



# SPIRAL POINT TAPS

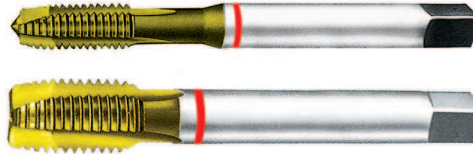
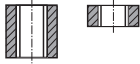
## TD422 SERIES

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

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

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

Hole type



DIN 371

DIN 376



HSS-E

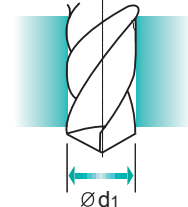
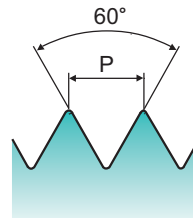
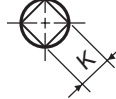
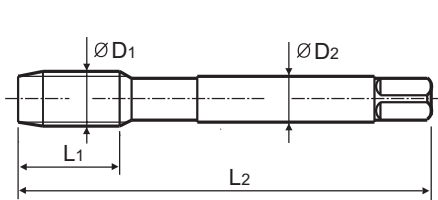
DIN 371/376

6H



TiN

Machine taps  
Maschinengewindebohrer



Unit : mm

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

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

► \* DIN profile not ISO

Unit : N/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
		○												

HSS

CARBIDE

COMBO TAPS

SPIRAL POINT TAPS

SPIRAL FLUTE TAPS

STRAIGHT FLUTE TAPS

COLD FORMING TAPS

NUT TAPS

STI TAPS

HAND TAPS

PIPE TAPS

CARBIDE TAPS

THREAD MILLS

TECHNICAL DATA