

## Machine taps

### Machine taps for ISO metric threads



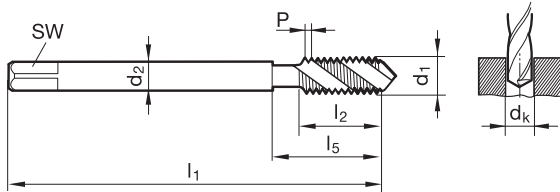
Catalog no. 73048



P	M	K	N	S	H
●	○	○	○		

Application  
recomm. p. 348

- for blind holes
- flutes with appr. 40° right-hand helix
- chip evacuation in shank 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	18.500	49.000
<b>M14</b>	2.000	11.000	9.000	12.00	110.000	20.000	53.000
<b>M16</b>	2.000	12.000	9.000	14.00	110.000	20.000	54.000
<b>M18</b>	2.500	14.000	11.000	15.50	125.000	25.000	62.000
<b>M20</b>	2.500	16.000	12.000	17.50	140.000	25.000	62.000
<b>M22</b>	2.500	18.000	14.500	19.50	140.000	27.000	62.000
<b>M24</b>	3.000	18.000	14.500	21.00	160.000	30.000	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						53050 M5 - M10 368
	DIN 376	ISO 2 6H	73038 M12 - M24 367		73048 M12 - M24 374	63048 M12 - M20 373		53054 M12 - M20 363
		6HX						53051 M12 - M20 369
MF	DIN 374	ISO 2 6H	73183 M6x0.75 - M20x1.5 439		73187 M6x0.75 - M20x1.5 440		53055 M8x1 - M16x1.5 437	
		6HX					53052 M8x1 - M20x1.5 438	
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						
	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

