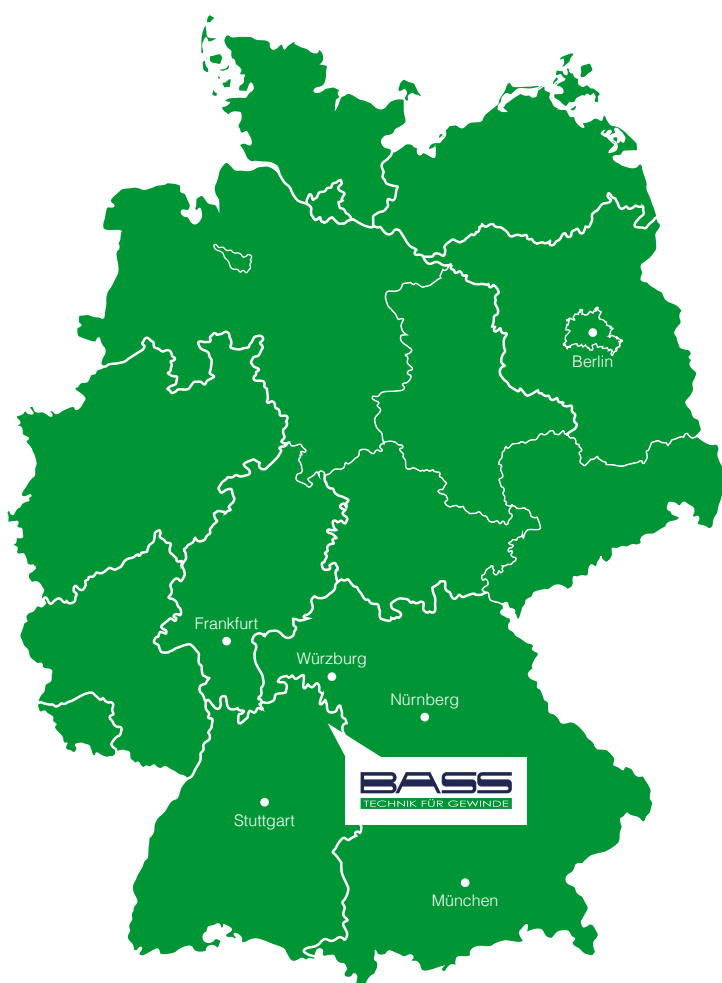


LITELINE

Your tap for standard applications.

For more than 75 years, we have been developing, producing and distributing high-precision products for the industrial, efficient thread production.

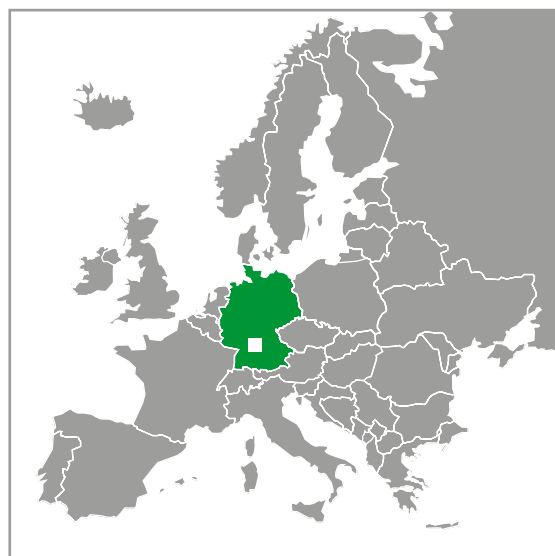
Around the world, customers from the automotive and aerospace industry as well as mechanical engineering and medical technology trust in our solutions.



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Edition 5 | You can find the current edition of our catalogue on our website.

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TABLE OF CONTENTS

APPLICATION TABLE	2
PRODUCT INDEX	3
GENERAL INFORMATION	4
CUTTING TAPS	8
M	8
MF	16
G	24
UNC	28
UNF	30
STI (EG-M)	32
NPT	34

APPLICATION TABLE

number of revolutions (rpm)

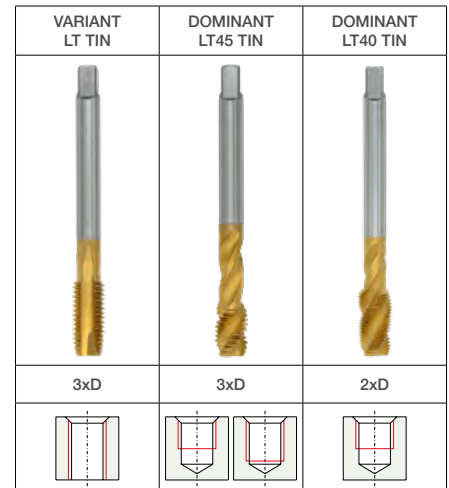
$$n = \frac{v_c \cdot 1000}{\pi \cdot d_1}$$

cutting speed

$$v_c = \frac{n \cdot \pi \cdot d_1}{1000}$$

How to proceed

1. Select hole shape
2. Select application
3. Search for cutting speed (vc m/min)



	Application	Examples of materials	R _m N/mm²	HB	HRC	vc m/min (Tool well suitable – tool suitable)		
P	Steel materials							
	Magnetic soft steel	FeP01	> 100 < 450			20 - 30	20 - 30	2 - 8
	Construction steel / case hardening steel	En40B	> 300 < 700			20 - 30	20 - 30	2 - 8
	Carbon steel	080M46	> 400 < 950			20 - 30	20 - 30	2 - 8
	Alloyed / heat-treatable steel	En19A	> 450 < 950			15 - 30	15 - 30	
	Alloyed steel	BD2	> 800 < 1250	> 235 < 370	> 22 < 40	10 - 20	10 - 20	
M	Stainless steel							
	Ferritic / martensitic steel	420S37	> 450 < 1200			6 - 12	6 - 12	
	Austenitic steel	320S18	> 400 < 950			6 - 12	6 - 12	
	High temperature steel	301S81	> 850 < 1550	> 250 < 455	> 25 < 48			
K	Cast iron							
	Grey cast iron	EN-GJL-200	> 150 < 1000	> 100 < 300				
	Cast iron with nodular graphite	Grade 420/12	> 350 < 1000	> 100 < 350		8 - 20	8 - 20	2 - 8
	Malleable cast iron	EN-GJMB-350-10	> 300 < 700	> 100 < 200		15 - 25	15 - 25	1 - 8
	Cast iron with vermicular graphite	EN-GJV-300	> 700 < 1000	> 200 < 300	> 20 < 32	5 - 15	–	
N	Copper							
	Copper non-alloyed	Cu-ETP-2 C 101	> 200 < 400	> 60 < 120		10 - 25	10 - 25	
	Brass (short chipping)	CZ 120	> 350 < 700	> 100 < 200		15 - 35	–	
	Brass (long chipping)	CZ 108	> 150 < 700	> 45 < 200		15 - 35	15 - 35	1 - 8
	Copper-alu-nickel alloyed (short chipping)	CN 102	> 150 < 700	> 45 < 200		10 - 20	10 - 20	
	Copper-alu-nickel alloyed (long chipping)	CA 104	> 500 < 750	> 150 < 220		15 - 25	15 - 25	
	Special copper alloyed ≤ Ampco 20	CA 105	> 550 < 650	> 160 < 190				
	Special copper alloyed ≥ Ampco 21	AMPCO 21	> 700 < 1500	> 200 < 440	> 21 < 47			
	Aluminium / Magnesium							
	Alu wrought alloy Si ≤ 0,5%	1B	> 100 < 700	> 30 < 200				
	Alu alloyed Si ≤ 6%	LM22	> 150 < 700	> 45 < 200		15 - 40	15 - 40	1 - 8
	Alu alloyed Si > 6%	LM9	> 150 < 900	> 45 < 265		15 - 40	15 - 40	1 - 8
	Magnesium wrought alloy	MAG 101	> 150 < 500	> 45 < 150				
	Synthetics							
	Thermoplastic (long chipping)	Styreme	> 20 < 80					
	Duroplastic (short chipping)	Touffnell	> 80 < 110					
	Fibre-reinforced plastic	Carbonfibre	> 800 < 1500	> 235 < 440				
	Special materials							
	Cobalt alloyed		> 400 < 2000	> 120 < 590				
	Tungsten alloyed		> 1400 < 1800	> 410 < 530	> 44 < 52			
	TiC-hard material			> 440 < 495	> 47 < 50			
	Graphite		> 38 < 60					
S	Titanium							
	Titanium non-alloyed	TA.2	> 300 < 700	> 90 < 200				
	Titanium alloyed	TA.10	> 450 < 900	> 135 < 265	> 14 < 27			
	Titanium alloyed	TA.10	> 900 < 1250	> 265 < 370	> 27 < 40			
	Nickel							
	Nickel non-alloyed	BS3072: NA11	> 400 < 600	> 120 < 175				
	Nickel alloyed	BS3072: NA13	> 400 < 1200	> 120 < 350	> 12 < 39			
	Nickel alloyed	INCONEL alloy718	> 1200 < 1550	> 350 < 455	> 39 < 48			
H	Steel materials							
	Alloyed steel	En19A	> 1100 < 1400	> 325 < 410	> 34 < 45			
	Alloyed steel	251A58	> 1200 < 1550	> 350 < 455	> 39 < 48			
	Hardened steel	708A30	> 1600 < 2000	> 470 < 590	> 48 < 56			
	Hardened steel	BA2			> 56 < 63			

PRODUCT INDEX


PRODUCT INDEX					
type	series	model	chamfer	thread tol.	page
M – METRIC COARSE THREAD					
through hole	VARIANT LT	TIN	B	4HX	8
through hole	VARIANT LT	TIN	B	6HX	8-9
through hole	VARIANT LT	TIN	B	6GX	8-9
through hole	VARIANT LT	TIN	B	7GX	8-9
through hole	VARIANT LT	TIN	B	6H+0.1	8-9
through hole	VARIANT LT	LH TIN	B	6HX	10
through hole	VARIANT LT	TIN SL	B	6HX	11
blind hole	DOMINANT LT45	TIN	C	4HX	12
blind hole	DOMINANT LT45	TIN	C	6HX	12-13
blind hole	DOMINANT LT45	TIN	C	6GX	12-13
blind hole	DOMINANT LT45	TIN	C	7GX	12-13
blind hole	DOMINANT LT45	TIN	C	6H+0.1	12-13
blind hole	DOMINANT LT45	TIN	E	6HX	14
blind hole	DOMINANT LT45	LH TIN	C	6HX	14
blind hole	DOMINANT LT45	TIN SL	C	6HX	15
MF – METRIC FINE THREAD					
through hole	VARIANT LT	TIN	B	6HX	16-17
through hole	VARIANT LT	LH TIN	B	6HX	16-17
through hole	VARIANT LT	TIN SL	B	6HX	18
blind hole	DOMINANT LT45	TIN	C	6HX	20-21
blind hole	DOMINANT LT45	LH TIN	C	6HX	20-21
blind hole	DOMINANT LT45	TIN SL	C	6HX	22
G – BRITISH STANDARD PIPE THREAD					
through hole	VARIANT LT	TIN	B	–	24
through hole	VARIANT LT	TIN SL	B	–	25
blind hole	DOMINANT LT45	TIN	C	–	26
blind hole	DOMINANT LT45	TIN	E	–	26
blind hole	DOMINANT LT45	TIN SL	C	–	27
UNC – UNIFIED COARSE THREAD					
through hole	VARIANT LT	TIN	B	2BX	28
blind hole	DOMINANT LT45	TIN	C	2BX	29
UNF – UNIFIED FINE THREAD					
through hole	VARIANT LT	TIN	B	2BX	30
blind hole	DOMINANT LT45	TIN	C	2BX	31
EG-M – STI METRIC ISO THREAD					
through hole	VARIANT LT	TIN	B	6HX mod	32
blind hole	DOMINANT LT45	TIN	E	6HX mod	33
NPT – AMERICAN STANDARD TAPER PIPE THREAD					
through and blind hole	DOMINANT LT40	TIN	C	–	34

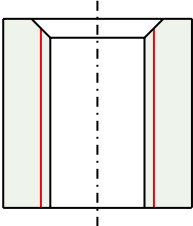
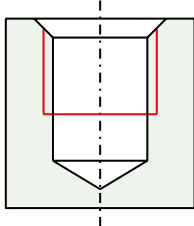
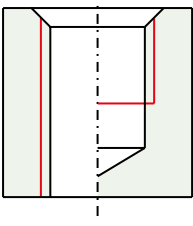
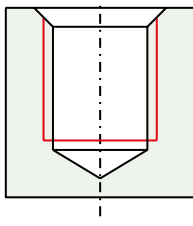
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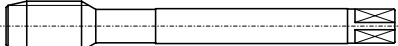
With our **LITELINE** we offer quality taps in a comprehensive range of sizes, tolerances and chamfer forms. In the product index (right page) you find an overview of all cutting taps included, specialties marked bold.

For pricing information, please refer to our latest price list, which is available separately.

CUTTING TAPS			
	VARIANT® <ul style="list-style-type: none"> » straight flutes and spiral point » chamfer form B / 3 - 5.5 threads » for through hole » thread depth up to 3xD » chip evacuation forwards 		DOMINANT® <ul style="list-style-type: none"> » spiral flute 40° - 45° » chamfer form C / 2 - 3 threads » chamfer form E / 1.5 - 2 threads » for blind hole » thread depth up to 3xD » chip evacuation backwards » all dimensions without center points

ABBREVIATIONS		
LH = Left hand 	SL = Tools with long shank	HSSE = High speed steel

TYPES OF BORE HOLES			
	for through holes (chamfer form B)		for blind holes with normal thread chamfer (chamfer form C)
	for through and blind holes with normal thread chamfer (chamfer form C)		for blind holes with short thread chamfer (chamfer form E)

SHANK TYPES			
1	reinforced shank (e.g. DIN 371) 	2	reduced shank (e.g. DIN 376) 

MEET THE TAP

BASS's latest product line is already being used successfully worldwide. The **LITELINE** taps, placed below our catalog program, are the perfect choice for anyone who needs an affordable, **universally applicable** tool but still expects **reliable** machining.

MACROGEOMETRY

Universal and **stable** tool geometry, suitable for almost all materials.

TIN-COATING

The all-rounder coating for a wide range of materials **protects** the tool from abrasive wear.

HSSE-V3

With 3% vanadium in its composition, the tap gains higher heat resistance for a **longer tool life**.

DYNAMIC FLUTE

The **innovative** design of the flutes with variable helix angles ensures that chips are safely removed from the machining area.

MICROGEOMETRY

Optimized cutting edges ensure a **reliable** machining process and prevent axial miscut.



NO MORE BIRDNESTING

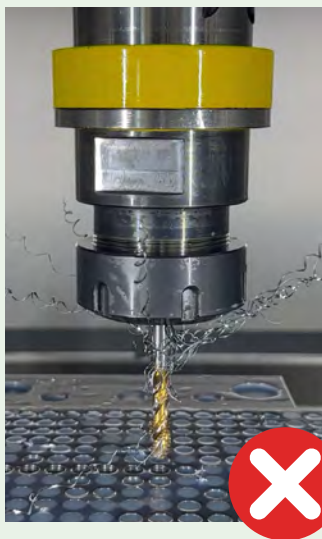
Our **LITELINE** taps offer you the perfect combination of price and performance. Thanks to their proven geometry and innovative **dynamic flute**, they reliably prevent bird nesting and ensure uninterrupted machining.

The variable helix of highly spiralized DOMINANT taps reliably evacuates chips even when machining blind holes in difficult materials. This means there is no need to manually remove the chip wrapping, making the machining reliable and cost-effective.

Competitor A
tool after 6 threads



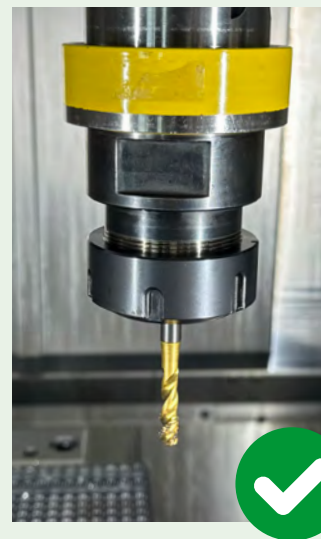
Competitor B
tool after 14 threads



Competitor C
tool after 16 threads

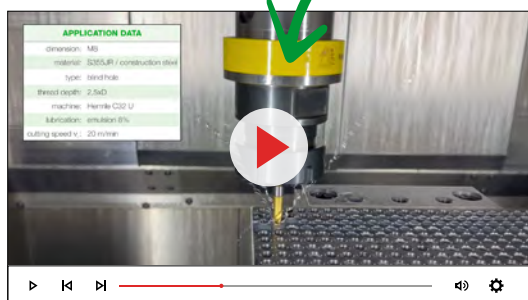


LITELINE
tool after 25 threads



LITELINE IN ACTION

Scan the QR-code and see our **LITELINE** tap in action.



APPLICATION DATA

dimension:	M8
material:	S355JR / construction steel
type:	blind hole
thread depth:	2,5xD
machine:	Hermle C32 U
lubrication:	emulsion 8%
cutting speed v_c :	20 m/min



LITELINE-SET

Our sets for machining blind and through holes offer you the ideal opportunity to test our tools in different applications and experience their versatility.

LITELINE-SET



DOMINANT LT45 TIN

- » cutting tap for blind holes
- » thread depth up to 3xD
- » 45° spiral flute
- » chip evacuation backwards
- » for general application
- » TIN-coating
- » chamfer form C / 2 - 3 threads
- » thread tolerance 6HX
- » HSSE


identification number: 093462



VARIANT LT TIN

- » cutting tap for through holes
- » thread depth up to 3xD
- » straight flutes and spiral point
- » chip evacuation forwards
- » for general application
- » TIN-coating
- » chamfer form B / 3 - 5.5 threads
- » thread tolerance 6HX
- » HSSE

identification number: 093464

dimension	pitch	OAL	shank Ø	square		application
M 3	0.5	56	3.5	2.7	2.5	<div> <div>P</div> <div>M</div> <div>K</div> <div>N</div> </div>
M 4	0.7	63	4.5	3.4	3.3	
M 5	0.8	70	6	4.9	4.2	
M 6	1	80	6	4.9	5	
M 8	1.25	90	8	6.2	6.8	
M 10	1.5	100	10	8	8.5	
M 12	1.75	110	9	7	10.2	

CUTTING TAPS FOR THROUGH HOLE

M

ISO Metric coarse
thread DIN 13



series

model

material

VARIANT
LT
TIN
HSSE

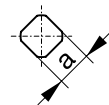
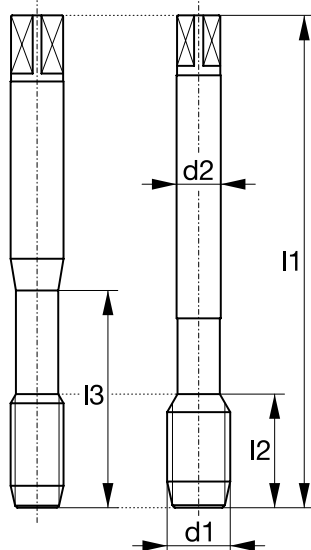
VARIANT
LT
TIN
HSSE

VARIANT
LT
TIN
HSSE

VARIANT
LT
TIN
HSSE

type 1

type 2



(number of flutes)



chamfer

B / 3-5.5

B / 3-5.5

B / 3-5.5

B / 3-5.5

thread tol.

6HX

6GX

7GX

6H+0.1

shank tol.

h9

h9

h9

h9

thread depth

3xD

3xD

3xD

3xD

bore hole



General dimensions

DIN 371 / DIN 376

i For detailed cutting speeds please refer
to the application table on page 2.

P

10 - 30

10 - 30

10 - 30

10 - 30

M

6 - 12

6 - 12

6 - 12

6 - 12

K

5 - 25

5 - 25

5 - 25

5 - 25

N

10 - 40


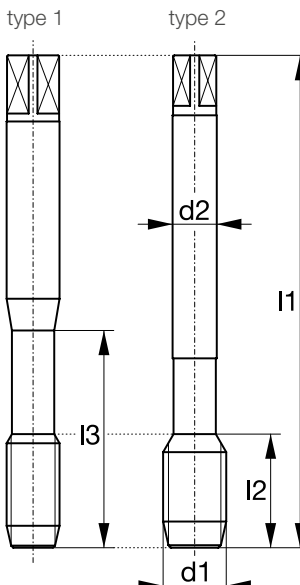

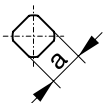








10 - 40

10 - 40

10 - 40

Ød ₁	P	l ₁	l ₂	l ₃	Ød ₂	a	N	type		identification number
M 1	0.25	40	5	-	2.5	2.1	2	1	0.75	780000*
M 1.1	0.25	40	5	-	2.5	2.1	2	1	0.85	780001*
M 1.2	0.25	40	5	-	2.5	2.1	2	1	0.95	780002*
M 1.4	0.3	40	7	-	2.5	2.1	2	1	1.1	780003
M 1.6	0.35	40	8	-	2.5	2.1	2	1	1.25	780004
M 1.7	0.35	40	8	-	2.5	2.1	2	1	1.3	780005
M 1.8	0.35	40	8	-	2.5	2.1	2	1	1.45	780006
M 2	0.4	45	8	-	2.8	2.1	2	1	1.6	780007
M 2.2	0.45	45	9	-	2.8	2.1	2	1	1.75	780008
M 2.3	0.4	45	9	-	2.8	2.1	2	1	1.9	780009
M 2.5	0.45	50	9	-	2.8	2.1	2	1	2.05	780010
M 2.6	0.45	50	9	-	2.8	2.1	2	1	2.1	780011
M 3	0.5	56	11	18	3.5	2.7	3	1	2.5	780012
M 3	0.5	56	11	-	2.2	-	3	2	2.5	780030
M 3.5	0.6	56	12	20	4	3	3	1	2.9	780013
M 4	0.7	63	13	21	4.5	3.4	3	1	3.3	780014
M 4	0.7	63	13	-	2.8	2.1	3	2	3.3	780031
M 4.5	0.75	70	16	25	6	4.9	3	1	3.7	780015
M 5	0.8	70	16	25	6	4.9	3	1	4.2	780016
M 5	0.8	70	16	-	3.5	2.7	3	2	4.2	780032
										780037
										780048
										780421**
										780057**
										780058**
										780059**


CUTTING TAPS FOR THROUGH HOLE

M	ISO Metric coarse thread DIN 13		series	VARIANT LT	VARIANT LT	VARIANT LT	VARIANT LT
			model	TIN	TIN	TIN	TIN
			material	HSSE	HSSE	HSSE	HSSE
<div><div><div>type 1</div><div>type 2</div></div></div> <div><div>(number of flutes)</div></div>							
			chamfer	B / 3-5.5	B / 3-5.5	B / 3-5.5	B / 3-5.5
			thread tol.	6HX	6GX	7GX	6H+0.1
			shank tol.	h9	h9	h9	h9
			thread depth	3xD	3xD	3xD	3xD
			bore hole				
			P	10 - 30	10 - 30	10 - 30	10 - 30
			M	6 - 12	6 - 12	6 - 12	6 - 12
K	5 - 25	5 - 25	5 - 25	5 - 25			
N	10 - 40	10 - 40	10 - 40	10 - 40			

For detailed cutting speeds please refer to the application table on page 2

General dimensions
DIN 371 / DIN 376

i For detailed cutting speeds please refer to the application table on page 2.

Ød ₁	P	I ₁	I ₂	I ₃	Ød ₂	a	N	type		identification number			
M 6	1	80	19	30	6	4.9	3	1	5	780017	780040	780052	780060**
M 6	1	80	19	-	4.5	3.4	3	2	5	780033			
M 7	1	80	19	30	7	5.5	3	1	6	780018			
M 8	1.25	90	22	35	8	6.2	3	1	6.8	780019	780041	780053	780061**
M 8	1.25	90	22	-	6	4.9	3	2	6.8	780034			
M 10	1.5	100	24	39	10	8	3	1	8.5	780020	780042	780054	780062**
M 10	1.5	100	24	-	7	5.5	3	2	8.5	780035			
M 12	1.75	110	28	-	9	7	3	2	10.2	780021	780043	780055	780063**
M 14	2	110	30	-	11	9	3	2	12	780022	780044		
M 16	2	110	32	-	12	9	3	2	14	780023	780045	780056	780064**
M 18	2.5	125	34	-	14	11	3	2	15.5	780024			
M 20	2.5	140	34	-	16	12	3	2	17.5	780025	780046		
M 22	2.5	140	34	-	18	14.5	3	2	19.5	780026			
M 24	3	160	38	-	18	14.5	3	2	21	780027	780047		
M 27	3	160	38	-	20	16	4	2	24	780028			
M 30	3.5	180	45	-	22	18	4	2	26.5	780029			

CUTTING TAPS FOR THROUGH HOLE

M

ISO Metric coarse
thread DIN 13



series

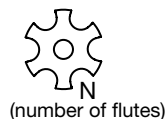
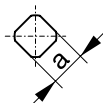
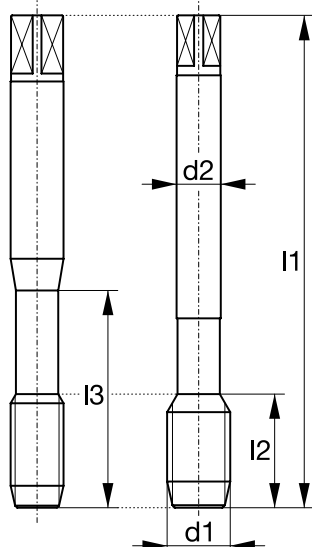
model

material

VARIANT
LT
LH TIN
HSSE

type 1

type 2



chamfer

B / 3-5.5

thread tol.

6HX

shank tol.

h9

thread depth

3xD

bore hole



General dimensions

DIN 371 / DIN 376

P

10 - 30

M

6 - 12

K

5 - 25


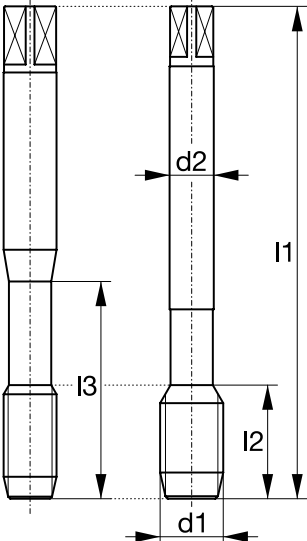
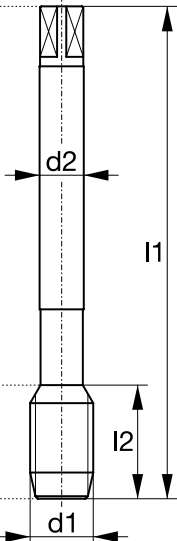
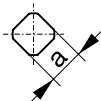



N

10 - 40

i For detailed cutting speeds please refer
to the application table on page 2.

Ød ₁	P	l ₁	l ₂	l ₃	Ød ₂	a	N	type		identification number
M 3	0.5	56	11	18	3.5	2.7	3	1	2.5	780080
M 4	0.7	63	13	21	4.5	3.4	3	1	3.3	780081
M 5	0.8	70	16	25	6	4.9	3	1	4.2	780082
M 6	1	80	19	30	6	4.9	3	1	5	780083
M 8	1.25	90	22	35	8	6.2	3	1	6.8	780084
M 10	1.5	100	24	39	10	8	3	1	8.5	780085
M 12	1.75	110	28	-	9	7	3	2	10.2	780086
M 14	2	110	30	-	11	9	3	2	12	780087
M 16	2	110	32	-	12	9	3	2	14	780088
M 20	2.5	140	34	-	16	12	3	2	17.5	780089
M 24	3	160	38	-	18	14.5	3	2	21	780090


CUTTING TAPS FOR THROUGH HOLE

M	ISO Metric coarse thread DIN 13		series	VARIANT LT			
			model	TIN SL			
			material	HSSE			
<div><div><div><div><div>type 1</div></div><div><div>type 2</div></div></div><div>  (number of flutes)</div></div></div>							
chamfer				B / 3-5.5			
thread tol.				6HX			
shank tol.				h9			
thread depth				3xD			
bore hole							
General dimensions ~ DIN 371/ ~ DIN 376							
P				10 - 30			
M				6 - 12			
K				5 - 25			
N				10 - 40			

i

For detailed cutting speeds please refer to the application table on page 2

i For detailed cutting speeds please refer to the application table on page 2.

Ød ₁	P	l ₁	l ₂	l ₃	Ød ₂	a	N	type		identification number
M 3	0.5	100	11	20	3.5	2.7	3	1	2.5	780065
M 4	0.7	125	13	27	4.5	3.4	3	1	3.3	780066
M 4	0.7	125	13	-	2.8	2.1	3	2	3.3	780075
M 5	0.8	160	16	33	6	4.9	3	1	4.2	780067
M 5	0.8	160	16	-	3.5	2.7	3	2	4.2	780076
M 6	1	160	19	40	6	4.9	3	1	5	780068
M 6	1	160	19	-	4.5	3.4	3	2	5	780077
M 8	1.25	180	22	52	8	6.2	3	1	6.8	780069
M 8	1.25	180	22	-	6	4.9	3	2	6.8	780078
M 10	1.5	200	24	65	10	8	3	1	8.5	780070
M 10	1.5	200	24	-	7	5.5	3	2	8.5	780079
M 12	1.75	200	28	-	9	7	3	2	10.2	780071
M 14	2	200	30	-	11	9	3	2	12	780072
M 16	2	200	32	-	12	9	3	2	14	780073
M 20	2.5	200	34	-	16	12	3	2	17.5	780074

CUTTING TAPS FOR BLIND HOLE

M

ISO Metric coarse thread DIN 13



series

model

material

**DOMINANT
LT45
TIN
HSSE**

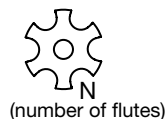
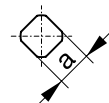
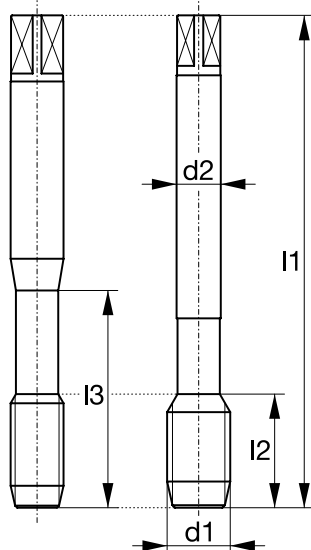
**DOMINANT
LT45
TIN
HSSE**

**DOMINANT
LT45
TIN
HSSE**

**DOMINANT
LT45
TIN
HSSE**

type 1

type 2



(number of flutes)



chamfer

C / 2-3

C / 2-3

C / 2-3

C / 2-3

thread tol.

6HX

6GX

7GX

6H+0.1

shank tol.

h9

h9

h9

h9

thread depth

3xD

3xD

3xD

3xD

bore hole



General dimensions

DIN 371 / DIN 376

P

10 - 30

10 - 30

10 - 30

10 - 30

M

6 - 12

6 - 12

6 - 12

6 - 12

K

8 - 25

8 - 25

8 - 25

8 - 25

N

10 - 40

10 - 40

10 - 40

10 - 40

i For detailed cutting speeds please refer to the application table on page 2.

Ød ₁	P	l ₁	l ₂	l ₃	Ød ₂	a	N	type		identification number
M 1	0.25	40	5	-	2.5	2.1	2	1	0.75	780091*
M 1.1	0.25	40	5	-	2.5	2.1	2	1	0.85	780092*
M 1.2	0.25	40	5	-	2.5	2.1	2	1	0.95	780093*
M 1.4	0.3	40	6	-	2.5	2.1	2	1	1.1	780094
M 1.6	0.35	40	7	-	2.5	2.1	2	1	1.25	780095
M 1.7	0.35	40	8	-	2.5	2.1	2	1	1.3	780096
M 1.8	0.35	40	8	-	2.5	2.1	2	1	1.45	780097
M 2	0.4	45	3.2	10	2.8	2.1	2	1	1.6	780098
M 2.2	0.45	45	3.6	11	2.8	2.1	2	1	1.75	780099
M 2.3	0.4	45	3.6	12	2.8	2.1	2	1	1.9	780100
M 2.5	0.45	50	3.6	13	2.8	2.1	2	1	2.05	780101
M 2.6	0.45	50	3.6	13	2.8	2.1	2	1	2.1	780102
M 3	0.5	56	4	18	3.5	2.7	3	1	2.5	780103
M 3	0.5	56	4	-	2.2	-	3	2	2.5	780121
M 3.5	0.6	56	4.8	20	4	3	3	1	2.9	780104
M 4	0.7	63	5.6	21	4.5	3.4	3	1	3.3	780105
M 4	0.7	63	5.6	-	2.8	2.1	3	2	3.3	780122
M 4.5	0.75	70	6	25	6	4.9	3	1	3.7	780106
M 5	0.8	70	6.4	25	6	4.9	3	1	4.2	780107
M 5	0.8	70	6.4	-	3.5	2.7	3	2	4.2	780123

CUTTING TAPS FOR BLIND HOLE

M

ISO Metric coarse
thread DIN 13



series

model

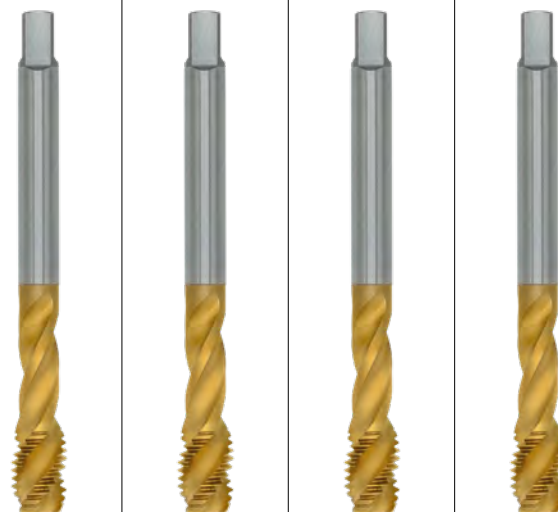
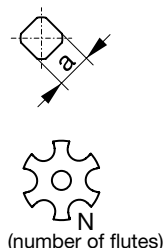
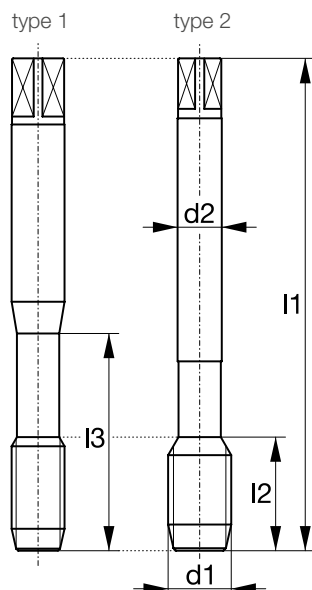
material

**DOMINANT
LT45
TIN
HSSE**

**DOMINANT
LT45
TIN
HSSE**

**DOMINANT
LT45
TIN
HSSE**

**DOMINANT
LT45
TIN
HSSE**



General dimensions
DIN 371 / DIN 376

chamfer	C / 2-3	C / 2-3	C / 2-3	C / 2-3
thread tol.	6HX	6GX	7GX	6H+0.1
shank tol.	h9	h9	h9	h9
thread depth	3xD	3xD	3xD	3xD
bore hole				
P	10 - 30	10 - 30	10 - 30	10 - 30
M	6 - 12	6 - 12	6 - 12	6 - 12
K	8 - 25	8 - 25	8 - 25	8 - 25
N	10 - 40	10 - 40	10 - 40	10 - 40

i For detailed cutting speeds please refer
to the application table on page 2.

Ød ₁	P	l ₁	l ₂	l ₃	Ød ₂	a	N	type		identification number			
M 6	1	80	8	30	6	4.9	3	1	5	780108	780143	780155	780163**
M 6	1	80	8	-	4.5	3.4	3	2	5	780124			
M 7	1	80	8	30	7	5.5	3	1	6	780109			
M 8	1.25	90	10	35	8	6.2	3	1	6.8	780110	780144	780156	780164**
M 8	1.25	90	10	-	6	4.9	3	2	6.8	780125			
M 10	1.5	100	12	39	10	8	3	1	8.5	780111	780145	780157	780165**
M 10	1.5	100	12	-	7	5.5	3	2	8.5	780126			
M 12	1.75	110	14	-	9	7	3	2	10.2	780112	780146	780158	780166**
M 14	2	110	16	-	11	9	3	2	12	780113	780147		
M 16	2	110	16	-	12	9	3	2	14	780114	780148	780159	780167**
M 18	2.5	125	25	-	14	11	4	2	15.5	780115			
M 20	2.5	140	25	-	16	12	4	2	17.5	780116	780149		
M 22	2.5	140	25	-	18	14.5	4	2	19.5	780117			
M 24	3	160	30	-	18	14.5	4	2	21	780118	780150		
M 27	3	160	36	-	20	16	4	2	24	780119			
M 30	3.5	180	42	-	22	18	4	2	26.5	780120			

CUTTING TAPS FOR BLIND HOLE

M

ISO Metric coarse
thread DIN 13



series

model

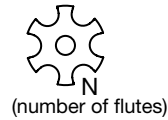
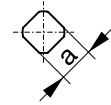
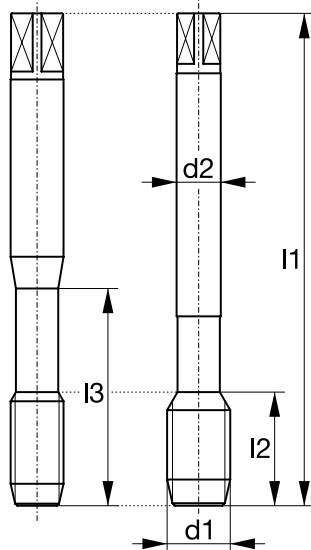
material

**DOMINANT
LT45
TIN
HSSE**

**DOMINANT
LT45
LH TIN
HSSE**

type 1

type 2



General dimensions
DIN 371 / DIN 376



chamfer

E / 1.5-2

C / 2-3

thread tol.

6HX

6HX

shank tol.

h9

h9

thread depth

3xD

3xD

bore hole



P

10 - 30

10 - 30

M

6 - 12

6 - 12

K

8 - 25

8 - 25

N


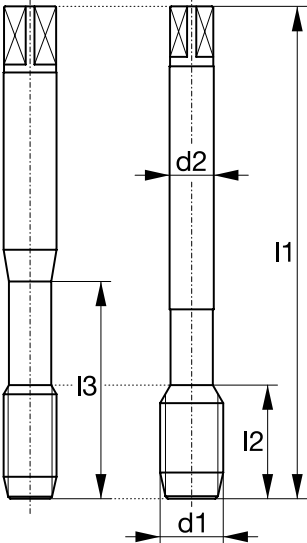
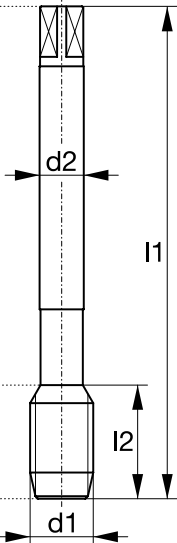
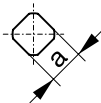



10 - 40

10 - 40

i For detailed cutting speeds please refer
to the application table on page 2.

Ød ₁	P	l ₁	l ₂	l ₃	Ød ₂	a	N	type		identification number	
M 2	0.4	45	3.2	10	2.8	2.1	2	1	1.6	780127	
M 3	0.5	56	4	18	3.5	2.7	3	1	2.5	780128	780183
M 4	0.7	63	5.6	21	4.5	3.4	3	1	3.3	780129	780184
M 5	0.8	70	6.4	25	6	4.9	3	1	4.2	780130	780185
M 6	1	80	8	30	6	4.9	3	1	5	780131	780186
M 8	1.25	90	10	35	8	6.2	3	1	6.8	780132	780187
M 10	1.5	100	12	39	10	8	3	1	8.5	780133	780188
M 12	1.75	110	14	-	9	7	3	2	10.2	780134	780189
M 14	2	110	16	-	11	9	3	2	12	780135	780190
M 16	2	110	16	-	12	9	3	2	14	780136	780191
M 20	2.5	140	25	-	16	12	4	2	17.5	780137	780192
M 24	3	160	30	-	18	14.5	4	2	21	780138	780193


CUTTING TAPS FOR BLIND HOLE

<div>M</div>	ISO Metric coarse thread DIN 13		series	DOMINANT			
			model	LT45			
			material	TIN SL HSSE			
<div><div><div><div>type 1</div></div><div><div>type 2</div></div></div><div>  (number of flutes)</div></div>							
chamfer		C / 2-3					
thread tol.		6HX					
shank tol.		h9					
thread depth		3xD					
bore hole							
		P	10 - 30				
		M	6 - 12				
		K	8 - 25				
		N	10 - 40				

i

For detailed cutting speeds please refer to the application table on page 2

i For detailed cutting speeds please refer to the application table on page 2.

Ød ₁	P	l ₁	l ₂	l ₃	Ød ₂	a	N	type		identification number
M 3	0.5	100	4	18	3.5	2.7	3	1	2.5	780168
M 4	0.7	125	5.6	21	4.5	3.4	3	1	3.3	780169
M 4	0.7	125	5.6	-	2.8	2.1	3	2	3.3	780178
M 5	0.8	160	6.4	25	6	4.9	3	1	4.2	780170
M 5	0.8	160	6.4	-	3.5	2.7	3	2	4.2	780179
M 6	1	160	8	30	6	4.9	3	1	5	780171
M 6	1	160	8	-	4.5	3.4	3	2	5	780180
M 8	1.25	180	10	35	8	6.2	3	1	6.8	780172
M 8	1.25	180	10	-	6	4.9	3	2	6.8	780181
M 10	1.5	200	12	39	10	8	3	1	8.5	780173
M 10	1.5	200	12	-	7	5.5	3	2	8.5	780182
M 12	1.75	200	14	-	9	7	3	2	10.2	780174
M 14	2	200	16	-	11	9	3	2	12	780175
M 16	2	200	16	-	12	9	3	2	14	780176
M 20	2.5	200	25	-	16	12	4	2	17.5	780177

CUTTING TAPS FOR THROUGH HOLE

MF

ISO Metric fine
thread DIN 13



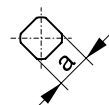
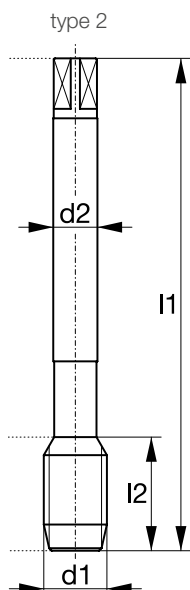
series

model

material

VARIANT
LT
TIN
HSSE

VARIANT
LT
LH TIN
HSSE



(number of flutes)



General dimensions
DIN 374

chamfer

B / 3-5.5

B / 3-5.5

thread tol.

6HX

6HX

shank tol.

h9

h9

thread depth

3xD

3xD

bore hole



P

10 - 30

10 - 30

M

6 - 12

6 - 12

K

5 - 25

5 - 25

N

10 - 40

10 - 40

i For detailed cutting speeds please refer
to the application table on page 2.

Ød ₁	P	l ₁	l ₂	l ₃	Ød ₂	a	N	type		identification number
MF 2.5	0.35	50	9	-	1.8	-	2	2	2.15	780194
MF 2.6	0.35	50	9	-	1.8	-	2	2	2.25	780195
MF 3	0.35	56	8	-	2.2	-	3	2	2.65	780196
MF 3.5	0.35	56	9	-	2.5	2.1	3	2	3.15	780197
MF 4	0.35	63	10	-	2.8	2.1	3	2	3.65	780198
MF 4	0.5	63	10	-	2.8	2.1	3	2	3.5	780199
MF 4.5	0.5	70	12	-	3.5	2.7	3	2	4	780200
MF 5	0.5	70	16	-	3.5	2.7	3	2	4.5	780201
MF 6	0.5	80	14	-	4.5	3.4	3	2	5.5	780202
MF 6	0.75	80	14	-	4.5	3.4	3	2	5.2	780203
MF 6.5	0.75	80	14	-	5.5	4.3	3	2	5.75	780204
MF 7	0.5	80	14	-	5.5	4.3	3	2	6.5	780205
MF 8	0.75	80	22	-	6	4.9	3	2	7.2	780206
MF 8	1	90	22	-	6	4.9	3	2	7	780207
MF 9	1	90	22	-	7	5.5	3	2	8	780208
MF 10	0.75	90	20	-	7	5.5	3	2	9.2	780209
MF 10	1	90	20	-	7	5.5	3	2	9	780210
MF 10	1.25	100	24	-	7	5.5	3	2	8.8	780211
MF 11	1	90	20	-	8	6.2	3	2	10	780212

780235

780236

780237

CUTTING TAPS FOR THROUGH HOLE

MF

ISO Metric fine
thread DIN 13



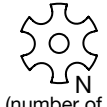
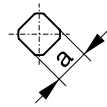
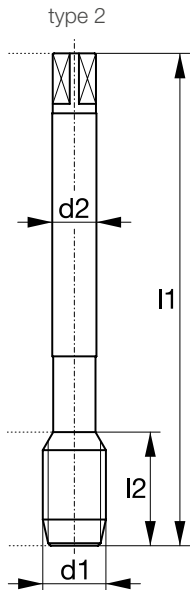
series

model

material

VARIANT
LT
TIN
HSSE

VARIANT
LT
LH TIN
HSSE



(number of flutes)



General dimensions
DIN 374

chamfer

B / 3-5.5

B / 3-5.5

thread tol.

6HX

6HX

shank tol.

h9

h9

thread depth

3xD

3xD

bore hole



P

10 - 30

10 - 30

M

6 - 12

6 - 12

K

5 - 25

5 - 25

N

10 - 40

10 - 40

i For detailed cutting speeds please refer
to the application table on page 2.

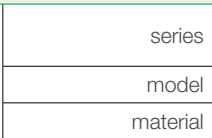
Ød ₁	P	l ₁	l ₂	l ₃	Ød ₂	a	N	type		identification number
MF 12	0.5	100	22	-	9	7	3	2	11.5	780213
MF 12	0.75	100	22	-	9	7	3	2	11.2	780214
MF 12	1	100	22	-	9	7	3	2	11	780215
MF 12	1.25	100	22	-	9	7	3	2	10.8	780216
MF 12	1.5	100	22	-	9	7	3	2	10.5	780217
MF 13	1	100	22	-	11	9	3	2	12	780218
MF 14	1.5	100	22	-	11	9	3	2	12.5	780219
MF 16	1.5	100	22	-	12	9	3	2	14.5	780220
MF 18	1	110	25	-	14	11	3	2	17	780221
MF 18	1.5	110	25	-	14	11	3	2	16.5	780222
MF 20	1.5	125	25	-	16	12	3	2	18.5	780223
MF 22	1.5	125	25	-	18	14.5	3	2	20.5	780224
MF 24	1.5	140	28	-	18	14.5	3	2	22.5	780225
MF 26	1.5	140	28	-	18	14.5	4	2	24.5	780226
MF 30	1.5	150	28	-	22	18	4	2	28.5	780227

CUTTING TAPS FOR THROUGH HOLE

MF

ISO Metric fine thread DIN 13

A technical drawing showing a cross-section of a metric thread. The thread profile is a V-shape with a 60-degree angle, indicated by an arc and the text '60°'. The pitch of the thread is labeled 'P'. The drawing shows the thread on a cylindrical part, with the root of the thread shaded with diagonal lines.



VARIANT LT TIN SL HSSE			
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General dimensions
~ DIN 374

i For detailed cutting speeds please refer to the application table on page 2.

[illegible]

CUTTING TAPS FOR BLIND HOLE

MF

ISO Metric fine
thread DIN 13



series

model

material

**DOMINANT
LT45**

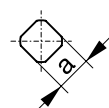
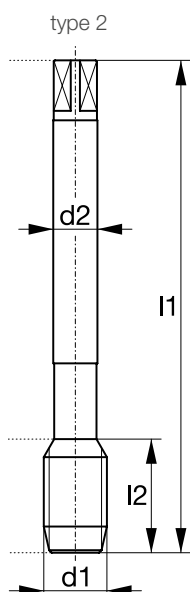
TIN

HSSE

**DOMINANT
LT45**

LH TIN

HSSE



(number of flutes)



**General dimensions
DIN 374**

chamfer

C / 2-3

C / 2-3

thread tol.

6HX

6HX

shank tol.

h9

h9

thread depth

3xD

3xD

bore hole



P

10 - 30

10 - 30

M

6 - 12

6 - 12

K

8 - 25

8 - 25

N

10 - 40

10 - 40

i For detailed cutting speeds please refer
to the application table on page 2.

Ød ₁	P	l ₁	l ₂	l ₃	Ød ₂	a	N	type		identification number
MF 2.5	0.35	50	9	-	1.8	-	2	2	2.15	780243
MF 2.6	0.35	50	9	-	1.8	-	2	2	2.25	780244
MF 3	0.35	56	4	-	2.2	-	3	2	2.65	780245
MF 3.5	0.35	56	4.8	-	2.5	2.1	3	2	3.15	780246
MF 4	0.35	63	5.6	-	2.8	2.1	3	2	3.65	780247
MF 4	0.5	63	5.6	-	2.8	2.1	3	2	3.5	780248
MF 4.5	0.5	70	6	-	3.5	2.7	3	2	4	780249
MF 5	0.5	70	6.4	-	3.5	2.7	3	2	4.5	780250
MF 6	0.5	80	8	-	4.5	3.4	3	2	5.5	780251
MF 6	0.75	80	8	-	4.5	3.4	3	2	5.25	780252
MF 6.5	0.75	80	8	-	5.5	4.3	3	2	5.75	780253
MF 7	0.5	80	8	-	5.5	4.3	3	2	6.5	780254
MF 8	0.75	80	8	-	6	4.9	3	2	7.25	780255
MF 8	1	90	10	-	6	4.9	3	2	7	780256
MF 9	1	90	10	-	7	5.5	3	2	8	780257
MF 10	0.75	90	10	-	7	5.5	3	2	9.25	780258
MF 10	1	90	10	-	7	5.5	3	2	9	780259
MF 10	1.25	100	12	-	7	5.5	3	2	8.75	780260
MF 11	1	90	12	-	8	6.2	3	2	10	780261

780284

780285

780286

CUTTING TAPS FOR BLIND HOLE

MF

ISO Metric fine
thread DIN 13



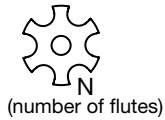
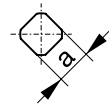
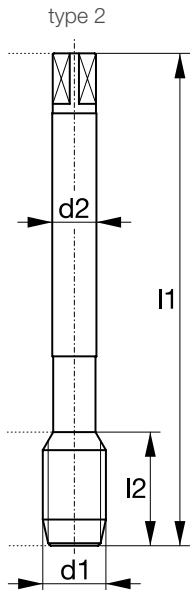
series

model

material

**DOMINANT
LT45
TIN
HSSE**

**DOMINANT
LT45
LH TIN
HSSE**



(number of flutes)



**General dimensions
DIN 374**

chamfer

thread tol.

shank tol.

thread depth

bore hole



P

M

K

N

10 - 30

6 - 12

8 - 25

10 - 40

10 - 30

6 - 12

8 - 25

10 - 40

i For detailed cutting speeds please refer
to the application table on page 2.

Ød ₁	P	l ₁	l ₂	l ₃	Ød ₂	a	N	type		identification number
MF 12	0.5	100	8	-	9	7	3	2	11.5	780262
MF 12	0.75	100	10	-	9	7	3	2	11.25	780263
MF 12	1	100	12	-	9	7	3	2	11	780264
MF 12	1.25	100	12	-	9	7	3	2	10.75	780265
MF 12	1.5	100	14	-	9	7	3	2	10.5	780266
MF 13	1	100	12	-	11	9	3	2	12	780267
MF 14	1.5	100	16	-	11	9	3	2	12.5	780268
MF 16	1.5	100	16	-	12	9	3	2	14.5	780269
MF 18	1	110	16	-	14	11	4	2	17	780270
MF 18	1.5	110	16	-	14	11	4	2	16.5	780271
MF 20	1.5	125	16	-	16	12	4	2	18.5	780272
MF 22	1.5	125	16	-	18	14.5	4	2	20.5	780273
MF 24	1.5	140	16	-	18	14.5	4	2	22.5	780274
MF 26	1.5	140	24	-	18	14.5	4	2	24.5	780275
MF 30	1.5	150	36	-	22	18	4	2	28.5	780276

CUTTING TAPS FOR BLIND HOLE

MF

ISO Metric fine
thread DIN 13



series

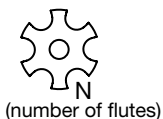
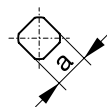
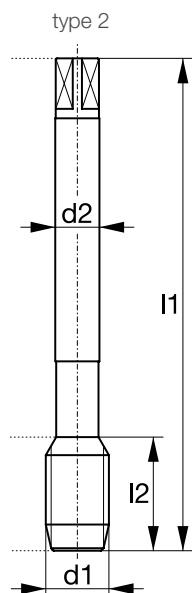
model

material

**DOMINANT
LT45**

TIN SL

HSSE



(number of flutes)



chamfer

C / 2-3

thread tol.

6HX

shank tol.

h9

thread depth

3xD

bore hole



General dimensions

~ DIN 374

P

10 - 30

M

6 - 12

K

8 - 25

N

10 - 40

i For detailed cutting speeds please refer
to the application table on page 2.

Ød ₁	P	l ₁	l ₂	l ₃	Ød ₂	a	N	type		identification number
MF 8	1	180	10	-	6	4.9	3	2	7	780277
MF 10	1	180	10	-	7	5.5	3	2	9	780278
MF 10	1.25	200	12	-	7	5.5	3	2	8.75	780279
MF 12	1.25	200	12	-	9	7	3	2	10.75	780280
MF 12	1.5	200	14	-	9	7	3	2	10.5	780281
MF 14	1.5	200	16	-	11	9	3	2	12.5	780424
MF 16	1.5	200	16	-	12	9	3	2	14.5	780282
MF 20	1.5	250	16	-	16	12	4	2	18.5	780283

CUTTING TAPS FOR THROUGH HOLE

G

British standard
pipe thread
DIN EN ISO 228

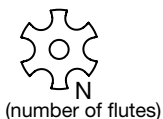
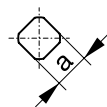
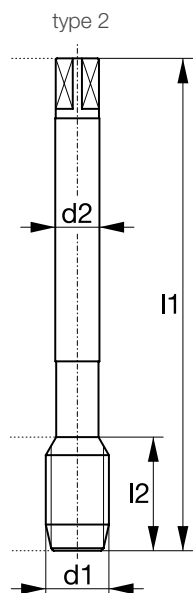


series

model

material

VARIANT
LT
TIN
HSSE



General dimensions
DIN 5156

chamfer

B / 3-5.5

thread tol.

–

shank tol.

h9

thread depth

3xD

bore hole



P

10 - 30

M

6 - 12

K

5 - 25

N

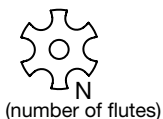
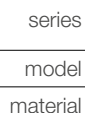
10 - 40

i For detailed cutting speeds please refer
to the application table on page 2.

Ød ₁	P	l ₁	l ₂	l ₃	Ød ₂	a	N	type		identification number
G 1/16"	28	90	20	-	6	4.9	3	2	6.8	780314
G 1/8"	28	90	20	-	7	5.5	3	2	8.8	780315
G 1/4"	19	100	22	-	11	9	3	2	11.8	780316
G 3/8"	19	100	22	-	12	9	3	2	15.25	780317
G 1/2"	14	125	25	-	16	12	3	2	19	780318
G 5/8"	14	125	25	-	18	14.5	3	2	21	780319
G 3/4"	14	140	28	-	20	16	4	2	24.5	780320
G 1"	11	160	30	-	25	20	4	2	30.75	780321

CUTTING TAPS FOR THROUGH HOLE

British standard
pipe thread
DIN EN ISO 228




chamfer
thread tol.
shank tol.
lead depth
bore hole



P
M
K
N

10-30
6-12
5-25
10-40

Ød ₁		P	l ₁	l ₂	l ₃	Ød ₂	a	N	type		identification number
G	1/8"	28	180	20	-	7	5.5	3	2	8.8	780322
G	1/4"	19	200	22	-	11	9	3	2	11.8	780323
G	3/8"	19	200	22	-	12	9	3	2	15.25	780324
G	1/2"	14	250	25	-	16	12	3	2	19	780325
G	3/4"	14	280	28	-	20	16	4	2	24.5	780326
G	1"	11	280	30	-	25	20	4	2	30.75	780327

CUTTING TAPS FOR BLIND HOLE

G

British standard
pipe thread
DIN EN ISO 228



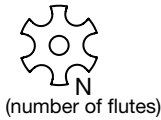
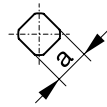
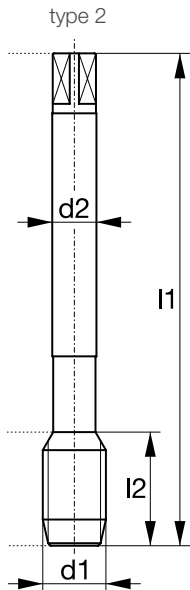
series

model

material

**DOMINANT
LT45
TIN
HSSE**

**DOMINANT
LT45
TIN
HSSE**



chamfer

C / 2-3

E / 1.5-2

thread tol.

h9

h9

thread depth

3xD

3xD

bore hole



General dimensions
DIN 5156

P

10 - 30

10 - 30

M

6 - 12

6 - 12

K

8 - 25

8 - 25

N

10 - 40

10 - 40

i For detailed cutting speeds please refer
to the application table on page 2.

Ød ₁	P	l ₁	l ₂	l ₃	Ød ₂	a	N	type		identification number	
G 1/16"	28	90	9.1	-	6	4.9	3	2	6.8	780328	
G 1/8"	28	90	9.1	-	7	5.5	3	2	8.8	780329	780342
G 1/4"	19	100	13.4	-	11	9	3	2	11.8	780330	780343
G 3/8"	19	100	13.4	-	12	9	4	2	15.25	780331	780344
G 1/2"	14	125	18.2	-	16	12	4	2	19	780332	780345
G 5/8"	14	125	18.2	-	18	14.5	4	2	21	780333	
G 3/4"	14	140	28	-	20	16	4	2	24.5	780334	780346
G 1"	11	160	30	-	25	20	4	2	30.75	780335	780347

CUTTING TAPS FOR BLIND HOLE

G

British standard
pipe thread
DIN EN ISO 228

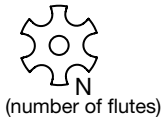
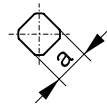
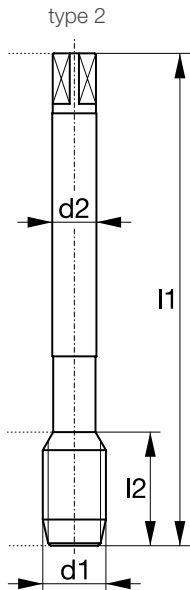


series

model

material

DOMINANT
LT45
TIN SL
HSSE



chamfer

C / 2-3

thread tol.

h9

thread depth

3xD

bore hole



General dimensions
~ DIN 5156

i For detailed cutting speeds please refer
to the application table on page 2.

P

10 - 30

M

6 - 12

K

8 - 25

N

10 - 40

Ød₁

P

l₁

l₂

l₃

Ød₂

a

N

type



identification number

G	1/8"	28	180	9.1	-	7	5.5	3	2	8.8
G	1/4"	19	200	13.4	-	11	9	3	2	11.8
G	3/8"	19	200	13.4	-	12	9	4	2	15.25
G	1/2"	14	250	18.2	-	16	12	4	2	19
G	3/4"	14	280	28	-	20	16	4	2	24.5
G	1"	11	280	30	-	25	20	4	2	30.75

780336
780337
780338
780339
780340
780341

CUTTING TAPS FOR THROUGH HOLE

UNC

Unified coarse
thread ASME B1.1



series

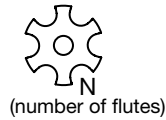
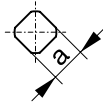
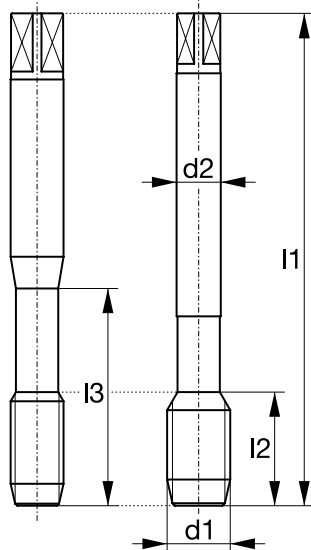
model

material

VARIANT
LT
TIN
HSSE

type 1

type 2



(number of flutes)



General dimensions
DIN 2184-1

chamfer

B / 3-5.5

thread tol.

2BX

shank tol.

h9

thread depth

3xD

bore hole



P

10 - 30

M

6 - 12

K

5 - 25

N

10 - 40

i For detailed cutting speeds please refer
to the application table on page 2.

Ød ₁	P	l ₁	l ₂	l ₃	Ød ₂	a	N	type		identification number
UNC No2 -	56	45	9	-	2.8	2.1	2	1	1.85	780348
UNC No4 -	40	56	11	18	3.5	2.7	2	1	2.35	780349
UNC No5 -	40	56	11	18	3.5	2.7	3	1	2.65	780350
UNC No6 -	32	56	12	20	4	3	3	1	2.85	780351
UNC No8 -	32	63	13	21	4.5	3.4	3	1	3.5	780352
UNC No10 -	24	70	16	25	6	4.9	3	1	3.9	780353
UNC No12 -	24	80	17	30	6	4.9	3	1	4.5	780354
UNC 1/4" -	20	80	19	30	7	5.5	3	1	5.1	780355
UNC 5/16" -	18	90	22	35	8	6.2	3	1	6.6	780356
UNC 3/8" -	16	100	24	39	10	8	3	1	8	780357
UNC 1/2" -	13	110	28	-	9	7	3	2	10.8	780358
UNC 5/8" -	11	110	32	-	12	9	3	2	13.5	780359
UNC 3/4" -	10	125	34	-	14	11	3	2	16.5	780360
UNC 7/8" -	9	140	34	-	18	14.5	3	2	19.5	780361
UNC 1" -	8	160	38	-	18	14.5	3	2	22.25	780362

CUTTING TAPS FOR BLIND HOLE

UNC

Unified coarse
thread ASME B1.1



series

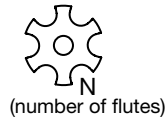
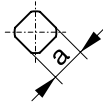
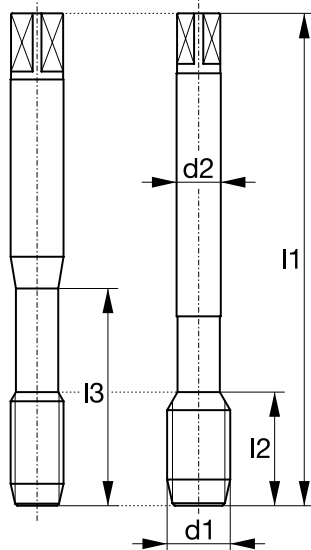
model

material

DOMINANT
LT45
TIN
HSSE

type 1

type 2



(number of flutes)



General dimensions
DIN 2184-1

chamfer

C / 2-3

thread tol.

2BX

shank tol.

h9

thread depth

3xD

bore hole



P

10 - 30

M

6 - 12

K

8 - 25

N

10 - 40

i For detailed cutting speeds please refer
to the application table on page 2.

Ød ₁	P	l ₁	l ₂	l ₃	Ød ₂	a	N	type		identification number
UNC No2 - 56	45	3.6	11	2.8	2.1	2	1	1.85		780363
UNC No3 - 48	50	3.6	13	2.8	2.1	2	1	2.1		780364
UNC No4 - 40	56	5.1	18	3.5	2.7	2	1	2.35		780365
UNC No5 - 40	56	5.1	18	3.5	2.7	2	1	2.65		780366
UNC No6 - 32	56	6.4	20	4	3	2	1	2.85		780367
UNC No8 - 32	63	6.4	21	4.5	3.4	2	1	3.5		780368
UNC No10 - 24	70	8.5	25	6	4.9	2	1	3.9		780369
UNC No12 - 24	80	8.5	30	6	4.9	2	1	4.5		780370
UNC 1/4" - 20	80	10.2	30	7	5.5	2	1	5.1		780371
UNC 5/16" - 18	90	11.3	35	8	6.2	3	1	6.6		780372
UNC 3/8" - 16	100	12.7	39	10	8	3	1	8		780373
UNC 1/2" - 13	110	15.6	-	9	7	3	2	10.8		780374
UNC 5/8" - 11	110	18.5	-	12	9	3	2	13.5		780375
UNC 3/4" - 10	125	25.4	-	14	11	4	2	16.5		780376
UNC 7/8" - 9	140	28.2	-	18	14.5	4	2	19.5		780377
UNC 1" - 8	160	31.8	-	18	14.5	4	2	22.25		780378

CUTTING TAPS FOR THROUGH HOLE

UNF

Unified fine thread
ASME B1.1



series

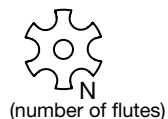
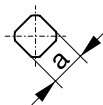
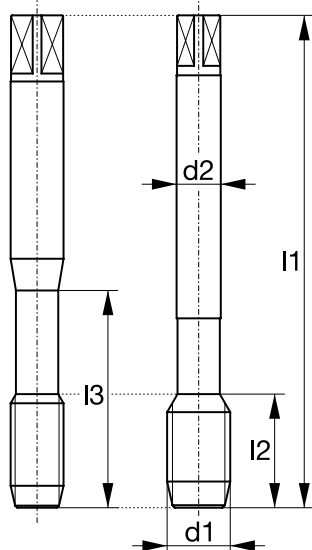
model

material

VARIANT
LT
TIN
HSSE

type 1

type 2



(number of flutes)



General dimensions
DIN 2184-1

chamfer

B / 3-5.5

thread tol.

2BX

shank tol.

h9

thread depth

3xD

bore hole



P

10 - 30

M

6 - 12

K

5 - 25

N

10 - 40

i For detailed cutting speeds please refer to the application table on page 2.

Ød ₁	P	l ₁	l ₂	l ₃	Ød ₂	a	N	type		identification number
UNF No2 -	64	45	9	-	2.8	2.1	2	1	1.85	780379
UNF No3 -	56	50	9	-	2.8	2.1	2	1	2.15	780380
UNF No4 -	48	56	11	18	3.5	2.7	2	1	2.4	780381
UNF No5 -	44	56	11	18	3.5	2.7	3	1	2.7	780382
UNF No6 -	40	56	12	20	4	3	3	1	2.95	780383
UNF No8 -	36	63	13	21	4.5	3.4	3	1	3.5	780384
UNF No10 -	32	70	16	25	6	4.9	3	1	4.1	780385
UNF 1/4" -	28	80	19	30	7	5.5	3	1	5.5	780386
UNF 5/16" -	24	90	22	35	8	6.2	3	1	6.9	780387
UNF 3/8" -	24	90	20	35	10	8	3	1	8.5	780388
UNF 7/16" -	20	100	24	-	8	6.2	3	2	9.9	780389
UNF 1/2" -	20	100	22	-	9	7	3	2	11.5	780390
UNF 9/16" -	18	100	22	-	11	9	3	2	12.9	780391
UNF 5/8" -	18	100	22	-	12	9	3	2	14.5	780392
UNF 3/4" -	16	110	25	-	14	11	3	2	17.5	780393
UNF 7/8" -	14	125	25	-	18	14.5	3	2	20.4	780394
UNF 1" -	12	140	28	-	18	14.5	3	2	23.25	780395

CUTTING TAPS FOR BLIND HOLE

UNF

Unified fine thread
ASME B1.1



series

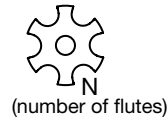
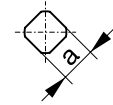
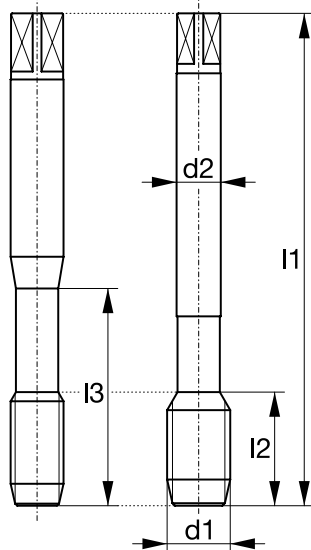
model

material

DOMINANT
LT45
TIN
HSSE

type 1

type 2



General dimensions
DIN 2184-1

chamfer

C / 2-3

thread tol.

2BX

shank tol.

h9

thread depth

3xD

bore hole



P

10 - 30

M

6 - 12

K

8 - 25

N

10 - 40

i For detailed cutting speeds please refer to the application table on page 2.

Ød ₁	P	l ₁	l ₂	l ₃	Ød ₂	a	N	type		identification number
UNF No2 -	64	45	3.6	11	2.8	2.1	2	1	1.85	780396
UNF No3 -	56	50	3.6	13	2.8	2.1	2	1	2.15	780397
UNF No4 -	48	56	5.1	18	3.5	2.7	2	1	2.4	780398
UNF No5 -	44	56	5.1	18	3.5	2.7	2	1	2.7	780399
UNF No6 -	40	56	6.4	20	4	3	2	1	2.95	780400
UNF No8 -	36	63	6.4	21	4.5	3.4	2	1	3.5	780401
UNF No10 -	32	70	8.5	25	6	4.9	2	1	4.1	780402
UNF No12 -	28	80	8.5	30	6	4.9	2	1	4.6	780403
UNF 1/4" -	28	80	10.2	30	7	5.5	2	1	5.5	780404
UNF 5/16" -	24	90	11.3	35	8	6.2	3	1	6.9	780405
UNF 3/8" -	24	90	12.7	35	10	8	3	1	8.5	780406
UNF 7/16" -	20	100	14.5	-	8	6.2	3	2	9.9	780407
UNF 1/2" -	20	100	15.6	-	9	7	3	2	11.5	780408
UNF 9/16" -	18	100	16.9	-	11	9	3	2	12.9	780409
UNF 5/8" -	18	100	18.5	-	12	9	3	2	14.5	780410
UNF 3/4" -	16	110	25.4	-	14	11	4	2	17.5	780411
UNF 7/8" -	14	125	28.2	-	18	14.5	4	2	20.4	780412
UNF 1" -	12	140	31.8	-	18	14.5	4	2	23.25	780413

CUTTING TAPS FOR THROUGH HOLE

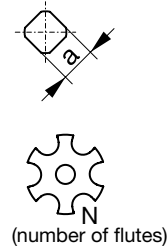
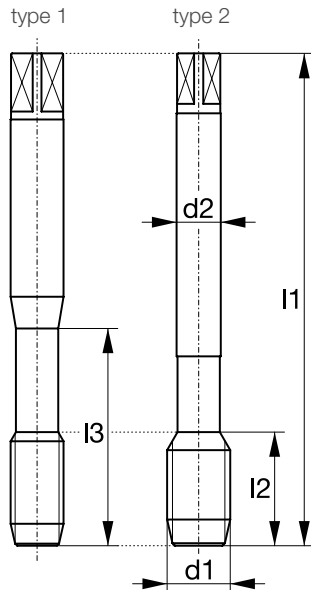
STI
EG-M

STI Metric ISO
thread DIN 8140



series
model
material

VARIANT
LT
TIN
HSSE



General dimensions
DIN 40435

chamfer

B / 3-5.5

thread tol.

6HX mod

shank tol.

h9

thread depth

3xD

bore hole



P

10 - 30

M

6 - 12

K

5 - 25

N

10 - 40

i For detailed cutting speeds please refer to the application table on page 2.

Ød ₁	P	l ₁	l ₂	l ₃	Ød ₂	a	N	type		identification number
EG-M 2	0.4	50	9	-	2.8	2.1	2	1	2.1	780292
EG-M 2.5	0.45	56	11	18	3.5	2.7	3	1	2.65	780293
EG-M 3	0.5	63	13	21	4.5	3.4	3	1	3.15	780294
EG-M 4	0.7	70	16	25	6	4.9	3	1	4.2	780295
EG-M 5	0.8	80	19	30	6	4.9	3	1	5.25	780296
EG-M 6	1	90	22	35	8	6.2	3	1	6.3	780297
EG-M 8	1.25	100	24	39	10	8	3	1	8.4	780298
EG-M 10	1.5	100	29	-	9	7	3	2	10.5	780299
EG-M 12	1.75	110	30	-	11	9	3	2	12.5	780300
EG-M 16	2	125	34	-	14	11	3	2	16.5	780301
EG-M 20	2.5	160	34	-	18	14.5	3	2	20.8	780302

CUTTING TAPS FOR BLIND HOLE

STI
EG-M

STI Metric ISO
thread DIN 8140

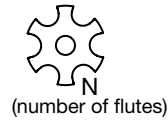
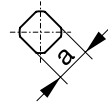
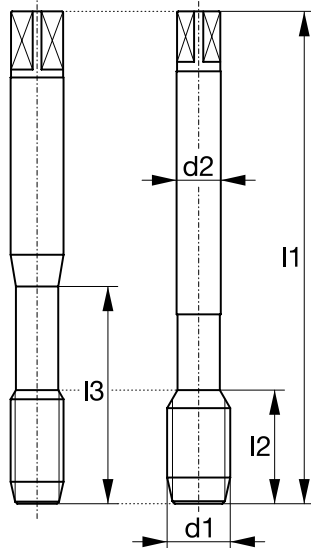


series
model
material

DOMINANT
LT45
TIN
HSSE

type 1

type 2



(number of flutes)



General dimensions
DIN 40435

chamfer

E / 1.5-2

thread tol.

6HX mod

shank tol.

h9

thread depth

3xD

bore hole



P

10 - 30

M

6 - 12

K

8 - 25

N

10 - 40

i For detailed cutting speeds please refer to the application table on page 2.

Ød ₁	P	l ₁	l ₂	l ₃	Ød ₂	a	N	type		identification number
EG-M 2	0.4	50	4.5	13	2.8	2.1	2	1	2.1	780303
EG-M 2.5	0.45	56	5	18	3.5	2.7	3	1	2.65	780304
EG-M 3	0.5	63	5	21	4.5	3.4	3	1	3.15	780305
EG-M 4	0.7	70	7	25	6	4.9	3	1	4.2	780306
EG-M 5	0.8	80	8	30	6	4.9	3	1	5.25	780307
EG-M 6	1	90	10	35	8	6.2	3	1	6.3	780308
EG-M 8	1.25	100	13	39	10	8	3	1	8.4	780309
EG-M 10	1.5	100	15	-	9	7	3	2	10.5	780310
EG-M 12	1.75	110	18	-	11	9	3	2	12.5	780311
EG-M 16	2	125	20	-	14	11	4	2	16.5	780312
EG-M 20	2.5	160	25	-	18	14.5	4	2	20.8	780313

CUTTING TAPS FOR THROUGH AND BLIND HOLE

NPT

American standard
taper pipe thread
ASME B1.20.3
tapered 1:16

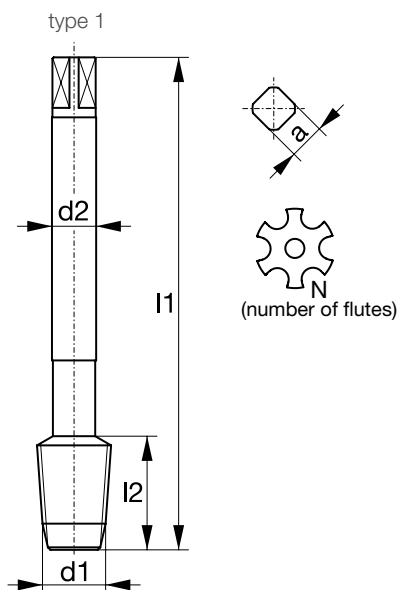


series

model

material

DOMINANT
LT40
TIN
HSSE



chamfer

C / 2-3

thread tol.

—

shank tol.

h9

thread depth

—

bore hole



General dimensions
~ DIN 5156

P

2 - 8

M

—

K

1 - 8

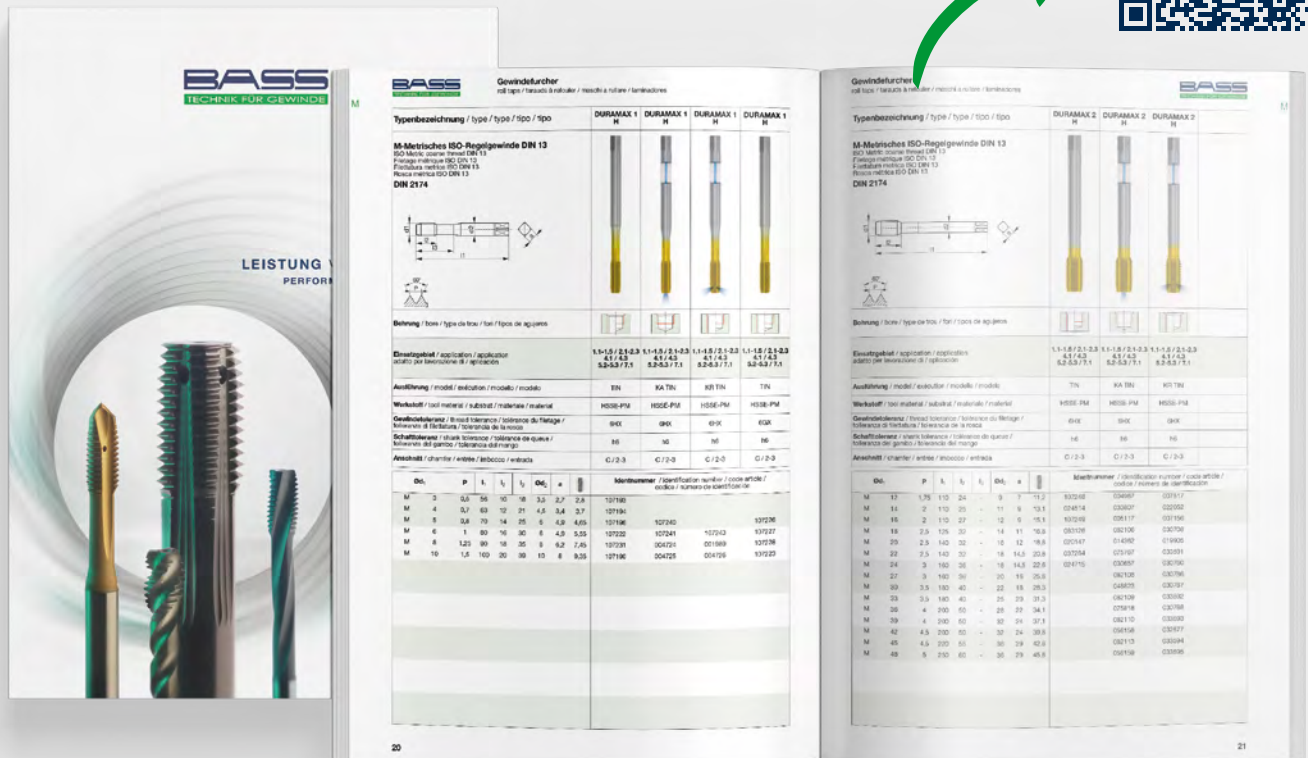
N

1 - 8

i For detailed cutting speeds please refer to the application table on page 2.

Ød ₁	P	l ₁	l ₂	l ₃	Ød ₂	a	N	type		identification number
NPT 1/16"	27	90	18	-	6	4.9	3	2	6.15	780414
NPT 1/8"	27	90	19	-	7	5.5	3	2	8.4	780415
NPT 1/4"	18	100	28	-	11	9	3	2	11.1	780416
NPT 3/8"	18	100	28	-	12	9	4	2	14.3	780417
NPT 1/2"	14	125	35	-	16	12	4	2	17.9	780418
NPT 3/4"	14	140	35	-	20	16	4	2	23.2	780419
NPT 1"	11.5	160	45	-	25	20	4	2	29	780420

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