SPIRAL POINT TAPS

TCH23 SERIES

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

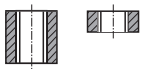
▶ Suitable for through hole in more cutting speed than other taps due to thick web.

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

DIN 371

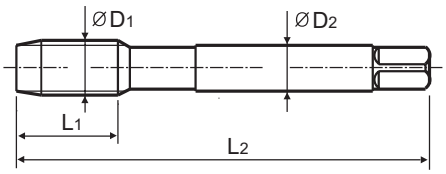
DIN 376

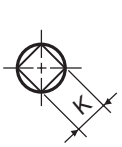
Hole type

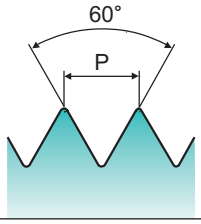


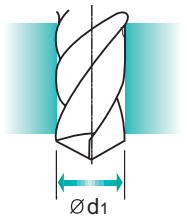
Material groups: VA NW | HSS-E | DIN 371/376 | 6HX | 60° | B | Hardslick

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	TCH23136	8	45	2.8	2.1	1.6
M2.2	0.45	TCH23156	8	45	2.8	2.1	1.75
* M2.3	0.4	TCH23196	8	45	2.8	2.1	1.9
M2.5	0.45	TCH23176	9	50	2.8	2.1	2.05
* M2.6	0.45	TCH23496	9	50	2.8	2.1	2.1
M3	0.5	TCH23206	11	56	3.5	2.7	2.5
M3.5	0.6	TCH23226	12	56	4	3	2.9
M4	0.7	TCH23246	13	63	4.5	3.4	3.3
M4.5	0.75	TCH23266	14	70	6	4.9	3.7
M5	0.8	TCH23286	15	70	6	4.9	4.2
M6	1	TCH23316	17	80	6	4.9	5
M7	1	TCH23346	17	80	7	5.5	6
M8	1.25	TCH23366	20	90	8	6.2	6.8
M9	1.25	TCH23396	20	90	9	7	7.8
M10	1.5	TCH23426	22	100	10	8	8.5
M11	1.5	TCH23466	22	100	8	6.2	9.5
M12	1.75	TCH23506	24	110	9	7	10.2
M14	2	TCH23546	26	110	11	9	12
M16	2	TCH23606	27	110	12	9	14
M18	2.5	TCH23656	30	125	14	11	15.5
M20	2.5	TCH23706	32	140	16	12	17.5
M22	2.5	TCH23746	32	140	18	14.5	19.5
M24	3	TCH23786	34	160	18	14.5	21
M27	3	TCH23866	36	160	20	16	24
M30	3.5	TCH23946	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
		○												