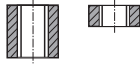


**SPIRAL
POINT TAPS****TC622** SERIES**M-Az** ISO metric coarse threads DIN 13
Metrisches ISO-Gewinde DIN 13

► Interrupted tap to reduce contact area and tapping torque, and to give more chip space.

► Gewindebohrer mit ausgesetzten Zähnen um die Kontaktzone mit dem Werkstück und das Drehmoment zu minimieren und dem Span mehr Raum zu geben.

Hole type



DIN 371



DIN 376

Material groups

AI

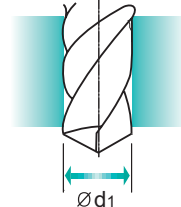
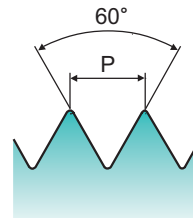
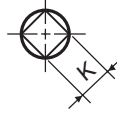
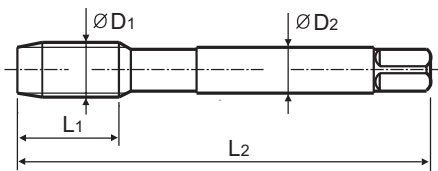
HSS-E

DIN
371/376

6H



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	TC622136	8	45	2.8	2.1	1.6
M2.2	× 0.45	TC622156	8	45	2.8	2.1	1.75
* M2.3	× 0.4	TC622196	8	45	2.8	2.1	1.9
M2.5	× 0.45	TC622176	9	50	2.8	2.1	2.05
* M2.6	× 0.45	TC622496	9	50	2.8	2.1	2.1
M3	× 0.5	TC622206	11	56	3.5	2.7	2.5
M3.5	× 0.6	TC622226	12	56	4	3	2.9
M4	× 0.7	TC622246	13	63	4.5	3.4	3.3
M4.5	× 0.75	TC622266	14	70	6	4.9	3.7
M5	× 0.8	TC622286	15	70	6	4.9	4.2
M6	× 1	TC622316	17	80	6	4.9	5
M7	× 1	TC622346	17	80	7	5.5	6
M8	× 1.25	TC622366	20	90	8	6.2	6.8
M9	× 1.25	TC622396	20	90	9	7	7.8
M10	× 1.5	TC622426	22	100	10	8	8.5
M11	× 1.5	TC622466	22	100	8	6.2	9.5
M12	× 1.75	TC622506	24	110	9	7	10.2
M14	× 2	TC622546	26	110	11	9	12
M16	× 2	TC622606	27	110	12	9	14
M18	× 2.5	TC622656	30	125	14	11	15.5
M20	× 2.5	TC622706	32	140	16	12	17.5
M22	× 2.5	TC622746	32	140	18	14.5	19.5
M24	× 3	TC622786	34	160	18	14.5	21
M27	× 3	TC622866	36	160	20	16	24
M30	× 3.5	TC622946	40	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
				○				○	○	○				