SPIRAL FLUTE TAPS

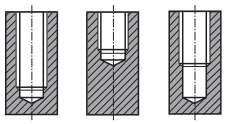
TD312 SERIES

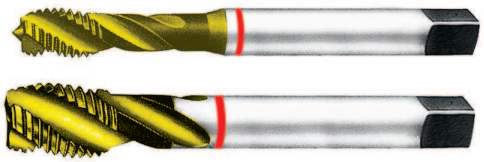
M ISO metric coarse threads DIN 13
Metrisches ISO-Gewinde DIN 13

▶ Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

▶ Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

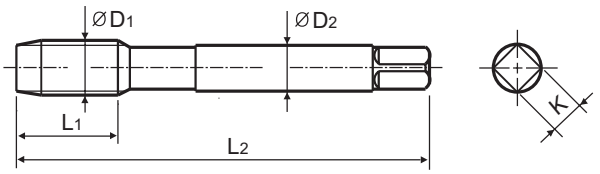
Hole type

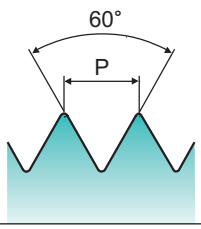


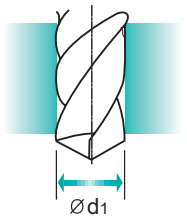


Material groups **VG** | HSS-E | DIN 371/376 | 6H | 60° | C | TiN | R40

Machine taps
Maschinengewindebohrer







Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping drill diameter Ød1
M2	0.4	TD312136	8	45	2.8	2.1	1.6
M2.2	0.45	TD312156	8	45	2.8	2.1	1.75
* M2.3	0.4	TD312196	8	45	2.8	2.1	1.9
M2.5	0.45	TD312176	9	50	2.8	2.1	2.05
* M2.6	0.45	TD312496	9	50	2.8	2.1	2.1
M3	0.5	TD312206	6	56	3.5	2.7	2.5
M3.5	0.6	TD312226	7	56	4	3	2.9
M4	0.7	TD312246	7	63	4.5	3.4	3.3
M4.5	0.75	TD312266	8	70	6	4.9	3.7
M5	0.8	TD312286	8	70	6	4.9	4.2
M6	1	TD312316	10	80	6	4.9	5
M7	1	TD312346	10	80	7	5.5	6
M8	1.25	TD312366	13	90	8	6.2	6.8
M9	1.25	TD312396	13	90	9	7	7.8
M10	1.5	TD312426	15	100	10	8	8.5
M11	1.5	TD312466	17	100	8	6.2	9.5
M12	1.75	TD312506	18	110	9	7	10.2
M14	2	TD312546	20	110	11	9	12
M16	2	TD312606	20	110	12	9	14
M18	2.5	TD312656	25	125	14	11	15.5
M20	2.5	TD312706	25	140	16	12	17.5
M22	2.5	TD312746	25	140	18	14.5	19.5
M24	3	TD312786	30	160	18	14.5	21
M27	3	TD312866	30	160	20	16	24
M30	3.5	TD312946	35	180	22	18	26.5

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

Unit : N/mm²

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
			○	◎				○						○

Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si≤10%	Al Si>10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
		○												