New products for machining technicians

NEW Through hole – machine taps right-hand, type Stabil NW

M → Page 26 | MF → Page 64 | G → Page 82

- Highly efficient machining of non-ferrous metals
- 1 – 2 µm thick DLC monolayer coating ensures minimal friction values and therefore ideal chip clearance
- 4xD

NEW Blind hole – machine taps right-hand, type Salo-Rex NW

M → Page 42 | MF → Page 73 | G → Page 85

- Highly efficient machining of non-ferrous metals
- 1 – 2 µm thick DLC monolayer coating ensures minimal friction values and therefore ideal chip clearance
- 3xD

NEW Through hole – machine taps right-hand, type Stabil HR

M → Page 25

- Specialist for thread production in high-strength steels
- New optimised hard material/carbon coating delivers the very best results
- 4xD

NEW Blind hole – machine taps right-hand, type SL HR

M → Page 38

- Specialist for thread production in high-strength steels
- New optimised hard material/carbon coating delivers the very best results
- 2xD

Table of contents

WNT \ Performance

Premium quality tools for high performance.

The premium quality tools from the **WNT Performance** product line have been designed for specific applications and are distinguished by their outstanding performance. If you make high demands on the performance of your production and want to achieve the very best results, we recommend the Premium tools in this product line.

WNT \ Standard

Quality tools for standard applications.

The quality tools of the **WNT Standard** product line are high quality, powerful and reliable and enjoy the highest trust of our customers worldwide. Tools from this product line are the first choice for many standard applications and guarantee optimal results.

Symbol explanation

Chamfer form

Form B
(with spiral point, 4 – 5 cutting leads)

Form C
(without spiral point, 2 – 3 cutting leads)

Form D
(without spiral point, 4 – 5 cutting leads)

Form E
(without spiral point, 1.5 – 2 cutting leads)

Helix angle

Example: helix angle 42°

Tolerances

ISO 2 6H

Explanation of the tolerances can be found on → **Page 113.**

Tensile strength

≤ 1100 N/mm²

Example up to 1100 N/mm²

Tool Material

HSS	High-speed steel
HSS-E	High-performance high speed steel
HSS-PM	High-performance sintered high-speed steel
VHM	Solid carbide

Coloured rings

WNT \ Performance

An explanation of the coloured rings can be found on → **Page 116.**

Thread types

M

Explanation of the thread types can be found on → **Page 3.**

Coolant supply version


Int. coolant supply

The cutting data is highly dependent on external conditions, such as stability of the tool and workpiece clamping, material and machine type!
The values indicated represent possible cutting data which may need to be corrected depending on operating conditions !

Tap types

Tool type

WNT \ Performance

Stabil	for through holes to 4xD	**Salo-Rex**	for blind holes up to 3xD, high helix angle for secure chip evacuation	**TWIN**	straight flutes for through and blind holes up 2xD
DL	left hand helix for through holes up to 4xD	**SL**	for blind holes up to 2xD, 15°, 25° or 30° helix angle	**Spanlos**	Thread former for through and blind holes up to 3xD

A detailed explanation of the types of tools can be found on → **Page 112.**

Application range

WNT \ Performance

UNI	for universal application	**ST**	for good quality free machining steel	**VG**	for tempered and heat-resistant steels < 1100 N/mm²
HR	for high-tensile steels < 1400 N/mm²	**GG**	for cast iron	**VA**	for stainless and acid-resistant steels up to 1100 N/mm²
NW	for aluminium	**Soft**	for soft materials	**Ms**	for short chipping brass
Ti	for titanium and titanium alloys	**Ni**	special for Inconel 718	**AMPCO**	for Ampco alloys
HT	for hardened steel and chilled iron up to 55 HRc	**EC**	Spanlos – Thread former for universal application	**NEO**	Spanlos – Thread former for heat resistant alloys
ERGO	Hand Taps for stainless, heat-resistant and heat-treated steels up to 1100 N/mm²	**ERGO F.T.**	Hand tap for steel up to 1400 N/mm², wolfram, chilled iron	**FE**	Dies for steel

WNT \ Standard

UNI	for universal application up to 1000 N/mm²	**FE**	for steel to 850 N/mm²	**FE-HF**	for high-tensile steel to 1100 N/mm ²
VA	for corrosion and acid-resistant steels	**GG**	for cast iron	**AL**	for aluminium and aluminium alloys

Special Features

CNC	for synchronised CNC machining with minimum length compensation chuck	**NC**	for synchronised CNC machining with minimum length compensation chuck	**NCW**	with Weldon flat for synchronised CNC machining without length compensation chuck
AZ	with intermittent teeth, reduces friction	**S**	with back taper, for deep threads	**DRY**	for dry machining or minimum quantity lubrication (MMS)
TS	for high-speed machining, up to 100 m/min.	**LH**	for left hand threads	**EL**	extra long, with double overall length
AUT	short version for automatic use	**SN**	Thread formers with lubrication grooves	**ES**	extra short
MMB	Machine taps	**R_z=1**	Lapped Dies		

Thread types

M	ISO metric coarse thread DIN 13	**UNF**	Unified fine thread ASME – B1.1	**NPTF**	American taper pipe thread with sealing (1:16) ANSI/ASME B1.20.3
EG M	ISO Metric coarse thread for wire inserts DIN 8140-2	**EG UNF**	EG Unified fine thread for wire inserts ASME B18.29.1	**Rp**	Cyl. Whitworth coarse thread DIN EN 10226-1 (ISO7-1)
MF	ISO Metric fine thread DIN 13	**UNJC**	Unified coarse thread ASME – B1.15 and ISO 3161	**Rc**	Whitworth taper pipe thread (1:16) DIN EN 10226-2 (ISO7-1)
G	Whitworth pipe thread DIN EN ISO 228	**UNJF**	Unified fine thread ASME – B1.15 and ISO 3161	**Tr**	ISO metric trapezoidal thread DIN 103
UNC	Unified coarse thread ASME – B1.1	**BSW**	Whitworth thread BS84		The thread types BSW, NPTF, Rp and Rc as well as hand taps and dies are now available in the online shop.
EG UNC	EG Unified coarse thread for wire inserts ASME B18.29.1	**NPT**	American taper pipe thread with sealing (1:16) ANSI/ASME B1.20.1		

Toolfinder – WNT Performance

Thread formers

for cold-formable materials

HSS taps

- Through hole-Blind hole

for universal application up to 1100 N/mm²

- Through hole
- Blind hole

for steel up to 750 N/mm²

- Through hole
- Blind hole
- Through hole-Blind hole

for steel up to 1400 N/mm²

- Through hole
- Blind hole
- Through hole-Blind hole

for corrosion and acid-resistant steels

- Through hole
- Blind hole

For cast iron materials

- Through hole-Blind hole

for heat-resistant materials

- Through hole
- Blind hole

for aluminium and non-ferrous metal

- Through hole
- Blind hole
- Through hole-Blind hole

Hard materials

- Through hole-Blind hole

For tools for other applications, refer to the taps overview on → **Pages 8–20.**

Shank extensions for taps and thread-cutting oils can be found in our online shop at cuttingtools.ceratizit.com

WNT \ Performance

Tool type	Application range	M	EG M	MF	G	UNC	EG UNC	UNJC	UNF	EG UNF	UNJF	BSW	NPT	NPTF	Rp	Tr
Spanlos	EC	57+58		80	88	93			102							
Stabil	UNI	21–23	61	63+64	82	89	94		97	103		🛒				
Salo-Rex	UNI	34–37	62	67+68	84+85	91	95		99	104		🛒	🛒			
Stabil	ST	24+25		64	82											108
Salo-Rex	ST	39+40		69+70	85											
TWIN	ST	51+52		78–79	87								107	🛒	🛒	
Stabil	HR	25														
Salo-Rex	HR	40														
TWIN	HR	51+52		77+78	87											
Stabil	VA	26			82	89										
Salo-Rex	VA	41		72	85	91			99				105			
TWIN	GG	53		78												
Stabil	Ti	27				89			97		🛒					
SL	Ti	43				🛒		96	100		🛒					
Stabil	NW	26		64	82											
Salo-Rex	NW	42		73	85											
TWIN	AMPCO	51+52														
TWIN	HT	54		77												

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Toolfinder – WNT Standard

Thread formers

for cold-formable materials

-  Through hole-Blind hole

HSS taps

for universal application up to 1000 N/mm²

-  Through hole
-  Blind hole

for steel to 850 N/mm²

-  Through hole
-  Blind hole

for high-tensile steels up to 1100 N/mm²

-  Through hole
-  Blind hole

for corrosion and acid-resistant steels

-  Through hole
-  Blind hole

For cast iron materials

-  Through hole-Blind hole

for aluminium and non-ferrous metal

-  Through hole
-  Blind hole

For tools for other applications, refer to the taps overview on → **Pages 8–20.**

Shank extensions for taps and thread-cutting oils can be found in our online shop at cuttingtools.ceratizit.com

Application range	WNT \ Standard M	MF	G	UNC	UNF
UNI	60	81			
UNI	31+32	65+66	83	90	98
UNI	48+49	74	86	92	101
FE	32	66			
FE	49	75			
FE-HF	32			90	
FE-HF	49			92	
VA	33	66		90	98
VA	49+50	76		92	101
GG	56				
AL	33				
AL	50				

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Taps Overview

M – Metric ISO Standard Thread

Application range	Through hole	Blind hole	Through hole-Blind hole	Tool type	Application Area / Special Features	Tolerance	Tool Material	coated ■	uncoated □	Comments	WNT \ Performance	WNT \ Standard
Universal				Stabil	UNI	ISO 2 6H ISO 3 6G 7G	HSS-E	■			21+22	
					UNI	ISO 2 6H	HSS-E HSS-PM	■				31
				Stabil	UNI NCW	ISO 2 6H	HSS-PM	■		with Weldon flat for synchronised CNC machining without length compensation chuck	23	
					UNI NCW	ISO 2 6H	HSS-PM	■		with Weldon flat for synchronised CNC machining without length compensation chuck		32
				Stabil	UNI CNC	ISO 2X 6HX ISO 3X 6GX 7GX	HSS-E	■		for synchronised CNC machining with minimum length compensation chuck	23	
					UNI NC	ISO 2 6H	HSS-E	■		for synchronised CNC machining with minimum length compensation chuck		32
				Stabil	UNI EL	ISO 2 6H	HSS-E	■		extra long, with double overall length	29	
Steel				Stabil	ST	ISO 2 6H	HSS-E		□		24	
				Stabil	ST	ISO 1 4H ISO 3 6G	HSS-E		□			
					FE	ISO 2 6H	HSS-E		□			32
					FE ES	ISO 2 6H	HSS-E		□	extra short		
				Stabil	ST LH	ISO 2 6H	HSS-E		□	for left hand threads	24	
				Stabil	ST TS	ISO 2X 6HX	HSS-E	■		for high-speed machining, up to 100 m/min.	25	
				Stabil	HR	ISO 2X 6HX	HSS-PM	■			25	
				Stabil	VG	ISO 2X 6HX	HSS-E	■			25	
						ISO 2 6H	HSS-E	■				32

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Taps Overview

M – Metric ISO Standard Thread

Application range	Through hole	Blind hole	Through hole-Blind hole	Tool type	Application Area / Special Features	Tolerance	Tool Material	coated ■	uncoated □	Comments	WNT \ Performance	WNT \ Standard
Steel	✓			Stabil	ST EL	ISO 2 6H	HSS-E		□	extra long, with double overall length	29	
	✓				ST MMB	ISO 2 6H	HSS-E		□	Machine taps	30	
Stainless steel	✓			Stabil	VA	ISO 2 6H	HSS-E	■			26	
	✓				VA	ISO 2 6H	HSS-PM HSS-E	■				33
Non ferrous metals	✓			Stabil	NW	ISO 2 6H	HSS-E	■			26	
	✓				AL	ISO 2 6H	HSS-E	■	□			33
	✓			Stabil	Soft	ISO 2 6H	HSS-E	■			🛒	
Heat resistant	✓			Stabil	Ti	ISO 1X 4HX ISO 2X 6HX	HSS-PM	■			27	
	✓			DL	Ti	ISO 2X 6HX	HSS-E	■			28	
	✓			DL	Ni	ISO 2X 6HX	HSS-E	■			28	
Universal		✓		Salo-Rex	UNI	ISO 2 6H 7G	HSS-E	■			34+35	
		✓		Salo-Rex	UNI	ISO 1 4H ISO 3 6G	HSS-E	■			🛒	
		✓			UNI	ISO 2 6H	HSS-E HSS-PM	■				48
		✓		Salo-Rex	UNI NCW	ISO 2 6H	HSS-PM	■		with Weldon flat for synchronised CNC machining without length compensation chuck	35	
		✓			UNI NCW	ISO 2 6H	HSS-PM	■		with Weldon flat for synchronised CNC machining without length compensation chuck		49
		✓		Salo-Rex	UNI CNC	ISO 2X 6HX ISO 2 6H, 7G	HSS-E	■		for synchronised CNC machining with minimum length compensation chuck	36	
		✓		Salo-Rex	UNI CNC	ISO 3 6G	HSS-E	■		for synchronised CNC machining with minimum length compensation chuck	🛒	
		✓			UNI NC	ISO 2 6H	HSS-E	■		for synchronised CNC machining with minimum length compensation chuck		48

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Taps Overview

M – Metric ISO Standard Thread

Application range	Through hole	Blind hole	Through hole-Blind hole	Tool type	Application Area / Special Features	Tolerance	Tool Material	coated ■	uncoated □	Comments	WNT \ Performance	WNT \ Standard
Universal				Salo-Rex	UNI DRY	ISO 2 6H	HSS-E	■		for dry machining or minimum quantity lubrication (MMS), with thro' coolant	37	
				Salo-Rex	UNI S	ISO 2 6H	HSS-E	■		with back taper, for deep threads		
				Salo-Rex	UNI ES	ISO 2 6H	HSS-E	■		extra short	44	
				Salo-Rex	UNI EL	ISO 2 6H	HSS-E	■		extra long, with double overall length	46	
				SL	UNI	ISO 2 6H	HSS-E		□			
Steel				SL	ST	ISO 2 6H	HSS-E		□			
				SL	ST CNC	ISO 2X 6HX	HSS-E	■		for synchronised CNC machining with minimum length compensation chuck, with thro' coolant	38	
				SL	ST TS	ISO 2 6H	HSS-PM	■		for high-speed machining, up to 100 m/min.		
				SL	ST TS	ISO 2X 6HX	HSS-E	■		for high-speed machining, up to 100 m/min.	38	
				SL	ST ES	ISO 2 6H	HSS-E		□	extra short	45	
				SL	ST EL	ISO 2 6H	HSS-E		□	extra long, with double overall length	47	
				SL	HR	ISO 2 6H	HSS-PM		□		38	
				Salo-Rex	ST	ISO 2 6H	HSS-E	■	□		39	
				Salo-Rex	ST	ISO 1 4H ISO 3 6G	HSS-E	■	□			
					FE	ISO 2 6H	HSS-E		□			49
					FE-HF	ISO 2 6H	HSS-E	■				49
				Salo-Rex	ST LH	ISO 2 6H	HSS-E		□	for left hand threads	39	
				Salo-Rex	ST ES	ISO 2 6H	HSS-E		□	extra short		
				Salo-Rex	ST EL	ISO 2 6H	HSS-E		□	extra long, with double overall length	46	

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Taps Overview

M – Metric ISO Standard Thread

Application range	Through hole	Blind hole	Through hole-Blind hole	Tool type	Application Area / Special Features	Tolerance	Tool Material	coated ■	uncoated □	Comments	WNT \ Performance	WNT \ Standard
Steel		✓		Salo-Rex	HR	ISO 2 6H	HSS-PM	■	□		40	
		✓		Salo-Rex	ST TS	ISO 2 6H	HSS-E	■			40	
Stainless steel		✓		Salo-Rex	VA	ISO 2 6H	HSS-E	■			41	
		✓			VA	ISO 2 6H	HSS-E HSS-PM	■	□			49+50
		✓		Salo-Rex	VA S	ISO 2 6H	HSS-E	■		with back taper, for deep threads		
Non ferrous metals		✓		Salo-Rex	Soft	ISO 2 6H	HSS-E	■	□		42	
		✓		Salo-Rex	NW	ISO 2 6H	HSS-E	■			42	
		✓			AL	ISO 2 6H	HSS-E	■	□			50
Heat resistant		✓		SL	Ti	ISO 2X 6HX	HSS-PM	■			43	
		✓		SL	Ni	ISO 2X 6HX ISO 2 6H	HSS-PM	■			43	
Steel			✓	TWIN	ST	ISO 2X 6HX	HSS-E		□		51+52	
			✓	TWIN	ST AZ	ISO 2X 6HX	HSS-E		□	with intermittent teeth, reduces friction		
			✓	TWIN	ST ES	ISO 2X 6HX	HSS-E		□	extra short		
			✓	TWIN	ST LH/ES	ISO 2X 6HX	HSS-E		□	for left hand threads; extra short		
			✓	TWIN	HR	ISO 2X 6HX	HSS-E	■			51+52	
			✓	TWIN	HR EL	ISO 2X 6HX	HSS-E	■		extra long, with double overall length	55	
Cast iron			✓	TWIN	GG	ISO 2X 6HX	HSS-E	■			53	
			✓		GG	ISO 2X 6HX	HSS-E	■				56
Non ferrous metals			✓	TWIN	Ms	ISO 2X 6HX	HSS-E		□			

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Taps Overview

M – Metric ISO Standard Thread

Application range	Through hole	Blind hole	Through hole-Blind hole	Tool type	Application Area / Special Features	Tolerance	Tool Material	coated ■	uncoated □	Comments	WNT \ Performance	WNT \ Standard
Non ferrous metals				TWIN	AMPCO	ISO 2X 6HX	HSS-PM		□		51+52	
hardened materials				TWIN	HT	ISO 2X 6HX	VHM HSS-PM	■			54	
Machine thread formers				Spanlos	EC	ISO 2X 6HX	HSS-E	■			57	
				Spanlos	EC SN	ISO 2X 6HX ISO 3X 6GX	HSS-E	■		Thread formers with lubrication grooves	58	
				Spanlos	NEO SN	ISO 2X 6HX	HSS-PM	■		Thread formers with lubrication grooves	59	
					UNI	ISO 2X 6HX	HSS-E	■				60
					UNI SN	ISO 2X 6HX	HSS-E	■		Thread formers with lubrication grooves		60
Hand taps					ST	ISO 2X 6HX	HSS-E VHM		□			
					ERGO	ISO 2X 6HX	HSS-E		□			
					ERGO F.T.	ISO 2X 6HX	HSS-E	■				
Dies					FE	ISO 6g ISO 6e	HSS		□			
					FE	ISO 6g	HSS		□			
					FE R_z=1	ISO 6g	HSS		□	Lapped Dies		
					FE LH	ISO 6g	HSS		□	for left hand threads		
					VA	ISO 6g	HSS-E		□			
					VA R_z=1	ISO 6g	HSS-E		□	Lapped Dies		
					Ms R_z=1	ISO 6g	HSS		□	Lapped Dies		

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Taps Overview

Application range	Through hole	Blind hole	Through hole-Blind hole	Tool type	Application Area / Special Features	Tolerance	Tool Material	coated ■	uncoated □	Comments	WNT \ Performance	WNT \ Standard
Metric ISO standard thread for wire thread inserts												
Universal	✓			Stabil	UNI	6H mod	HSS-E	■			61	
Universal		✓		Stabil	UNI	6H mod	HSS-E	■			62	
Non ferrous metals		✓		Stabil	Soft	6H mod	HSS-E	■			62	
MF – Metric ISO Fine Thread												
Universal	✓			Stabil	UNI	ISO 2 6H	HSS-E	■			63+64	
Universal	✓			Stabil	UNI	ISO 3 6G	HSS-E	■			🛒	
Universal	✓				UNI	ISO 2 6H	HSS-PM HSS-E	■				65+66
Steel	✓			Stabil	ST	ISO 2 6H	HSS-E		□		🛒	
Steel	✓				FE	ISO 2 6H	HSS-E		□			66
Steel	✓				FE-HF	ISO 2 6H	HSS-E	■				🛒
Steel	✓			Stabil	ST TS	ISO 2X 6HX	HSS-E	■		for high-speed machining, up to 100 m/min.	64	
Steel	✓			Stabil	ST LH	ISO 2 6H	HSS-E		□	for left hand threads	64	
Stainless steel	✓			Stabil	VA	ISO 2 6H	HSS-E	■			🛒	
Stainless steel	✓				VA	ISO 2 6H	HSS-E	■				66
Non ferrous metals	✓			Stabil	NW	ISO 2 6H	HSS-E	■			64	
Universal		✓		Salo-Rex	UNI	ISO 2 6H ISO 3 6G	HSS-E	■			67+68	
Universal		✓			UNI	ISO 2 6H	HSS-E HSS-PM	■				74
Universal		✓		Salo-Rex	UNI CNC	ISO 3 6G	HSS-E	■		for synchronised CNC machining with minimum length compensation chuck	🛒	

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Taps Overview

MF – Metric ISO Fine Thread

Application range	Through hole	Blind hole	Through hole-Blind hole	Tool type	Application Area / Special Features	Tolerance	Tool Material	coated ■	uncoated □	Comments	WNT \ Performance	WNT \ Standard
Universal				Salo-Rex	UNI CNC	7G ISO 2 6H	HSS-E	■		for synchronised CNC machining with minimum length compensation chuck	68	
					UNI NC	ISO 2 6H	HSS-E	■		for synchronised CNC machining with minimum length compensation chuck		75
Steel				Salo-Rex	ST	ISO 2 6H	HSS-E		□		69	
				Salo-Rex	ST	ISO 1 4H	HSS-E		□		🛒	
					FE	ISO 2 6H	HSS-E		□			75
					FE-HF	ISO 2 6H	HSS-E	■				🛒
				Salo-Rex	ST TS	ISO 2 6H	HSS-E	■		for high-speed machining, up to 100 m/min.	🛒	
				Salo-Rex	ST LH	ISO 2 6H	HSS-E		□	for left hand threads	69	
				SL	ST	ISO 2 6H	HSS-E		□		70+71	
				SL	ST CNC	ISO 2X 6HX	HSS-E	■		for synchronised CNC machining with minimum length compensation chuck	🛒	
Stainless steel				Salo-Rex	VA	ISO 2 6H	HSS-E	■			72+73	
					VA	ISO 2 6H	HSS-E HSS-PM	■				76
Non ferrous metals				Salo-Rex	NW	ISO 2 6H	HSS-E	■			73	
Steel				TWIN	ST	ISO 2X 6HX	HSS-E		□		77+78	
				TWIN	ST ES	ISO 2X 6HX	HSS-E		□	extra short	79	
				TWIN	ST LH/ES	ISO 2X 6HX	HSS-E		□	for left hand threads	79	
				TWIN	HR	ISO 2X 6HX	HSS-E	■			77+78	
Cast iron				TWIN	GG	ISO 2X 6HX	HSS-E	■			78	
hardened materials				TWIN	HT	ISO 2X 6HX	VHM	■			77	

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Taps Overview

Application range	Through hole	Blind hole	Through hole-Blind hole	Tool type	Application Area / Special Features	Tolerance	Tool Material	coated ■	uncoated □	Comments	WNT \ Performance	WNT \ Standard
MF – Metric ISO Fine Thread												
Machine thread formers				Spanlos	EC	ISO 2X 6HX	HSS-E	■			80	
Machine thread formers				Spanlos	EC SN	ISO 2X 6HX	HSS-E	■		Thread formers with lubrication grooves	80	
Machine thread formers					UNI	ISO 2X 6HX	HSS-E	■				81
Machine thread formers					UNI SN	ISO 2X 6HX	HSS-E	■		Thread formers with lubrication grooves		81
Hand taps					ST	ISO 2X 6HX	HSS-E		□			
Dies					FE	ISO 6g	HSS		□			
Dies					FE	ISO 6g	HSS		□			
Dies					FE LH	ISO 6g	HSS		□	for left hand threads		
Dies					VA	ISO 6g	HSS-E		□			
G – Whitworth Pipe Thread												
Universal				Stabil	UNI	ISO 228	HSS-E	■			82	
Universal					UNI	ISO 228	HSS-E	■				83
Steel				Stabil	ST	ISO 228	HSS-E		□		82	
Steel					FE	ISO 228	HSS-E		□			
Stainless steel				Stabil	VA	ISO 228	HSS-E	■			82	
Non ferrous metals				Stabil	NW	ISO 228	HSS-E	■			82	
Universal				Salo-Rex	UNI	ISO 228 ISO 228 +0,05	HSS-E	■			84	
Universal					UNI	ISO 228	HSS-E	■				86
Universal				Salo-Rex	UNI CNC	ISO 228	HSS-E	■		for synchronised CNC machining with minimum length compensation chuck	85	

 This article can be found in our online shop at cuttingtools.ceratizit.com

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Taps Overview

G – Whitworth Pipe Thread

Application range	Through hole	Blind hole	Through hole-Blind hole	Tool type	Application Area / Special Features	Tolerance	Tool Material	coated ■	uncoated □	Comments	WNT \ Performance	WNT \ Standard
Steel		✓		Salo-Rex	ST	ISO 228	HSS-E		□		85	
Steel		✓		SL	ST	ISO 228	HSS-E		□		🛒	
Stainless steel		✓		Salo-Rex	VA	ISO 228	HSS-E	■			85	
Non ferrous metals		✓		Salo-Rex	NW	ISO 228	HSS-E	■			85	
Steel			✓	TWIN	ST	ISO 228X	HSS-E		□		87	
Steel			✓	TWIN	HR	ISO 228X	HSS-E	■			87	
Cast iron			✓	TWIN	GG	ISO 228X	HSS-E	■			🛒	
Machine thread formers			✓	Spanlos	EC	ISO 228	HSS-E	■			88	
Machine thread formers			✓	Spanlos	EC SN	ISO 228	HSS-E	■		Thread formers with lubrication grooves	88	
Hand taps					ERGO	ISO 228	HSS-E		□		🛒	
Dies					FE	ISO 228A	HSS		□		🛒	

UNC – Unified Coarse Thread

Application range	Through hole	Blind hole	Through hole-Blind hole	Tool type	Application Area / Special Features	Tolerance	Tool Material	coated ■	uncoated □	Comments	WNT \ Performance	WNT \ Standard
Universal	✓			Stabil	UNI	3B	HSS-E	■			🛒	
Universal	✓			Stabil	UNI	2B	HSS-E	■			89	
Universal	✓				UNI	2B	HSS-E	■				90
Steel	✓			Stabil	ST	2B	HSS-E		□		🛒	
Steel	✓				FE-HF	2B	HSS-E	■				90
Stainless steel	✓			Stabil	VA	2B	HSS-E	■			89	
Stainless steel	✓				VA	2B	HSS-E	■				90

🛒 This article can be found in our online shop at cuttingtools.ceratizit.com

Taps Overview

UNC – Unified Coarse Thread

Application range	Through hole	Blind hole	Through hole-Blind hole	Tool type	Application Area / Special Features	Tolerance	Tool Material	coated ■	uncoated □	Comments	WNT \ Performance	WNT \ Standard
Heat resistant	✓			Stabil	Ti	2BX	HSS-PM	■			89	
Universal		✓		Salo-Rex	UNI	2B	HSS-E	■			91	
Universal		✓		Salo-Rex	UNI	2B +0,05	HSS-E	■			🛒	
Universal		✓			UNI	2B	HSS-E	■				92
Steel		✓		Salo-Rex	ST	2B	HSS-E		□		🛒	
Steel		✓			FE-HF	2B	HSS-E	■				92
Stainless steel		✓		Salo-Rex	VA	2B	HSS-E	■			91	
Stainless steel		✓			VA	2B	HSS-E		□			92
Heat resistant		✓		SL	Ti	2BX	HSS-PM	■			🛒	
Cast iron			✓	TWIN	GG	2BX	HSS-E	■			🛒	
Machine thread formers			✓	Spanlos	EC	2BX	HSS-E	■			93	
Machine thread formers			✓	Spanlos	EC SN	2BX	HSS-E	■		Thread formers with lubrication grooves	93	
Hand taps			✓		ERGO	2BX	HSS-E		□		🛒	
Dies			✓		FE	2A	HSS-E		□		🛒	

EG UNC – Unified coarse thread for wire inserts

Application range	Through hole	Blind hole	Through hole-Blind hole	Tool type	Application Area / Special Features	Tolerance	Tool Material	coated ■	uncoated □	Comments	WNT \ Performance	WNT \ Standard
Universal	✓			Stabil	UNI	2B	HSS-E	■			94	
Universal		✓		Salo-Rex	UNI	2B	HSS-E	■			95	

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Taps Overview

Application range	Through hole	Blind hole	Through hole-Blind hole	Tool type	Application Area / Special Features	Tolerance	Tool Material	coated ■	uncoated □	Comments	WNT \ Performance	WNT \ Standard
UNJC – Unified Coarse Thread												
Heat resistant				SL	Ti	3BX	HSS-E	■			96	
UNF – Unified Fine Thread												
Universal				Stabil	UNI	2B	HSS-E	■			97	
					UNI	2B	HSS-E	■				98
Steel				Stabil	ST	2B	HSS-E		□			
					FE	2B	HSS-E		□			98
Stainless steel					VA	2B	HSS-E	■				98
Heat resistant				Stabil	Ti	2BX	HSS-PM	■			97	
Universal				Salo-Rex	UNI	2B 2B +0,05	HSS-E	■			99	
					UNI	2B	HSS-E	■				101
Steel					FE	2B	HSS-E		□			
Stainless steel				Salo-Rex	VA	2B	HSS-E	■			99	
					VA	2B	HSS-E		□			101
Heat resistant				SL	Ti	2BX 3BX	HSS-PM	■			100	
Cast iron				TWIN	GG	2BX	HSS-E	■				
Thread formers				Spanlos	EC SN	2BX	HSS-E	■		Thread formers with lubrication grooves	102	
Dies					FE	2A	HSS		□			

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Taps Overview

Application range	Through hole	Blind hole	Through hole-Blind hole	Tool type	Application Area / Special Features	Tolerance	Tool Material	coated ■	uncoated □	Comments	WNT \ Performance	WNT \ Standard
EG UNF – Unified fine thread for wire inserts												
Universal	✓			Stabil	UNI	2B	HSS-E	■			103	
		✓		Salo-Rex	UNI	2B	HSS-E	■			104	
UNJF – Unified Extra Fine Thread												
Heat resistant	✓			DL	Ti	3BX	HSS-E	■			🛒	
		✓		SL	Ti	3BX	HSS-E	■			🛒	
BSW – Whitworth Thread												
Universal	✓			Stabil	UNI	med.	HSS-E	■			🛒	
		✓		Salo-Rex	UNI	med.	HSS-E	■			🛒	
NPT – American Tapered Pipe Thread												
Stainless steel		✓		Salo-Rex	VA		HSS-E	■			105	
Steel			✓	TWIN	VG		HSS-E		□		106	
			✓	TWIN	VG AZ		HSS-E		□	with intermittent teeth, reduces friction	🛒	
			✓	TWIN	ST ES		HSS-E		□	extra short	107	
Dies					FE		HSS-E		□		🛒	

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Taps Overview

Application range	Through hole	Blind hole	Through hole-Blind hole	Tool type	Application Area / Special Features	Tolerance	Tool Material	coated ■	uncoated □	Comments	WNT \ Performance	WNT \ Standard
NPTF – American Tapered Pipe Thread												
Steel				TWIN	ST		HSS-E		□			
Steel				TWIN	VG		HSS-E		□			
Steel				TWIN	ST ES		HSS-E		□	extra short		
Rp – Cylindrical Whitworth Pipe Thread												
Steel				TWIN	ST	X	HSS-E		□			
Rc – Tapered Whitworth Pipe Thread												
Steel				TWIN	VG		HSS-E		□			
Tr – Metric ISO Trapezoidal Thread												
Steel					ST	7H	HSS-E		□		108	

Accessories

Shank extensions for taps	
Tapping Oil, Chlorine Free	

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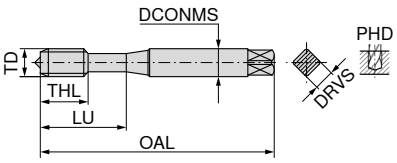
Through hole – Machine taps, right hand

M | Stabil



DIN 371 with reinforced shank

	UNI	UNI	UNI	UNI	UNI
	B 4–5	B 4–5	B 4–5	B 4–5	B 4–5
	ISO 2 6H	ISO 2 6H	ISO 2 6H	ISO 3 6G	7G
	nitr. + vap.	TiN	TiCN	nitr. + vap.	nitr. + vap.
					
	HSS-E ◁ 0° ≤ 1100 N/mm² ≤ 4xD	HSS-E ◁ 0° ≤ 1100 N/mm² ≤ 4xD	HSS-E ◁ 0° ≤ 1100 N/mm² ≤ 4xD	HSS-E ◁ 0° ≤ 1100 N/mm² ≤ 4xD	HSS-E ◁ 0° ≤ 1100 N/mm² ≤ 4xD
	22 501 ...	**22 503 ...**	**22 505 ...**	**22 508 ...**	**22 510 ...**

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	EUR U0		EUR U0		EUR U0		EUR U0		EUR U0	
M1	0,25	40	2,5	2,1	0,75	5	13	2	102,80	**010** [1]								
M1,2	0,25	40	2,5	2,1	0,95	5	13	2	97,58	**012** [1]								
M1,4	0,30	40	2,5	2,1	1,10	7	13	3	88,31	**014** [1]								
M1,6	0,35	40	2,5	2,1	1,25	8	11	3	62,01	**016**								
M1,7	0,35	40	2,5	2,1	1,35	6	11	2	95,40	**017**								
M1,8	0,35	40	2,5	2,1	1,45	6	11	2	131,00	**018**								
M2	0,40	45	2,8	2,1	1,60	7	12	2			42,67	**020**			45,07	**020**	52,40	**020**
M2	0,40	45	2,8	2,1	1,60	7	12	3	45,07	**020**								
M2,2	0,45	45	2,8	2,1	1,75	7	12	2	48,03	**022**								
M2,5	0,45	50	2,8	2,1	2,05	9	14	2	44,31	**025**					44,31	**025**	51,30	**025**
M3	0,50	56	3,5	2,7	2,50	11	18	3	33,19	**030**	36,03	**030**	36,03	**030**	36,03	**030**	41,48	**030**
M3,5	0,60	56	4,0	3,0	2,90	12	20	3	36,45	**035**					36,68	**035**		
M4	0,70	63	4,5	3,4	3,30	13	21	3	30,12	**040**	37,54	**040**	37,54	**040**	36,45	**040**	41,70	**040**
M5	0,80	70	6,0	4,9	4,20	15	25	3	30,89	**050**	38,09	**050**	38,09	**050**	36,68	**050**	42,67	**050**
M6	1,00	80	6,0	4,9	5,00	17	30	3	31,33	**060**	43,01	**060**	43,01	**060**	37,54	**060**	43,76	**060**
M7	1,00	80	7,0	5,5	6,00	17	30	3	43,76	**070**								
M8	1,25	90	8,0	6,2	6,80	20	35	3	35,47	**080**	48,25	**080**	48,25	**080**	42,47	**080**	48,03	**080**
M10	1,50	100	10,0	8,0	8,50	22	39	3	42,57	**100**	67,24	**100**	67,24	**100**	51,30	**100**	58,62	**100**
M12	1,75	110	12,0	9,0	10,20	24	44	3	62,65	**120**								

P	**12**	**15**	**15**	**12**	**12**
M	**7**	**9**	**9**	**7**	**7**
K	**12**	**18**	**18**	**12**	**12**
N		**12**	**12**		
S					
H					
O					

1) Tol. ISO 1 4H ≤ M1.4

DIN 376 can be found on the next page

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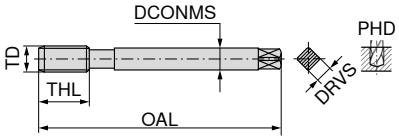
Through hole – Machine taps, right hand

M | Stabil



DIN 376 with reduced shank

	UNI	UNI	UNI	UNI
	B 4–5	B 4–5	B 4–5	B 4–5
	ISO 2 6H	ISO 2 6H	ISO 3 6G	7G
	nitr. + vap.	TiN	nitr. + vap.	nitr. + vap.
				
	HSS-E	HSS-E	HSS-E	HSS-E
	◁ 0° ≤ 1100 N/mm² ≤ 4xD	◁ 0° ≤ 1100 N/mm² ≤ 4xD	◁ 0° ≤ 1100 N/mm² ≤ 4xD	◁ 0° ≤ 1100 N/mm² ≤ 4xD
	22 502 ...	**22 504 ...**	**22 509 ...**	**22 511 ...**

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	EUR U0		EUR U0		EUR U0		EUR U0	
M3	0,50	56	2,2		2,5	11	3	61,45	**030**						
M4	0,70	63	2,8	2,1	3,3	13	3	40,93	**040**						
M5	0,80	70	3,5	2,7	4,2	15	3	39,08	**050**						
M6	1,00	80	4,5	3,4	5,0	17	3	38,32	**060**						
M8	1,25	90	6,0	4,9	6,8	20	3	42,02	**080**						
M10	1,50	100	7,0	5,5	8,5	22	3	48,69	**100**						
M12	1,75	110	9,0	7,0	10,2	24	3	47,60	**120**	77,39	**120**	58,95	**120**	66,59	**120**
M14	2,00	110	11,0	9,0	12,0	26	3	68,66	**140**	114,60	**140**				
M16	2,00	110	12,0	9,0	14,0	27	3	69,42	**160**	99,65	**160**	86,56	**160**	100,90	**160**
M18	2,50	125	14,0	11,0	15,5	30	3	136,50	**180**	180,00	**180**				
M20	2,50	140	16,0	12,0	17,5	32	3	106,20	**200**	185,50	**200**	132,10	**200**		
M22	2,50	140	18,0	14,5	19,5	32	3	170,40	**220**	275,10	**220**				
M24	3,00	160	18,0	14,5	21,0	34	3	138,60	**240**	234,70	**240**				
M27	3,00	160	20,0	16,0	24,0	36	3	193,20	**270**						
M30	3,50	180	22,0	18,0	26,5	40	4	227,10	**300**						
M33	3,50	180	25,0	20,0	29,5	40	4	524,00	**330**						
M36	4,00	200	28,0	22,0	32,0	50	4	624,40	**360**						
M42	4,50	200	32,0	24,0	37,5	56	4	1.189,00	**420**						
M48	5,00	250	36,0	29,0	43,0	65	4	1.200,00	**480**						

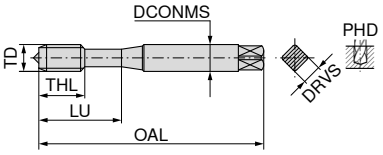
P	**12**	**15**	**12**	**12**
M	**7**	**9**	**7**	**7**
K	**12**	**18**	**12**	**12**
N		**12**		
S				
H				
O				

Through hole – Machine taps, right hand

▲ CNC = for synchronised CNC machining with minimum length compensation chuck

▲ NCW = with Weldon flat for synchronised CNC machining without length compensation chuck

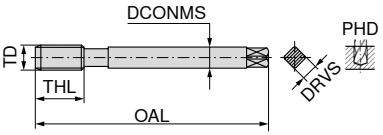
M | Stabil



DIN 371 with reinforced shank

	UNI NCW	UNI CNC	UNI CNC	UNI CNC
	B 4–5	B 4–5	B 4–5	B 4–5
	ISO 2 6H	ISO 2X 6HX	ISO 3X 6GX	7GX
	TiN	TiN GS	TiN GS	TiN GS
				
	HSS-PM ◁ 0° ≤ 1100 N/mm² ≤ 4xD	HSS-E ◁ 0° ≤ 1100 N/mm² ≤ 4xD	HSS-E ◁ 0° ≤ 1100 N/mm² ≤ 4xD	HSS-E ◁ 0° ≤ 1100 N/mm² ≤ 4xD
	22 148 ...	22 542 ...	22 596 ...	22 592 ...

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	EUR U0		EUR U0		EUR U0		EUR U0	
M3	0,50	70	6,0	4,9	2,5	6	18	3	51,52	030						
M3	0,50	56	3,5	2,7	2,5	6	18	3			39,08	030				
M4	0,70	70	6,0	4,9	3,3	7	21	3	53,59	040						
M4	0,70	63	4,5	3,4	3,3	7	21	3			41,48	040	50,00	040	50,00	040
M5	0,80	70	6,0	4,9	4,2	8	25	3	54,14	050	42,02	050	51,52	050	51,52	050
M6	1,00	80	6,0	4,9	5,0	10	30	3	68,11	060	53,37	060	56,43	060	62,98	060
M8	1,25	90	8,0	6,2	6,8	14	35	3	76,08	080						
M8	1,25	90	8,0	6,2	6,8	14	35	4			58,95	080	61,02	080	68,77	080
M10	1,50	100	10,0	8,0	8,5	16	39	3	93,44	100						
M10	1,50	100	10,0	8,0	8,5	16	39	4			73,36	100	76,08	100	82,64	100
M12	1,75	110	10,0	8,0	10,2	18		3	113,50	120						
M16	2,00	110	12,0	9,0	14,0	22		3	158,30	160						



DIN 376 with reduced shank

	22 543 ...	22 597 ...	22 593 ...
	EUR U0	EUR U0	EUR U0

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	EUR U0		EUR U0		EUR U0	
M12	1,75	110	9	7	10,2	18	4	85,37	120	92,90	120	100,10	120
M14	2,00	110	11	9	12,0	20	4	240,20	140				
M16	2,00	110	12	9	14,0	22	4	122,30	160				
M20	2,50	140	16	12	17,5	25	4	207,30	200				

P	15	15	15	15
M	8	9	9	9
K	15	18	18	18
N	22	12	12	12
S				
H				
O				

6

Through hole – Machine taps

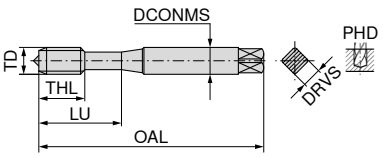
▲ LH = for left hand threads

M | Stabil

ST | ST LH

B 4–5

ISO 2 6H | ISO 2 6H

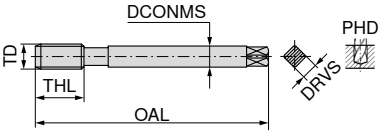


DIN 371 with reinforced shank

HSS-E
0°
≤ 750 N/mm²
≤ 4xD

HSS-E
0°
≤ 750 N/mm²
≤ 4xD

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	22 020 ... EUR U0		22 127 ... EUR U0	
M2	0,40	45	2,8	2,1	1,60	7	12	2	29,47	020		
M2,3	0,40	45	2,8	2,1	1,90	7	12	2	32,41	023		
M2,5	0,45	50	2,8	2,1	2,05	9	14	2	29,47	025		
M2,6	0,45	50	2,8	2,1	2,15	9	14	2	32,41	026		
M3	0,50	56	3,5	2,7	2,50	11	18	3	23,91	030	38,09	030
M3,5	0,60	56	4,0	3,0	2,90	12	20	3	25,53	035		
M4	0,70	63	4,5	3,4	3,30	13	21	3	24,23	040	39,73	040
M5	0,80	70	6,0	4,9	4,20	15	25	3	25,53	050	40,93	050
M6	1,00	80	6,0	4,9	5,00	17	30	3	25,53	060	40,93	060
M8	1,25	90	8,0	6,2	6,80	20	35	3	30,67	080	46,06	080
M10	1,50	100	10,0	8,0	8,50	22	39	3	36,78	100	58,62	100



DIN 376 with reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	22 021 ... EUR U0		22 147 ... EUR U0	
M5	0,80	70	3,5	2,7	4,2	15	3	30,24	050		
M6	1,00	80	4,5	3,4	5,0	17	3	31,00	060		
M8	1,25	90	6,0	4,9	6,8	20	3	32,96	080		
M10	1,50	100	7,0	5,5	8,5	22	3	37,54	100		
M12	1,75	110	9,0	7,0	10,2	24	3	45,62	120	70,08	120
M14	2,00	110	11,0	9,0	12,0	26	3	62,01	140		
M16	2,00	110	12,0	9,0	14,0	27	3	64,84	160	106,90	160
M18	2,50	125	14,0	11,0	15,5	30	3	95,40	180		
M20	2,50	140	16,0	12,0	17,5	32	3	96,71	200	157,20	200
M22	2,50	140	18,0	14,5	19,5	32	3	149,60	220		
M24	3,00	160	18,0	14,5	21,0	34	3	127,70	240		
M27	3,00	160	20,0	16,0	24,0	36	3	174,60	270		
M30	3,50	180	22,0	18,0	26,5	40	4	207,30	300		

P	12	12
M		
K	12	12
N	12	22
S		
H		
O		

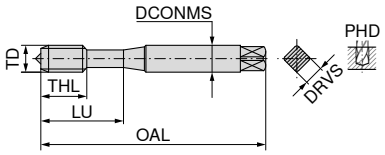
Through hole – Machine taps, right hand

▲ TS = for high-speed machining, up to 100 m/min.

M | Stabil

NEW

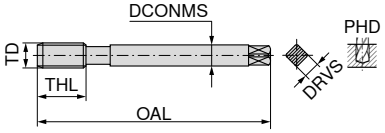
ST TS	HR	VG
B 4–5	B 4–5	B 4–5
ISO 2X 6HX	ISO 2X 6HX	ISO 2X 6HX
TiN	AlTiN-HD	TiN



DIN 371 with reinforced shank

	HSS-E	HSS-PM	HSS-E
	0° ≤ 1100 N/mm² ≤ 4xD	0° ≤ 1400 N/mm² ≤ 4xD	0° ≤ 1100 N/mm² ≤ 4xD
	22 092 ...	**22 468 ...**	**22 120 ...**

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	EUR U0		EUR U0		EUR U0	
M2	0,40	45	2,8	2,1	1,60	7	12	2			75,30	02000		
M2	0,40	45	2,8	2,1	1,60	4	12	2	50,65	020			44,31	020
M2,5	0,45	50	2,8	2,1	2,05	9	14	2			75,30	02500		
M2,5	0,45	50	2,8	2,1	2,05	5	15	2	50,65	025			44,31	025
M3	0,50	56	3,5	2,7	2,50	11	18	2			48,97	03000		
M3	0,50	56	3,5	2,7	2,50	6	18	3	39,73	030			32,64	030
M4	0,70	63	4,5	3,4	3,30	13	21	2			51,09	04000		
M4	0,70	63	4,5	3,4	3,30	7	21	3	43,33	040			35,04	040
M5	0,80	70	6,0	4,9	4,20	15	25	2			52,73	05000		
M5	0,80	70	6,0	4,9	4,20	8	25	3	47,37	050			37,33	050
M6	1,00	80	6,0	4,9	5,00	17	30	3			59,74	06000		
M6	1,00	80	6,0	4,9	5,00	10	30	3	57,63	060			45,41	060
M8	1,25	90	8,0	6,2	6,80	20	35	3			65,64	08000		
M8	1,25	90	8,0	6,2	6,80	14	35	4	72,70	080			48,03	080
M10	1,50	100	10,0	8,0	8,50	22	39	3			92,45	10000		
M10	1,50	100	10,0	8,0	8,50	16	39	4	78,81	100			68,77	100



DIN 376 with reduced shank

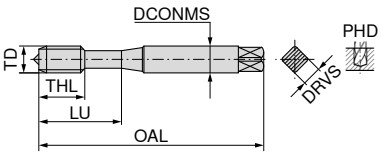
	22 093 ...		**22 121 ...**	
TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	EUR U0		EUR U0	
---	---	---	---	---	---	---	---	---	---	---	---
M12	1,75	110	9	7	10,2	18	4	106,00	120	81,43	120
M16	2,00	110	12	9	14,0	22	4	137,50	160	113,50	160
M20	2,50	140	16	12	17,5	25	4	205,30	200	191,00	200

P	**65**	**8**	**10**
M		**8**	**8**
K	**65**		
N	**75**	**10**	**22**
S		**4**	
H			
O			

6

Through hole – Machine taps, right hand

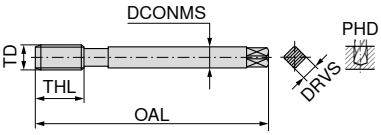
M | Stabil



DIN 371 with reinforced shank

	VA	VA		NW
	B 4–5	B 4–5	B 4–5	B 4–5
	ISO 2 6H	ISO 2 6H	ISO 2 6H	ISO 2 6H
	nitr.	TiN GS	vap.	DLC
	HSS-E ◁ 0° ≤ 900 N/mm² ≤ 4xD	HSS-E ◁ 0° ≤ 900 N/mm² ≤ 4xD	HSS-E ◁ 0° ≤ 500 N/mm² ≤ 4xD	HSS-E ◁ 0° ≤ 880 N/mm² ≤ 4xD

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	22 056 ... EUR U0		22 038 ... EUR U0		22 058 ... EUR U0		22 464 ... EUR U0	
M1,6	0,35	40	2,5	2,1	1,25	6	11	2			58,62	016				
M2	0,40	45	2,8	2,1	1,60	7	12	2	33,40	020	48,03	020	32,41	020	43,67	02000
M2,3	0,40	45	2,8	2,1	1,90	7	12	2					37,33	023		
M2,5	0,45	50	2,8	2,1	2,05	9	14	2	32,96	025	46,61	025	32,41	025	43,67	02500
M2,6	0,45	50	2,8	2,1	2,15	9	14	2					37,00	026		
M3	0,50	56	3,5	2,7	2,50	11	18	3	26,75	030	39,95	030	25,76	030	33,48	03000
M3,5	0,60	56	4,0	3,0	2,90	12	20	3	30,01	035			26,75	035		
M4	0,70	63	4,5	3,4	3,30	13	21	3	28,06	040	42,02	040	25,76	040	33,98	04000
M5	0,80	70	6,0	4,9	4,20	15	25	3	29,04	050	43,33	050	26,75	050	34,47	05000
M6	1,00	80	6,0	4,9	5,00	17	30	3	30,24	060	53,92	060	26,75	060	34,47	06000
M8	1,25	100	8,0	6,2	6,80	20	35	3							40,30	08000
M8	1,25	90	8,0	6,2	6,80	20	35	3	33,63	080	59,71	080	31,87	080		
M10	1,50	110	10,0	8,0	8,50	22	39	3							50,77	10000
M10	1,50	100	10,0	8,0	8,50	22	39	3	41,48	100	74,12	100	38,09	100		



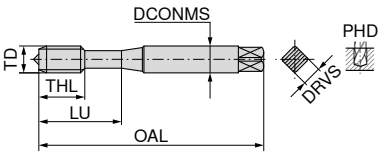
DIN 376 with reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	22 057 ... EUR U0		22 039 ... EUR U0		22 059 ... EUR U0		22 465 ... EUR U0	
M12	1,75	110	9	7,0	10,2	24	3	52,73	120	88,31	120	48,03	120	61,14	12000
M14	2,00	110	11	9,0	12,0	26	3	72,70	140	126,60	140				
M16	2,00	110	12	9,0	14,0	27	3	75,31	160	124,50	160	68,11	160	78,92	16000
M18	2,50	125	14	11,0	15,5	30	3	145,10	180						
M20	2,50	140	16	12,0	17,5	32	3	108,20	200	209,60	200			125,90	20000
M22	2,50	140	18	14,5	19,5	32	3	229,30	220						
M24	3,00	160	18	14,5	21,0	34	3	147,40	240						
M27	3,00	160	20	16,0	24,0	36	3	247,80	270						
M30	3,50	180	22	18,0	26,5	40	4	237,90	300						

P	8	10	15	
M	6	8	6	
K				
N				15
S				
H				
O				

Through hole – Machine taps, right hand

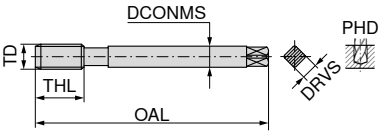
M | Stabil



DIN 371 with reinforced shank

	Ti	Ti	Ti
	B 4–5	B 4–5	B 4–5
	ISO 1X 4HX	ISO 2X 6HX	ISO 2X 6HX
	TiN	vap.	TiN
			
	HSS-PM	HSS-PM	HSS-PM
	0° ≤ 44 HRC ≤ 4xD	0° ≤ 1400 N/mm² ≤ 4xD	0° ≤ 44 HRC ≤ 4xD
	22 081 ...	**22 075 ...**	**22 077 ...**
	EUR U0	EUR U0	EUR U0

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes					
M1,6	0,35	40	2,5	2,1	1,25	8	9,5	3			108,20	**016**	
M2	0,40	45	2,8	2,1	1,60	8	9,5	3	77,94	**020**	86,56	**020**	
M2,5	0,45	50	2,8	2,1	2,05	9	14,0	3			84,82	**025**	
M3	0,50	56	3,5	2,7	2,50	11	18,0	3	53,59	**030**	59,38	**030**	56,76 **030**
M3,5	0,60	56	4,0	3,0	2,90	12	20,0	3			67,90	**035**	
M4	0,70	63	4,5	3,4	3,30	13	21,0	3	55,13	**040**	62,33	**040**	58,95 **040**
M5	0,80	70	6,0	4,9	4,20	15	25,0	3	56,76	**050**	62,33	**050**	59,38 **050**
M6	1,00	80	6,0	4,9	5,00	17	30,0	3	63,30	**060**	64,08	**060**	60,80 **060**
M8	1,25	90	8,0	6,2	6,80	20	35,0	3	76,08	**080**	73,36	**080**	70,08 **080**
M10	1,50	100	10,0	8,0	8,50	22	39,0	3			85,37	**100**	84,15 **100**



DIN 376 with reduced shank

									22 140 ...		**22 142 ...**	
									EUR U0		EUR U0	
M12	1,75	110	9	7	10,2	24	3		103,40	**120**	92,12	**120**

P	**7**	**5**	**7**
M	**7**	**5**	**7**
K			
N			
S	**5**	**3**	**5**
H			
O			

6

Through hole – Machine taps, right hand

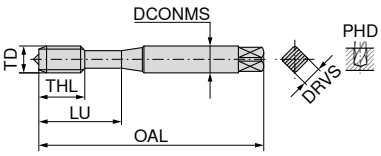
M | DL

Ti | Ni

D 4–5

ISO 2X 6HX

TiCN

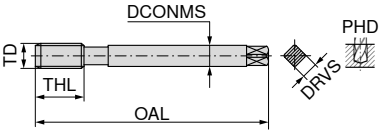


DIN 371 with reinforced shank

HSS-E
◁ 15°
≤ 1200 N/mm²
≤ 4xD

HSS-E
◁ 15°
≤ 1600 N/mm²
≤ 4xD

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	22 159 ... EUR U0		22 297 ... EUR U0	
M3	0,50	56	3,5	2,7	2,5	11	18	2	47,48	**030**	56,76	**030**
M4	0,70	63	4,5	3,4	3,3	13	21	3	51,95	**040**	59,27	**040**
M5	0,80	70	6,0	4,9	4,2	15	25	3	52,28	**050**	60,70	**050**
M6	1,00	80	6,0	4,9	5,0	17	30	3	69,86	**060**	76,75	**060**
M8	1,25	90	8,0	6,2	6,8	20	35	3	76,75	**080**	85,14	**080**
M10	1,50	100	10,0	8,0	8,5	22	39	3	94,42	**100**	106,60	**100**



DIN 376 with reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	22 160 ... EUR U0		22 298 ... EUR U0	
M12	1,75	110	9	7,0	10,2	24	3	109,00	**120**	123,40	**120**
M16	2,00	110	12	9,0	14,0	27	3	154,00	**160**	172,40	**160**
M20	2,50	140	16	12,0	17,5	32	3	266,30	**200**	294,70	**200**
M24	3,00	160	18	14,5	21,0	34	3	312,20	**240**		

P	**7**	
M	**7**	
K		
N	**22**	**22**
S	**5**	**2**
H		
O		

Through hole – Machine taps, right hand

▲ EL = extra long, with double overall length

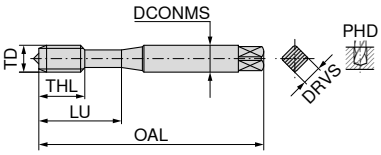
M | Stabil

UNI EL | ST EL

B 4–5

ISO 2 6H

nitr. + vap.

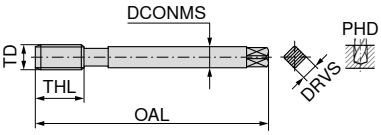


DIN 371 with reinforced shank

HSS-E
0°
≤ 1100 N/mm²
≤ 4xD

HSS-E
0°
≤ 950 N/mm²
≤ 4xD

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	22 514 ... EUR U0		22 233 ... EUR U0	
M3	0,50	100	3,5	2,7	2,5	11	18	3	63,30	030	61,79	030
M4	0,70	125	4,5	3,4	3,3	13	21	3	63,30	040	59,27	040
M5	0,80	140	6,0	4,9	4,2	15	25	3	70,08	050	64,74	050
M6	1,00	160	6,0	4,9	5,0	17	30	3	77,29	060	67,57	060
M8	1,25	180	8,0	6,2	6,8	20	35	3	82,64	080	80,56	080



DIN 376 with reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	22 515 ... EUR U0		22 234 ... EUR U0	
M6	1,00	160	4,5	3,4	5,0	17	3	64,40	060	67,57	060
M8	1,25	180	6,0	4,9	6,8	20	3	79,58	080	80,56	080
M10	1,50	200	7,0	5,5	8,5	22	3	87,32	100	89,72	100
M12	1,75	224	9,0	7,0	10,2	24	3	108,20	120	108,20	120
M14	2,00	224	11,0	9,0	12,0	26	3	163,80	140	174,60	140
M16	2,00	224	12,0	9,0	14,0	27	3	209,60	160	168,10	160
M18	2,50	250	14,0	11,0	15,5	30	3	250,00	180	253,30	180
M20	2,50	280	16,0	12,0	17,5	32	3	219,40	200	228,20	200

P	12	12
M	7	
K	12	12
N		22
S		
H		
O		

Through hole – Machine taps, right hand

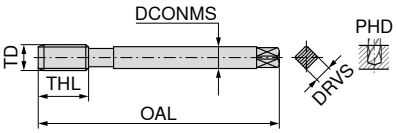
▲ MMB = Nut taps

M

ST
MMB

≈ 20

ISO 2
6H



DIN 357 with reduced shank

HSS-E
0°
≤ 850 N/mm²
≤ 1xD

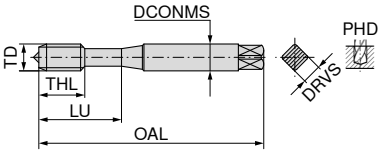
22 098 ...

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	EUR U0	
M3	0,50	70	2,2		2,5	16	3	46,61	**030**
M4	0,70	90	2,8	2,1	3,3	22	3	46,61	**040**
M5	0,80	100	3,5	2,7	4,2	24	3	48,79	**050**
M6	1,00	110	4,5	3,4	5,0	30	3	48,79	**060**
M8	1,25	125	6,0	4,9	6,8	38	3	60,26	**080**
M10	1,50	140	7,0	5,5	8,5	45	3	68,77	**100**
M12	1,75	180	9,0	7,0	10,2	50	3	92,12	**120**
M16	2,00	200	12,0	9,0	14,0	63	3	131,00	**160**

P	**15**
M	
K	
N	
S	
H	
O	

Through hole – Machine taps, right hand

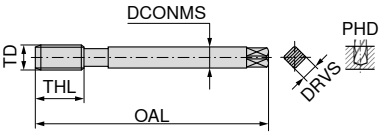
M



DIN 371 with reinforced shank

	UNI	UNI	UNI
	B 4–5	B 4–5	B 4–5
	ISO 2 6H	ISO 2 6H	ISO 2 6H
	nitr. + vap.	TiN	TiN
			
	HSS-E	HSS-E	HSS-PM
	0° ≤ 1000 N/mm² ≤ 3xD	0° ≤ 1000 N/mm² ≤ 3xD	0° ≤ 1000 N/mm² ≤ 3xD

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	23 110 ... EUR T9		23 112 ... EUR T9		23 010 ... EUR T9	
M2	0,40	45	2,8	2,1	1,60	7	12,0	2	12,31	020	14,48	020		
M2	0,40	45	2,8	2,1	1,60	4	13,5	2					10,03	020
M2,5	0,45	50	2,8	2,1	2,05	9	14,0	2	12,10	025	16,14	025		
M3	0,50	56	3,5	2,7	2,50	11	18,0	3	8,20	030	10,44	030	12,51	030
M4	0,70	63	4,5	3,4	3,30	13	21,0	3	8,36	040	11,38	040	11,48	040
M5	0,80	70	6,0	4,9	4,20	15	25,0	3	8,36	050	11,48	050	12,83	050
M6	1,00	80	6,0	4,9	5,00	17	30,0	3	8,52	060	14,59	060	15,31	060
M8	1,25	90	8,0	6,2	6,80	20	35,0	3	9,87	080	15,82	080	17,06	080
M10	1,50	100	10,0	8,0	8,50	22	39,0	3	11,79	100	19,55	100	22,54	100



DIN 376 with reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	23 111 ... EUR T9		23 113 ... EUR T9		23 021 ... EUR T9	
M3	0,50	56	2,2		2,5	11	3	8,88	030				
M4	0,70	63	2,8	2,1	3,3	13	3	8,74	040				
M5	0,80	70	3,5	2,7	4,2	15	3	8,74	050				
M6	1,00	80	4,5	3,4	5,0	17	3	9,18	060				
M8	1,25	90	6,0	4,9	6,8	20	3	10,76	080				
M10	1,50	100	7,0	5,5	8,5	22	3	12,41	100				
M12	1,75	110	9,0	7,0	10,2	24	3	14,89	120	23,17	120	26,89	120
M14	2,00	110	11,0	9,0	12,0	26	3	21,52	140	40,32	14000		
M14	2,00	110	11,0	9,0	12,0	20	4					40,75	140
M16	2,00	110	12,0	9,0	14,0	27	3	22,03	160	32,78	160	37,86	160
M18	2,50	125	14,0	11,0	15,5	30	3			63,97	18000		
M18	2,50	125	14,0	11,0	15,5	25	4					66,30	180
M20	2,50	140	16,0	12,0	17,5	32	3	35,06	200	56,37	200	68,47	200
M22	2,50	140	18,0	14,5	19,5	32	3			94,73	22000		
M24	3,00	160	18,0	14,5	21,0	34	3			84,91	240		
M27	3,00	160	20,0	16,0	24,0	36	3			118,50	27000		
M30	3,50	180	22,0	18,0	26,5	40	4			132,90	30000		
M33	3,50	180	25,0	20,0	29,5	40	4			174,30	33000		
M36	4,00	200	28,0	22,0	32,0	50	4			213,50	36000		

P	12	15	15
M	7	9	9
K	12	18	18
N		12	12
S			
H			
O			

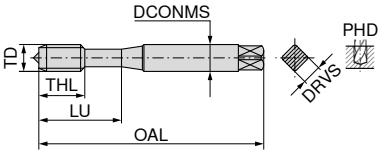
6

Through hole – Machine taps, right hand

▲ NCW = with Weldon flat for synchronised CNC machining without length compensation chuck

▲ NC = for synchronised CNC machining with minimum length compensation chuck

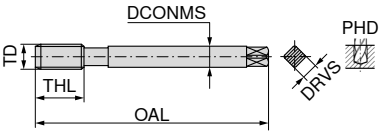
M



DIN 371 with reinforced shank

	UNI NC	UNI NCW	FE	FE-HF
	B 4–5	B 4–5	B 4–5	B 4–5
	ISO 2 6H	ISO 2 6H	ISO 2 6H	ISO 2 6H
	TiN GS	TiCN		TiCN
				
	HSS-E ◁ 0° ≤ 1000 N/mm² ≤ 3xD	HSS-PM ◁ 0° ≤ 1000 N/mm² ≤ 3xD	HSS-E ◁ 0° ≤ 850 N/mm² ≤ 3xD	HSS-E ◁ 0° ≤ 1100 N/mm² ≤ 3xD
	23 114 ...	23 116 ...	23 212 ...	23 310 ...

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	23 114 ... EUR T9		23 116 ... EUR T9		23 212 ... EUR T9		23 310 ... EUR T9	
M1,6	0,35	40	2,5	2,1	1,25	6	11	2					25,55	016		
M2	0,40	45	2,8	2,1	1,60	7	12	2					17,28	020		
M2,5	0,45	50	2,8	2,1	2,05	9	14	2					14,48	025		
M3	0,50	70	6,0	4,9	2,50	6	18	3			21,20	030				
M3	0,50	56	3,5	2,7	2,50	11	18	3	17,68	030			11,48	030	16,76	030
M3,5	0,60	56	4,0	3,0	2,90	12	20	3					12,93	035		
M4	0,70	70	6,0	4,9	3,30	7	21	3			24,20	040				
M4	0,70	63	4,5	3,4	3,30	13	21	3	19,23	040			11,48	040	17,79	040
M5	0,80	70	6,0	4,9	4,20	15	25	3	19,35	050			11,90	050	18,00	050
M5	0,80	70	6,0	4,9	4,20	8	25	3			24,61	050				
M6	1,00	80	6,0	4,9	5,00	17	30	3	28,34	060			11,90	060	24,61	060
M6	1,00	80	6,0	4,9	5,00	10	30	3			24,61	060				
M8	1,25	90	8,0	6,2	6,80	20	35	3	29,99	080			15,41	080	26,58	080
M8	1,25	90	8,0	6,2	6,80	14	35	3			31,13	080				
M10	1,50	100	10,0	8,0	8,50	22	39	3	37,75	100			18,41	100	33,40	100
M10	1,50	100	10,0	8,0	8,50	16	39	3			37,54	100				



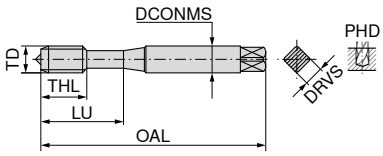
DIN 376 with reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	23 115 ... EUR T9		23 117 ... EUR T9		23 213 ... EUR T9		23 311 ... EUR T9	
M12	1,75	110	10	8	10,2	18	3			46,95	120				
M12	1,75	110	9	7	10,2	24	3	43,54	120			24,83	120	38,68	120
M14	2,00	110	11	9	12,0	26	3					29,89	140		
M16	2,00	110	12	9	14,0	22	3			63,19	160				
M16	2,00	110	12	9	14,0	27	3	59,05	160			37,65	160	53,68	160
M20	2,50	140	16	12	17,5	32	3	107,60	200			58,85	200	94,84	200

P	15	15	12	15
M	9	8		
K	18	15	12	15
N	12	22	12	15
S				
H				
O				

Through hole – Machine taps, right hand

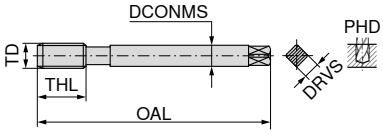
M



DIN 371 with reinforced shank

	VA	VA	VA	AL	AL
	B 4–5	B 4–5	B 4–5	B 4–5	B 4–5
	ISO 2 6H	ISO 2 6H	ISO 2 6H	ISO 2 6H	ISO 2 6H
	nitr.	nitr.	TiN		CrN
					
	HSS-PM	HSS-E	HSS-E	HSS-E	HSS-E
	◁ 0° ≤ 1200 N/mm² ≤ 3xD	◁ 0° ≤ 1200 N/mm² ≤ 3xD	◁ 0° ≤ 1200 N/mm² ≤ 3xD	◁ 0° ≤ 500 N/mm² ≤ 3xD	◁ 0° ≤ 500 N/mm² ≤ 3xD
	23 450 ...	**23 410 ...**	**23 412 ...**	**23 610 ...**	**23 612 ...**

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	EUR T9		EUR T9		EUR T9		EUR T9		EUR T9	
M2	0,40	45	2,8	2,1	1,60	7	12	2			12,72	020	23,38	020				
M2,5	0,45	50	2,8	2,1	2,05	9	14	2			14,69	025	19,65	025				
M3	0,50	56	3,5	2,7	2,50	11	18	3	11,68	030	8,36	030	15,52	030	11,48	030	13,03	030
M4	0,70	63	4,5	3,4	3,30	13	21	3	11,79	040	8,36	040	17,28	040	11,48	040	13,45	040
M5	0,80	70	6,0	4,9	4,20	15	25	3	12,72	050	8,71	050	17,68	050	11,90	050	13,85	050
M6	1,00	80	6,0	4,9	5,00	17	30	3	12,93	060	8,71	060	23,17	060	11,90	060	13,85	060
M8	1,25	90	8,0	6,2	6,80	20	35	3	14,48	080	11,18	080	24,72	080	15,41	080	15,82	080
M10	1,50	100	10,0	8,0	8,50	22	39	3	16,44	100	13,55	100	34,03	100	18,41	100	19,45	100

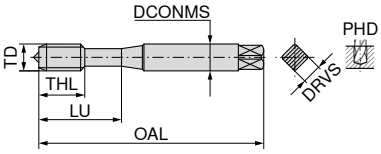


DIN 376 with reduced shank

								23 451 ...		**23 411 ...**		**23 413 ...**		**23 611 ...**		**23 613 ...**	
TD mm	**TP mm**	**OAL mm**	**DCONMS mm**	**DRVS mm**	**PHD mm**	**THL mm**	**Flutes**	**EUR T9**		**EUR T9**		**EUR T9**		**EUR T9**		**EUR T9**	
M12	1,75	110	9	7,0	10,2	24	3	29,27	120	18,00	120	37,54	120	24,83	120	24,41	120
M14	2,00	110	11	9,0	12,0	26	3	38,78	140								
M16	2,00	110	12	9,0	14,0	27	3	41,06	160	27,72	160	46,85	160				
M20	2,50	140	16	12,0	17,5	32	3	61,34	200	42,41	200	81,91	200				
M24	3,00	160	18	14,5	21,0	34	3			56,06	240						
P									**8**		**8**		**10**				
M									**6**		**6**		**8**				
K																	
N									**22**		**22**		**24**		**15**		**15**
S																	
H																	
O																	

Blind hole – Machine taps, right hand

M | Salo-Rex

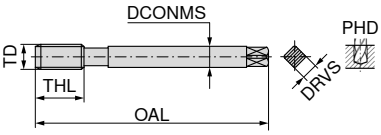


DIN 371 with reinforced shank

UNI	UNI	UNI	UNI
C 2–3	C 2–3	C 2–3	C 2–3
ISO 2 6H	7G	ISO 2 6H	ISO 2 6H
vap.	vap.	TiN	TiCN

HSS-E
◁ 42°
≤ 1100 N/mm²
≤ 3xD

TD	TP	OAL	DCONMS	DRVS	PHD	THL	LU	Flutes	22 518 ... EUR U0		22 532 ... EUR U0		22 520 ... EUR U0		22 522 ... EUR U0	
mm	mm	mm	mm	mm	mm	mm	mm									
M2	0,40	45	2,8	2,1	1,60	4,0	12	2	34,82	020			50,00	020		
M2,2	0,45	45	2,8	2,1	1,75	4,5	12	2	39,41	022						
M2,3	0,40	45	2,8	2,1	1,90	4,5	12	2	41,70	023						
M2,5	0,45	50	2,8	2,1	2,05	5,0	15	2	33,40	025						
M2,6	0,45	50	2,8	2,1	2,15	5,0	15	2	39,73	026						
M3	0,50	56	3,5	2,7	2,50	6,0	18	3	29,69	030	34,82	030	37,54	030	37,54	030
M3,5	0,60	56	4,0	3,0	2,90	7,0	20	3	32,09	035						
M4	0,70	63	4,5	3,4	3,30	7,0	21	3	31,33	040	34,82	040	40,17	040	40,17	040
M5	0,80	70	6,0	4,9	4,20	8,0	25	3	31,65	050	37,33	050	40,49	050	40,49	050
M6	1,00	80	6,0	4,9	5,00	10,0	30	3	32,64	060	50,00	060	47,70	060	47,70	060
M7	1,00	80	7,0	5,5	6,00	10,0	30	3	48,03	070						
M8	1,25	90	8,0	6,2	6,80	14,0	35	3	38,42	080	58,40	080	52,61	080	53,05	080
M10	1,50	100	10,0	8,0	8,50	16,0	39	3	46,06	100	86,56	100	62,65	100	62,65	100
M12	1,75	110	12,0	9,0	10,20	18,0	44	3	50,65	120			76,75	120	79,79	120



DIN 376 with reduced shank

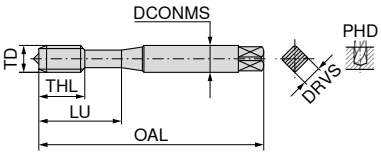
TD	TP	OAL	DCONMS	DRVS	PHD	THL	Flutes	22 519 ... EUR U0		22 533 ... EUR U0		22 521 ... EUR U0		22 523 ... EUR U0	
mm	mm	mm	mm	mm	mm	mm									
M3	0,50	56	2,2		2,5	6	3	51,85	030						
M4	0,70	63	2,8	2,1	3,3	7	3	49,01	040						
M5	0,80	70	3,5	2,7	4,2	8	3	34,82	050						
M6	1,00	80	4,5	3,4	5,0	10	3	36,68	060						
M8	1,25	90	6,0	4,9	6,8	14	3	40,93	080						
M10	1,50	100	7,0	5,5	8,5	16	3	51,52	100						
M12	1,75	110	9,0	7,0	10,2	18	3	54,03	120	65,16	120	75,53	120	83,07	120
M14	2,00	110	11,0	9,0	12,0	20	3	72,58	140			121,10	140	136,50	140
M16	2,00	110	12,0	9,0	14,0	22	3	77,29	160	101,50	160	109,20	160	110,20	160
M18	2,50	125	14,0	11,0	15,5	25	3	117,90	180			189,90	180	206,30	180
M20	2,50	140	16,0	12,0	17,5	25	3	117,90	200	157,20	200	186,70	200	197,60	200
M22	2,50	140	18,0	14,5	19,5	27	4	163,80	220			275,10	220		
M24	3,00	160	18,0	14,5	21,0	30	4	147,40	240			240,20	240		
M27	3,00	160	20,0	16,0	24,0	30	4	194,40	270						
M30	3,50	180	22,0	18,0	26,5	35	4	250,00	300						
M33	3,50	180	25,0	20,0	29,5	35	4	479,20	330						
M36	4,00	200	28,0	22,0	32,0	40	4	397,30	360						

P	12	12	15	15
M	7	7	9	9
K	12	12	18	18
N			12	12
S				
H				
O				

Blind hole – Machine taps, right hand

▲ NCW = with Weldon flat for synchronised CNC machining without length compensation chuck

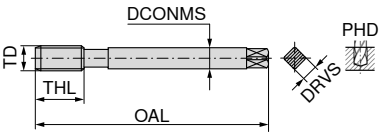
M | Salo-Rex



DIN 371 with reinforced shank

	UNI NCW	UNI	UNI	UNI
	C 2–3	E 1,5–2	E 1,5–2	E 1,5–2
	ISO 2 6H	ISO 2 6H	ISO 2 6H	ISO 2 6H
	TiN	vap.	vap.	TiN
				
				
	HSS-PM ◁ 42° ≤ 1100 N/mm² ≤ 3xD	HSS-E ◁ 42° ≤ 1100 N/mm² ≤ 3xD	HSS-E ◁ 42° ≤ 1100 N/mm² ≤ 3xD	HSS-E ◁ 42° ≤ 1100 N/mm² ≤ 3xD
	22 149 ...	22 524 ...	22 534 ...	22 526 ...

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	EUR U0		EUR U0		EUR U0		EUR U0	
M3	0,50	70	6,0	4,9	2,5	6	18	3	52,73	030						
M3	0,50	56	3,5	2,7	2,5	6	18	3			31,00	030			35,04	030
M4	0,70	63	4,5	3,4	3,3	7	21	3			31,00	040			38,32	040
M4	0,70	70	6,0	4,9	3,3	7	21	3	57,63	040						
M5	0,80	70	6,0	4,9	4,2	8	25	3	59,71	050	32,41	050	48,79	050	39,08	050
M6	1,00	80	6,0	4,9	5,0	10	30	3	73,36	060	32,41	060	48,79	060	46,29	060
M8	1,25	90	8,0	6,2	6,8	14	35	3	81,98	080	37,00	080	54,14	080	50,65	080
M10	1,50	100	10,0	8,0	8,5	16	39	3	100,90	100	45,07	100	65,16	100	60,80	100



DIN 376 with reduced shank

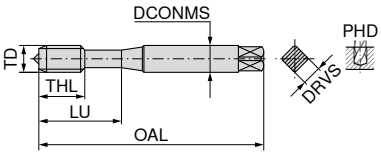
								22 149 ...		22 525 ...		22 535 ...		22 527 ...	
TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	EUR U0		EUR U0		EUR U0		EUR U0	
M12	1,75	110	10	8,0	10,2	18	3	121,10	120						
M12	1,75	110	9	7,0	10,2	18	4			57,31	120	74,12	120	73,36	120
M14	2,00	110	11	9,0	12,0	20	4			93,44	140	108,20	140		
M16	2,00	110	12	9,0	14,0	22	3	162,60	160						
M16	2,00	110	12	9,0	14,0	22	4			80,11	160	106,90	160	105,50	160
M18	2,50	125	14	11,0	15,5	25	4			146,40	180				
M20	2,50	140	16	12,0	17,5	25	4			124,50	200	159,40	200	179,00	200
M22	2,50	140	18	14,5	19,5	27	5			199,80	220				
M24	3,00	160	18	14,5	21,0	30	5			174,60	240				
P									15		12		12		15
M									8		7		7		9
K									15		12		12		18
N									22						12
S															
H															
O															

6

Blind hole – Machine taps, right hand

▲ CNC = for synchronised CNC machining with minimum length compensation chuck

M | Salo-Rex

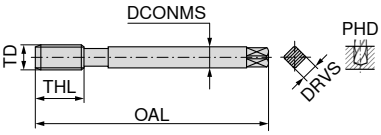


DIN 371 with reinforced shank

	UNI CNC	UNI CNC	UNI CNC	UNI CNC
	C 2–3	C 2–3	E 1,5–2	C 2–3
	ISO 2X 6HX	ISO 2 6H	ISO 2 6H	7G
	TiN	TiN GS	TiN GS	TiN GS

	HSS-E ◁ 50° ≤ 1100 N/mm² ≤ 3xD	HSS-E ◁ 45° ≤ 1100 N/mm² ≤ 3xD	HSS-E ◁ 45° ≤ 1100 N/mm² ≤ 3xD	HSS-E ◁ 45° ≤ 1100 N/mm² ≤ 3xD
	22 416 ...	**22 544 ...**	**22 546 ...**	**22 594 ...**

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	EUR U0		EUR U0		EUR U0		EUR U0	
M3	0,50	56	3,5	2,7	2,5	6	18	3	50,97	**030**	45,07	**030**			51,85	**030**
M4	0,70	63	4,5	3,4	3,3	7	21	3	53,37	**040**	46,06	**040**			52,40	**040**
M5	0,80	70	6,0	4,9	4,2	8	25	3	54,80	**050**	47,70	**050**	68,11	**050**	53,92	**050**
M6	1,00	80	6,0	4,9	5,0	10	30	3	66,25	**060**	49,34	**060**	68,77	**060**	58,95	**060**
M8	1,25	90	8,0	6,2	6,8	14	35	3	73,68	**080**	61,67	**080**	88,31	**080**	72,70	**080**
M10	1,50	100	10,0	8,0	8,5	16	39	3	91,26	**100**	70,08	**100**	101,50	**100**	80,66	**100**



DIN 376 with reduced shank

									22 417 ...		**22 545 ...**			**22 595 ...**	
TD mm	**TP mm**	**OAL mm**	**DCONMS mm**	**DRVS mm**	**PHD mm**	**THL mm**	**Flutes**		**EUR U0**		**EUR U0**			**EUR U0**	
M12	1,75	110	9	7	10,2	18	3		107,50	**120**					
M12	1,75	110	9	7	10,2	18	4				95,40	**120**		108,20	**120**
M14	2,00	110	11	9	12,0	20	3		154,00	**140**					
M14	2,00	110	11	9	12,0	20	4				116,80	**140**		128,80	**140**
M16	2,00	110	12	9	14,0	22	3		149,60	**160**					
M16	2,00	110	12	9	14,0	22	4				127,70	**160**		139,70	**160**
M20	2,50	140	16	12	17,5	25	3		256,60	**200**					
M20	2,50	140	16	12	17,5	25	4				185,50	**200**		204,20	**200**

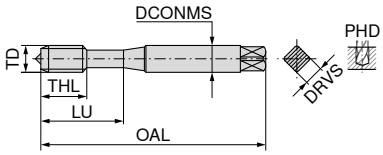
P	**15**	**15**	**15**	**15**
M	**9**	**9**	**9**	**9**
K	**18**	**18**	**18**	**18**
N	**22**	**12**	**12**	**12**
S				
H				
O				

Blind hole – Machine taps, right hand

▲ DRY = for dry machining or minimum quantity lubrication (MMS)

M | Salo-Rex

UNI DRY | C 2–3 | ISO 2 6H | TiN

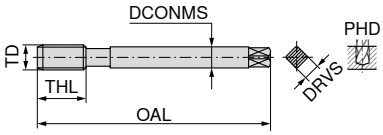


DIN 371 with reinforced shank

HSS-E
42°
≤ 1100 N/mm²
≤ 3xD

22 449 ...

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	EUR U0	
M5	0,80	70	6	4,9	4,2	8	25	3	69,86	**050**
M6	1,00	80	6	4,9	5,0	10	30	3	81,33	**060**
M8	1,25	90	8	6,2	6,8	14	35	3	89,72	**080**
M10	1,50	100	10	8,0	8,5	16	39	3	109,00	**100**



DIN 376 with reduced shank

22 450 ...

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	EUR U0	
M12	1,75	110	9	7	10,2	18	4	119,00	**120**
M16	2,00	110	12	9	14,0	22	4	168,10	**160**
M20	2,50	140	16	12	17,5	25	4	275,10	**200**

P	**12**
M	
K	**12**
N	**22**
S	
H	
O	

6

Blind hole – Machine taps, right hand

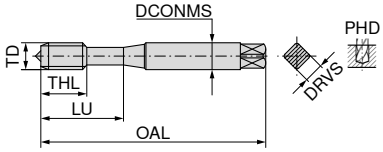
▲ CNC = for synchronised CNC machining with minimum length compensation chuck

▲ TS = for high-speed machining, up to 100 m/min.

M | SL

NEW

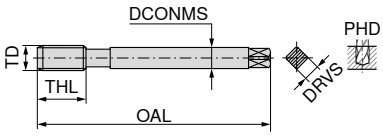
	ST TS	ST CNC	HR	ST CNC
	C 2–3	C 2–3	C 2–3	C 2–3
	ISO 2X 6HX	ISO 2X 6HX	ISO 2 6H	ISO 2X 6HX
	TiN	TiN	AlTiN-HD	TiN



DIN 371 with reinforced shank

	HSS-E	HSS-E	HSS-PM	HSS-E
	◁ 15° ≤ 1050 N/mm² ≤ 2xD	◁ 15° ≤ 1100 N/mm² ≤ 2xD	◁ 25° ≤ 1400 N/mm² ≤ 2xD	◁ 15° ≤ 1100 N/mm² ≤ 2xD
	22 406 ...	**22 328 ...**	**22 469 ...**	**22 443 ...**

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	EUR U0		EUR U0		EUR U0		EUR U0	
M3	0,50	56	3,5	2,7	2,5	6	18	2	48,03	030	43,76	030				
M3	0,50	56	3,5	2,7	2,5	11	18	3					38,89	03000		
M4	0,70	63	4,5	3,4	3,3	13	21	3					46,04	04000		
M4	0,70	63	4,5	3,4	3,3	7	21	3	50,97	040	45,62	040				
M5	0,80	70	6,0	4,9	4,2	15	25	3					47,08	05000		
M5	0,80	70	6,0	4,9	4,2	8	25	3	52,61	050	47,48	050			69,86	050
M6	1,00	80	6,0	4,9	5,0	17	30	3					48,74	06000		
M6	1,00	80	6,0	4,9	5,0	10	30	3	64,08	060	58,62	060			81,33	060
M8	1,25	90	8,0	6,2	6,8	20	35	3					53,19	08000		
M8	1,25	90	8,0	6,2	6,8	14	35	3	71,49	080	66,25	080			89,07	080
M10	1,50	100	10,0	8,0	8,5	22	39	3					65,18	10000		
M10	1,50	100	10,0	8,0	8,5	16	39	3	87,32	100	81,33	100			108,20	100
M12	1,75	110	12,0	9,0	10,2	24	44	3					77,82	12000		



DIN 376 with reduced shank

								22 407 ...		22 329 ...				22 444 ...	
TD mm	**TP mm**	**OAL mm**	**DCONMS mm**	**DRVS mm**	**PHD mm**	**THL mm**	**Flutes**	EUR U0		EUR U0				EUR U0	
M12	1,75	110	9	7	10,2	18	3	104,30	120	95,18	120			121,10	120
M16	2,00	110	12	9	14,0	22	3	146,40	160	137,50	160			170,40	160
M20	2,50	140	16	12	17,5	25	3	239,10	200	228,20	200				

P	65	12	8	12
M		8	8	8
K	65	20		20
N	22	22	10	22
S			4	
H				
O				

Blind hole – Machine taps

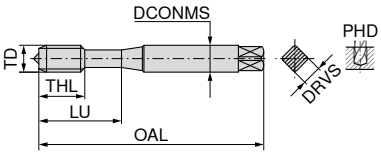
▲ LH = for left hand threads

M | Salo-Rex

ST | C 2–3 | ISO 2 6H

ST | C 2–3 | ISO 2 6H | TiN

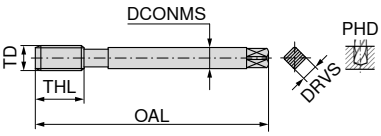
ST LH | C 2–3 | ISO 2 6H



DIN 371 with reinforced shank

HSS-E
∢ 42°
≤ 750 N/mm²
≤ 3xD

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	22 082 ... EUR U0		22 084 ... EUR U0		22 138 ... EUR U0	
M2	0,40	45	2,8	2,1	1,60	4,0	12	2	32,41	020	41,70	020		
M2,3	0,40	45	2,8	2,1	1,90	4,5	12	2	36,03	023				
M2,5	0,45	50	2,8	2,1	2,05	5,0	15	2	31,44	025				
M3	0,50	56	3,5	2,7	2,50	6,0	18	3	27,40	030	34,05	030	47,37	030
M3,5	0,60	56	4,0	3,0	2,90	7,0	20	3	30,24	035				
M4	0,70	63	4,5	3,4	3,30	7,0	21	3	27,30	040	34,82	040	42,67	040
M5	0,80	70	6,0	4,9	4,20	8,0	25	3	27,73	050	35,04	050	46,06	050
M6	1,00	80	6,0	4,9	5,00	10,0	30	3	28,38	060	43,99	060	44,31	060
M8	1,25	90	8,0	6,2	6,80	14,0	35	3	34,05	080	49,34	080	53,37	080
M10	1,50	100	10,0	8,0	8,50	16,0	39	3	40,17	100	66,59	100	61,45	100



DIN 376 with reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	22 083 ... EUR U0		22 085 ... EUR U0		22 139 ... EUR U0	
M3	0,50	56	2,2		2,5	6	3	31,87	030				
M4	0,70	63	2,8	2,1	3,3	7	3	32,09	040				
M5	0,80	70	3,5	2,7	4,2	8	3	32,41	050				
M6	1,00	80	4,5	3,4	5,0	10	3	38,86	060				
M8	1,25	90	6,0	4,9	6,8	14	3	36,03	080				
M10	1,50	100	7,0	5,5	8,5	16	3			74,77	100		
M12	1,75	110	9,0	7,0	10,2	18	3	51,95	120	78,81	120	87,32	120
M14	2,00	110	11,0	9,0	12,0	20	3	65,93	140				
M16	2,00	110	12,0	9,0	14,0	22	3	72,04	160	101,50	160	125,60	160
M18	2,50	125	14,0	11,0	15,5	25	3	105,30	180				
M20	2,50	140	16,0	12,0	17,5	25	3	107,10	200	170,40	200	185,50	200
M22	2,50	140	18,0	14,5	19,5	27	4	147,40	220				
M24	3,00	160	18,0	14,5	21,0	30	4	137,50	240				
M30	3,50	180	22,0	18,0	26,5	35	4	235,80	300				
M33	3,50	180	25,0	20,0	29,5	35	4	341,80	330				
M36	4,00	200	28,0	22,0	32,0	40	4	341,80	360				

P	12	15	12
M			
K	12	15	12
N	12	15	22
S			
H			
O			

6

Blind hole – Machine taps, right hand

▲ TS = for high-speed machining, up to 100 m/min.

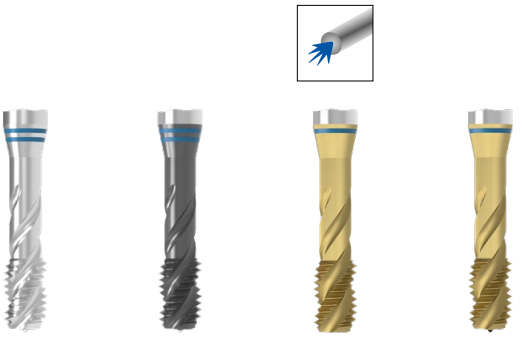
M | Salo-Rex

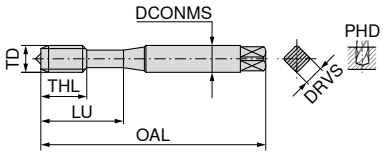
HR | HR | ST TS | ST TS

C 2–3 | C 2–3 | C 2–3 | C 2–3

ISO 2 6H | ISO 2 6H | ISO 2 6H | ISO 2 6H

OSM | TiN | TiN



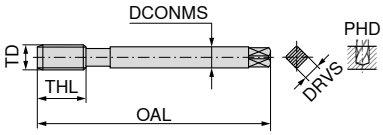


DIN 371 with reinforced shank

HSS-PM | HSS-PM | HSS-E | HSS-E

∢ 42° ≤ 1400 N/mm² ≤ 3xD | ∢ 42° ≤ 1400 N/mm² ≤ 3xD | ∢ 40° ≤ 1100 N/mm² ≤ 2xD | ∢ 40° ≤ 1100 N/mm² ≤ 2xD

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	22 498 ... EUR U0		22 499 ... EUR U0		22 046 ... EUR U0		22 044 ... EUR U0	
M3	0,50	56	3,5	2,7	2,5	6	18	3	32,09	**030**	40,72	**030**				
M4	0,70	63	4,5	3,4	3,3	7	21	3	30,24	**040**	40,72	**040**			49,66	**040**
M5	0,80	70	6,0	4,9	4,2	8	25	3	31,87	**050**	43,33	**050**	84,15	**050**	53,37	**050**
M6	1,00	80	6,0	4,9	5,0	10	30	3	31,44	**060**	44,75	**060**	109,20	**060**	56,76	**060**
M8	1,25	90	8,0	6,2	6,8	14	35	3	38,09	**080**	56,76	**080**	113,50	**080**	64,08	**080**
M10	1,50	100	10,0	8,0	8,5	16	39	3	46,06	**100**	64,08	**100**	154,00	**100**	79,58	**100**



DIN 376 with reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	22 045 ... EUR U0	
M5	0,80	70	6	4,9	4,2	8	3		
M6	1,00	80	6	4,9	5,0	10	3		
M8	1,25	90	8	6,2	6,8	14	3		
M10	1,50	100	10	8,0	8,5	16	3		
M12	1,75	110	9	7,0	10,2	18	4	95,40	**120**
M16	2,00	110	12	9,0	14,0	22	4	137,50	**160**

P	**6**	**8**	**65**	**65**
M	**6**	**8**		
K			**65**	**65**
N	**8**	**12**	**75**	**75**
S				
H				
O				

Blind hole – Machine taps, right hand

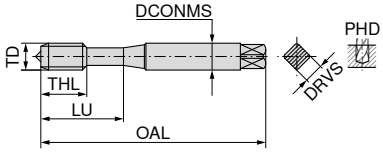
M | Salo-Rex

VA | VA | VA

C 2–3 | E 1,5–2 | C 2–3

ISO 2 6H | ISO 2 6H | ISO 2 6H

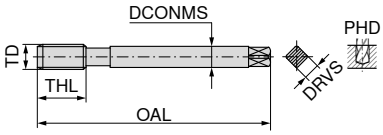
vap. | TiN GS | TiN GS



DIN 371 with reinforced shank

HSS-E ◁ 42° ≤ 900 N/mm² ≤ 3xD | HSS-E ◁ 45° ≤ 900 N/mm² ≤ 3xD | HSS-E ◁ 45° ≤ 900 N/mm² ≤ 3xD

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	22 090 ... EUR U0		22 042 ... EUR U0		22 040 ... EUR U0	
M1,6	0,35	40	2,5	2,1	1,25	4	11	2					83,50	016
M2	0,40	45	2,8	2,1	1,60	4	12	2	52,40	020			47,05	020
M2,5	0,45	50	2,8	2,1	2,05	5	15	2	41,48	025				
M2,5	0,45	50	2,8	2,1	2,05	5	15	3					44,75	025
M3	0,50	56	3,5	2,7	2,50	6	18	3	31,00	030			46,06	030
M4	0,70	63	4,5	3,4	3,30	7	21	3	31,87	040			46,61	040
M5	0,80	70	6,0	4,9	4,20	8	25	3	32,41	050	68,77	050	48,79	050
M6	1,00	80	6,0	4,9	5,00	10	30	3	32,64	060	69,54	060	50,00	060
M8	1,25	90	8,0	6,2	6,80	14	35	3	38,09	080	88,86	080	62,65	080
M10	1,50	100	10,0	8,0	8,50	16	39	3	46,06	100	102,20	100	72,70	100



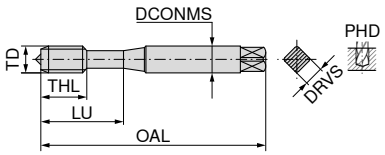
DIN 376 with reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	22 091 ... EUR U0		22 041 ... EUR U0	
M12	1,75	110	9	7,0	10,2	18	4	57,31	120	97,58	120
M14	2,00	110	11	9,0	12,0	20	4	84,15	140	117,90	140
M16	2,00	110	12	9,0	14,0	22	4	80,66	160	128,80	160
M20	2,50	140	16	12,0	17,5	25	4	124,50	200	187,80	200
M22	2,50	140	18	14,5	19,5	27	5	208,50	220		
M24	3,00	160	18	14,5	21,0	30	5	158,30	240		
M30	3,50	180	22	18,0	26,5	35	5	325,40	300		

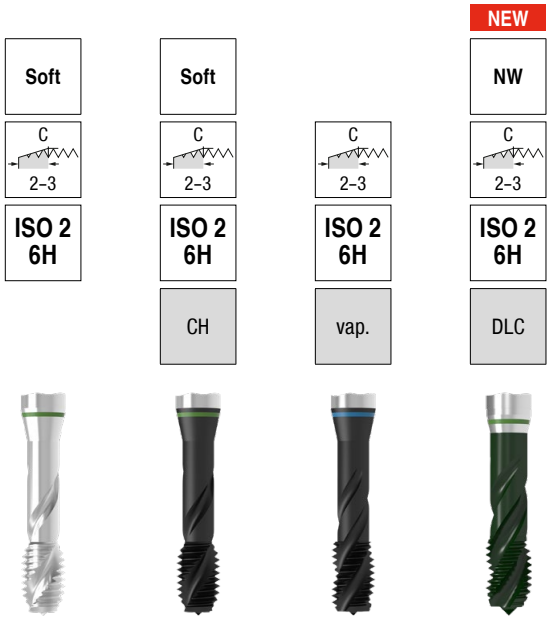
P	8	10	10
M	6	8	8
K			
N			
S			
H			
O			

Blind hole – Machine taps, right hand

M | Salo-Rex

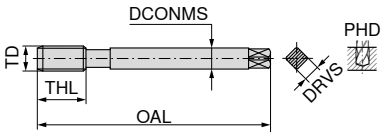


DIN 371 with reinforced shank



HSS-E ◁ 42° ≤ 500 N/mm² ≤ 3xD — HSS-E ◁ 42° ≤ 500 N/mm² ≤ 3xD — HSS-E ◁ 38° ≤ 500 N/mm² ≤ 3xD — HSS-E ◁ 38° ≤ 880 N/mm² ≤ 3xD

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	22 326 ... EUR U0		22 324 ... EUR U0		22 086 ... EUR U0		22 460 ... EUR U0	
M2	0,40	45	2,8	2,1	1,60	4	12	2	42,57	020	57,53	020	36,68	020	47,43	02000
M2,5	0,45	50	2,8	2,1	2,05	5	15	2	39,84	025	55,89	025	34,05	025		
M2,5	0,45	50	2,8	2,1	2,05	5	14	2							47,43	02500
M3	0,50	56	3,5	2,7	2,50	6	18	2	32,64	030	48,46	030				
M3	0,50	56	3,5	2,7	2,50	6	18	3					28,60	030	38,52	03000
M4	0,70	63	4,5	3,4	3,30	7	21	2	32,64	040	52,28	040				
M4	0,70	63	4,5	3,4	3,30	7	21	3					28,60	040	39,63	04000
M5	0,80	70	6,0	4,9	4,20	8	25	2	33,73	050	53,92	050				
M5	0,80	70	6,0	4,9	4,20	8	25	3					29,69	050	39,63	05000
M6	1,00	80	6,0	4,9	5,00	10	30	2	33,73	060	74,88	060				
M6	1,00	80	6,0	4,9	5,00	10	30	3					29,69	060	40,77	06000
M8	1,25	90	8,0	6,2	6,80	14	35	2	40,39	080	81,33	080				
M8	1,25	90	8,0	6,2	6,80	14	35	3					34,28	080	46,02	08000
M10	1,50	100	10,0	8,0	8,50	16	39	2	47,48	100	102,20	100				
M10	1,50	100	10,0	8,0	8,50	16	39	3					42,02	100	52,48	10000



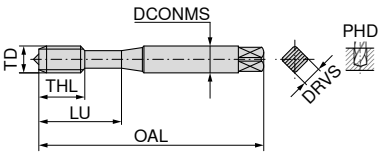
DIN 376 with reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	22 087 ... EUR U0		22 461 ... EUR U0	
M12	1,75	110	9	7	10,2	18	3	52,73	120	66,33	12000
M14	2,00	110	11	9	12,0	20	3			95,26	14000
M16	2,00	110	12	9	14,0	22	3	75,31	160	92,52	16000
M20	2,50	140	16	12	17,5	25	3			132,70	20000

P									15					15		
M														6		
K																
N									22		22					15
S																
H																
O																

Blind hole – Machine taps, right hand

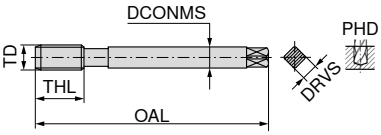
M | SL



DIN 371 with reinforced shank

	Ti	Ti	Ni	Ni
	C 2–3	C 2–3	C 2–3	C 2–3
	ISO 2X 6HX	ISO 2X 6HX	ISO 2 6H	ISO 2X 6HX
	TiN	TiCN	TiCN	TiCN
				
	HSS-PM ◁ 30° ≤ 1400 N/mm² ≤ 1,5xD	HSS-PM ◁ 15° ≤ 1200 N/mm² ≤ 2xD	HSS-PM ◁ 15° ≤ 1600 N/mm² ≤ 1,5xD	HSS-PM ◁ 15° ≤ 1600 N/mm² ≤ 2xD
	22 076 ...	**22 163 ...**	**22 073 ...**	**22 424 ...**

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	22 076 ... EUR U0		22 163 ... EUR U0		22 073 ... EUR U0		22 424 ... EUR U0	
M3	0,50	56	3,5	2,7	2,5	11	18	2			46,39	**030**			59,27	**030**
M3	0,50	56	3,5	2,7	2,5	11	18	3					100,10	**030**		
M3	0,50	56	3,5	2,7	2,5	6	18	3	44,75	**030**						
M3,5	0,60	56	4,0	3,0	2,9	12	20	3			49,88	**035**				
M4	0,70	56	4,5	3,4	3,3	7	21	3	46,06	**040**						
M4	0,70	63	4,5	3,4	3,3	13	21	3			50,97	**040**	100,10	**040**	61,79	**040**
M5	0,80	70	6,0	4,9	4,2	8	25	3	46,29	**050**						
M5	0,80	70	6,0	4,9	4,2	15	25	3			51,52	**050**	89,40	**050**	64,08	**050**
M6	1,00	80	6,0	4,9	5,0	10	30	3	50,65	**060**						
M6	1,00	80	6,0	4,9	5,0	17	30	3			68,66	**060**	105,50	**060**	80,56	**060**
M8	1,25	90	8,0	6,2	6,8	14	35	3	53,37	**080**						
M8	1,25	90	8,0	6,2	6,8	20	35	3			74,88	**080**	155,00	**080**	88,42	**080**
M10	1,50	100	10,0	8,0	8,5	16	39	3	77,29	**100**						
M10	1,50	100	10,0	8,0	8,5	22	39	3			92,12	**100**	134,20	**100**	110,20	**100**
M12	1,75	110	12,0	9,0	10,2	18	44	3	88,31	**120**						



DIN 376 with reduced shank

								22 164 ... EUR U0		22 124 ... EUR U0		22 425 ... EUR U0	
M12	1,75	110	9	7,0	10,2	24	3	104,30	**120**			128,80	**120**
M12	1,75	110	9	7,0	10,2	24	4			154,00	**120**		
M14	2,00	110	11	9,0	12,0	26	3					188,90	**140**
M14	2,00	110	11	9,0	12,0	26	4			206,30	**140**		
M16	2,00	110	12	9,0	14,0	27	3	146,40	**160**			176,90	**160**
M16	2,00	110	12	9,0	14,0	27	5			186,70	**160**		
M20	2,50	140	16	12,0	17,5	32	3	253,30	**200**			306,70	**200**
M24	3,00	160	18	14,5	21,0	34	3	289,20	**240**				

P	**7**	**7**		
M	**7**	**7**		
K				
N		**22**	**22**	**22**
S	**5**	**5**	**2**	**2**
H				
O				

6

Blind hole – Machine taps, right hand

▲ ES = extra short

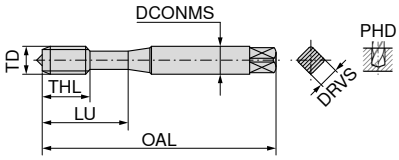
M | Salo-Rex

UNI ES

E 1,5–2

ISO 2 6H

vap.



DIN 352 with reinforced shank

HSS-E
42°
≤ 1100 N/mm²
≤ 3xD

22 500 ...

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	EUR U0	
M3	0,50	40	3,5	2,7	2,5	6	18	3	25,98	**030**
M4	0,70	45	4,5	3,4	3,3	7	22	3	26,75	**040**
M5	0,80	50	6,0	4,9	4,2	9	25	3	27,40	**050**
M6	1,00	56	6,0	4,9	5,0	10	28	3	28,38	**060**
M8	1,25	63	6,0	4,9	6,8	14		3	32,64	**080**
M10	1,50	70	7,0	5,5	8,5	16		3	38,86	**100**
M12	1,75	75	9,0	7,0	10,2	18		4	50,65	**120**
M16	2,00	80	12,0	9,0	14,0	22		4	80,11	**160**

P	**12**
M	**7**
K	**12**
N	
S	
H	
O	

Blind hole – Machine taps, right hand

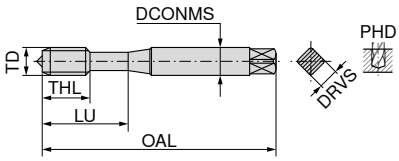
▲ ES = extra short

M | SL

ST
ES

C
2–3

ISO 2
6H



DIN 352 with reinforced shank

HSS-E
∢ 15°
≤ 750 N/mm²
≤ 2xD

22 016 ...

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	EUR U0	
M3	0,50	40	3,5	2,7	2,5	10	18	2	23,36	**030**
M4	0,70	45	4,5	3,4	3,3	12	22	3	23,47	**040**
M5	0,80	50	6,0	4,9	4,2	14	25	3	24,12	**050**
M6	1,00	56	6,0	4,9	5,0	16	28	3	24,88	**060**
M8	1,25	63	6,0	4,9	6,8	20		3	28,38	**080**
M10	1,50	70	7,0	5,5	8,5	22		3	36,03	**100**
M12	1,75	75	9,0	7,0	10,2	24		3	46,29	**120**

P	**12**
M	
K	**12**
N	**12**
S	
H	
O	

6

Blind hole – Machine taps, right hand

▲ EL = extra long, with double overall length

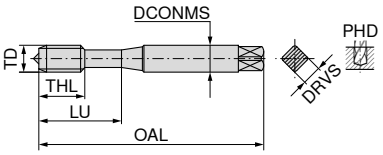
M | Salo-Rex

UNI EL | ST EL

C 2–3

ISO 2 6H

vap.

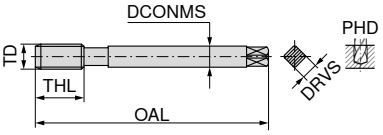


DIN 371 with reinforced shank

HSS-E
∢ 42°
≤ 1100 N/mm²
≤ 3xD

HSS-E
∢ 42°
≤ 750 N/mm²
≤ 3xD

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	22 538 ... EUR U0		22 422 ... EUR U0	
M3	0,50	100	3,5	2,7	2,5	6	18	3	53,92	030	62,76	030
M4	0,70	125	4,5	3,4	3,3	7	21	3	53,92	040	61,45	040
M5	0,80	140	6,0	4,9	4,2	8	25	3	60,47	050	68,66	050
M6	1,00	160	6,0	4,9	5,0	10	30	3	63,64	060	71,49	060
M8	1,25	180	8,0	6,2	6,8	14	35	3	76,08	080	86,02	080



DIN 376 with reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	22 539 ... EUR U0		22 423 ... EUR U0	
M6	1,00	160	4,5	3,4	5,0	10	3	68,77	060	71,49	060
M8	1,25	180	6,0	4,9	6,8	14	3	83,50	080	86,02	080
M10	1,50	200	7,0	5,5	8,5	16	3	84,15	100	94,42	100
M12	1,75	224	9,0	7,0	10,2	18	3	107,50	120	123,40	120
M14	2,00	224	11,0	9,0	12,0	20	3	158,30	140	179,00	140
M16	2,00	224	12,0	9,0	14,0	22	3	151,70	160	173,60	160
M18	2,50	250	14,0	11,0	15,5	25	3	243,40	180	263,10	180
M20	2,50	280	16,0	12,0	17,5	25	3	208,50	200	234,70	200

P	12	12
M	7	
K	12	12
N		22
S		
H		
O		

Blind hole – Machine taps, right hand

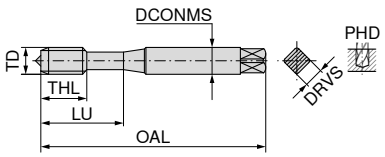
▲ EL = extra long, with double overall length

M | SL

ST
EL

E
1,5–2

ISO 2
6H

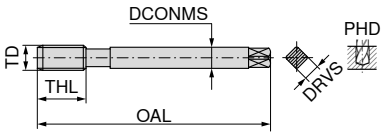


DIN 371 with reinforced shank

HSS-E
∢ 15°
≤ 750 N/mm²
≤ 2xD

22 078 ...

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	EUR U0	
M3	0,50	100	3,5	2,7	2,5	11	18	2	51,85	**030**
M4	0,70	125	4,5	3,4	3,3	13	21	3	51,52	**040**
M5	0,80	140	6,0	4,9	4,2	15	25	3	58,40	**050**
M6	1,00	160	6,0	4,9	5,0	17	30	3	60,80	**060**
M8	1,25	180	8,0	6,2	6,8	20	35	3	73,36	**080**



DIN 376 with reduced shank

22 080 ...

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	EUR U0	
M6	1,00	160	4,5	3,4	5,0	17	3	63,30	**060**
M8	1,25	180	6,0	4,9	6,8	20	3	75,31	**080**
M10	1,50	200	7,0	5,5	8,5	22	3	80,11	**100**
M12	1,75	224	9,0	7,0	10,2	24	3	102,20	**120**
M14	2,00	224	11,0	9,0	12,0	26	3	149,60	**140**
M16	2,00	224	12,0	9,0	14,0	27	3	147,40	**160**
M20	2,50	280	16,0	12,0	17,5	32	3	204,20	**200**

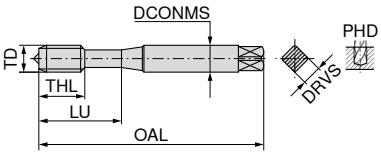
P	**12**
M	
K	**12**
N	**12**
S	
H	
O	

6

Blind hole – Machine taps, right hand

▲ NC = for synchronised CNC machining with minimum length compensation chuck

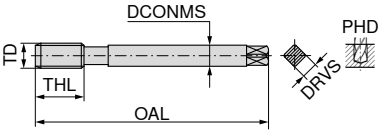
M



DIN 371 with reinforced shank

	UNI	UNI	UNI	UNI	UNI NC
	C 2–3	C 2–3	C 2–3	C 2–3	C 2–3
	ISO 2 6H	ISO 2 6H	ISO 2 6H	ISO 2 6H	ISO 2 6H
	vap.	TiN	TiN	TiCN	TiN GS
					
	HSS-E ◁ 35° ≤ 1000 N/mm² ≤ 2,5xD	HSS-E ◁ 35° ≤ 1000 N/mm² ≤ 2,5xD	HSS-PM ◁ 50° ≤ 1000 N/mm² ≤ 2,5xD	HSS-E ◁ 45° ≤ 1000 N/mm² ≤ 3xD	HSS-E ◁ 45° ≤ 1000 N/mm² ≤ 3xD
	23 118 ...	**23 120 ...**	**23 026 ...**	**23 122 ...**	**23 124 ...**

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	EUR T9		EUR T9		EUR T9		EUR T9		EUR T9	
M2	0,40	45	2,8	2,1	1,60	4	12	2	12,83	**020**	11,18	**020**						
M2,5	0,45	50	2,8	2,1	2,05	5	14	2	12,62	**025**	16,86	**025**						
M3	0,50	56	3,5	2,7	2,50	6	18	3	8,67	**030**	12,83	**030**	14,27	**030**	18,72	**030**	19,75	**030**
M4	0,70	63	4,5	3,4	3,30	7	21	3	8,67	**040**	13,75	**040**	14,27	**040**	19,75	**040**	20,89	**040**
M5	0,80	70	6,0	4,9	4,20	8	25	3	9,10	**050**	13,97	**050**	15,31	**050**	20,58	**050**	22,03	**050**
M6	1,00	80	6,0	4,9	5,00	10	30	3	9,41	**060**	17,38	**060**	17,79	**060**	26,58	**060**	29,79	**060**
M8	1,25	90	8,0	6,2	6,80	14	35	3	11,06	**080**	18,72	**080**	21,10	**080**	28,54	**080**	31,96	**080**
M10	1,50	100	10,0	8,0	8,50	16	39	3	12,72	**100**	23,99	**100**	26,58	**100**	36,09	**100**	40,65	**100**



DIN 376 with reduced shank

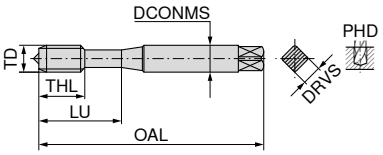
									23 119 ...		**23 121 ...**		**23 027 ...**		**23 123 ...**		**23 125 ...**	
TD mm	**TP mm**	**OAL mm**	**DCONMS mm**	**DRVS mm**	**PHD mm**	**THL mm**	**Flutes**		**EUR T9**		**EUR T9**		**EUR T9**		**EUR T9**		**EUR T9**	
M3	0,50	56	2,2		2,5	6	3		10,34	**030**								
M4	0,70	63	2,8	2,1	3,3	7	3		9,32	**040**								
M5	0,80	70	3,5	2,7	4,2	8	3		9,18	**050**								
M6	1,00	80	4,5	3,4	5,0	10	3		9,03	**060**								
M8	1,25	90	6,0	4,9	6,8	14	3		9,46	**080**								
M10	1,50	100	7,0	5,5	8,5	16	3		12,83	**100**								
M12	1,75	110	9,0	7,0	10,2	18	3		14,48	**120**	28,75	**120**						
M12	1,75	110	9,0	7,0	10,2	18	4						31,34	**120**	42,82	**120**	47,17	**120**
M14	2,00	110	11,0	9,0	12,0	20	3				43,72	**14000**						
M14	2,00	110	11,0	9,0	12,0	20	4						45,20	**140**				
M16	2,00	110	12,0	9,0	14,0	22	3		21,30	**160**	40,03	**160**						
M16	2,00	110	12,0	9,0	14,0	22	4						45,20	**160**	57,09	**160**	62,89	**160**
M18	2,50	125	14,0	11,0	15,5	25	3				69,15	**18000**						
M20	2,50	140	16,0	12,0	17,5	25	3		32,06	**200**	59,27	**200**	51,71	**200**				
M20	2,50	140	16,0	12,0	17,5	25	4								103,40	**200**	114,80	**200**
M22	2,50	140	18,0	14,5	19,5	27	4				101,40	**22000**						
M24	3,00	160	18,0	14,5	21,0	34	4				83,58	**240**						
M27	3,00	160	20,0	16,0	24,0	30	4				126,80	**27000**						
M30	3,50	180	22,0	18,0	26,5	35	4				140,80	**30000**						
M33	3,50	180	25,0	20,0	29,5	35	4				203,00	**33000**						
M36	4,00	200	28,0	22,0	32,0	40	4				220,60	**36000**						

P	**12**	**15**	**15**	**15**	**15**
M	**7**	**9**	**9**	**9**	**9**
K	**12**	**18**	**18**	**18**	**18**
N		**12**	**12**	**12**	**12**
S					
H					
O					

Blind hole – Machine taps, right hand

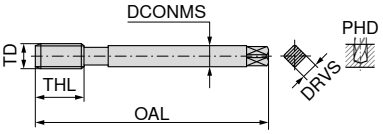
▲ NCW = with Weldon flat for synchronised CNC machining without length compensation chuck

M



DIN 371 with reinforced shank

									HSS-PM ◁ 35° ≤ 1000 N/mm² ≤ 2,5xD		HSS-E ◁ 35° ≤ 850 N/mm² ≤ 2,5xD		HSS-E ◁ 35° ≤ 1100 N/mm² ≤ 2,5xD		HSS-E ◁ 35° ≤ 1200 N/mm² ≤ 2,5xD	
									23 126 ...		23 216 ...		23 312 ...		23 414 ...	
TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	EUR T9		EUR T9		EUR T9		EUR T9	
M2	0,40	45	2,8	2,1	1,60	4	12	2			11,68	020			19,97	020
M2,5	0,45	50	2,8	2,1	2,05	5	14	2			21,41	025			23,69	025
M3	0,50	56	3,5	2,7	2,50	6	18	3			11,48	030	17,17	030	12,93	030
M3	0,50	70	6,0	4,9	2,50	6	18	3	21,20	030						
M4	0,70	63	4,5	3,4	3,30	7	21	3			11,48	040	18,72	040	12,93	040
M4	0,70	70	6,0	4,9	3,30	7	21	3	24,20	040						
M5	0,80	70	6,0	4,9	4,20	8	25	3	24,61	050	11,90	050	18,93	050	13,35	050
M6	1,00	80	6,0	4,9	5,00	10	30	3	24,61	060	11,90	060	26,17	060	13,35	060
M8	1,25	90	8,0	6,2	6,80	14	35	3	31,13	080	15,41	080	28,54	080	17,28	080
M10	1,50	100	10,0	8,0	8,50	16	39	3	37,54	100	18,41	100	35,58	100	21,00	100



DIN 376 with reduced shank

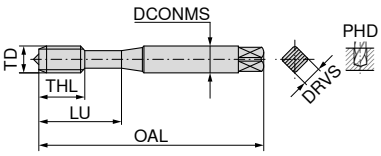
								23 127 ...		23 217 ...		23 313 ...		23 415 ...	
TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	EUR T9		EUR T9		EUR T9		EUR T9	
M12	1,75	110	10	8,0	10,2	18	3	46,95	120						
M12	1,75	110	9	7,0	10,2	18	3			24,83	120	41,17	120	27,82	120
M14	2,00	110	11	9,0	12,0	20	3			29,89	140				
M16	2,00	110	12	9,0	14,0	22	3	63,19	160	37,65	160	55,64	160	42,82	160
M20	2,50	140	16	12,0	17,5	25	3			59,37	200	99,70	200	65,47	200
M24	3,00	160	18	14,5	21,0	30	4							89,78	240

P	15	12	15	8
M	8			6
K	15	12	15	
N	22	22	24	22
S				
H				
O				

6

Blind hole – Machine taps, right hand

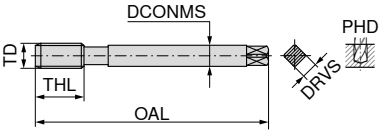
M



DIN 371 with reinforced shank

	VA	VA	VA	AL	AL
	C 2–3	C 2–3	C 2–3	C 2–3	C 2–3
	ISO 2 6H	ISO 2 6H	ISO 2 6H	ISO 2 6H	ISO 2 6H
	TiN		TiN		CrN
					
	HSS-E ◁ 45° ≤ 1200 N/mm² ≤ 3xD	HSS-PM ◁ 40° ≤ 1200 N/mm² ≤ 2,5xD	HSS-PM ◁ 40° ≤ 1200 N/mm² ≤ 2,5xD	HSS-E ◁ 35° ≤ 500 N/mm² ≤ 2,5xD	HSS-E ◁ 35° ≤ 500 N/mm² ≤ 2,5xD
	23 416 ...	**23 426 ...**	**23 456 ...**	**23 616 ...**	**23 614 ...**

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	EUR T9		EUR T9		EUR T9		EUR T9		EUR T9	
M2	0,40	45	2,8	2,1	1,60	4	12	2	21,52	**020**								
M2,5	0,45	50	2,8	2,1	2,05	5	14	2	20,58	**025**								
M3	0,50	56	3,5	2,7	2,50	6	18	3	17,48	**030**	12,72	**030**	14,27	**030**	11,48	**030**	15,10	**030**
M4	0,70	63	4,5	3,4	3,30	7	21	3	18,31	**040**	12,93	**040**	15,52	**040**	11,48	**040**	15,10	**040**
M5	0,80	70	6,0	4,9	4,20	8	25	3	18,72	**050**	13,24	**050**	15,82	**050**	11,90	**050**	15,62	**050**
M6	1,00	80	6,0	4,9	5,00	10	30	3	23,48	**060**	13,45	**060**	20,37	**060**	11,90	**060**	15,62	**060**
M8	1,25	90	8,0	6,2	6,80	14	35	3	25,86	**080**	15,82	**080**	21,82	**080**	15,41	**080**	18,10	**080**
M10	1,50	100	10,0	8,0	8,50	16	39	3	32,68	**100**	19,03	**100**	30,09	**100**	18,41	**100**	22,14	**100**



DIN 376 with reduced shank

								23 417 ...		**23 427 ...**		**23 457 ...**		**23 617 ...**		**23 615 ...**	
TD mm	**TP mm**	**OAL mm**	**DCONMS mm**	**DRVS mm**	**PHD mm**	**THL mm**	**Flutes**	**EUR T9**		**EUR T9**		**EUR T9**		**EUR T9**		**EUR T9**	
M12	1,75	110	9	7,0	10,2	18	3			31,44	**120**	43,03	**120**	24,83	**120**	27,41	**120**
M12	1,75	110	9	7,0	10,2	18	4	38,68	**120**								
M14	2,00	110	11	9,0	12,0	20	4			41,37	**140**						
M16	2,00	110	12	9,0	14,0	22	3			44,99	**160**	54,20	**160**				
M16	2,00	110	12	9,0	14,0	22	4	52,75	**160**								
M20	2,50	140	16	12,0	17,5	25	3			67,02	**200**	107,60	**200**				
M20	2,50	140	16	12,0	17,5	25	4	90,91	**200**								
M24	3,00	160	18	14,5	21,0	30	4			84,81	**240**						

P	**10**	**8**	**10**			
M	**8**	**6**	**8**			
K						
N	**24**	**22**	**24**	**15**	**20**	
S						
H						
O						

Through hole / Blind hole – Machine taps, right hand

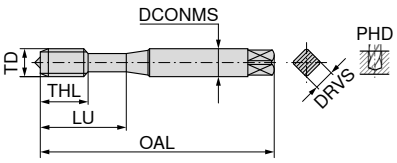
M | TWIN

ST | HR | AMPCO

C 2–3

ISO 2X 6HX

nitr.



DIN 371 with reinforced shank

HSS-E | HSS-E | HSS-PM

0° | 0° | 0°

≤ 750 N/mm² | ≤ 1400 N/mm² | ≤ 800 N/mm²

≤ 2xD | ≤ 2xD | ≤ 2xD

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	22 028 ... EUR U0		22 006 ... EUR U0		22 030 ... EUR U0	
M1,2	0,25	40	2,5	2,1	0,95	5	13	2	45,41	**012** [1]				
M1,4	0,30	40	2,5	2,1	1,10	6	13	2	36,68	**014** [1]				
M1,6	0,35	40	2,5	2,1	1,25	6	11	2	32,96	**016**				
M1,7	0,35	40	2,5	2,1	1,35	6	11	2	36,03	**017**				
M1,8	0,35	40	2,5	2,1	1,45	6	11	2	33,40	**018**				
M2	0,40	45	2,8	2,1	1,60	7	12	3	28,06	**020**				
M2,2	0,45	45	2,8	2,1	1,75	7	12	3	29,69	**022**				
M2,3	0,40	45	2,8	2,1	1,90	7	12	3	32,09	**023**				
M2,5	0,45	50	2,8	2,1	2,05	9	14	3	27,40	**025**				
M2,6	0,45	50	2,8	2,1	2,15	9	14	3	29,47	**026**				
M3	0,50	56	3,5	2,7	2,50	11	18	3	22,81	**030**	31,00	**030**	33,63	**030**
M3,5	0,60	56	4,0	3,0	2,90	12	20	3	23,36	**035**				
M4	0,70	63	4,5	3,4	3,30	13	21	3	23,13	**040**	32,09	**040**	34,82	**040**
M5	0,80	70	6,0	4,9	4,20	15	25	3	23,36	**050**	33,40	**050**	34,82	**050**
M6	1,00	80	6,0	4,9	5,00	17	30	3	23,47	**060**	33,63	**060**	34,82	**060**
M7	1,00	80	7,0	5,5	6,00	17	30	3	33,40	**070**				
M8	1,25	90	8,0	6,2	6,80	20	35	3	26,75	**080**	37,33	**080**	39,73	**080**
M10	1,50	100	10,0	8,0	8,50	22	39	3	33,63	**100**	46,29	**100**	50,00	**100**
P										**12**		**6**		
M														
K										**12**		**16**		
N												**12**		**8**
S														
H														
O														

1) Tol. 4H/5H ≤ M1.4

DIN 376 can be found on the next page

6

Through hole / Blind hole – Machine taps, right hand

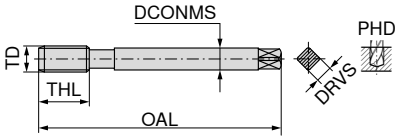
M | TWIN

ST | HR | AMPCO

C 2–3

ISO 2X 6HX

nitr.



DIN 376 with reduced shank

HSS-E | HSS-E | HSS-PM

0° | 0° | 0°

≤ 750 N/mm² | ≤ 1400 N/mm² | ≤ 800 N/mm²

≤ 2xD | ≤ 2xD | ≤ 2xD

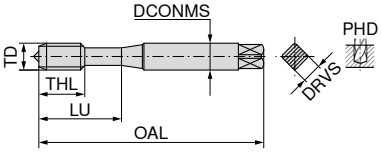
TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	22 029 ... EUR U0		22 007 ... EUR U0		22 031 ... EUR U0	
M4	0,70	63	2,8	2,1	3,3	13	3	29,04	**040**				
M5	0,80	70	3,5	2,7	4,2	15	3	29,69	**050**				
M6	1,00	80	4,5	3,4	5,0	17	3	29,69	**060**				
M8	1,25	90	6,0	4,9	6,8	20	3	37,54	**080**				
M10	1,50	100	7,0	5,5	8,5	22	3	42,02	**100**				
M12	1,75	110	9,0	7,0	10,2	24	3	43,33	**120**	58,95	**120**		
M12	1,75	110	9,0	7,0	10,2	24	4					84,15	**120**
M14	2,00	110	11,0	9,0	12,0	26	3	59,71	**140**				
M16	2,00	110	12,0	9,0	14,0	27	3	63,64	**160**	83,50	**160**		
M16	2,00	110	12,0	9,0	14,0	27	4					126,60	**160**
M18	2,50	125	14,0	11,0	15,5	30	4	94,64	**180**				
M20	2,50	140	16,0	12,0	17,5	32	4	96,16	**200**			160,50	**200**
M22	2,50	140	18,0	14,5	19,5	32	4	136,50	**220**				
M24	3,00	160	18,0	14,5	21,0	34	4	130,00	**240**			196,40	**240**
M33	3,50	180	25,0	20,0	29,5	40	4	256,60	**330**				
P									**12**		**6**		
M													
K									**12**		**16**		
N											**12**		**8**
S													
H													
O													

Through hole / Blind hole – Machine taps, right hand

M | TWIN

GG | C 2–3 | ISO 2X 6HX | nitr.

GG | C 2–3 | ISO 2X 6HX | nitr.

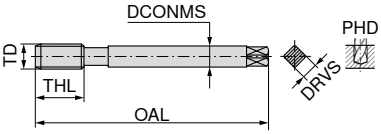


DIN 371 with reinforced shank

HSS-E
0°
≤ 1050 N/mm²
≤ 2xD

HSS-E
0°
≤ 1050 N/mm²
≤ 2xD

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	22 032 ... EUR U0		22 036 ... EUR U0	
M2	0,40	45	2,8	2,1	1,60	7	12	3	29,69	**020**		
M2,5	0,45	50	2,8	2,1	2,05	9	14	3	29,69	**025**		
M3	0,50	56	3,5	2,7	2,50	11	18	3	25,00	**030**		
M3,5	0,60	56	4,0	3,0	2,90	12	20	3	27,40	**035**		
M4	0,70	63	4,5	3,4	3,30	13	21	3	25,66	**040**		
M5	0,80	70	6,0	4,9	4,20	15	25	3	27,30	**050**	39,95	**050**
M6	1,00	80	6,0	4,9	5,00	17	30	3	27,30	**060**	40,93	**060**
M8	1,25	90	8,0	6,2	6,80	20	35	3	31,98	**080**	45,07	**080**
M10	1,50	100	10,0	8,0	8,50	22	39	3	37,54	**100**	53,37	**100**



DIN 376 with reduced shank

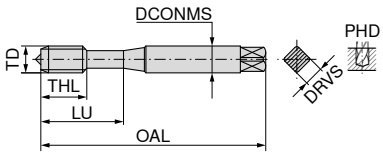
TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	22 033 ... EUR U0		22 037 ... EUR U0	
M6	1,00	80	4,5	3,4	5,0	17	3	32,64	**060**		
M8	1,25	90	6,0	4,9	6,8	20	3	34,82	**080**		
M10	1,50	100	7,0	5,5	8,5	22	3	39,95	**100**		
M12	1,75	110	9,0	7,0	10,2	24	3	47,60	**120**	62,98	**120**
M14	2,00	110	11,0	9,0	12,0	26	3	62,98	**140**	86,56	**140**
M16	2,00	110	12,0	9,0	14,0	27	3	68,66	**160**	87,32	**160**
M18	2,50	125	14,0	11,0	15,5	30	4	101,60	**180**		
M20	2,50	140	16,0	12,0	17,5	32	4	101,60	**200**	130,00	**200**
M22	2,50	140	18,0	14,5	19,5	32	4	154,00	**220**		
M24	3,00	160	18,0	14,5	21,0	34	4	134,20	**240**		

P		
M		
K	**16**	**16**
N	**12**	**12**
S		
H		
O		

6

Through hole / Blind hole – Machine taps, right hand

M | TWIN

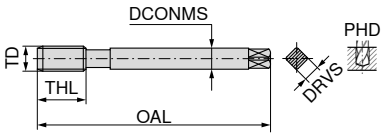


DIN 371 with reinforced shank

	HT	HT
	D 4–5	C 2–3
	ISO 2X 6HX	ISO 2X 6HX
	OSM	TiCN


	Solid carbide	HSS-PM
	0° ≤ 63 HRC ≤ 1,5xD	0° 44 - 52 HRC ≤ 1,5xD
	22 806 ...	22 227 ...

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	EUR U0		EUR U0	
M3	0,50	63	4,5	3,4	2,55	6	18	4	203,70	030		
M4	0,70	63	4,5	3,4	3,40	8	20	4	203,70	040		
M5	0,80	70	6,0	4,9	4,30	10	26	4	230,30	050		
M6	1,00	80	6,0	4,9	5,00	10	30	4			133,20	060
M6	1,00	80	6,0	4,9	5,10	12	28	4	240,80	060		
M8	1,25	90	8,0	6,2	6,80	14	35	5			143,00	080
M8	1,25	90	8,0	6,2	6,90	15	35	5	268,50	080		
M10	1,50	100	10,0	8,0	8,50	18	38	5	332,20	100		
M10	1,50	100	10,0	8,0	8,50	16	39	5			179,00	100
M12	1,75	110	12,0	9,0	10,40	21	41	5	510,40	120		
M16	2,00	110	16,0	12,0	14,20	24	44	6	719,90	160		



DIN 376 with reduced shank

								22 228 ...	
TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	EUR U0	
M12	1,75	110	9	7	10,4	18	5	223,80	120
M16	2,00	110	12	9	14,2	22	6	306,70	160

P		
M		
K		
N		22
S		
H	2	2
O		

Through hole / Blind hole – Machine taps, right hand

▲ EL = extra long, with double overall length

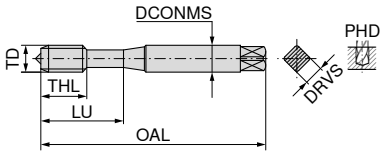
M | TWIN

HR EL

C 2–3

ISO 2X 6HX

nitr.

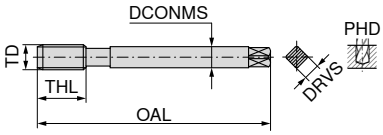


DIN 371 with reinforced shank

HSS-E
0°
≤ 1400 N/mm²
≤ 2xD

22 122 ...

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	EUR U0	
M3	0,50	100	3,5	2,7	2,5	11	18	3	56,98	**030**
M4	0,70	125	4,5	3,4	3,3	13	21	3	56,98	**040**
M5	0,80	140	6,0	4,9	4,2	15	25	3	60,26	**050**
M6	1,00	160	6,0	4,9	5,0	17	30	3	62,98	**060**
M8	1,25	180	8,0	6,2	6,8	20	35	3	74,77	**080**



DIN 376 with reduced shank

22 123 ...

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	EUR U0	
M10	1,50	200	7	5,5	8,5	22	3	83,50	**100**
M12	1,75	224	9	7,0	10,2	24	3	100,10	**120**
M16	2,00	224	12	9,0	14,0	27	3	157,20	**160**
M20	2,50	280	16	12,0	17,5	32	4	213,90	**200**

P	**6**
M	
K	**16**
N	**22**
S	
H	
O	

Through hole / Blind hole – Machine taps, right hand

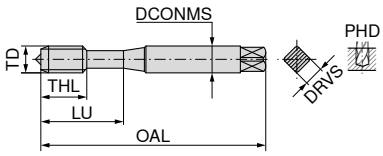
M

GG

C
2–3

ISO 2X
6HX

TiCN

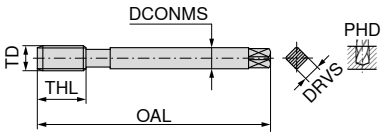


DIN 371 with reinforced shank

HSS-E
0°
≤ 900 N/mm²
≤ 2xD

23 512 ...

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	EUR T9	
M3	0,50	56	3,5	2,7	2,5	11	18	3	15,62	**030**
M4	0,70	63	4,5	3,4	3,3	13	21	3	16,96	**040**
M5	0,80	70	6,0	4,9	4,2	15	25	3	17,28	**050**
M6	1,00	80	6,0	4,9	5,0	17	30	3	23,89	**060**
M8	1,25	90	8,0	6,2	6,8	20	35	3	25,13	**080**
M10	1,50	100	10,0	8,0	8,5	22	39	3	31,96	**100**



DIN 376 with reduced shank

23 513 ...

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	EUR T9	
M12	1,75	110	9	7	10,2	24	3	37,03	**120**

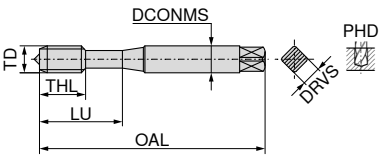
P	
M	
K	**20**
N	**24**
S	
H	
O	

Through hole / Blind hole – Machine thread formers, right hand

M | Spanlos

EC | C 2–3 | ISO 2X 6HX | HCr

EC | C 2–3 | ISO 2X 6HX | TiN



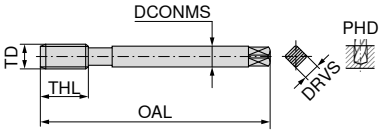
DIN 2174 with reinforced shank

HSS-E
≤ 1100 N/mm²
≤ 1,5xD

HSS-E
≤ 1100 N/mm²
≤ 1,5xD

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	22 128 ... EUR U0		22 100 ... EUR U0	
M1	0,25	40	2,5	2,1	0,90	5	6,5			80,34	**010** 1)
M1,2	0,25	40	2,5	2,1	1,10	5	6,5			76,08	**012** 1)
M1,4	0,30	40	2,5	2,1	1,28	6	9,0			68,00	**014** 1)
M1,6	0,35	40	2,5	2,1	1,47	6	9,0			65,60	**016**
M1,7	0,35	40	2,5	2,1	1,57	6	9,0			72,04	**017**
M2	0,40	45	2,8	2,1	1,85	7	10,0	65,93	**020**	47,05	**020**
M2,5	0,45	50	2,8	2,1	2,33	9	14,0	56,76	**025**	45,62	**025**
M2,6	0,45	50	2,8	2,1	2,43	9	14,0			50,76	**026**
M3	0,50	56	3,5	2,7	2,80	11	18,0	40,82	**030**	43,66	**030**
M3,5	0,60	56	4,0	3,0	3,25	12	20,0			38,42	**035**
M4	0,70	63	4,5	3,4	3,70	13	21,0	42,47	**040**	44,65	**040**
M5	0,80	70	6,0	4,9	4,65	15	25,0	44,31	**050**	46,61	**050**
M6	1,00	80	6,0	4,9	5,60	17	30,0	44,31	**060**	53,27	**060**
M8	1,25	90	8,0	6,2	7,40	20	35,0			58,50	**080**
M8	1,25	90	8,0	6,2	7,45	20	35,0	50,43	**080**		
M10	1,50	100	10,0	8,0	9,35	22	39,0	65,93	**100**	74,22	**100**

1) Tol. ISO 1X 4HX ≤ M1.4



DIN 2174 with reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	22 101 ... EUR U0	
M12	1,75	110	9	7	11,25	24	81,53	**120**
M16	2,00	110	12	9	15,10	27	137,50	**160**

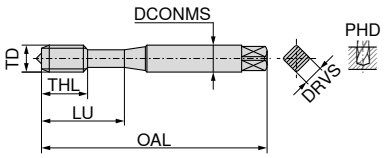
P	**18**	**18**
M	**10**	**10**
K	**10**	**10**
N	**18**	**22**
S		
H		
O		

6

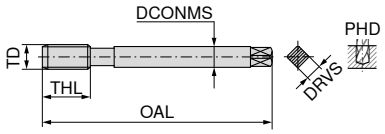
Through hole / Blind hole – Machine thread formers, right hand

▲ SN = Thread formers with lubrication grooves

M | Spanlos



DIN 2174 with reinforced shank



DIN 2174 with reduced shank

	EC SN	EC SN	EC SN	EC SN	EC SN
	C 2–3	C 2–3	C 2–3	C 2–3	C 2–3
	ISO 2X 6HX	ISO 2X 6HX	ISO 3X 6GX	ISO 2X 6HX	ISO 2X 6HX
	nitr.	HCr	TiN	TiN GS	TiN
					
	HSS-E ≤ 1100 N/mm² ≤ 3xD	HSS-E ≤ 1100 N/mm² ≤ 3xD	HSS-E ≤ 1100 N/mm² ≤ 3xD	HSS-E ≤ 1100 N/mm² ≤ 3xD	HSS-E ≤ 1100 N/mm² ≤ 3xD
	22 104 ...	**22 107 ...**	**22 108 ...**	**22 154 ...**	**22 105 ...**

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	EUR U0		EUR U0		EUR U0		EUR U0		EUR U0	
M2	0,40	45	2,8	2,1	1,85	7	10	3									54,03	**020**
M2,5	0,45	50	2,8	2,1	2,33	9	14	3									49,34	**025**
M3	0,50	56	3,5	2,7	2,80	11	18	3	33,63	**030**	46,61	**030**	45,30	**030**	62,44	**030**	47,60	**030**
M3,5	0,60	56	4,0	3,0	3,25	12	20	3									47,05	**035**
M4	0,70	63	4,5	3,4	3,70	13	21	4	34,82	**040**	47,60	**040**	47,05	**040**	64,19	**040**	49,34	**040**
M5	0,80	70	6,0	4,9	4,65	15	25	4	36,78	**050**	50,00	**050**	49,34	**050**	66,48	**050**		
M5	0,80	70	6,0	4,9	4,65	15	25	5									51,30	**050**
M6	1,00	80	6,0	4,9	5,60	17	30	4	37,33	**060**	50,00	**060**	57,63	**060**	73,46	**060**	58,17	**060**
M8	1,25	90	8,0	6,2	7,45	20	35	5	44,97	**080**	57,31	**080**	65,60	**080**	79,90	**080**	64,19	**080**
M10	1,50	100	10,0	8,0	9,35	22	39	6	57,63	**100**	75,53	**100**	83,07	**100**	97,15	**100**	80,34	**100**

	22 106 ...
	EUR U0

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes		
M12	1,75	110	9	7	11,25	24	6	100,20	**120**
M14	2,00	110	11	9	13,10	26	5	193,20	**140**
M16	2,00	110	12	9	15,10	27	7	155,00	**160**

P	**12**	**18**	**18**	**18**	**18**
M		**10**	**10**	**10**	**10**
K	**8**	**10**	**10**	**10**	**10**
N	**12**	**18**	**22**	**22**	**22**
S					
H					
O					

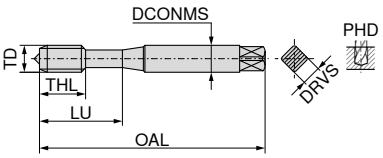
Through hole / Blind hole – Machine thread formers, right hand

▲ SN = Thread formers with lubrication grooves

M | Spanlos

NEO SN | C 2–3 | ISO 2X 6HX | TiN

NEO SN | C 2–3 | ISO 2X 6HX | TiN

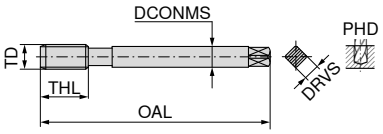


DIN 2174 with reinforced shank

HSS-PM
≤ 1100 N/mm²
≤ 3xD

HSS-PM
≤ 1100 N/mm²
≤ 3xD

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	22 452 ... EUR U0		22 453 ... EUR U0	
M3	0,50	56	3,5	2,7	2,80	11	18	4	62,44	**030**		
M4	0,70	63	4,5	3,4	3,70	13	21	4	64,19	**040**		
M5	0,80	70	6,0	4,9	4,65	15	25	4	68,33	**050**	85,37	**050**
M6	1,00	80	6,0	4,9	5,60	17	30	5	86,13	**060**	104,10	**060**
M8	1,25	90	8,0	6,2	7,45	20	35	5	96,49	**080**	117,90	**080**
M10	1,50	100	10,0	8,0	9,35	22	39	5	125,60	**100**	149,60	**100**



DIN 2174 with reduced shank

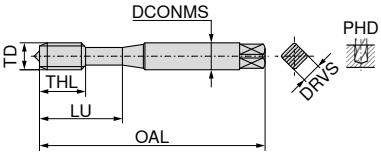
TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	22 452 ... EUR U0		22 454 ... EUR U0	
M12	1,75	110	9	7	11,25	24	6	145,10	**120**	174,60	**120**
M16	2,00	110	12	9	15,10	27	6	235,80	**160**	267,50	**160**

P	**18**	**18**
M	**10**	**10**
K	**10**	**10**
N	**22**	**22**
S		
H		
O		

Through hole / Blind hole – Machine thread formers, right hand

▲ SN = Thread formers with lubrication grooves

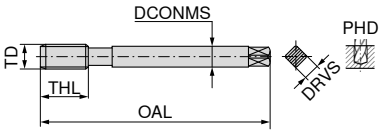
M



DIN 2174 with reinforced shank

	UNI	UNI	UNI SN	UNI SN
	C 2–3	C 2–3	C 2–3	C 2–3
	ISO 2X 6HX	ISO 2X 6HX	ISO 2X 6HX	ISO 2X 6HX
	TiN	CrN	TiN	CrN
				
	HSS-E 0° ≤ 850 N/mm² ≤ 3xD	HSS-E 0° ≤ 850 N/mm² ≤ 3xD	HSS-E 0° ≤ 850 N/mm² ≤ 3xD	HSS-E 0° ≤ 850 N/mm² ≤ 3xD

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	23 810 ... EUR T9		23 812 ... EUR T9		23 814 ... EUR T9		23 816 ... EUR T9	
M2	0,40	45	2,8	2,1	1,85	7	12		25,45	020	24,93	020				
M2	0,40	45	2,8	2,1	1,85	7	12	3					28,86	020	28,44	020
M2,5	0,45	50	2,8	2,1	2,33	9	14	3					26,17	025	24,93	025
M2,5	0,45	50	2,8	2,1	2,33	9	14		22,65	025	21,62	025				
M3	0,50	56	3,5	2,7	2,80	11	18	3					18,72	030	18,10	030
M3	0,50	56	3,5	2,7	2,80	11	18		16,44	030	15,62	030				
M4	0,70	63	4,5	3,4	3,70	13	21	4					19,45	040	18,10	040
M4	0,70	63	4,5	3,4	3,70	13	21		17,06	040	16,03	040				
M5	0,80	70	6,0	4,9	4,65	15	25	4					20,58	050	19,13	050
M5	0,80	70	6,0	4,9	4,65	15	25		18,10	050	16,76	050				
M6	1,00	80	6,0	4,9	5,60	17	30	4					23,79	060	19,13	060
M6	1,00	80	6,0	4,9	5,60	17	30		21,52	060	16,76	060				
M8	1,25	90	8,0	6,2	7,45	20	35	5					26,89	080	22,54	080
M8	1,25	90	8,0	6,2	7,45	20	35		23,99	080	19,35	080				
M10	1,50	100	10,0	8,0	9,35	22	39	5					34,86	100	28,86	100
M10	1,50	100	10,0	8,0	9,35	22	39		31,96	100	24,93	100				



DIN 2174 with reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	23 811 ... EUR T9		23 813 ... EUR T9		23 815 ... EUR T9		23 817 ... EUR T9	
M12	1,75	110	9	7,0	11,25	24		36,51	120	30,51	120				
M12	1,75	110	9	7,0	11,25	24	5					40,85	120	35,06	120
M16	2,00	110	12	9,0	15,10	27	6					76,43	160	70,13	160
M16	2,00	110	12	9,0	15,10	27		68,78	160	61,02	160				
M18	2,50	125	14	11,0	16,80	30	6					141,00	18000		
M20	2,50	140	16	12,0	18,80	32	6					131,10	20000		
M24	3,00	160	18	14,5	22,60	34	6					175,20	24000		

P	18	18	18	18
M	10	10	10	10
K	10		10	
N	22	18	22	18
S				
H				
O				

Through hole – machine taps for wire thread inserts, right hand

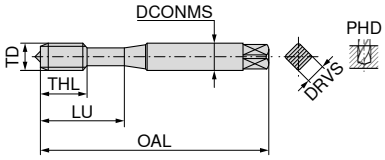
EG M | Stabil

UNI

B
4–5

6H mod

nitr. + vap.

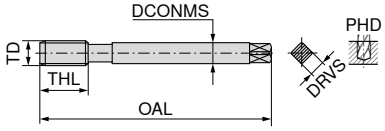


DIN 40435 with reinforced shank

HSS-E
0°
≤ 1100 N/mm²
≤ 4xD

22 662 ...

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	EUR U0	
EG-M2,5	0,45	56	3,5	2,7	2,65	11	18	3	50,20	**025**
EG-M3	0,50	63	4,5	3,4	3,15	10	21	3	41,70	**030**
EG-M4	0,70	70	6,0	4,9	4,20	12	25	3	43,33	**040**
EG-M5	0,80	80	6,0	4,9	5,25	13	30	3	42,02	**050**
EG-M6	1,00	90	8,0	6,2	6,30	17	35	3	42,47	**060**
EG-M8	1,25	100	10,0	8,0	8,40	18	39	3	50,65	**080**



DIN 40435 with reduced shank

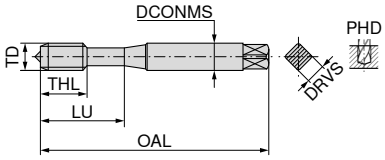
22 663 ...

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	EUR U0	
EG-M10	1,50	100	9	7,0	10,50	22	3	68,11	**100**
EG-M12	1,75	110	11	9,0	12,50	26	3	77,94	**120**
EG-M16	2,00	125	14	11,0	16,50	27	3	113,50	**160**
EG-M20	2,50	160	18	14,5	20,75	34	3	159,40	**200**

P	**12**
M	**7**
K	**12**
N	
S	
H	
O	

Blind hole – machine taps for wire thread inserts, right hand

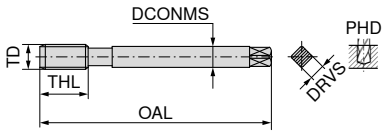
EG M | Salo-Rex



DIN 40435 with reinforced shank

	Soft	UNI
	C 2–3	C 2–3
	6H mod	6H mod
	CH	vap.
		
	HSS-E ◁ 42° ≤ 500 N/mm² ≤ 3xD	HSS-E ◁ 42° ≤ 1100 N/mm² ≤ 3xD

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	22 280 ... EUR U0		22 664 ... EUR U0	
EG-M2,5	0,45	56	3,5	2,7	2,65	5	18	2	60,70	025		
EG-M2,5	0,45	56	3,5	2,7	2,65	5	18	3			48,03	025
EG-M3	0,50	63	4,5	3,4	3,15	5	21	2	58,62	030		
EG-M3	0,50	63	4,5	3,4	3,15	5	21	3			43,76	030
EG-M4	0,70	70	6,0	4,9	4,20	8	25	2	58,62	040		
EG-M4	0,70	70	6,0	4,9	4,20	8	25	3			43,76	040
EG-M5	0,80	80	6,0	4,9	5,25	8	30	2	79,90	050		
EG-M5	0,80	80	6,0	4,9	5,25	8	30	3			40,39	050
EG-M6	1,00	90	8,0	6,2	6,30	10	35	2	81,33	060		
EG-M6	1,00	90	8,0	6,2	6,30	10	35	3			43,76	060
EG-M8	1,25	100	10,0	8,0	8,40	16	39	2	102,20	080		
EG-M8	1,25	100	10,0	8,0	8,40	16	39	3			49,01	080



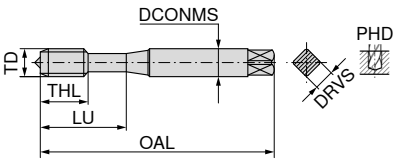
DIN 40435 with reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	22 665 ... EUR U0	
EG-M10	1,50	100	9	7,0	10,50	15	5	62,65	100
EG-M12	1,75	110	11	9,0	12,50	20	4	76,75	120
EG-M16	2,00	125	14	11,0	16,50	20	5	115,70	160
EG-M20	2,50	160	18	14,5	20,75	30	4	157,20	200

P		12
M		7
K		12
N	22	
S		
H		
O		

Through hole – Machine taps, right hand

MF | Stabil



DIN 371 with reinforced shank

	UNI	UNI
	B 4–5	B 4–5
	ISO 2 6H	ISO 2 6H
	nitr. + vap.	TiN
		
	HSS-E	HSS-E
	0° ≤ 1100 N/mm² ≤ 4xD	0° ≤ 1100 N/mm² ≤ 4xD
	22 590 ...	**22 550 ...**

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	EUR U0		EUR U0	
M4x0,5	0,50	63	4,5	3,4	3,5	10	21	3	50,65	040	58,62	040
M5x0,5	0,50	70	6,0	4,9	4,5	11	25	3	50,65	050	58,62	050
M6x0,5	0,50	80	6,0	4,9	5,5	13	30	3	53,37	060	73,36	060
M6x0,75	0,75	80	6,0	4,9	5,2	13	30	3	53,37	062	73,36	062
M8x1	1,00	90	8,0	6,2	7,0	17	35	3	52,07	084	70,08	080
M10x1	1,00	90	10,0	8,0	9,0	18	35	4	53,37	102	79,58	100

P	**12**	**15**
M	**7**	**9**
K	**12**	**18**
N		**12**
S		
H		
O		

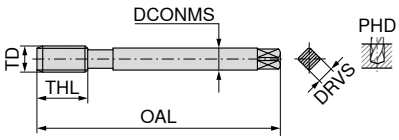
DIN 374 can be found on the next page

Through hole – Machine taps, right hand

▲ TS = for high-speed machining, up to 100 m/min.

▲ LH = for left hand threads

MF | Stabil



DIN 374 with reduced shank

	ST LH	ST TS	UNI	UNI	NEW NW
	B 4–5	B 4–5	B 4–5	B 4–5	B 4–5
	ISO 2 6H	ISO 2X 6HX	ISO 2 6H	ISO 2 6H	ISO 2X 6HX
		TiN	nitr. + vap.	TiN	DLC
					
	HSS-E	HSS-E	HSS-E	HSS-E	HSS-E
	0° ≤ 750 N/mm² ≤ 4xD	0° ≤ 1100 N/mm² ≤ 4xD	0° ≤ 1100 N/mm² ≤ 4xD	0° ≤ 1100 N/mm² ≤ 4xD	0° ≤ 880 N/mm² ≤ 4xD
	22 210 ...	**22 193 ...**	**22 551 ...**	**22 552 ...**	**22 466 ...**

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	EUR U0		EUR U0		EUR U0		EUR U0		EUR U0	
M6x0,5	0,50	80	4,5	3,4	5,5	13	3					93,99	060				
M6x0,75	0,75	80	4,5	3,4	5,2	13	3					45,41	062				
M8x0,75	0,75	80	6,0	4,9	7,2	14	3					49,66	082				
M8x1	1,00	90	6,0	4,9	7,0	10	4			79,58	080						
M8x1	1,00	90	6,0	4,9	7,0	17	3	66,25	084			45,41	084	70,08	080	55,91	08000
M10x0,75	0,75	90	7,0	5,5	9,2	18	4					66,59	100				
M10x1,25	1,25	100	7,0	5,5	8,8	22	3					99,33	104			73,18	10200
M10x1	1,00	90	7,0	5,5	9,0	10	4			85,37	100						
M10x1	1,00	90	7,0	5,5	9,0	18	4	68,77	102			46,29	102	76,75	100	58,08	10000
M12x1,5	1,50	100	9,0	7,0	10,5	22	3	94,64	124			51,30	124	79,58	120	64,79	12400
M12x1,25	1,25	100	9,0	7,0	10,8	22	3					75,31	122			75,25	12200
M12x1,5	1,50	100	9,0	7,0	10,5	15	4			81,98	120						
M12x1	1,00	100	9,0	7,0	11,0	18	4	88,86	120			54,14	120	89,95	121	66,98	12000
M14x1,5	1,50	100	11,0	9,0	12,5	22	3	121,10	144			68,77	144	104,10	140	85,75	14400
M14x1,25	1,25	100	11,0	9,0	12,8	22	3									85,75	14200
M14x1,5	1,50	100	11,0	9,0	12,5	15	4			103,40	140						
M14x1	1,00	100	11,0	9,0	13,0	18	4					139,70	140			90,38	14000
M16x1,5	1,50	100	12,0	9,0	14,5	22	3	121,10	162			81,98	162	107,50	160	95,71	16200
M16x1,5	1,50	100	12,0	9,0	14,5	15	4			137,50	160						
M16x1	1,00	100	12,0	9,0	15,0	18	4									98,29	16000
M18x1	1,00	110	14,0	11,0	17,0	20	5					228,20	180				
M18x2	2,00	125	14,0	11,0	16,0	26	3					187,80	184				
M18x1,5	1,50	110	14,0	11,0	16,5	17	4			170,40	180						
M18x1,5	1,50	110	14,0	11,0	16,5	25	4	137,50	182			95,40	182				
M20x1	1,00	125	16,0	12,0	19,0	20	5					246,70	200				
M20x1,5	1,50	125	16,0	12,0	18,5	17	4			213,90	200						
M20x1,5	1,50	125	16,0	12,0	18,5	25	4	159,40	202			107,50	202	169,20	200		
M25x1,5	1,50	140	18,0	14,5	23,5	28	4					397,30	250				
M26x1,5	1,50	140	18,0	14,5	24,5	28	4					164,90	260				
M24x1,5	1,50	140	18,0	14,5	22,5	27	4					133,20	242				
M24x2	2,00	140	18,0	14,5	22,0	27	4					241,20	244				
M22x1,5	1,50	125	18,0	14,5	20,5	25	4					117,90	222	205,30	220		
M27x2	2,00	140	20,0	16,0	25,0	28	4					419,20	272				
M28x1,5	1,50	140	20,0	16,0	26,5	28	5					193,20	280				
M30x1,5	1,50	150	22,0	18,0	28,5	28	5					207,30	302				

P	**12**	**65**	**12**	**15**	
M			**7**	**9**	
K	**12**	**65**	**12**	**18**	
N	**22**	**22**		**12**	**15**
S					
H					
O					

Through hole – Machine taps, right hand

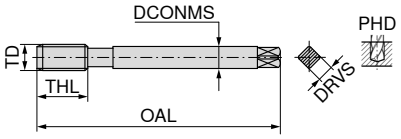
MF

UNI

B
4–5

ISO 2
6H

TiN



DIN 374 with reduced shank

HSS-PM

0°
≤ 1000 N/mm²
≤ 3xD

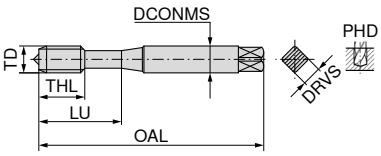
23 041 ...

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	EUR T9	
M8x1	1,00	90	6	4,9	7,0	17	3	22,24	**081**
M10x1	1,00	90	7	5,5	9,0	18	4	25,45	**102**
M10x1,25	1,25	100	7	5,5	8,8	22	3	27,30	**104**
M12x1	1,00	100	9	7,0	11,0	18	4	31,34	**120**
M12x1,25	1,25	100	9	7,0	10,8	22	3	32,78	**122**
M12x1,5	1,50	100	9	7,0	10,5	22	3	29,17	**121**
M14x1,5	1,50	100	11	9,0	12,5	22	3	35,99	**144**
M14x1,25	1,25	100	11	9,0	12,8	22	3	37,86	**142**
M16x1,5	1,50	100	12	9,0	14,5	22	3	40,75	**162**
M18x1,5	1,50	110	14	11,0	16,5	17	4	53,89	**182**
M20x1,5	1,50	125	16	12,0	18,5	17	4	72,82	**202**
M24x1,5	1,50	140	18	14,5	22,5	27	4	78,60	**242**
M24x2	2,00	140	18	14,5	22,0	27	4	89,57	**244**
M22x1,5	1,50	125	18	14,5	20,5	25	4	68,47	**222**

P	**15**
M	**9**
K	**18**
N	**12**
S	
H	
O	

Through hole – Machine taps, right hand

MF



DIN 371 with reinforced shank

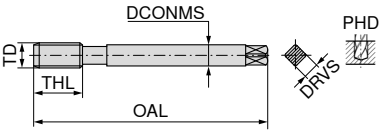
HSS-E
◁ 0°
≤ 1000 N/mm²
≤ 3xD

HSS-E
◁ 0°
≤ 1000 N/mm²
≤ 3xD

HSS-E
◁ 0°
≤ 850 N/mm²
≤ 3xD

HSS-E
◁ 0°
≤ 1200 N/mm²
≤ 4xD

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	23 140 ... EUR T9		23 142 ... EUR T9		23 240 ... EUR T9		23 440 ... EUR T9	
M4x0,5	0,50	63	4,5	3,4	3,5	10	21	3	15,72	040	21,20	040	18,93	040		
M5x0,5	0,50	70	6,0	4,9	4,5	11	25	3	15,72	050	21,41	050	19,13	050	26,07	050
M6x0,5	0,50	80	6,0	4,9	5,5	13	30	3	16,76	060	26,37	060	19,13	060		
M6x0,75	0,75	80	6,0	4,9	5,2	13	30	3	15,72	062	26,37	062	18,93	062	31,86	062



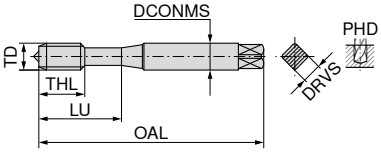
DIN 374 with reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	23 141 ... EUR T9		23 143 ... EUR T9		23 241 ... EUR T9		23 441 ... EUR T9	
M8x0,5	0,50	80	6	8,0	7,5	14	3					25,45	080		
M8x1	1,00	90	6	4,9	7,0	17	3	14,07	084			20,79	084	33,72	084
M8x1	1,00	90	6	4,9	7,0	17	4			25,96	084				
M8x0,75	0,75	80	6	4,9	7,2	14	3	18,00	082	27,62	082	22,03	082	35,89	082
M10x0,75	0,75	90	7	5,5	9,2	18	4	24,31	100	36,93	100	30,41	100		
M10x1,25	1,25	100	7	5,5	8,8	22	3	21,92	104	34,75	104	25,03	104		
M10x1	1,00	90	7	5,5	9,0	18	4	14,48	102	28,34	102	24,20	102	36,71	102
M12x1,5	1,50	100	9	7,0	10,5	22	3	16,44	124	30,09	124	26,89	124	39,30	124
M12x1,25	1,25	100	9	7,0	10,8	22	3	22,14	122	35,37	122	29,37	122		
M12x1	1,00	100	9	7,0	11,0	18	4	18,62	120	32,58	120	28,02	120	42,31	120
M14x1	1,00	100	11	9,0	13,0	18	4	26,37	140	39,10	140	34,54	140		
M14x1,5	1,50	100	11	9,0	12,5	22	3	23,48	144	40,03	144	33,20	144	51,92	144
M16x1	1,00	100	12	9,0	15,0	18	4	29,58	160	45,61	160	45,61	160		
M16x1,5	1,50	100	12	9,0	14,5	22	3	24,31	162	45,61	162	42,20	162	59,37	162
M18x1	1,00	110	14	11,0	17,0	20	5					60,30	180		
M18x1,5	1,50	110	14	11,0	16,5	25	4	33,52	182	56,37	182	54,82	182		
M20x1,5	1,50	125	16	12,0	18,5	25	4	37,34	202	71,47	202	60,82	202		
M20x1	1,00	125	16	12,0	19,0	20	5					65,16	200		
M22x1,5	1,50	125	18	14,5	20,5	25	4	42,20	222	74,26	222	70,02	222		
M24x1,5	1,50	140	18	14,5	22,5	27	4	48,61	242	77,78	242	81,61	242		
M26x1,5	1,50	140	18	14,5	24,5	28	4					104,40	260		
M28x1,5	1,50	140	20	16,0	26,5	28	5					120,00	280		
M30x1,5	1,50	150	22	18,0	28,5	28	5					133,50	300		

P	12	15	12	10
M	7	9		8
K	12	18	12	
N		12	12	24
S				
H				
O				

Blind hole – Machine taps, right hand

MF | Salo-Rex

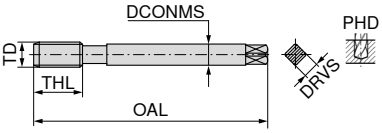


DIN 371 with reinforced shank

UNI	UNI	UNI	UNI
E 1,5–2	E 1,5–2	E 1,5–2	E 1,5–2
ISO 2 6H	ISO 2 6H	ISO 2 6H	ISO 3 6G
vap.	TiN	vap.	vap.

HSS-E ◁ 42° ≤ 1100 N/mm² ≤ 3xD | HSS-E ◁ 42° ≤ 1100 N/mm² ≤ 3xD | HSS-E ◁ 42° ≤ 1100 N/mm² ≤ 3xD | HSS-E ◁ 42° ≤ 1100 N/mm² ≤ 3xD

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	22 441 ... EUR U0	
M4x0,5	0,50	63	4,5	3,4	3,50	5	21	3	54,68	**040**
M5x0,5	0,50	70	6,0	4,9	4,50	5	25	3	54,68	**050**
M6x0,75	0,75	80	6,0	4,9	5,25	8	30	3	54,68	**062**



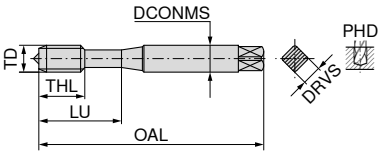
DIN 374 with reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	22 555 ... EUR U0		22 556 ... EUR U0		22 491 ... EUR U0		22 490 ... EUR U0	
M8x1	1,0	90	6	4,9	7,0	10	3	50,00	**080**	64,08	**080**			54,68	**080**
M10x1	1,0	90	7	5,5	9,0	10	4	53,92	**100**	81,98	**100**			60,26	**100**
M12x1,5	1,5	100	9	7,0	10,5	15	5	61,67	**120**	93,99	**120**	88,86	**120**	66,25	**120**
M14x1,5	1,5	100	11	9,0	12,5	15	5	79,58	**140**	120,10	**140**	117,90	**140**	87,32	**140**
M16x1,5	1,5	100	12	9,0	14,5	15	5	94,64	**160**	126,60	**160**	121,10	**160**	104,10	**160**
M18x1,5	1,5	110	14	11,0	16,5	17	5							120,10	**180**
M20x1,5	1,5	125	16	12,0	18,5	17	5					185,50	**200**	137,50	**200**
P									**12**		**15**		**12**		**12**
M									**7**		**9**		**7**		**7**
K									**12**		**18**		**12**		**12**
N											**12**				
S															
H															
O															

Blind hole – Machine taps, right hand

▲ CNC = for synchronised CNC machining with minimum length compensation chuck

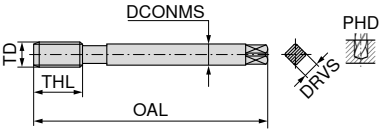
MF | Salo-Rex



DIN 371 with reinforced shank

	UNI	UNI	UNI CNC	UNI CNC
	C 2–3	C 2–3	E 1,5–2	E 1,5–2
	ISO 2 6H	ISO 2 6H	7G	ISO 2 6H
	vap.	TiN	TiN GS	TiN GS
				
	HSS-E ◁ 42° ≤ 1100 N/mm² ≤ 3xD	HSS-E ◁ 42° ≤ 1100 N/mm² ≤ 3xD	HSS-E ◁ 45° ≤ 1100 N/mm² ≤ 3xD	HSS-E ◁ 45° ≤ 1100 N/mm² ≤ 3xD
	22 202 ...			**22 548 ...**

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	EUR U0		EUR U0	
M4x0,5	0,50	63	4,5	3,4	3,5	5	21	3	54,68	040		
M5x0,5	0,50	70	6,0	4,9	4,5	5	25	3	50,00	050	63,30	050
M6x0,75	0,75	80	6,0	4,9	5,2	8	30	3	54,68	062	63,30	062
M6x0,5	0,50	80	6,0	4,9	5,5	5	30	3	54,68	060	63,30	060



DIN 374 with reduced shank

								22 553 ...		22 554 ...		22 563 ...		22 549 ...	
TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	EUR U0		EUR U0		EUR U0		EUR U0	
M6x0,75	0,75	80	4,5	3,4	5,2	8	3	54,68	062						
M8x0,75	0,75	80	6,0	4,9	7,2	8	3	51,30	080					66,59	082
M8x1	1,00	90	6,0	4,9	7,0	10	3	47,37	082	64,08	080	96,71	084	80,66	084
M10x0,75	0,75	90	7,0	5,5	9,2	10	4	94,64	101						
M10x1	1,00	90	7,0	5,5	9,0	10	3	50,65	100	81,98	100				
M10x1	1,00	90	7,0	5,5	9,0	10	4					104,10	102	92,12	102
M10x1,25	1,25	100	7,0	5,5	8,8	16	3	125,60	102						
M12x1	1,00	100	9,0	7,0	11,0	11	4	64,08	120	96,16	121			106,00	120
M12x1,25	1,25	100	9,0	7,0	10,8	15	4	100,10	122						
M12x1,5	1,50	100	9,0	7,0	10,5	15	4	61,67	124	93,99	120				
M12x1,5	1,50	100	9,0	7,0	10,5	15	5					117,90	124	102,20	124
M14x1,5	1,50	100	11,0	9,0	12,5	15	5					145,10	144	130,00	144
M14x1,5	1,50	100	11,0	9,0	12,5	15	4	76,08	140	108,80	140				
M16x1,5	1,50	100	12,0	9,0	14,5	15	4	92,90	160	126,60	160				
M16x1,5	1,50	100	12,0	9,0	14,5	15	5					164,90	162	151,70	162
M18x1,5	1,50	110	14,0	11,0	16,5	17	5							185,50	182
M18x1,5	1,50	110	14,0	11,0	16,5	17	4	113,50	180	161,50	182				
M20x1,5	1,50	125	16,0	12,0	18,5	17	5					246,70	202	228,20	202
M20x1,5	1,50	125	16,0	12,0	18,5	17	4	155,00	200	205,30	202				
M22x1,5	1,50	125	18,0	14,5	20,5	17	4	150,60	220						
M26x1,5	1,50	140	18,0	14,5	24,5	20	5	209,60	260						
M24x1,5	1,50	140	18,0	14,5	22,5	20	5	163,80	240						
M28x1,5	1,50	140	20,0	16,0	26,5	20	5	246,70	280						
M30x1,5	1,50	150	22,0	18,0	28,5	22	6	250,00	300						

P	**12**	**15**	**15**	**15**
M	**7**	**9**	**9**	**9**
K	**12**	**18**	**18**	**18**
N		**12**	**12**	**12**
S				
H				
O				

Blind hole – Machine taps

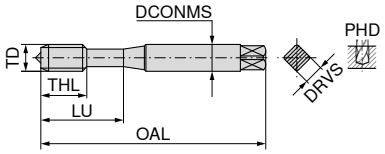
▲ LH = for left hand threads

MF | Salo-Rex

ST LH | ST

C 2–3 | C 2–3

ISO 2 6H | ISO 2 6H



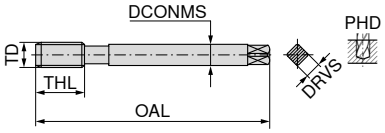
DIN 371 with reinforced shank

HSS-E
42°
≤ 750 N/mm²
≤ 3xD

HSS-E
42°
≤ 750 N/mm²
≤ 3xD

6

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	22 238 ... EUR U0	
M2,5x0,35	0,35	50	2,8	2,1	2,15	5,0	15	2	87,32	025
M3x0,35	0,35	56	3,5	2,7	2,65	4,5	18	3	53,37	030
M3,5x0,35	0,35	56	4,0	3,0	3,15	5,0	20	3	73,36	035
M4x0,5	0,50	63	4,5	3,4	3,50	5,0	21	3	49,34	040
M5x0,5	0,50	70	6,0	4,9	4,50	5,0	25	3	49,34	050
M6x0,75	0,75	80	6,0	4,9	5,20	8,0	30	3	49,34	060
M8x0,75	0,75	80	8,0	6,2	7,20	8,0	30	3	54,68	080
M8x1	1,00	90	8,0	6,2	7,00	10,0	35	3	49,34	082



DIN 374 with reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	22 601 ... EUR U0		22 186 ... EUR U0	
M6x0,75	0,75	80	4,5	3,4	5,2	8	3			48,79	060
M8x0,75	0,75	80	6,0	4,9	7,2	8	3			50,00	080
M8x1	1,00	90	6,0	4,9	7,0	10	3	79,58	082	45,41	082
M10x1	1,00	90	7,0	5,5	9,0	10	3	81,98	100	47,37	100
M12x1,5	1,50	100	9,0	7,0	10,5	15	4			56,43	122
M12x1	1,00	100	9,0	7,0	11,0	11	4	100,10	120	58,40	120
M14x1,5	1,50	100	11,0	9,0	12,5	15	4	108,20	140	75,31	140
M16x1,5	1,50	100	12,0	9,0	14,5	15	4	128,80	160	88,86	160
M18x1,5	1,50	110	14,0	11,0	16,5	17	4	149,60	180	115,70	180
M20x1,5	1,50	125	16,0	12,0	18,5	17	4	174,60	200	114,60	200
M22x1,5	1,50	125	18,0	14,5	20,5	17	4			128,80	220
M26x1,5	1,50	140	18,0	14,5	24,5	20	5			201,90	260
M24x1,5	1,50	140	18,0	14,5	22,5	20	5			138,60	240
P									**12**		**12**
M											
K									**12**		**12**
N									**12**		**22**
S											
H											
O											

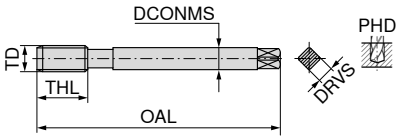
Blind hole – Machine taps, right hand

MF | SL

ST

C
2–3

ISO 2
6H



DIN 374 with reduced shank

HSS-E
15°
≤ 750 N/mm²
≤ 2xD

22 182 ...

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	EUR U0	
M6x0,75	0,75	80	4,5	3,4	5,2	13	3	50,20	**062**
M8x0,75	0,75	80	6,0	4,9	7,2	14	3	50,65	**082**
M8x1	1,00	90	6,0	4,9	7,0	17	3	46,29	**084**
M10x1	1,00	90	7,0	5,5	9,0	18	3	48,79	**102**
M10x0,75	0,75	90	7,0	5,5	9,2	18	3	80,66	**100**
M10x1,25	1,25	100	7,0	5,5	8,8	22	3	69,54	**104**
M9x1	1,00	90	7,0	5,5	8,0	17	3	68,77	**090**
M11x1	1,00	90	8,0	6,2	10,0	18	3	77,29	**110**
M12x1,25	1,25	100	9,0	7,0	10,8	22	3	77,29	**122**
M12x1,5	1,50	100	9,0	7,0	10,5	22	3	56,98	**124**
M12x1	1,00	100	9,0	7,0	11,0	18	3	59,71	**120**
M14x1	1,00	100	11,0	9,0	13,0	18	4	78,81	**140**
M14x1,5	1,50	100	11,0	9,0	12,5	22	3	76,75	**144**
M16x1	1,00	100	12,0	9,0	15,0	18	4	92,90	**160**
M16x1,5	1,50	100	12,0	9,0	14,5	22	3	90,60	**162**
M15x1	1,00	100	12,0	9,0	14,0	18	4	103,40	**150**
M18x1,5	1,50	110	14,0	11,0	16,5	25	4	117,90	**182**
M18x2	2,00	125	14,0	11,0	16,0	26	3	186,70	**184**
M18x1	1,00	110	14,0	11,0	17,0	20	4	127,70	**180**
M20x1	1,00	125	16,0	12,0	19,0	20	4	130,00	**200**
M20x2	2,00	140	16,0	12,0	18,0	27	3	159,40	**204**
M20x1,5	1,50	125	16,0	12,0	18,5	25	4	116,80	**202**
M22x2	2,00	140	18,0	14,5	20,0	27	4	162,60	**224**
M24x1,5	1,50	140	18,0	14,5	22,5	27	4	144,10	**242**
M24x1	1,00	140	18,0	14,5	23,0	20	5	177,90	**240**
M24x2	2,00	140	18,0	14,5	22,0	27	4	168,10	**244**
M22x1,5	1,50	125	18,0	14,5	20,5	25	4	132,10	**222**
M25x1,5	1,50	140	18,0	14,5	23,5	28	4	240,20	**252**
M22x1	1,00	125	18,0	14,5	21,0	20	4	170,40	**220**
M27x1,5	1,50	140	20,0	16,0	25,5	28	4	208,50	**270**
M28x2	2,00	140	20,0	16,0	26,0	28	4	275,10	**282**
M27x2	2,00	140	20,0	16,0	25,0	28	4	235,80	**272**
M30x1,5	1,50	150	22,0	18,0	28,5	28	5	239,10	**302**
M32x1,5	1,50	150	22,0	18,0	30,5	28	6	275,10	**320**
M30x2	2,00	150	22,0	18,0	28,0	28	4	253,30	**304**
M33x2	2,00	160	25,0	20,0	31,0	30	4	332,90	**332**
M36x2	2,00	170	28,0	22,0	34,0	30	5	423,50	**362**
M36x3	3,00	200	28,0	22,0	33,0	42	4	397,30	**364**
M34x1,5	1,50	170	28,0	22,0	32,5	30	6	336,30	**340**
M40x1,5	1,50	170	32,0	24,0	38,5	30	6	417,10	**400**
M42x3	3,00	200	32,0	24,0	39,0	45	4	533,80	**424**
M42x2	2,00	170	32,0	24,0	40,0	30	6	504,30	**422**
M45x1,5	1,50	180	36,0	29,0	43,5	32	6	493,40	**450**
M48x2	2,00	190	36,0	29,0	46,0	32	6	695,40	**482**
M48x3	3,00	225	36,0	29,0	45,0	50	5	706,30	**484**

P	**12**
M	
K	**12**
N	**22**
S	
H	
O	

Continued on next page

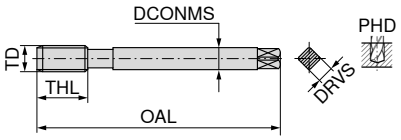
Blind hole – Machine taps, right hand

MF | SL

ST

C
2–3

ISO 2
6H



DIN 374 with reduced shank

HSS-E
15°
≤ 750 N/mm²
≤ 2xD

22 182 ...

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	EUR U0	
M45x3	3,00	200	36,0	29,0	42,0	45	5	681,10	**454**
M48x1,5	1,50	190	36,0	29,0	46,5	32	6	579,60	**480**
M52x2	2,00	190	40,0	32,0	50,0	32	6	825,20	**522**

P	**12**
M	
K	**12**
N	**22**
S	
H	
O	

6

Blind hole – Machine taps, right hand

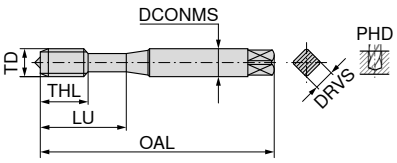
MF | Salo-Rex

VA

E
1,5–2

ISO 2
6H

TiN GS



DIN 371 with reinforced shank

HSS-E
45°
≤ 900 N/mm²
≤ 3xD

22 176 ...

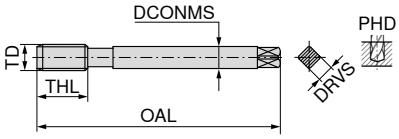
TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	EUR U0	
M4x0,5	0,50	63	4,5	3,4	3,5	5	21	3	83,50	**040**
M5x0,5	0,50	70	6,0	4,9	4,5	5	25	3	64,08	**050**
M6x0,5	0,50	80	6,0	4,9	5,5	5	30	3	64,08	**060**
M6x0,75	0,75	80	6,0	4,9	5,2	8	30	3	64,08	**062**

P	**10**
M	**8**
K	
N	**22**
S	
H	
O	

DIN 374 can be found on the next page

Blind hole – Machine taps, right hand

MF | Salo-Rex



DIN 374 with reduced shank

	NW	NW	VA	VA
	NEW			
	C 2–3	C 2–3	E 1,5–2	E 1,5–2
	ISO 2 6H	ISO 2 6H	ISO 2 6H	ISO 2 6H
	vap.	DLC	vap.	TiN GS
				
	HSS-E ◁ 42° ≤ 500 N/mm² ≤ 3xD	HSS-E ◁ 38° ≤ 880 N/mm² ≤ 3xD	HSS-E ◁ 42° ≤ 750 N/mm² ≤ 3xD	HSS-E ◁ 45° ≤ 900 N/mm² ≤ 3xD
	22 188 ...	22 462 ...	22 189 ...	22 177 ...

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	EUR U0		EUR U0		EUR U0		EUR U0	
M8x1	1,00	90	6	4,9	7,0	10	3	50,00	**081**	59,46	**08000**	50,00	**082**	81,43	**084**
M8x0,75	0,75	80	6	4,9	7,2	8	3							67,34	**082**
M10x1	1,00	90	7	5,5	9,0	10	3	52,07	**100**	64,21	**10000**				
M10x1,25	1,25	100	7	5,5	8,8	16	3			85,56	**10200**				
M10x1	1,00	90	7	5,5	9,0	10	4					58,07	**100**	92,90	**102**
M12x1,25	1,25	100	9	7,0	10,8	15	4			95,26	**12200**				
M12x1,5	1,50	100	9	7,0	10,5	15	4	57,31	**122**	76,03	**12400**				
M12x1,5	1,50	100	9	7,0	10,5	15	5					64,08	**120**	103,40	**124**
M12x1	1,00	100	9	7,0	11,0	11	4	63,64	**120**	77,05	**12000**	65,70	**121**	107,50	**120**
M14x1	1,00	100	11	9,0	13,0	11	4			98,50	**14000**				
M14x1,25	1,25	100	11	9,0	12,8	15	4			99,51	**14200**				
M14x1,5	1,50	100	11	9,0	12,5	15	4	81,98	**140**	97,39	**14400**				
M14x1,5	1,50	100	11	9,0	12,5	15	5					79,58	**140**	132,10	**144**
M16x1	1,00	100	12	9,0	15,0	12	4			113,50	**16000**				
M16x1,5	1,50	100	12	9,0	14,5	15	4	89,95	**160**	112,40	**16200**				
M16x1,5	1,50	100	12	9,0	14,5	15	5					96,16	**160**	154,00	**162**
M18x1,5	1,50	110	14	11,0	16,5	17	5							187,80	**182**
M18x1,5	1,50	110	14	11,0	16,5	17	4	126,60	**180**						
M20x1,5	1,50	125	16	12,0	18,5	17	5					133,20	**200**	232,60	**202**
M20x1,5	1,50	125	16	12,0	18,5	17	4	117,90	**200**						
M26x1,5	1,50	140	18	14,5	24,5	20	6					258,70	**260**		
M28x1,5	1,50	140	20	16,0	26,5	20	6					302,40	**280**		
M30x1,5	1,50	150	22	18,0	28,5	22	6					299,10	**300**		

P			**15**		**8**	**10**
M					**6**	**8**
K						
N			**22**	**15**	**22**	**22**
S						
H						
O						

6

Blind hole – Machine taps, right hand

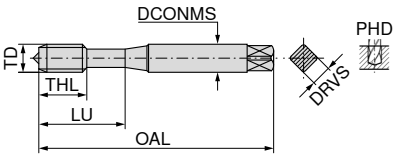
MF

UNI

C
2–3

ISO 2
6H

TiN



DIN 374 with reinforced shank

HSS-PM
40°
≤ 1000 N/mm²
≤ 2,5xD

23 047 ...

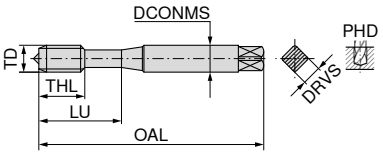
TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	EUR T9	
M8x1	1,00	90	6	4,9	7,0	10	35	3	21,82	**081**
M10x1	1,00	90	7	5,5	9,0	10	35	4	28,44	**102**
M10x1,25	1,25	100	7	5,5	8,8	16	39	4	27,72	**104**
M12x1	1,00	100	9	7,0	11,0	11	40	4	32,37	**120**
M12x1,25	1,25	100	9	7,0	10,8	15	40	5	35,27	**122**
M12x1,5	1,50	100	9	7,0	10,5	15	40	5	31,34	**121**
M14x1	1,00	100	11	9,0	12,8	11	40	4	37,86	**140**
M14x1,5	1,50	100	11	9,0	12,5	15	40	5	37,13	**144**
M16x1,5	1,50	100	12	9,0	14,5	15	44	5	48,09	**162**
M18x1,5	1,50	110	14	11,0	16,5	17	44	5	62,57	**182**
M20x1,5	1,50	125	16	12,0	18,5	17	44	5	71,36	**202**
M22x1,5	1,50	125	18	14,5	20,5	17	44	5	78,60	**222**
M24x1,5	1,50	140	18	14,5	22,5	20	48	5	80,05	**242**
M24x2	2,00	140	18	14,5	22,0	20	48	5	93,19	**244**

P	**15**
M	**9**
K	**18**
N	**12**
S	
H	
O	

Blind hole – Machine taps, right hand

▲ NC = for synchronised CNC machining with minimum length compensation chuck

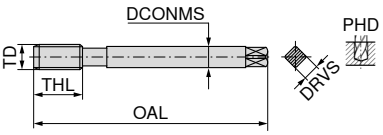
MF



DIN 371 with reinforced shank

	UNI	UNI	UNI NC	FE
	C 2–3	C 2–3	E 1,5–2	C 2–3
	ISO 2 6H	ISO 2 6H	ISO 2 6H	ISO 2 6H
	vap.	TiN	TiN GS	
	HSS-E ◁ 35° ≤ 1000 N/mm² ≤ 2,5xD	HSS-E ◁ 35° ≤ 1000 N/mm² ≤ 2,5xD	HSS-E ◁ 45° ≤ 1000 N/mm² ≤ 3xD	HSS-E ◁ 35° ≤ 850 N/mm² ≤ 2,5xD
	23 144 ...	**23 146 ...**	**23 148 ...**	**23 242 ...**

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	EUR T9		EUR T9		EUR T9		EUR T9	
M4x0,5	0,50	63	4,5	3,4	3,5	5	21	3	15,72	040	22,86	040			20,37	040
M5x0,5	0,50	70	6,0	4,9	4,5	5	25	3	15,72	050	22,86	050	30,31	050	20,79	050
M6x0,5	0,50	80	6,0	4,9	5,5	5	30	3	17,17	060	26,58	060	38,88	060	20,79	060
M6x0,75	0,75	80	6,0	4,9	5,2	8	30	3	16,76	062	26,58	062	38,88	062	20,37	062



DIN 374 with reduced shank

								23 145 ...		23 147 ...		23 149 ...		23 243 ...	
TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	EUR T9		EUR T9		EUR T9		EUR T9	
M4x0,5	0,50	63	2,8	2,1	3,5	5	3	15,31	040						
M5x0,5	0,50	70	3,5	2,7	4,5	5	3	15,31	050						
M6x0,75	0,75	80	4,5	3,4	5,2	8	3	16,34	062						
M8x1	1,00	90	6,0	4,9	7,0	10	3	13,55	084	26,58	084	38,88	084	22,14	084
M8x0,75	0,75	80	6,0	4,9	7,2	8	3	18,51	082	28,34	082	41,47	082	23,58	082
M8x0,5	0,50	80	6,0	8,0	7,5	6	3							45,30	080
M10x1,25	1,25	100	7,0	5,5	8,8	16	3	15,72	104	37,65	104			42,92	104
M10x1	1,00	90	7,0	5,5	9,0	10	3	14,17	102	29,79	102			25,96	102
M10x1	1,00	90	7,0	5,5	9,0	10	4					45,72	102		
M10x0,75	0,75	90	7,0	5,5	9,2	10	4	29,79	100	43,23	100			49,64	100
M12x1,25	1,25	100	9,0	7,0	10,8	15	4	22,44	122	42,41	122			48,20	122
M12x1,5	1,50	100	9,0	7,0	10,5	15	4	16,76	124	33,72	124			28,75	124
M12x1,5	1,50	100	9,0	7,0	10,5	15	5					49,34	124		
M12x1	1,00	100	9,0	7,0	11,0	11	4	19,03	120	34,96	120	52,03	120	29,89	120
M14x1,5	1,50	100	11,0	9,0	12,5	15	4	22,76	144	42,41	144			35,37	144
M14x1,5	1,50	100	11,0	9,0	12,5	15	5					63,40	144		
M14x1	1,00	100	11,0	9,0	13,0	11	4	25,03	140	45,61	140			48,20	140
M16x1,5	1,50	100	12,0	9,0	14,5	15	4	26,07	162	50,06	162			45,10	162
M16x1,5	1,50	100	12,0	9,0	14,5	15	5					70,64	162		
M16x1	1,00	100	12,0	9,0	15,0	12	4	26,89	160	50,06	160			56,68	160
M18x1,5	1,50	110	14,0	11,0	16,5	17	4	36,09	182	58,33	182			58,33	182
M18x1,5	1,50	110	14,0	11,0	16,5	17	5					89,57	182		
M20x1,5	1,50	125	16,0	12,0	18,5	17	5					116,90	202		
M20x1,5	1,50	125	16,0	12,0	18,5	17	4	33,20	202	74,26	202			65,16	202
M22x1,5	1,50	125	18,0	14,5	20,5	17	4	49,34	222	82,54	222			75,40	222
M24x1,5	1,50	140	18,0	14,5	22,5	20	5	53,78	242	88,12	242			87,92	242

P	12	15	15	12
M	7	9	9	
K	12	18	18	12
N		12	12	22
S				
H				
O				

6

Blind hole – Machine taps, right hand

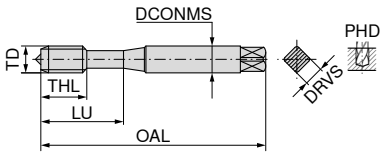
MF

VA

E
1,5–2

ISO 2
6H

TiN

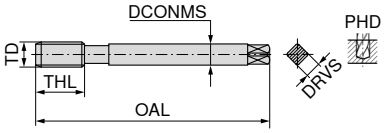


DIN 371 with reinforced shank

HSS-E
∢ 45°
≤ 1200 N/mm²
≤ 3xD

23 442 ...

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	EUR T9	
M5x0,5	0,50	70	6	4,9	4,5	5	25	3	27,62	**050**
M6x0,75	0,75	80	6	4,9	5,2	8	30	3	32,48	**062**



DIN 374 with reduced shank

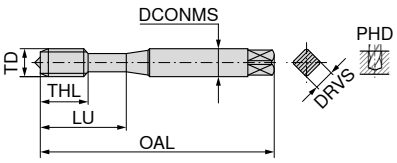
23 443 ...

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	EUR T9	
M8x1	1,00	90	6	4,9	7,0	10	3	32,48	**084**
M8x0,75	0,75	80	6	4,9	7,2	8	3	34,65	**082**
M10x1	1,00	90	7	5,5	9,0	10	4	36,51	**102**
M12x1	1,00	100	9	7,0	11,0	11	4	42,82	**120**
M12x1,5	1,50	100	9	7,0	10,5	15	5	41,17	**124**
M14x1,5	1,50	100	11	9,0	12,5	15	5	52,23	**144**
M16x1,5	1,50	100	12	9,0	14,5	15	5	59,99	**162**

P	**10**
M	**8**
K	
N	**24**
S	
H	
O	

Through hole / Blind hole – Machine taps, right hand

MF | TWIN



DIN 371 with reinforced shank

ST	HR	HT
C 2–3	C 2–3	D 4–5
ISO 2X 6HX	ISO 2X 6HX	ISO 2X 6HX
	nitr.	OSM



	HSS-E	HSS-E	Solid carbide
	0° ≤ 750 N/mm² ≤ 2xD	0° ≤ 1400 N/mm² ≤ 2xD	0° ≤ 63 HRC ≤ 1,5xD
	22 144 ...	**22 146 ...**	**22 817 ...**

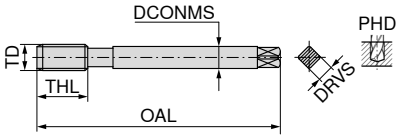
TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	EUR U0		EUR U0		EUR U0	
M4x0,5	0,50	63	4,5	3,4	3,5	10	21	3	42,67	**040**	47,37	**040**		
M5x0,5	0,50	70	6,0	4,9	4,5	11	25	3	42,67	**050**	47,37	**050**		
M6x0,5	0,50	80	6,0	4,9	5,5	13	30	3	42,67	**060**	47,37	**060**		
M6x0,75	0,75	80	6,0	4,9	5,2	13	30	3	42,67	**062**	47,37	**062**		
M8x1	1,00	90	8,0	6,2	7,0	17	35	3	42,67	**084**				
M8x1	1,00	90	8,0	6,2	7,1	15	35	5					359,90	**080**
M10x1	1,00	100	10,0	8,0	9,1	18	38	5					459,40	**100**
M10x1	1,00	90	10,0	8,0	9,0	18	35	4	42,67	**104**				
M12x1,5	1,50	110	12,0	9,0	10,6	21	41	5					532,40	**120**
M14x1,5	1,50	110	14,0	11,0	12,6	24	44	6					625,00	**140**
M16x1,5	1,50	110	16,0	12,0	14,6	24	44	6					710,50	**160**

P	**12**	**6**	
M			
K	**12**	**16**	
N	**22**	**22**	
S			
H			**2**
O			

DIN 374 can be found on the next page

Through hole / Blind hole – Machine taps, right hand

MF | TWIN



DIN 374 with reduced shank

ST	HR	GG
C 2–3	C 2–3	C 2–3
ISO 2X 6HX	ISO 2X 6HX	ISO 2X 6HX
	nitr.	nitr.

	HSS-E	HSS-E	HSS-E
	0° ≤ 750 N/mm² ≤ 2xD	0° ≤ 1400 N/mm² ≤ 2xD	0° ≤ 1050 N/mm² ≤ 2xD
	22 171 ...	22 209 ...	22 173 ...

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	EUR U0		EUR U0		EUR U0	
M4x0,5	0,50	63	2,8	2,1	3,5	10	3	38,86	042				
M5x0,5	0,50	70	3,5	2,7	4,5	11	3	46,61	050			43,33	050
M6x0,75	0,75	80	4,5	3,4	5,2	13	3	42,02	062			47,37	062
M6x0,5	0,50	80	4,5	3,4	5,5	13	3	43,33	060			53,59	060
M8x0,75	0,75	80	6,0	4,9	7,2	14	3	47,70	082			83,50	080
M8x1	1,00	90	6,0	4,9	7,0	17	3	38,32	084	47,37	082	83,50	082
M10x1	1,00	90	7,0	5,5	9,0	18	4	39,73	104	47,37	100	46,61	100
M10x1,25	1,25	100	7,0	5,5	8,8	22	3	47,37	106				
M10x0,75	0,75	90	7,0	5,5	9,2	18	4	61,67	102				
M11x1	1,00	90	8,0	6,2	10,0	18	4	70,08	110				
M12x1	1,00	100	9,0	7,0	11,0	18	4	46,29	122			53,59	120
M12x1,25	1,25	100	9,0	7,0	10,8	22	4	56,98	124				
M12x1,5	1,50	100	9,0	7,0	10,5	22	4	46,29	126	56,98	120	51,52	124
M14x1	1,00	100	11,0	9,0	13,0	18	4	70,08	140			79,58	140
M14x1,25	1,25	100	11,0	9,0	12,8	22	4	64,08	142				
M14x1,5	1,50	100	11,0	9,0	12,5	22	4	66,25	144	73,36	140	72,70	142
M16x1	1,00	100	12,0	9,0	15,0	18	5	72,70	160				
M16x1,5	1,50	100	12,0	9,0	14,5	22	4	65,16	162	79,58	160	75,31	160
M18x1	1,00	110	14,0	11,0	17,0	20	5	93,99	180				
M18x2	2,00	125	14,0	11,0	16,0	26	4	104,80	184				
M18x1,5	1,50	110	14,0	11,0	16,5	25	4	87,32	182	94,64	180	100,90	180
M20x1	1,00	125	16,0	12,0	19,0	20	5	104,80	200				
M20x2	2,00	140	16,0	12,0	18,0	27	4	131,00	204				
M20x1,5	1,50	125	16,0	12,0	18,5	25	4	95,40	202	120,10	200	105,50	200
M24x2	2,00	140	18,0	14,5	22,0	27	4	128,80	244				
M22x2	2,00	140	18,0	14,5	20,0	27	4	145,10	224				
M22x1	1,00	125	18,0	14,5	21,0	20	5	147,40	220				
M24x1	1,00	140	18,0	14,5	23,0	20	6	161,50	240				
M26x1,5	1,50	140	18,0	14,5	24,5	28	4	162,60	260			159,40	260
M24x1,5	1,50	140	18,0	14,5	22,5	27	4	114,60	242			128,80	240
M25x1,5	1,50	140	18,0	14,5	23,5	28	4	208,50	250				
M22x1,5	1,50	125	18,0	14,5	20,5	25	4	102,20	222			113,50	220
M28x1,5	1,50	140	20,0	16,0	26,5	28	5					188,90	280
M27x2	2,00	140	20,0	16,0	25,0	28	4	177,90	274				
M27x1,5	1,50	140	20,0	16,0	25,5	28	5	188,90	272				
M30x2	2,00	150	22,0	18,0	28,0	28	4	218,40	302				
M32x2	2,00	150	22,0	18,0	30,0	28	5	303,40	322				
M32x1,5	1,50	150	22,0	18,0	30,5	28	6	218,40	320				
M30x1,5	1,50	150	22,0	18,0	28,5	28	5	182,30	300			205,30	300
M33x2	2,00	160	25,0	20,0	31,0	30	5	246,70	332				
M36x2	2,00	170	28,0	22,0	34,0	30	5	306,70	362				
M36x1,5	1,50	170	28,0	22,0	34,5	30	6	273,00	360				
M35x1,5	1,50	170	28,0	22,0	33,5	30	6	336,30	350				
M42x1,5	1,50	170	32,0	24,0	40,5	30	6	401,70	420				
M42x3	3,00	200	32,0	24,0	39,0	45	5	486,90	424				
M40x2	2,00	170	32,0	24,0	38,0	30	6	354,80	402				
M50x1,5	1,50	190	36,0	29,0	48,5	32	8	513,00	500				
M52x1,5	1,50	190	40,0	32,0	50,5	32	8	586,20	520				

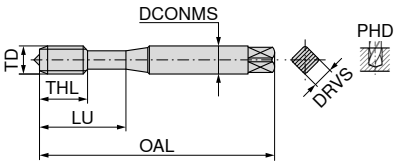
P	12	6	
M			
K	12	16	15
N	22	22	22
S			
H			
O			

Through Hole / Blind Hole – Machine taps

▲ ES = extra short

▲ LH = for left hand threads; ES = extra short

MF | TWIN

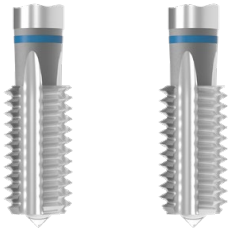


DIN 2181 with reinforced shank

ST ES | ST LH/ES

C 2–3

ISO 2X 6HX | ISO 2X 6HX



HSS-E | HSS-E

0° | 0°

≤ 750 N/mm² | ≤ 750 N/mm²

≤ 2xD | ≤ 2xD

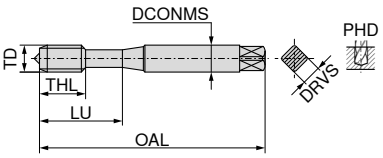
TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	22 179 ... EUR U0		22 200 ... EUR U0	
M2,5x0,35	0,35	40	2,8	2,1	2,15	9		3	62,98	025		
M3x0,35	0,35	40	3,5	2,7	2,65	8	18	3	40,93	030		
M4x0,35	0,35	45	4,5	3,4	3,65	9	22	3	58,62	040		
M4x0,5	0,50	45	4,5	3,4	3,50	9	22	3	40,93	042		
M4,5x0,5	0,50	50	6,0	4,9	4,00	10	24	3	68,11	045		
M5x0,5	0,50	50	6,0	4,9	4,50	11	25	3	40,93	050		
M6x0,5	0,50	56	6,0	4,9	5,50	12	27	3	43,01	060		
M6x0,75	0,75	56	6,0	4,9	5,20	12	27	3	40,93	062	56,98	062
M7x0,75	0,75	56	6,0	4,9	6,20	14		3	46,06	070		
M8x0,5	0,50	56	6,0	4,9	7,50	14		4	56,98	080		
M8x0,75	0,75	56	6,0	4,9	7,20	14		3	46,06	082		
M8x1	1,00	63	6,0	4,9	7,00	17		3	40,93	084	56,98	084
M9x1	1,00	63	7,0	5,5	8,00	17		4	56,98	090		
M10x0,75	0,75	63	7,0	5,5	9,20	18		4	60,26	100		
M10x1	1,00	63	7,0	5,5	9,00	18		4	43,01	102	58,62	102
M10x1,25	1,25	70	7,0	5,5	8,80	22		3	55,13	104		
M11x1	1,00	63	8,0	6,2	10,00	18		4	66,59	110		
M12x1	1,00	70	9,0	7,0	11,00	18		4	50,65	120	70,08	120
M12x1,25	1,25	70	9,0	7,0	10,80	20		4	56,98	122		
M12x1,5	1,50	70	9,0	7,0	10,50	20		4	49,34	124	68,11	124
M13x1	1,00	70	11,0	9,0	12,00	18		4	74,77	130		
M14x1	1,00	70	11,0	9,0	13,00	18		4	66,59	140		
M14x1,25	1,25	70	11,0	9,0	12,80	20		4	66,59	142		
M14x1,5	1,50	70	11,0	9,0	12,50	20		4	62,98	144	89,95	144
M15x1	1,00	70	12,0	9,0	14,00	18		5	80,66	150		
M16x1	1,00	70	12,0	9,0	15,00	18		5	76,08	160		
M16x1,5	1,50	70	12,0	9,0	14,50	20		4	70,08	162	98,79	162
M18x1	1,00	80	14,0	11,0	17,00	18		5	98,79	180		
M18x1,5	1,50	80	14,0	11,0	16,50	22		4	81,98	182	116,80	182
M18x2	2,00	80	14,0	11,0	16,00	22		4	98,79	184		
M20x1,5	1,50	80	16,0	12,0	18,50	22		4	96,16	202	133,20	202
M20x2	2,00	80	16,0	12,0	18,00	22		4	104,10	204		

P	12	12
M		
K	12	12
N	22	22
S		
H		
O		

Through hole / Blind hole – Machine thread formers, right hand

▲ SN = Thread formers with lubrication grooves

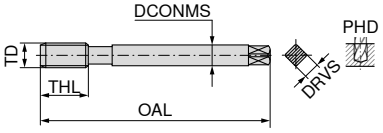
MF | Spanlos



DIN 2174 with reinforced shank

	EC	EC SN
	C 2–3	C 2–3
	ISO 2X 6HX	ISO 2X 6HX
	TiN	TiN
	HSS-E ≤ 1100 N/mm² ≤ 1,5xD	HSS-E ≤ 1100 N/mm² ≤ 3xD
	22 204 ...	22 205 ...

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	EUR U0		EUR U0	
M4x0,5	0,50	63	4,5	3,4	3,8	10	21		89,95	040		
M4x0,5	0,50	63	4,5	3,4	3,8	10	21	4			101,00	040
M5x0,5	0,50	70	6,0	4,9	4,8	11	25		76,75	050		
M5x0,5	0,50	70	6,0	4,9	4,8	11	25	4			89,95	050
M6x0,5	0,50	80	6,0	4,9	5,8	13	30		89,95	060		
M6x0,5	0,50	80	6,0	4,9	5,8	13	30	5			101,00	060
M6x0,75	0,75	80	6,0	4,9	5,7	13	30		71,28	062		
M6x0,75	0,75	80	6,0	4,9	5,7	13	30	4			80,34	062
M8x0,75	0,75	80	8,0	6,2	7,7	14	30		93,99	080		
M8x0,75	0,75	80	8,0	6,2	7,7	14	30	5			89,95	080
M8x1	1,00	90	8,0	6,2	7,6	17	35		87,11	082		
M8x1	1,00	90	8,0	6,2	7,6	17	35	5			95,40	082
M10x1	1,00	90	10,0	8,0	9,6	18	35		80,34	100		
M10x1	1,00	90	10,0	8,0	9,6	18	35	5			88,63	100



DIN 2174 with reduced shank

	22 196 ...	22 197 ...

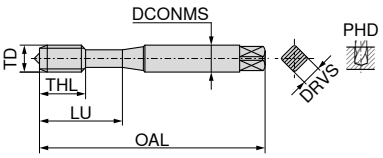
TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	EUR U0		EUR U0	
M12x1	1,0	100	9	7	11,60	18		92,67	120		
M12x1	1,0	100	9	7	11,60	18	6			102,90	120
M12x1,5	1,5	100	9	7	11,35	22		93,32	124		
M12x1,5	1,5	100	9	7	11,35	22	6			104,30	124
M14x1,5	1,5	100	11	9	13,35	22		127,70	140		
M14x1,5	1,5	100	11	9	13,35	22	6			133,20	140
M16x1,5	1,5	100	12	9	15,35	22		132,10	160		
M16x1,5	1,5	100	12	9	15,35	22	6			150,60	160
M20x1,5	1,5	125	16	12	19,35	25		191,00	200		
M20x1,5	1,5	125	16	12	19,35	25	6			210,70	200

P	18	18
M	10	10
K	10	10
N	22	22
S		
H		
O		

Through hole / Blind hole – Machine thread formers, right hand

▲ SN = Thread formers with lubrication grooves

MF



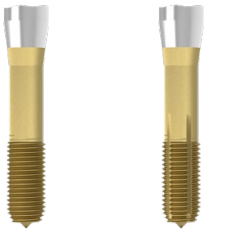
DIN 2174 with reinforced shank

UNI | UNI SN

C 2–3

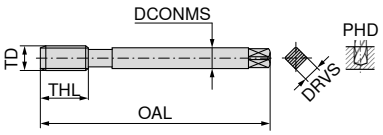
ISO 2X 6HX

TiN



HSS-E
≤ 850 N/mm²
≤ 3xD

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	23 840 ... EUR T9		23 842 ... EUR T9	
M4x0,5	0,50	63	4,5	3,4	3,80	10	21		39,72	**040**		
M4x0,5	0,50	63	4,5	3,4	3,80	10	21	4			44,58	**040**
M5x0,5	0,50	70	6,0	4,9	4,80	11	25		34,34	**050**		
M5x0,5	0,50	70	6,0	4,9	4,80	11	25	4			40,13	**050**
M6x0,5	0,50	80	6,0	4,9	5,80	13	30		39,72	**060**		
M6x0,5	0,50	80	6,0	4,9	5,80	13	30	5			44,78	**060**
M8x1	1,00	90	8,0	6,2	7,60	17	35		38,27	**084**		
M8x1	1,00	90	8,0	6,2	7,60	17	35	5			42,61	**084**
M10x1	1,00	90	10,0	8,0	9,60	18	35		43,54	**102**		
M10x1	1,00	90	10,0	8,0	9,60	18	35	5			47,17	**102**
M10x1,25	1,25	100	10,0	8,0	9,45	18	39		51,82	**104**		
M10x1,25	1,25	100	10,0	8,0	9,45	18	39	5			57,61	**104**



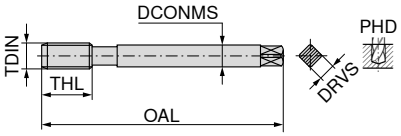
DIN 2174 with reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	23 841 ... EUR T9		23 843 ... EUR T9	
M12x1,25	1,25	100	9	7	11,45	22		55,64	**122**		
M12x1,25	1,25	100	9	7	11,45	22	6			62,89	**122**
M12x1,5	1,50	100	9	7	11,35	22		50,37	**124**		
M12x1,5	1,50	100	9	7	11,35	22	6			56,16	**124**
M14x1,5	1,50	100	11	9	13,35	22		62,47	**144**		
M14x1,5	1,50	100	11	9	13,35	22	6			69,71	**144**
M16x1,5	1,50	100	12	9	15,35	22		71,16	**162**		
M16x1,5	1,50	100	12	9	15,35	22	6			81,29	**162**
P									**18**		**18**
M									**10**		**10**
K									**10**		**10**
N									**22**		**22**
S											
H											
O											

6

Through hole – Machine taps, right hand

G | Stabil



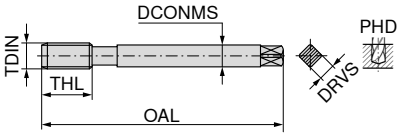
DIN 5156 with reduced shank

	UNI	UNI	ST	NW	VA
				NEW	
	B 4–5	B 4–5	B 4–5	B 4–5	B 4–5
	ISO 228	ISO 228	ISO 228	ISO 228	ISO 228
	nitr. + vap.	TiN		DLC	nitr.
					
	HSS-E	HSS-E	HSS-E	HSS-E	HSS-E
	◁ 0° ≤ 1100 N/mm² ≤ 4xD	◁ 0° ≤ 1100 N/mm² ≤ 4xD	◁ 0° ≤ 750 N/mm² ≤ 4xD	◁ 0° ≤ 880 N/mm² ≤ 4xD	◁ 0° ≤ 900 N/mm² ≤ 4xD
	22 632 ...	**22 630 ...**	**22 346 ...**	**22 467 ...**	**22 352 ...**

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	EUR U0		EUR U0		EUR U0		EUR U0		EUR U0	
1/8-28	0,907	90	7	5,5	8,80	18	3	60,80	**012**	81,98	**012**	46,06	**012**	60,62	**01200**	58,62	**012**
1/4-19	1,337	100	11	9,0	11,80	22	3	81,43	**025**	108,20	**025**	62,33	**025**	81,04	**02500**	76,75	**025**
3/8-19	1,337	100	12	9,0	15,25	22	3	101,50	**037**	126,60	**037**	74,77	**037**	104,00	**03700**	95,40	**037**
1/2-14	1,814	125	16	12,0	19,00	25	4	131,00	**050**	194,40	**050**	102,20	**050**	138,40	**05000**	126,60	**050**
3/4-14	1,814	140	20	16,0	24,50	28	4	208,50	**075**			163,80	**075**	219,30	**07500**	187,80	**075**
1-11	2,309	160	25	20,0	30,75	30	4	323,10	**100**			234,70	**100**	322,80	**10000**	287,10	**100**
P									**12**		**15**		**12**				**8**
M									**7**		**9**						**6**
K									**12**		**18**		**12**				
N											**12**		**22**		**15**		**22**
S																	
H																	
O																	

Through hole – Machine taps, right hand

G



DIN 5156 with reduced shank

UNI	UNI
B 4–5	B 4–5
ISO 228	ISO 228
nitr. + vap.	TiN

HSS-E
0°
≤ 1100 N/mm²
≤ 3xD

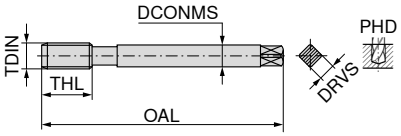
HSS-E
0°
≤ 1100 N/mm²
≤ 3xD

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	23 161 ... EUR T9		23 160 ... EUR T9	
1/8-28	0,907	90	7	5,5	8,80	18	3	16,03	**012**	29,58	**012**
1/4-19	1,337	100	11	9,0	11,80	22	3	21,62	**025**	39,10	**025**
3/8-19	1,337	100	12	9,0	15,25	22	3	26,48	**037**	46,03	**037**
1/2-14	1,814	125	16	12,0	19,00	25	4	36,61	**050**	70,64	**050**
3/4-14	1,814	140	20	16,0	24,50	28	4	71,68	**075**	92,47	**075**
1-11	2,309	160	25	20,0	30,75	30	4	79,12	**100**	170,60	**100**

P	**12**	**15**
M	**7**	**9**
K	**12**	**18**
N		**12**
S		
H		
O		

Blind hole – Machine taps, right hand

G | Salo-Rex



DIN 5156 with reduced shank

	UNI	UNI	UNI	UNI	UNI
	C 2–3	C 2–3	E 1,5–2	E 1,5–2	E 1,5–2
	ISO 228	ISO 228	ISO 228	ISO 228	ISO 228 +0,05
	vap.	TiN	vap.	TiN	vap.
					
	HSS-E ◁ 42° ≤ 1100 N/mm² ≤ 3xD	HSS-E ◁ 42° ≤ 1100 N/mm² ≤ 3xD	HSS-E ◁ 42° ≤ 1100 N/mm² ≤ 3xD	HSS-E ◁ 42° ≤ 1100 N/mm² ≤ 3xD	HSS-E ◁ 42° ≤ 1100 N/mm² ≤ 3xD
	22 633 ...	**22 634 ...**	**22 635 ...**	**22 636 ...**	**22 639 ...**

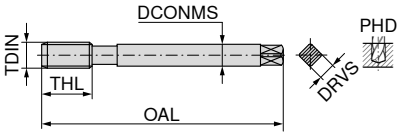
TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	EUR U0		EUR U0		EUR U0		EUR U0		EUR U0	
1/8-28	0,907	90	7	5,5	8,80	10	3	60,80	**012**	85,37	**012**						
1/8-28	0,907	90	7	5,5	8,80	10	4					62,33	**012**	85,37	**012**	81,98	**012**
1/4-19	1,337	100	11	9,0	11,80	15	4	85,37	**025**	106,90	**025**						
1/4-19	1,337	100	11	9,0	11,80	15	5					82,64	**025**	106,90	**025**	108,20	**025**
3/8-19	1,337	100	12	9,0	15,25	15	4	104,80	**037**	150,60	**037**						
3/8-19	1,337	100	12	9,0	15,25	15	5					102,20	**037**	150,60	**037**	134,20	**037**
1/2-14	1,814	125	16	12,0	19,00	17	4	138,60	**050**	216,20	**050**						
1/2-14	1,814	125	16	12,0	19,00	17	5					133,20	**050**	209,60	**050**	172,40	**050**
5/8-14	1,814	125	18	14,5	21,00	17	4	170,40	**062**								
3/4-14	1,814	140	20	16,0	24,50	20	4	213,90	**075**								
3/4-14	1,814	140	20	16,0	24,50	20	5									262,00	**075**
7/8-14	1,814	150	22	18,0	28,25	22	5	294,70	**087**								
1-11	2,309	160	25	20,0	30,75	24	5	325,40	**100**								
1-11	2,309	160	25	20,0	30,75	24	6									399,50	**100**
1 1/4-11	2,309	170	32	24,0	39,50	25	6	524,00	**125**								
1 1/2-11	2,309	190	36	29,0	45,25	27	6	747,70	**150**								

P	**12**	**15**	**12**	**15**	**12**
M	**7**	**9**	**7**	**9**	**7**
K	**12**	**18**	**12**	**18**	**12**
N		**12**		**12**	
S					
H					
O					

Blind hole – Machine taps, right hand

▲ CNC = for synchronised CNC machining with minimum length compensation chuck

G | Salo-Rex



DIN 5156 with reduced shank

	UNI CNC	ST	NW (NEW)	VA	VA
	E	C	C	E	E
	1,5–2	2–3	2–3	1,5–2	1,5–2
	ISO 228	ISO 228	ISO 228	ISO 228	ISO 228
	TiN GS		DLC	vap.	TiN GS
					
	HSS-E	HSS-E	HSS-E	HSS-E	HSS-E
	◁ 45°	◁ 42°	◁ 36°	◁ 42°	◁ 45°
	≤ 1100 N/mm²	≤ 750 N/mm²	≤ 880 N/mm²	≤ 900 N/mm²	≤ 900 N/mm²
	≤ 3xD	≤ 3xD	≤ 2,5xD	≤ 3xD	≤ 3xD
	22 624 ...	**22 354 ...**	**22 463 ...**	**22 355 ...**	**22 358 ...**

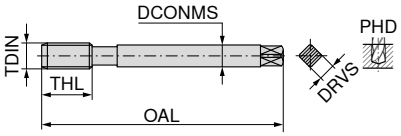
TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	EUR U0		EUR U0		EUR U0		EUR U0		EUR U0	
1/8-28	0,907	90	7	5,5	8,80	10	3			52,07	**012**	67,44	**01200**			99,33	**012**
1/8-28	0,907	90	7	5,5	8,80	10	4	97,58	**012**					62,33	**012**		
1/4-19	1,337	100	11	9,0	11,80	15	4			72,70	**025**	97,39	**02500**				
1/4-19	1,337	100	11	9,0	11,80	15	5	127,70	**025**					82,64	**025**	128,80	**025**
3/8-19	1,337	100	12	9,0	15,25	15	4			88,86	**037**	116,10	**03700**				
3/8-19	1,337	100	12	9,0	15,25	15	5	151,70	**037**					102,20	**037**	154,00	**037**
1/2-14	1,814	125	16	12,0	19,00	17	4			114,60	**050**	148,30	**05000**				
1/2-14	1,814	125	16	12,0	19,00	17	5	229,30	**050**					130,00	**050**	232,60	**050**
5/8-14	1,814	125	18	14,5	21,00	17	5							170,40	**062**		
3/4-14	1,814	140	20	16,0	24,50	20	4			182,30	**075**	236,40	**07500**				
3/4-14	1,814	140	20	16,0	24,50	20	5							218,40	**075**		
1-11	2,309	160	25	20,0	30,75	24	5			277,30	**100**	378,70	**10000**				
1-11	2,309	160	25	20,0	30,75	24	6							321,00	**100**		

P	**15**	**12**		**8**	**10**
M	**9**			**6**	**8**
K	**18**	**12**			
N	**12**	**22**	**15**	**22**	**22**
S					
H					
O					

6

Blind hole – Machine taps, right hand

G



DIN 5156 with reduced shank

UNI
C
2–3
ISO 228
vap.

HSS-E
◁ 35°
≤ 1100 N/mm²
≤ 2,5xD

23 163 ...

UNI
C
2–3
ISO 228
TiN

HSS-E
◁ 35°
≤ 1100 N/mm²
≤ 2,5xD

23 162 ...

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	EUR T9		EUR T9	
1/8-28	0,907	90	7	5,5	8,80	10	3	16,76	**012**	30,83	**012**
1/4-19	1,337	100	11	9,0	11,80	15	4	23,89	**025**	42,41	**025**
3/8-19	1,337	100	12	9,0	15,25	15	4	34,75	**037**	50,06	**037**
1/2-14	1,814	125	16	12,0	19,00	17	4	44,78	**050**	75,40	**050**
3/4-14	1,814	140	20	16,0	24,50	20	4	68,67	**075**	96,81	**075**
1-11	2,309	160	25	20,0	30,75	24	5	95,57	**100**	184,10	**100**

P	**12**	**15**
M	**7**	**9**
K	**12**	**18**
N		**12**
S		
H		
O		

Through hole / Blind hole – Machine taps, right hand

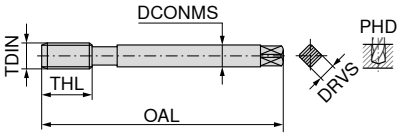
G | TWIN

ST | HR

C 2–3 | C 2–3

ISO 228 X | ISO 228 X

nitr.



DIN 5156 with reduced shank

HSS-E
0°
≤ 750 N/mm²
≤ 2xD

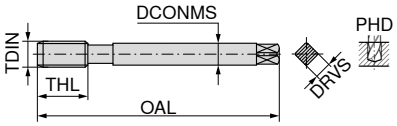
HSS-E
0°
≤ 1400 N/mm²
≤ 2xD

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	22 347 ... EUR U0		22 339 ... EUR U0	
1/16-28	0,907	90	6	4,9	6,80	17	3	53,92	**006**		
1/8-28	0,907	90	7	5,5	8,80	18	4	50,00	**012**	50,65	**012**
1/4-19	1,337	100	11	9,0	11,80	22	4	60,26	**025**	68,11	**025**
3/8-19	1,337	100	12	9,0	15,25	22	4	73,36	**037**	85,37	**037**
1/2-14	1,814	125	16	12,0	19,00	25	4	100,90	**050**	117,90	**050**
3/4-14	1,814	140	20	16,0	24,50	28	4	154,00	**075**	185,50	**075**
1-11	2,309	160	25	20,0	30,75	30	5	235,80	**100**	253,30	**100**
1 1/8-11	2,309	170	28	22,0	35,50	30	5	330,80	**112**	358,00	**112**
1 1/4-11	2,309	170	32	24,0	39,50	30	6	390,80	**125**	421,30	**125**
1 3/8-11	2,309	180	36	29,0	41,75	32	6	477,00	**137**	524,00	**137**
1 1/2-11	2,309	190	36	29,0	45,25	32	6	520,70	**150**	584,00	**150**
1 3/4-11	2,309	190	40	32,0	51,00	32	6			788,10	**175**
P									**12**		**6**
M											
K									**12**		**16**
N									**22**		**22**
S											
H											
O											

Through hole / Blind hole – Machine thread formers, right hand

▲ SN = Thread formers with lubrication grooves

G | Spanlos



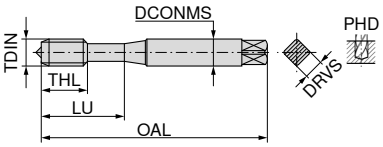
DIN 2189 with reduced shank

	EC	EC SN
	C 2–3	C 2–3
	ISO 228	ISO 228
	TiN	TiN
		
	HSS-E ≤ 1100 N/mm² ≤ 1,5xD	HSS-E ≤ 1100 N/mm² ≤ 3xD
	22 360 ...	**22 359 ...**

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	EUR U0		EUR U0	
1/8-28	0,907	90	7	5,5	9,25	18		97,70	**012**		
1/8-28	0,907	90	7	5,5	9,25	18	5			110,20	**012**
1/4-19	1,337	100	11	9,0	12,55	22		125,60	**025**		
1/4-19	1,337	100	11	9,0	12,55	22	6			138,60	**025**
3/8-19	1,337	100	12	9,0	16,05	22		169,20	**037**		
3/8-19	1,337	100	12	9,0	16,05	22	6			189,90	**037**
1/2-14	1,814	125	16	12,0	20,10	25		225,90	**050**		
1/2-14	1,814	125	16	12,0	20,10	25	6			254,30	**050**
P									**18**		**18**
M									**10**		**10**
K									**10**		**10**
N									**22**		**22**
S											
H											
O											

Through hole – Machine taps, right hand

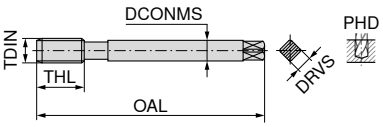
UNC | Stabil



DIN 371 with reinforced shank

	VA	Ti	UNI
	B 4–5	B 4–5	B 4–5
	2B	2BX	2B
	nitr.	TiN	nitr. + vap.
			
	HSS-E	HSS-PM	HSS-E
	0° ≤ 900 N/mm² ≤ 4xD	0° ≤ 44 HRC ≤ 4xD	0° ≤ 1100 N/mm² ≤ 4xD
	22 250 ...	**22 269 ...**	**22 572 ...**

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	EUR U0		EUR U0		EUR U0	
Nr. 2-56	0,454	45	2,8	2,1	1,85	7	12	2					79,58	**002**
Nr. 4-40	0,635	56	3,5	2,7	2,35	11	18	2					43,76	**004**
Nr. 4-40	0,635	56	3,5	2,7	2,35	11	18	3			70,08	**004**		
Nr. 6-32	0,794	56	4,0	3,0	2,85	12	20	3	37,33	**006**	61,67	**006**	39,08	**006**
Nr. 8-32	0,794	63	4,5	3,4	3,50	13	21	3	36,68	**008**	62,98	**008**	37,00	**008**
Nr. 10-24	1,058	70	6,0	4,9	3,90	15	25	3	36,68	**010**	63,64	**010**	41,70	**010**
Nr. 12-24	1,058	80	6,0	4,9	4,50	16	30	3					50,00	**012**
1/4-20	1,270	80	7,0	5,5	5,10	17	30	3	46,61	**025**	67,34	**025**	45,07	**025**
5/16-18	1,411	90	8,0	6,2	6,60	20	35	3	47,05	**031**	74,77	**031**	51,85	**031**
3/8-16	1,588	100	10,0	8,0	8,00	22	39	3	47,70	**037**	87,32	**037**	57,63	**037**



DIN 376 with reduced shank

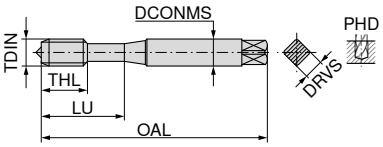
								22 573 ...	
TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	EUR U0	
1/2-13	1,954	110	9	7,0	10,80	25	3	68,77	**050**
5/8-11	2,309	110	12	9,0	13,50	27	3	96,16	**062**
3/4-10	2,540	125	14	11,0	16,50	30	3	119,00	**075**
7/8-9	2,822	140	18	14,5	19,50	32	3	151,70	**087**
1-8	3,175	160	18	14,5	22,25	36	3	193,20	**100**

P	**8**	**7**	**12**
M	**6**	**7**	**7**
K			**12**
N	**22**		
S		**5**	
H			
O			

Through hole – Machine taps, right hand

UNC

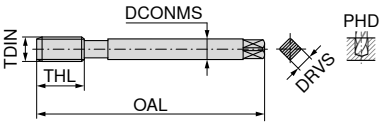
UNI	FE-HF	VA
B	B	B
4–5	4–5	4–5
2B	2B	2B
TiN	TiCN	nitr.



DIN 371 with reinforced shank

HSS-E
0°
≤ 1000 N/mm²
≤ 3xD

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	23 170 ... EUR T9		23 370 ... EUR T9		23 470 ... EUR T9	
Nr. 4-40	0,635	56	3,5	2,7	2,30	11	18	2	19,35	**004**	27,41	**004**	16,03	**004**
Nr. 6-32	0,794	56	4,0	3,0	2,85	12	20	3	18,62	**006**	26,58	**006**	14,89	**006**
Nr. 8-32	0,794	63	4,5	3,4	3,50	13	21	3	18,62	**008**	26,58	**008**	14,48	**008**
Nr. 10-24	1,058	70	6,0	4,9	3,90	15	25	3	19,35	**010**	27,62	**010**	16,03	**010**
1/4-20	1,270	80	7,0	5,5	5,20	17	30	3	25,45	**025**	38,37	**025**	17,17	**025**
5/16-18	1,411	90	8,0	6,2	6,60	20	35	3	27,82	**031**	41,79	**031**	19,55	**031**
3/8-16	1,588	100	10,0	8,0	8,00	22	39	3	33,10	**037**	49,34	**037**	22,14	**037**



DIN 376 with reduced shank

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	23 171 ... EUR T9		23 371 ... EUR T9		23 471 ... EUR T9	
7/16-14	1,814	100	8	6,2	9,40	22	3	38,48	**043**	57,09	**043**	27,72	**043**
1/2-13	1,954	110	9	7,0	10,75	25	3	43,03	**050**	64,85	**050**	30,31	**050**
5/8-11	2,309	110	12	9,0	13,50	27	3	53,68	**062**	78,30	**062**	39,10	**062**
3/4-10	2,540	125	14	11,0	16,50	30	3	81,29	**075**	123,10	**075**	50,26	**075**

P	**15**	**15**	**8**
M	**9**		**6**
K	**18**	**15**	
N	**12**	**15**	**22**
S			
H			
O			

Blind hole – Machine taps, right hand

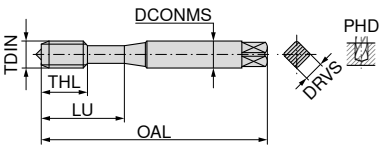
UNC | Salo-Rex

UNI | VA

C 2–3 | C 2–3

2B | 2B

vap. | vap.

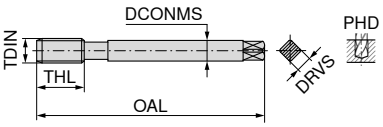


DIN 371 with reinforced shank

HSS-E
◁ 42°
≤ 1100 N/mm²
≤ 3xD

HSS-E
◁ 42°
≤ 900 N/mm²
≤ 3xD

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	22 582 ... EUR U0		22 266 ... EUR U0	
Nr. 2-56	0,454	45	2,8	2,1	1,85	4,5	12	2	63,64	**002**		
Nr. 4-40	0,635	56	3,5	2,7	2,35	6,0	18	2	39,73	**004**		
Nr. 6-32	0,794	56	4,0	3,0	2,85	7,0	20	3	34,82	**006**	38,09	**006**
Nr. 8-32	0,794	63	4,5	3,4	3,50	8,0	21	3	37,33	**008**	40,72	**008**
Nr. 10-24	1,058	70	6,0	4,9	3,90	10,0	25	3	39,08	**010**	43,33	**010**
1/4-20	1,270	80	7,0	5,5	5,10	13,0	30	3	42,02	**025**	44,31	**025**
5/16-18	1,411	90	8,0	6,2	6,60	14,0	35	3	44,75	**031**	50,20	**031**
3/8-16	1,588	100	10,0	8,0	8,00	16,0	39	3	50,20	**037**	52,07	**037**



DIN 376 with reduced shank

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	22 583 ... EUR U0		22 267 ... EUR U0	
7/16-14	1,814	100	8	6,2	9,40	18	3	68,77	**043**		
7/16-14	1,814	100	8	6,2	9,40	18	4			87,32	**043**
1/2-13	1,954	110	9	7,0	10,80	20	3	68,77	**050**		
1/2-13	1,954	110	9	7,0	10,80	20	4			76,75	**050**
9/16-12	2,117	110	11	9,0	12,25	20	3	97,58	**056**		
5/8-11	2,309	110	12	9,0	13,50	22	3	90,60	**062**		
5/8-11	2,309	110	12	9,0	13,50	22	4			98,79	**062**
3/4-10	2,540	125	14	11,0	16,50	25	3	116,80	**075**		
3/4-10	2,540	125	14	11,0	16,50	25	4			121,10	**075**
7/8-9	2,822	140	18	14,5	19,50	27	4	139,70	**087**		
1-8	3,175	160	18	14,5	22,25	30	4	189,90	**100**		
1-8	3,175	160	18	14,5	22,25	30	5			203,00	**100**

P	**12**	**8**
M	**7**	**6**
K	**12**	
N		**22**
S		
H		
O		

Blind hole – Machine taps, right hand

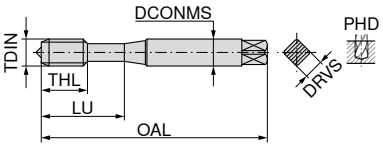
UNC

UNI | FE-HF | VA

C 2–3

2B

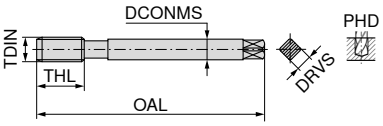
TiN | TiCN



DIN 371 with reinforced shank

HSS-E
35°
≤ 1000 N/mm²
≤ 2,5xD

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	23 172 ... EUR T9		23 372 ... EUR T9		23 472 ... EUR T9	
Nr. 4-40	0,635	56	3,5	2,7	2,30	11	18	2			21,92	004		
Nr. 4-40	0,635	56	3,5	2,7	2,30	6	18	2	20,89	004			26,48	004
Nr. 6-32	0,794	56	4,0	3,0	2,85	7	20	3	19,23	006			24,83	006
Nr. 6-32	0,794	56	4,0	3,0	2,85	12	20	3			20,79	006		
Nr. 8-32	0,794	63	4,5	3,4	3,50	8	21	3	20,69	008			25,75	008
Nr. 8-32	0,794	63	4,5	3,4	3,50	13	21	3			22,03	008		
Nr. 10-24	1,058	70	6,0	4,9	3,90	10	25	3	21,41	010			26,79	010
Nr. 10-24	1,058	70	6,0	4,9	3,90	15	25	3			22,76	010		
1/4-20	1,270	80	7,0	5,5	5,20	13	30	3	27,62	025			30,09	025
1/4-20	1,270	80	7,0	5,5	5,20	17	30	3			30,71	025		
5/16-18	1,411	90	8,0	6,2	6,60	14	35	3	27,62	031			31,75	031
5/16-18	1,411	90	8,0	6,2	6,60	20	35	3			31,96	031		
3/8-16	1,588	100	10,0	8,0	8,00	16	39	3	33,82	037			35,47	037
3/8-16	1,588	100	10,0	8,0	8,00	22	39	3			38,06	037		



DIN 376 with reduced shank

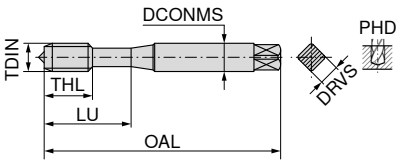
TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	23 173 ... EUR T9		23 373 ... EUR T9		23 473 ... EUR T9	
7/16-14	1,814	100	8	6,2	9,40	22	3			47,47	043		
7/16-14	1,814	100	8	6,2	9,40	18	3	42,82	043			49,13	043
1/2-13	1,954	110	9	7,0	10,75	20	3	45,20	050			48,41	050
1/2-13	1,954	110	9	7,0	10,75	25	3			51,30	050		
5/8-11	2,309	110	12	9,0	13,50	22	3	55,64	062			67,95	062
5/8-11	2,309	110	12	9,0	13,50	27	3			61,44	062		
3/4-10	2,540	125	14	11,0	16,50	25	3	84,19	075			83,36	075
3/4-10	2,540	125	14	11,0	16,50	30	3			96,29	075		

P	15	15	8
M	9		6
K	18	15	
N	12	24	22
S			
H			
O			

Through hole / Blind hole – Machine thread formers, right hand

▲ SN = Thread formers with lubrication grooves

UNC | Spanlos



DIN 2174 with reduced shank

	EC	EC SN
	C 2–3	C 2–3
	2BX	2BX
	TiN	TiN

	HSS-E ≤ 1100 N/mm² ≤ 1,5xD	HSS-E ≤ 1100 N/mm² ≤ 3xD
	22 270 ...	**22 271 ...**

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	EUR U0		EUR U0	
Nr. 4-40	0,635	56	3,5	2,7	2,55	11	18		56,11	**004**		
Nr. 4-40	0,635	56	3,5	2,7	2,55	11	18	3			64,84	**004**
Nr. 6-32	0,794	56	4,0	3,0	3,15	12	20		52,28	**006**		
Nr. 6-32	0,794	56	4,0	3,0	3,15	12	20	3			60,26	**006**
Nr. 8-32	0,794	63	4,5	3,4	3,80	13	21		52,50	**008**		
Nr. 8-32	0,794	63	4,5	3,4	3,80	13	21	4			60,26	**008**
Nr. 10-24	1,058	70	6,0	4,9	4,35	15	25		58,50	**010**		
Nr. 10-24	1,058	70	6,0	4,9	4,35	15	25	4			66,25	**010**
1/4-20	1,270	80	7,0	5,5	5,75	17	30		68,00	**025**		
1/4-20	1,270	80	7,0	5,5	5,75	17	30	4			76,75	**025**
5/16-18	1,411	90	8,0	6,2	7,30	20	35		73,36	**031**		
5/16-18	1,411	90	8,0	6,2	7,30	20	35	5			83,07	**031**
3/8-16	1,588	100	10,0	8,0	8,80	22	39		87,98	**037**		
3/8-16	1,588	100	10,0	8,0	8,80	22	39	5			96,71	**037**
P										**18**		**18**
M										**10**		**10**
K										**10**		**10**
N										**22**		**22**
S												
H												
O												

6

Through hole – machine taps for wire thread inserts, right hand

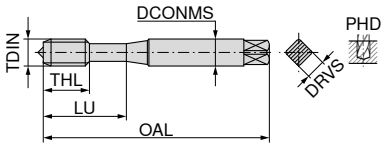
EG UNC | Stabil

UNI

B
4–5

2B

nitr. + vap.



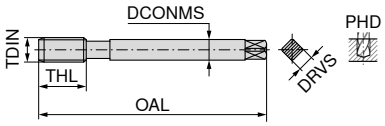
DIN 371 with reinforced shank

HSS-E

0°
≤ 1100 N/mm²
≤ 4xD

22 668 ...

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	EUR U0	
EG Nr. 4-40	0,635	63	4,5	3,4	3,1	13	21	3	57,63	**004**
EG Nr. 6-32	0,794	70	6,0	4,9	3,8	14	25	3	59,71	**006**
EG Nr. 8-32	0,794	80	6,0	4,9	4,4	16	30	3	57,31	**008**
EG Nr. 10-24	1,058	80	7,0	5,5	5,2	17	30	3	62,33	**010**
EG 1/4-20	1,270	90	8,0	6,2	6,7	20	35	3	64,40	**025**
EG 5/16-18	1,411	100	10,0	8,0	8,4	22	39	3	74,12	**031**



DIN 376 with reduced shank

22 670 ...

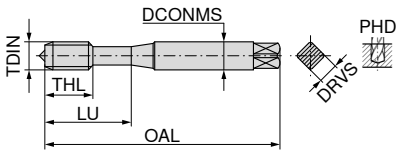
TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	EUR U0	
EG 3/8-16	1,588	100	9	7,0	10,00	22	3	85,37	**037**
EG 7/16-14	1,814	110	11	9,0	11,60	26	3	103,40	**043**
EG 1/2-13	1,954	110	12	9,0	13,30	27	3	110,20	**050**
EG 5/8-11	2,309	125	14	11,0	16,50	30	3	137,50	**062**
EG 3/4-10	2,540	140	18	14,5	19,75	32	3	179,00	**075**

P	**12**
M	**7**
K	**12**
N	
S	
H	
O	

Blind hole – machine taps for wire thread inserts, right hand

EG UNC | Salo-Rex

UNI | E 1,5–2 | 2B | vap.



DIN 371 with reinforced shank

HSS-E
42°
≤ 1100 N/mm²
≤ 3xD

22 672 ...

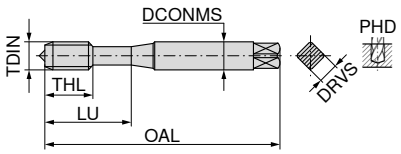
TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	EUR U0	
EG Nr. 4-40	0,635	63	4,5	3,4	3,1	7	21	3	58,40	**004**
EG Nr. 6-32	0,794	70	6,0	4,9	3,8	8	25	3	54,68	**006**
EG Nr. 8-32	0,794	80	6,0	4,9	4,4	8	30	3	58,07	**008**
EG Nr. 10-24	1,058	80	7,0	5,5	5,2	10	30	3	61,02	**010**
EG 1/4-20	1,270	90	8,0	6,2	6,7	14	35	3	67,34	**025**
EG 5/16-18	1,411	100	10,0	8,0	8,4	16	39	3	72,70	**031**

P	**12**
M	**7**
K	**12**
N	
S	
H	
O	

Blind hole – Machine taps, right hand

UNJC | SL

Ti | C 2–3 | 3BX | TiCN



DIN 371 with reinforced shank

HSS-E
15°
≤ 1200 N/mm²
≤ 2xD

22 166 ...

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	EUR U0	
Nr. 4-40	0,635	56	3,5	2,7	2,30	11	18	2	76,75	**004**
Nr. 6-32	0,794	56	4,0	3,0	2,85	12	20	3	78,37	**006**
Nr. 8-32	0,794	63	4,5	3,4	3,50	13	21	3	77,29	**008**
Nr. 10-24	1,058	70	6,0	4,9	3,90	15	25	3	81,33	**010**
1/4-20	1,270	80	7,0	5,5	5,25	17	30	3	104,30	**025**
3/8-16	1,588	100	10,0	8,0	8,10	22	39	3	126,60	**037**

P	**7**
M	**7**
K	
N	**22**
S	**5**
H	
O	

Through hole – Machine taps, right hand

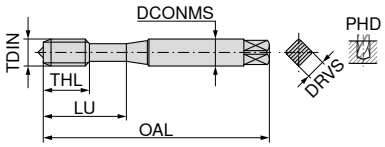
UNF | Stabil

UNI | Ti

B 4–5 | B 4–5

2B | 2BX

nitr. + vap. | TiN

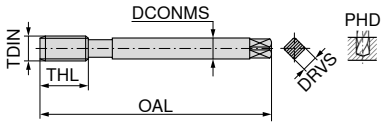


DIN 371 with reinforced shank

HSS-E
0°
≤ 1100 N/mm²
≤ 4xD

HSS-PM
0°
≤ 44 HRC
≤ 4xD

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	22 602 ... EUR U0		22 317 ... EUR U0	
Nr. 4-48	0,529	56	3,5	2,7	2,40	11	18	2	53,37	004		
Nr. 4-48	0,529	56	3,5	2,7	2,40	11	18	3			75,31	004
Nr. 5-44	0,577	56	3,5	2,7	2,70	11	18	3			82,64	005
Nr. 6-40	0,635	56	4,0	3,0	2,95	12	20	3	47,37	006	65,70	006
Nr. 8-36	0,706	63	4,5	3,4	3,50	13	21	3	47,37	008	75,86	008
Nr. 10-32	0,794	70	6,0	4,9	4,10	15	25	3	48,79	010	68,77	010
1/4-28	0,907	80	7,0	5,5	5,50	17	30	3	53,59	025	77,29	025
5/16-24	1,058	90	8,0	6,2	6,90	17	35	3	60,47	031	88,31	031
3/8-24	1,058	90	10,0	8,0	8,50	18	35	3			93,44	037



DIN 374 with reduced shank

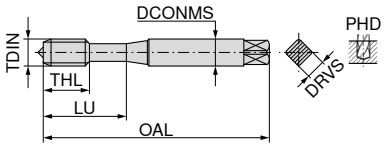
TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	22 603 ... EUR U0		22 421 ... EUR U0	
7/16-20	1,270	100	8	6,2	9,90	22	3	72,15	043		
1/2-20	1,270	100	9	7,0	11,50	22	3	68,77	050	113,50	050
9/16-18	1,411	100	11	9,0	12,90	22	3	106,00	056		
5/8-18	1,411	100	12	9,0	14,50	22	3	96,71	062		
3/4-16	1,588	110	14	11,0	17,50	25	4	122,30	075		
7/8-14	1,814	125	18	14,5	20,50	25	4	159,40	087		
1-12	2,117	140	18	14,5	23,25	28	4	206,30	100		
1 1/8-12	2,117	150	22	18,0	26,50	28	4	542,50	112		
1 1/4-12	2,117	150	22	18,0	29,75	28	4	594,90	125		
1 3/8-12	2,117	170	28	22,0	33,00	30	5	626,60	137		

P	12	7
M	7	7
K	12	
N		22
S		5
H		
O		

Through hole – Machine taps, right hand

UNF

UNI	FE	VA
B 4–5	B 4–5	B 4–5
2B	2B	2B
TiN		nitr.



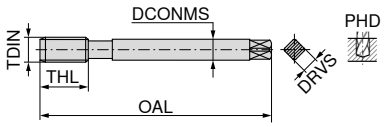
DIN 371 with reinforced shank

HSS-E
0°
≤ 1100 N/mm²
≤ 3xD

HSS-E
0°
≤ 850 N/mm²
≤ 3xD

HSS-E
0°
≤ 1100 N/mm²
≤ 3xD

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	23 180 ... EUR T9		23 280 ... EUR T9		23 480 ... EUR T9	
Nr. 10-32	0,794	70	6	4,9	4,1	15	25	3	22,34	**010**	27,10	**010**	18,41	**010**
1/4-28	0,907	80	7	5,5	5,5	17	30	3	28,54	**025**	29,17	**025**	20,79	**025**
5/16-24	1,058	90	8	6,2	6,9	17	35	3	31,75	**031**	32,27	**031**	22,96	**031**
3/8-24	1,058	90	10	8,0	8,5	18	35	4	34,65	**037**	33,62	**037**	23,99	**037**



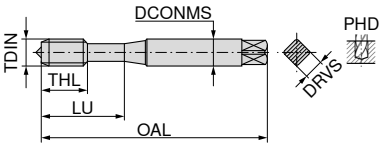
DIN 374 with reduced shank

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	23 181 ... EUR T9		23 281 ... EUR T9		23 481 ... EUR T9	
7/16-20	1,270	100	8	6,2	9,9	22	3	41,69	**043**	43,23	**043**	30,71	**043**
1/2-20	1,270	100	9	7,0	11,5	22	3	43,03	**050**	43,23	**050**	30,71	**050**
9/16-18	1,411	100	11	9,0	12,9	22	3	58,55	**056**	53,68	**056**	38,06	**056**
5/8-18	1,411	100	12	9,0	14,5	22	3	54,20	**062**	48,41	**062**	34,44	**062**
3/4-16	1,588	110	14	11,0	17,5	25	4	82,23	**075**	63,09	**075**	44,88	**075**

P	**15**	**12**	**8**
M	**9**		**6**
K	**18**	**12**	
N	**12**	**22**	**22**
S			
H			
O			

Blind hole – Machine taps, right hand

UNF | Salo-Rex



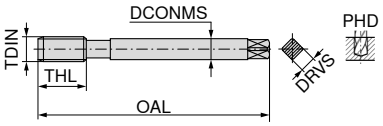
DIN 371 with reinforced shank

HSS-E
∢ 42°
≤ 900 N/mm²
≤ 3xD

HSS-E
∢ 42°
≤ 1100 N/mm²
≤ 3xD

HSS-E
∢ 42°
≤ 1100 N/mm²
≤ 3xD

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	22 308 ... EUR U0		22 606 ... EUR U0		22 307 ... EUR U0	
Nr. 2-64	0,397	45	2,8	2,1	1,85	4,5	12	2	65,50	002				
Nr. 4-48	0,529	56	3,5	2,7	2,40	6,0	18	2	49,34	004	47,37	004		
Nr. 6-40	0,635	56	4,0	3,0	2,95	7,0	20	3	47,37	006	42,02	006		
Nr. 6-40	0,635	56	4,0	3,0	3,00	7,0	20	3					66,25	006
Nr. 8-36	0,706	63	4,5	3,4	3,50	8,0	21	3	47,37	008	42,02	008		
Nr. 10-32	0,794	70	6,0	4,9	4,10	10,0	25	3	50,65	010	44,31	010		
Nr. 10-32	0,794	70	6,0	4,9	4,15	10,0	25	3					70,08	010
1/4-28	0,907	80	7,0	5,5	5,50	10,0	30	3	52,07	025	48,46	025		
1/4-28	0,907	80	7,0	5,5	5,55	10,0	30	3					73,36	025
5/16-24	1,058	90	8,0	6,2	6,90	10,0	35	3	58,07	031	54,68	031		
5/16-24	1,058	90	8,0	6,2	6,95	10,0	35	3					83,50	031
3/8-24	1,058	90	10,0	8,0	8,50	10,0	35	3	60,80	037				
3/8-24	1,058	90	10,0	8,0	8,55	10,0	35	3					83,50	037



DIN 374 with reduced shank

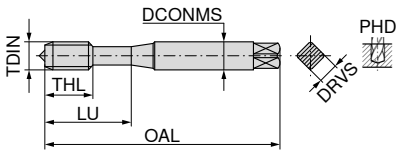
TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	22 607 ... EUR U0		22 409 ... EUR U0	
7/16-20	1,270	100	8	6,2	9,90	13	3	68,77	043		
7/16-20	1,270	100	8	6,2	9,95	13	4			105,50	043
1/2-20	1,270	100	9	7,0	11,50	13	4	68,77	050		
1/2-20	1,270	100	9	7,0	11,55	13	5			101,50	050
9/16-18	1,411	100	11	9,0	12,90	15	4	103,40	056		
9/16-18	1,411	100	11	9,0	12,95	15	5			144,10	056
5/8-18	1,411	100	12	9,0	14,50	15	4	90,60	062		
5/8-18	1,411	100	12	9,0	14,55	15	5			131,00	062
3/4-16	1,588	110	14	11,0	17,50	17	4	124,50	075		
3/4-16	1,588	110	14	11,0	17,55	17	5			176,90	075
7/8-14	1,814	125	18	14,5	20,50	17	4	150,60	087		
1-12	2,117	140	18	14,5	23,25	20	4	213,90	100		
1-12	2,117	140	18	14,5	23,30	20	5			277,30	100
1 1/8-12	2,117	150	22	18,0	26,50	22	4	291,50	112		
1 1/4-12	2,117	150	22	18,0	29,75	22	5	332,90	125		
1 3/8-12	2,117	170	28	22,0	33,00	24	5	405,00	137		

P	8	12	12
M	6	7	7
K		12	12
N	22		22
S			
H			
O			

6

Blind hole – Machine taps, right hand

UNF | SL



DIN 371 with reinforced shank

Ti | C 2–3 | 2BX | vap.

HSS-PM
◁ 30°
≤ 1400 N/mm²
≤ 1,5xD

22 302 ...

Ti | C 2–3 | 3BX | vap.

HSS-PM
◁ 30°
≤ 1400 N/mm²
≤ 1,5xD

22 303 ...

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	EUR U0		EUR U0	
Nr. 10-32	0,794	70	6	4,9	4,1	10	25	3	92,12	**010**	92,12	**010**
1/4-28	0,907	80	7	5,5	5,5	10	30	3	100,10	**025**	100,10	**025**
5/16-24	1,058	90	8	6,2	6,9	10	35	3	119,00	**031**	108,20	**031**
3/8-24	1,058	90	10	8,0	8,5	10	35	3	117,90	**037**	117,90	**037**

P	**5**	**5**
M	**5**	**5**
K		
N	**22**	**22**
S	**3**	**3**
H		
O		

Blind hole – Machine taps, right hand

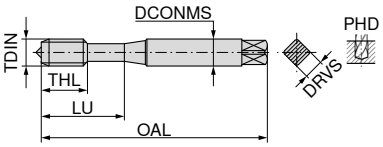
UNF

UNI | VA

C 2–3

2B | 2B

TiN

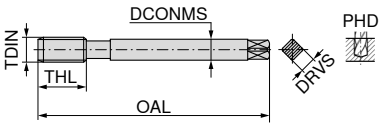


DIN 371 with reinforced shank

HSS-E
◁ 35°
≤ 1100 N/mm²
≤ 2,5xD

HSS-E
◁ 35°
≤ 1100 N/mm²
≤ 2,5xD

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	23 182 ... EUR T9		23 482 ... EUR T9	
Nr. 10-32	0,794	70	6	4,9	4,1	10	25	3	23,58	**010**	31,44	**010**
1/4-28	0,907	80	7	5,5	5,5	10	30	3	30,20	**025**	34,34	**025**
5/16-24	1,058	90	8	6,2	6,9	10	35	3	31,96	**031**	36,41	**031**
3/8-24	1,058	90	10	8,0	8,5	10	35	3	35,58	**037**	39,51	**037**



DIN 374 with reduced shank

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	23 183 ... EUR T9		23 483 ... EUR T9	
7/16-20	1,270	100	8	6,2	9,9	13	3	42,82	**043**	49,13	**043**
1/2-20	1,270	100	9	7,0	11,5	13	4	45,20	**050**	49,54	**050**
9/16-18	1,411	100	11	9,0	12,9	15	4	61,02	**056**	69,51	**056**
5/8-18	1,411	100	12	9,0	14,5	15	4	55,23	**062**	61,02	**062**
3/4-16	1,588	110	14	11,0	17,5	17	4	87,60	**075**	82,54	**075**

P	**15**	**8**
M	**9**	**6**
K	**18**	
N	**12**	**22**
S		
H		
O		

6

Through hole / Blind hole – Machine thread formers, right hand

▲ SN = Thread formers with lubrication grooves

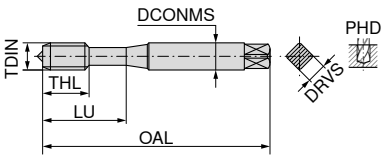
UNF | Spanlos

EC
SN

C
2–3

2BX

TiN

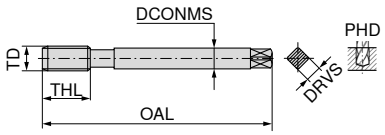


DIN 2174 with reduced shank

HSS-E
≤ 1100 N/mm²
≤ 3xD

22 312 ...

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	EUR U0	
Nr. 4-48	0,529	56	3,5	2,7	2,62	11	18	3	72,04	**004**
Nr. 6-40	0,635	56	4,0	3,0	3,22	12	20	3	66,91	**006**
Nr. 8-36	0,706	63	4,5	3,4	3,85	13	21	4	68,66	**008**
Nr. 10-32	0,794	70	6,0	4,9	4,45	15	25	4	74,22	**010**
1/4-28	0,907	80	7,0	5,5	5,95	17	30	4	87,11	**025**



DIN 2174 with reduced shank

22 313 ...

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	EUR U0	
7/16-20	1,27	100	8	6,2	10,55	22	6	130,00	**043**
1/2-20	1,27	100	9	7,0	12,15	22	6	133,20	**050**

P	**18**
M	**10**
K	**10**
N	**22**
S	
H	
O	

Through hole – machine taps for wire thread inserts, right hand

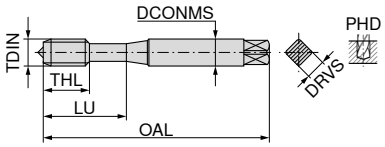
EG UNF | Stabil

UNI

B
4–5

2B

nitr. + vap.

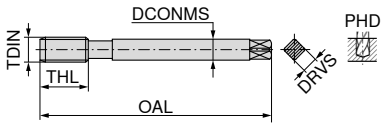


DIN 371 with reinforced shank

HSS-E
0°
≤ 1100 N/mm²
≤ 4xD

22 676 ...

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	EUR U0	
EG Nr. 4-48	0,529	56	4	3,0	3,0	9	20	3	74,77	**004**
EG Nr. 6-40	0,635	70	6	4,9	3,7	11	25	3	72,15	**006**
EG Nr. 8-36	0,706	80	6	4,9	4,4	13	30	3	72,15	**008**
EG Nr. 10-32	0,794	80	6	4,9	5,1	13	30	3	76,75	**010**
EG 1/4-28	0,907	90	8	6,2	6,6	17	35	3	81,98	**025**



DIN 374 with reduced shank

22 677 ...

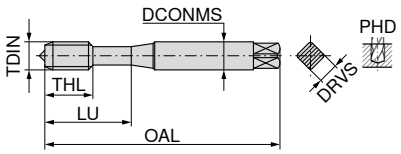
TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	EUR U0	
EG 3/8-24	1,058	90	8	6,2	9,80	18	4	100,10	**037**
EG 7/16-20	1,270	100	9	7,0	11,50	22	3	125,60	**043**
EG 1/2-20	1,270	100	11	9,0	13,10	22	3	117,90	**050**
EG 5/8-18	1,411	110	14	11,0	16,25	25	4	180,00	**062**
EG 3/4-16	1,588	125	16	12,0	19,50	25	4	230,30	**075**

P	**12**
M	**7**
K	**12**
N	
S	
H	
O	

Blind hole – machine taps for wire thread inserts, right hand

EG UNF | Salo-Rex

UNI | E 1,5–2 | 2B | vap.



DIN 371 with reinforced shank

HSS-E
42°
≤ 1100 N/mm²
≤ 3xD

22 680 ...

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes	EUR U0	
EG Nr. 4-48	0,529	56	4	3,0	3,0	7	20	3	70,08	**004**
EG Nr. 6-40	0,635	70	6	4,9	3,7	8	25	3	69,54	**006**
EG Nr. 8-36	0,706	80	6	4,9	4,4	8	30	3	72,70	**008**
EG Nr. 10-32	0,794	80	6	4,9	5,1	8	30	3	76,75	**010**
EG 1/4-28	0,907	90	8	6,2	6,6	10	35	3	84,15	**025**

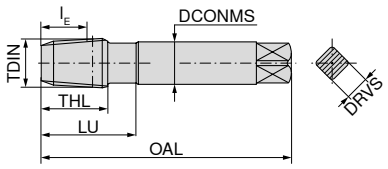
P	**12**
M	**7**
K	**12**
N	
S	
H	
O	

Blind hole – Machine taps, right hand

NPT | Salo-Rex

VA | C 2–3 | vap.

VA | C 2–3 | TiN

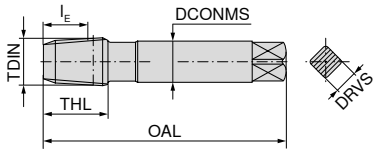


DIN 371 with reinforced shank

HSS-E
∢ 35°
≤ 900 N/mm²

HSS-E
∢ 42°
≤ 1100 N/mm²

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	l_E mm	THL mm	LU mm	Flutes	22 364 ... EUR U0		22 365 ... EUR U0	
1/16-27	0,941	90	8	6,2	9,24	13,0	26,0	3	95,40	**006**		
1/8-27	0,941	90	10	8,0	9,28	13,0	26,0	3	110,20	**012**		
1/8-27	0,941	90	10	8,0	9,28	12,0	26,0	4			144,10	**012**
1/4-18	1,411	100	14	11,0	13,55	19,5	34,5	3	128,80	**025**		
1/4-18	1,411	100	14	11,0	13,55	18,0	34,5	4			147,40	**025**



DIN 374 with reduced shank

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	l_E mm	THL mm	Flutes	22 371 ... EUR U0		22 372 ... EUR U0	
3/8-18	1,411	110	14	11	13,86	19,5	3	158,30	**037**		
3/8-18	1,411	110	14	11	13,86	18,0	5			239,10	**037**
1/2-14	1,814	140	16	12	18,11	25,0	5	230,30	**050**		
1/2-14	1,814	140	16	12	18,11	23,0	5			338,40	**050**
3/4-14	1,814	150	20	16	18,59	26,0	5	310,00	**075**		
1-11,5	2,209	170	25	20	22,31	32,0	5	454,10	**100**		

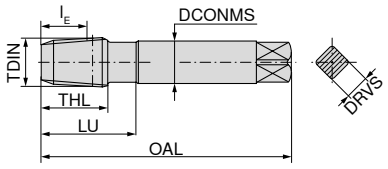
P	**4**	**5**
M	**3**	**4**
K		
N	**22**	**22**
S		
H		
O		

Through hole / Blind hole – Machine taps, right hand

NPT | TWIN

VG

C
2–3

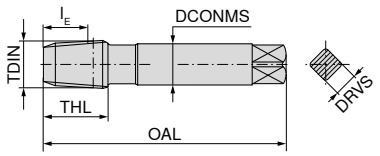


DIN 371 with reinforced shank

HSS-E
0°
≤ 1100 N/mm²

22 374 ...

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	l_E mm	THL mm	LU mm	Flutes	EUR U0	
1/16-27	0,941	90	8	6,2	9,24	13,0	26,0	3	68,77	**006**
1/8-27	0,941	90	10	8,0	9,28	13,0	26,0	3	89,40	**012**
1/4-18	1,411	100	14	11,0	13,55	19,5	34,5	3	94,64	**025**



DIN 374 with reduced shank

22 375 ...

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	l_E mm	THL mm	Flutes	EUR U0	
3/8-18	1,411	110	14	11	13,86	19,5	3	117,90	**037**
1/2-14	1,814	140	16	12	18,11	25,0	5	158,30	**050**
3/4-14	1,814	150	20	16	18,59	26,0	5	204,20	**075**
1-11,5	2,209	170	25	20	22,31	30,0	5	279,40	**100**

P	**4**
M	
K	**6**
N	**22**
S	
H	
O	

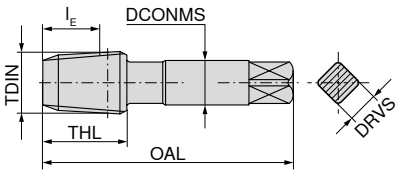
Through hole / Blind hole – Machine taps, right hand

▲ ES = extra short

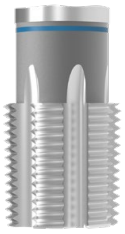
NPT | TWIN

ST
ES

C
2–3



DIN 2181 with reduced shank



HSS-E
0°
≤ 750 N/mm²

6

22 361 ...

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	l_E mm	THL mm	Flutes	EUR U0	
1/16-27	0,941	63	6	4,9	9,24	13,0	4	58,62	**006**
1/8-27	0,941	63	7	5,5	9,28	13,0	5	61,67	**012**
1/4-18	1,411	63	11	9,0	13,55	19,5	5	73,36	**025**
3/8-18	1,411	70	12	9,0	13,86	19,5	5	92,12	**037**
1/2-14	1,814	80	16	12,0	18,11	23,0	5	123,40	**050**
3/4-14	1,814	100	20	16,0	18,59	26,0	6	155,00	**075**
1-11,5	2,209	110	25	20,0	22,31	32,0	6	231,30	**100**

P	**6**
M	
K	**6**
N	**22**
S	
H	
O	

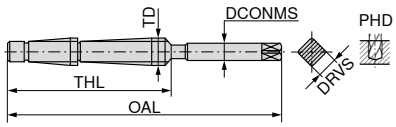
Through hole – Machine taps, right hand

▲ Single finishing trapezoidal taps (2 steps)
▲ do not reverse

Tr

ST

7H



Factory standard

HSS-E
5°
≤ 900 N/mm²
≤ 2xD

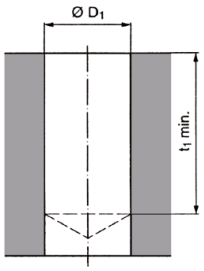
22 402 ...

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	EUR U0	
Tr 8	1,5	105	6	4,9	6,60	55	3	513,00	**080**
Tr 9	2,0	130	7	5,5	7,20	70	3	513,00	**090**
Tr 10	2,0	130	7	5,5	8,20	70	3	513,00	**102**
Tr 10	3,0	155	7	5,5	7,25	95	3	472,70	**103**
Tr 12	3,0	160	9	7,0	9,25	95	3	566,60	**123**
Tr 14	3,0	170	10	8,0	11,25	100	3	657,00	**143**
Tr 14	4,0	195	10	8,0	10,25	125	3	555,70	**144**
Tr 16	4,0	225	12	9,0	12,25	130	3	555,70	**164**
Tr 18	4,0	225	14	11,0	14,25	116	3	573,10	**184**
Tr 20	4,0	225	16	12,0	16,25	130	3	663,70	**204**
Tr 22	5,0	260	16	12,0	17,25	160	3	772,90	**225**
Tr 24	5,0	285	18	14,5	19,25	165	3	894,00	**245**

P	●
M	
K	●
N	●
S	
H	
O	

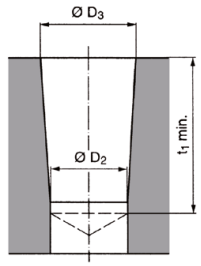
Core hole diameters for taper threads (taper 1:16)

Pre-drilling of cylindrical holes without reamer



		NPT		NPTF				Rc	
Ø d_1 inch	Pitch Gg/1"	Ø D_1 mm	t_1 min. mm	Ø D_1 mm	t_1 min. mm	Ø d_1 inch	Pitch Gg/1"	Ø D_1 mm	t_1 min. mm
1/16	27	6,15	12	6,1	12	1/16	28	6,2	11,9
1/8	27	8,5	12	8,45	12	1/8	28	8,2	11,9
1/4	18	11	17,5	10,9	17,5	1/4	19	10,85	16,3
3/8	18	14,5	17,6	14,3	17,6	3/8	19	14,5	18,1
1/2	14	17,85	22,9	17,6	22,9	1/2	14	18	24
3/4	14	23,2	23	23	23	3/4	14	23,5	25,3
1	11½	29,5	27,4	28,75	27,4	1	11	29,5	30,6
1¼	11½	37,8	28,1	37,5	28,1				
1½	11½	44	28,4	43,75	28,4				
2	11½	56	28,4	55,75	28,4				

Pre-drilling of cylindrical holes and conical boring with reamer

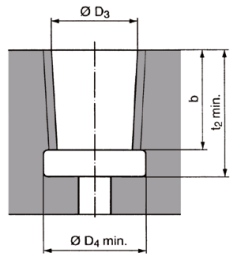


Taper 1:16

		NPT			NPTF		
Ø d_1 inch	Pitch Gg/1"	Ø d_2 mm	Ø d_3 mm	t_1 min. mm	Ø D_2 mm	Ø D_3 mm	t_1 min. mm
1/16	27	5,95	6,39	12	5,95	6,41	12
1/8	27	8,25	8,74	12	8,25	8,76	12
1/4	18	10,75	11,36	17,5	10,75	11,4	17,5
3/8	18	14,1	14,8	17,6	14,1	14,84	17,6
1/2	14	17,5	18,32	22,9	17,5	18,33	22,9
3/4	14	22,7	23,67	23	22,7	23,68	23
1	11½	28,6	29,69	27,4	28,6	29,72	27,4
1¼	11½	37,3	38,45	28,1	37,3	38,48	28,1
1½	11½	43,4	44,52	28,4	43,4	44,5	28,4
2	11½	55,5	56,56	28,4	55,5	56,59	28,4

		Rc		
Ø d_1 inch	Pitch Gg/1"	Ø D_2 mm	Ø D_3 mm	t_1 min. mm
1/16	28	6,1	6,56	11,9
1/8	28	8,1	8,57	11,9
1/4	19	10,75	11,45	17,7
3/8	19	14,25	14,95	18,1
1/2	14	17,75	18,63	24
3/4	14	23	24,12	25,3
1	11	29	30,29	30,6

Recommendation for the pre-drilling of blind hole threads



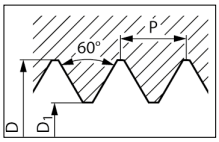
Taper 1:16

		NPT				NPTF			
Ø d_1 inch	Pitch Gg/1"	Ø D_3 mm	b mm	t_2 min. mm	Ø D_4 mm	Ø D_3 mm	b mm	t_2 min. mm	Ø D_4 min. mm
1/16	27	6,39	7	10	7,6	6,41	8	11	7,4
1/8	27	8,74	7	10	10	8,76	8	11	9,8
1/4	18	11,36	10,2	14,5	13,1	11,4	11,6	15,5	12,9
3/8	18	14,8	10,6	15	16,5	14,84	12	16	16,3
1/2	14	18,32	13,8	19	20,5	18,33	15,6	20,5	20,3
3/4	14	23,67	14,2	20	25,8	23,68	16	21,5	25,6
1	11½	29,69	17	24	32,2	29,72	19,2	26	32
1¼	11½	38,45	17,5	24,5	41	38,48	19,7	26,5	40,8
1½	11½	44,52	17,5	24,5	47,2	44,5	19,7	26,5	47
2	11½	56,56	18	25	59,2	56,59	20,2	27	59

		Rc			
Ø d_1 inch	Pitch Gg/1"	Ø D_3 mm	b mm	t_2 min. mm	Ø D_4 min. mm
1/16	28	6,56	5,6	9,5	7,6
1/8	28	8,57	5,6	9,5	9,6
1/4	19	11,45	8,4	14	13
3/8	19	14,95	8,8	14,4	16,5
1/2	14	18,63	11,4	19	20,6
3/4	14	24,12	12,7	20,3	26
1	11	30,29	14,5	24,3	32,8

Tapped hole pilot diameter

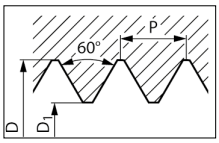
M ISO metric coarse threads 6H to DIN 13 and DIN ISO 965-1 (M1-M1,4 = 5H)



Thread nominal Ø		Ø D_1		Core hole
D	P	min.	max.	
M1	0,25	0,729	0,785	0,75
M1,1	0,25	0,829	0,885	0,85
M1,2	0,25	0,929	0,985	0,95
M1,4	0,3	1,075	1,142	1,1
M1,6	0,35	1,221	1,321	1,25
M1,8	0,35	1,421	1,521	1,45
M2	0,4	1,567	1,679	1,6
M2,2	0,45	1,713	1,838	1,75
M2,5	0,45	2,013	2,138	2,05
M3	0,5	2,459	2,599	2,5
M3,5	0,6	2,850	3,010	2,9
M4	0,7	3,242	3,422	3,3
M4,5	0,75	3,688	3,878	3,7
M5	0,8	4,134	4,334	4,2
M6	1,0	4,917	5,153	5
M7	1,0	5,917	6,153	6
M8	1,25	6,647	6,912	6,8
M9	1,25	7,647	7,912	7,8
M10	1,5	8,376	8,676	8,5
M11	1,5	9,376	9,676	9,5

Thread nominal Ø		Ø D_1		Core hole
D	P	min.	max.	
M12	1,75	10,106	10,441	10,2
M14	2,0	11,835	12,210	12
M16	2,0	13,835	14,210	14
M18	2,5	15,294	15,744	15,5
M20	2,5	17,294	17,744	17,5
M22	2,5	19,294	19,744	19,5
M24	3,0	20,752	21,252	21
M27	3,0	23,752	24,252	24
M30	3,5	26,211	26,771	26,5
M33	3,5	29,211	29,771	29,5
M36	4,0	31,670	32,270	32
M39	4,0	34,670	35,270	35
M42	4,5	37,129	37,799	37,5
M45	4,5	40,129	40,799	40,5
M48	5,0	42,587	43,297	43
M52	5,0	46,587	47,297	47
M56	5,5	50,046	50,796	50,5
M60	5,5	54,046	54,796	54,5
M64	6,0	57,505	58,305	58
M68	6,0	61,505	62,305	62

MF ISO metric fine threads 6H to DIN 13 and DIN ISO 965-1



Thread nominal Ø			Ø D_1		Core hole
D	x	P	min.	max.	
M2	x	0,25	1,729	1,774	1,75
M2,2	x	0,25	1,929	1,974	1,95
M2,5	x	0,35	2,121	2,221	2,15
M3	x	0,35	2,621	2,721	2,65
M3,5	x	0,35	3,121	3,221	3,15
M4	x	0,35	3,621	3,721	3,65
M4	x	0,5	3,459	3,599	3,5
M4,5	x	0,5	3,959	4,099	4
M5	x	0,5	4,459	4,599	4,5
M6	x	0,5	5,459	5,599	5,5
M6	x	0,75	5,188	5,378	5,2
M8	x	0,75	7,188	7,378	7,2
M8	x	1,0	6,917	7,153	7
M10	x	0,75	9,188	9,378	9,2
M10	x	1,0	8,917	9,153	9
M10	x	1,25	8,647	8,912	8,8
M12	x	1,0	10,917	11,153	11
M12	x	1,5	10,376	10,676	10,5
M14	x	1,25	12,647	12,912	12,8
M16	x	1,0	14,917	15,153	15
M16	x	1,5	14,376	14,676	14,5

Thread nominal Ø			Ø D_1		Core hole
D	x	P	min.	max.	
M20	x	1,0	18,917	19,153	19
M20	x	1,5	18,376	18,676	18,5
M20	x	2,0	17,835	18,210	18
M24	x	1,5	22,376	22,676	22,5
M30	x	2,0	27,835	28,210	28
M36	x	1,5	34,376	34,676	34,5
M36	x	3,0	32,752	33,252	33
M42	x	2,0	39,835	40,210	40
M48	x	1,5	46,376	46,676	46,5
M48	x	3,0	44,752	45,252	45
M48	x	4,0	43,670	44,270	44
M56	x	1,5	54,376	54,676	54,5
M56	x	2,0	53,835	54,210	54
M56	x	3,0	52,752	53,252	53
M56	x	4,0	51,670	52,270	52
M64	x	3,0	60,752	61,252	61
M64	x	4,0	59,670	60,270	60
M72	x	4,0	67,670	68,270	68
M80	x	6,0	73,505	74,305	74
M95	x	6,0	88,505	89,305	89
M110	x	6,0	103,505	104,305	104

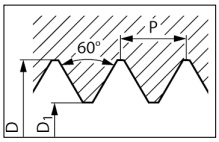
Dimensions in mm; P = Pitch

Thread former pilot hole diameter

M ISO metric coarse threads 6H to DIN 13 and DIN ISO 965-1 (M1-M1,4 = 5H)

Thread nominal Ø		Ø D_1		Core hole
D	P	min.	max.	
M1	0,25	0,89		0,9
M1,2	0,25	1,09		1,1
M1,4	0,3	1,26		1,26
M1,6	0,35	1,45		1,45
M1,8	0,35	1,65		1,65
M2	0,4	1,83	1,86	1,85
M2,2	0,45	2,00	2,04	2,0
M2,5	0,45	2,30	2,34	2,3
M3	0,5	2,77	2,82	2,8
M3,5	0,6	3,23	3,28	3,25
M4	0,7	3,68	3,73	3,7
M4,5	0,75	4,15	4,21	4,15
M5	0,8	4,63	4,68	4,65

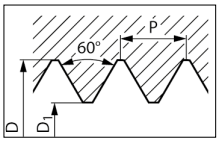
Thread nominal Ø		Ø D_1		Core hole
D	P	min.	max.	
M6	1	5,51	5,59	5,55
M7	1	6,51	6,59	6,55
M8	1,25	7,39	7,48	7,4
M9	1,25	8,39	8,48	8,4
M10	1,5	9,25	9,35	9,3
M11	1,5	10,25	10,35	10,3
M12	1,75	11,12	11,25	11,2
M14	2	13,00	13,15	13,0
M16	2	15,00	15,15	15,0
M18	2,5	16,72	16,90	16,8
M20	2,5	18,72	18,90	18,8
M22	2,5	20,72	20,9	20,8
M24	3	22,46	22,7	22,5



MF ISO metric fine threads 6H to DIN 13 and DIN ISO 965-1

Thread nominal Ø			Ø D_1		Core hole
D	x	P	min.	max.	
M2	x	0,25	1,89		1,9
M2,2	x	0,25	2,09		2,1
M2,5	x	0,25	2,39		2,4
M2,5	x	0,35	2,35		2,35
M3	x	0,25	2,89		2,9
M3	x	0,35	2,85		2,85
M3,5	x	0,35	3,35		3,35
M3,5	x	0,5	3,27	3,32	3,3
M4	x	0,35	3,85		3,85
M4	x	0,5	3,77	3,82	3,8
M4,5	x	0,5	4,27	4,32	4,3
M5	x	0,5	4,77	4,82	4,8
M5	x	0,75	4,65	4,71	4,65
M5,5	x	0,5	5,27	5,32	5,3
M6	x	0,5	5,78	5,83	5,8
M6	x	0,75	5,65	5,71	5,65
M7	x	0,5	6,78	6,83	6,8
M7	x	0,75	6,65	6,71	6,65
M8	x	0,5	7,78	7,83	7,8
M8	x	0,75	7,65	7,71	7,65
M8	x	1,0	7,51	7,59	7,55
M9	x	0,5	8,78	8,83	8,8
M9	x	0,75	8,65	8,71	8,65
M9	x	1,0	8,51	8,59	8,55
M10	x	0,5	9,78	9,83	9,8
M10	x	0,75	9,65	9,71	9,65
M10	x	1,0	9,51	9,59	9,55
M10	x	1,25	9,39	9,48	9,4
M11	x	0,75	10,65	10,71	10,7
M11	x	1,0	10,51	10,59	10,5
M12	x	0,75	11,66	11,72	11,7

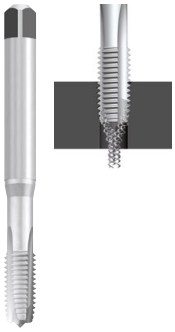
Thread nominal Ø			Ø D_1		Core hole
D	x	P	min.	max.	
M12	x	1,0	11,52	11,6	11,5
M12	x	1,25	11,4	11,49	11,4
M12	x	1,5	11,26	11,36	11,3
M13	x	0,75	12,66	12,72	12,7
M13	x	1,0	12,52	12,6	12,5
M13	x	1,5	12,26	12,36	12,3
M14	x	0,75	13,66	13,72	13,7
M14	x	1,0	13,52	13,6	13,5
M14	x	1,25	13,4	13,49	13,4
M14	x	1,5	13,26	13,36	13,3
M15	x	0,75	14,66	14,72	14,7
M15	x	1,0	14,52	14,6	14,5
M15	x	1,5	14,26	14,36	14,3
M16	x	0,75	15,66	15,72	15,7
M16	x	1,0	15,52	15,6	15,5
M16	x	1,5	15,26	15,36	15,3
M18	x	1,0	17,52	17,6	17,5
M18	x	1,5	17,26	17,36	17,3
M18	x	2,0	17	17,15	17
M20	x	1,0	19,52	19,6	19,5
M20	x	1,5	19,26	19,36	19,3
M20	x	2,0	19	19,15	19
M22	x	1,5	21,26	21,36	21,3
M22	x	2,0	21	21,15	21
M24	x	1,5	23,26	23,38	23,3
M24	x	2,0	23,01	23,16	23
M25	x	1,5	24,26	24,38	24,3
M26	x	1,5	25,26	25,38	25,3
M27	x	2,0	26,01	26,16	26
M28	x	1,5	27,26	27,38	27,25
M30	x	1,5	29,26	29,38	29,25
M30	x	2,0	29,01	29,16	29



Dimensions in mm; P = Pitch

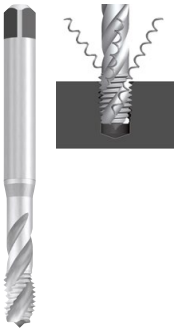
Tap Type Explanation

Stabil Through hole tap type Stabil



- For through holes up to 4xD
- Lead Form B: 3.5–5 cutting leads, with spiral point
- Straight Flutes
- Also suitable for synchronised machining, with Wedlon flat and with extra long version
- Due to the special geometry of the flutes, the chips are removed in the direction of cut

Salo-Rex Blind hole tap type Salo-Rex

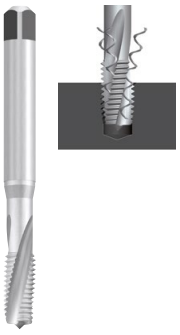


- For blind holes up to 3xD
- Lead Form C: 2–3 cutting leads, without spiral point
- Lead Form E: 1.5–2 cutting leads, without spiral point
- (35°, 42°, 45°, 50°) right hand helix
- Also suitable for syncronised machining, with Weldon flat, with extra long version and through coolant
- The high helix angle ensures chips are discharged effectively against the direction of cut

TWIN Through and blind hole tap Type TWIN

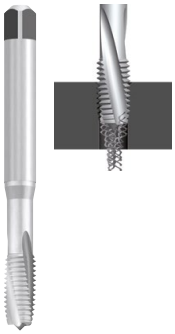
- For blind and through holes up to 2xD
- Lead Form C: 2–3 cutting leads, without spiral point
- Lead Form D: 3.5–5 cutting leads, without spiral point
- Lead Form E: 1.5–2 cutting leads, without spiral point
- Straight Flutes
- For steel, short chipping and hardened materials to 55 (62) HRc
- Also with extra long version and through coolant

SL Blind hole tap type SL



- For blind holes up to 2xD
- Lead Form C: 2–3 cutting leads, without spiral point
- Lead Form E: 1.5–2 cutting leads, without spiral point
- (15°, 25°, 30°) slow right hand helix
- For steel, titanium alloys and Inconel 718
- Also suitable for synchronised machining, with extra long version and through coolant
- Also suitable for difficult operating conditions such as cross holes

DL Through hole tap type DL

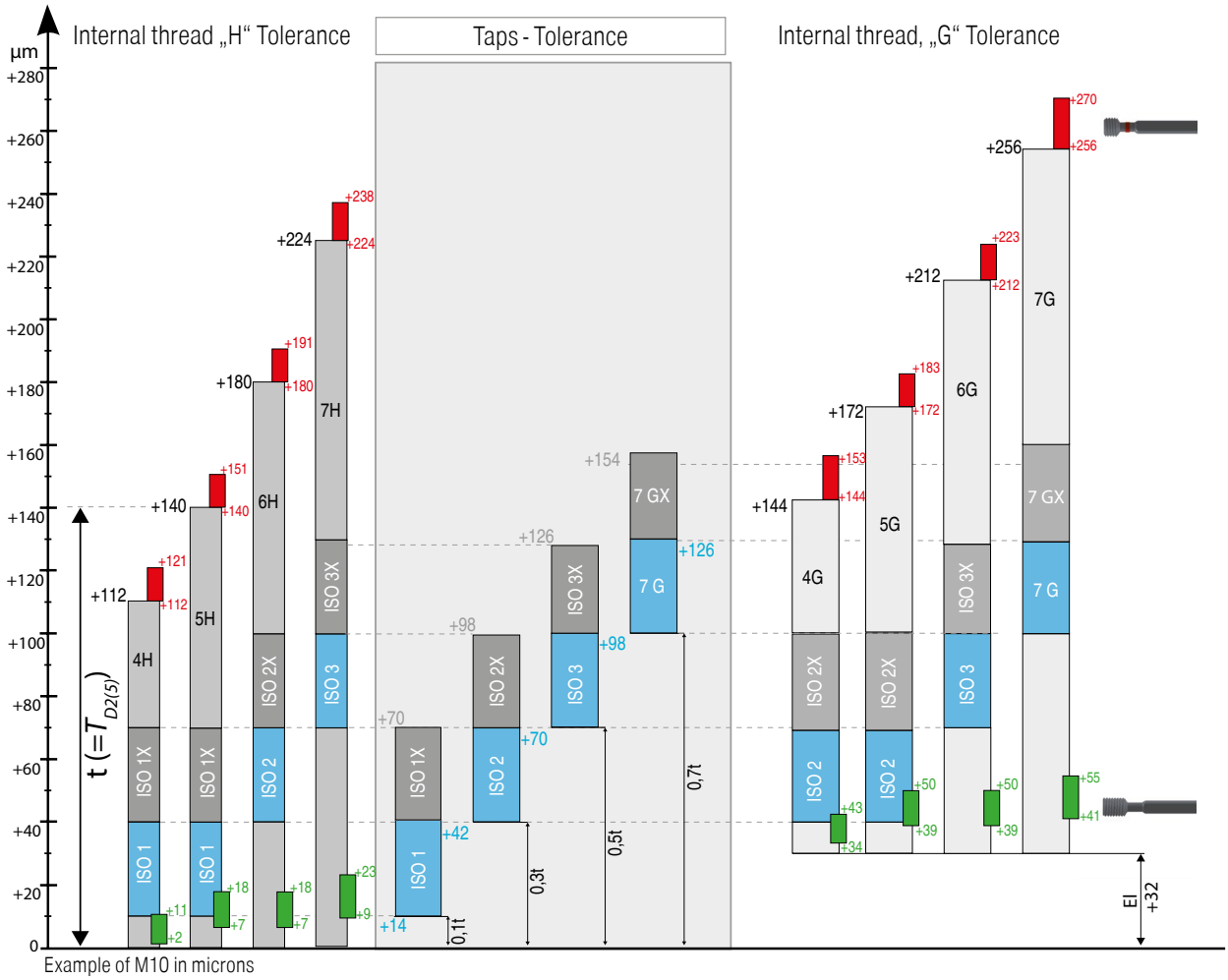


- For through holes up to 4xD
- Lead Form C: 3.5–5 cutting leads, without spiral point
- 15° left hand helix
- Suitable for steel, titanium alloys and Inconel 718
- The chips are discharged in the direction of cut

Spanlos Thread former type Spanlos

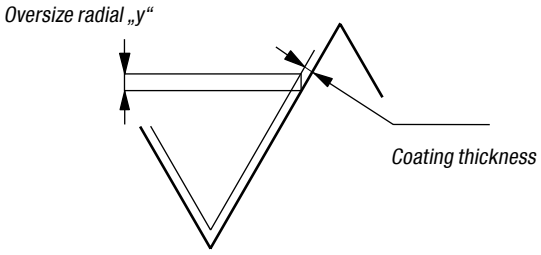
- For blind and through holes up to 3xD
- Lead Form C: 2–3 cutting leads, without spiral point
- For cold formable materials up to 1400 N/mm^2
- Suitable for synchronised machining, with lubrication grooves and internal cooling

Thread tolerances and recommended manufacturing tolerances



Workpieces to be plated require oversize taps.
The interference depends on the coating thickness and the flank angle.

at	60° Flank angle	Oversize ≙ 4 x coating thickness
	55° Flank angle	Oversize ≙ 4.331 x coating thickness
	30° Flank angle	Oversize ≙ 7.727 x coating thickness

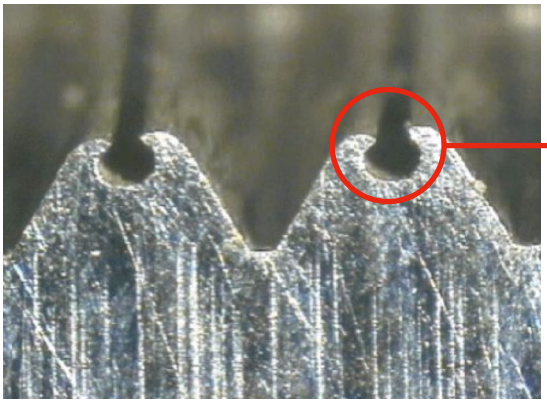


Application class of the tap Designation according to		Tolerance class of the internal thread to be cut				
DIN	ISO					
4H	ISO1	4H	5H	–	–	–
6H	ISO2	4G	5G	6H	–	–
6G	ISO3	–	(4E)	6G	7H	8H
7G	–	–	–	(6E)	7G	8G

For special applications, e.g. abrasive cast iron materials or plastics other dimensions have to be chosen which are determined on previous experience. In such cases an „X“ is added to the short designation of the tolerance, e.g. ISO 2X, however the tolerance zone assignment may be limited (6HX for tolerance zone 6H and 5G). In addition it should be taken into account that the dimensions of the internal thread do not only depend on the dimensions of the tap but on the material to be machined and all production conditions. For first taps and intermediate taps no thread dimensions are determined.

Thread formers

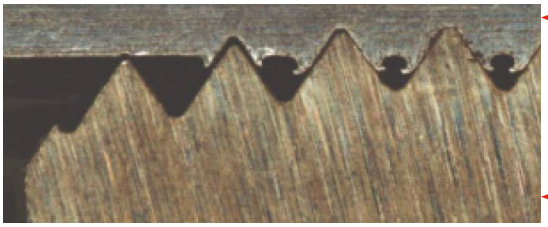
Spanlos thread forming taps for cold-formable materials up to 1400 N/mm² or at least 5 % elongation.
The thread is produced by plastic deformation. The molded thread has very high strength.



Prior to forming a thread, you should ensure that a molded thread is acceptable. In certain sectors, the forming of a thread is **not** permitted. Dirt or bacteria can settle in the formed crown.

Important

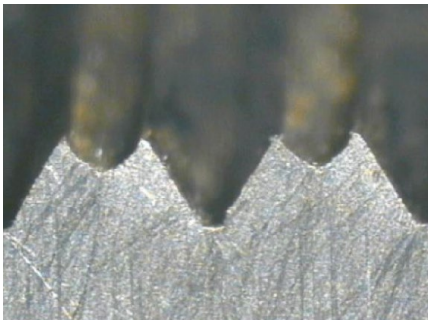
Incremental pressure forming



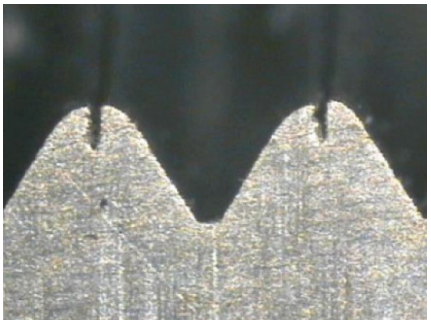
The thread profile is pressed gradually into the material via the start (leading edge) of the tap.

Properties

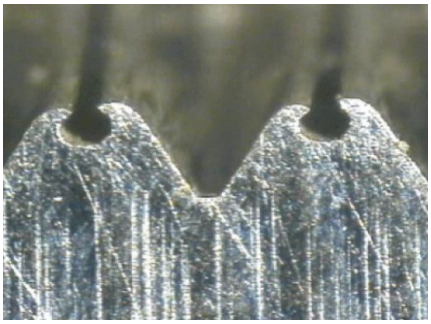
- One type can be used in different materials
- For through and blind holes
- Very good thread surface quality
- High static and dynamic strength thread
- Secure machining of deep and counterbored threads
- Short machining times
- No chip problems
- No swarf
- High process security
- HSS-E and HSS-PM taps for materials up to 33 HRC with a minimum elongation of 5 %



Underformed – core hole too large



Overformed – core hole too small



Perfect form – Core hole correct

Troubleshooting

Poor tool life

Cause

- Overload fractures of the cutting edge on the lead
- Hardness or tool material not suitable for the application
- Core hole too small, or work hardened
- Insufficient lubrication or incorrect application parameters

Remedy

- A longer lead or more flutes for the same lead length, giving a greater number of cutting teeth
- In reground tools the hardness can be reduced, apply correct parameters for regrinding
- Increase frequency of changes or regrinding of the drill
- Use the correct operating parameters for drilling
- Select the correct lubricant and ensure adequate supply

Axial thread error

Cause

- Selected geometry is not suitable
- Spindle speed is wrong compared with feed (synchronisation error)
- Blind hole taps are used with high feed pressure
- Through hole taps are used with low feed pressure

Remedy

- Check programming and pitch control or machine synchronisation
- Use tapping chuck with length compensation
- Increase retraction feed pessure
- Increase feed pessure

Oversize thread

Cause

- Thread tolerances of tool and thread gauge do not match
- Burred tool edges after regrinding
- Cold pressure welding

Remedy

- Check the correct tolerances for tool and thread gauge
- Carefully deburr
- Use appropriate (positive) geometry
- Reduce cutting speed
- Use different surface treatment or coating
- Use tapping chuck with length compensation
- Use appropriate lubricant

Broken tool

Cause

- Tool is worn
- Tool has hit the bottom of the hole
- Weld deposits
- Core hole too small
- Chip trapping
- Incorrect cutting speed
- Chip trapping in the flute
- Insufficient cooling / lubrication

Remedy

- Employ set taps
- Use a tool with lower helix
- Use tools with a shorter / longer lead
- Check the pre-drilling depth and the thread depth
- Drill core hole deeper
- Correct cutting speed
- Use a different coating or surface treatment
- Use tool holder with length compensation
- Use suitable lubricant
- Use correct core hole
- Change geometry and / or flute type
- Note chip shape and chip formation

Coatings

vap.
- Vaporised
- Vaporisation (vapour-deposition) prevents cold welds from forming on the tool and increases the surface hardness and thus the wear resistance

nitr.
- Nitrided
- Nitriding increases wear resistance and offers low friction properties

vap. + nitr.
- Vaporized + Nitrated
- Combination of increased surface hardness and lubricant carrier

TiN
- TiN coating
- Maximum application temperature: 450 °C

TiN GS
- Titanium nitride low friction layer
- High wear resistance with low friction properties
- Maximum application temperature: 450 °C

TiCN
- TiCN multilayer coating
- Maximum application temperature: 450 °C

DLC
- Diamond-like carbon coating
- Specifically for machining non-ferrous metals
- Maximum application temperature: 400 °C

Ti200
- TiN coating
- Well suited for high cutting speeds during thread forming
- Maximum application temperature: 450 °C

OSM
- Hard material layer and anti-friction layer
- For use in high-strength steels

CH
- Amorphous carbon layer
- For use in non-ferrous metals or aluminum
- Reduces the material adhesion

HCr
- Hard chromed
- For use in non-ferrous metals or aluminum
- Very low surface roughness

CrN
- Chromium-nitrogen coating
- Very wear-resistant coating
- Especially suitable for use in aluminum, but also for P, M and S materials

ALTiNHD
- AlTiN-based nanolayer hard material coating
- Maximum application temperature 500 °C

Coloured rings - overview

WNT \ Performance

for steel up to 750 N/mm²

Type ST uncoated tap for steel up to 750 N/mm² tensile strength

for steel to 1100 N/mm²

Type ST and VG coated tap for steel up to 1100 N/mm² tensile strength

for steel up to 1400 N/mm²

Type HR for steel up to 1400 N/mm² tensile strength

for corrosion and acid-resistant steels

Type VA for stainless steel

For cast iron materials

Type GG for cast iron

for aluminium and non-ferrous metal

Type NW, Soft and Ms for aluminium, short-chipping brass and soft materials

for heat resistant alloys

Type Ti, Ni and AMPCO for heat-resistant steel, titanium and Inconel

for hardened steels

Type HT for hard machining

for universal application up to 1100 N/mm²

Type UNI for the all-purpose use