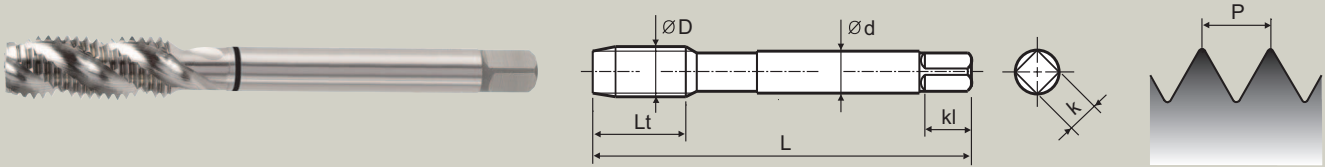


ISO Metric coarse threads DIN13 SPIRAL FLUTE TAPS for Multi Purpose



SPIRAL FLUTE TAPS ♦ **TC804**



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	TC804136	45.0	8.0	2.8	2.1
M2.2	x	0.45	6H	TC804156	45.0	8.0	2.8	2.1
M2.3	x	0.4	6H	TC804196	45.0	8.0	2.8	2.1
M2.5	x	0.45	6H	TC804176	50.0	9.0	2.8	2.1
M2.6	x	0.45	6H	TC804496	50.0	9.0	2.8	2.1
M3	x	0.5	6H	TC804206	56.0	6.0	3.5	2.7
M3.5	x	0.6	6H	TC804226	56.0	7.0	4.0	3.0
M4	x	0.7	6H	TC804246	63.0	7.0	4.5	3.4
M4.5	x	0.75	6H	TC804266	70.0	8.0	6.0	4.9
M5	x	0.8	6H	TC804286	70.0	8.0	6.0	4.9
M6	x	1.0	6H	TC804316	80.0	10.0	6.0	4.9
M7	x	1.0	6H	TC804346	80.0	10.0	7.0	5.5
M8	x	1.25	6H	TC804366	90.0	13.0	8.0	6.2
M9	x	1.25	6H	TC804396	90.0	13.0	9.0	7.0
M10	x	1.5	6H	TC804426	100.0	15.0	10.0	8.0
M11	x	1.5	6H	TC804466	100.0	15.0	8.0	6.2
M12	x	1.75	6H	TC804506	110.0	18.0	9.0	7.0
M14	x	2.0	6H	TC804546	110.0	20.0	11.0	9.0
M16	x	2.0	6H	TC804606	110.0	20.0	12.0	9.0
M18	x	2.5	6H	TC804656	125.0	25.0	14.0	11.0
M20	x	2.5	6H	TC804706	140.0	25.0	16.0	12.0
M22	x	2.5	6H	TC804746	140.0	25.0	18.0	14.5
M24	x	3.0	6H	TC804786	160.0	30.0	18.0	14.5
M27	x	3.0	6H	TC804866	160.0	30.0	20.0	16.0
M30	x	3.5	6H	TC804946	180.0	35.0	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.