.2
M6	× 1	TC803316	32	110	4.5	3.4	5
M7	× 1	TC803346	36	110	5.5	4.3	6
M8	× 1.25	TC803366	40	125	6	4.9	6.8
M10	× 1.5	TC803426	45	140	7	5.5	8.5
M12	× 1.75	TC803506	50	180	9	7	10.2
M14	× 2	TC803546	56	200	11	9	12
M16	× 2	TC803606	63	200	12	9	14
M18	× 2.5	TC803656	63	220	14	11	15.5
M20	× 2.5	TC803706	70	250	16	12	17.5

Unit : mm

Unit : N/mm²

◎ : Excellent ○ : Good

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
○	○	○	○	○	○	○	○	○	○	○	○	○	○	○