



# SPIRAL FLUTE TAPS

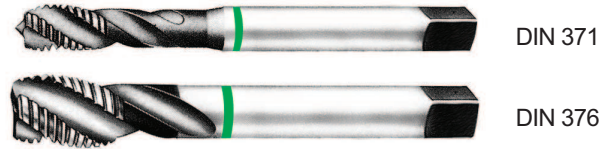
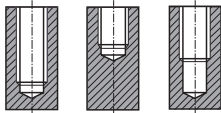
**TB914** SERIES

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

- ▶ With recessed threads for machine tapping of deep blind holes.
- ▶ Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

- ▶ Mit abgesetztem Gewinde zum Schneiden von tiefen Sacklochgewinden.
- ▶ Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

Hole type



HSS-E

DIN 371/376

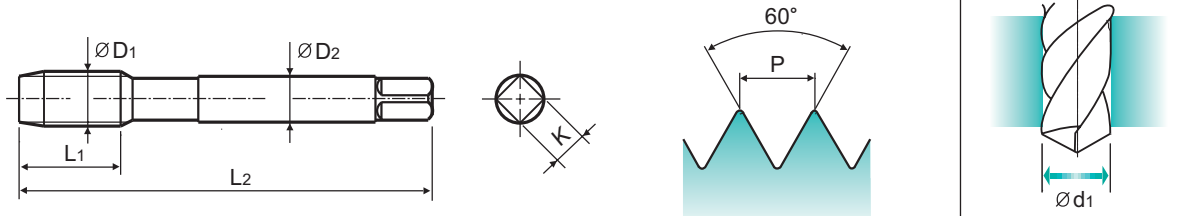
6H



Vap



Machine taps  
Maschinengewindebohrer



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>TB914136</b>	8	45	2.8	2.1	1.6
M2.2	× 0.45	<b>TB914156</b>	8	45	2.8	2.1	1.75
* M2.3	× 0.4	<b>TB914196</b>	8	45	2.8	2.1	1.9
M2.5	× 0.45	<b>TB914176</b>	9	50	2.8	2.1	2.05
* M2.6	× 0.45	<b>TB914496</b>	9	50	2.8	2.1	2.1
M3	× 0.5	<b>TB914206</b>	6	56	3.5	2.7	2.5
M3.5	× 0.6	<b>TB914226</b>	7	56	4	3	2.9
M4	× 0.7	<b>TB914246</b>	7	63	4.5	3.4	3.3
M4.5	× 0.75	<b>TB914266</b>	8	70	6	4.9	3.7
M5	× 0.8	<b>TB914286</b>	8	70	6	4.9	4.2
M6	× 1	<b>TB914316</b>	10	80	6	4.9	5
M7	× 1	<b>TB914346</b>	10	80	7	5.5	6
M8	× 1.25	<b>TB914366</b>	13	90	8	6.2	6.8
M9	× 1.25	<b>TB914396</b>	13	90	9	7	7.8
M10	× 1.5	<b>TB914426</b>	15	100	10	8	8.5
M11	× 1.5	<b>TB914466</b>	17	100	8	6.2	9.5
M12	× 1.75	<b>TB914506</b>	18	110	9	7	10.2
M14	× 2	<b>TB914546</b>	20	110	11	9	12
M16	× 2	<b>TB914606</b>	20	110	12	9	14
M18	× 2.5	<b>TB914656</b>	25	125	14	11	15.5
M20	× 2.5	<b>TB914706</b>	25	140	16	12	17.5
M22	× 2.5	<b>TB914746</b>	25	140	18	14.5	19.5
M24	× 3	<b>TB914786</b>	30	160	18	14.5	21
M27	× 3	<b>TB914866</b>	30	160	20	16	24
M30	× 3.5	<b>TB914946</b>	35	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