



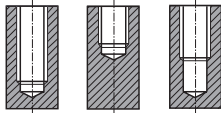
SPIRAL FLUTE TAPS

TB183 SERIES

MF ISO metric fine threads DIN 13 Metrisches ISO-Feingewinde 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


DIN 374



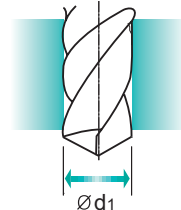
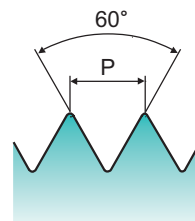
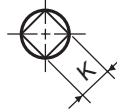
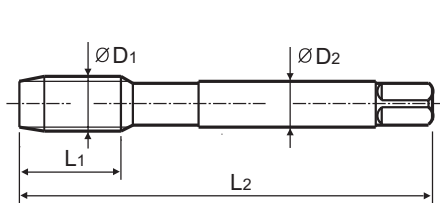
HSS-E

DIN 374

6H



Vap


 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
M4	× 0.5	TB183256	5	63	2.8	2.1	3.5
M5	× 0.5	TB183296	5	70	3.5	2.7	4.5
M6	× 0.75	TB183326	8	80	4.5	3.4	5.2
M6	× 0.5	TB183336	5	80	4.5	3.4	5.5
M7	× 0.75	TB183356	10	80	5.5	4.3	6.2
M8	× 1	TB183376	10	90	6	4.9	7
M8	× 0.75	TB183386	8	80	6	4.9	7.2
M10	× 1.25	TB183436	16	100	7	5.5	8.8
M10	× 1	TB183446	10	90	7	5.5	9
M10	× 0.75	TB183456	10	90	7	5.5	9.2
M12	× 1.5	TB183516	15	100	9	7	10.5
M12	× 1.25	TB183526	15	100	9	7	10.8
M12	× 1	TB183536	11	100	9	7	11
M14	× 1.5	TB183556	15	100	11	9	12.5
M14	× 1.25	TB183566	15	100	11	9	12.8
M16	× 1.5	TB183616	15	100	12	9	14.5
M18	× 1.5	TB183676	17	110	14	11	16.5
M20	× 1.5	TB183726	17	125	16	12	18.5
M22	× 1.5	TB183766	17	125	18	14.5	20.5
M24	× 1.5	TB183806	20	140	18	14.5	22.5

 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