

## Machine taps

### Machine taps for ISO metric threads



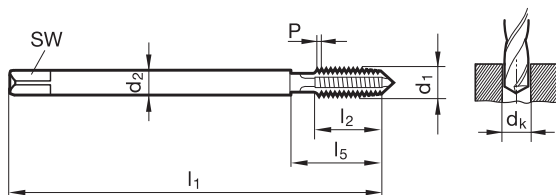
Catalog no. 73038

Produktiv <b>N</b>	DIN <b>376</b>	<b>B</b>	<b>HSS-E</b>	steam tempered	<b>R</b>	ISO2/6H
-----------------------	-------------------	----------	--------------	-------------------	----------	---------

<b>P</b>	<b>M</b>	<b>K</b>	<b>N</b>	<b>S</b>	<b>H</b>
●	○	○	○		

Application  
recomm. p. 348

- for through holes
- with spiral point
- chip evacuation in feed direction
- universal application
- steel materials up to 1100 N/mm<sup>2</sup>



d1	P mm	d2 mm	SW mm	dk mm	l1 mm	l2 mm	l5 mm
<b>M12</b>	1.750	9.000	7.000	10.20	110.000	24.000	49.000
<b>M14</b>	2.000	11.000	9.000	12.00	110.000	26.000	53.000
<b>M16</b>	2.000	12.000	9.000	14.00	110.000	26.000	54.000
<b>M18</b>	2.500	14.000	11.000	15.50	125.000	30.000	62.000
<b>M20</b>	2.500	16.000	12.000	17.50	140.000	32.000	62.000
<b>M22</b>	2.500	18.000	14.500	19.50	140.000	32.000	62.000
<b>M24</b>	3.000	18.000	14.500	21.00	160.000	36.000	73.000

# 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	
	Hole type		Hole type			Hole type	
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		optimal				
	73038	73048		optimal				
	73183	73187		optimal				
	73308	73322		optimal				
	73309	73323		optimal				
	73310	73324		optimal				
	73321	73325		optimal				
	63033	63046		optimal				
		63048		optimal				
		73047		optimal				
Green Synchro	53733	53746	well suited	optimal		optimal	well suited	
	53778	53780	optimal	optimal		optimal		
	53787	53788	optimal	optimal		optimal		
	53053	53050		optimal				
	53054	53051		optimal				
53055	53052		optimal					
Yellow	73133	73146		optimal				
	73132	73145		optimal				
	73138	73148		optimal				
	73250	73173		optimal				
		73227		optimal				
		73286		optimal				
	63133	63146		optimal				
	63138	63148		optimal				
	63173		optimal					
Blue	73176	73660				optimal	well suited	
	73177	73659				optimal	well suited	
	73178	73180				optimal	well suited	
	73297	73304				optimal	well suited	
	73298	73305				optimal	well suited	
	73299	73306				optimal	well suited	
	73300	73288				optimal	well suited	
	63176	73662				optimal	well suited	
	63177	73665				optimal	well suited	
	73641	63662				optimal	well suited	
	73643	63665				optimal	well suited	
		73293				optimal	well suited	
	53641	53662				optimal	well suited	
	53643	53665				optimal	well suited	
w/o ring	53667	53666					well suited	optimal
	53669	53668					well suited	optimal
Red	73642	53661		optimal			well suited	optimal
	73645	73619		optimal			well suited	optimal
	73646	73661		optimal			well suited	optimal
	53642	73664		optimal			well suited	optimal
	73640	73666		optimal			well suited	optimal
	63641	63010		optimal			well suited	optimal
	63643	63674		optimal			well suited	optimal
	53640	63675		optimal			well suited	optimal
53670	53670		optimal			well suited	optimal	
Black	73131	73156	optimal	optimal				
	73189	73136	optimal	optimal				
	73011	73011	optimal	optimal				
	53670	53670	optimal	optimal				
White	73201	73201			optimal			
	73211	73211			optimal			
	73194	73194			optimal			
	73326	73326			optimal			
	73327	73327			optimal			
	73345	73345			optimal			
	63201	63201			optimal			well suited
	53670	53670			optimal			well suited
for blind and through holes								
Thread forming taps	73121	63122	optimal	optimal		optimal	well suited	
	63121	53620	optimal	optimal		optimal	well suited	
	63123	53621	optimal	optimal		optimal	well suited	
	73120	53622	optimal	optimal		optimal	well suited	
	63120	63013	optimal	optimal		optimal	well suited	
	63119		optimal	optimal		optimal	well suited	
Thread milling cutters	73810	53820	optimal	optimal	optimal	optimal	optimal	optimal
	73820	73830	optimal	optimal	optimal	optimal	optimal	optimal
	53810	53830	optimal	optimal	optimal	optimal	optimal	optimal

optimal well suited

by tensile strength

