



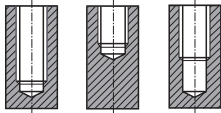
SPIRAL FLUTE TAPS

TCH14 SERIES

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

- ▶ With recessed threads for machine tapping of deep blind holes.
- ▶ Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

- ▶ Mit abgesetztem Gewinde zum Schneiden von tiefen Sacklochgewinden.
- ▶ Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

Hole type


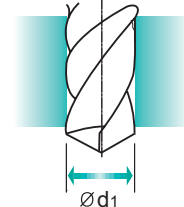
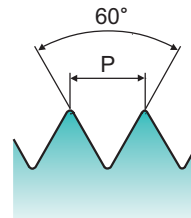
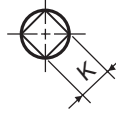
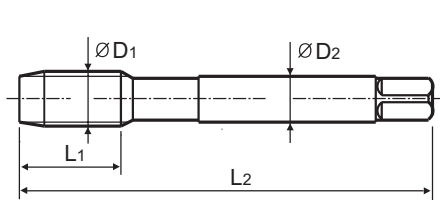
HSS-E

DIN
371/376

6H



Hardslick


 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	TCH14136	8	45	2.8	2.1	1.6
M2.2	× 0.45	TCH14156	8	45	2.8	2.1	1.75
* M2.3	× 0.4	TCH14196	8	45	2.8	2.1	1.9
M2.5	× 0.45	TCH14176	9	50	2.8	2.1	2.05
* M2.6	× 0.45	TCH14496	9	50	2.8	2.1	2.1
M3	× 0.5	TCH14206	6	56	3.5	2.7	2.5
M3.5	× 0.6	TCH14226	7	56	4	3	2.9
M4	× 0.7	TCH14246	7	63	4.5	3.4	3.3
M4.5	× 0.75	TCH14266	8	70	6	4.9	3.7
M5	× 0.8	TCH14286	8	70	6	4.9	4.2
M6	× 1	TCH14316	10	80	6	4.9	5
M7	× 1	TCH14346	10	80	7	5.5	6
M8	× 1.25	TCH14366	13	90	8	6.2	6.8
M9	× 1.25	TCH14396	13	90	9	7	7.8
M10	× 1.5	TCH14426	15	100	10	8	8.5
M11	× 1.5	TCH14466	17	100	8	6.2	9.5
M12	× 1.75	TCH14506	18	110	9	7	10.2
M14	× 2	TCH14546	20	110	11	9	12
M16	× 2	TCH14606	20	110	12	9	14
M18	× 2.5	TCH14656	25	125	14	11	15.5
M20	× 2.5	TCH14706	25	140	16	12	17.5
M22	× 2.5	TCH14746	25	140	18	14.5	19.5
M24	× 3	TCH14786	30	160	18	14.5	21
M27	× 3	TCH14866	30	160	20	16	24
M30	× 3.5	TCH14946	35	180	22	18	26.5

▶ DIN 371(M2~M10) and DIN 376(M11~M30)

▶ * M 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