



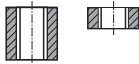
# SPIRAL POINT TAPS

**TR853** SERIES

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

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

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

**Hole type**


DIN 371



DIN 376

Material groups

**VA**

HSS-PM

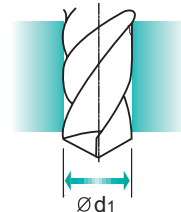
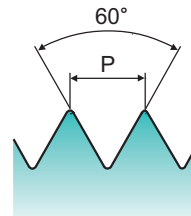
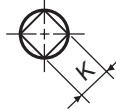
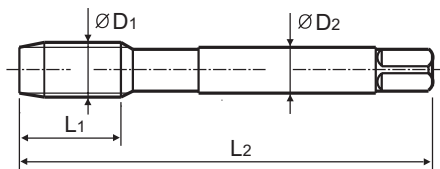
 DIN  
371/376

6H

60°

B

Bright

 Machine taps  
Maschinengewindebohrer


Unit : mm

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

► DIN 371(M2~M10) and DIN 376(M12)

 Unit : N/mm<sup>2</sup>

◎ : Excellent ○ : Good

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