

Machine taps

Machine taps for ISO metric threads



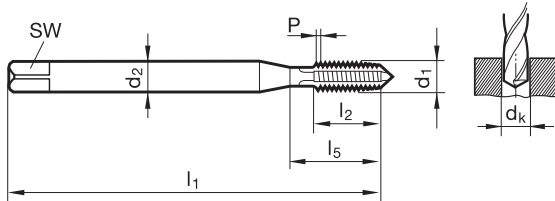
Catalog no. 73033

Produktiv N	DIN 371	B	HSS-E	steam tempered	R	ISO2/6H
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P	M	K	N	S	H
●	○	○	○		

Application
recomm. p. 348

- for through holes
- with spiral point
- chip evacuation in feed direction
- universal application
- steel materials up to 1100 N/mm²



d1	P mm	d2 mm	SW mm	dk mm	l1 mm	l2 mm	l5 mm
M 3	0.500	3.500	2.700	2.50	56.000	10.000	18.000
M 4	0.700	4.500	3.400	3.30	63.000	12.000	21.000
M 5	0.800	6.000	4.900	4.20	70.000	14.000	25.000
M 6	1.000	6.000	4.900	5.00	80.000	16.000	30.000
M 8	1.250	8.000	6.200	6.80	90.000	17.000	35.000
M 10	1.500	10.000	8.000	8.50	100.000	20.000	39.000

Application recommendations for taps



Material examples	for universal applications in materials <1100 MPa, e. g. : structural steels, free-cutting steels case hardened steels, heat-treatable steels nitriding steels spheroidal graphite cast iron					for synchro machining universal applications in materials up to 1200 MPa	
Tool material	HSS-E					HSS-E-PM	HSS-E-PM
Type	Produktiv N		Intensiv N		Intensiv N	Produktiv-Synchro	Intensiv-Synchro
Form	B		C		E	B	C
Surface finish	steam temp.	TiN	steam temp.	TiN	br	TiCN	TiCN
v_c m/min	≤ 15	≤ 20	≤ 15	≤ 20	≤ 15	≤ 20	≤ 20

Thread type	Dimensions to DIN 2184-1	Tolerance zone	Catalog no./Ø-range/Page					
M	DIN 371	ISO 2 6H	73033 M3 - M10 366	63033 M3 - M10 365	73046 M3 - M10 372	63046 M3 - M10 371	73047 M4 - M10 375	53053 M2 - M10 362
		6HX						
	DIN 376	ISO 2 6H	73038 M12 - M24 367	73048 M12 - M24 374		63048 M12 - M20 373		53054 M12 - M20 363
		6HX						
MF	DIN 374	ISO 2 6H	73183 M6x0.75 - M20x1.5 439	73187 M6x0.75 - M20x1.5 440		53055 M8x1 - M16x1.5 437		
		6HX						
UNC	DIN ~ 371	2B	73308 Nr.4-40 - 3/8-16 449	73322 Nr.4-40 - 3/8-16 451				
	DIN ~ 376	2B	73309 1/2-13 - 3/4-10 450	73323 1/2-13 - 3/4-10 452				
UNF	DIN ~ 374	2B	73310 Nr.10-32 - 5/8-18 459	73324 Nr.10-32 - 5/8-18 460				
G	DIN 5156	-	73321 G1/8 - G1 464	73325 G1/8 - G1 465				

Application

by materials

Coloured ring	Catalog no.		Nonferrous metals, Aluminium	Steels	GG, GGG	Stainless and acid resistant steels	Nickel, Titanium alloys	Harded steels
	Produktiv	Intensiv						
Green	73033	73046		■				
	73038	73048		■				
	73183	73187		■				
	73308	73322		■				
	73309	73323		■				
	73310	73324		■				
	73321	73325		■				
	63033	63046		■				
		63048		■				
		73047		■				
Green Synchro	53733	53746	■	■		■	■	
	53778	53780	■	■		■	■	
	53787	53788	■	■		■	■	
	53053	53050		■				
	53054	53051		■				
53055	53052		■					
Yellow	73133	73146		■				
	73132	73145		■				
	73138	73148		■				
	73250	73173		■				
		73227		■				
		73286		■				
	63133	63146		■				
	63138	63148		■				
	63173		■					
Blue	73176	73660				■		
	73177	73659				■		
	73178	73180				■		
	73297	73304				■		
	73298	73305				■		
	73299	73306				■		
	73300	73288				■		
	63176	73662				■		
	63177	73665				■		
	73641	63662				■		
	73643	63665				■		
		73293				■		
	53641	53662				■		
	53643	53665				■		
w/o ring	53667	53666					■	■
	53669	53668					■	■
Red	73642	53661		■				
	73645	73619		■				
	73646	73661		■				
	53642	73664		■				
	73640	73666		■				
	63641	63010		■				
	63643	63674		■				
	53640	63675		■				
53670	53670		■					
Black	73131	73156	■					
	73189	73136	■					
	73011	73011	■					
	53670	53670	■					
White	73201	73201			■			
	73211	73211			■			
	73194	73194			■			
	73326	73326			■			
	73327	73327			■			
	73345	73345			■			
	63201	63201			■			
	53670	53670			■			
for blind and through holes								
Thread forming taps	73121	63122	■			■	■	
	63121	53620	■			■	■	
	63123	53621	■			■	■	
	73120	53622	■			■	■	
	63120	63013	■			■	■	
	63119		■			■	■	
Thread milling cutters	73810	53820	■	■	■	■	■	■
	73820	73830	■	■	■	■	■	■
	53810	53830	■	■	■	■	■	■

■ optimal ■ well suited

by tensile strength

