HSS

Being the best through innovation

SPIRAL POINT TAPS

GEWINDEBOHRER MIT SCHALANSCHNITT

- **Tapping Through Holes, HSS-E & HSS-PM**
- **Für Durchgangslöcher. HSS-E und HSS-PM**

SPIRAL POINT TAPS
Tapping Through Holes, HSS-E & HSS-PM

SPIRAL POINT TAPS

EDP No.	MODEL	Tool Material	Standard	Work Material	Dimensions	Tolerance	Chamfer	Surface Treatment	PAGE
TC122		HSS-E	M	**GS**	DIN 352	ISO 2/6H	B	Bright	**340**
TC127		HSS-E	M	**GS**	DIN 371	ISO 2/6H	B	Bright	**341**
TC227		HSS-E	M	**GS**	DIN 376	ISO 2/6H	B	Bright	**342**
TD127		HSS-E	M	**GS**	DIN 371	ISO 2/6H	B	TiN	**343**
TD227		HSS-E	M	**GS**	DIN 376	ISO 2/6H	B	TiN	**344**
TQ863		HSS-PM	M	**VG**	DIN 371/376	ISO 2/6H	B	vap	**345**
TR863		HSS-PM	M	**VG**	DIN 371/376	ISO 2/6H	B	Bright	**346**
TC422		HSS-E	M	**VG**	DIN 371/376	ISO 2/6H	B	Bright	**347**
TE422		HSS-E	M	**VG**	DIN 371/376	ISO 2/6H	B	NI	**348**
TD422		HSS-E	M	**VG**	DIN 371/376	ISO 2/6H	B	TiN	**349**
TY422		HSS-E	M	**VG**	DIN 371/376	ISO 2/6H	B	TiAlN	**350**
TQ853		HSS-PM	M	**VA**	DIN 371/376	ISO 2/6H	B	vap	**351**
TR853		HSS-PM	M	**VA**	DIN 371/376	ISO 2/6H	B	Bright	**352**
TC283		HSS-E	M	**HR**	DIN 371/376	ISO 2/6H	B	Bright	**353**
TY283		HSS-E	M	**HR**	DIN 371/376	ISO 2/6H	B	TiAlN	**354**
TB623		HSS-E	M	**VA NW**	DIN 371/376	ISO 2X/6HX	B	vap	**355**
TCH23		HSS-E	M	**VA NW**	DIN 371/376	ISO 2X/6HX	B	Hardslick	**356**
TM293		HSS-PM	M-Az	**Ti**	DIN 371/376	ISO 2/6H	B	Bright	**357**
TZ293		HSS-PM	M-Az	**Ti**	DIN 371/376	ISO 2/6H	B	TiAlN	**358**
TQ873		HSS-PM	M	**Ti Ni**	DIN 371/376	ISO 2/6H	B	vap	**359**

SPIRAL POINT TAPS

EDP No.	MODEL	Tool Material	Standard	Work Material	Dimensions	Tolerance	Chamfer	Surface Treatment	PAGE
TR873		HSS-PM	M	**Ti Ni**	DIN 371/376	ISO 2/6H	B	Bright	**360**
TM923		HSS-PM	M	**Ni**	DIN 371/376	ISO 2/6H	B	Bright	**361**
TZ923		HSS-PM	M	**Ni**	DIN 371/376	ISO 2/6H	B	TiAlN	**362**
TE943		HSS-E	M	**Al**	DIN 371/376	ISO 2/6H	B	NI	**363**
TC622		HSS-E	M-Az	**Al**	DIN 371/376	ISO 2/6H	B	Bright	**364**
TC222		HSS-E	MF	**GS**	DIN 374	ISO 2/6H	B	Bright	**365**
TD222		HSS-E	MF	**GS**	DIN 374	ISO 2/6H	B	TiN	**367**
TC263		HSS-E	MF	**VG**	DIN 374	ISO 2/6H	B	Bright	**369**
TD263		HSS-E	MF	**VG**	DIN 374	ISO 2/6H	B	TiN	**370**
TB123		HSS-E	MF	**VA NW**	DIN 374	ISO 2X/6HX	B	vap	**371**
TC214		HSS-E	UNC	**GS**	DIN 371/376	2B	B	Bright	**372**
TC244		HSS-E	UNC	**VG**	DIN 371/376	2B	B	Bright	**373**
TD244		HSS-E	UNC	**VG**	DIN 371/376	2B	B	TiN	**374**
TB264		HSS-E	UNC	**VA NW**	DIN 371/376	2B	B	vap	**375**
TC234		HSS-E	UNF	**GS**	DIN 371/374	2B	B	Bright	**376**
TC254		HSS-E	UNF	**VG**	DIN 371/374	2B	B	Bright	**377**
TB274		HSS-E	UNF	**VA NW**	DIN 371/374	2B	B	vap	**378**
TC224		HSS-E	BSW	**GS**	DIN 2182/2183	-	B	Bright	**379**

SPIRAL POINT TAPS

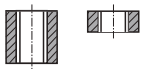
TC122 SERIES

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

▶ Suitable for through hole in more cutting speed than other taps due to thick web.

▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

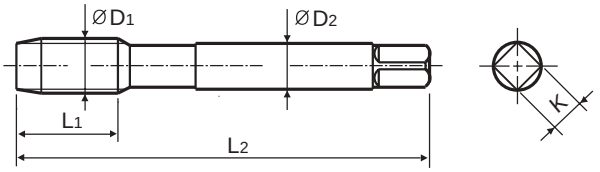
Hole type

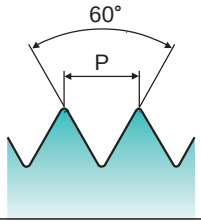


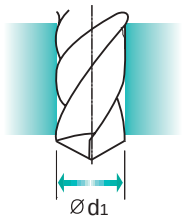
DIN 352

Material groups **GS** | HSS-E | DIN 352 | 6H | 60° | B | Bright

Short machine taps
Maschinengewindebohrer kurz







Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping drill diameter Ød1
M2	× 0.4	TC122136	8	36	2.8	2.1	1.6
M2.5	× 0.45	TC122176	9	40	2.8	2.1	2.05
M3	× 0.5	TC122206	11	40	3.5	2.7	2.5
M4	× 0.7	TC122246	13	45	4.5	3.4	3.3
M5	× 0.8	TC122286	16	52	6	4.9	4.2
M6	× 1	TC122316	18	56	6	4.9	5
M8	× 1.25	TC122366	20	63	6	4.9	6.8
M10	× 1.5	TC122426	22	70	7	5.5	8.5
M12	× 1.75	TC122506	24	80	9	7	10.2
M14	× 2	TC122546	26	80	11	9	12
M16	× 2	TC122606	27	80	12	9	14

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
	○			○		◎		○	○	○	◎	○		

SPIRAL POINT TAPS

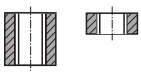
TC127 SERIES

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

▶ Suitable for through hole in more cutting speed than other taps due to thick web.

▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

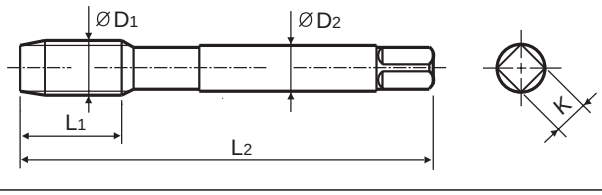
Hole type

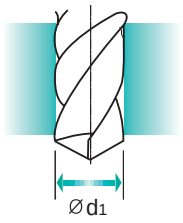


DIN 371

Material groups **GS** | HSS-E | DIN 371 | 6H | 60° | B | Bright

Machine taps
Maschinengewindebohrer





Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping drill diameter Ød1
M2	0.4	TC127136	8	45	2.8	2.1	1.6
M2.2	0.45	TC127156	8	45	2.8	2.1	1.75
✳ M2.3	0.4	TC127196	8	45	2.8	2.1	1.9
M2.5	0.45	TC127176	9	50	2.8	2.1	2.05
✳ M2.6	0.45	TC127496	9	50	2.8	2.1	2.1
M3	0.5	TC127206	11	56	3.5	2.7	2.5
M3.5	0.6	TC127226	12	56	4	3	2.9
M4	0.7	TC127246	13	63	4.5	3.4	3.3
M4.5	0.75	TC127266	14	70	6	4.9	3.7
M5	0.8	TC127286	15	70	6	4.9	4.2
M6	1	TC127316	17	80	6	4.9	5
M7	1	TC127346	17	80	7	5.5	6
M8	1.25	TC127366	20	90	8	6.2	6.8
M9	1.25	TC127396	20	90	9	7	7.8
M10	1.5	TC127426	22	100	10	8	8.5
M11	1.5	TC127466	22	100	11	9	9.5
M12	1.75	TC127506	24	110	12	9	10.2

▶ ✳ DIN profile not ISO

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
	○			○		◎		○	○	○	◎	○		

SPIRAL POINT TAPS

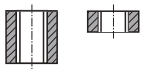
TC227 SERIES

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

▶ Suitable for through hole in more cutting speed than other taps due to thick web.

▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

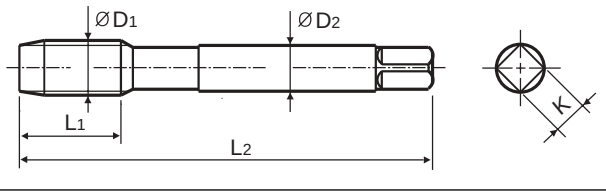
Hole type

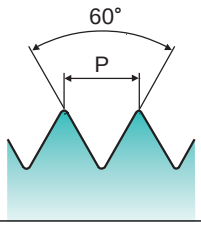


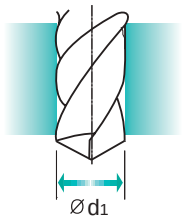
DIN 376

Material groups **GS** | HSS-E | DIN 376 | 6H | 60° | B | Bright

Machine taps
Maschinengewindebohrer







Unit : mm

SIZE ØD1		Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping drill diameter Ød1
M3	×	0.5	TC227206	11	56	2.2	1.8	2.5
M3.5	×	0.6	TC227226	12	56	2.5	2.1	2.9
M4	×	0.7	TC227246	13	63	2.8	2.1	3.3
M4.5	×	0.75	TC227266	14	70	3.5	2.7	3.7
M5	×	0.8	TC227286	15	70	3.5	2.7	4.2
M6	×	1	TC227316	17	80	4.5	3.4	5
M7	×	1	TC227346	17	80	5.5	4.3	6
M8	×	1.25	TC227366	20	90	6	4.9	6.8
M9	×	1.25	TC227396	20	90	7	5.5	7.8
M10	×	1.5	TC227426	22	100	7	5.5	8.5
M11	×	1.5	TC227466	22	100	8	6.2	9.5
M12	×	1.75	TC227506	24	110	9	7	10.2
M14	×	2	TC227546	26	110	11	9	12
M16	×	2	TC227606	27	110	12	9	14
M18	×	2.5	TC227656	30	125	14	11	15.5
M20	×	2.5	TC227706	32	140	16	12	17.5
M22	×	2.5	TC227746	32	140	18	14.5	19.5
M24	×	3	TC227786	34	160	18	14.5	21
M27	×	3	TC227866	36	160	20	16	24
M30		3.5	TC227946	40	180	22	18	26.5

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
	○			○		◎		○	○	○	◎	○		

SPIRAL POINT TAPS

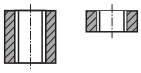
TD127 SERIES

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

▶ Suitable for through hole in more cutting speed than other taps due to thick web.

▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

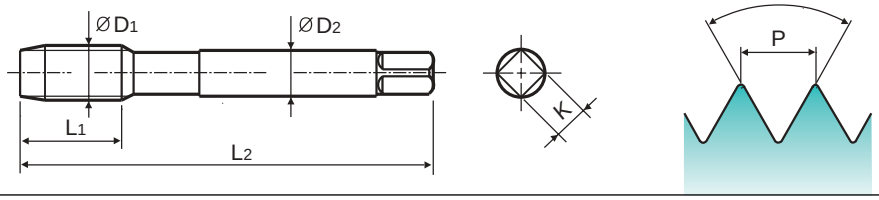
Hole type

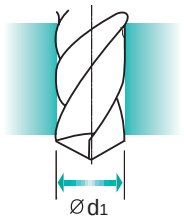


DIN 371

Material groups **GS** | HSS-E | DIN 371 | 6H | 60° | B | TiN

Machine taps
Maschinengewindebohrer





Unit : mm

SIZE ØD1		Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping drill diameter Ød1
M2	×	0.4	TD127136	8	45	2.8	2.1	1.6
M2.2	×	0.45	TD127156	8	45	2.8	2.1	1.75
✳ M2.3	×	0.4	TD127196	8	45	2.8	2.1	1.9
M2.5	×	0.45	TD127176	9	50	2.8	2.1	2.05
✳ M2.6	×	0.45	TD127496	9	50	2.8	2.1	2.1
M3	×	0.5	TD127206	11	56	3.5	2.7	2.5
M3.5	×	0.6	TD127226	12	56	4	3	2.9
M4	×	0.7	TD127246	13	63	4.5	3.4	3.3
M4.5	×	0.75	TD127266	14	70	6	4.9	3.7
M5	×	0.8	TD127286	15	70	6	4.9	4.2
M6	×	1	TD127316	17	80	6	4.9	5
M7	×	1	TD127346	17	80	7	5.5	6
M8	×	1.25	TD127366	20	90	8	6.2	6.8
M9	×	1.25	TD127396	20	90	9	7	7.8
M10	×	1.5	TD127426	22	100	10	8	8.5
M11	×	1.5	TD127466	22	100	11	9	9.5
M12	×	1.75	TD127506	24	110	12	9	10.2

▶ ✳ DIN profile not ISO

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
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SPIRAL POINT TAPS

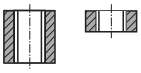
TD227 SERIES

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

▶ Suitable for through hole in more cutting speed than other taps due to thick web.

▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

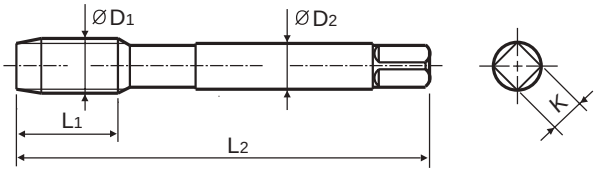
Hole type

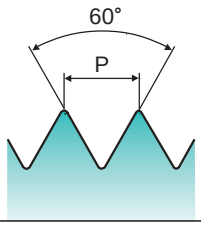


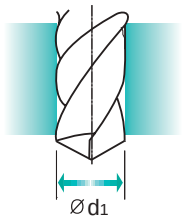
DIN 376

Material groups **GS** | HSS-E | DIN 376 | 6H | 60° | B | TiN

Machine taps
Maschinengewindebohrer







Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping drill diameter Ød1
M3	0.5	TD227206	11	56	2.2	1.8	2.5
M3.5	0.6	TD227226	12	56	2.5	2.1	2.9
M4	0.7	TD227246	13	63	2.8	2.1	3.3
M4.5	0.75	TD227266	14	70	3.5	2.7	3.7
M5	0.8	TD227286	15	70	3.5	2.7	4.2
M6	1	TD227316	17	80	4.5	3.4	5
M7	1	TD227346	17	80	5.5	4.3	6
M8	1.25	TD227366	20	90	6	4.9	6.8
M9	1.25	TD227396	20	90	7	5.5	7.8
M10	1.5	TD227426	22	100	7	5.5	8.5
M11	1.5	TD227466	22	100	8	6.2	9.5
M12	1.75	TD227506	24	110	9	7	10.2
M14	2	TD227546	26	110	11	9	12
M16	2	TD227606	27	110	12	9	14
M18	2.5	TD227656	30	125	14	11	15.5
M20	2.5	TD227706	32	140	16	12	17.5
M22	2.5	TD227746	32	140	18	14.5	19.5
M24	3	TD227786	34	160	18	14.5	21
M27	3	TD227866	36	160	20	16	24
M30	3.5	TD227946	40	180	22	18	26.5

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
	○			○		◎		○	○	○	◎	○		

SPIRAL POINT TAPS

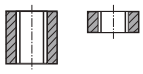
TQ863 SERIES

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

▶ Suitable for through hole in more cutting speed than other taps due to thick web and the best substrate.

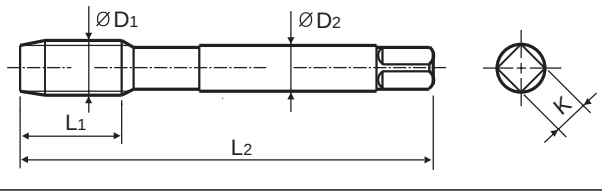
▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke und bestem Werkstoff.

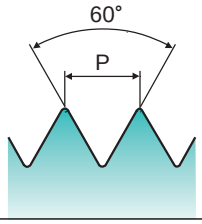
Hole type

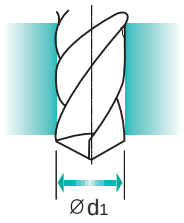


Material groups **VG** | HSS-PM | DIN 371/376 | 6H | 60° | B | Vap

Machine taps
Maschinengewindebohrer







Unit : mm

SIZE ØD1	×	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping drill diameter Ød1
M2	×	0.4	TQ863136	8	45	2.8	2.1	1.6
M2.2	×	0.45	TQ863156	8	45	2.8	2.1	1.75
M2.5	×	0.45	TQ863176	9	50	2.8	2.1	2.05
M3	×	0.5	TQ863206	11	56	3.5	2.7	2.5
M3.5	×	0.6	TQ863226	12	56	4	3	2.9
M4	×	0.7	TQ863246	13	63	4.5	3.4	3.3
M4.5	×	0.75	TQ863266	14	70	6	4.9	3.7
M5	×	0.8	TQ863286	15	70	6	4.9	4.2
M6	×	1	TQ863316	17	80	6	4.9	5
M7	×	1	TQ863346	17	80	7	5.5	6
M8	×	1.25	TQ863366	20	90	8	6.2	6.8
M10	×	1.5	TQ863426	22	100	10	8	8.5
M12	×	1.75	TQ863506	24	110	9	7	10.2

▶ DIN 371(M2~M10) and DIN 376(M12)

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
		○												

SPIRAL POINT TAPS

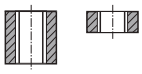
TR863 SERIES

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

▶ Suitable for through hole in more cutting speed than other taps due to thick web and the best substrate.

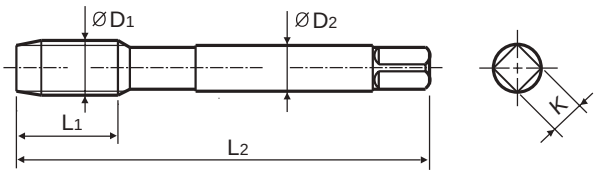
▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke und bestem Werkstoff.

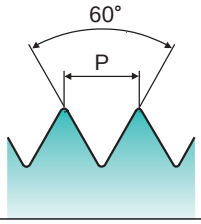
Hole type

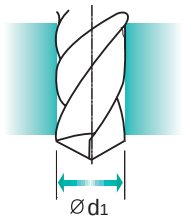


Material groups **VG** | HSS-PM | DIN 371/376 | 6H | 60° | B | Bright

Machine taps
Maschinengewindebohrer







Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping drill diameter Ød1
M2	0.4	TR863136	8	45	2.8	2.1	1.6
M2.2	0.45	TR863156	8	45	2.8	2.1	1.75
M2.5	0.45	TR863176	9	50	2.8	2.1	2.05
M3	0.5	TR863206	11	56	3.5	2.7	2.5
M3.5	0.6	TR863226	12	56	4	3	2.9
M4	0.7	TR863246	13	63	4.5	3.4	3.3
M4.5	0.75	TR863266	14	70	6	4.9	3.7
M5	0.8	TR863286	15	70	6	4.9	4.2
M6	1	TR863316	17	80	6	4.9	5
M7	1	TR863346	17	80	7	5.5	6
M8	1.25	TR863366	20	90	8	6.2	6.8
M10	1.5	TR863426	22	100	10	8	8.5
M12	1.75	TR863506	24	110	9	7	10.2

▶ DIN 371(M2~M10) and DIN 376(M12)

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
		○												

SPIRAL POINT TAPS

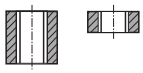
TC422 SERIES

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

▶ Suitable for through hole in more cutting speed than other taps due to thick web.

▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

Hole type

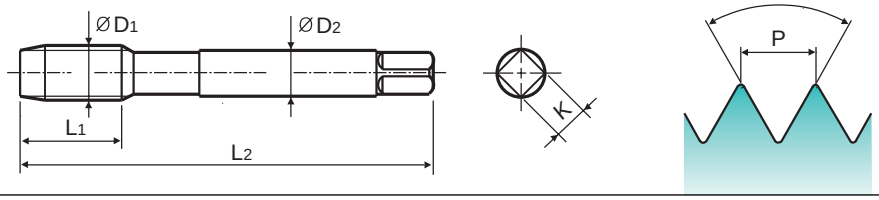


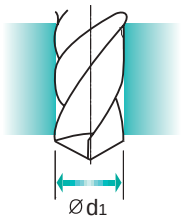
DIN 371

DIN 376

Material groups **VG** | HSS-E | DIN 371/376 | 6H | 60° | B | Bright

Machine taps
Maschinengewindebohrer





Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping drill diameter
ØD1	P		L1	L2	ØD2	K	Ød1
M2	× 0.4	TC422136	8	45	2.8	2.1	1.6
M2.2	× 0.45	TC422156	8	45	2.8	2.1	1.75
✳ M2.3	× 0.4	TC422196	8	45	2.8	2.1	1.9
M2.5	× 0.45	TC422176	9	50	2.8	2.1	2.05
✳ M2.6	× 0.45	TC422496	9	50	2.8	2.1	2.1
M3	× 0.5	TC422206	11	56	3.5	2.7	2.5
M3.5	× 0.6	TC422226	12	56	4	3	2.9
M4	× 0.7	TC422246	13	63	4.5	3.4	3.3
M4.5	× 0.75	TC422266	14	70	6	4.9	3.7
M5	× 0.8	TC422286	15	70	6	4.9	4.2
M6	× 1	TC422316	17	80	6	4.9	5
M7	× 1	TC422346	17	80	7	5.5	6
M8	× 1.25	TC422366	20	90	8	6.2	6.8
M9	× 1.25	TC422396	20	90	9	7	7.8
M10	× 1.5	TC422426	22	100	10	8	8.5
M11	× 1.5	TC422466	22	100	8	6.2	9.5
M12	× 1.75	TC422506	24	110	9	7	10.2
M14	× 2	TC422546	26	110	11	9	12
M16	× 2	TC422606	27	110	12	9	14
M18	× 2.5	TC422656	30	125	14	11	15.5
M20	× 2.5	TC422706	32	140	16	12	17.5
M22	× 2.5	TC422746	32	140	18	14.5	19.5
M24	× 3	TC422786	34	160	18	14.5	21
M27	× 3	TC422866	36	160	20	16	24
M30	× 3.5	TC422946	40	180	22	18	26.5

▶ DIN 371(M2~M10) and DIN 376(M11~M30)
▶ ✳ DIN profile not ISO

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
		○												

SPIRAL POINT TAPS

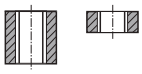
TE422 SERIES

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

▶ Recommended for tapping abrasive materials due to nitriding, not suitable for tapping tough or high strength materials.

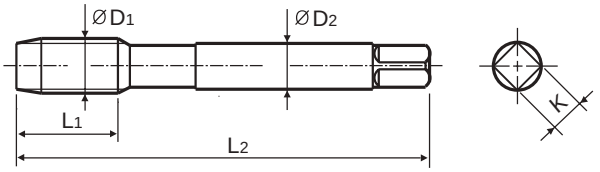
▶ Empfohlen für das Gewindeschneiden verschleißfordernder Werkstoffe wegen der Nitrierung; nicht geeignet für das Gewinden zaher oder hochfester Werkstoffe.

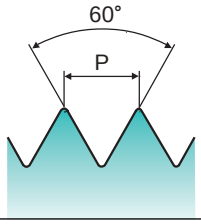
Hole type

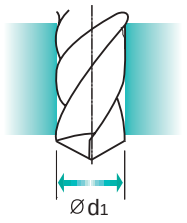


Material groups **VG** | HSS-E | DIN 371/376 | 6H | 60° | B | NI

Machine taps
Maschinengewindebohrer







Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping drill diameter Ød1
M2	0.4	TE422136	8	45	2.8	2.1	1.6
M2.2	0.45	TE422156	8	45	2.8	2.1	1.75
* M2.3	0.4	TE422196	8	45	2.8	2.1	1.9
M2.5	0.45	TE422176	9	50	2.8	2.1	2.05
* M2.6	0.45	TE422496	9	50	2.8	2.1	2.1
M3	0.5	TE422206	11	56	3.5	2.7	2.5
M3.5	0.6	TE422226	12	56	4	3	2.9
M4	0.7	TE422246	13	63	4.5	3.4	3.3
M4.5	0.75	TE422266	14	70	6	4.9	3.7
M5	0.8	TE422286	15	70	6	4.9	4.2
M6	1	TE422316	17	80	6	4.9	5
M7	1	TE422346	17	80	7	5.5	6
M8	1.25	TE422366	20	90	8	6.2	6.8
M9	1.25	TE422396	20	90	9	7	7.8
M10	1.5	TE422426	22	100	10	8	8.5
M11	1.5	TE422466	22	100	8	6.2	9.5
M12	1.75	TE422506	24	110	9	7	10.2
M14	2	TE422546	26	110	11	9	12
M16	2	TE422606	27	110	12	9	14
M18	2.5	TE422656	30	125	14	11	15.5
M20	2.5	TE422706	32	140	16	12	17.5
M22	2.5	TE422746	32	140	18	14.5	19.5
M24	3	TE422786	34	160	18	14.5	21
M27	3	TE422866	36	160	20	16	24
M30	3.5	TE422946	40	180	22	18	26.5

▶ DIN 371(M2~M10) and DIN 376(M11~M30)
▶ * DIN profile not ISO

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
		○												

SPIRAL POINT TAPS

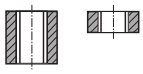
TD422 SERIES

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

▶ Suitable for through hole in more cutting speed than other taps due to thick web.

▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

Hole type

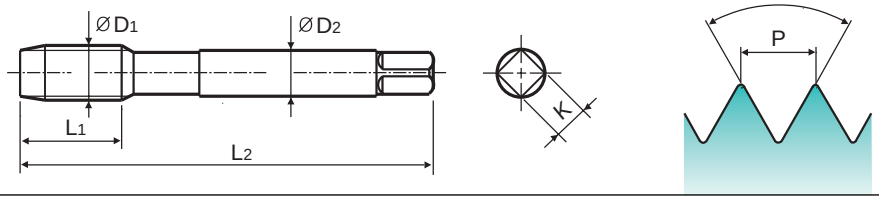


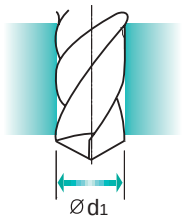
DIN 371

DIN 376

Material groups **VG** | HSS-E | DIN 371/376 | 6H | 60° | B | TiN

Machine taps
Maschinengewindebohrer





Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping drill diameter
ØD1	P		L1	L2	ØD2	K	Ød1
M2	× 0.4	TD422136	8	45	2.8	2.1	1.6
M2.2	× 0.45	TD422156	8	45	2.8	2.1	1.75
✳ M2.3	× 0.4	TD422196	8	45	2.8	2.1	1.9
M2.5	× 0.45	TD422176	9	50	2.8	2.1	2.05
✳ M2.6	× 0.45	TD422496	9	50	2.8	2.1	2.1
M3	× 0.5	TD422206	11	56	3.5	2.7	2.5
M3.5	× 0.6	TD422226	12	56	4	3	2.9
M4	× 0.7	TD422246	13	63	4.5	3.4	3.3
M4.5	× 0.75	TD422266	14	70	6	4.9	3.7
M5	× 0.8	TD422286	15	70	6	4.9	4.2
M6	× 1	TD422316	17	80	6	4.9	5
M7	× 1	TD422346	17	80	7	5.5	6
M8	× 1.25	TD422366	20	90	8	6.2	6.8
M9	× 1.25	TD422396	20	90	9	7	7.8
M10	× 1.5	TD422426	22	100	10	8	8.5
M11	× 1.5	TD422466	22	100	8	6.2	9.5
M12	× 1.75	TD422506	24	110	9	7	10.2
M14	× 2	TD422546	26	110	11	9	12
M16	× 2	TD422606	27	110	12	9	14
M18	× 2.5	TD422656	30	125	14	11	15.5
M20	× 2.5	TD422706	32	140	16	12	17.5
M22	× 2.5	TD422746	32	140	18	14.5	19.5
M24	× 3	TD422786	34	160	18	14.5	21
M27	× 3	TD422866	36	160	20	16	24
M30	× 3.5	TD422946	40	180	22	18	26.5

▶ DIN 371(M2~M10) and DIN 376(M11~M30)
▶ ✳ DIN profile not ISO

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
		○												

SPIRAL POINT TAPS

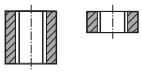
TY422 SERIES

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

▶ Suitable for through hole in more cutting speed than other taps due to thick web.

▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

Hole type

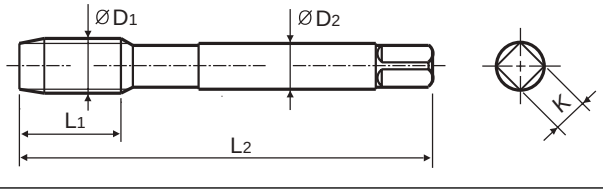


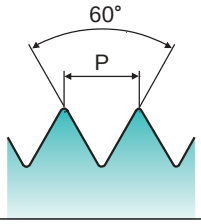
DIN 371

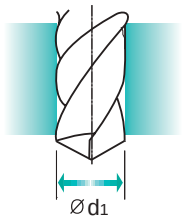
DIN 376

Material groups **VG** | HSS-E | DIN 371/376 | 6H | 60° | B | TiAlN

Machine taps
Maschinengewindebohrer







Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping drill diameter Ød1
M2	0.4	TY422136	8	45	2.8	2.1	1.6
M2.2	0.45	TY422156	8	45	2.8	2.1	1.75
＊ M2.3	0.4	TY422196	8	45	2.8	2.1	1.9
M2.5	0.45	TY422176	9	50	2.8	2.1	2.05
＊ M2.6	0.45	TY422496	9	50	2.8	2.1	2.1
M3	0.5	TY422206	11	56	3.5	2.7	2.5
M3.5	0.6	TY422226	12	56	4	3	2.9
M4	0.7	TY422246	13	63	4.5	3.4	3.3
M4.5	0.75	TY422266	14	70	6	4.9	3.7
M5	0.8	TY422286	15	70	6	4.9	4.2
M6	1	TY422316	17	80	6	4.9	5
M7	1	TY422346	17	80	7	5.5	6
M8	1.25	TY422366	20	90	8	6.2	6.8
M9	1.25	TY422396	20	90	9	7	7.8
M10	1.5	TY422426	22	100	10	8	8.5
M11	1.5	TY422466	22	100	8	6.2	9.5
M12	1.75	TY422506	24	110	9	7	10.2
M14	2	TY422546	26	110	11	9	12
M16	2	TY422606	27	110	12	9	14
M18	2.5	TY422656	30	125	14	11	15.5
M20	2.5	TY422706	32	140	16	12	17.5
M22	2.5	TY422746	32	140	18	14.5	19.5
M24	3	TY422786	34	160	18	14.5	21
M27	3	TY422866	36	160	20	16	24
M30	3.5	TY422946	40	180	22	18	26.5

▶ DIN 371(M2~M10) and DIN 376(M11~M30)
▶ ＊ DIN profile not ISO

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
		○												

SPIRAL POINT TAPS

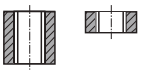
TQ853 SERIES

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

▶ Suitable for through hole in more cutting speed than other taps due to thick web and the best substrate.

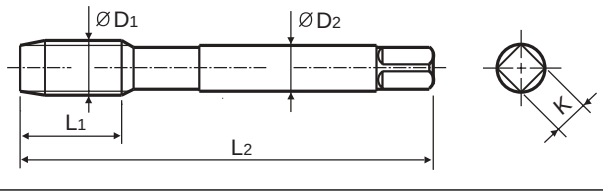
▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke und bestem Werkstoff.

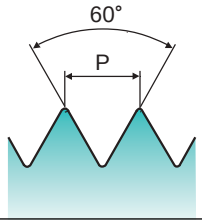
Hole type

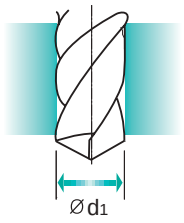


Material groups **VA** | HSS-PM | DIN 371/376 | 6H | 60° | B | Vap

Machine taps
Maschinengewindebohrer







Unit : mm

SIZE ØD1	×	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping drill diameter Ød1
M2	×	0.4	TQ853136	8	45	2.8	2.1	1.6
M2.2	×	0.45	TQ853156	8	45	2.8	2.1	1.75
M2.5	×	0.45	TQ853176	9	50	2.8	2.1	2.05
M3	×	0.5	TQ853206	11	56	3.5	2.7	2.5
M3.5	×	0.6	TQ853226	12	56	4	3	2.9
M4	×	0.7	TQ853246	13	63	4.5	3.4	3.3
M4.5	×	0.75	TQ853266	14	70	6	4.9	3.7
M5	×	0.8	TQ853286	15	70	6	4.9	4.2
M6	×	1	TQ853316	17	80	6	4.9	5
M7	×	1	TQ853346	17	80	7	5.5	6
M8	×	1.25	TQ853366	20	90	8	6.2	6.8
M10	×	1.5	TQ853426	22	100	10	8	8.5
M12	×	1.75	TQ853506	24	110	9	7	10.2

▶ DIN 371(M2~M10) and DIN 376(M12)

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
		○												

SPIRAL POINT TAPS

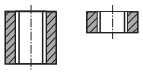
TR853 SERIES

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

▶ Suitable for through hole in more cutting speed than other taps due to thick web and the best substrate.

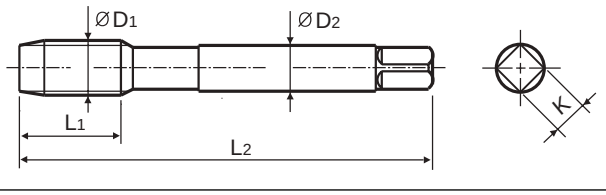
▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke und bestem Werkstoff.

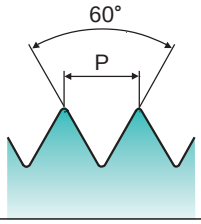
Hole type

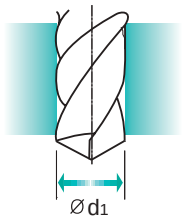


Material groups **VA** | HSS-PM | DIN 371/376 | 6H | 60° | B | Bright

Machine taps
Maschinengewindebohrer







Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping drill diameter Ød1
M2	0.4	TR853136	8	45	2.8	2.1	1.6
M2.2	0.45	TR853156	8	45	2.8	2.1	1.75
M2.5	0.45	TR853176	9	50	2.8	2.1	2.05
M3	0.5	TR853206	11	56	3.5	2.7	2.5
M3.5	0.6	TR853226	12	56	4	3	2.9
M4	0.7	TR853246	13	63	4.5	3.4	3.3
M4.5	0.75	TR853266	14	70	6	4.9	3.7
M5	0.8	TR853286	15	70	6	4.9	4.2
M6	1	TR853316	17	80	6	4.9	5
M7	1	TR853346	17	80	7	5.5	6
M8	1.25	TR853366	20	90	8	6.2	6.8
M10	1.5	TR853426	22	100	10	8	8.5
M12	1.75	TR853506	24	110	9	7	10.2

▶ DIN 371(M2~M10) and DIN 376(M12)

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
		○												

SPIRAL POINT TAPS

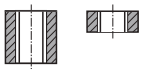
TC283 SERIES

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

▶ Suitable for through hole in more cutting speed than other taps due to thick web.

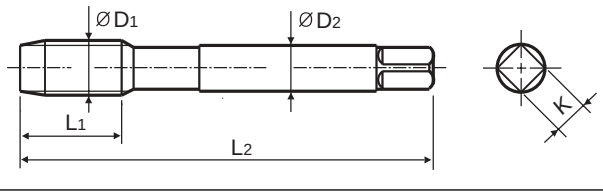
▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

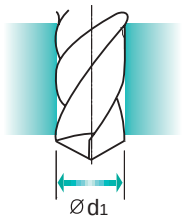
Hole type



Material groups **HR** | HSS-E | DIN 371/376 | 6H | 60° | B | Bright

Machine taps
Maschinengewindebohrer





Unit : mm

SIZE ØD1		Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping drill diameter Ød1
M2	×	0.4	TC283136	8	45	2.8	2.1	1.6
M2.2	×	0.45	TC283156	8	45	2.8	2.1	1.75
✳ M2.3	×	0.4	TC283196	8	45	2.8	2.1	1.9
M2.5	×	0.45	TC283176	9	50	2.8	2.1	2.05
✳ M2.6	×	0.45	TC283496	9	50	2.8	2.1	2.1
M3	×	0.5	TC283206	11	56	3.5	2.7	2.5
M3.5	×	0.6	TC283226	12	56	4	3	2.9
M4	×	0.7	TC283246	13	63	4.5	3.4	3.3
M4.5	×	0.75	TC283266	14	70	6	4.9	3.7
M5	×	0.8	TC283286	15	70	6	4.9	4.2
M6	×	1	TC283316	17	80	6	4.9	5
M7	×	1	TC283346	17	80	7	5.5	6
M8	×	1.25	TC283366	20	90	8	6.2	6.8
M9	×	1.25	TC283396	20	90	9	7	7.8
M10	×	1.5	TC283426	22	100	10	8	8.5
M11	×	1.5	TC283466	22	100	8	6.2	9.5
M12	×	1.75	TC283506	24	110	9	7	10.2
M14	×	2	TC283546	26	110	11	9	12
M16	×	2	TC283606	27	110	12	9	14
M18	×	2.5	TC283656	30	125	14	11	15.5
M20	×	2.5	TC283706	32	140	16	12	17.5
M22	×	2.5	TC283746	32	140	18	14.5	19.5
M24	×	3	TC283786	34	160	18	14.5	21
M27	×	3	TC283866	36	160	20	16	24
M30	×	3.5	TC283946	40	180	22	18	26.5

▶ DIN 371(M2~M10) and DIN 376(M11~M30)
▶ ✳ DIN profile not ISO

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
					○		◎						○	○

SPIRAL POINT TAPS

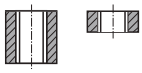
TY283 SERIES

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

▶ Suitable for through hole in more cutting speed than other taps due to thick web.

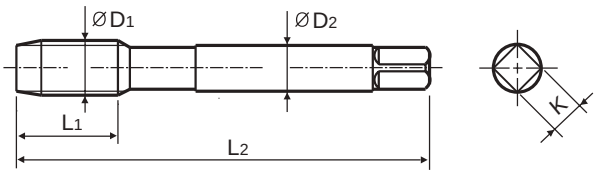
▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

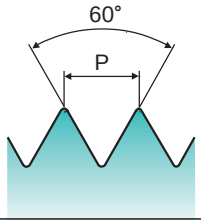
Hole type

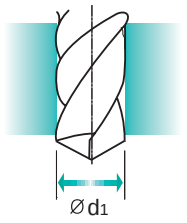


Material groups **HR** | HSS-E | DIN 371/376 | 6H | 60° | B | TiAlN

Machine taps
Maschinengewindebohrer







Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping drill diameter Ød1
M2	0.4	TY283136	8	45	2.8	2.1	1.6
M2.2	0.45	TY283156	8	45	2.8	2.1	1.75
＊ M2.3	0.4	TY283196	8	45	2.8	2.1	1.9
M2.5	0.45	TY283176	9	50	2.8	2.1	2.05
＊ M2.6	0.45	TY283496	9	50	2.8	2.1	2.1
M3	0.5	TY283206	11	56	3.5	2.7	2.5
M3.5	0.6	TY283226	12	56	4	3	2.9
M4	0.7	TY283246	13	63	4.5	3.4	3.3
M4.5	0.75	TY283266	14	70	6	4.9	3.7
M5	0.8	TY283286	15	70	6	4.9	4.2
M6	1	TY283316	17	80	6	4.9	5
M7	1	TY283346	17	80	7	5.5	6
M8	1.25	TY283366	20	90	8	6.2	6.8
M9	1.25	TY283396	20	90	9	7	7.8
M10	1.5	TY283426	22	100	10	8	8.5
M11	1.5	TY283466	22	100	8	6.2	9.5
M12	1.75	TY283506	24	110	9	7	10.2
M14	2	TY283546	26	110	11	9	12
M16	2	TY283606	27	110	12	9	14
M18	2.5	TY283656	30	125	14	11	15.5
M20	2.5	TY283706	32	140	16	12	17.5
M22	2.5	TY283746	32	140	18	14.5	19.5
M24	3	TY283786	34	160	18	14.5	21
M27	3	TY283866	36	160	20	16	24
M30	3.5	TY283946	40	180	22	18	26.5

▶ DIN 371(M2~M10) and DIN 376(M11~M30)
▶ ＊ DIN profile not ISO

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
					○		◎						○	○

SPIRAL POINT TAPS

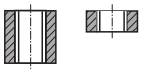
TB623 SERIES

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

▶ Suitable for through hole in more cutting speed than other taps due to thick web.

▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

Hole type

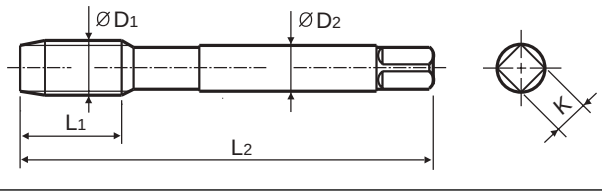


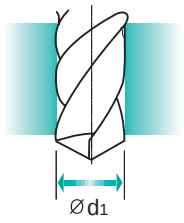
DIN 371

DIN 376

Material groups VA NW | HSS-E | DIN 371/376 | 6HX | 60° | B | Vap

Machine taps
Maschinengewindebohrer





Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping drill diameter
ØD1	P		L1	L2	ØD2	K	Ød1
M2	× 0.4	TB623136	8	45	2.8	2.1	1.6
M2.2	× 0.45	TB623156	8	45	2.8	2.1	1.75
✳ M2.3	× 0.4	TB623196	8	45	2.8	2.1	1.9
M2.5	× 0.45	TB623176	9	50	2.8	2.1	2.05
✳ M2.6	× 0.45	TB623496	9	50	2.8	2.1	2.1
M3	× 0.5	TB623206	11	56	3.5	2.7	2.5
M3.5	× 0.6	TB623226	12	56	4	3	2.9
M4	× 0.7	TB623246	13	63	4.5	3.4	3.3
M4.5	× 0.75	TB623266	14	70	6	4.9	3.7
M5	× 0.8	TB623286	15	70	6	4.9	4.2
M6	× 1	TB623316	17	80	6	4.9	5
M7	× 1	TB623346	17	80	7	5.5	6
M8	× 1.25	TB623366	20	90	8	6.2	6.8
M9	× 1.25	TB623396	20	90	9	7	7.8
M10	× 1.5	TB623426	22	100	10	8	8.5
M11	× 1.5	TB623466	22	100	8	6.2	9.5
M12	× 1.75	TB623506	24	110	9	7	10.2
M14	× 2	TB623546	26	110	11	9	12
M16	× 2	TB623606	27	110	12	9	14
M18	× 2.5	TB623656	30	125	14	11	15.5
M20	× 2.5	TB623706	32	140	16	12	17.5
M22	× 2.5	TB623746	32	140	18	14.5	19.5
M24	× 3	TB623786	34	160	18	14.5	21
M27	× 3	TB623866	36	160	20	16	24
M30	× 3.5	TB623946	40	180	22	18	26.5

▶ DIN 371(M2~M10) and DIN 376(M11~M30)

▶ ✳ DIN profile not ISO

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
		○												

SPIRAL POINT TAPS

TCH23 SERIES

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

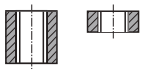
▶ Suitable for through hole in more cutting speed than other taps due to thick web.

▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.


DIN 371

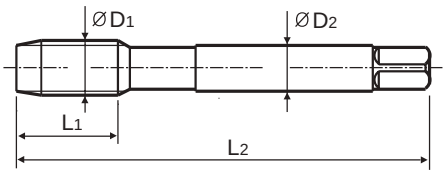

DIN 376

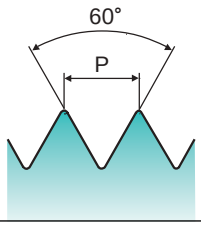
Hole type

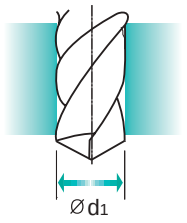


Material groups: VA NW | HSS-E | DIN 371/376 | 6HX | 60° | B | Hardslick

Machine taps
Maschinengewindebohrer







Unit : mm

SIZE ØD1	×	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping drill diameter Ød1
M2	×	0.4	TCH23136	8	45	2.8	2.1	1.6
M2.2	×	0.45	TCH23156	8	45	2.8	2.1	1.75
* M2.3	×	0.4	TCH23196	8	45	2.8	2.1	1.9
M2.5	×	0.45	TCH23176	9	50	2.8	2.1	2.05
* M2.6	×	0.45	TCH23496	9	50	2.8	2.1	2.1
M3	×	0.5	TCH23206	11	56	3.5	2.7	2.5
M3.5	×	0.6	TCH23226	12	56	4	3	2.9
M4	×	0.7	TCH23246	13	63	4.5	3.4	3.3
M4.5	×	0.75	TCH23266	14	70	6	4.9	3.7
M5	×	0.8	TCH23286	15	70	6	4.9	4.2
M6	×	1	TCH23316	17	80	6	4.9	5
M7	×	1	TCH23346	17	80	7	5.5	6
M8	×	1.25	TCH23366	20	90	8	6.2	6.8
M9	×	1.25	TCH23396	20	90	9	7	7.8
M10	×	1.5	TCH23426	22	100	10	8	8.5
M11	×	1.5	TCH23466	22	100	8	6.2	9.5
M12	×	1.75	TCH23506	24	110	9	7	10.2
M14	×	2	TCH23546	26	110	11	9	12
M16	×	2	TCH23606	27	110	12	9	14
M18	×	2.5	TCH23656	30	125	14	11	15.5
M20	×	2.5	TCH23706	32	140	16	12	17.5
M22	×	2.5	TCH23746	32	140	18	14.5	19.5
M24	×	3	TCH23786	34	160	18	14.5	21
M27	×	3	TCH23866	36	160	20	16	24
M30	×	3.5	TCH23946	40	180	22	18	26.5

▶ DIN 371(M2~M10) and DIN 376(M11~M30)
▶ * DIN profile not ISO

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
		○												

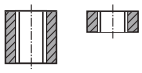
SPIRAL POINT TAPS

TM293 SERIES

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

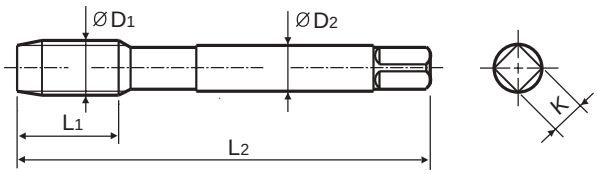
▶ Interrupted tap to reduce contact area and tapping torque, and to give more chip space.

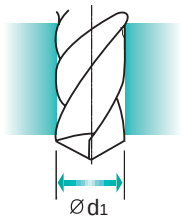
▶ Gewindebohrer mit ausgesetzten Zahnen um die Kontaktzone mit dem Werkstuck und das Drehmoment zu minimieren und dem Span mehr Raum zu geben.

Hole type 

Material groups **Ti** | HSS-PM | DIN 371/376 | 6H | 60° | B | Bright

Macnhine taps
Maschinengewindebohrer





Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping drill diameter Ød1
M2	0.4	TM293136	8	45	2.8	2.1	1.6
M2.2	0.45	TM293156	8	45	2.8	2.1	1.75
✳ M2.3	0.4	TM293196	8	45	2.8	2.1	1.9
M2.5	0.45	TM293176	9	50	2.8	2.1	2.05
✳ M2.6	0.45	TM293496	9	50	2.8	2.1	2.1
M3	0.5	TM293206	11	56	3.5	2.7	2.5
M3.5	0.6	TM293226	12	56	4	3	2.9
M4	0.7	TM293246	13	63	4.5	3.4	3.3
M4.5	0.75	TM293266	14	70	6	4.9	3.7
M5	0.8	TM293286	15	70	6	4.9	4.2
M6	1	TM293316	17	80	6	4.9	5
M7	1	TM293346	17	80	7	5.5	6
M8	1.25	TM293366	20	90	8	6.2	6.8
M9	1.25	TM293396	20	90	9	7	7.8
M10	1.5	TM293426	22	100	10	8	8.5
M11	1.5	TM293466	22	100	8	6.2	9.5
M12	1.75	TM293506	24	110	9	7	10.2
M14	2	TM293546	26	110	11	9	12
M16	2	TM293606	27	110	12	9	14
M18	2.5	TM293656	30	125	14	11	15.5
M20	2.5	TM293706	32	140	16	12	17.5
M22	2.5	TM293746	32	140	18	14.5	19.5
M24	3	TM293786	34	160	18	14.5	21
M27	3	TM293866	36	160	20	16	24
M30	3.5	TM293946	40	180	22	18	26.5

▶ DIN 371(M2~M10) and DIN 376(M11~M30)
▶ ✳ DIN profile not ISO

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
◎														

SPIRAL POINT TAPS

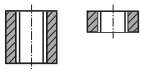
TZ293 SERIES

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

▶ Interrupted tap to reduce contact area and tapping torque, and to give more chip space.

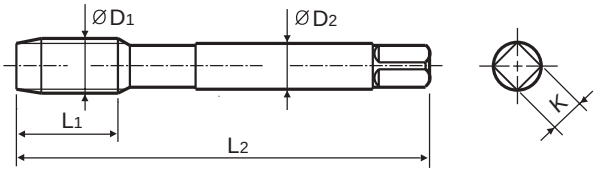
▶ Gewindebohrer mit ausgesetzten Zahnen um die Kontaktzone mit dem Werkstuck und das Drehmoment zu minimieren und dem Span mehr Raum zu geben.

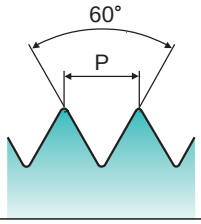
Hole type

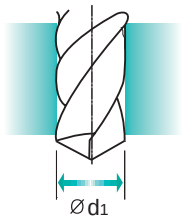


Material groups **Ti** | HSS-PM | DIN 371/376 | 6H | 60° | B | TiAlN

Machine taps
Maschinengewindebohrer







Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping drill diameter Ød1
M2	0.4	TZ293136	8	45	2.8	2.1	1.6
M2.2	0.45	TZ293156	8	45	2.8	2.1	1.75
＊ M2.3	0.4	TZ293196	8	45	2.8	2.1	1.9
M2.5	0.45	TZ293176	9	50	2.8	2.1	2.05
＊ M2.6	0.45	TZ293496	9	50	2.8	2.1	2.1
M3	0.5	TZ293206	11	56	3.5	2.7	2.5
M3.5	0.6	TZ293226	12	56	4	3	2.9
M4	0.7	TZ293246	13	63	4.5	3.4	3.3
M4.5	0.75	TZ293266	14	70	6	4.9	3.7
M5	0.8	TZ293286	15	70	6	4.9	4.2
M6	1	TZ293316	17	80	6	4.9	5
M7	1	TZ293346	17	80	7	5.5	6
M8	1.25	TZ293366	20	90	8	6.2	6.8
M9	1.25	TZ293396	20	90	9	7	7.8
M10	1.5	TZ293426	22	100	10	8	8.5
M11	1.5	TZ293466	22	100	8	6.2	9.5
M12	1.75	TZ293506	24	110	9	7	10.2
M14	2	TZ293546	26	110	11	9	12
M16	2	TZ293606	27	110	12	9	14
M18	2.5	TZ293656	30	125	14	11	15.5
M20	2.5	TZ293706	32	140	16	12	17.5
M22	2.5	TZ293746	32	140	18	14.5	19.5
M24	3	TZ293786	34	160	18	14.5	21
M27	3	TZ293866	36	160	20	16	24
M30	3.5	TZ293946	40	180	22	18	26.5

▶ DIN 371(M2~M10) and DIN 376(M11~M30)
▶ ＊ DIN profile not ISO

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
◎														

SPIRAL POINT TAPS

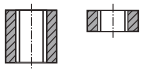
TQ873 SERIES

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

▶ Suitable for through hole in more cutting speed than other taps due to thick web and the best substrate.

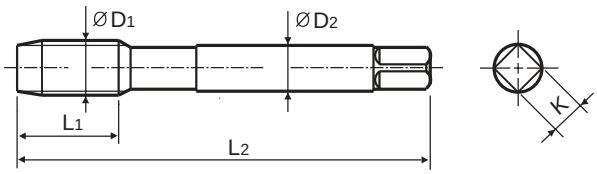
▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke und bestem Werkstoff.

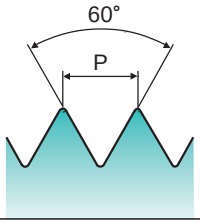
Hole type

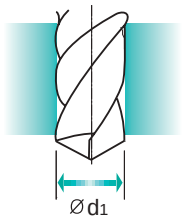


Material groups: Ti Ni | HSS-PM | DIN 371/376 | 6H | 60° | B | Vap

Machine taps
Maschinengewindebohrer







Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping drill diameter Ød1
M2	0.4	TQ873136	8	45	2.8	2.1	1.6
M2.2	0.45	TQ873156	8	45	2.8	2.1	1.75
M2.5	0.45	TQ873176	9	50	2.8	2.1	2.05
M3	0.5	TQ873206	11	56	3.5	2.7	2.5
M3.5	0.6	TQ873226	12	56	4	3	2.9
M4	0.7	TQ873246	13	63	4.5	3.4	3.3
M4.5	0.75	TQ873266	14	70	6	4.9	3.7
M5	0.8	TQ873286	15	70	6	4.9	4.2
M6	1	TQ873316	17	80	6	4.9	5
M7	1	TQ873346	17	80	7	5.5	6
M8	1.25	TQ873366	20	90	8	6.2	6.8
M10	1.5	TQ873426	22	100	10	8	8.5
M12	1.75	TQ873506	24	110	9	7	10.2

▶ DIN 371(M2~M10) and DIN 376(M12)

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
◎		◎	◎				○							

SPIRAL POINT TAPS

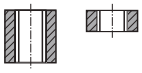
TR873 SERIES

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

▶ Suitable for through hole in more cutting speed than other taps due to thick web and the best substrate.

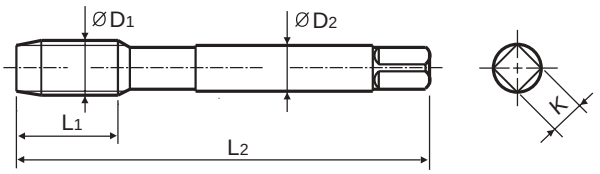
▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke und bestem Werkstoff.

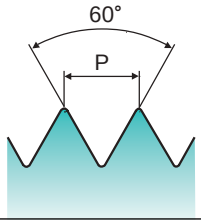
Hole type

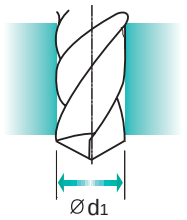


Material groups: **Ti Ni** | HSS-PM | DIN 371/376 | 6H | 60° | B | Bright

Machine taps
Maschinengewindebohrer







Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping drill diameter Ød1
M2	0.4	TR873136	8	45	2.8	2.1	1.6
M2.2	0.45	TR873156	8	45	2.8	2.1	1.75
M2.5	0.45	TR873176	9	50	2.8	2.1	2.05
M3	0.5	TR873206	11	56	3.5	2.7	2.5
M3.5	0.6	TR873226	12	56	4	3	2.9
M4	0.7	TR873246	13	63	4.5	3.4	3.3
M4.5	0.75	TR873266	14	70	6	4.9	3.7
M5	0.8	TR873286	15	70	6	4.9	4.2
M6	1	TR873316	17	80	6	4.9	5
M7	1	TR873346	17	80	7	5.5	6
M8	1.25	TR873366	20	90	8	6.2	6.8
M10	1.5	TR873426	22	100	10	8	8.5
M12	1.75	TR873506	24	110	9	7	10.2

▶ DIN 371(M2~M10) and DIN 376(M12)

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
◎		◎	◎				○							

SPIRAL POINT TAPS

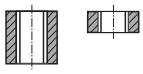
TM923 SERIES

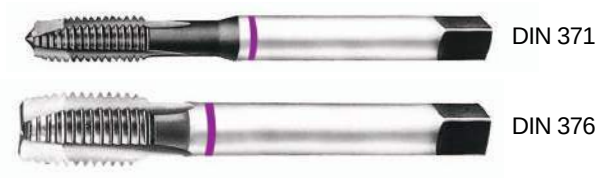
M ISO metric coarse threads DIN 13
Metrisches ISO-Gewinde DIN 13

▶ For tapping Nickel alloys and heat resistant alloy steels which are used in aero space and checmical industries.

▶ Zum Gewindeschneiden von Nickellegierungen und hitzefesten Legierungsstählen, die in der Luftfahrtindustrie und chemischen Industrie verwendet werden.

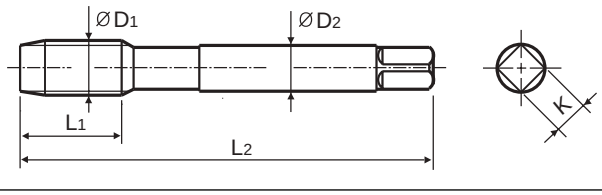
Hole type

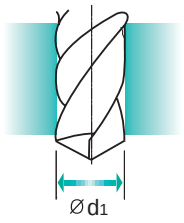




Material groups **Ni** | HSS-PM | DIN 371/376 | 6H | 60° | B | Bright

Machine taps
Maschinengewindebohrer





Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping drill diameter Ød1
M2	0.4	TM923136	8	45	2.8	2.1	1.6
M2.2	0.45	TM923156	8	45	2.8	2.1	1.75
✳ M2.3	0.4	TM923196	8	45	2.8	2.1	1.9
M2.5	0.45	TM923176	9	50	2.8	2.1	2.05
✳ M2.6	0.45	TM923496	9	50	2.8	2.1	2.1
M3	0.5	TM923206	11	56	3.5	2.7	2.5
M3.5	0.6	TM923226	12	56	4	3	2.9
M4	0.7	TM923246	13	63	4.5	3.4	3.3
M4.5	0.75	TM923266	14	70	6	4.9	3.7
M5	0.8	TM923286	15	70	6	4.9	4.2
M6	1	TM923316	17	80	6	4.9	5
M7	1	TM923346	17	80	7	5.5	6
M8	1.25	TM923366	20	90	8	6.2	6.8
M9	1.25	TM923396	20	90	9	7	7.8
M10	1.5	TM923426	22	100	10	8	8.5
M11	1.5	TM923466	22	100	8	6.2	9.5
M12	1.75	TM923506	24	110	9	7	10.2
M14	2	TM923546	26	110	11	9	12
M16	2	TM923606	27	110	12	9	14
M18	2.5	TM923656	30	125	14	11	15.5
M20	2.5	TM923706	32	140	16	12	17.5
M22	2.5	TM923746	32	140	18	14.5	19.5
M24	3	TM923786	34	160	18	14.5	21
M27	3	TM923866	36	160	20	16	24
M30	3.5	TM923946	40	180	22	18	26.5

▶ DIN 371(M2~M10) and DIN 376(M11~M30)
▶ ✳ DIN profile not ISO

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
○		◎	◎				○							

SPIRAL POINT TAPS

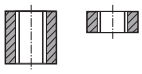
TZ923 SERIES

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

▶ For tapping Nickel alloys and heat resistant alloy steels which are used in aero space and checmical industries.

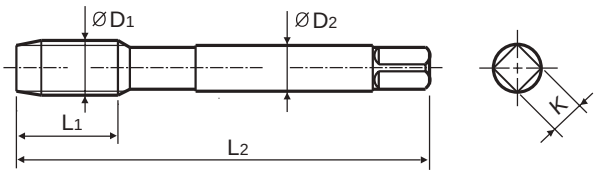
▶ Zum Gewindeschneiden von Nickellegierungen und hitzefesten Legierungsstählen, die in der Luftfahrtindustrie und chemischen Industrie verwendet werden.

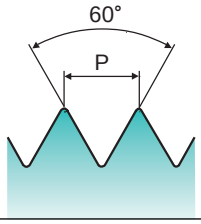
Hole type

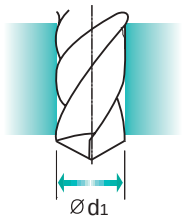


Material groups **Ni** | HSS-PM | DIN 371/376 | 6H | 60° | B | TiAlN

Machine taps
Maschinengewindebohrer







Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping drill diameter Ød1
M2	0.4	TZ923136	8	45	2.8	2.1	1.6
M2.2	0.45	TZ923156	8	45	2.8	2.1	1.75
* M2.3	0.4	TZ923196	8	45	2.8	2.1	1.9
M2.5	0.45	TZ923176	9	50	2.8	2.1	2.05
* M2.6	0.45	TZ923496	9	50	2.8	2.1	2.1
M3	0.5	TZ923206	11	56	3.5	2.7	2.5
M3.5	0.6	TZ923226	12	56	4	3	2.9
M4	0.7	TZ923246	13	63	4.5	3.4	3.3
M4.5	0.75	TZ923266	14	70	6	4.9	3.7
M5	0.8	TZ923286	15	70	6	4.9	4.2
M6	1	TZ923316	17	80	6	4.9	5
M7	1	TZ923346	17	80	7	5.5	6
M8	1.25	TZ923366	20	90	8	6.2	6.8
M9	1.25	TZ923396	20	90	9	7	7.8
M10	1.5	TZ923426	22	100	10	8	8.5
M11	1.5	TZ923466	22	100	8	6.2	9.5
M12	1.75	TZ923506	24	110	9	7	10.2
M14	2	TZ923546	26	110	11	9	12
M16	2	TZ923606	27	110	12	9	14
M18	2.5	TZ923656	30	125	14	11	15.5
M20	2.5	TZ923706	32	140	16	12	17.5
M22	2.5	TZ923746	32	140	18	14.5	19.5
M24	3	TZ923786	34	160	18	14.5	21
M27	3	TZ923866	36	160	20	16	24
M30	3.5	TZ923946	40	180	22	18	26.5

▶ DIN 371(M2~M10) and DIN 376(M11~M30)
▶ * DIN profile not ISO

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
○		◎	◎				○							

SPIRAL POINT TAPS

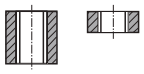
TE943 SERIES

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

▶ Suitable for through hole in more cutting speed than other taps due to thick web.

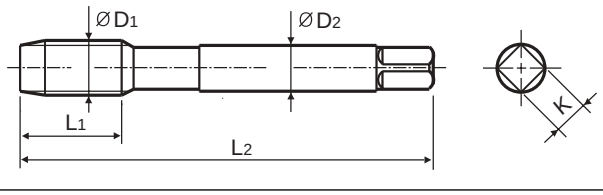
▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

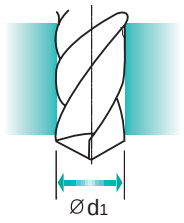
Hole type



Material groups **Al** | HSS-E | DIN 371/376 | 6H | 60° | B | NI

Machine taps
Maschinengewindebohrer





Unit : mm

	SIZE		Pitch	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping drill diameter
	ØD1		P		L1	L2	ØD2	K	Ød1
	M2	×	0.4	TE943136	8	45	2.8	2.1	1.6
	M2.2	×	0.45	TE943156	8	45	2.8	2.1	1.75
✳	M2.3	×	0.4	TE943196	8	45	2.8	2.1	1.9
	M2.5	×	0.45	TE943176	9	50	2.8	2.1	2.05
✳	M2.6	×	0.45	TE943496	9	50	2.8	2.1	2.1
	M3	×	0.5	TE943206	11	56	3.5	2.7	2.5
	M3.5	×	0.6	TE943226	12	56	4	3	2.9
	M4	×	0.7	TE943246	13	63	4.5	3.4	3.3
	M4.5	×	0.75	TE943266	14	70	6	4.9	3.7
	M5	×	0.8	TE943286	15	70	6	4.9	4.2
	M6	×	1	TE943316	17	80	6	4.9	5
	M7	×	1	TE943346	17	80	7	5.5	6
	M8	×	1.25	TE943366	20	90	8	6.2	6.8
	M9	×	1.25	TE943396	20	90	9	7	7.8
	M10	×	1.5	TE943426	22	100	10	8	8.5
	M11	×	1.5	TE943466	22	100	8	6.2	9.5
	M12	×	1.75	TE943506	24	110	9	7	10.2
	M14	×	2	TE943546	26	110	11	9	12
	M16	×	2	TE943606	27	110	12	9	14
	M18	×	2.5	TE943656	30	125	14	11	15.5
	M20	×	2.5	TE943706	32	140	16	12	17.5
	M22	×	2.5	TE943746	32	140	18	14.5	19.5
	M24	×	3	TE943786	34	160	18	14.5	21
	M27	×	3	TE943866	36	160	20	16	24
	M30	×	3.5	TE943946	40	180	22	18	26.5

▶ DIN 371(M2~M10) and DIN 376(M11~M30)
▶ ✳ DIN profile not ISO

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
											◎			

SPIRAL POINT TAPS

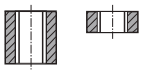
TC622 SERIES

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

▶ Interrupted tap to reduce contact area and tapping torque, and to give more chip space.

▶ Gewindebohrer mit ausgesetzten Zahnen um die Kontaktzone mit dem Werkstuck und das Drehmoment zu minimieren und dem Span mehr Raum zu geben.

Hole type

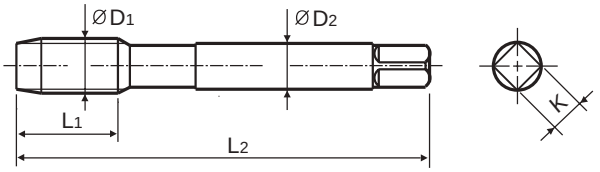


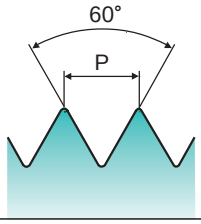
DIN 371

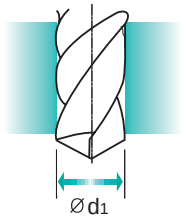
DIN 376

Material groups **Al** | HSS-E | DIN 371/376 | 6H | 60° | B | Bright

Machine taps
Maschinengewindebohrer







Unit : mm

SIZE ØD1		Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping drill diameter Ød1
M2	×	0.4	TC622136	8	45	2.8	2.1	1.6
M2.2	×	0.45	TC622156	8	45	2.8	2.1	1.75
* M2.3	×	0.4	TC622196	8	45	2.8	2.1	1.9
M2.5	×	0.45	TC622176	9	50	2.8	2.1	2.05
* M2.6	×	0.45	TC622496	9	50	2.8	2.1	2.1
M3	×	0.5	TC622206	11	56	3.5	2.7	2.5
M3.5	×	0.6	TC622226	12	56	4	3	2.9
M4	×	0.7	TC622246	13	63	4.5	3.4	3.3
M4.5	×	0.75	TC622266	14	70	6	4.9	3.7
M5	×	0.8	TC622286	15	70	6	4.9	4.2
M6	×	1	TC622316	17	80	6	4.9	5
M7	×	1	TC622346	17	80	7	5.5	6
M8	×	1.25	TC622366	20	90	8	6.2	6.8
M9	×	1.25	TC622396	20	90	9	7	7.8
M10	×	1.5	TC622426	22	100	10	8	8.5
M11	×	1.5	TC622466	22	100	8	6.2	9.5
M12	×	1.75	TC622506	24	110	9	7	10.2
M14	×	2	TC622546	26	110	11	9	12
M16	×	2	TC622606	27	110	12	9	14
M18	×	2.5	TC622656	30	125	14	11	15.5
M20	×	2.5	TC622706	32	140	16	12	17.5
M22	×	2.5	TC622746	32	140	18	14.5	19.5
M24	×	3	TC622786	34	160	18	14.5	21
M27	×	3	TC622866	36	160	20	16	24
M30	×	3.5	TC622946	40	180	22	18	26.5

▶ DIN 371(M2~M10) and DIN 376(M11~M30)
▶ * DIN profile not ISO

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
				◎				◎	◎	◎				

SPIRAL POINT TAPS

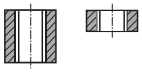
TC222 SERIES

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

▶ Suitable for through hole in more cutting speed than other taps due to thick web.

▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

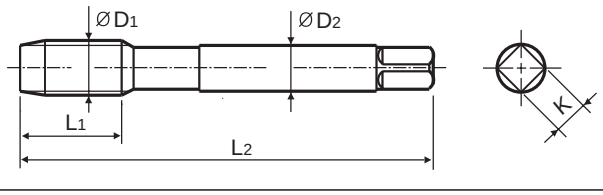
Hole type

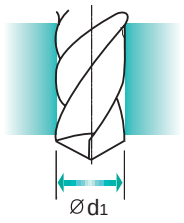


DIN 374

Material groups **GS** | HSS-E | DIN 374 | 6H | 60° | B | Bright

Machine taps
Maschinengewindebohrer





Unit : mm

SIZE		Pitch	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping drill diameter
ØD1		P		L1	L2	ØD2	K	Ød1
M4	×	0.5	TD222256	10	63	2.8	2.1	3.5
M5	×	0.5	TD222296	11	70	3.5	2.7	4.5
M6	×	0.75	TD222326	13	80	4.5	3.4	5.2
M6	×	0.5	TD222336	13	80	4.5	3.4	5.5
M7	×	0.75	TD222356	14	80	5.5	4.3	6.2
M8	×	1	TD222376	17	90	6	4.9	7
M8	×	0.75	TD222386	14	80	6	4.9	7.2
M8	×	0.5	TD222936	14	80	6	4.9	7.5
M10	×	1.25	TD222436	22	100	7	5.5	8.8
M10	×	1	TD222446	18	90	7	5.5	9
M10	×	0.75	TD222456	18	90	7	5.5	9.2
M12	×	1.5	TD222516	22	100	9	7	10.5
M12	×	1.25	TD222526	22	100	9	7	10.8
M12	×	1	TD222536	18	100	9	7	11
M14	×	1.5	TD222556	22	100	11	9	12.5
M14	×	1.25	TD222566	22	100	11	9	12.8
M14	×	1	TD222576	18	100	11	9	13

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
	○			○		◎		○	○	○	◎	○		

SPIRAL POINT TAPS

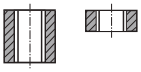
TC222 SERIES

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

▶ Suitable for through hole in more cutting speed than other taps due to thick web.

▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

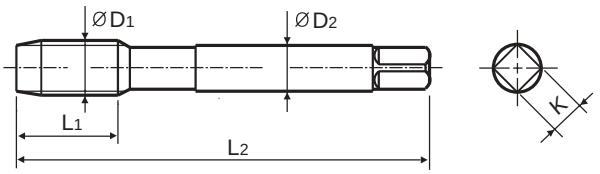
Hole type

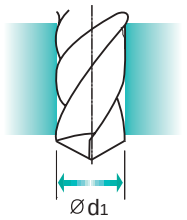


DIN 374

Material groups **GS** | HSS-E | DIN 374 | 6H | 60° | B | Bright

Machine taps
Maschinengewindebohrer





Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping drill diameter Ød1
M16	1.5	TC222616	22	100	12	9	14.5
M16	1	TC222626	18	100	12	9	15
M18	1.5	TC222676	25	110	14	11	16.5
M18	1	TC222686	20	110	14	11	17
M20	1.5	TC222726	25	125	16	12	18.5
M20	1	TC222736	20	125	16	12	19
M22	1.5	TC222766	25	125	18	14.5	20.5
M22	1	TC222776	20	125	18	14.5	21
M24	2	TC222796	27	140	18	14.5	22
M24	1.5	TC222806	27	140	18	14.5	22.5
M26	1.5	TC222856	28	140	18	14.5	24.5
M27	2	TC222876	28	140	20	16	25
M27	1.5	TC222886	28	140	20	16	25.5
M28	1.5	TC222916	28	140	20	16	26.5
M30	2	TC222966	30	150	22	18	28
M30	1.5	TC222976	30	150	22	18	28.5

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
	○			○		◎		○	○	○	◎	○		

SPIRAL POINT TAPS

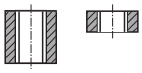
TD222 SERIES

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

▶ Suitable for through hole in more cutting speed than other taps due to thick web.

▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

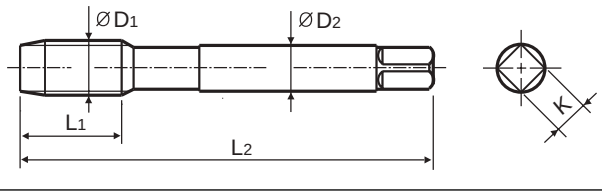
Hole type

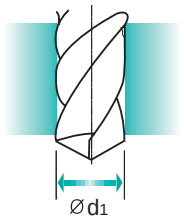


DIN 374

Material groups **GS** | HSS-E | DIN 374 | 6H | 60° | B | TiN

Machine taps
Maschinengewindebohrer





Unit : mm

SIZE ØD1		Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping drill diameter Ød1
M4	×	0.5	TD222256	10	63	2.8	2.1	3.5
M5	×	0.5	TD222296	11	70	3.5	2.7	4.5
M6	×	0.75	TD222326	13	80	4.5	3.4	5.2
M6	×	0.5	TD222336	13	80	4.5	3.4	5.5
M7	×	0.75	TD222356	14	80	5.5	4.3	6.2
M8	×	1	TD222376	17	90	6	4.9	7
M8	×	0.75	TD222386	14	80	6	4.9	7.2
M8	×	0.5	TD222936	14	80	6	4.9	7.5
M10	×	1.25	TD222436	22	100	7	5.5	8.8
M10	×	1	TD222446	18	90	7	5.5	9
M10	×	0.75	TD222456	18	90	7	5.5	9.2
M12	×	1.5	TD222516	22	100	9	7	10.5
M12	×	1.25	TD222526	22	100	9	7	10.8
M12	×	1	TD222536	18	100	9	7	11
M14	×	1.5	TD222556	22	100	11	9	12.5
M14	×	1.25	TD222566	22	100	11	9	12.8
M14	×	1	TD222576	18	100	11	9	13

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
	○			○		◎		○	○	○	◎	○		

SPIRAL POINT TAPS

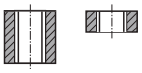
TD222 SERIES

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

▶ Suitable for through hole in more cutting speed than other taps due to thick web.

▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

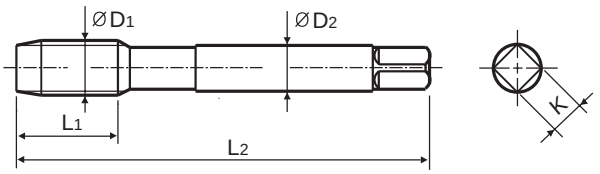
Hole type

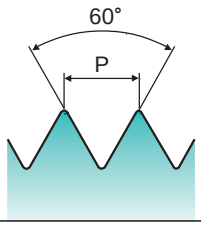


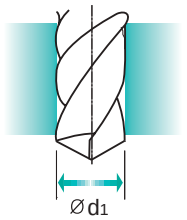
DIN 374

Material groups **GS** | HSS-E | DIN 374 | 6H | 60° | B | TiN

Machine taps
Maschinengewindebohrer







Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping drill diameter Ød1
M16	1.5	TD222616	22	100	12	9	14.5
M16	1	TD222626	18	100	12	9	15
M18	1.5	TD222676	25	110	14	11	16.5
M18	1	TD222686	20	110	14	11	17
M20	1.5	TD222726	25	125	16	12	18.5
M20	1	TD222736	20	125	16	12	19
M22	1.5	TD222766	25	125	18	14.5	20.5
M22	1	TD222776	20	125	18	14.5	21
M24	2	TD222796	27	140	18	14.5	22
M24	1.5	TD222806	27	140	18	14.5	22.5
M26	1.5	TD222856	28	140	18	14.5	24.5
M27	2	TD222876	28	140	20	16	25
M27	1.5	TD222886	28	140	20	16	25.5
M28	1.5	TD222916	28	140	20	16	26.5
M30	2	TD222966	30	150	22	18	28
M30	1.5	TD222976	30	150	22	18	28.5

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
	○			○		◎		○	○	○	◎	○		

SPIRAL POINT TAPS

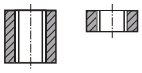
TC263 SERIES

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

▶ Suitable for through hole in more cutting speed than other taps due to thick web.

▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

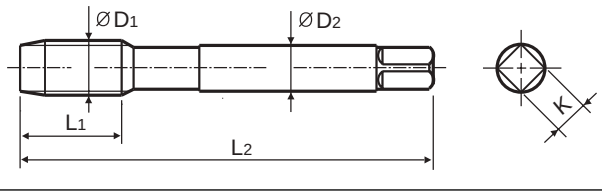
Hole type

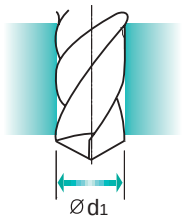


DIN 374

Material groups **VG** | HSS-E | DIN 374 | 6H | 60° | B | Bright

Machine taps
Maschinengewindebohrer





Unit : mm

SIZE ØD1		Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping drill diameter Ød1
M4	×	0.5	TC263256	10	63	2.8	2.1	3.5
M5	×	0.5	TC263296	11	70	3.5	2.7	4.5
M6	×	0.75	TC263326	13	80	4.5	3.4	5.2
M6	×	0.5	TC263336	13	80	4.5	3.4	5.5
M7	×	0.75	TC263356	14	80	5.5	4.3	6.2
M8	×	1	TC263376	17	90	6	4.9	7
M8	×	0.75	TC263386	14	80	6	4.9	7.2
M10	×	1.25	TC263436	22	100	7	5.5	8.8
M10	×	1	TC263446	18	90	7	5.5	9
M10	×	0.75	TC263456	18	90	7	5.5	9.2
M12	×	1.5	TC263516	22	100	9	7	10.5
M12	×	1.25	TC263526	22	100	9	7	10.8
M12	×	1	TC263536	18	100	9	7	11
M14	×	1.5	TC263556	22	100	11	9	12.5
M14	×	1.25	TC263566	22	100	11	9	12.8
M16	×	1.5	TC263616	22	100	12	9	14.5
M18	×	1.5	TC263676	25	110	14	11	16.5
M20	×	1.5	TC263726	25	125	16	12	18.5
M22	×	1.5	TC263766	25	125	18	14.5	20.5
M24	×	1.5	TC263806	27	140	18	14.5	22.5

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
		○												

SPIRAL POINT TAPS

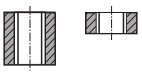
TD263 SERIES

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

▶ Suitable for through hole in more cutting speed than other taps due to thick web.

▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

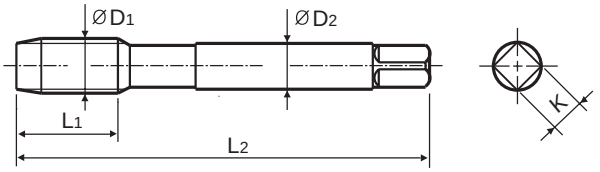
Hole type

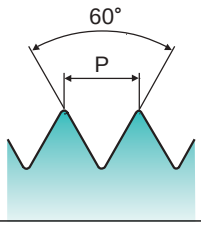


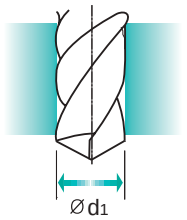
DIN 374

Material groups **VG** | HSS-E | DIN 374 | 6H | 60° | B | TiN

Machine taps
Maschinengewindebohrer







Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping drill diameter
ØD1	P		L1	L2	ØD2	K	Ød1
M4	× 0.5	TD263256	10	63	2.8	2.1	3.5
M5	× 0.5	TD263296	11	70	3.5	2.7	4.5
M6	× 0.75	TD263326	13	80	4.5	3.4	5.2
M6	× 0.5	TD263336	13	80	4.5	3.4	5.5
M7	× 0.75	TD263356	14	80	5.5	4.3	6.2
M8	× 1	TD263376	17	90	6	4.9	7
M8	× 0.75	TD263386	14	80	6	4.9	7.2
M10	× 1.25	TD263436	22	100	7	5.5	8.8
M10	× 1	TD263446	18	90	7	5.5	9
M10	× 0.75	TD263456	18	90	7	5.5	9.2
M12	× 1.5	TD263516	22	100	9	7	10.5
M12	× 1.25	TD263526	22	100	9	7	10.8
M12	× 1	TD263536	18	100	9	7	11
M14	× 1.5	TD263556	22	100	11	9	12.5
M14	× 1.25	TD263566	22	100	11	9	12.8
M16	× 1.5	TD263616	22	100	12	9	14.5
M18	× 1.5	TD263676	25	110	14	11	16.5
M20	× 1.5	TD263726	25	125	16	12	18.5
M22	× 1.5	TD263766	25	125	18	14.5	20.5
M24	× 1.5	TD263806	27	140	18	14.5	22.5

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
		○												

SPIRAL POINT TAPS

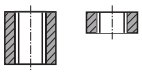
TB123 SERIES

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

▶ Suitable for through hole in more cutting speed than other taps due to thick web.

▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

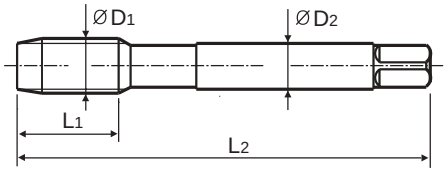
Hole type

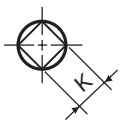


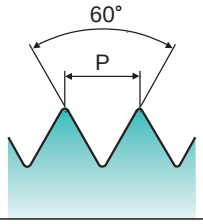
DIN 374

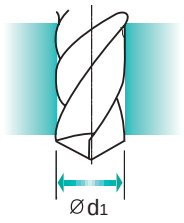
Material groups VA NW | HSS-E | DIN 374 | 6HX | 60° | B | Vap

Machine taps
Maschinengewindebohrer









Unit : mm

SIZE ØD1		Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping drill diameter Ød1
M4	×	0.5	TB123256	10	63	2.8	2.1	3.5
M5	×	0.5	TB123296	11	70	3.5	2.7	4.5
M6	×	0.75	TB123326	13	80	4.5	3.4	5.2
M6	×	0.5	TB123336	13	80	4.5	3.4	5.5
M7	×	0.75	TB123356	14	80	5.5	4.3	6.2
M8	×	1	TB123376	17	90	6	4.9	7
M8	×	0.75	TB123386	14	80	6	4.9	7.2
M10	×	1.25	TB123436	22	100	7	5.5	8.8
M10	×	1	TB123446	18	90	7	5.5	9
M10	×	0.75	TB123456	18	90	7	5.5	9.2
M12	×	1.5	TB123516	22	100	9	7	10.5
M12	×	1.25	TB123526	22	100	9	7	10.8
M12	×	1	TB123536	18	100	9	7	11
M14	×	1.5	TB123556	22	100	11	9	12.5
M14	×	1.25	TB123566	22	100	11	9	12.8
M16	×	1.5	TB123616	22	100	12	9	14.5
M18	×	1.5	TB123676	25	110	14	11	16.5
M20	×	1.5	TB123726	25	125	16	12	18.5
M22	×	1.5	TB123766	25	125	18	14.5	20.5
M24	×	1.5	TB123806	27	140	18	14.5	22.5

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
		○												

SPIRAL POINT TAPS

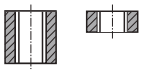
TC214 SERIES

UNC Unified coarse threads
Unified Grobgewinde

▶ Suitable for through hole in more cutting speed than other taps due to thick web.

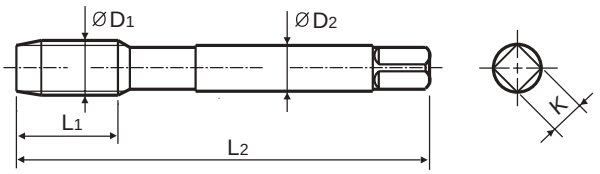
▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

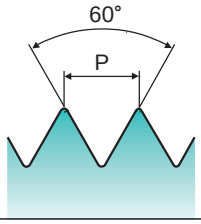
Hole type

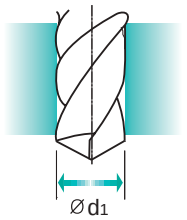


Material groups **GS** | HSS-E | DIN 371/376 | 2B | 60° | B | Bright

Machine taps
Maschinengewindebohrer







Unit : mm

SIZE ØD1	TPI	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping drill diameter Ød1
#4	– 40 UNC	TC214162	11	56	3.5	2.7	2.3
#5	– 40 UNC	TC214202	11	56	3.5	2.7	2.6
#6	– 32 UNC	TC214242	12	56	4	3	2.85
#8	– 32 UNC	TC214282	13	63	4.5	3.4	3.5
#10	– 24 UNC	TC214322	15	70	6	4.9	3.9
#12	– 24 UNC	TC214362	16	80	6	4.9	4.5
1/4"	– 20 UNC	TC214402	17	80	7	5.5	5.2
5/16"	– 18 UNC	TC214442	20	90	8	6.2	6.6
3/8"	– 16 UNC	TC214482	22	100	9	7	8
7/16"	– 14 UNC	TC214522	22	100	8	6.2	9.4
1/2"	– 13 UNC	TC214562	25	110	9	7	10.75
9/16"	– 12 UNC	TC214602	26	110	11	9	12.25
5/8"	– 11 UNC	TC214642	27	110	12	9	13.5
3/4"	– 10 UNC	TC214702	30	125	14	11	16.5
7/8"	– 9 UNC	TC214742	32	140	18	14.5	19.5
1"	– 8 UNC	TC214782	36	160	20	16	22.25
1*1/8"	– 7 UNC	TC214822	40	180	22	18	25

▶ DIN 371(#4~3/8") and DIN 376(7/16"~1*1/8")

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
	○			○		◎		○	○	○	◎	○		

SPIRAL POINT TAPS

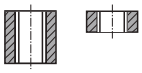
TC244 SERIES

UNC Unified coarse threads
Unified Grobgewinde

▶ Suitable for through hole in more cutting speed than other taps due to thick web.

▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

Hole type

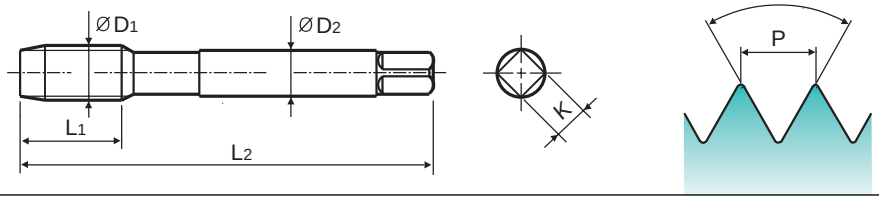


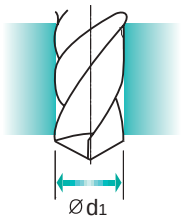
DIN 371

DIN 376

Material groups **VG** | HSS-E | DIN 371/376 | 2B | 60° | B | Bright

Machine taps
Maschinengewindebohrer





Unit : mm

SIZE	TPI	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping drill diameter
ØD1			L1	L2	ØD2	K	Ød1
#4	– 40 UNC	TC244162	11	56	3.5	2.7	2.3
#5	– 40 UNC	TC244202	11	56	3.5	2.7	2.6
#6	– 32 UNC	TC244242	12	56	4	3	2.85
#8	– 32 UNC	TC244282	13	63	4.5	3.4	3.5
#10	– 24 UNC	TC244322	15	70	6	4.9	3.9
#12	– 24 UNC	TC244362	16	80	6	4.9	4.5
1/4"	– 20 UNC	TC244402	17	80	7	5.5	5.2
5/16"	– 18 UNC	TC244442	20	90	8	6.2	6.6
3/8"	– 16 UNC	TC244482	22	100	9	7	8
7/16"	– 14 UNC	TC244522	22	100	8	6.2	9.4
1/2"	– 13 UNC	TC244562	25	110	9	7	10.75
9/16"	– 12 UNC	TC244602	26	110	11	9	12.25
5/8"	– 11 UNC	TC244642	27	110	12	9	13.5
3/4"	– 10 UNC	TC244702	30	125	14	11	16.5
7/8"	– 9 UNC	TC244742	32	140	18	14.5	19.5
1"	– 8 UNC	TC244782	36	160	20	16	22.25
1*1/8"	– 7 UNC	TC244822	40	180	22	18	25

▶ DIN 371(#4~3/8") and DIN 376(7/16"~1*1/8")

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
		○												

SPIRAL POINT TAPS

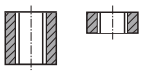
TD244 SERIES

UNC Unified coarse threads
Unified Grobgewinde

▶ Suitable for through hole in more cutting speed than other taps due to thick web.

▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

Hole type

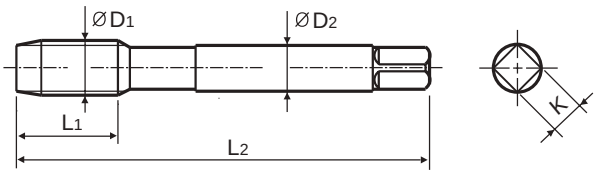


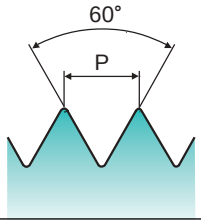
DIN 371

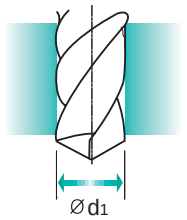
DIN 376

Material groups **VG** | HSS-E | DIN 371/376 | 2B | 60° | B | TiN

Machine taps
Maschinengewindebohrer







Unit : mm

SIZE ØD1	TPI	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping drill diameter Ød1
#4	– 40 UNC	TD244162	11	56	3.5	2.7	2.3
#5	– 40 UNC	TD244202	11	56	3.5	2.7	2.6
#6	– 32 UNC	TD244242	12	56	4	3	2.85
#8	– 32 UNC	TD244282	13	63	4.5	3.4	3.5
#10	– 24 UNC	TD244322	15	70	6	4.9	3.9
#12	– 24 UNC	TD244362	16	80	6	4.9	4.5
1/4"	– 20 UNC	TD244402	17	80	7	5.5	5.2
5/16"	– 18 UNC	TD244442	20	90	8	6.2	6.6
3/8"	– 16 UNC	TD244482	22	100	9	7	8
7/16"	– 14 UNC	TD244522	22	100	8	6.2	9.4
1/2"	– 13 UNC	TD244562	25	110	9	7	10.75
9/16"	– 12 UNC	TD244602	26	110	11	9	12.25
5/8"	– 11 UNC	TD244642	27	110	12	9	13.5
3/4"	– 10 UNC	TD244702	30	125	14	11	16.5
7/8"	– 9 UNC	TD244742	32	140	18	14.5	19.5
1"	– 8 UNC	TD244782	36	160	20	16	22.25
1*1/8"	– 7 UNC	TD244822	40	180	22	18	25

▶ DIN 371(#4~3/8") and DIN 376(7/16"~1*1/8")

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
		○												

SPIRAL POINT TAPS

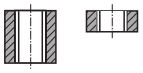
TB264 SERIES

UNC Unified coarse threads
Unified Grobgewinde

▶ Suitable for through hole in more cutting speed than other taps due to thick web.

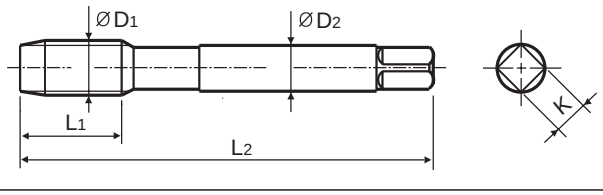
▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

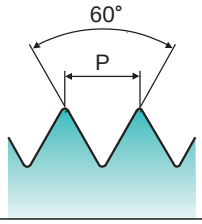
Hole type

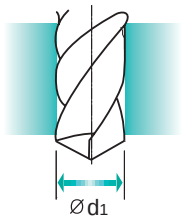


Material groups **VA NW** | HSS-E | DIN 371/376 | 2B | 60° | B | Vap

Machine taps
Maschinengewindebohrer







Unit : mm

SIZE	TPI	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping drill diameter
ØD1			L1	L2	ØD2	K	Ød1
#4	– 40 UNC	TB264162	11	56	3.5	2.7	2.3
#5	– 40 UNC	TB264202	11	56	3.5	2.7	2.6
#6	– 32 UNC	TB264242	12	56	4	3	2.85
#8	– 32 UNC	TB264282	13	63	4.5	3.4	3.5
#10	– 24 UNC	TB264322	15	70	6	4.9	3.9
#12	– 24 UNC	TB264362	16	80	6	4.9	4.5
1/4"	– 20 UNC	TB264402	17	80	7	5.5	5.2
5/16"	– 18 UNC	TB264442	20	90	8	6.2	6.6
3/8"	– 16 UNC	TB264482	22	100	9	7	8
7/16"	– 14 UNC	TB264522	22	100	8	6.2	9.4
1/2"	– 13 UNC	TB264562	25	110	9	7	10.75
9/16"	– 12 UNC	TB264602	26	110	11	9	12.25
5/8"	– 11 UNC	TB264642	27	110	12	9	13.5
3/4"	– 10 UNC	TB264702	30	125	14	11	16.5
7/8"	– 9 UNC	TB264742	32	140	18	14.5	19.5
1"	– 8 UNC	TB264782	36	160	20	16	22.25
1∗1/8"	– 7 UNC	TB264822	40	180	22	18	25

▶ DIN 371(#4~3/8") and DIN 376(7/16"~1∗1/8")

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
		○												

SPIRAL POINT TAPS

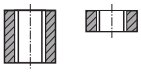
TC234 SERIES

UNF Unified fine threads
Unified Feingewinde

▶ Suitable for through hole in more cutting speed than other taps due to thick web.

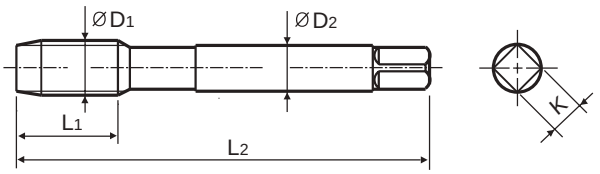
▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

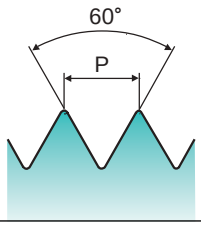
Hole type

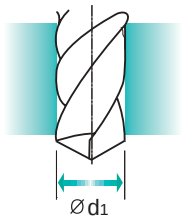


Material groups **GS** | HSS-E | DIN 371/374 | 2B | 60° | B | Bright

Machine taps
Maschinengewindebohrer







Unit : mm

SIZE	TPI	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping drill diameter
ØD1			L1	L2	ØD2	K	Ød1
#4	– 48 UNF	TC234182	11	56	3.5	2.7	2.4
#5	– 44 UNF	TC234222	11	56	3.5	2.7	2.7
#6	– 40 UNF	TC234262	12	56	4	3	3
#8	– 36 UNF	TC234302	13	63	4.5	3.4	3.5
#10	– 32 UNF	TC234342	13	70	6	4.9	4.1
#12	– 28 UNF	TC234382	16	80	6	4.9	4.7
1/4"	– 28 UNF	TC234422	17	80	7	5.5	5.5
5/16"	– 24 UNF	TC234462	17	90	8	6.2	6.9
3/8"	– 24 UNF	TC234502	18	100	9	7	8.5
7/16"	– 20 UNF	TC234542	22	100	8	6.2	9.9
1/2"	– 20 UNF	TC234582	22	100	9	7	11.5
9/16"	– 18 UNF	TC234622	22	100	11	9	12.9
5/8"	– 18 UNF	TC234662	22	100	12	9	14.5
3/4"	– 16 UNF	TC234722	25	110	14	11	17.5
7/8"	– 14 UNF	TC234762	26	125	18	14.5	20.5
1"	– 12 UNF	TC234802	28	140	20	16	23.25
1*1/8"	– 12 UNF	TC234842	30	150	22	18	26.5

▶ DIN 371(#4~3/8") and DIN 374(7/16"~1*1/8")

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
	○			○		◎		○	○	○	◎	○		

SPIRAL POINT TAPS

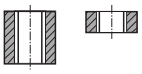
TC254 SERIES

UNF Unified fine threads
Unified Feingewinde

▶ Suitable for through hole in more cutting speed than other taps due to thick web.

▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

Hole type

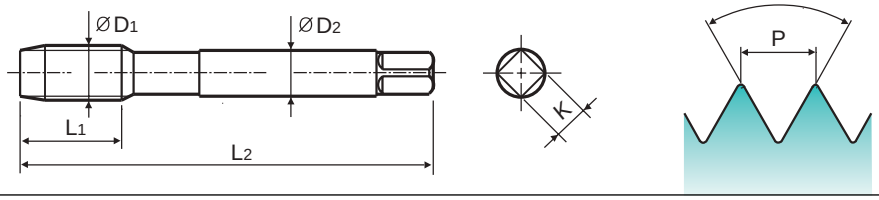


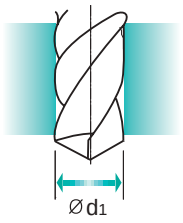
DIN 371

DIN 374

Material groups **VG** | HSS-E | DIN 371/374 | 2B | 60° | B | Bright

Machine taps
Maschinengewindebohrer





Unit : mm

SIZE	TPI	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping drill diameter
ØD1			L1	L2	ØD2	K	Ød1
#4	– 48 UNF	TC254182	11	56	3.5	2.7	2.4
#5	– 44 UNF	TC254222	11	56	3.5	2.7	2.7
#6	– 40 UNF	TC254262	12	56	4	3	3
#8	– 36 UNF	TC254302	13	63	4.5	3.4	3.5
#10	– 32 UNF	TC254342	13	70	6	4.9	4.1
#12	– 28 UNF	TC254382	16	80	6	4.9	4.7
1/4"	– 28 UNF	TC254422	17	80	7	5.5	5.5
5/16"	– 24 UNF	TC254462	17	90	8	6.2	6.9
3/8"	– 24 UNF	TC254502	18	100	9	7	8.5
7/16"	– 20 UNF	TC254542	22	100	8	6.2	9.9
1/2 "	– 20 UNF	TC254582	22	100	9	7	11.5
9/16"	– 18 UNF	TC254622	22	100	11	9	12.9
5/8"	– 18 UNF	TC254662	22	100	12	9	14.5
3/4"	– 16 UNF	TC254722	25	110	14	11	17.5
7/8"	– 14 UNF	TC254762	26	125	18	14.5	20.5
1"	– 12 UNF	TC254802	28	140	20	16	23.25
1∗1/8"	– 12 UNF	TC254842	30	150	22	18	26.5

▶ DIN 371(#4~3/8") and DIN 374(7/16"~1∗1/8")

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
		○												

SPIRAL POINT TAPS

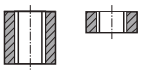
TB274 SERIES

UNF Unified fine threads
Unified Feingewinde

▶ Suitable for through hole in more cutting speed than other taps due to thick web.

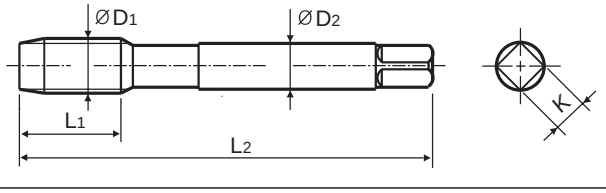
▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

Hole type



Material groups VA NW | HSS-E | DIN 371/374 | 2B | 60° | B | Vap

Machine taps
Maschinengewindebohrer



Unit : mm

SIZE	TPI	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping drill diameter
ØD1			L1	L2	ØD2	K	Ød1
#4	– 48 UNF	TB274182	11	56	3.5	2.7	2.4
#5	– 44 UNF	TB274222	11	56	3.5	2.7	2.7
#6	– 40 UNF	TB274262	12	56	4	3	3
#8	– 36 UNF	TB274302	13	63	4.5	3.4	3.5
#10	– 32 UNF	TB274342	13	70	6	4.9	4.1
#12	– 28 UNF	TB274382	16	80	6	4.9	4.7
1/4"	– 28 UNF	TB274422	17	80	7	5.5	5.5
5/16"	– 24 UNF	TB274462	17	90	8	6.2	6.9
3/8"	– 24 UNF	TB274502	18	100	9	7	8.5
7/16"	– 20 UNF	TB274542	22	100	8	6.2	9.9
1/2"	– 20 UNF	TB274582	22	100	9	7	11.5
9/16"	– 18 UNF	TB274622	22	100	11	9	12.9
5/8"	– 18 UNF	TB274662	22	100	12	9	14.5
3/4"	– 16 UNF	TB274722	25	110	14	11	17.5
7/8"	– 14 UNF	TB274762	26	125	18	14.5	20.5
1"	– 12 UNF	TB274802	28	140	20	16	23.25
1*1/8"	– 12 UNF	TB274842	30	150	22	18	26.5

▶ DIN 371(#4~3/8") and DIN 374(7/16"~1*1/8")

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
		○												

SPIRAL POINT TAPS

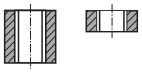
TC224 SERIES

BSW Whitworth threads
Whitworth Gewinde

▶ Suitable for through hole in more cutting speed than other taps due to thick web.

▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

Hole type

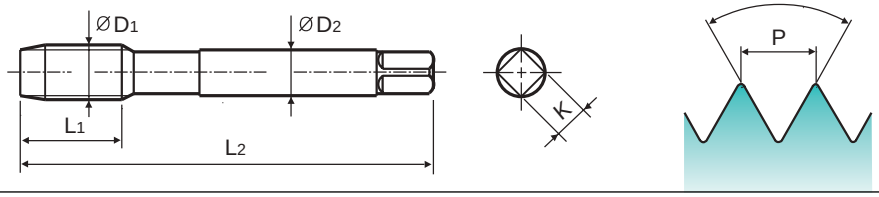


DIN 2182

DIN 2183

Material groups **GS** | HSS-E | DIN 2182/2183 | 55° | B | Bright

Machine taps
Maschinengewindebohrer



Unit : mm

SIZE	TPI	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping drill diameter
ØD1			L1	L2	ØD2	K	Ød1
W1/8"	– 40	TC224200	11	56	3.5	2.7	2.5
W5/32"	– 32	TC224280	13	63	4.5	3.4	3.1
W3/16"	– 24	TC224320	15	70	6	4.9	3.6
W7/32"	– 24	TC224360	16	80	6	4.9	4.4
W1/4"	– 20	TC224400	17	80	7	5.5	5.1
W5/16"	– 18	TC224440	20	90	8	6.2	6.5
W3/8"	– 16	TC224480	22	100	9	7	7.9
W7/16"	– 14	TC224520	22	100	8	6.2	9.3
W1/2"	– 12	TC224560	25	110	9	7	10.5
W9/16"	– 12	TC224600	26	110	11	9	12
W5/8"	– 11	TC224640	27	110	12	9	13.5
W3/4"	– 10	TC224700	30	125	14	11	16.5
W7/8"	– 9	TC224740	32	140	18	14.5	19.25
W1"	– 8	TC224780	36	160	20	16	22
W1∗1/8"	– 7	TC224820	40	180	22	18	24.75

▶ DIN 2182(W1/8"~W3/8") and DIN 2183(W7/16"~W1∗1/8")

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
	○			○		◎		○	○	○	◎	○		