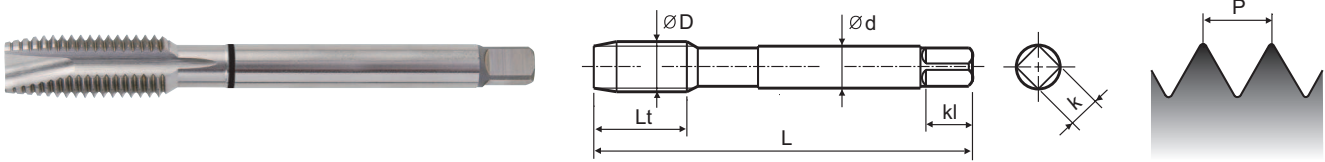


ISO Metric coarse threads DIN13

GUN POINT TAPS for Multi Purpose



GUN POINT TAPS ♦ **TC814**



Unit : mm

SIZE		Pitch	Limit	EDP No.	Overall Length	Thread Length	Shank Diameter	Square Size
D	P	L			Lt	d	k	
M2	x 0.4	6H	TC814136	45.0	8.0	2.8	2.1	
M2.2	x 0.45	6H	TC814156	45.0	8.0	2.8	2.1	
M2.3	x 0.4	6H	TC814196	45.0	8.0	2.8	2.1	
M2.5	x 0.45	6H	TC814176	50.0	9.0	2.8	2.1	
M2.6	x 0.45	6H	TC814496	50.0	9.0	2.8	2.1	
M3	x 0.5	6H	TC814206	56.0	11.0	3.5	2.7	
M3.5	x 0.6	6H	TC814226	56.0	12.0	4.0	3.0	
M4	x 0.7	6H	TC814246	63.0	13.0	4.5	3.4	
M4.5	x 0.75	6H	TC814266	70.0	14.0	6.0	4.9	
M5	x 0.8	6H	TC814286	70.0	15.0	6.0	4.9	
M6	x 1.0	6H	TC814316	80.0	17.0	6.0	4.9	
M7	x 1.0	6H	TC814346	80.0	17.0	7.0	5.5	
M8	x 1.25	6H	TC814366	90.0	20.0	8.0	6.2	
M9	x 1.25	6H	TC814396	90.0	20.0	9.0	7.0	
M10	x 1.5	6H	TC814426	100.0	22.0	10.0	8.0	
M11	x 1.5	6H	TC814466	100.0	22.0	8.0	6.2	
M12	x 1.75	6H	TC814506	110.0	24.0	9.0	7.0	
M14	x 2.0	6H	TC814546	110.0	26.0	11.0	9.0	
M16	x 2.0	6H	TC814606	110.0	27.0	12.0	9.0	
M18	x 2.5	6H	TC814656	125.0	30.0	14.0	11.0	
M20	x 2.5	6H	TC814706	140.0	32.0	16.0	12.0	
M22	x 2.5	6H	TC814746	140.0	32.0	18.0	14.5	
M24	x 3.0	6H	TC814786	160.0	34.0	18.0	14.5	
M27	x 3.0	6H	TC814866	160.0	36.0	20.0	16.0	
M30	x 3.5	6H	TC814946	180.0	40.0	22.0	18.0	

► DIN371 (M2~M10) and DIN376 (M11~M30)

RECOMMENDED TAPPING SPEEDS

Work Materials		Spiral Flute	Tapping Speed	Gun point	Tapping Speed
		TC814,TC834	(m/min)	TC804,TC824	(m/min)
Steels	Structure steels	●	15 ~ 20	●	15 ~ 20
	Plain carbon steels	●	12 ~ 18	●	12 ~ 18
	Alloy steels up to 850N/mm ²	●	10 ~ 15	●	10 ~ 15
	Hardened & Tempered steels up to 1,200N/mm ²	○	6 ~ 10	○	6 ~ 10
Stainless steels	Free machining	●	7 ~ 10	●	7 ~ 10
	Austenitic	●	5 ~ 8	●	5 ~ 8
Cast iron	Grey Cast irons up to 500N/mm ²	○	10 ~ 15	○	10 ~ 15
	Malleable Cast irons up to 700N/mm ²	○	10 ~ 15	○	10 ~ 15
	Nodular graphite up to 700N/mm ²	○	10 ~ 15	○	10 ~ 15
Aluminum	Alloyed Aluminum, Si<10%	○	15 ~ 20	○	15 ~ 20
	Alloyed Aluminum, Si>10%	●	10 ~ 15	●	10 ~ 15
Titanium	Unalloyed Titanium	●	10 ~ 15	●	10 ~ 15
	Alloyed Titanium up to 900N/mm ²	○	8 ~ 12	○	8 ~ 12
Nickel	Unalloyed Nickel	●	8 ~ 12	●	8 ~ 12
	Alloyed Nickel up to 900N/mm ²	○	10 ~ 15	○	10 ~ 15
Copper	Unalloyed Copper	●	8 ~ 12	●	8 ~ 12
	Long chipping Copper	●	15 ~ 20	●	15 ~ 20
Brass	Long chipping Brass	●	15 ~ 20	●	15 ~ 20
Bronze	Long chipping Bronze	●	15 ~ 20	●	15 ~ 20

● : RECOMMENDED
○ : SUITABLE

**International
patent**

FEATURES OF COMBO TAP

1. Thread configuration with a special design. (International patent)
 - * Prevents over-feeding, thin thread and pitch diameter oversize.
2. Flute geometry with special design.
 - * Better chip evacuation.
 - * Prevents chip clogging.
 - * Improves thread quality.
3. Applicable for wide applications.
 - * Blind and through holes.
4. Excellent performance on various materials.
 - * Carbon Steels, Alloyed Steels, Tool Steel etc.