Gewindebohrer

Taps

ILIX PRECISION

Gewindebohrer
Taps

▶ Zeichenerklärung
Key to symbols

SCHNEIDSTOFF / TOOL MATERIAL

- HSS-Co
- HSS-Co PM
- HSS

BESCHICHTUNG / COATING

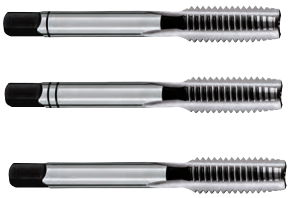
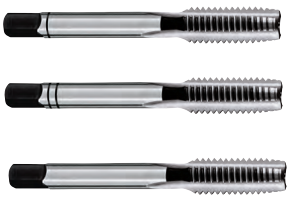
- Unbeschichtet / Blank
- TN — TiN
- TF — TiAlN Futura
- TC — TiCN
- HL — Hard Lube
- XP — XP TOP
- TX — TiNOX

OBERFLÄCHENBEHANDLUNGEN / SURFACE TREATMENT

- VP — Vaporizzato / Vaporized
- Nitrurato / Nitrided

▶ Werkzeug-Auswahlhilfe
Tool selection guide

HAND-GEWINDEBOHRER / HAND TAPS

KAT.-NR. ITEM	SIMBOL SYMBOL	Ø mm	DIN	SACKLOCH / DURCHGANGSLOCH Blind hole/ Through hole	TOLERANZ TOLERANCE	DRALLWINKEL HELIX ANGLE	ANSCHNITT FORM CHAMFER FORM
N							
6615	**M**	1 ÷ 68	**352**		6H	0°	C
6608 Sätze in Metallkassetten / Sets in metal cases with tap drills	**M**	3 ÷ 12	**352**		6H	0°	C
6609 Sätze in Metallkassetten / Sets in metal cases with tap drills	**M**	3 ÷ 12	**352**		6H	0°	C
6618	**M**	3 ÷ 20	**352**		6H	0°	C
6633	**MF**	2 ÷ 52	**2181**		6H	0°	C
6775 	**UNC**	1 ÷ 2	**352***		2B	0°	C
6776	**UNF**	3 ÷ 7/16	**2181***		2B	0°	C
6603 	**BSW/W**	1/16 ÷ 2	**352***		-	0°	C
6627	**BSP/G**	1/16 ÷ 2	**5157**		-	0°	C

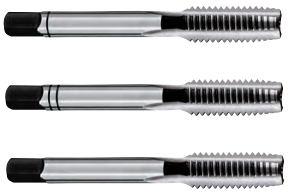
* **Abmessungen ähnlich DIN 352/2181** - Dimension similar to DIN 352/2181

HAND-GEWINDEBOHRER / HAND TAPS

BESCHICHTUNG COATING	KÜHLUNG INTERNAL COOLANT	SCHNEIDRICHTUNG CUTTING DIRECT.	SCHNEIDSTOFF TOOL MATERIAL	P	M	K	N	S	H	Seite Page
-	-		HSS	●	●	●	●	❍	-	504
-	-		HSS	●	●	●	●	❍	-	508
-	-		HSS	●	●	●	●	❍	-	509
-	-		HSS	●	●	●	●	❍	-	504
-	-		HSS	●	●	●	●	❍	-	552
-	-		HSS	●	●	●	●	❍	-	569
-	-		HSS	●	●	●	●	❍	-	581
-	-		HSS	●	●	●	●	❍	-	594
-	-		HSS	●	●	●	●	❍	-	598

HSS-CO

HAND-GEWINDEBOHRER / HAND TAPS

KAT.-NR. ITEM	SIMBOL SYMBOL	Ø mm	DIN	SACKLOCH / DURCHGANGSLOCH Blind hole/ Through hole	TOLERANZ TOLERANCE	DRALLWINKEL HELIX ANGLE	ANSCHNITT FORM CHAMFER FORM
VA							
6614 	**M**	2 ÷ 20	**352**		6HX	0°	C
Ti							
6625	**M**	2 ÷ 20	**352**		6HX	0°	C

HSS-CO

KURZE MASCHINEN-GEWINDEBOHRER / SHORT MACHINE TAPS

N							
6678	**M**	2 ÷ 20	**352**		6H	0°	C
6659	**M**	3 ÷ 20	**352**		6H	15°	C
6639	**M**	3 ÷ 20	**352**		6H	40°	C
6604	**M**	3 ÷ 24	**352**		6H-6G	40°	C
6899	**MF**	6 ÷ 20	**2181**		6H	0°	C
6656	**MF**	4 ÷ 24	**2181**		6H	15°	C
6858	**BSP/G**	1/16 ÷ 1-1/2	**5157**		-	0°	C
6905	**BSP/G**	1/8 ÷ 3/4	**5157**		+0,1	15°	C

HAND-GEWINDEBOHRER / HAND TAPS

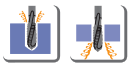
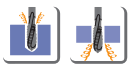
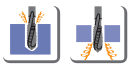
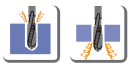
BESCHICHTUNG COATING	KÜHLUNG INTERNAL COOLANT	SCHNEIDRICHTUNG CUTTING DIRECT.	SCHNEIDSTOFF TOOL MATERIAL	P	M	K	N	S	H	Seite Page
-	-		HSS-CO	❍	●	-	●	●	-	505
-	-		HSS-CO	-	●	-	-	●	-	505

HSS-CO
KURZE MASCHINEN-GEWINDEBOHRER / SHORT MACHINE TAPS

-	-		HSS-Co	●	-	●	-	-	-	510
-	-		HSS-Co	●	-	●	-	-	-	510
-	-		HSS-Co	●	-	●	-	-	-	510
-	-		HSS-Co	●	-	●	-	-	-	510
-	-		HSS-Co	●	-	●	-	-	-	554
-	-		HSS-Co	●	-	●	-	-	-	554
-	-		HSS-Co	●	-	●	-	-	-	599
-	-		HSS-Co	●	❍	●	●	-	-	599

HSS-CO

KURZE MASCHINEN-GEWINDEBOHRER / SHORT MACHINE TAPS

KAT.-NR. ITEM	SIMBOL SYMBOL	Ø mm	DIN	SACKLOCH / DURCHGANGSLOCH Blind hole/ Through hole	TOLERANZ TOLERANCE	DRALLWINKEL HELIX ANGLE	ANSCHNITT FORM CHAMFER FORM
RAPID							
6679	**M**	2 ÷ 20	**352**		6H	0°	B
VA							
6648	**M**	3 ÷ 16	**352**		6HX	15°	C
6612	**M**	3 ÷ 16	**352**		6HX	15°	C
6857	**BSP/G**	1/16 ÷ 1/2	**5157**		-	0°	B
6951	**BSP/G**	1/16 ÷ 1	**5157**		-	15°	**E**
MS							
6624	**M**	2 ÷ 12	**352**		6H	0°	C
6724	**MF**	4 ÷ 12	**2181**		6H	0°	C
6913	**BSP/G**	1/16 ÷ 1" 1/2	**5157**		-	0°	**E**
AZ							
6621	**M**	3 ÷ 16	**352**		6H	0°	C
6613	**M**	3 ÷ 16	**352**		6H	0°	B

HSS-CO

MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

RAPID							
6707	**M**	2 ÷ 10	**371**		6H-6G 4H-**7G**	0°	B
6711	**M**	2 ÷ 52	**376**		6H-6G **7G**	0°	B

HSS-CO

KURZE MASCHINEN-GEWINDEBOHRER / SHORT MACHINE TAPS

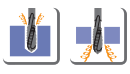
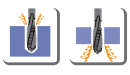
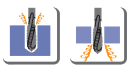
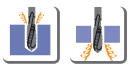
BESCHICHTUNG COATING	KÜHLUNG INTERNAL COOLANT	SCHNEIDRICHTUNG CUTTING DIRECT.	SCHNEIDSTOFF TOOL MATERIAL	P	M	K	N	S	H	Seite Page
-	-		HSS-Co	●	-	●	-	-	-	510
-	-		HSS-Co	❍	●	❍	-	❍	-	511
-	-		HSS-Co	❍	●	❍	-	❍	-	511
-	-		HSS-Co	❍	●	❍	-	❍	-	600
-	-		HSS-Co	❍	●	❍	-	❍	-	599
-	-		HSS-Co	-	-	❍	●	-	-	511
-	-		HSS-Co	-	-	❍	●	-	-	554
-	-		HSS-Co	-	-	❍	●	-	-	599
-	-		HSS-Co	-	❍	-	●	-	-	510
-	-		HSS-Co	-	❍	-	●	-	-	510

HSS-CO

MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

TN TC	-		HSS-Co	●	❍	❍	●	-	-	520
TN TC	-		HSS-Co	●	❍	❍	●	-	-	536

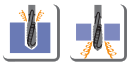
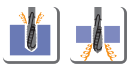
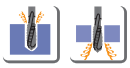
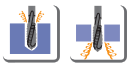
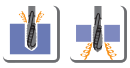
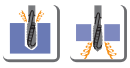
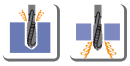
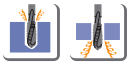
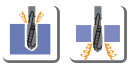
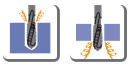
MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

KAT.-NR. ITEM	SIMBOL SYMBOL	Ø mm	DIN	SACKLOCH / DURCHGANGSLOCH Blind hole/ Through hole	TOLERANZ TOLERANCE	DRALLWINKEL HELIX ANGLE	ANSCHNITT FORM CHAMFER FORM
RAPID							
6730	**MF**	3 ÷ 52	**374**		6H	0°	B
6690	**UNC**	1 ÷ 3/8	**2184/1**		2B-3B	0°	B
6693	**UNC**	7/16 ÷ 2	**2184/1**		2B-3B	0°	B
6607	**UNF**	1 ÷ 3/8	**2184/1**		2B-3B	0°	B
6687	**UNF**	7/16 ÷ 1 1/2	**2184/1**		2B-3B	0°	B
6697	**BSW/W**	1/8 ÷ 3/8	**371***		-	0°	B
6636	**BSW/W**	7/16 ÷ 1x8	**376***		-	0°	B
6704	**BSP/G**	1/16 ÷ 2X11	**5156**		-	0°	B
6673	**RP**	1/16 ÷ 2	**5156**		-	0°	B
6710	**PG**	7 ÷ 48	**40 432**		-	0°	B
RAPID 2							
6640	**M**	2 ÷ 10	**371**		6H-6G	0°	B
N ■ **Gerade genutet /** Straight Flutes							
6706	**M**	1 ÷ 10	**371**		6H	0°	C
6705	**M**	2 ÷ 52	**376**		6H	0°	C
6726	**MF**	3 ÷ 52	**374**		6H	0°	C
6823	**UNC**	3 ÷ 3/8	**2184/1**		2B	0°	C

* **Abmessungen ähnlich DIN 352/2181** - Dimension similar to DIN 352/2181

BESCHICHTUNG COATING	KÜHLUNG INTERNAL COOLANT	SCHNEIDRICHTUNG CUTTING DIRECT.	SCHNEIDSTOFF TOOL MATERIAL	P	M	K	N	S	H	Seite Page
TN TC	-		HSS-Co	●	❍	❍	●	-	-	564
TN	-		HSS-Co	●	❍	❍	●	-	-	572
-	-		HSS-Co	●	❍	❍	●	-	-	578
TN	-		HSS-Co	●	❍	❍	●	-	-	584
-	-		HSS-Co	●	❍	❍	●	-	-	592
-	-		HSS-Co	●	❍	❍	●	-	-	595
-	-		HSS-Co	●	❍	❍	●	-	-	596
TN	-		HSS-Co	●	❍	❍	●	-	-	604
-	-		HSS-Co	●	❍	❍	●	-	-	597
-	-		HSS-Co	●	❍	❍	●	-	-	610
-	-		HSS-Co	●	❍	❍	●	-	-	521
TN TC	-		HSS-Co	●	-	❍	●	-	-	512
TN TC	-		HSS-Co	●	-	❍	●	-	-	530
TN TC	-		HSS-Co	●	-	❍	●	-	-	556
-	-		HSS-Co	●	-	❍	●	-	-	570

MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

KAT.-NR. ITEM	SIMBOL SYMBOL	Ø mm	DIN	SACKLOCH / DURCHGANGSLOCH Blind hole/ Through hole	TOLERANZ TOLERANCE	DRALLWINKEL HELIX ANGLE	ANSCHNITT FORM CHAMFER FORM
N ■ Gerade genutet / Straight Flutes							
6824	**UNC**	7/16 ÷ 1	**2184/1**		2B	0°	C
6838	**UNF**	1 ÷ 3/8	**2184/1**		2B	0°	C
6839	**UNF**	7/16 ÷ 1 1/2	**2184/1**		2B	0°	C
6699	**BSW/W**	1/8 ÷ 3/8	**371***		-	0°	C
6610	**NPT**	1/16 ÷ 2x1	**2181***		-	0°	C
6611	**NPTF**	1/16 ÷ 1 1/2	**2181***		-	0°	C
6915	**PG**	7 ÷ 48	**40 432**		-	0°	C
6914	**PG**	7 ÷ 36	**40 432**		-	0°	D
6790	**RC**	1/8 ÷ 1	**5156***		-	0°	C
N SX ■ Linksschneidend / Left hand thread							
6712	**M**	3 ÷ 10	**371**		6H	0°	C
6859	**M**	3 ÷ 10	**371**		6H	0°	B
6861	**M**	3 ÷ 10	**371**		6H	40°	C
6715	**M**	12 ÷ 24	**376**		6H	0°	C
6860	**M**	12 ÷ 20	**376**		6H	0°	B
6862	**M**	12 ÷ 20	**376**		6H	40°	C
6863	**MF**	8 ÷ 20	**374**		6H	0°	B

* **Abmessungen ähnlich DIN 352/2181** - Dimension similar to DIN 352/2181

MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

BESCHICHTUNG COATING	KÜHLUNG INTERNAL COOLANT	SCHNEIDRICHTUNG CUTTING DIRECT.	SCHNEIDSTOFF TOOL MATERIAL	P	M	K	N	S	H	Seite Page
-	-		HSS-Co	●	-	❍	●	-	-	576
-	-		HSS-Co	●	-	❍	●	-	-	582
-	-		HSS-Co	●	-	❍	●	-	-	588
-	-		HSS-Co	●	-	❍	●	-	-	595
-	-		HSS-Co	●	-	❍	●	-	-	607
-	-		HSS-Co	●	-	❍	●	-	-	607
-	-		HSS-Co	●	-	❍	●	-	-	610
-	-		HSS-Co	●	-	❍	●	-	-	611
-	-		HSS-Co	●	-	❍	●	-	-	606
-	-		HSS-Co	●	❍	❍	●	-	-	512
-	-		HSS-Co	●	❍	❍	●	-	-	521
-	-		HSS-Co	●	❍	❍	●	-	-	515
-	-		HSS-Co	●	❍	❍	●	-	-	530
-	-		HSS-Co	●	❍	❍	●	-	-	537
-	-		HSS-Co	●	❍	❍	●	-	-	531
-	-		HSS-Co	●	❍	❍	●	-	-	564

MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

KAT.-NR. ITEM	SIMBOL SYMBOL	Ø mm	DIN	SACKLOCH / DURCHGANGSLOCH Blind hole/ Through hole	TOLERANZ TOLERANCE	DRALLWINKEL HELIX ANGLE	ANSCHNITT FORM CHAMFER FORM
N SX ■ Linksschneidend / Left hand thread							
6864	**MF**	8 ÷ 20	**374**		6H	40°	C
NL ■ 15° Linksdrall, rechtsschneidend / 15° left flute right hand thread							
6727	**M**	3 ÷ 10	**371**		6H	15°	D
6740	**M**	12 ÷ 20	**376**		6H	15°	B
6741	**MF**	8 ÷ 20	**374**		6H	15°	B
N 15°							
6657	**M**	2 ÷ 10	**371**		6H-6G	15°	C
6902	**M**	3 ÷ 10	**371**		6H+**0,1**	15°	C
6658	**M**	8 ÷ 30	**376**		6H	15°	C
6903	**M**	12 ÷ 20	**376**		6H+**0,1**	15°	C
6664	**MF**	8 ÷ 30	**374**		6H	15°	C
6904	**MF**	16 ÷ 24	**374**		6H+**0,1**	15°	**E**
6696	**UNC**	nr. 3 ÷ 3/8	**2184/1**		2B	15°	C
6728	**UNC**	7/16 ÷ 1x8	**2184/1**		2B	15°	C
6719	**UNF**	nr. 5 ÷ 3/8	**2184/1**		2B	15°	C
6729	**UNF**	7/16 ÷ 1x12	**2184/1**		2B	15°	C
6665	**BSP/G**	1/16 ÷ 1x11	**5156**		-	15°	C

MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

BESCHICHTUNG COATING	KÜHLUNG INTERNAL COOLANT	SCHNEIDRICHTUNG CUTTING DIRECT.	SCHNEIDSTOFF TOOL MATERIAL	P	M	K	N	S	H	Seite Page
-	-		HSS-Co	●	❍	❍	●	-	-	557
-	-		HSS-Co	●	❍	❍	●	-	-	523
-	-		HSS-Co	●	❍	❍	●	-	-	538
-	-		HSS-Co	●	❍	❍	●	-	-	564
TN TC	-		HSS-Co	●	❍	●	●	-	-	513
-	-		HSS-Co	●	❍	●	●	-	-	513
TN TC	-		HSS-Co	●	❍	●	●	-	-	530
-	-		HSS-Co	●	❍	●	●	-	-	530
TN TC	-		HSS-Co	●	❍	●	●	-	-	556
-	-		HSS-Co	●	❍	●	●	-	-	557
-	-		HSS-Co	●	❍	●	●	-	-	570
-	-		HSS-Co	●	❍	●	●	-	-	576
-	-		HSS-Co	●	❍	●	●	-	-	582
-	-		HSS-Co	●	❍	●	●	-	-	588
-	-		HSS-Co	●	❍	●	●	-	-	601

MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

KAT.-NR. ITEM	SIMBOL SYMBOL	Ø mm	DIN	SACKLOCH / DURCHGANGSLOCH Blind hole/ Through hole	TOLERANZ TOLERANCE	DRALLWINKEL HELIX ANGLE	ANSCHNITT FORM CHAMFER FORM
N 15°							
6675	**RP**	1/8 ÷ 1	**5156**		-	15°	C
N 40°							
6644	**M**	2 ÷ 10	**371**		6H-6G 7G	40°	C
6867	**M**	3 ÷ 10	**371**		6H	40°	E
6638	**M**	3 ÷ 36	**376**		6H-6G 7G	40°	C
6868	**M**	12 ÷ 20	**376**		6H	40°	E
6652	**MF**	3 ÷ 30	**374**		6H	40°	C
6877	**MF**	6 ÷ 20	**374**		6H	40°	E
6691	**UNC**	2 ÷ 3/8	**2184/1**		2B-3B	40°	C
6694	**UNC**	7/16 ÷ 1x8	**2184/1**		2B-3B	40°	C
6680	**UNF**	5 ÷ 3/8	**2184/1**		2B-3B	40°	C
6688	**UNF**	7/16 ÷ 1	**2184/1**		2B-3B	40°	C
6836	**BSW/W**	1/8 ÷ 1 3/8	**371***		-	40°	C
6837	**BSW/W**	7/16 ÷ 1	**376***		-	40°	C
6703	**BSP/G**	1/16 ÷ 1	**5156**		-	40°	C

BESCHICHTUNG COATING	KÜHLUNG INTERNAL COOLANT	SCHNEIDRICHTUNG CUTTING DIRECT.	SCHNEIDSTOFF TOOL MATERIAL	P	M	K	N	S	H	Seite Page
-	-		HSS-Co	●	❍	●	●	-	-	597
TN TC	-		HSS-Co	●	❍	●	●	-	-	514
-	-		HSS-Co	●	❍	●	●	-	-	515
TN TC	-		HSS-Co	●	❍	●	●	-	-	531
-	-		HSS-Co	●	❍	●	●	-	-	531
TN TC	-		HSS-Co	●	❍	●	●	-	-	557
-	-		HSS-Co	●	❍	●	●	-	-	557
TN	-		HSS-Co	●	❍	●	●	-	-	570
-	-		HSS-Co	●	❍	●	●	-	-	576
TN	-		HSS-Co	●	❍	●	●	-	-	582
-	-		HSS-Co	●	❍	●	●	-	-	588
-	-		HSS-Co	●	❍	●	●	-	-	595
-	-		HSS-Co	●	❍	●	●	-	-	596
TN	-		HSS-Co	●	❍	●	●	-	-	601

MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

KAT.-NR. ITEM	SIMBOL SYMBOL	Ø mm	DIN	SACKLOCH / DURCHGANGSLOCH Blind hole/ Through hole	TOLERANZ TOLERANCE	DRALLWINKEL HELIX ANGLE	ANSCHNITT FORM CHAMFER FORM
VA							
6646 NEW XP	M	2 ÷ 10	371		6HX-6GX	0°	B
6654 NEW XP	M	2 ÷ 10	371		6HX	15°	C
6661 NEW XP	M	2 ÷ 10	371		6HX-6GX	35°	C
6647 NEW XP	M	12 ÷ 24	376		6HX-6GX	0°	B
6634	M	12 ÷ 24	376		6HX	15°	C
6662 NEW XP	M	12 ÷ 24	376		6HX-6GX	35°	C
6663 NEW XP	MF	8 ÷ 30	374		6HX-6GX	0°	B
6671	MF	8 ÷ 30	374		6HX	15°	C
6655 NEW XP	MF	8 ÷ 30	374		6HX-6GX	35°	C
6739 NEW XP	UNC	nr. 2 ÷ 3/8	2184/1		2BX	0°	B
6735 NEW XP	UNC	nr. 6 ÷ 3/8	2184/1		2BX	35°	C
6749	UNC	1/2 ÷ 1	2184/1		2BX	0°	B
6754	UNC	1/2 ÷ 1	2184/1		2BX	35°	C
6718	UNF	nr. 2 ÷ 3/8	2184/1		2BX	0°	B
6794	UNF	10x32 ÷ 3/8	2184/1		2BX	35°	C
6797	UNF	7/16 ÷ 3/4	2184/1		2BX	0°	B
6796	UNF	7/16 ÷ 3/4	2184/1		2BX	35°	C
6945 NEW	UN-8	1 1/8 ÷ 1 1/2	2184/1		2BX	35°	C

MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

BESCHICHTUNG COATING	KÜHLUNG INTERNAL COOLANT	SCHNEIDRICHTUNG CUTTING DIRECT.	SCHNEIDSTOFF TOOL MATERIAL	P	M	K	N	S	H	Seite Page
TN TX XP	-		HSS-Co	❍	●	❍	●	❍	-	524
XP	-		HSS-Co	❍	●	❍	●	❍	-	516
TN TX XP	-		HSS-Co	❍	●	❍	●	❍	-	517
XP	-		HSS-Co	❍	●	❍	●	❍	-	538
-	-		HSS-Co	❍	●	❍	●	❍	-	532
TX XP	-		HSS-Co	❍	●	❍	●	❍	-	533
TN XP	-		HSS-Co	❍	●	❍	●	❍	-	565
-	-		HSS-Co	❍	●	❍	●	❍	-	560
XP	-		HSS-Co	❍	●	❍	●	❍	-	560
XP	-		HSS-Co	❍	●	❍	●	❍	-	573
XP	-		HSS-Co	❍	●	❍	●	❍	-	571
-	-		HSS-Co	❍	●	❍	●	❍	-	578
-	-		HSS-Co	❍	●	❍	●	❍	-	577
-	-		HSS-Co	❍	●	❍	●	❍	-	585
-	-		HSS-Co	❍	●	❍	●	❍	-	583
-	-		HSS-Co	❍	●	❍	●	❍	-	592
-	-		HSS-Co	❍	●	❍	●	❍	-	589
-	-		HSS-Co	❍	●	❍	●	❍	-	590

MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

KAT.-NR. ITEM	SIMBOL SYMBOL	Ø mm	DIN	SACKLOCH / DURCHGANGSLOCH Blind hole/ Through hole	TOLERANZ TOLERANCE	DRALLWINKEL HELIX ANGLE	ANSCHNITT FORM CHAMFER FORM
VA							
6700 NEW XP	**BSP/G**	1/16 ÷ 1	**5156**		-	0°	B
6716	**BSP/G**	1/16 ÷ 1	**5156**		-	15°	C
6701 NEW XP	**BSP/G**	1/16 ÷ 1	**5156**		-	35°	C
VA i 15° ■ Mit Innenkühlung / With internal coolant							
6620 NEW XP	**M**	6 ÷ 10	**371**		6HX	15°	C
6605 NEW XP	**M**	12 ÷ 20	**376**		6HX	15°	C
6626 NEW XP	**M**	8 ÷ 20	**374**		6HX	15°	C
VR 50°							
6850	**M**	2 ÷ 10	**371**		6HX	50°	C
6851	**M**	12 ÷ 24	**376**		6HX	50°	C
6852	**UNC**	nr. 6 ÷ 3/8	**2181-1**		2BX	50°	C
6853	**UNC**	1/2 ÷ 1	**2181-1**		2BX	50°	C
6854	**UNF**	nr. 10 ÷ 3/8	**2181-1**		2BX	50°	C
6855	**UNF**	7/16 ÷ 3/4	**2181-1**		2BX	50°	C
6856	**BSP/G**	1/16 ÷ 1	**5156**		-	50°	C

MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

BESCHICHTUNG COATING	KÜHLUNG INTERNAL COOLANT	SCHNEIDRICHTUNG CUTTING DIRECT.	SCHNEIDSTOFF TOOL MATERIAL	P	M	K	N	S	H	Seite Page
XP	-		HSS-Co	❍	●	❍	●	❍	-	605
-	-		HSS-Co	❍	●	❍	●	❍	-	602
XP	-		HSS-Co	❍	●	❍	●	❍	-	602
XP	-		HSS-Co	❍	●	❍	●	❍	-	516
XP	-		HSS-Co	❍	●	❍	●	❍	-	532
XP	-		HSS-Co	❍	●	❍	●	❍	-	560
TN	-		HSS-Co	❍	●	-	❍	-	-	517
TN	-		HSS-Co	❍	●	-	❍	-	-	533
-	-		HSS-Co	❍	●	-	❍	-	-	571
-	-		HSS-Co	❍	●	-	❍	-	-	577
-	-		HSS-Co	❍	●	-	❍	-	-	583
-	-		HSS-Co	❍	●	-	❍	-	-	589
-	-		HSS-Co	❍	●	-	❍	-	-	602

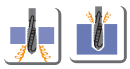
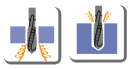
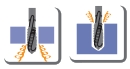
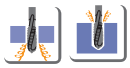
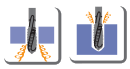
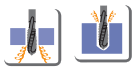
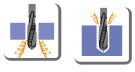
MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

HD

KAT.-NR. ITEM	SIMBOL SYMBOL	Ø mm	DIN	SACKLOCH / DURCHGANGSLOCH Blind hole/ Through hole	TOLERANZ TOLERANCE	DRALLWINKEL HELIX ANGLE	ANSCHNITT FORM CHAMFER FORM
6870	**M**	2 ÷ 10	**371**		6H	0°	B
6878	**M**	3 ÷ 10	**371**		6H	15°	C
6666	**M**	3 ÷ 10	**371**		4H-6H-6G	40°	C
6871	**M**	12 ÷ 30	**376**		6H	0°	B
6879	**M**	12 ÷ 30	**376**		6H	15°	C
6667	**M**	3 ÷ 20	**376**		6H	40°	C
6872	**MF**	6 ÷ 24	**374**		6H	0°	B
6880	**MF**	6 ÷ 24	**374**		6H	15°	C
6873	**UNC**	nr. 2 ÷ 3/8	**2184/1**		2B	0°	B
6865	**UNC**	nr. 3 ÷ 3/8	**2184/1**		2B	15°	C
6874	**UNC**	7/16 ÷ 1x8	**2184/1**		2B	0°	B
6866	**UNC**	7/16 ÷ 1x8	**2184/1**		2B	15°	C
6875	**UNF**	nr. 2 ÷ 3/8	**2184/1**		2B	0°	B
6848	**UNF**	nr. 5 ÷ 3/8	**2184/1**		2B	15°	C
6876	**UNF**	7/16 ÷ 1	**2184/1**		2B	0°	B
6849	**UNF**	7/16 ÷ 1	**2184/1**		2B	15°	C
6912	**BSP/G**	1/16 ÷ 2	**5156**		-	0°	C

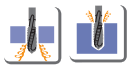
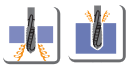
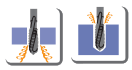
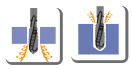
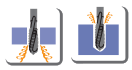
BESCHICHTUNG COATING	KÜHLUNG INTERNAL COOLANT	SCHNEIDRICHTUNG CUTTING DIRECT.	SCHNEIDSTOFF TOOL MATERIAL	P	M	K	N	S	H	Seite Page
TN TF	-		HSS-Co	●	-	●	-	-	-	525
HL	-		HSS-Co	●	-	●	-	-	❍	513
TN TF	-		HSS-Co	●	-	●	-	-	-	519
TN TF	-		HSS-Co	●	-	●	-	-	-	539
HL	-		HSS-Co	●	-	●	-	-	❍	535
TN TF	-		HSS-Co	●	-	●	-	-	-	535
TN	-		HSS-Co	●	-	●	-	-	-	565
HL	-		HSS-Co	●	-	●	-	-	❍	561
-	-		HSS-Co	●	-	●	-	-	-	572
-	-		HSS-Co	●	-	●	-	-	-	571
-	-		HSS-Co	●	-	●	-	-	-	578
-	-		HSS-Co	●	-	●	-	-	-	577
-	-		HSS-Co	●	-	●	-	-	-	585
-	-		HSS-Co	●	-	●	-	-	-	583
-	-		HSS-Co	●	-	●	-	-	-	592
-	-		HSS-Co	●	-	●	-	-	-	589
TN	-		HSS-Co	●	-	●	-	-	-	601

MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

KAT.-NR. ITEM	SIMBOL SYMBOL	Ø mm	DIN	SACKLOCH / DURCHGANGSLOCH Blind hole/ Through hole	TOLERANZ TOLERANCE	DRALLWINKEL HELIX ANGLE	ANSCHNITT FORM CHAMFER FORM
HD							
6917	**NPT**	1/16 ÷ 1/4	**371**		-	0°	C
6918	**NPT**	3/8 ÷ 1 1/2	**376**		-	0°	C
6923	**NPTF**	1/16 ÷ 1/4	**371**		-	0°	C
6924	**NPTF**	3/8 ÷ 1 1/2	**374**		-	0°	C
HR							
6681	**M**	3 ÷ 10	**371**		6H	40°	C
6689	**M**	12 ÷ 20	**376**		6H	40°	C
GG							
6631	**M**	3 ÷ 10	**371**		6HX	0°	C
6632	**M**	6 ÷ 30	**376**		6HX	0°	C
6653	**MF**	8 ÷ 30	**374**		6HX	0°	C
6708	**BSP/G**	1/16 ÷ 2	**5157**		-	0°	C
6674	**RP**	1/8 ÷ 2	**5156**		-	0°	C
GG i							
6629	**M**	5 ÷ 10	**371**		6HX	0°	C
6637	**M**	12 ÷ 20	**376**		6HX	0°	C

BESCHICHTUNG COATING	KÜHLUNG INTERNAL COOLANT	SCHNEIDRICHTUNG CUTTING DIRECT.	SCHNEIDSTOFF TOOL MATERIAL	P	M	K	N	S	H	Seite Page
TN	-		HSS-Co	●	-	●	-	-	-	608
-	-		HSS-Co	●	-	●	-	-	-	609
-	-		HSS-Co	●	-	●	-	-	-	608
-	-		HSS-Co	●	-	●	-	-	-	609
TF	-		HSS-Co	●	-	❍	-	-	-	519
TF	-		HSS-Co	●	-	❍	-	-	-	535
TF	-		HSS-Co	-	-	●	❍	-	-	518
TF	-		HSS-Co	-	-	●	❍	-	-	534
-	-		HSS-Co	-	-	●	❍	-	-	561
TF	-		HSS-Co	-	-	●	❍	-	-	603
-	-		HSS-Co	-	-	●	❍	-	-	597
TC			HSS-Co	-	-	●	❍	-	-	518
TC			HSS-Co	-	-	●	❍	-	-	534

MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

KAT.-NR. ITEM	SIMBOL SYMBOL	Ø mm	DIN	SACKLOCH / DURCHGANGSLOCH Blind hole/ Through hole	TOLERANZ TOLERANCE	DRALLWINKEL HELIX ANGLE	ANSCHNITT FORM CHAMFER FORM
AZ							
6820	**M**	2 ÷ 10	**371**		6H	0°	C
6616	**M**	2 ÷ 10	**371**		6H	0°	B
6821	**M**	6 ÷ 24	**376**		6H	0°	C
6617	**M**	12 ÷ 20	**376**		6H	0°	B
6916	**NPT**	1/16 ÷ 2	**371**		-	0°	C
6919	**NPT**	1/16 ÷ 1/4	**371**		-	0°	C
6920	**NPT**	3/8 ÷ 1 1/2	**376**		-	0°	C
6921	**NPT**	1/16 ÷ 1/4	**371**		-	35°	C
6922	**NPT**	3/8 ÷ 1 1/2	**376**		-	35°	C
6925	**NPTF**	1/16 ÷ 1/4	**374**		-	35°	C
6926	**NPTF**	3/8 ÷ 1 1/2	**374**		-	35°	C
ALU							
6641	**M**	2 ÷ 10	**371**		6H	0°	B
6643	**M**	2 ÷ 10	**371**		6H	45°	C
6642	**M**	12 ÷ 20	**376**		6H	0°	B
6651	**M**	12 ÷ 20	**376**		6HX	45°	C
6731	**MF**	8 ÷ 20	**374**		6H	45°	C

MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

BESCHICHTUNG COATING	KÜHLUNG INTERNAL COOLANT	SCHNEIDRICHTUNG CUTTING DIRECT.	SCHNEIDSTOFF TOOL MATERIAL	P	M	K	N	S	H	Seite Page
-	-		HSS-Co	❍	-	-	●	-	-	513
-	-		HSS-Co	❍	-	-	●	-	-	523
-	-		HSS-Co	❍	-	-	●	-	-	530
-	-		HSS-Co	❍	-	-	●	-	-	538
-	-		HSS-Co	❍	-	-	●	-	-	607
-	-		HSS-Co	❍	-	-	●	-	-	608
-	-		HSS-Co	❍	-	-	●	-	-	609
TN	-		HSS-Co	❍	-	-	●	-	-	608
-	-		HSS-Co	❍	-	-	●	-	-	609
-	-		HSS-Co	❍	-	-	●	-	-	608
-	-		HSS-Co	❍	-	-	●	-	-	609
-	-		HSS-Co	-	-	-	●	-	-	525
-	-		HSS-Co	-	-	-	●	-	-	518
-	-		HSS-Co	-	-	-	●	-	-	539
-	-		HSS-Co	-	-	-	●	-	-	534
-	-		HSS-Co	-	-	-	●	-	-	561

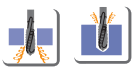
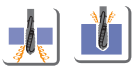
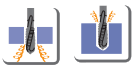
MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

KAT.-NR. ITEM	SIMBOL SYMBOL	Ø mm	DIN	SACKLOCH / DURCHGANGSLOCH Blind hole/ Through hole	TOLERANZ TOLERANCE	DRALLWINKEL HELIX ANGLE	ANSCHNITT FORM CHAMFER FORM
ALU							
6732	**UNC**	nr. 4 ÷ 3/8	**2184/1**		2B	45°	C
6733	**UNC**	1/2	**2184/1**		2B	45°	C
6628	**UNF**	nr. 10 ÷ 3/8	**2184/1**		2B	45°	C
6734	**UNF**	1/2	**2184/1**		2B	45°	C
BAK							
6670	**M**	2 ÷ 10	**371**		6HX	0°	**E**
ULTRA							
6606	**M**	1 ÷ 10	**371**		6HX-6GX	0°	B
6737	**UNC**	nr. 1 ÷ 3/8	**2184/1**		2B	0°	B
ULTRA S							
6649	**M**	2 ÷ 10	**371**		6HX-6GX	0°	B
EGM							
6908	**M**	3 ÷ 8	**8140/371**		6H	0°	B
6910	**M**	3 ÷ 8	**8140/371**		6H	40°	C
6909	**M**	10 ÷ 16	**8140/376**		6H	0°	B
6911	**M**	10 ÷ 16	**8140/376**		6H	40°	C

MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

BESCHICHTUNG COATING	KÜHLUNG INTERNAL COOLANT	SCHNEIDRICHTUNG CUTTING DIRECT.	SCHNEIDSTOFF TOOL MATERIAL	P	M	K	N	S	H	Seite Page
-	-		HSS-Co	-	-	-	●	-	-	571
-	-		HSS-Co	-	-	-	●	-	-	577
-	-		HSS-Co	-	-	-	●	-	-	583
-	-		HSS-Co	-	-	-	●	-	-	589
-	-		HSS-Co	-	-	-	●	-	-	518
-	-		HSS-Co	❍	-	-	●	-	-	522
-	-		HSS-Co	❍	-	-	●	-	-	572
TN	-		HSS-Co	❍	-	-	●	-	-	522
-	-		HSS-Co	●	❍	❍	●	-	-	613
-	-		HSS-Co	●	❍	❍	●	-	-	612
-	-		HSS-Co	●	❍	❍	●	-	-	615
-	-		HSS-Co	●	❍	❍	●	-	-	614

MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

KAT.-NR. ITEM	SIMBOL SYMBOL	Ø mm	DIN	SACKLOCH / DURCHGANGSLOCH Blind hole/ Through hole	TOLERANZ TOLERANCE	DRALLWINKEL HELIX ANGLE	ANSCHNITT FORM CHAMFER FORM
FORMER							
6722	**M**	1 ÷ 10	**371**		6HX	-	C
6622	**M**	2 ÷ 10	**371**		6GX	-	C
6723	**M**	12 ÷ 16	**376**		6HX	-	C
6623	**M**	12 ÷ 16	**376**		6GX	-	C
6721	**MF**	8 ÷ 16	**374**		6HX-6GX	-	C
6738	**UNC**	nr. 2 ÷ 3/8	**2184/1**		2BX	-	C
6747	**UNF**	nr. 4 ÷ 3/8	**2184/1**		2BX	-	C
6702	**BSP/G**	1/16 ÷ 1/2	**5156**		-	-	B
FORMER S ■ **Mit Schmiernuten/** Coolant groove							
6709	**M**	3 ÷ 10	**371**		6HX	-	C
6808	**M**	3 ÷ 10	**371**		6GX	-	C
6819	**M**	6 ÷ 10	**371**		**7GX**	-	C
6725	**M**	12 ÷ 16	**376**		6HX	-	C
6809	**M**	12 ÷ 16	**376**		6GX	-	C
6720	**MF**	8 ÷ 16	**374**		6HX-6GX	-	C
6802	**UNC**	nr. 5 ÷ 3/8	**2184/1**		2BX	-	C
6811	**UNC**	7/16 ÷ 1/2	**2184/1**		2BX	-	C

BESCHICHTUNG COATING	KÜHLUNG INTERNAL COOLANT	SCHNEIDRICHTUNG CUTTING DIRECT.	SCHNEIDSTOFF TOOL MATERIAL	P	M	K	N	S	H	Seite Page
TN TF TX	-		HSS-Co	●	❍	-	●	-	-	526
TN TF TX	-		HSS-Co	●	❍	-	●	-	-	526
TN TF TX	-		HSS-Co	●	❍	-	●	-	-	540
TN TF TX	-		HSS-Co	●	❍	-	●	-	-	540
-	-		HSS-Co	●	❍	-	●	-	-	568
-	-		HSS-Co	●	❍	-	●	-	-	575
-	-		HSS-Co	●	❍	-	●	-	-	587
-	-		HSS-Co	●	❍	-	●	-	-	605
TN TF TX	-		HSS-Co	●	❍	-	●	-	-	528
TN TF TX	-		HSS-Co	●	❍	-	●	-	-	528
-	-		HSS-Co	●	❍	-	●	-	-	529
TN TF TX	-		HSS-Co	●	❍	-	●	-	-	542
TN TF TX	-		HSS-Co	●	❍	-	●	-	-	542
-	-		HSS-Co	●	❍	-	●	-	-	568
-	-		HSS-Co	●	❍	-	●	-	-	575
-	-		HSS-Co	●	❍	-	●	-	-	579

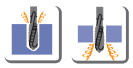
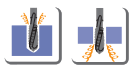
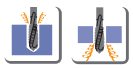
MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

KAT.-NR. ITEM	SIMBOL SYMBOL	Ø mm	DIN	SACKLOCH / DURCHGANGSLOCH Blind hole/ Through hole	TOLERANZ TOLERANCE	DRALLWINKEL HELIX ANGLE	ANSCHNITT FORM CHAMFER FORM
FORMER S ■ **Mit Schmiernuten/** Coolant groove							
6815	**UNF**	nr. 4 ÷ 3/8	**2184/1**		2BX	-	C
6816	**UNF**	7/16 ÷ 5/8	**2184/1**		2BX	-	C
6818	**BSP/G**	1/16 ÷ 1/2	**5156**		-	-	C
Langer Schaft / Long shank							
6672	**M**	3 ÷ 14	**ILIX NORM**		6H	0°	B
Extra langer Schaft / Extra long shank							
6692	**M**	3 ÷ 6	**ILIX NORM**		6H	0°	B
6695	**M**	8 ÷ 20	**ILIX NORM**		6H	0°	B
Muttergewindebohrer / Nut Tap							
6660	**M**	3 ÷ 30	**357**		6H	0°	A

MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

BESCHICHTUNG COATING	KÜHLUNG INTERNAL COOLANT	SCHNEIDRICHTUNG CUTTING DIRECT.	SCHNEIDSTOFF TOOL MATERIAL	P	M	K	N	S	H	Seite Page
-	-		HSS-Co	●	❍	-	●	-	-	587
-	-		HSS-Co	●	❍	-	●	-	-	593
-	-		HSS-Co	●	❍	-	●	-	-	605
-	-		HSS-Co	●	❍	❍	●	-	-	544
-	-		HSS-Co	●	❍	❍	●	-	-	546
-	-		HSS-Co	●	❍	❍	●	-	-	547
-	-		HSS-Co	●	❍	❍	●	-	-	545

MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

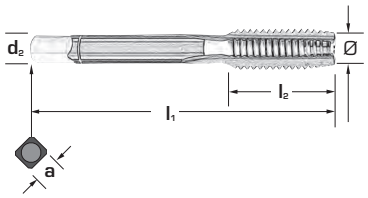
KAT.-NR. ITEM	SIMBOL SYMBOL	Ø mm	DIN	SACKLOCH / DURCHGANGSLOCH Blind hole/ Through hole	TOLERANZ TOLERANCE	DRALLWINKEL HELIX ANGLE	ANSCHNITT FORM CHAMFER FORM
Extra langer Schaft / Extra long shank							
6842	**M**	3 ÷ 6	**ILIX NORM**		6H	0°	B
6840	**M**	3 ÷ 6	**ILIX NORM**		6H	40°	C
6843	**M**	8 ÷ 20	**ILIX NORM**		6H	0°	B
6841	**M**	8 ÷ 20	**ILIX NORM**		6H	40°	C
TR ■ Trapez / Trapezoidal							
6938	**TR**	10 ÷ 36	**ILIX NORM**		7H	0°	-
6939	**TR**	10 ÷ 36	**ILIX NORM**		7H	0°	-
6937	**TR**	10 ÷ 30	**ILIX NORM**		7H	0°	C

BESCHICHTUNG COATING	KÜHLUNG INTERNAL COOLANT	SCHNEIDRICHTUNG CUTTING DIRECT.	SCHNEIDSTOFF TOOL MATERIAL	P	M	K	N	S	H	Seite Page
-	-		HSS-Co	●	❍	❍	●	-	-	549
-	-		HSS-Co	●	❍	❍	●	-	-	548
-	-		HSS-Co	●	❍	❍	●	-	-	551
-	-		HSS-Co	●	❍	❍	●	-	-	550
-	-		HSS-Co	●	❍	❍	●	-	-	617
-	-		HSS-Co	●	❍	❍	●	-	-	618
-	-		HSS-Co	●	❍	❍	●	-	-	616

DIN 352

Hand-Gewindebohrer, dreiteiliger Satz
für Metrisches ISO-Gewinde nach DIN 13
Hand taps, serial in set of 3 pieces
for ISO metric coarse thread as per DIN 13

M



Typ / Type							N	N	N	N	N	N
Toleranz Tolerance							6 H	6 H	6 H	6 H	6 H	6 H
Anschnitt / Gangzahl Chamfer form / No. of threads							A/5-6	D/3-4	C/2,5-3	A/5-6	D/3-4	C/2,5-3
Schneidrichtung Cutting direction												
Schneidstoff/ Material							HSS	HSS	HSS	HSS	HSS	HSS
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap-drill Ø	**l_1** mm	**l_2** mm	**d_2** mm h9**	**a** h12	**6615 V**	**6615 M**	**6615 F**	**6618 V**	**6618 M**	**6618 F**
								Einzel single tap		**Satz** set	**Einzel** single tap		**Satz** set
M	1,0	0,25	0,75	32	5,5	2,5	2,1	●		●	-		-
M	1,1	0,25	0,85	32	5,5	2,5	2,1	●		●	-		-
M	1,2	0,25	0,95	32	5,5	2,5	2,1	●		●	-		-
M	1,4	0,30	1,10	32	7,0	2,5	2,1	●		●	-		-
M	1,6	0,35	1,25	32	8,0	2,5	2,1	●		●	-		-
M	1,7*	0,35	1,30	32	8,0	2,5	2,1	●		●	-		-
M	1,8	0,35	1,45	32	8,0	2,5	2,1	●		●	-		-
M	2,0	0,40	1,60	36	8,0	2,8	2,1	●		●	-		-
M	2,2	0,45	1,75	36	9,0	2,8	2,1	●		●	-		-
M	2,3*	0,40	1,90	36	9,0	2,8	2,1	●		●	-		-
M	2,5	0,45	2,05	40	9,0	2,8	2,1	●		●	-		-
M	2,6*	0,45	2,10	40	9,0	2,8	2,1	●		●	-		-
M	3,0	0,50	2,50	40	11,0	3,5	2,7	●		●	●		●
M	3,0*	0,60	2,40	40	11,0	3,5	2,7	●		●	-		-
M	3,5	0,60	2,90	45	13,0	4,0	3,0	●		●	●		●
M	4,0	0,70	3,30	45	13,0	4,5	3,4	●		●	●		●
M	4*	0,75	3,25	45	13,0	4,5	3,4	●		-	-		-
M	4,5	0,75	3,70	50	16,0	6,0	4,9	●		●	-		-
M	5,0	0,80	4,20	50	16,0	6,0	4,9	●		-	●		●
M	5*	0,90	4,10	50	16,0	6,0	4,9	●		●	-		-
M	6,0	1,00	5,00	50	19,0	6,0	4,9	●		●	●		●
M	7,0	1,00	6,00	50	19,0	6,0	4,9	●		●	●		●
M	8,0	1,25	6,80	56	22,0	6,0	4,9	●		●	●		●

N: **Herkömmliche Anwendung**
universal application

* Diese Gewinde sind im Metrischen ISO-Gewinde nicht enthalten / These sizes are not ISO standard.
** Schafttoleranz der Vor- und Mittelschneider h 12 / Shank tolerance of 1st and 2nd tap h 12

● Standardartikel / Items available ex stock

DIN 352

Hand-Gewindebohrer, dreiteiliger Satz
für Metrisches ISO-Gewinde nach DIN 13
Hand taps, serial in set of 3 pieces
for ISO metric coarse thread as per DIN 13

VA	VA	VA	Ti	Ti	Ti	**Typ /** Type
6 HX	6 HX	6 HX	HX	HX	6 HX	**Toleranz** Tolerance
A/5-6	D/3-4	C/2,5-3	A/5-6	D/3-4	C/2,5-3	**Anschnitt / Gangzahl** Chamfer form / No. of threads
						Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material

6614 V	6614 M	6614 F	6625 V	6625 M	6625 F	Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø
Einzel single tap	Satz set		Einzel single tap	Satz set					
-	-	-	-			M	1,0	0,25	0,75
-	-	-	-			M	1,1	0,25	0,85
-	-	-	-			M	1,2	0,25	0,95
-	-	-	-			M	1,4	0,30	1,10
-	-	-	-			M	1,6	0,35	1,25
-	-	-	-			M	1,7*	0,35	1,30
-	-	-	-			M	1,8	0,35	1,45
●	●	●	●			M	2,0	0,40	1,60
●	●	●	●			M	2,2	0,45	1,75
●	●	●	●			M	2,3*	0,40	1,90
●	●	●	●			M	2,5	0,45	2,05
●	●	■	■			M	2,6*	0,45	2,10
●	●	●	●			M	3,0	0,50	2,50
-	■	●	-			M	3*	0,60	2,40
●	●	●	●			M	3,5	0,60	2,90
●	●	●	●			M	4,0	0,70	3,30
-	-	-	-			M	4*	0,75	3,25
-	-	-	-			M	4,5	0,75	3,70
●	●	●	●			M	5,0	0,80	4,20
■	-	●	●			M	5*	0,90	4,10
●	●	-	●			M	6,0	1,00	5,00
●	●	●	●			M	7,0	1,00	6,00
●	●	●	●			M	8,0	1,25	6,80

VA: **für rostfreien Stahl**
for stainless steel

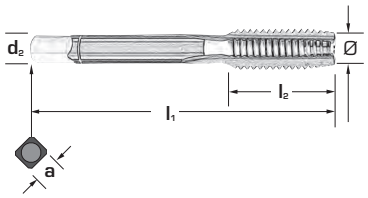
Ti: **für Titanlegierung**
for titanium alloys

● Standardartikel / Items available ex stock - ■ Auslaufender Artikel / discontinued items

DIN 352

Hand-Gewindebohrer, dreiteiliger Satz
für Metrisches ISO-Gewinde nach DIN 133
Hand taps, serial in set of 3 pieces
for ISO metric coarse thread as per DIN 13

M



Typ / Type								N	N	N	N	N	N
Toleranz Tolerance								6 H	6 H	6 H	6 H	6 H	6 H
Anschnitt / Gangzahl Chamfer form / No. of threads								A/5-6	D/3-4	C/2,5-3	A/5-6	D/3-4	C/2,5-3
Schneidrichtung Cutting direction													
Schneidstoff/ Material								HSS	HSS	HSS	HSS	HSS	HSS
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1** mm	**l_2** mm	**d_2** mm h9**	**a** h12	**6615 V**	**6615 M**	**6615 F**	**6618 V**	**6618 M**	**6618 F**
								Einzel single tap		**Satz** set	**Einzel** single tap		**Satz** set
M	9	1,25	7,8	63	22	7	5,5	●		●	-		-
M	10	1,50	8,5	70	24	7	6,2	●		●	●		●
M	11	1,50	9,5	70	24	8	5,5	●		●	-		-
M	12	1,75	10,2	75	29	9	7,0	●		●	●		●
M	14	2,00	12,0	80	30	11	9,0	●		●	●		●
M	16	2,00	14,0	80	32	12	9,0	●		●	●		●
M	18	2,50	15,5	95	40	14	11,0	●		●	●		●
M	20	2,50	17,5	95	40	16	12,0	●		●	●		●
M	22	2,50	19,5	100	40	18	14,5	●		●	-		-
M	24	3,00	21,0	110	50	18	14,5	●		●	-		-
M	27	3,00	24,0	110	50	20	16,0	●		●	-		-
M	30	3,50	26,5	125	56	22	18,0	●		●	-		-
M	33	3,50	29,5	125	56	25	20,0	●		●	-		-
M	36	4,00	32,0	150	63	28	22,0	●		●	-		-
M	39	4,00	35,0	150	63	32	24,0	●		●	-		-
M	42	4,50	37,5	150	63	32	24,0	●		●	-		-
M	45	4,50	40,5	160	70	36	29,0	●		●	-		-
M	48	5,00	43,0	180	75	36	29,0	●		●	-		-
M	52	5,00	47,0	180	75	40	32,0	●		●	-		-
M	56	5,50	50,5	200	85	45	35,0	●		●	-		-
M	60	5,50	54,5	200	85	45	35,0	●		●	-		-
M	64	6,00	58,0	220	90	50	39,0	●		●	-		-
M	68	6,00	62,0	220	90	50	29,0	●		●	-		-

N: **Herkömmliche Anwendung**
universal application

** Schafttoleranz der Vor- und Mittelschneider h 12 / Shank tolerance of 1st and 2nd tap h 12

● Standardartikel / Items available ex stock

DIN 352

Hand-Gewindebohrer, dreiteiliger Satz
für Metrisches ISO-Gewinde nach DIN 13
Hand taps, serial in set of 3 pieces
for ISO metric coarse thread as per DIN 13

VA	VA	VA	Ti	Ti	Ti	**Typ /** Type
6 HX	6 HX	6 HX	HX	HX	6 HX	**Toleranz** Tolerance
A/5-6	D/3-4	C/2,5-3	A/5-6	D/3-4	C/2,5-3	**Anschnitt / Gangzahl** Chamfer form / No. of threads
						Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material

6614 V	6614 M	6614 F	6625 V	6625 M	6625 F	Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø
Einzel single tap	Satz set		Einzel single tap	Satz set					
-	-		-	-		M	9	1,25	7,8
●	●		●	●		M	10	1,50	8,5
-	-		-	-		M	11	1,50	9,5
●	●		●	●		M	12	1,75	10,2
●	●		●	●		M	14	2,00	12,0
●	●		●	●		M	16	2,00	14,0
●	●		●	●		M	18	2,50	15,5
●	●		●	●		M	20	2,50	17,5
-	-		-	-		M	22	2,50	19,5
-	-		-	-		M	24	3,00	21,0
-	-		-	-		M	27	3,00	24,0
-	-		-	-		M	30	3,50	26,5
-	-		-	-		M	33	3,50	29,5
-	-		-	-		M	36	4,00	32,0
-	-		-	-		M	39	4,00	35,0
-	-		-	-		M	42	4,50	37,5
-	-		-	-		M	45	4,50	40,5
-	-		-	-		M	48	5,00	43,0
-	-		-	-		M	52	5,00	47,0
-	-		-	-		M	56	5,50	50,5
-	-		-	-		M	60	5,50	54,5
-	-		-	-		M	64	6,00	58,0
-	-		-	-		M	68	6,00	62,0

VA: **für rostfreien Stahl** for stainless steel
Ti: **für Titanlegierung** for titanium alloys

● Standardartikel / Items available ex stock

DIN 352

Hand-Gewindebohrer, dreiteilige Sätze, in Metallkassetten für Metrisches ISO-Gewinde nach DIN 13
Hand taps, serial, in set of 3 pieces in metal cases for ISO metric coarse thread as per DIN 13

M

Ø mm		Steigung Pitch		6608
			Satz in Kassette set in metal case	
Typ / Type				-
Toleranz Tolerance				-
Anschnitt / Gangzahl Chamfer form / No. of threads				-
Schneidrichtung Cutting direction				-
Schneidstoff/ Material				HSS
M	3	0,50		●
M	4	0,70		●
M	5	0,80		●
M	6	1,00		●
M	8	1,25		●
M	10	1,50		●
M	12	1,75		●

Die Kassette enthält Gewindebohrer nach Kat.-Nr. 6615 / The metal case contains hand taps Cat.-No. 6615

● Standardartikel / Items available ex stock

DIN 352

Hand-Gewindebohrer, dreiteilige Sätze und Kernlochbohrer nach DIN 338, in Metallkassetten für Metrisches ISO-Gewinde nach DIN 13

Hand taps, serial, in set of 3 pieces and drills for Tap drill Ø hole acc. to DIN 338, in metal cases for ISO metric coarse thread as per DIN 13

M

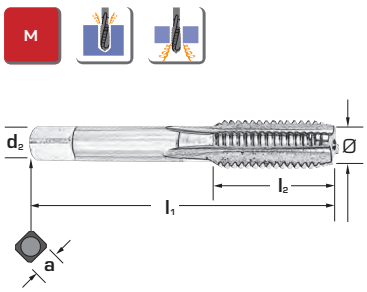
Typ / Type					-
Toleranz Tolerance					-
Anschnitt / Gangzahl Chamfer form / No. of threads					-
Schneidrichtung Cutting direction					-
Schneidstoff/ Material					HSS
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø		**6609**
				Satz in Kassette set in metal case	
M	**3**	0,50	2,5		✔
M	**4**	0,70	3,3		✔
M	**5**	0,80	4,2		✔
M	**6**	1,00	5,0		✔
M	**8**	1,25	6,8		✔
M	**10**	1,50	8,5		✔
M	**12**	1,75	10,2		✔

Die Kassette enthält Gewindebohrer Kat.-Nr. 6615 und Spiralbohrer nach DIN 338
The metal case contains hand taps Cat.-No. 6615 and twist drills Cat.-No. 6151 DIN 338

✔ Auf Anfrage / Upon request

DIN 352

Kurze Maschinen-Gewindebohrer
für Metrisches ISO-Gewinde nach DIN 13
Short machine taps
for ISO metric coarse thread as per DIN 13



Typ / Type	N	N 15°	N 40°	N 40°	N 40°	Rapid	AZ	AZ
Toleranz / Tolerance	6 H	6 H	6 H	6 H	6 G	6 H	6 H	6 H
Anschnitt / Gangzahl / Chamfer form / No. of threads	C/2,5-3	C/2,5-3	C/2,5-3	E/1,5-2	E/1,5-2	B/4-5	B/4-5	C/2,5-3
Schneidrichtung / Cutting direction								
Schneidstoff / Material	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co

Ø mm	Steigung / Pitch	Kernloch Ø / Tap drill Ø	l_1 mm	l_2 mm	l_3 mm	d_2 mm h9	a h12	6678	6659	6639	6604	6604 6G	6679	6613	6621
M 2,0	0,40	1,60	36	8	-	2,8	2,1	●	-	-	-	-	●	-	-
M 2,2	0,45	1,75	36	9	-	2,8	2,1	●	-	-	-	-	●	-	-
M 2,3*	0,40	1,90	36	9	-	2,8	2,1	●	-	-	-	-	●	-	-
M 2,5	0,45	2,05	40	9	-	2,8	2,1	●	-	-	-	-	●	-	-
M 2,6*	0,45	2,10	40	9	-	2,8	2,1	●	-	-	-	-	●	-	-
M 3,0	0,50	2,50	40	11	5	3,5	2,7	●	●	●	●	●	●	●	●
M 3,5	0,60	2,90	45	13	6	4,0	3,0	●	●	●	-	-	●	-	-
M 4,0	0,70	3,30	45	13	7	4,5	3,4	●	●	●	●	●	●	●	●
M 5,0	0,80	4,20	50	16	8	6,0	4,9	●	●	●	●	●	●	●	●
M 6,0	1,00	5,00	50	19	10	6,0	4,9	●	●	●	●	●	●	●	●
M 7,0	1,00	6,00	50	19	10	6,0	4,9	-	●	●	-	-	●	-	-
M 8,0	1,25	6,80	56	22	12	6,0	4,9	●	●	●	●	●	●	●	●
M 10,0	1,50	8,50	70	24	14	7,0	5,5	●	●	●	●	●	●	●	●
M 12,0	1,75	10,20	75	29	16	9,0	7,0	●	●	●	●	●	●	●	●
M 14,0	2,00	12,00	80	30	20	11,0	9,0	●	●	●	-	-	●	-	-
M 16,0	2,00	14,00	80	32	20	12,0	9,0	●	●	●	●	●	●	●	●
M 18,0	2,50	15,50	95	40	25	14,0	11,0	●	●	●	-	-	●	-	-
M 20,0	2,50	17,50	95	40	25	16,0	12,0	●	●	●	●	●	●	-	-
M 24,0	3,00	21,00	110	38	30	18,0	14,5	-	-	-	●	●	-	-	-

N: herkömmliche Anwendunng
universal application

N15/40°: 15°/40° Rechtsrall
15°/40° right hand helix

Rapid: Herkömmliche Anwendung
universal application

AZ: Ausgesetzte Zähne
interrupted threads

* Diese Gewinde sind im Metrischen ISO-Gewinde nicht enthalten / These sizes are not ISO standard.

● Standardartikel / Items available ex stock

DIN 352

Kurze Maschinen-Gewindebohrer
für Metrisches ISO-Gewinde nach DIN 13
Short machine taps
for ISO metric coarse thread as per DIN 13

VA 15°	VA 15°	MS	**Typ /** Type
6 HX	6 HX	6H	**Toleranz** Tolerance
C/2,5-3	E/1,5-2	E/1,5-2	**Anschnitt / Gangzahl** Chamfer form / No. of threads
			Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material

6648	6612	6624	Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø
-	-	●	M	2,0	0,40	1,60
-	-	●	M	2,2	0,45	1,75
-	-	●	M	2,3*	0,40	1,90
-	-	●	M	2,5	0,45	2,05
-	-	●	M	2,6*	0,45	2,10
●	●	●	M	3,0	0,50	2,50
●	-	●	M	3,5	0,60	2,90
●	●	●	M	4,0	0,70	3,30
●	●	●	M	5,0	0,80	4,20
●	●	●	M	6,0	1,00	5,00
-	-	●	M	7,0	1,00	6,00
●	●	●	M	8,0	1,25	6,80
●	●	●	M	10,0	1,50	8,50
●	●	●	M	12,0	1,75	10,20
●	-	-	M	14,0	2,00	12,00
●	●	-	M	16,0	2,00	14,00
-	-	-	M	18,0	2,50	15,50
-	-	-	M	20,0	2,50	17,50
-	-	-	M	24,0	3,00	21,00

VA: für rostfreien Stahl
for stainless steel

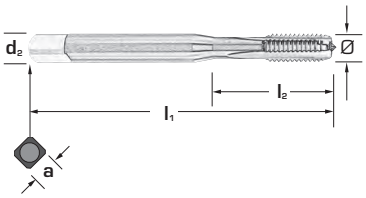
MS: für Messing
for brass

● Standardartikel / Items available ex stock

DIN 371

Maschinen-Gewindebohrer mit verstärktem Schaft
für Metrisches ISO-Gewinde nach DIN 13
Machine taps with reinforced shank
for ISO metric coarse thread as per DIN 13

M | HARD LUBE | TICN | TiN



Typ / Type	N	N	N	N
Toleranz Tolerance	6 H	6 H	6 H	6 H
Anschnitt / Gangzahl Chamfer form / No. of threads	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3
Schneidrichtung Cutting direction				
Schneidstoff/ Material	HSS-Co	HSS-Co	HSS-Co	HSS-Co

Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	l_3 mm	d_2 mm h9	a h12	6706	6706 TN	6706 TC	6712
M	1	0,25	0,75	40	5,5	-	2,5	2,1	●	●	●	-
M	1,1	0,25	0,85	40	5,5	-	2,5	2,1	●	●	●	-
M	1,2	0,25	0,95	40	5,5	-	2,5	2,1	●	●	●	-
M	1,4	0,30	1,10	40	7	-	2,5	2,1	●	●	●	-
M	1,6	0,35	1,25	40	8	-	2,5	2,1	●	●	●	-
M	1,7*	0,35	1,30	40	8	-	2,5	2,1	●	●	●	-
M	1,8	0,35	1,45	40	8	-	2,5	2,1	●	●	●	-
M	2	0,40	1,60	45	8	4	2,8	2,1	●	●	●	-
M	2,2	0,45	1,75	45	9	4	2,8	2,1	●	●	●	-
M	2,3*	0,40	1,90	45	9	4	2,8	2,1	●	●	●	-
M	2,5	0,45	2,05	50	9	4	2,8	2,1	●	●	●	-
M	2,6*	0,45	2,10	50	9	4	2,8	2,1	●	●	●	-
M	3	0,50	2,50	56	11	5	3,5	2,7	●	●	●	●
M	3*	0,60	2,40	56	11	5	3,5	2,7	●	●	●	-
M	3,5	0,60	2,90	56	13	6	4,0	3,0	●	●	●	-
M	4	0,70	3,30	63	13	7	4,5	3,4	●	●	●	●
M	4*	0,75	3,25	63	13	7	4,5	3,4	●	●	●	-
M	5	0,80	4,20	70	16	8	6,0	4,9	●	●	●	●
M	5*	0,90	4,10	70	16	8	6,0	4,9	■	●	●	-
M	6	1,00	5,00	80	19	10	6,0	4,9	●	●	●	●
M	7	1,00	6,00	80	19	10	7,0	5,5	●	●	●	-
M	8	1,25	6,80	90	22	12	8,0	6,2	●	●	●	●
M	9	1,25	7,80	90	22	12	9,0	7,0	●	●	●	-
M	10	1,50	8,50	100	24	14	10,0	8,0	●	●	●	●
Abmessungen mit Überlaufschaft über M 10 siehe Kat.-Nr / above M 10 refer to Cat.-No.									6705	6705TN	6706TC	6715

N: Herkömmliche Anwendung
universal application

* Diese Gewinde sind im Metrischen ISO-Gewinde nicht enthalten / These sizes are not ISO standard.

● Standardartikel / Items available ex stock ■ Auslaufender Artikel / discontinued item

DIN 371

Maschinen-Gewindebohrer mit verstärktem Schaft
für Metrisches ISO-Gewinde nach DIN 13
Machine taps with reinforced shank
for ISO metric coarse thread as per DIN 13

AZ	N 15°	N 15°	N 15°	N 15°	N 15°	HD 15°	HD 15°	**Typ /** Type
6 H	6 H	6 G	6 H	6 H	6 H+0,1	6H	6H	**Toleranz** Tolerance
C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	**Anschnitt / Gangzahl** Chamfer form / No. of threads
								Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material
6820	**6657**	**6657 6G**	**6657 TN**	**6657 TC**	**6902**	**6878**	**6878 HL**	**Ø mm**	**Steigung** Pitch	**Kernloch Ø** Tap drill Ø
-	-	-	-	-	-	-	-	**M 1**	0,25	0,75
-	-	-	-	-	-	-	-	**M 1,1**	0,25	0,85
-	-	-	-	-	-	-	-	**M 1,2**	0,25	0,95
-	-	-	-	-	-	-	-	**M 1,4**	0,30	1,10
-	-	-	-	-	-	-	-	**M 1,6**	0,35	1,25
-	-	-	-	-	-	-	-	**M 1,7***	0,35	1,30
-	-	-	-	-	-	-	-	**M 1,8**	0,35	1,45
●	●	●	●	●	-	-	-	**M 2**	0,40	1,60
-	●	-	●	●	-	-	-	**M 2,2**	0,45	1,75
-	●	-	●	●	-	-	-	**M 2,3***	0,40	1,90
-	●	●	●	●	-	-	-	**M 2,5**	0,45	2,05
-	●	-	●	●	-	-	-	**M 2,6***	0,45	2,10
●	●	●	●	●	●	●	●	**M 3**	0,50	2,50
-	-	-	-	-	-	-	-	**M 3***	0,60	2,40
-	●	●	●	●	-	-	-	**M 3,5**	0,60	2,90
●	●	●	●	●	●	●	●	**M 4**	0,70	3,30
-	-	-	-	-	-	-	-	**M 4***	0,75	3,25
●	●	●	●	●	●	●	●	**M 5**	0,80	4,20
-	-	-	-	-	-	-	-	**M 5***	0,90	4,10
●	●	●	●	●	●	●	●	**M 6**	1,00	5,00
-	●	●	●	●	-	-	-	**M 7**	1,00	6,00
●	●	●	●	●	●	●	●	**M 8**	1,25	6,80
-	-	-	-	-	-	-	-	**M 9**	1,25	7,80
●	●	●	●	●	●	●	●	**M 10**	1,50	8,50
	6658					6879	6679HL			

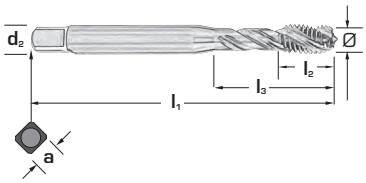
AZ: Ausgesetzte Zähne/ interrupted threads
N15°: 15° Rechtsdrall / 15°right hand helix
HD: für zähe Werkstoffe / for tough materials

● Standardartikel / Items available ex stock

DIN 371

Maschinen-Gewindebohrer mit verstärktem Schaft
für Metrisches ISO-Gewinde nach DIN 13
Machine taps with reinforced shank
for ISO metric coarse thread as per DIN 13

M TICN TiN



Typ / Type									N 40°	N/VAP 40°	N 40°	N 40°
Toleranz Tolerance									6 H	6 H	6 G	6 G*
Anschnitt / Gangzahl Chamfer form / No. of threads									C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3
Schneidrichtung Cutting direction												
Schneidstoff/ Material									HSS-Co	HSS-Co	HSS-Co	HSS-Co
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1** mm	**l_2** mm	**l_3** mm	**d_2** mm h9	**a** h12	**6644**	**6644 VP**	**6644 6G**	**6644 TN**
M	1	0,25	0,75	40	-	5,5	2,5	2,1	-	-	-	-
M	1,1	0,25	0,85	40	-	5,5	2,5	2,1	-	-	-	-
M	1,2	0,25	0,95	40	-	5,5	2,5	2,1	-	-	-	-
M	1,4	0,30	1,10	40	-	7,0	2,5	2,1	-	-	-	-
M	1,6	0,35	1,25	40	-	8,0	2,5	2,1	-	-	-	-
M	1,7*	0,35	1,30	40	-	8,0	2,5	2,1	-	-	-	-
M	1,8	0,35	1,45	40	-	8,0	2,5	2,1	-	-	-	-
M	2	0,40	1,60	45	4	8,0	2,8	2,1	●	●	●	●
M	2,2	0,45	1,75	45	4	9,0	2,8	2,1	●	●	-	-
M	2,3*	0,40	1,90	45	4	9,0	2,8	2,1	●	●	-	-
M	2,5	0,45	2,05	50	4	9,0	2,8	2,1	●	●	●	●
M	2,6*	0,45	2,10	50	4	9,0	2,8	2,1	●	●	-	-
M	3	0,50	2,50	56	5	11,0	3,5	2,7	●	●	●	●
M	3*	0,60	2,40	56	5	11,0	3,5	2,7	-	-	-	-
M	3,5	0,60	2,90	56	6	13,0	4,0	3,0	●	●	●	●
M	4	0,70	3,30	63	7	13,0	4,5	3,4	●	●	●	●
M	4*	0,75	3,25	63	7	13,0	4,5	3,4	-	-	-	-
M	5	0,80	4,20	70	8	16,0	6,0	4,9	●	●	●	●
M	5*	0,90	4,10	70	8	16,0	6,0	4,9	-	-	-	-
M	6	1,00	5,00	80	10	19,0	6,0	4,9	●	●	●	●
M	7	1,00	6,00	80	10	19,0	7,0	5,5	●	●	●	●
M	8	1,25	6,80	90	12	22,0	8,0	6,2	●	●	●	●
M	9	1,25	7,80	90	12	22,0	9,0	7,0	●	●	-	-
M	10	1,50	8,50	100	14	24,0	10,0	8,0	●	●	●	●
Abmessungen mit Überlaufschaft über M 10 siehe Kat.-Nr / above M 10 refer to Cat.-No.									6638	6638VP	66386G	6638TN

N 40°: Rechtsrall a 40° / 40° right hand helix **VAP: vaporisiert /** 40° vaporized

* Diese Gewinde sind im Metrischen ISO-Gewinde nicht enthalten / These sizes are not ISO standard. - **6 G*** Bei Bestellung bitte 6G angeben / when ordering please state 6G

● Standardartikel / Items available ex stock

DIN 371

Maschinen-Gewindebohrer mit verstärktem Schaft
für Metrisches ISO-Gewinde nach DIN 13
Machine taps with reinforced shank
for ISO metric coarse thread as per DIN 13

N 40°	N 40°	N 40°	N 40°	N Sx 40°	**Typ /** Type
7 G	6 H	6 H	6 H	6 H	**Toleranz** Tolerance
C/2,5-3	C/2,5-3	C/2,5-3	E/1,5-2	C/2,5-3	**Anschnitt / Gangzahl** Chamfer form / No. of threads
					Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material
6644 7G	**6644 TN**	**6644 TC**	**6867**	**6861**	**Ø mm**	**Steigung** Pitch	**Kernloch Ø** Tap drill Ø
---	---	---	---	---	---	---	---
-	-	-	-	-	M 1	0,25	0,75
-	-	-	-	-	M 1,1	0,25	0,85
-	-	-	-	-	M 1,2	0,25	0,95
-	-	-	-	-	M 1,4	0,30	1,10
-	-	-	-	-	M 1,6	0,35	1,25
-	-	-	-	-	M 1,7*	0,35	1,30
-	-	-	-	-	M 1,8	0,35	1,45
●	●	●	-	-	M 2	0,40	1,60
-	-	-	-	-	M 2,2	0,45	1,75
-	-	-	-	-	M 2,3*	0,40	1,90
●	●	●	-	-	M 2,5	0,45	2,05
-	-	-	-	-	M 2,6*	0,45	2,10
●	●	●	●	●	M 3	0,50	2,50
-	-	-	-	-	M 3*	0,60	2,40
-	●	●	-	-	M 3,5	0,60	2,90
●	●	●	●	●	M 4	0,70	3,30
-	-	-	-	-	M 4*	0,75	3,25
●	●	●	●	●	M 5	0,80	4,20
-	-	-	-	-	M 5*	0,90	4,10
●	●	●	●	●	M 6	1,00	5,00
-	●	-	-	-	M 7	1,00	6,00
●	●	●	●	●	M 8	1,25	6,80
-	-	-	-	-	M 9	1,25	7,80
●	●	●	●	●	M 10	1,50	8,50
66387G	6638TN	6638TC	6868	6862			

N 40°: Rechtsrall a 40° / 40° right hand helix

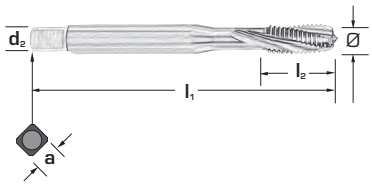
● Standardartikel / Items available ex stock

DIN 371

Maschinen-Gewindebohrer mit verstärktem Schaft
für Metrisches ISO-Gewinde nach DIN 13
Machine taps with reinforced shank
for ISO metric coarse thread as per DIN 13

M | TICN | TiN | TINOX | XP TOP

Axialer Kühlmittelaustritt
Axial internal cooling



Typ / Type									VA 15°	VAP 15°	VA 15°	VA 15°	VA i 15°
Toleranz / Tolerance									6 HX	6 HX	6 HX	6 HX	6 HX
Anschnitt / Gangzahl / Chamfer form / No. of threads									C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3
Schneidrichtung / Cutting direction													
Schneidstoff / Material									HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co
Ø mm		Steigung / Pitch	Kernloch Ø / Tap drill Ø	l_1 mm	l_2 mm	l_3 mm	d_2 mm h9	a h12	6654	6654 VP	6654 XP	6620	6620 XP
M	2	0,40	1,60	45	8	4	2,8	2,1	●	●	●	-	-
M	2,2	0,45	1,75	45	9	4	2,8	2,1	●	●	●	-	-
M	2,3*	0,40	1,90	45	9	4	2,8	2,1	●	●	●	-	-
M	2,5	0,45	2,05	50	9	4	2,8	2,1	●	●	●	-	-
M	2,6*	0,45	2,10	50	9	4	2,8	2,1	●	●	●	-	-
M	3	0,50	2,50	56	11	5	3,5	2,7	●	●	●	-	-
M	3,5	0,60	2,90	56	13	6	4,0	3,0	●	●	●	-	-
M	4	0,70	3,30	63	13	7	4,5	3,4	●	●	●	-	-
M	5	0,80	4,20	70	16	8	6,0	4,9	●	●	●	-	-
M	6	1,00	5,00	80	19	10	6,0	4,9	●	●	●	●	●
M	7	1,00	6,00	80	19	10	7,0	5,5	●	●	●	-	-
M	8	1,25	6,80	90	22	12	8,0	6,2	●	●	●	●	●
M	10	1,50	8,50	100	24	14	10,0	8,0	●	●	●	●	●
Abmessungen mit Überlaufschaft über M 10 siehe Kat.-Nr / above M 10 refer to Cat.-No.									6634	6634VP	6634XP	6605	6605XP

VA: **Für rostfreien Stahl**
for stainless steel

VA i: **Für rostfreien Stahl, con fori di lubruficazione**
for stainless steel, with internal cooling

VAP: vaporisiert / 40° vaporized

* Diese Gewinde sind im Metrischen ISO-Gewinde nicht enthalten / These sizes are not ISO standard.
Kat.Nr.6661 mit Abschrägung ab M 3, ausgenommen M 7 / Cat.-No. 6661 with back tapered from M 3 onwards, except M 7

● Standardartikel / Items available ex stock

DIN 371

Maschinen-Gewindebohrer mit verstärktem Schaft
für Metrisches ISO-Gewinde nach DIN 13
Machine taps with reinforced shank
for ISO metric coarse thread as per DIN 13

VR 35°	VRP 35°	VR 35°	VR 35°	VR 35°	VR 35°	VRP 50°	VR 50°	**Typ /** Type
6 HX	6 HX	6 G	6 HX	6 HX	6 HX	6 HX	6 HX	**Toleranz** Tolerance
C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	**Anschnitt / Gangzahl** Chamfer form / No. of threads
								Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material
6661	**6661 VP**	**6661 6G**	**6661 TN**	**6661 TX**	**6661 XP**	**6850 VP**	**6850 TN**	

			Ø mm	Steigung Pitch	Kernloch Ø Tap drill Ø
●	●	●	M 2	0,40	1,60
●	●	●	M 2,2	0,45	1,75
●	●	-	M 2,3*	0,40	1,90
●	●	●	M 2,5	0,45	2,05
●	●	-	M 2,6*	0,45	2,10
●	●	●	M 3	0,50	2,50
●	●	-	M 3,5	0,60	2,90
●	●	●	M 4	0,70	3,30
●	●	●	M 5	0,80	4,20
●	●	●	M 6	1,00	5,00
●	●	-	M 7	1,00	6,00
●	●	●	M 8	1,25	6,80
●	●	●	M 10	1,50	8,50

6662	6662VP	66626G	6662	6662TX	6662XB	6851VP	6851TN

VR: **für rostfreien Stahl, mit Abschrägung**
for stainless steel, back tapered
VRP: für rostfreien Stahl, mit Abschrägung und vaporisiert
for stainless steel, back tapered and vaporized

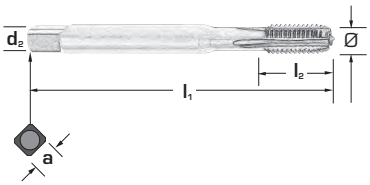
● **Standartartikel /** Items available ex stock

DIN 371

Maschinen-Gewindebohrer mit verstärktem Schaft
für Metrisches ISO-Gewinde nach DIN 13
Machine taps with reinforced shank
for ISO metric coarse thread as per DIN 13

M | TICN | TiN | TiAlN Futura

Axialer Kühlmittelaustritt
Axial internal cooling



Typ / Type									GG	GG	Multi GG i	Multi GG i	Alu 45°	BAK
Toleranz Tolerance									6 HX	6 HX	6 HX	6 HX	6 H	6 HX
Anschnitt / Gangzahl Chamfer form / No. of threads									C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	E/1,5-2
Schneidrichtung Cutting direction														
Schneidstoff/ Material									HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1** mm	**l_2** mm	**l_3** mm	**d_2** mm h9	**a** h12	**6631**	**6631 TF**	**6629**	**6629 TC**	**6643**	**6670**
M	2	0,40	1,60	45	8	4	2,8	2,1	-	-	-	-	●	●
M	2,2	0,45	1,75	45	9	4	2,8	2,1	-	-	-	-	●	-
M	2,3*	0,40	1,90	45	9	4	2,8	2,1	-	-	-	-	●	■
M	2,5	0,45	2,05	50	9	4	2,8	2,1	-	-	-	-	●	●
M	2,6*	0,45	2,10	50	9	4	2,8	2,1	-	-	-	-	●	-
M	3	0,50	2,50	56	11	5	3,5	2,7	●	●	-	-	●	●
M	3,5	0,60	2,90	56	13	6	4,0	3,0	●	●	-	-	●	●
M	4	0,70	3,30	63	13	7	4,5	3,4	●	●	-	-	●	●
M	5	0,80	4,20	70	16	8	6,0	4,9	●	●	●	●	●	●
M	6	1,00	5,00	80	19	10	6,0	4,9	●	●	●	●	●	●
M	7	1,00	6,00	80	19	10	7,0	5,5	●	●	-	-	●	■
M	8	1,25	6,80	90	22	12	8,0	6,2	●	●	●	●	●	●
M	10	1,50	8,50	100	24	14	10,0	8,0	●	●	●	●	●	●
Abmessungen mit Überlaufschaft über M 10 siehe Kat.-Nr / above M 10 refer to Cat.-No.									6632	6632TF	6637	6637TC	6651	-

Alu: **für Aluminium** for Aluminium
BAK: **für Bakelit** for bakelite
GG: **für Guss** for cast iron

* Diese Gewinde sind im Metrischen ISO-Gewinde nicht enthalten / These sizes are not ISO standard.

● Standardartikel / Items available ex stock ■ Auslaufender Artikel / discontinued items

DIN 371

Maschinen-Gewindebohrer mit verstärktem Schaft
für Metrisches ISO-Gewinde nach DIN 13
Machine taps with reinforced shank
for ISO metric coarse thread as per DIN 13

HD 40°	HD 40°	HD 40°	HD 40°	HD 40°	HR 40°	HR 40°	**Typ /** Type	
6 H	6 G	4 H	6 H	6 H	6 H	6 H	**Toleranz** Tolerance	
C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	**Anschnitt / Gangzahl** Chamfer form / No. of threads	
							Schneidrichtung Cutting direction	
HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material	
6666	**6666 6G**	**6666 4H**	**6666 TN**	**6666 TF**	**6681**	**6681 TF**	**Ø mm**	**Steigung** Pitch	**Kernloch Ø** Tap drill Ø
-	-	-	-	-	-	-	M 2	0,40	1,60
-	-	-	-	-	-	-	M 2,2	0,45	1,75
-	-	-	-	-	-	-	M 2,3*	0,40	1,90
-	-	-	-	-	-	-	M 2,5	0,45	2,05
-	-	-	-	-	-	-	M 2,6*	0,45	2,10
●	●	●	●	●	●	●	M 3	0,50	2,50
●	●	●	●	●	-	-	M 3,5	0,60	2,90
●	●	●	●	●	●	●	M 4	0,70	3,30
●	●	●	●	●	●	●	M 5	0,80	4,20
●	●	●	●	●	●	●	M 6	1,00	5,00
●	●	●	●	●	-	-	M 7	1,00	6,00
●	●	●	●	●	●	●	M 8	1,25	6,80
●	●	●	●	●	●	●	M 10	1,50	8,50
6667	-	-	6667TN	6667TF	6689	6689TF			

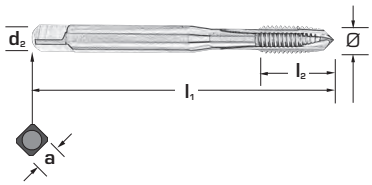
HD: **für zähe Werkstoffe**
for tough materials
HR: **für zähe Werkstoffe, mit Abschrägung**
for tough materials, back tapered

● Standardartikel / Items available ex stock

DIN 371

Maschinen-Gewindebohrer mit verstärktem Schaft
für Metrisches ISO-Gewinde nach DIN 13
Machine taps with reinforced shank
for ISO metric coarse thread as per DIN 13

M TICN TiN



Typ / Type	Rapid	VAP Rapid	Rapid	Rapid	Rapid	Rapid
Toleranz Tolerance	6 H	6 H	6 G	6 G*	4 H	7 G
Anschnitt / Gangzahl Chamfer form / No. of threads	B/4-5	B/4-5	B/4-5	B/4-5	B/4-5	B/4-5
Schneidrichtung Cutting direction						
Schneidstoff/ Material	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co

Ø mm	Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a h12	6707	6707 VP	6707 6G	6707 TN	6707 4H	6707 7G
M 2	0,40	1,60	45	8	2,8	2,1	●	●	●	●	●	●
M 2,2	0,45	1,75	45	9	2,8	2,1	●	●	●	●	●	●
M 2,3*	0,40	1,90	45	9	2,8	2,1	●	●	-	-	-	-
M 2,5	0,45	2,05	50	9	2,8	2,1	●	●	●	●	●	●
M 2,6*	0,45	2,10	50	9	2,8	2,1	●	●	-	-	-	-
M 3	0,50	2,50	56	11	3,5	2,7	●	●	●	●	●	●
M 3*	0,60	2,40	56	11	3,5	2,7	■	-	■	-	-	-
M 3,5	0,60	2,90	56	13	4,0	3,0	●	●	●	●	●	-
M 4	0,70	3,30	63	13	4,5	3,4	●	●	●	●	●	●
M 4*	0,75	3,25	63	13	4,5	3,4	■	-	-	-	-	-
M 5	0,80	4,20	70	16	6,0	4,9	●	●	●	●	●	●
M 6	1,00	5,00	80	19	6,0	4,9	●	●	●	●	●	●
M 7	1,00	6,00	80	19	7,0	5,5	●	●	●	●	●	-
M 8	1,25	6,80	90	22	8,0	6,2	●	●	●	●	●	●
M 9	1,25	7,80	90	22	9,0	7,0	●	●	-	-	-	-
M 10	1,50	8,50	100	24	10,0	8,0	●	●	●	●	●	●
Abmessungen mit Überlaufschaft über M 10 siehe Kat.-Nr / above M 10 refer to Cat.-No.							6711	6711VP	67116G	6711TN	-	67117G

Rapid: **Herkömmliche Anwendung**
universal application
VAP: **vaporisiert**
vaporized

* Diese Gewinde sind im Metrischen ISO-Gewinde nicht enthalten / These sizes are not ISO standard.

● Standardartikel / Items available ex stock ■ Auslaufender Artikel / discontinued items- **6 G*** Bei Bestellung bitte 6G angeben / when ordering please state 6G

DIN 371

Maschinen-Gewindebohrer mit verstärktem Schaft
für Metrisches ISO-Gewinde nach DIN 13
Machine taps with reinforced shank
for ISO metric coarse thread as per DIN 13

Rapid	Rapid	N sx	Rapid 2	Rapid 2	**Typ /** Type
6 H	6 H	6 H	6 H	6 G	**Toleranz** Tolerance
B/4-5	B/4-5	B/4-5	B/4-5	B/4-5	**Anschnitt / Gangzahl** Chamfer form / No. of threads
					Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material
6707 TN	**6707 TC**	**6859**	**6640**	**6640 6G**	**Ø mm**	**Steigung** Pitch	**Kernloch Ø** Tap drill Ø
●	●	-	●	●	M 2	0,40	1,60
-	-	-	●	●	M 2,2	0,45	1,75
-	-	-	●	-	M 2,3*	0,40	1,90
●	●	-	●	●	M 2,5	0,45	2,05
-	-	-	●	-	M 2,6*	0,45	2,10
●	●	●	●	●	M 3	0,50	2,50
-	-	-	-	-	M 3*	0,60	2,40
●	●	-	●	●	M 3,5	0,60	2,90
●	●	●	●	●	M 4	0,70	3,30
-	-	-	-	-	M 4*	0,75	3,25
●	●	●	●	●	M 5	0,80	4,20
●	●	●	●	●	M 6	1,00	5,00
●	-	-	●	●	M 7	1,00	6,00
●	●	●	●	●	M 8	1,25	6,80
-	-	-	-	-	M 9	1,25	7,80
●	●	●	●	●	M 10	1,50	8,50
6711TN	6711TC	6860	-	-			

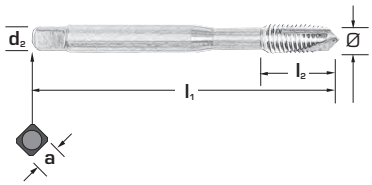
Rapid 2: **Herkömmliche Anwendung (2 Nuten)**
universal application (2 flutes)

● Standardartikel / Items available ex stock

DIN 371

Maschinen-Gewindebohrer mit verstärktem Schaft
für Metrisches ISO-Gewinde nach DIN 13
Machine taps with reinforced shank
for ISO metric coarse thread as per DIN 13

M TiN



Typ / Type	Ultra	Ultra	Ultra-S
Toleranz Tolerance	6 HX	6 GX	6 HX
Anschnitt / Gangzahl Chamfer form / No. of threads	B/4-5	B/4-5	B/4-5
Schneidrichtung Cutting direction			
Schneidstoff/ Material	HSS-Co	HSS-Co	HSS-Co

Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a h12	6606	6606 6G	6649
M	1	0,25	0,75	40	5,5	2,5	2,1	●	-	-
M	1,2	0,25	0,95	40	5,5	2,5	2,1	●	-	-
M	1,4	0,30	1,10	40	7,0	2,5	2,1	●	-	-
M	1,6	0,35	1,25	40	8,0	2,5	2,1	●	-	-
M	1,7*	0,35	1,30	40	8,0	2,5	2,1	●	-	-
M	1,8	0,35	1,45	40	8,0	2,5	2,1	●	-	-
M	2	0,40	1,60	45	8,0	2,8	2,1	●	●	●
M	2,2	0,45	1,75	45	9,0	2,8	2,1	●	●	●
M	2,3*	0,40	1,90	45	9,0	2,8	2,1	●	-	●
M	2,5	0,45	2,05	50	9,0	2,8	2,1	●	●	●
M	2,6*	0,45	2,10	50	9,0	2,8	2,1	●	-	●
M	3	0,50	2,50	56	11,0	3,5	2,7	●	●	●
M	3,5	0,60	2,90	56	13,0	4,0	3,0	●	●	●
M	4	0,70	3,30	63	13,0	4,5	3,4	●	●	●
M	4*	0,75	3,25	63	13,0	4,5	3,4	■	-	-
M	5	0,80	4,20	70	16,0	6,0	4,9	●	●	●
M	6	1,00	5,00	80	19,0	6,0	4,9	●	●	●
M	7	1,00	6,00	80	19,0	7,0	5,5	●	●	●
M	8	1,25	6,80	90	22,0	8,0	6,2	●	●	●
M	9	1,25	7,80	90	22,0	9,0	7,0	●	-	●
M	10	1,50	8,50	100	24,0	10,0	8,0	●	●	●
Abmessungen mit Überlaufschaft über M 10 siehe Kat.-Nr / above M 10 refer to Cat.-No.								-	-	-

Ultra: **für Bleche**
for sheet metals
Ultra-s: **mit Schmiernuten für Bleche**
with coolant grooves for sheet metals

* Diese Gewinde sind im Metrischen ISO-Gewinde nicht enthalten / These sizes are not ISO standard.

● Standardartikel / Items available ex stock ■ Auslaufender Artikel / discontinued items

DIN 371

Maschinen-Gewindebohrer mit verstärktem Schaft
für Metrisches ISO-Gewinde nach DIN 13
Machine taps with reinforced shank
for ISO metric coarse thread as per DIN 13

Ultra-S	Ultra-S	AZ	NL15°	**Typ /** Type
6 GX	6 HX	6 H	6 H	**Toleranz** Tolerance
B/4-5	B/4-5	B/4-5	D/4-5	**Anschnitt / Gangzahl** Chamfer form / No. of threads
				Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material

6649 6G	6649 TN	6616	6727	Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø
-	-	-	-	M	1	0,25	0,75
-	-	-	-	M	1,2	0,25	0,95
-	-	-	-	M	1,4	0,30	1,10
-	-	-	-	M	1,6	0,35	1,25
-	-	-	-	M	1,7*	0,35	1,30
-	-	-	-	M	1,8	0,35	1,45
-	●	●	-	M	2	0,40	1,60
●	-	●	-	M	2,2	0,45	1,75
-	-	●	-	M	2,3*	0,40	1,90
●	-	●	-	M	2,5	0,45	2,05
-	-	●	-	M	2,6*	0,45	2,10
●	●	●	●	M	3	0,50	2,50
●	-	●	●	M	3,5	0,60	2,90
●	●	●	●	M	4	0,70	3,30
-	-	-	-	M	4*	0,75	3,25
●	●	●	●	M	5	0,80	4,20
●	●	●	●	M	6	1,00	5,00
■	●	●	-	M	7	1,00	6,00
●	-	●	●	M	8	1,25	6,80
-	-	-	-	M	9	1,25	7,80
●	-	●	●	M	10	1,50	8,50
-	-	6617	6740				

Ultra-s: **mit Schmiernuten für Bleche**
with coolant grooves for sheet metals

AZ: **mit Schmiernuten für Bleche**
interrupted threads

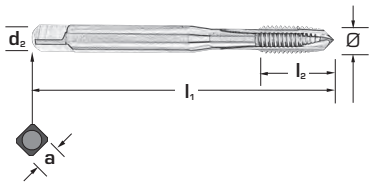
NL15°: **15° Linksdrall**
15° left hand helix

● **Standardartikel /** Items available ex stock

DIN 371

Maschinen-Gewindebohrer mit verstärktem Schaft
für Metrisches ISO-Gewinde nach DIN 13
Machine taps with reinforced shank
for ISO metric coarse thread as per DIN 13

M | TiN | TINOX | XP TOP | TiAlN Futura



Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a h12	6646	6646 XP	6646 VP	6646 TN	6646 TX	6646 6G
Typ / Type								VA	VA	VAP	VA	VA	VA
Toleranz Tolerance								6 HX	6 HX	6 HX	6 HX	6 HX	6 GX
Anschnitt / Gangzahl Chamfer form / No. of threads								B/4-5	B/4-5	B/4-5	B/4-5	B/4-5	B/4-5
Schneidrichtung Cutting direction													
Schneidstoff/ Material								HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co
M	1	0,25	0,75	40	5,5	2,5	2,1	-	-	-	-	-	-
M	1,2	0,25	0,95	40	5,5	2,5	2,1	-	-	-	-	-	-
M	1,4	0,30	1,10	40	7,0	2,5	2,1	-	-	-	-	-	-
M	1,6	0,35	1,25	40	8,0	2,5	2,1	-	-	-	-	-	-
M	1,7*	0,35	1,30	40	8,0	2,5	2,1	-	-	-	-	-	-
M	1,8	0,35	1,45	40	8,0	2,5	2,1	-	-	-	-	-	-
M	2	0,40	1,60	45	8,0	2,8	2,1	●	●	●	●	●	●
M	2,2	0,45	1,75	45	9,0	2,8	2,1	●	●	●	●	●	●
M	2,3*	0,40	1,90	45	9,0	2,8	2,1	●	-	●	●	●	-
M	2,5	0,45	2,05	50	9,0	2,8	2,1	●	●	●	●	●	●
M	2,6*	0,45	2,10	50	9,0	2,8	2,1	●	-	●	●	●	-
M	3	0,50	2,50	56	11,0	3,5	2,7	●	●	●	●	●	●
M	3,5	0,60	2,90	56	13,0	4,0	3,0	●	-	●	●	●	-
M	4	0,70	3,30	63	13,0	4,5	3,4	●	●	●	●	●	●
M	4*	0,75	3,25	63	13,0	4,5	3,4	-	-	-	-	-	-
M	5	0,80	4,20	70	16,0	6,0	4,9	●	●	●	●	●	●
M	6	1,00	5,00	80	19,0	6,0	4,9	●	●	●	●	●	●
M	7	1,00	6,00	80	19,0	7,0	5,5	●	-	●	●	●	-
M	8	1,25	6,80	90	22,0	8,0	6,2	●	●	●	●	●	●
M	9	1,25	7,80	90	22,0	9,0	7,0	-	-	-	-	-	-
M	10	1,50	8,50	100	24,0	10,0	8,0	●	●	●	●	●	●
Abmessungen mit Überlaufschaft über M 10 siehe Kat.-Nr / above M 10 refer to Cat.-No.								6647	6647XP	6647VP	-	6647XP	66476G

VA: **Für rostfreien Stahl**
for stainless steel
VAP: **vaporisiert**
vaporized

* Diese Gewinde sind im Metrischen ISO-Gewinde nicht enthalten / These sizes are not ISO standard.

● Standardartikel / Items available ex stock

DIN 371

Maschinen-Gewindebohrer mit verstärktem Schaft
für Metrisches ISO-Gewinde nach DIN 13
Machine taps with reinforced shank
for ISO metric coarse thread as per DIN 13

Alu	HD	HD	HD	**Typ /** Type
6 H	6 H	6 H	6 H	**Toleranz** Tolerance
B/4-5	B/4-5	B/4-5	B/4-5	**Anschnitt / Gangzahl** Chamfer form / No. of threads
				Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material
6641	**6870**	**6870 TN**	**6870 TF**	**Ø mm**	**Steigung** Pitch	**Kernloch Ø** Tap drill Ø
---	---	---	---	---	---	---
-	-	-	-	M 1	0,25	0,75
-	-	-	-	M 1,2	0,25	0,95
-	-	-	-	M 1,4	0,30	1,10
-	-	-	-	M 1,6	0,35	1,25
-	-	-	-	M 1,7*	0,35	1,30
-	-	-	-	M 1,8	0,35	1,45
●	●	●	●	M 2	0,40	1,60
●	●	●	●	M 2,2	0,45	1,75
●	-	-	-	M 2,3*	0,40	1,90
●	●	●	●	M 2,5	0,45	2,05
●	-	-	-	M 2,6*	0,45	2,10
●	●	●	●	M 3	0,50	2,50
●	-	-	-	M 3,5	0,60	2,90
●	●	●	●	M 4	0,70	3,30
-	-	-	-	M 4*	0,75	3,25
●	●	●	●	M 5	0,80	4,20
●	●	●	●	M 6	1,00	5,00
●	●	●	●	M 7	1,00	6,00
●	●	●	●	M 8	1,25	6,80
-	-	-	-	M 9	1,25	7,80
●	●	●	●	M 10	1,50	8,50
6642	**6871**	**6871TN**	**6871TF**			

HD: **für zähe Werkstoffe**
for tough materials
Alu: **für Aluminium**
for Aluminium

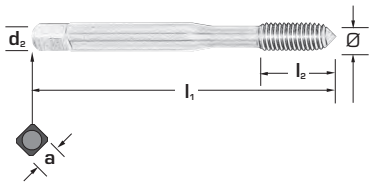
● Standardartikel / Items available ex stock

DIN 371

Innengewinde-Former mit verstärktem Schaft
für Metrisches ISO-Gewinde nach DIN 13
Cold forming taps with reinforced shank
for ISO metric coarse thread as per DIN 13

Ref. **6722 – 6622** mit Schmiernuten / with coolant grooves

M | TiN | TINOX | TiAlN Futura



Typ / Type	Former	Former	Former	Former
Toleranz Tolerance	6 HX	6 GX	6 HX	6 GX
Anschnitt / Gangzahl Chamfer form / No. of threads	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3
Schneidrichtung Cutting direction				
Schneidstoff/ Material	HSS-Co	HSS-Co	HSS-Co	HSS-Co

Ø mm	Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a h12	6722	6622	6722 BL	6622 BL
M 1**	0,25	0,88	40	5,5	2,5	2,1	●	-	●	-
M 1,1**	0,25	0,98	40	5,5	2,5	2,1	●	-	●	-
M 1,2**	0,25	1,08	40	5,5	2,5	2,1	●	-	●	-
M 1,4**	0,30	1,25	40	7,0	2,5	2,1	●	-	●	-
M 1,6	0,35	1,45	40	8,0	2,5	2,1	●	-	●	-
M 1,7*	0,35	1,55	40	8,0	2,5	2,1	●	-	●	-
M 1,8	0,35	1,65	40	8,0	2,5	2,1	●	-	●	-
M 2	0,40	1,80	45	8,0	2,8	2,1	●	●	●	●
M 2,2	0,45	2,00	45	9,0	2,8	2,1	●	-	●	-
M 2,3*	0,40	2,10	45	9,0	2,8	2,1	●	-	●	-
M 2,5	0,45	2,30	50	9,0	2,8	2,1	●	●	●	●
M 2,6*	0,45	2,40	50	9,0	2,8	2,1	●	-	●	-
M 3	0,50	2,75	56	11,0	3,5	2,7	●	●	●	●
M 3,5	0,60	3,20	56	13,0	4,0	3,0	●	●	●	●
M 4	0,70	3,65	63	13,0	4,5	3,4	●	●	●	●
M 5	0,80	4,60	70	16,0	6,0	4,9	●	●	●	●
M 6	1,00	5,50	80	19,0	6,0	4,9	●	●	●	●
M 7	1,00	6,50	80	19,0	7,0	5,5	●	-	●	-
M 8	1,25	7,40	90	22,0	8,0	6,2	●	●	●	●
M 10	1,50	9,30	100	24,0	10,0	8,0	●	●	●	●
Abmessungen mit Überlaufschaft über M 10 siehe Kat.-Nr / above M 10 refer to Cat.-No.							6723	6623	6723	6623

* Diese Gewinde sind im Metrischen ISO-Gewinde nicht enthalten / These sizes are not ISO standard.
** Toleranz 5H / Tolerance 5H

● Standardartikel / Items available ex stock

DIN 371

Innengewinde-Former mit verstärktem Schaft
für Metrisches ISO-Gewinde nach DIN 13
Cold forming taps with reinforced shank
for ISO metric coarse thread as per DIN 13

Ref. **6722 – 6622** mit Schmiernuten / with coolant grooves

Former	Former	Former	Former	Former	Former	**Typ /** Type
6 HX	6 GX	6 HX	6 GX	6 HX	6 GX	**Toleranz** Tolerance
C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	**Anschnitt / Gangzahl** Chamfer form / No. of threads
						Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material

6722 TN	6622 TN	6722 TF	6622 TF	6722 TX	6622 TX	Ø mm	Steigung Pitch	Kernloch Ø Tap drill Ø
●	-	●	-	●	-	M 1**	0,25	0,88
●	-	●	-	●	-	M 1,1**	0,25	0,98
●	-	●	-	●	-	M 1,2**	0,25	1,08
●	-	●	-	●	-	M 1,4**	0,30	1,25
●	-	●	-	●	-	M 1,6	0,35	1,45
●	-	●	-	●	-	M 1,7*	0,35	1,55
●	-	●	-	●	-	M 1,8	0,35	1,65
●	●	●	●	●	●	M 2	0,40	1,80
●	-	●	-	●	-	M 2,2	0,45	2,00
●	-	●	-	●	-	M 2,3*	0,40	2,10
●	●	●	●	●	●	M 2,5	0,45	2,30
●	-	●	-	●	-	M 2,6*	0,45	2,40
●	●	●	●	●	●	M 3	0,50	2,75
●	●	●	●	●	●	M 3,5	0,60	3,20
●	●	●	●	●	●	M 4	0,70	3,65
●	●	●	●	●	●	M 5	0,80	4,60
●	●	●	●	●	●	M 6	1,00	5,50
●	-	●	-	●	-	M 7	1,00	6,50
●	●	●	●	●	●	M 8	1,25	7,40
●	●	●	●	●	●	M 10	1,50	9,30
6723TN	6623TN	6723TF	6623TF	6723TX	6623TX			

* Diese Gewinde sind im Metrischen ISO-Gewinde nicht enthalten / These sizes are not ISO standard.
** Toleranz 5H / Tolerance 5H

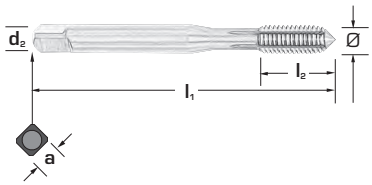
● Standardartikel / Items available ex stock

DIN 371

Innengewinde-Former mit verstärktem Schaft
für Metrisches ISO-Gewinde nach DIN 13
Cold forming taps with reinforced shank
for ISO metric coarse thread as per DIN 13

Ref. **6709 – 6819** mit Schmiernuten / with coolant grooves

M | TiN | TINOX | TiAlN Futura



Typ / Type								Former s	Former s	Former s	Former s
Toleranz Tolerance								6 HX	6 GX	6 HX	6 GX
Anschnitt / Gangzahl Chamfer form / No. of threads								C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3
Schneidrichtung Cutting direction											
Schneidstoff/ Material								HSS-Co	HSS-Co	HSS-Co	HSS-Co
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1** mm	**l_2** mm	**d_2** mm h9	**a** h12	**6709**	**6808**	**6709 BL**	**6808 BL**
M	**3,0**	0,50	2,75	56	11	3,5	2,7	●	●	●	●
M	**3,5**	0,60	3,20	56	13	4,0	3,0	●	●	●	●
M	**4,0**	0,70	3,65	63	13	4,5	3,4	●	●	●	●
M	**5,0**	0,80	4,60	70	16	6,0	4,9	●	●	●	●
M	**6,0**	1,00	5,50	80	19	6,0	4,9	●	●	●	●
M	**7,0**	1,00	6,50	80	19	7,0	5,5	●	-	●	-
M	**8,0**	1,25	7,40	90	22	8,0	6,2	●	●	●	●
M	**10,0**	1,50	9,30	100	24	10,0	8,0	●	●	●	●
Abmessungen mit Überlaufschaft über M 10 siehe Kat.-Nr / above M 10 refer to Cat.-No.								6725	6809	6725	6809

Former s: mit Schmiernuten
with coolant grooves

● Standardartikel / Items available ex stock

DIN 371

Innengewinde-Former mit verstärktem Schaft
für Metrisches ISO-Gewinde nach DIN 13
Cold forming taps with reinforced shank
for ISO metric coarse thread as per DIN 13

Ref. **6709 – 6819** mit Schmiernuten / with coolant grooves

Former s	Former s	Former s	Former s	Former s	Former s	Former s	**Typ /** Type
6 HX	6 GX	6 HX	6 GX	6 HX	6 GX	7 GX	**Toleranz** Tolerance
C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	**Anschnitt / Gangzahl** Chamfer form / No. of threads
							Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material
6709 TN	**6808 TN**	**6709 TF**	**6808 TF**	**6709 TX**	**6808 TX**	**6819**	**Ø mm**	**Steigung** Pitch	**Kernloch Ø** Tap drill Ø
●	●	●	●	●	●	-	**M 3,0**	0,50	2,75
●	●	●	●	●	●	-	**M 3,5**	0,60	3,20
●	●	●	●	●	●	-	**M 4,0**	0,70	3,65
●	●	●	●	●	●	-	**M 5,0**	0,80	4,60
●	●	●	●	●	●	●	**M 6,0**	1,00	5,50
●	-	●	-	●	-	-	**M 7,0**	1,00	6,50
●	●	●	●	●	●	●	**M 8,0**	1,25	7,40
●	●	●	●	●	●	●	**M 10,0**	1,50	9,30
6725TN	6809TN	6725TF	6809TF	6725TX	6809TX	-			

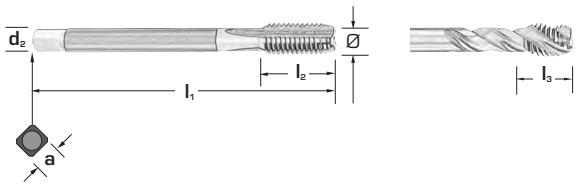
Former s: mit Schmiernuten
with coolant grooves

● Standardartikel / Items available ex stock

DIN 376

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Gewinde nach DIN 13
Machine taps with reduced shank
for ISO-metric coarse thread as per DIN 13

M | TiN | TICN



Typ / Type	N	N	N	N	AZ	N 15°	N 15°	N 15°	N 15°
Toleranz Tolerance	6 H	6 H	6 H	6 H	6 H	6 H	6 H	6 H	6 H+0,1
Anschnitt / Gangzahl Chamfer form / No. of threads	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3
Schneidrichtung Cutting direction									
Schneidstoff/ Material	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co

Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	l_3 mm	d_2 mm h9	a h12	6705	6705 TN	6705 TC	6715	6821	6658	6658 TN	6658 TC	6903
M	2	0,40	1,60	45	8	-	1,4	-	●	●	●	-	-	-	-	-	-
M	2,2	0,45	1,75	45	9	-	1,6	-	■	-	-	-	-	-	-	-	-
M	2,3*	0,40	1,90	45	9	-	1,6	-	●	●	●	-	-	-	-	-	-
M	2,5	0,45	2,05	50	9	-	1,8	-	●	●	●	-	-	-	-	-	-
M	2,6*	0,45	2,10	50	9	4	1,8	-	●	●	●	-	-	-	-	-	-
M	3	0,50	2,50	56	11	5	2,2	-	●	●	●	-	-	-	-	-	-
M	3,5	0,60	2,90	56	13	6	2,5	2,1	●	●	●	-	-	-	-	-	-
M	4	0,70	3,30	63	13	7	2,8	2,1	●	●	●	-	-	-	-	-	-
M	5	0,80	4,20	70	16	8	3,5	2,7	●	●	●	-	-	-	-	-	-
M	6	1,00	5,00	80	19	10	4,5	3,4	●	●	●	-	●	-	-	-	-
M	7	1,00	6,00	80	19	10	5,5	4,3	●	●	●	-	-	-	-	-	-
M	8	1,25	6,80	90	22	12	6,0	4,9	●	●	●	-	●	●	●	●	-
M	9	1,25	7,80	90	22	19	7,0	5,5	●	●	●	-	-	-	-	-	-
M	10	1,50	8,50	100	24	14	7,0	5,5	●	●	●	-	●	●	●	●	-
M	12	1,75	10,20	110	29	16	9,0	7,0	●	●	●	●	●	●	●	●	●
M	14	2,00	12,00	110	30	20	11,0	9,0	●	●	●	●	-	●	●	●	●
M	16	2,00	14,00	110	32	20	12,0	9,0	●	●	●	●	●	●	●	●	●
M	18	2,50	15,50	125	34	24	14,0	11,0	●	●	●	●	-	●	●	●	-
M	20	2,50	17,50	140	34	25	16,0	12,0	●	●	●	●	●	●	●	●	●
M	22	2,50	19,50	140	34	25	18,0	14,5	●	●	●	●	-	●	●	●	-
M	24	3,00	21,00	160	38	30	18,0	14,5	●	●	●	●	●	●	●	●	-
M	27	3,00	24,00	160	38	30	20,0	16,0	●	●	●	-	-	●	●	●	-
M	30	3,50	26,50	180	45	35	22,0	18,0	●	●	●	-	-	●	●	●	-
M	33	3,50	29,50	180	50	-	25,0	20,0	●	●	●	-	-	-	-	-	-
M	36	4,00	32,00	200	56	-	28,0	22,0	●	●	●	-	-	-	-	-	-
M	39	4,00	35,00	200	60	-	32,0	24,0	●	●	●	-	-	-	-	-	-
M	42	4,50	37,50	200	60	-	32,0	24,0	●	●	●	-	-	-	-	-	-
M	45	4,50	40,50	220	65	-	36,0	29,0	●	●	●	-	-	-	-	-	-
M	48	5,00	43,00	250	70	-	36,0	29,0	●	●	●	-	-	-	-	-	-
M	52	5,00	47,00	250	70	-	40,0	32,0	●	●	●	-	-	-	-	-	-

N: Herkömmliche Anwendung universal application

N 15°: 15° Rechtsdrall 15° right hand helix

AZ : Ausgesetzte Zähne interrupted threads

* Diese Gewinde sind im Metrischen ISO-Gewinde nicht enthalten / These sizes are not ISO standard.

● Standardartikel / Items available ex stock ■ Auslaufender Artikel / discontinued items

DIN 376

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Gewinde nach DIN 13
Machine taps with reduced shank
for ISO-metric coarse thread as per DIN 13

N 40°	N VAP 40°	N 40°	N 40°	N 40°	N 40°	N 40°	N Sx 40°	**Typ /** Type
6 H	6 H	6 G	7 G	6 H	6 H	6 H	6 H	**Toleranz** Tolerance
C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	E/1,5-2	C/2,5-3	**Anschnitt / Gangzahl** Chamfer form / No. of threads
								Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material

6638	6638 VP	6638 6G	6638 7G	6638 TN	6638 TC	6868	6862	Ø mm	Steigung Pitch	Kernloch Ø Tap drill Ø
-	-	-	-	-	-	-	-	M 2	0,40	1,60
-	-	-	-	-	-	-	-	M 2,2	0,45	1,75
-	-	-	-	-	-	-	-	M 2,3*	0,40	1,90
-	-	-	-	-	-	-	-	M 2,5	0,45	2,05
-	-	-	-	-	-	-	-	M 2,6*	0,45	2,10
●	●	●	-	-	-	-	-	M 3	0,50	2,50
●	●	●	-	-	-	-	-	M 3,5	0,60	2,90
●	●	●	-	-	-	-	-	M 4	0,70	3,30
●	●	●	-	-	-	-	-	M 5	0,80	4,20
●	●	●	-	-	-	-	-	M 6	1,00	5,00
●	●	-	-	-	-	-	-	M 7	1,00	6,00
●	●	●	●	-	-	-	-	M 8	1,25	6,80
●	●	-	-	-	-	-	-	M 9	1,25	7,80
●	●	●	●	-	-	-	-	M 10	1,50	8,50
●	●	●	●	●	●	●	●	M 12	1,75	10,20
●	●	●	-	●	●	●	●	M 14	2,00	12,00
●	●	●	●	●	●	●	●	M 16	2,00	14,00
●	●	●	-	●	●	●	●	M 18	2,50	15,50
●	●	●	●	●	●	●	●	M 20	2,50	17,50
●	●	●	-	-	-	-	-	M 22	2,50	19,50
●	●	●	●	-	-	-	-	M 24	3,00	21,00
●	●	-	-	-	-	-	-	M 27	3,00	24,00
●	●	●	-	-	-	-	-	M 30	3,50	26,50
●	●	-	-	-	-	-	-	M 33	3,50	29,50
●	●	-	-	-	-	-	-	M 36	4,00	32,00
-	-	-	-	-	-	-	-	M 39	4,00	35,00
-	-	-	-	-	-	-	-	M 42	4,50	37,50
-	-	-	-	-	-	-	-	M 45	4,50	40,50
-	-	-	-	-	-	-	-	M 48	5,00	43,00
-	-	-	-	-	-	-	-	M 52	5,00	47,00

N 40°: **Rechtsrall a 40°**
40° right hand helix

VAP: **vaporisiert**
vaporized

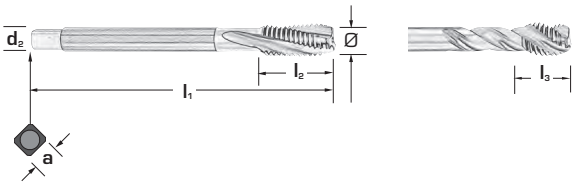
● Standardartikel / Items available ex stock

DIN 376

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Gewinde nach DIN 13
Machine taps with reduced shank
for ISO-metric coarse thread as per DIN 13

M | TiN | TINOX | XP TOP

Axialer Kühlmittelaustritt
Axial internal cooling



Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	l_3 mm	d_2 mm h9	a h12	VA 15° 6634	VA i 15° 6605	VA i 15° 6605 XP
									6 HX C/2,5-3 HSS-Co	6 HX C/2,5-3 HSS-Co	6 HX C/2,5-3 HSS-Co
M	12	1,75	10,2	110	29	16	9	7,0	●	●	●
M	14	2,00	12,0	110	30	20	11	9,0	●	-	-
M	16	2,00	14,0	110	32	20	12	9,0	●	●	●
M	18	2,50	15,5	125	34	24	14	11,0	●	-	-
M	20	2,50	17,5	140	34	25	16	12,0	●	●	●
M	22	2,50	19,5	140	34	25	18	14,5	●	-	-
M	24	3,00	21,0	160	38	30	18	14,5	●	-	-

VA: **Für rostfreien Stahl**
for stainless steel

VA i: **Für rostfreien Stahl mit Innenkühlung**
for stainless steel, with internal cooling

● Standardartikel / Items available ex stock

DIN 376

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Gewinde nach DIN 13
Machine taps with reduced shank
for ISO-metric coarse thread as per DIN 13

VR 35°	VRP 35°	VR 35°	VR 35°	VR 35°	VRP 50°	VR 50°	**Typ /** Type
6 HX	6 HX	6 HX	6 HX	6 GX	6 HX	6 HX	**Toleranz** Tolerance
C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	**Anschnitt / Gangzahl** Chamfer form / No. of threads
							Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material
6662	**6662 VP**	**6662 TX**	**6662 XP**	**6662 6G**	**6851 VP**	**6851 TN**	**Ø mm**	**Steigung** Pitch	**Kernloch Ø** Tap drill Ø
●	●	●	●	●	●	●	**M 12**	1,75	10,2
●	●	●	●	●	●	●	**M 14**	2,00	12,0
●	●	●	●	●	●	●	**M 16**	2,00	14,0
●	●	●	●	-	●	●	**M 18**	2,50	15,5
●	●	●	●	-	●	●	**M 20**	2,50	17,5
●	●	●	●	-	-	-	**M 22**	2,50	19,5
●	●	●	●	-	●	●	**M 24**	3,00	21,0

VR: **Für rostfreien Stahl, mit Abschrägung**
for stainless steel, back tapered
VRP: **Für rostfreien Stahl mit Abschrägung und vaporisiert**
for stainless steel, back tapered and vaporized

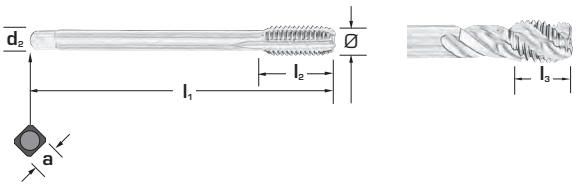
● Standardartikel / Items available ex stock

DIN 376

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Gewinde nach DIN 13
Machine taps with reduced shank
for ISO-metric coarse thread as per DIN 13

M | TICN | TiN | HARD LUBE | TiAlN Futura

Axialer Kühlmittelaustritt
Axial internal cooling



Typ / Type									GG	GG	Multi GGi	Multi GGi	Alu 45°
Toleranz Tolerance									6 HX	6 HX	6 HX	6 HX	6 HX
Anschnitt / Gangzahl Chamfer form / No. of threads									C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3
Schneidrichtung Cutting direction													
Schneidstoff/ Material									HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1** mm	**l_2** mm	**l_3** mm	**d_2** mm h9	**a** h12	**6632**	**6632 TF**	**6637**	**6637 TC**	**6651**
M	3	0,50	2,5	56	11	5	2,2	-	-	-	-	-	-
M	3,5	0,60	2,9	56	13	6	2,5	2,1	-	-	-	-	-
M	4	0,70	3,3	63	13	7	2,8	2,1	-	-	-	-	-
M	5	0,80	4,2	70	16	8	3,5	2,7	-	-	-	-	-
M	6	1,00	5,0	80	19	10	4,5	3,4	●	●	-	-	-
M	7	1,00	6,0	80	19	10	5,5	4,3	●	●	-	-	-
M	8	1,25	6,8	90	22	12	6,0	4,9	●	●	-	-	-
M	10	1,50	8,5	100	24	14	7,0	5,5	●	●	-	-	-
M	12	1,75	10,2	110	29	16	9,0	7,0	●	●	●	●	●
M	14	2,00	12,0	110	30	20	11,0	9,0	●	●	-	-	●
M	16	2,00	14,0	110	32	20	12,0	9,0	●	●	●	●	●
M	18	2,50	15,5	125	34	24	14,0	11,0	●	●	●	●	●
M	20	2,50	17,5	140	34	25	16,0	12,0	●	●	●	●	●
M	22	2,50	19,5	140	34	25	18,0	14,5	●	●	-	-	-
M	24	3,00	21,0	160	38	30	18,0	14,5	●	●	-	-	-
M	27	3,00	24,0	160	38	30	20,0	16,0	●	●	-	-	-
M	30	3,50	26,5	180	45	35	22,0	18,0	●	●	-	-	-

GG: **für Guss**
for cast iron
Alu: **für Aluminium**
for Aluminium

MULTI GG i: **Hochleistungs - Gewindebohrer mit Kühlkanälen für Guß**
High performance taps with internal cooling for cast iron

● Standardartikel / Items available ex stock

DIN 376

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Gewinde nach DIN 13
Machine taps with reduced shank
for ISO-metric coarse thread as per DIN 13

HD 15°	HD 15°	HD 40°	HD 40°	HD 40°	HR 40°	HR 40°	**Typ /** Type
6 H	6 H	6 H	6 H	6 H	6 H	6 H	**Toleranz** Tolerance
C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	**Anschnitt / Gangzahl** Chamfer form / No. of threads
							Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material
6879	**6879 HL**	**6667**	**6667 TN**	**6667 TF**	**6689**	**6689 TF**	**Ø mm**	**Steigung** Pitch	**Kernloch Ø** Tap drill Ø
-	-	●	●	●	-	-	**M 3**	0,50	2,5
-	-	●	●	●	-	-	**M 3,5**	0,60	2,9
-	-	●	●	●	-	-	**M 4**	0,70	3,3
-	-	●	●	●	-	-	**M 5**	0,80	4,2
-	-	●	●	●	-	-	**M 6**	1,00	5,0
-	-	●	●	●	-	-	**M 7**	1,00	6,0
-	-	●	●	●	-	-	**M 8**	1,25	6,8
-	-	●	●	●	-	-	**M 10**	1,50	8,5
●	●	●	●	●	●	●	**M 12**	1,75	10,2
●	●	●	●	●	●	●	**M 14**	2,00	12,0
●	●	●	●	●	●	●	**M 16**	2,00	14,0
●	●	●	●	●	●	●	**M 18**	2,50	15,5
●	●	●	●	●	●	●	**M 20**	2,50	17,5
●	●	-	-	-	-	-	**M 22**	2,50	19,5
●	●	-	-	-	-	-	**M 24**	3,00	21,0
●	●	-	-	-	-	-	**M 27**	3,00	24,0
●	●	-	-	-	-	-	**M 30**	3,50	26,5

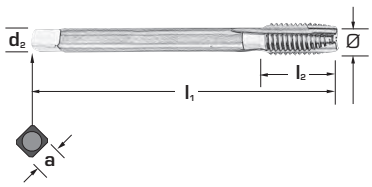
HD: **für zähe Werkstoffe**
for tough materials
HR: **für zähe Werkstoffe Abschrägung**
for tough materials, back tapered

● Standardartikel / Items available ex stock

DIN 376

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches IOS-Gewinde nach DIN 13
Machine taps with reduced shank
for ISO metric coarse thread as per DIN 13

M | TiN | TICN



Typ / Type	Rapid	Rapid VAP	Rapid	Rapid	Rapid
Toleranz / Tolerance	6 H	6 H	6 G	6 H	6 H
Anschnitt / Gangzahl / Chamfer form / No. of threads	B/4-5	B/4-5	B/4-5	B/4-5	B/4-5
Schneidrichtung / Cutting direction					
Schneidstoff / Material	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co

Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a h12	6711	6711 VP	6711 6G	6711 TN	6711 TC
M	2	0,40	1,60	45	8	1,4	-	●	●	●	-	-
M	2,2	0,45	1,75	45	9	1,6	-	●	●	-	-	-
M	2,3*	0,40	1,90	45	9	1,6	-	●	●	-	-	-
M	2,5	0,45	2,05	50	9	1,8	-	●	●	●	-	-
M	2,6*	0,45	2,10	50	9	1,8	-	●	●	-	-	-
M	3	0,50	2,50	56	11	2,2	-	●	●	●	-	-
M	3,5	0,60	2,90	56	13	2,5	2,1	●	●	●	-	-
M	4	0,70	3,30	63	13	2,8	2,1	●	●	●	-	-
M	5	0,80	4,20	70	16	3,5	2,7	●	●	●	-	-
M	6	1,00	5,00	80	19	4,5	3,4	●	●	●	-	-
M	7	1,00	6,00	80	19	5,5	4,3	●	●	-	-	-
M	8	1,25	6,80	90	22	6,0	4,9	●	●	●	-	-
M	9	1,25	7,80	90	22	7,0	5,5	●	●	-	-	-
M	10	1,50	8,50	100	24	7,0	5,5	●	●	●	-	-
M	12	1,75	10,20	110	29	9,0	7,0	●	●	●	●	●
M	14	2,00	12,00	110	30	11,0	9,0	●	●	●	●	●
M	16	2,00	14,00	110	32	12,0	9,0	●	●	●	●	●
M	18	2,50	15,50	125	34	14,0	11,0	●	●	●	●	●
M	20	2,50	17,50	140	34	16,0	12,0	●	●	●	●	●
M	22	2,50	19,50	140	34	18,0	14,5	●	●	●	-	-
M	24	3,00	21,00	160	38	18,0	14,5	●	●	●	-	-
M	27	3,00	24,00	160	38	20,0	16,0	●	●	●	-	-
M	30	3,50	26,50	180	45	22,0	18,0	●	●	-	-	-
M	33	3,50	29,50	180	50	25,0	20,0	●	●	●	-	-
M	36	4,00	32,00	200	56	28,0	22,0	●	●	●	-	-
M	39	4,00	35,00	200	60	32,0	24,0	●	●	●	-	-
M	42	4,50	37,50	200	60	32,0	24,0	●	●	●	-	-
M	45	4,50	40,50	220	65	36,0	29,0	●	●	-	-	-
M	48	5,00	43,00	250	70	36,0	29,0	●	●	●	-	-
M	52	5,00	47,00	250	70	40,0	32,0	●	●	-	-	-

Rapid: Herkömmliche Anwendung universal application **VAP:** vaporisiert vaporized

* Diese Gewinde sind im Metrischen ISO-Gewinde nicht enthalten / These sizes are not ISO standard.

● Standardartikel / Items available ex stock

DIN 376

Maschinen-Gewindebohrer mit Überlaufschaft für Metrisches IOS-Gewinde nach DIN 13
Machine taps with reduced shank for ISO metric coarse thread as per DIN 13

Rapid	N Sx				
		Typ / Type			
7 G	6 H	**Toleranz** Tolerance			
B/4-5	B/4-5	**Anschnitt / Gangzahl** Chamfer form / No. of threads			
		Schneidrichtung Cutting direction			
HSS-Co	HSS-Co	**Schneidstoff/** Material			
6711 7G	**6860**	**Ø mm**		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø
-	-	M	2	0,40	1,60
-	-	M	2,2	0,45	1,75
-	-	M	2,3*	0,40	1,90
-	-	M	2,5	0,45	2,05
-	-	M	2,6*	0,45	2,10
-	-	M	3	0,50	2,50
-	-	M	3,5	0,60	2,90
-	-	M	4	0,70	3,30
-	-	M	5	0,80	4,20
-	-	M	6	1,00	5,00
-	-	M	7	1,00	6,00
●	-	M	8	1,25	6,80
-	-	M	9	1,25	7,80
●	-	M	10	1,50	8,50
●	●	M	12	1,75	10,20
-	●	M	14	2,00	12,00
●	●	M	16	2,00	14,00
-	●	M	18	2,50	15,50
●	●	M	20	2,50	17,50
-	-	M	22	2,50	19,50
●	-	M	24	3,00	21,00
-	-	M	27	3,00	24,00
-	-	M	30	3,50	26,50
-	-	M	33	3,50	29,50
-	-	M	36	4,00	32,00
-	-	M	39	4,00	35,00
-	-	M	42	4,50	37,50
-	-	M	45	4,50	40,50
-	-	M	48	5,00	43,00
-	-	M	52	5,00	47,00

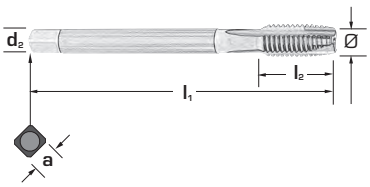
Rapid: Herkömmliche Anwendung
universal application

● Standardartikel / Items available ex stock

DIN 376

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches IOS-Gewinde nach DIN 13
Machine taps with reduced shank
for ISO metric coarse thread as per DIN 13

M | TiN | TiAlN Futura | XP TOP



Typ / Type	AZ	NL 15°	VA	VAP	VA	VA
Toleranz Tolerance	6 H	6 H	6 HX	6 HX	6 HX	6 GX
Anschnitt / Gangzahl Chamfer form / No. of threads	B/4-5	B/4-5	B/4-5	B/4-5	B/4-5	B/4-5
Schneidrichtung Cutting direction						
Schneidstoff/ Material	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co

Ø mm	Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a h12	6617	6740	6647	6647 VP	6647 XP	6647 6G
M 2	0,40	1,60	45	8	1,4	-	-	-	-	-	-	-
M 2,2	0,45	1,75	45	9	1,6	-	-	-	-	-	-	-
M 2,3*	0,40	1,90	45	9	1,6	-	-	-	-	-	-	-
M 2,5	0,45	2,05	50	9	1,8	-	-	-	-	-	-	-
M 2,6*	0,45	2,10	50	9	1,8	-	-	-	-	-	-	-
M 3	0,50	2,50	56	11	2,2	-	-	-	-	-	-	-
M 3,5	0,60	2,90	56	13	2,5	2,1	-	-	-	-	-	-
M 4	0,70	3,30	63	13	2,8	2,1	-	-	-	-	-	-
M 5	0,80	4,20	70	16	3,5	2,7	-	-	-	-	-	-
M 6	1,00	5,00	80	19	4,5	3,4	-	-	-	-	-	-
M 7	1,00	6,00	80	19	5,5	4,3	-	-	-	-	-	-
M 8	1,25	6,80	90	22	6,0	4,9	-	-	-	-	-	-
M 9	1,25	7,80	90	22	7,0	5,5	-	-	-	-	-	-
M 10	1,50	8,50	100	24	7,0	5,5	-	-	-	-	-	-
M 12	1,75	10,20	110	29	9,0	7,0	●	●	●	●	●	●
M 14	2,00	12,00	110	30	11,0	9,0	●	●	●	●	●	●
M 16	2,00	14,00	110	32	12,0	9,0	●	●	●	●	●	●
M 18	2,50	15,50	125	34	14,0	11,0	●	●	●	●	●	-
M 20	2,50	17,50	140	34	16,0	12,0	●	●	●	●	●	-
M 22	2,50	19,50	140	34	18,0	14,5	-	-	●	●	●	-
M 24	3,00	21,00	160	38	18,0	14,5	-	-	●	●	●	-
M 27	3,00	24,00	160	38	20,0	16,0	-	-	-	-	-	-
M 30	3,50	26,50	180	45	22,0	18,0	-	-	-	-	-	-

AZ: **Ausgesetzte Zähne** interrupted threads
NL15°: **15° Linksdrall** left hand helix
VAP: **vaporisiert** vaporized

* Diese Gewinde sind im Metrischen ISO-Gewinde nicht enthalten / These sizes are not ISO standard.

● Standardartikel / Items available ex stock

DIN 376

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches IOS-Gewinde nach DIN 13
Machine taps with reduced shank
for ISO metric coarse thread as per DIN 13

HD	HD	HD	Alu	**Typ /** Type
6 H	6 H	6 H	6 H	**Toleranz** Tolerance
B/4-5	B/4-5	B/4-5	B/4-5	**Anschnitt / Gangzahl** Chamfer form / No. of threads
				Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material

6871	6871 TN	6871 TF	6642	Ø mm	Steigung Pitch	Kernloch Ø Tap drill Ø
-	-	-	-	M 2	0,40	1,60
-	-	-	-	M 2,2	0,45	1,75
-	-	-	-	M 2,3*	0,40	1,90
-	-	-	-	M 2,5	0,45	2,05
-	-	-	-	M 2,6*	0,45	2,10
-	-	-	-	M 3	0,50	2,50
-	-	-	-	M 3,5	0,60	2,90
-	-	-	-	M 4	0,70	3,30
-	-	-	-	M 5	0,80	4,20
-	-	-	-	M 6	1,00	5,00
-	-	-	-	M 7	1,00	6,00
-	-	-	-	M 8	1,25	6,80
-	-	-	-	M 9	1,25	7,80
-	-	-	-	M 10	1,50	8,50
●	●	●	●	M 12	1,75	10,20
●	●	●	●	M 14	2,00	12,00
●	●	●	●	M 16	2,00	14,00
●	●	●	●	M 18	2,50	15,50
●	●	●	●	M 20	2,50	17,50
-	-	-	-	M 22	2,50	19,50
●	●	●	-	M 24	3,00	21,00
●	●	●	-	M 27	3,00	24,00
●	●	●	-	M 30	3,50	26,50

HD : **für zähe Werkstoffe**
for tough materials
Alu : **für Aluminium**
for Aluminium

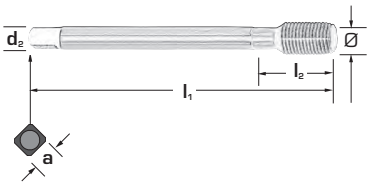
● Standardartikel / Items available ex stock

DIN 376

Maschinen-Gewindeformer mit Überlaufschaft
für Metrisches IOS-Gewinde nach DIN 13
Cold forming taps with reduced shank
for ISO metric coarse thread as per DIN

Ref. **6723 – 6623** ohne Schmiernuten / without coolant grooves

M TiN TINOX TiAlN Futura



Typ / Type								Former	Former	Former	Former
Toleranz / Tolerance								6 HX	6 GX	6 HX	6 GX
Anschnitt / Gangzahl / Chamfer form / No. of threads								C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3
Schneidrichtung / Cutting direction											
Schneidstoff / Material								HSS-Co	HSS-Co	HSS-Co	HSS-Co
Ø mm		Steigung / Pitch	Kernloch Ø / Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a h12	6723	6623	6723 BL	6623 BL
M	12	1,75	11,2	110	29	9	7	●	●	●	●
M	14	2,00	13,0	110	30	11	9	●	●	●	●
M	16	2,00	15,0	110	32	12	9	●	●	●	●

Former: **ohne Schmiernuten**
without coolant grooves

● Standardartikel / Items available ex stock

DIN 376

Maschinen-Gewindeformer mit Überlaufschaft
für Metrisches IOS-Gewinde nach DIN 13
Cold forming taps with reduced shank
for ISO metric coarse thread as per DIN

Ref. **6723 – 6623** ohne Schmiernuten / without coolant grooves

Former	Former	Former	Former	Former	Former	**Typ /** Type
6 HX	6 GX	6 HX	6 GX	6 HX	6 GX	**Toleranz** Tolerance
C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	**Anschnitt / Gangzahl** Chamfer form / No. of threads
						Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material
6723 TN	**6623 TN**	**6723 TF**	**6623 TF**	**6723 TX**	**6623 TX**	**Ø mm**	**Steigung** Pitch	**Kernloch Ø** Tap drill Ø
●	●	●	●	●	●	**M 12**	1,75	11,2
●	●	●	●	●	●	**M 14**	2,00	13,0
●	●	●	●	●	●	**M 16**	2,00	15,0

Former: **ohne Schmiernuten**
without coolant grooves

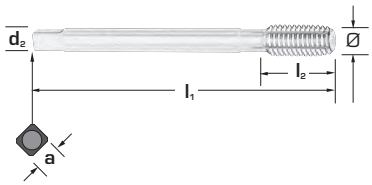
● Standardartikel / Items available ex stock

DIN 376

Maschinen-Gewindeformer mit Überlaufschaft
für Metrisches IOS-Gewinde nach DIN 13
Cold forming taps with reduced shank
for ISO metric coarse thread as per DIN

Ref. **6725 – 6809** mit Schmiernuten / with coolant grooves

M | TiN | TINOX | TiAlN Futura



Typ / Type								Former-S	Former-S	Former-S	Former-S
Toleranz / Tolerance								6 HX	6 GX	6 HX	6 GX
Anschnitt / Gangzahl / Chamfer form / No. of threads								C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3
Schneidrichtung / Cutting direction											
Schneidstoff / Material								HSS-Co	HSS-Co	HSS-Co	HSS-Co
Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a h12	6725	6809	6725 BL	6809 BL
M	12	1,75	11,2	110	29	9	7	●	●	●	●
M	14	2,00	13,0	110	30	11	9	●	●	●	●
M	16	2,00	15,0	110	32	12	9	●	●	●	●

Former S: **mit Schmiernuten**
with coolant grooves

● Standardartikel / Items available ex stock

DIN 376

Maschinen-Gewindeformer mit Überlaufschaft
für Metrisches IOS-Gewinde nach DIN 13
Cold forming taps with reduced shank
for ISO metric coarse thread as per DIN

Ref. **6725 – 6809** mit Schmiernuten / with coolant grooves

Former-S	Former-S	Former-S	Former-S	Former-S	Former-S	**Typ /** Type
6 HX	6 GX	6 HX	6 GX	6 HX	6 GX	**Toleranz** Tolerance
C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	**Anschnitt / Gangzahl** Chamfer form / No. of threads
						Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material

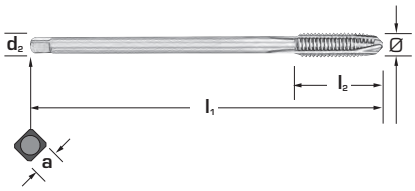
6725 TN	6809 TN	6725 TF	6809 TF	6725 TX	6809 TX	Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø
●	●	●	●	●	●	M	12	1,75	11,2
●	●	●	●	●	●	M	14	2,00	13,0
●	●	●	●	●	●	M	16	2,00	15,0

Former S: **mit Schmiernuten**
with coolant grooves

● Standardartikel / Items available ex stock

DIN 357

Maschinen-Gewindebohrer mit langem Schaft
für Metrisches ISO-Gewinde nach DIN 13
Machine taps with long shank
for ISO metric coarse thread as per DIN 13



Typ / Type	N
Toleranz Tolerance	6 H
Anschnitt / Gangzahl Chamfer form / No. of threads	B/4-5
Schneidrichtung Cutting direction	
Schneidstoff/ Material	HSS-Co

Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a h12	6672
M	3	0,50	2,5	70	18	2,2	-	●
M	4	0,70	3,3	90	22	2,8	2,1	●
M	5	0,80	4,2	100	24	3,5	2,7	●
M	6	1,00	5,0	110	25	4,5	3,4	●
M	7	1,00	6,0	110	25	5,5	4,3	●
M	8	1,25	6,8	125	28	6,0	4,9	●
M	10	1,50	8,5	140	30	7,0	5,5	●
M	12	1,75	10,2	180	35	9,0	7,0	●
M	14	2,00	12,0	200	35	11,0	9,0	●

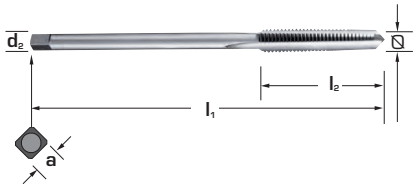
N: Herkömmliche Anwendung
universal application

● Standardartikel / Items available ex stock

DIN 357

Maschinen-Muttergewindebohrer mit langem Schaft für Metrisches ISO-Gewinde nach DIN 13

Machine nut taps with extra long lead, straight shank for ISO metric coarse thread as per DIN 13



									N
Typ / Type									
Toleranz Tolerance									6 H
Anschnitt / Gangzahl Chamfer form / No. of threads									A/6-8
Schneidrichtung Cutting direction									
Schneidstoff/ Material									HSS-Co
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1** mm	**l_2** mm	**d_2** mm h9	**a** h12		**6660**
M	**3**	0,50	2,5	70	22	2,2	-		●
M	**3,5**	0,60	2,9	80	25	2,5	2,1		●
M	**4**	0,70	3,3	90	25	2,8	2,1		●
M	**5**	0,80	4,2	100	28	3,5	2,7		●
M	**6**	1,00	5,0	110	32	4,5	3,4		●
M	**7**	1,00	6,0	110	36	5,5	4,3		●
M	**8**	1,25	6,8	125	40	6,0	4,9		●
M	**10**	1,50	8,5	140	45	7,0	5,5		●
M	**12**	1,75	10,2	180	50	9,0	7,0		●
M	**14**	2,00	12,0	200	56	11,0	9,0		●
M	**16**	2,00	14,0	200	63	12,0	9,0		●
M	**18**	2,50	15,5	220	63	14,0	11,0		●
M	**20**	2,50	17,5	250	70	16,0	12,0		●
M	**22**	2,50	19,5	280	80	18,0	14,5		●
M	**24**	3,00	21,0	280	80	18,0	14,5		●
M	**27**	3,00	24,0	315	90	20,0	16,0		●
M	**30**	3,50	26,5	315	100	22,0	18,0		●

N: Herkömmliche Anwendung
universal application

● Standardartikel / Items available ex stock

ILIX NORM

Maschinen-Gewindebohrer mit extra langem Schaft
für Metrisches ISO-Gewinde nach DIN 13
ca. doppelte Gesamtlänge wie DIN 371

Machine taps with extra long shank
for ISO metric coarse thread as per DIN 13
approx. double length of DIN 371

Typ / Type									N
Toleranz Tolerance									6 H
Anschnitt / Gangzahl Chamfer form / No. of threads									B/4-5
Schneidrichtung Cutting direction									
Schneidstoff/ Material									HSS-Co
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1 mm**	**l_2 mm**	**d_2 mm h9**	**a h12**		**6692**
M	**3**	0,5	2,5	100	11	3,5	2,7		●
M	**4**	0,7	3,3	120	13	4,5	3,4		●
M	**5**	0,8	4,2	140	15	6,0	4,9		●
M	**6**	1,0	5,0	160	17	6,0	4,9		●

● Standardartikel / Items available ex stock

ILIX NORM

Maschinen-Gewindebohrer mit extra langem Schaft
für Metrisches ISO-Gewinde nach DIN 13
ca. doppelte Gesamtlänge wie DIN 376

Machine taps with extra long shank
for ISO metric coarse thread as per DIN 13
approx. double length of DIN 3716

Typ / Type	N
Toleranz Tolerance	6 H
Anschnitt / Gangzahl Chamfer form / No. of threads	B/4-5
Schneidrichtung Cutting direction	
Schneidstoff/ Material	HSS-Co

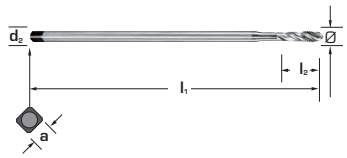
Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a h12	6695
M	8	1,25	6,8	180	20	6,0	4,9	●
M	10	1,50	8,5	200	22	7,0	5,5	●
M	12	1,75	10,2	224	24	9,0	7,0	●
M	14	2,00	12,0	224	26	11,0	9,0	●
M	16	2,00	14,0	224	27	12,0	9,0	●
M	18	2,50	15,5	250	30	14,0	11,0	●
M	20	2,50	17,5	280	32	16,0	12,0	●

● Standardartikel / Items available ex stock

ILIX NORM

Maschinen-Gewindebohrer, extra lang, 40° Rechtsdrall
für Metrisches ISO-Gewinde nach DIN 13
ca. doppelte Gesamtlänge wie DIN 371

Machine taps, extra long, 40° right hand helix
for ISO metric coarse thread as per DIN 13
approx. double length of DIN 371



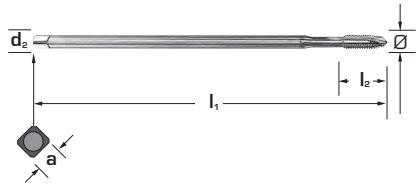
Typ / Type								N 40°
Toleranz Tolerance								6 H
Anschnitt / Gangzahl Chamfer form / No. of threads								C/2,5-3
Schneidrichtung Cutting direction								
Schneidstoff/ Material								HSS-Co
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1 mm**	**l_2 mm**	**d_2 mm h9**	**a h12**	**6840**
M	**3**	0,5	2,5	100	11	3,5	2,7	●
M	**4**	0,7	3,3	120	13	4,5	3,4	●
M	**5**	0,8	4,2	140	15	6,0	4,9	●
M	**6**	1,0	5,0	160	17	6,0	4,9	●

● Standardartikel / Items available ex stock

ILIX NORM

Maschinen-Gewindebohrer, extra lang, 40° Rechtsdrall
für Metrisches ISO-Gewinde nach DIN 13
ca. doppelte Gesamtlänge wie DIN 371

Machine taps, extra long
for ISO metric coarse thread as per DIN 13
approx. double total length of DIN 371



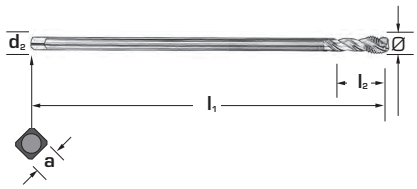
Typ / Type								N
Toleranz Tolerance								6 H
Anschnitt / Gangzahl Chamfer form / No. of threads								B/4-5
Schneidrichtung Cutting direction								
Schneidstoff/ Material								HSS-Co
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1 mm**	**l_2 mm**	**$d_2$mm h9**	**a h12**	**6842**
M	**3**	0,5	2,5	100	11	3,5	2,7	●
M	**4**	0,7	3,3	120	13	4,5	3,4	●
M	**5**	0,8	4,2	140	15	6,0	4,9	●
M	**6**	1,0	5,0	160	17	6,0	4,9	●

● Standardartikel / Items available ex stock

ILIX NORM

Maschinen-Gewindebohrer, extra lang, 40°
Rechtsdrall für Metrisches ISO-Gewinde nach DIN 13
ca. doppelte Gesamtlänge wie DIN 376

Machine taps, extra long, 40° right hand helix
for ISO metric coarse thread as per DIN 13
approx. double length of DIN 376



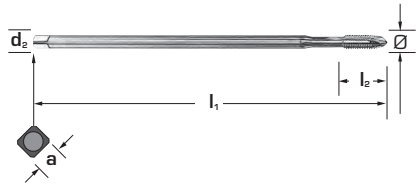
Typ / Type									N 40°
Toleranz Tolerance									6 H
Anschnitt / Gangzahl Chamfer form / No. of threads									C/2,5-3
Schneidrichtung Cutting direction									
Schneidstoff/ Material									HSS-Co
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1** mm	**l_2** mm	**d_2** mm h9	**a** h12		**6841**
M	**8**	1,25	6,8	180	20	6	4,9		●
M	**10**	1,50	8,5	200	22	7	4,9		●
M	**12**	1,75	10,2	224	24	9	7,0		●
M	**14**	2,00	12,0	224	26	11	9,0		●
M	**16**	2,00	14,0	224	27	12	9,0		●
M	**18**	2,50	15,5	250	30	14	11,0		●
M	**20**	2,50	17,5	280	32	16	12,0		●

● Standardartikel / Items available ex stock

ILIX NORM

Maschinen-Gewindebohrer, extra lang, 40° Rechtsdrall
für Metrisches ISO-Gewinde nach DIN 13
ca. doppelte Gesamtlänge wie DIN 376

Machine taps, extra long
for ISO metric coarse thread as per DIN 13
approx. double total length of DIN 376



Typ / Type									N
Toleranz Tolerance									6 H
Anschnitt / Gangzahl Chamfer form / No. of threads									B/4-5
Schneidrichtung Cutting direction									
Schneidstoff/ Material									HSS-Co
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1 mm**	**l_2 mm**	**d_2 mm h9**	**a h12**		**6843**
M	**8**	1,25	6,8	180	20	6	4,9		●
M	**10**	1,50	8,5	200	22	7	4,9		●
M	**12**	1,75	10,2	224	24	9	7,0		●
M	**14**	2,00	12,0	224	26	11	9,0		●
M	**16**	2,00	14,0	224	27	12	9,0		●
M	**18**	2,50	15,5	250	30	14	11,0		●
M	**20**	2,50	17,5	280	32	16	12,0		●

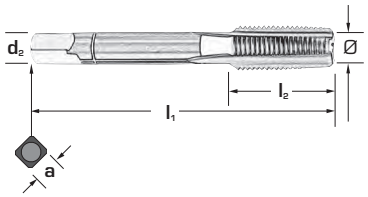
● Standardartikel / Items available ex stock

DIN 2181

Hand-Gewindebohrer, zweiteiliger Satz
für Metrisches ISO-Feingewinde nach DIN 13
Hand taps, serial, in set of 2 pieces
for ISO metric fine threads as per DIN 13

MF

Satz 6633



										N	N
Typ / Type											
Toleranz Tolerance										6 H	6 H
Anschnitt / Gangzahl Chamfer form / No. of threads										A/5-6	C/2,5-3
Schneidrichtung Cutting direction											
Schneidstoff/ Material										HSS	HSS
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1** mm	**l_2** mm	**d_2** mm h9	**a** h12			**6633 V**	**6633 F**
MF	2	0,25	1,8	36	8	2,8	2,1			●	●
MF	2,2	0,25	2,0	36	9	2,8	2,1			●	●
MF	2,3	0,25*	2,1	36	9	2,8	2,1			●	●
MF	2,5	0,35	2,2	40	9	2,8	2,1			●	●
MF	2,6	0,35	2,3	40	9	2,8	2,1			●	●
MF	3	0,35	2,7	40	9	3,5	2,7			●	●
MF	3,5	0,35	3,2	45	10	4,0	3,0			●	●
MF	4	0,50	3,5	45	10	4,5	3,4			●	●
MF	5	0,50	4,5	50	12	6,0	4,9			●	●
MF	6	0,50	5,5	50	14	6,0	4,9			●	●
MF	6	0,75	5,2	50	14	6,0	4,9			●	●
MF	7	0,75	6,2	50	14	6,0	4,9			●	●
MF	8	0,50	7,5	50	19	6,0	4,9			●	●
MF	8	0,75	7,2	50	19	6,0	4,9			●	●
MF	8	1,00	7,0	56	22	6,0	4,9			●	●
MF	9	1,00	8,0	63	22	7,0	5,5			●	●
MF	10	0,75	9,2	63	20	7,0	5,5			●	●
MF	10	1,00	9,0	63	20	7,0	5,5			●	●
MF	10	1,25	8,8	70	24	7,0	5,5			●	●
MF	11	1,00	10,0	63	20	8,0	6,2			●	●
MF	12	1,00	11,0	70	22	9,0	7,0			●	●
MF	12	1,25	10,8	70	22	9,0	7,0			●	●
MF	12	1,50	10,5	70	22	9,0	7,0			●	●
MF	14	1,00	13,0	70	22	11,0	9,0			●	●
MF	14	1,25*	12,8	70	22	11,0	9,0			●	●
MF	14	1,50	12,5	70	22	11,0	9,0			●	●
MF	15	1,00	14,0	70	22	12,0	9,0			●	●
MF	15	1,50	13,5	70	22	12,0	9,0			●	●
MF	16	1,00	15,0	70	22	12,0	9,0			●	●
MF	16	1,50	14,5	70	22	12,0	9,0			●	●
MF	18	1,00	17,0	80	22	14,0	11,0			●	●
MF	18	1,50	16,5	80	22	14,0	11,0			●	●

N: Herkömmliche Anwendung
universal application

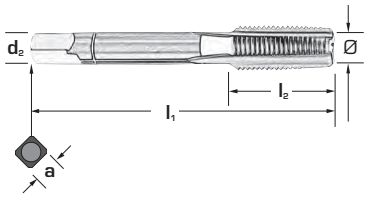
* Diese Gewinde sind im Metrischen ISO-Gewinde nicht enthalten / These sizes are not ISO standard. - Nur im Satz lieferbar. Nur Vorschneider auf Anfrage / Only available as set. Only taper Tap (No. 1) upon request.

● Standardartikel / Items available ex stock

DIN 2181

Hand-Gewindebohrer, zweiteiliger Satz
für Metrisches ISO-Feingewinde nach DIN 13
Hand taps, serial, in set of 2 pieces
for ISO metric fine threads as per DIN 13

MF **Satz 6633**



Typ / Type									N	N
Toleranz Tolerance									6 H	6 H
Anschnitt / Gangzahl Chamfer form / No. of threads									A/5-6	A/5-6
Schneidrichtung Cutting direction										
Schneidstoff/ Material									HSS	HSS
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1** mm	**l_2** mm	**d_2** mm h9	**a** h12		**6633 V**	**6633 F**
MF	18	2,0	16,00	80	22	14	11,0		●	●
MF	20	1,0	19,00	80	22	16	12,0		●	●
MF	20	1,5	18,50	80	22	16	12,0		●	●
MF	20	2,0	18,00	80	22	16	12,0		●	●
MF	22	1,0	21,00	80	22	18	14,5		●	●
MF	22	1,5	20,50	80	22	18	14,5		●	●
MF	22	2,0	20,00	80	22	18	14,5		●	●
MF	24	1,0	23,00	90	22	18	14,5		●	●
MF	24	1,5	22,50	90	22	18	14,5		●	●
MF	24	2,0	22,00	90	22	18	14,5		●	●
MF	26	1,5	24,50	90	22	18	14,5		●	●
MF	27	1,5	25,50	90	22	20	16,0		●	●
MF	27	2,0	25,00	90	22	20	16,0		●	●
MF	28	1,5	26,50	90	22	20	16,0		●	●
MF	30	1,0	29,00	90	22	22	18,0		●	●
MF	30	1,5	28,50	90	22	22	18,0		●	●
MF	30	2,0	28,00	90	22	22	18,0		●	●
MF	32	1,5	30,50	90	22	22	18,0		●	●
MF	33	1,5	31,50	100	25	25	20,0		●	●
MF	34	1,5	32,50	100	25	28	22,0		●	●
MF	35	1,5	33,50	100	25	25	20,0		●	●
MF	36	1,5	34,50	100	25	28	22,0		●	●
MF	36	3,0	33,00	125	40	28	22,0		●	●
MF	38	1,5	36,50	100	25	28	22,0		●	●
MF	40	1,5	38,50	110	25	32	24,0		●	●
MF	42	1,5	40,50	110	25	32	24,0		●	●
MF	45	1,5	43,50	110	25	36	29,0		●	●
MF	48	1,5	46,50	140	40	36	29,0		●	●
MF	48	2,0	46,00	140	40	36	29,0		●	●
MF	48	3,0	45,00	140	40	36	29,0		●	●
MF	50	1,5	48,50	140	40	36	29,0		●	●
MF	52	1,5	50,50	140	40	40	32,0		●	●

N: Herkömmliche Anwendung
universal application

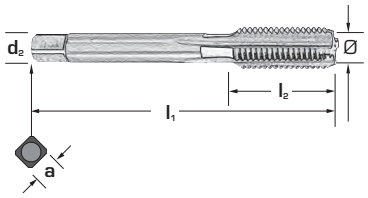
* Diese Gewinde sind im Metrischen ISO-Gewinde nicht enthalten / These sizes are not ISO standard. - Nur im Satz lieferbar. Nur Vorschneider auf Anfrage / Only available as set. Only taper Tap (No. 1) upon request.

● Standardartikel / Items available ex stock

DIN 2181

Kurze Maschinen-Gewindebohrer
für Metrisches ISO-Feingewinde nach DIN 13
Short machine taps
for ISO metric fine thread as per DIN 13

MF



Typ / Type	N	N 15°	MS
Toleranz Tolerance	6 H	6 H	6 H
Anschnitt / Gangzahl Chamfer form / No. of threads	C/2,5-3	C/2,5-3	C/2,5-3
Schneidrichtung Cutting direction			
Schneidstoff/ Material	HSS-Co	HSS-Co	HSS-Co

Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a h12	6899	6656	6724
MF	4	0,50	3,5	45	10	4,5	3,4	-	●	●
MF	5	0,50	4,5	50	12	6,0	4,9	-	●	●
MF	6	0,50	5,5	50	14	6,0	4,9	●	●	●
MF	6	0,75	5,2	50	14	6,0	4,9	●	-	●
MF	7	0,75	6,2	50	14	6,0	4,9	-	-	●
MF	8	0,50	7,5	50	19	6,0	4,9	●	●	●
MF	8	0,75	7,2	50	19	6,0	4,9	●	●	●
MF	8	1,00	7,0	56	22	6,0	4,9	●	-	●
MF	9	1,00	8,0	63	22	7,0	5,5	●	-	●
MF	10	0,75	9,2	63	20	7,0	5,5	●	-	●
MF	10	1,00	9,0	63	20	7,0	5,5	●	●	●
MF	10	1,25	8,8	70	24	7,0	5,5	●	-	●
MF	11	1,00	10,0	63	20	8,0	6,2	-	-	●
MF	12	1,00	11,0	70	22	9,0	7,0	●	●	●
MF	12	1,25	10,8	70	22	9,0	7,0	●	-	●
MF	12	1,50	10,5	70	22	9,0	7,0	●	●	●
MF	14	1,00	10,5	70	22	9,0	7,0	●	-	-
MF	14	1,25	10,5	70	22	9,0	7,0	●	-	-
MF	14	1,50	12,5	70	22	11,0	9,0	●	●	-
MF	16	1,00	12,5	70	22	11,0	9,0	●	-	-
MF	16	1,50	14,5	70	22	12,0	9,0	●	●	-
MF	18	1,00	14,5	70	22	12,0	9,0	●	-	-
MF	18	1,50	16,5	80	22	14,0	11,0	●	●	-
MF	18	2,00	16,5	80	22	14,0	11,0	●	-	-
MF	20	1,00	16,5	80	22	14,0	11,0	●	-	-
MF	20	1,50	18,5	80	22	16,0	12,0	●	●	-
MF	20	2,00	18,5	80	22	16,0	12,0	●	-	-
MF	22	1,50	20,5	80	22	18,0	14,5	-	●	-
MF	24	1,50	22,5	90	22	18,0	14,5	-	●	-

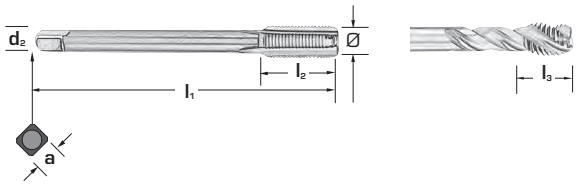
N: **Herkömmliche Anwendung** universal application
N 15°: **15° Rechtsdrall** right hand helix
MS: **für Messing** for brass

● Standardartikel / Items available ex stock

DIN 374

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Feingewinde nach DIN 13
Machine taps with reduced shank
for ISO metric fine thread as per DIN 13

MF TiN TICN



Typ / Type									N	N	N	N 15°	N 15°
Toleranz Tolerance									6 H	6 H	6 H	6 H	6 H
Anschnitt / Gangzahl Chamfer form / No. of threads									C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3
Schneidrichtung Cutting direction													
Schneidstoff/ Material									HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1** mm	**$l_{2\,MAX}$** mm	**l_3** mm	**d_2** mm h9	**a** h12	**6726**	**6726 TN**	**6726 TC**	**6664**	**6664 TN**
MF	3	0,35	2,65	56	9	5	2,2	-	●	●	●	-	-
MF	3,5	0,35	3,15	56	10	6	2,5	2,1	●	●	●	-	-
MF	4	0,50	3,50	63	10	7	2,8	2,1	●	●	●	-	-
MF	5	0,50	4,50	70	12	8	3,5	2,7	●	●	●	-	-
MF	6	0,50	5,50	80	14	10	4,5	3,4	●	●	●	-	-
MF	6	0,75	5,20	80	14	10	4,5	3,4	●	●	●	-	-
MF	7	0,75	6,20	80	14	10	5,5	4,3	●	●	●	-	-
MF	8	0,50	7,50	80	19	12	6,0	4,9	●	●	●	-	-
MF	8	0,75	7,20	80	19	12	6,0	4,9	●	●	●	●	●
MF	8	1,00	7,00	90	22	12	6,0	4,9	●	●	●	●	●
MF	9	1,00	8,00	90	22	12	7,0	5,5	●	●	●	-	-
MF	10	0,75	9,20	90	20	14	7,0	5,5	●	●	●	-	-
MF	10	1,00	9,00	90	20	14	7,0	5,5	●	●	●	●	●
MF	10	1,25	8,80	100	24	14	7,0	5,5	●	●	●	●	●
MF	11	1,00	10,00	90	20	14	8,0	6,2	●	●	●	-	-
MF	12	1,00	11,00	100	22	16	9,0	7,0	●	●	●	●	●
MF	12	1,25	10,80	100	22	16	9,0	7,0	●	●	●	-	-
MF	12	1,50	10,50	100	22	16	9,0	7,0	●	●	●	●	●
MF	14	1,00	13,00	100	22	20	11,0	9,0	●	●	●	-	-
MF	14	1,25*	12,80	100	22	20	11,0	9,0	●	●	●	-	-
MF	14	1,50	12,50	100	22	20	11,0	9,0	●	●	●	●	●
MF	15	1,00	14,00	100	22	20	12,0	9,0	●	●	●	-	-
MF	15	1,50	13,50	100	22	20	12,0	9,0	●	●	●	-	-
MF	16	1,00	15,00	100	22	20	12,0	9,0	●	●	●	-	-
MF	16	1,50	14,50	100	22	20	12,0	9,0	●	●	●	●	●
MF	18	1,00	17,00	110	25	25	14,0	11,0	●	●	●	-	-
MF	18	1,50	16,50	110	25	25	14,0	11,0	●	●	●	●	●
MF	18	2,00	16,00	125	34	25	14,0	11,0	●	●	●	-	-
MF	20	1,00	19,00	125	25	25	16,0	12,0	●	●	●	-	-
MF	20	1,50	18,50	125	25	25	16,0	12,0	●	●	●	●	●
MF	20	2,00	18,00	140	34	25	16,0	12,0	●	●	●	-	-
MF	22	1,00	21,00	125	25	25	18,0	14,5	●	●	●	-	-

N: Herkömmliche Anwendung universal application
N 15°: 15° Rechtsdrall right hand helix

* Diese Gewinde sind im Metrischen ISO-Gewinde nicht enthalten / These sizes are not ISO standard.

● Standardartikel / Items available ex stock

DIN 374

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Feingewinde nach DIN 13
Machine taps with reduced shank
for ISO metric fine thread as per DIN 13

N 15°	N 15°	N Sx 40°	N 40°	VAP 40°	N 40°	N 40°	N 40°	**Typ /** Type
6 H	6 H+0,1	6 H	6 H	6 H	6 H	6 H	6 H	**Toleranz** Tolerance
C/2,5-3	E/1-2	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	E/1-2	**Anschnitt / Gangzahl** Chamfer form / No. of threads
								Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material

6664 TC	6904	6864	6652	6652 VP	6652 TN	6652 TC	6877	Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø
-	-	-	●	●	●	●	-	MF	3	0,35	2,65
-	-	-	●	●	●	●	-	MF	3,5	0,35	3,15
-	-	-	●	●	●	●	-	MF	4	0,50	3,50
-	-	-	●	●	●	●	-	MF	5	0,50	4,50
-	-	-	●	●	●	●	●	MF	6	0,50	5,50
-	-	-	●	●	●	●	●	MF	6	0,75	5,20
-	-	-	-	-	-	-	-	MF	7	0,75	6,20
-	-	-	-	-	-	-	-	MF	8	0,50	7,50
●	-	-	●	●	●	●	●	MF	8	0,75	7,20
●	-	●	●	●	●	●	●	MF	8	1,00	7,00
-	-	-	-	-	-	-	-	MF	9	1,00	8,00
-	-	-	-	-	-	-	-	MF	10	0,75	9,20
●	-	●	●	●	●	●	●	MF	10	1,00	9,00
●	-	-	●	●	●	●	●	MF	10	1,25	8,80
-	-	-	-	-	-	-	-	MF	11	1,00	10,00
●	-	●	●	●	●	●	●	MF	12	1,00	11,00
-	-	-	-	-	-	-	●	MF	12	1,25	10,80
●	-	●	●	●	●	●	●	MF	12	1,50	10,50
-	-	-	-	-	-	-	-	MF	14	1,00	13,00
-	-	-	-	-	-	-	-	MF	14	1,25*	12,80
●	-	●	●	●	●	●	●	MF	14	1,50	12,50
-	-	-	-	-	-	-	-	MF	15	1,00	14,00
-	-	-	-	-	-	-	-	MF	15	1,50	13,50
-	●	-	-	-	-	-	-	MF	16	1,00	15,00
●	-	●	●	●	●	●	●	MF	16	1,50	14,50
-	●	-	-	-	-	-	-	MF	18	1,00	17,00
●	-	●	●	●	●	●	●	MF	18	1,50	16,50
-	-	-	-	-	-	-	-	MF	18	2,00	16,00
-	●	-	-	-	-	-	-	MF	20	1,00	19,00
●	-	●	●	●	●	●	●	MF	20	1,50	18,50
-	-	-	-	-	-	-	-	MF	20	2,00	18,00
-	●	-	-	-	-	-	-	MF	22	1,00	21,00

N 15°: 15° Rechtsdrall
right hand helix

N 40°: Rechtsrall a 40°
right hand helix

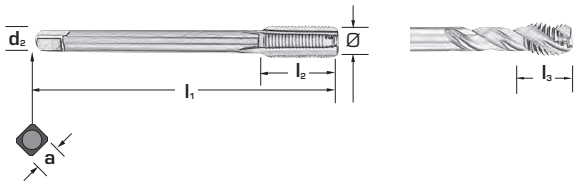
VAP: vaporisiert
vaporized

● Standardartikel / Items available ex stock

DIN 374

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Feingewinde nach DIN 13
Machine taps with reduced shank
for ISO metric fine thread as per DIN 13

MF TiN TICN



Typ / Type	N	N	N	N 15°	N 15°
Toleranz / Tolerance	6 H	6 H	6 H	6 H	6 H
Anschnitt / Gangzahl / Chamfer form / No. of threads	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3
Schneidrichtung / Cutting direction					
Schneidstoff / Material	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co

Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	$l_{2\,MAX}$ mm	l_3 mm	d_2 mm h9	a h12	6726	6726 TN	6726 TC	6664	6664 TN
MF	22	1,50	20,50	125	25	25	18,0	14,5	●	●	●	●	●
MF	22	2,00	20,00	140	34	25	18,0	14,5	●	●	●	-	-
MF	24	1,00	23,00	140	28	28	18,0	14,5	●	●	●	-	-
MF	24	1,50	22,50	140	28	28	18,0	14,5	●	●	●	●	●
MF	24	2,00	22,00	140	28	28	18,0	14,5	●	●	●	-	-
MF	26	1,50	24,50	140	28	28	18,0	14,5	●	●	●	●	●
MF	27	1,50	25,50	140	28	28	20,0	16,0	●	●	●	●	●
MF	27	2,00	25,00	140	28	28	20,0	16,0	●	●	●	●	●
MF	28	1,50	26,50	140	28	28	20,0	16,0	●	●	●	●	●
MF	30	1,00	29,00	150	28	28	22,0	18,0	●	●	●	-	-
MF	30	1,50	28,50	150	28	28	22,0	18,0	●	●	●	●	●
MF	30	2,00	28,00	150	28	28	22,0	18,0	●	●	●	●	●
MF	32	1,50	30,50	150	28	-	22,0	18,0	●	●	●	-	-
MF	33	1,50	31,50	160	30	-	25,0	20,0	●	●	●	-	-
MF	34	1,50	32,50	170	30	-	28,0	22,0	●	●	●	-	-
MF	35	1,50	33,50	170	30	-	28,0	22,0	●	●	●	-	-
MF	36	1,50	34,50	170	30	-	28,0	22,0	●	●	●	-	-
MF	38	1,50	36,50	170	30	-	28,0	22,0	●	●	●	-	-
MF	40	1,50	38,50	170	30	-	32,0	24,0	●	●	●	-	-
MF	42	1,50	40,50	170	30	-	32,0	24,0	●	●	●	-	-
MF	45	1,50	43,50	180	32	-	36,0	29,0	●	●	●	-	-
MF	48	1,50	46,50	190	32	-	36,0	29,0	●	●	●	-	-
MF	50	1,50	48,50	190	32	-	36,0	29,0	●	●	●	-	-
MF	52	1,50	50,50	190	32	-	40,0	32,0	●	●	●	-	-

N: Herkömmliche Anwendung universal application
N 15°: 15° Rechtsdrall right hand helix

* Diese Gewinde sind im Metrischen ISO-Gewinde nicht enthalten / These sizes are not ISO standard.

● Standardartikel / Items available ex stock

DIN 374

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Feingewinde nach DIN 13
Machine taps with reduced shank
for ISO metric fine thread as per DIN 13

N 15°	N 15°	N Sx 40°	N 40°	VAP 40°	N 40°	N 40°	N 40°	**Typ /** Type
6 H	6 H+0,1	6 H	6 H	6 H	6 H	6 H	6 H	**Toleranz** Tolerance
C/2,5-3	E/1-2	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	E/1-2	**Anschnitt / Gangzahl** Chamfer form / No. of threads
								Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material

6664 TC	6904	6864	6652	6652 VP	6652 TN	6652 TC	6877	Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø
●	-	-	●	●	●	●	-	MF	22	1,50	20,50
-	-	-	-	-	-	-	-	MF	22	2,00	20,00
-	●	-	-	-	-	-	-	MF	24	1,00	23,00
●	-	-	●	●	●	●	-	MF	24	1,50	22,50
●	-	-	-	-	-	-	-	MF	24	2,00	22,00
●	-	-	●	●	●	●	-	MF	26	1,50	24,50
●	-	-	●	●	●	●	-	MF	27	1,50	25,50
●	-	-	●	●	●	●	-	MF	27	2,00	25,00
●	-	-	●	●	●	●	-	MF	28	1,50	26,50
●	-	-	-	-	-	-	-	MF	30	1,00	29,00
-	-	-	●	●	●	●	-	MF	30	1,50	28,50
-	-	-	●	●	●	●	-	MF	30	2,00	28,00
-	-	-	-	-	-	-	-	MF	32	1,50	30,50
-	-	-	-	-	-	-	-	MF	33	1,50	31,50
-	-	-	-	-	-	-	-	MF	34	1,50	32,50
-	-	-	-	-	-	-	-	MF	35	1,50	33,50
-	-	-	-	-	-	-	-	MF	36	1,50	34,50
-	-	-	-	-	-	-	-	MF	38	1,50	36,50
-	-	-	-	-	-	-	-	MF	40	1,50	38,50
-	-	-	-	-	-	-	-	MF	42	1,50	40,50
-	-	-	-	-	-	-	-	MF	45	1,50	43,50
-	-	-	-	-	-	-	-	MF	48	1,50	46,50
-	-	-	-	-	-	-	-	MF	50	1,50	48,50
-	-	-	-	-	-	-	-	MF	52	1,50	50,50

N 15°: **15° Rechtsdrall** right hand helix
N 40°: **Rechtsrall a 40°** right hand helix
VAP: **vaporisiert** vaporized

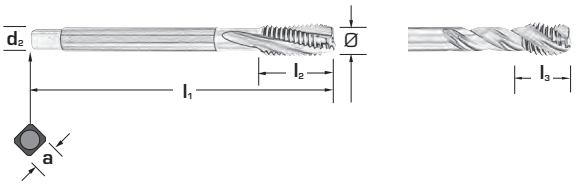
● Standardartikel / Items available ex stock

DIN 374

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Feingewinde nach DIN 13
Machine taps with reduced shank
for ISO metric fine thread as per DIN 13

MF | HARD LUBE | XP TOP

Axialer Kühlmittelaustritt
Axial internal cooling



Typ / Type	VA 15°	VA i 15°	VA i 15°	VA 35°	VAP 35°	VA 35°	VA 35°
Toleranz / Tolerance	6 HX	6 HX	6 HX	6 HX	6 HX	6 HX	6 GX
Anschnitt / Gangzahl / Chamfer form / No. of threads	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3
Schneidrichtung / Cutting direction							
Schneidstoff / Material	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co

Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	l_3 mm	d_2 mm h9	a h12	6671	6626	6626 XP	6655	6655 VP	6655 XP	6655 6G
MF	3	0,35	2,65	56	9	5	2,2	-	-	-	-	-	-	-	-
MF	3,5	0,35	3,15	56	10	6	2,5	2,1	-	-	-	-	-	-	-
MF	4	0,50	3,50	63	10	7	2,8	2,1	-	-	-	-	-	-	-
MF	5	0,50	4,50	70	12	8	3,5	2,7	-	-	-	-	-	-	-
MF	6	0,50	5,50	80	14	10	4,5	3,4	-	-	-	-	-	-	-
MF	6	0,75	5,20	80	14	10	4,5	3,4	-	-	-	-	-	-	-
MF	7	0,75	6,20	80	14	10	5,5	4,3	-	-	-	-	-	-	-
MF	8	0,50	7,50	80	19	12	6,0	4,9	-	-	-	-	-	-	-
MF	8	0,75	7,20	80	19	12	6,0	4,9	-	-	-	-	-	-	-
MF	8	1,00	7,00	90	22	12	6,0	4,9	●	●	●	●	●	●	●
MF	9	1,00	8,00	90	22	12	7,0	5,5	-	-	-	-	-	-	-
MF	10	0,75	9,20	90	20	14	7,0	5,5	-	-	-	-	-	-	-
MF	10	1,00	9,00	90	20	14	7,0	5,5	●	●	●	●	●	●	●
MF	10	1,25	8,80	100	24	14	7,0	5,5	●	●	●	●	●	●	-
MF	11	1,00	10,00	90	20	14	8,0	6,2	-	-	-	-	-	-	-
MF	12	1,00	11,00	100	22	16	9,0	7,0	●	●	●	●	●	●	●
MF	12	1,25	10,80	100	22	16	9,0	7,0	-	●	●	-	-	-	-
MF	12	1,50	10,50	100	22	16	9,0	7,0	●	●	●	●	●	●	●
MF	14	1,00	13,00	100	22	20	11,0	9,0	-	-	-	-	-	-	-
MF	14	1,25*	12,80	100	22	20	11,0	9,0	-	-	-	-	-	-	-
MF	14	1,50	12,50	100	22	20	11,0	9,0	●	●	●	●	●	●	●
MF	15	1,00	14,00	100	22	20	12,0	9,0	-	-	-	-	-	-	-
MF	15	1,50	13,50	100	22	20	12,0	9,0	-	-	-	-	-	-	-
MF	16	1,00	15,00	100	22	20	12,0	9,0	-	-	-	-	-	-	-
MF	16	1,50	14,50	100	22	20	12,0	9,0	●	●	●	●	●	●	●
MF	18	1,00	17,00	110	25	25	14,0	11,0	-	-	-	-	-	-	-
MF	18	1,50	16,50	110	25	25	14,0	11,0	●	●	●	●	●	●	●

VA: **Für rostfreien Stahl**
for stainless steel

VA i: **Für rostfreien Stahl mit Innenkühlung**
for stainless steel, with internal cooling

VAP: **vaporisiert**
vaporized

* Diese Gewinde sind im Metrischen ISO-Gewinde nicht enthalten / These sizes are not ISO standard.

● Standardartikel / Items available ex stock

DIN 374

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Feingewinde nach DIN 13
Machine taps with reduced shank
for ISO metric fine thread as per DIN 13

GG	HD 15°	HD 15°	Alu 45°	**Typ /** Type
6 HX	6 H	6 H	6 H	**Toleranz** Tolerance
C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	**Anschnitt / Gangzahl** Chamfer form / No. of threads
				Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material

6653	6880	6880 HL	6731	Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø
-	-	-	-	MF	3	0,35	2,65
-	-	-	-	MF	3,5	0,35	3,15
-	-	-	-	MF	4	0,50	3,50
-	-	-	-	MF	5	0,50	4,50
-	-	-	-	MF	6	0,50	5,50
-	●	●	-	MF	6	0,75	5,20
-	-	-	-	MF	7	0,75	6,20
-	-	-	-	MF	8	0,50	7,50
-	●	●	-	MF	8	0,75	7,20
●	●	●	●	MF	8	1,00	7,00
●	-	-	-	MF	9	1,00	8,00
-	-	-	-	MF	10	0,75	9,20
●	●	●	●	MF	10	1,00	9,00
●	-	-	●	MF	10	1,25	8,80
-	-	-	-	MF	11	1,00	10,00
-	●	●	●	MF	12	1,00	11,00
-	-	-	-	MF	12	1,25	10,80
●	●	●	●	MF	12	1,50	10,50
-	-	-	-	MF	14	1,00	13,00
-	-	-	-	MF	14	1,25*	12,80
●	●	●	●	MF	14	1,50	12,50
-	-	-	-	MF	15	1,00	14,00
-	-	-	-	MF	15	1,50	13,50
-	-	-	-	MF	16	1,00	15,00
●	●	●	●	MF	16	1,50	14,50
-	-	-	-	MF	18	1,00	17,00
●	●	●	●	MF	18	1,50	16,50

HD : **für zähe Werkstoffe**
for tough materials

GG: **für Guss**
for cast iron

Alu: **für Aluminium**
for Aluminium

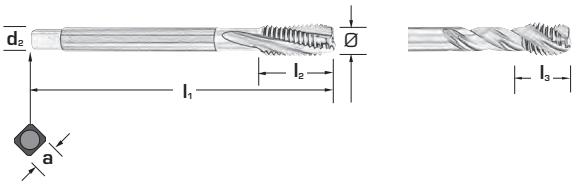
● Standardartikel / Items available ex stock

DIN 374

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Feingewinde nach DIN 13
Machine taps with reduced shank
for ISO metric fine thread as per DIN 13

MF | HARD LUBE | XP TOP

Axialer Kühlmittelaustritt
Axial internal cooling



Typ / Type									VA 15°	VA i 15°	VA i 15°	VA 35°	VAP 35°	VA 35°	VA 35°
Toleranz Tolerance									6 HX	6 HX	6 HX	6 HX	6 HX	6 HX	6 GX
Anschnitt / Gangzahl Chamfer form / No. of threads									C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3
Schneidrichtung Cutting direction															
Schneidstoff/ Material									HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1** mm	**l_2** mm	**l_3** mm	**d_2** mm h9	**a** h12	**6671**	**6626**	**6626 XP**	**6655**	**6655 VP**	**6655 XP**	**6655 6G**
MF	20	1,50	18,50	125	25	25	16,0	12,0	●	●	●	●	●	●	●
MF	20	2,00	18,00	140	34	25	16,0	12,0	-	-	-	-	-	-	-
MF	22	1,00	21,00	125	25	25	18,0	14,5	-	-	-	-	-	-	-
MF	22	1,50	20,50	125	25	25	18,0	14,5	●	-	-	●	●	●	-
MF	22	2,00	20,00	140	34	25	18,0	14,5	-	-	-	-	-	-	-
MF	24	1,00	23,00	140	28	28	18,0	14,5	-	-	-	-	-	-	-
MF	24	1,50	22,50	140	28	28	18,0	14,5	●	-	-	●	●	●	●
MF	24	2,00	22,00	140	28	28	18,0	14,5	-	-	-	-	-	-	-
MF	26	1,50	24,50	140	28	28	18,0	14,5	●	-	-	●	●	●	-
MF	27	1,50	25,50	140	28	28	20,0	16,0	●	-	-	●	●	●	-
MF	27	2,00	25,00	140	28	28	20,0	16,0	●	-	-	●	●	●	-
MF	28	1,50	26,50	140	28	28	20,0	16,0	●	-	-	●	●	●	-
MF	30	1,00	29,00	150	28	28	22,0	18,0	-	-	-	-	-	-	-
MF	30	1,50	28,50	150	28	28	22,0	18,0	●	-	-	●	●	●	-
MF	30	2,00	28,00	150	28	28	22,0	18,0	●	-	-	●	●	●	-

VA: **Für rostfreien Stahl**
for stainless steel

VA i: **Für rostfreien Stahl mit Innenkühlung**
for stainless steel, with internal cooling

VAP: **vaporisiert**
vaporized

* Diese Gewinde sind im Metrischen ISO-Gewinde nicht enthalten / These sizes are not ISO standard.

● Standardartikel / Items available ex stock

DIN 374

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Feingewinde nach DIN 13
Machine taps with reduced shank
for ISO metric fine thread as per DIN 13

GG	HD 15°	HD 15°	Alu 45°	**Typ /** Type
6 HX	6 H	6 H	6 H	**Toleranz** Tolerance
C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	**Anschnitt / Gangzahl** Chamfer form / No. of threads
				Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material

6653	6880	6880 HL	6731	Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø
●	●	●	●	MF	20	1,50	18,50
-	-	-	-	MF	20	2,00	18,00
-	-	-	-	MF	22	1,00	21,00
●	●	●	-	MF	22	1,50	20,50
-	-	-	-	MF	22	2,00	20,00
-	-	-	-	MF	24	1,00	23,00
●	●	●	-	MF	24	1,50	22,50
-	-	-	-	MF	24	2,00	22,00
-	-	-	-	MF	26	1,50	24,50
-	-	-	-	MF	27	1,50	25,50
-	-	-	-	MF	27	2,00	25,00
-	-	-	-	MF	28	1,50	26,50
-	-	-	-	MF	30	1,00	29,00
●	-	-	-	MF	30	1,50	28,50
-	-	-	-	MF	30	2,00	28,00

HD : **für zähe Werkstoffe**
for tough materials
GG: **für Guss**
for cast iron

Alu: **für Aluminium**
for Aluminium

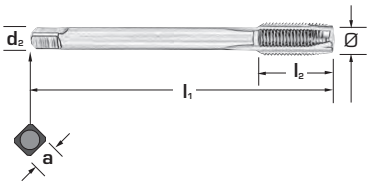
MULTI HD: **Hochleistungs - Gewindebohrer für zähe Werkstoffe**
High performance taps for tough materials

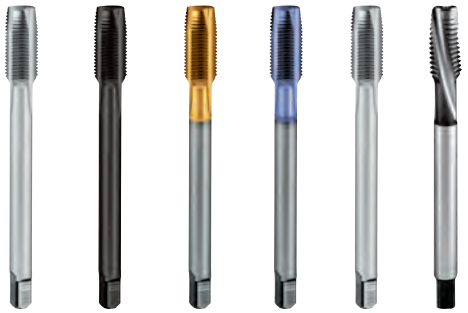
● Standardartikel / Items available ex stock

DIN 374

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Feingewinde nach DIN 13
Machine taps with reduced shank
for ISO metric fine thread as per DIN 13

MF | TiN | TICN | XP TOP





Typ / Type	Rapid	Rapid VAP	Rapid	Rapid	N Sx	NL 15°
Toleranz Tolerance	6 H	6 H	6 H	6 H	6 H	6 H
Anschnitt / Gangzahl Chamfer form / No. of threads	B/4-5	B/4-5	B/4-5	B/4-5	B/4-5	B/4-5
Schneidrichtung Cutting direction						
Schneidstoff/ Material	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co

Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a h12	6730	6730 VP	6730 TN	6730 TC	6863	6741
MF	3	0,35	2,65	56	9	2,2	-	●	●	●	●	-	-
MF	3,5	0,35	3,15	56	10	2,5	2,1	●	●	●	●	-	-
MF	4	0,50	3,50	63	10	2,8	2,1	●	●	●	●	-	-
MF	5	0,50	4,50	70	12	3,5	2,7	●	●	●	●	-	-
MF	6	0,50	5,50	80	14	4,5	3,4	●	●	●	●	-	-
MF	6	0,75	5,20	80	14	4,5	3,4	●	●	●	●	-	-
MF	7	0,75	6,20	80	14	5,5	4,3	●	●	●	●	-	-
MF	8	0,50	7,50	80	19	6,0	4,9	●	●	●	●	-	-
MF	8	0,75	7,20	80	19	6,0	4,9	●	●	●	●	-	●
MF	8	1,00	7,00	90	22	6,0	4,9	●	●	●	●	●	●
MF	9	1,00	8,00	90	22	7,0	5,5	●	●	●	●	-	-
MF	10	0,75	9,20	90	20	7,0	5,5	●	●	●	●	-	-
MF	10	1,00	9,00	90	20	7,0	5,5	●	●	●	●	●	●
MF	10	1,25	8,80	100	24	7,0	5,5	●	●	●	●	-	-
MF	11	1,00	10,00	90	20	8,0	6,2	●	●	●	●	-	-
MF	12	1,00	11,00	100	22	9,0	7,0	●	●	●	●	●	●
MF	12	1,25	10,80	100	22	9,0	7,0	●	●	●	●	-	-
MF	12	1,50	10,50	100	22	9,0	7,0	●	●	●	●	●	●
MF	14	1,00	13,00	100	22	11,0	9,0	●	●	●	●	-	-
MF	14	1,25*	12,80	100	22	11,0	9,0	●	●	●	●	-	-
MF	14	1,50	12,50	100	22	11,0	9,0	●	●	●	●	●	●
MF	15	1,00	14,00	100	22	12,0	9,0	●	●	●	●	-	-
MF	15	1,50	13,50	100	22	12,0	9,0	●	●	●	●	-	-
MF	16	1,00	15,00	100	22	12,0	9,0	●	●	●	●	-	-
MF	16	1,50	14,50	100	22	12,0	9,0	●	●	●	●	●	●
MF	18	1,00	16,50	110	25	14,0	11,0	●	●	●	●	-	-
MF	18	1,50	16,50	110	25	14,0	11,0	●	●	●	●	●	●
MF	18	2,00	16,00	125	34	14,0	11,0	●	●	●	●	-	-

Rapid: **Herkömmliche Anwendung**
universal application

VAP: **vaporisiert**
vaporized

NL15°: **15° Linksdrall**
left hand helix

N: **Herkömmliche Anwendung**
universal application

* Diese Gewinde sind im Metrischen ISO-Gewinde nicht enthalten / These sizes are not ISO standard.

● Standardartikel / Items available ex stock

DIN 374

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Feingewinde nach DIN 13
Machine taps with reduced shank
for ISO metric fine thread as per DIN 13

6663	6663 VP	6663 6G	6663 TN	6663 XP	6872	6872 TN	Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø
VA	VAP	VA	VA	VA	HD	HD	**Typ /** Type			
6 HX	6 HX	6 GX	6 HX	6 HX	6 H	6 H	**Toleranz** Tolerance			
B/4-5	B/4-5	B/4-5	B/4-5	B/4-5	B/4-5	B/4-5	**Anschnitt / Gangzahl** Chamfer form / No. of threads			
							Schneidrichtung Cutting direction			
HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material			
-	-	-	-	-	-	-	MF	3	0,35	2,65
-	-	-	-	-	-	-	MF	3,5	0,35	3,15
-	-	-	-	-	-	-	MF	4	0,50	3,50
-	-	-	-	-	-	-	MF	5	0,50	4,50
-	-	-	-	-	-	-	MF	6	0,50	5,50
-	-	-	-	-	●	●	MF	6	0,75	5,20
-	-	-	-	-	-	-	MF	7	0,75	6,20
-	-	-	-	-	-	-	MF	8	0,50	7,50
-	-	-	-	-	●	●	MF	8	0,75	7,20
●	●	●	●	●	●	●	MF	8	1,00	7,00
-	-	-	-	-	-	-	MF	9	1,00	8,00
-	-	-	-	-	-	-	MF	10	0,75	9,20
●	●	●	●	●	●	●	MF	10	1,00	9,00
●	●	-	●	●	-	-	MF	10	1,25	8,80
-	-	-	-	-	-	-	MF	11	1,00	10,00
●	●	●	●	●	●	●	MF	12	1,00	11,00
-	-	-	-	-	-	-	MF	12	1,25	10,80
●	●	●	●	●	●	●	MF	12	1,50	10,50
-	-	-	-	-	-	-	MF	14	1,00	13,00
-	-	-	-	-	-	-	MF	14	1,25*	12,80
●	●	●	●	●	●	●	MF	14	1,50	12,50
-	-	-	-	-	-	-	MF	15	1,00	14,00
-	-	-	-	-	-	-	MF	15	1,50	13,50
-	-	-	-	-	-	-	MF	16	1,00	15,00
●	●	●	●	●	●	●	MF	16	1,50	14,50
-	-	-	-	-	-	-	MF	18	1,00	16,50
●	●	●	●	●	●	●	MF	18	1,50	16,50
-	-	-	-	-	-	-	MF	18	2,00	16,00

VA: **Für rostfreien Stahl**
for stainless steel

VAP: **vaporisiert**
vaporized

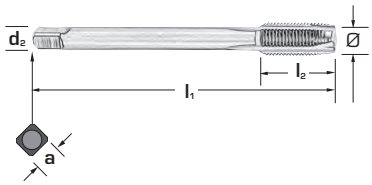
HD : **für zähe Werkstoffe**
for tough materials

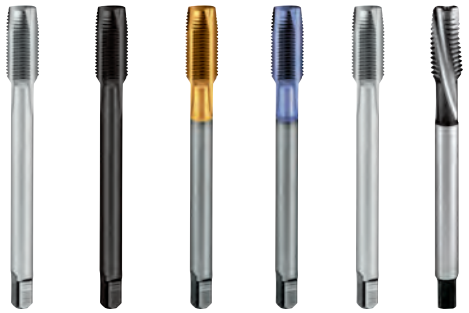
● Standardartikel / Items available ex stock

DIN 374

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Feingewinde nach DIN 13
Machine taps with reduced shank
for ISO metric fine thread as per DIN 13

MF | TiN | TICN | XP TOP





Typ / Type	Rapid	Rapid VAP	Rapid	Rapid	N Sx	NL 15°
Toleranz / Tolerance	6 H	6 H	6 H	6 H	6 H	6 H
Anschnitt / Gangzahl / Chamfer form / No. of threads	B/4-5	B/4-5	B/4-5	B/4-5	B/4-5	B/4-5
Schneidrichtung / Cutting direction						
Schneidstoff / Material	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co

Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a h12	6730	6730 VP	6730 TN	6730 TC	6863	6741
MF	20	1,00	19,00	125	25	16,0	12,0	●	●	●	●	-	-
MF	20	1,50	18,50	125	25	16,0	12,0	●	●	●	●	●	●
MF	20	2,00	18,00	140	34	16,0	12,0	●	●	●	●	-	-
MF	22	1,00	21,00	125	25	18,0	14,5	●	●	●	●	-	-
MF	22	1,50	20,50	125	25	18,0	14,5	●	●	●	●	-	-
MF	22	2,00	20,00	140	34	18,0	14,5	●	●	●	●	-	-
MF	24	1,00	23,00	140	28	18,0	14,5	●	●	●	●	-	-
MF	24	1,50	22,50	140	28	18,0	14,5	●	●	●	●	-	-
MF	24	2,00	22,00	140	28	18,0	14,5	●	●	●	●	-	-
MF	26	1,50	24,50	140	28	18,0	14,5	●	●	●	●	-	-
MF	27	1,50	25,50	140	28	20,0	16,0	●	●	●	●	-	-
MF	27	2,00	25,00	140	28	20,0	16,0	●	●	●	●	-	-
MF	28	1,50	26,50	140	28	20,0	16,0	●	●	●	●	-	-
MF	30	1,00	29,00	150	28	22,0	18,0	●	●	●	●	-	-
MF	30	1,50	28,50	150	28	22,0	18,0	●	●	●	●	-	-
MF	30	2,00	28,00	150	28	22,0	18,0	●	●	●	●	-	-
MF	32	1,50	30,50	150	28	22,0	18,0	●	●	●	●	-	-
MF	33	1,50	31,50	160	30	25,0	20,0	●	●	●	●	-	-
MF	34	1,50	32,50	170	30	28,0	22,0	●	●	●	●	-	-
MF	35	1,50	33,50	170	30	28,0	22,0	●	●	●	●	-	-
MF	36	1,50	34,50	170	30	28,0	22,0	●	●	●	●	-	-
MF	38	1,50	36,50	170	30	28,0	22,0	●	●	●	●	-	-
MF	40	1,50	38,50	170	30	32,0	24,0	●	●	●	●	-	-
MF	42	1,50	40,50	170	30	32,0	24,0	●	●	●	●	-	-
MF	45	1,50	43,50	180	32	36,0	29,0	●	●	●	●	-	-
MF	48	1,50	46,50	190	32	36,0	29,0	●	●	●	●	-	-
MF	50	1,50	48,50	190	32	36,0	29,0	●	●	●	●	-	-
MF	52	1,50	50,50	190	32	40,0	32,0	●	●	●	●	-	-

Rapid: **Herkömmliche Anwendung**
universal application

VAP: **vaporisiert**
vaporized

NL15°: **15° Linksdrall**
left hand helix

N: **Herkömmliche Anwendung**
universal application

* Diese Gewinde sind im Metrischen ISO-Gewinde nicht enthalten / These sizes are not ISO standard.

● Standardartikel / Items available ex stock

DIN 374

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Feingewinde nach DIN 13
Machine taps with reduced shank
for ISO metric fine thread as per DIN 13

VA	VAP	VA	VA	VA	HD	HD	**Typ /** Type
6 HX	6 HX	6 GX	6 HX	6 HX	6 H	6 H	**Toleranz** Tolerance
B/4-5	B/4-5	B/4-5	B/4-5	B/4-5	B/4-5	B/4-5	**Anschnitt / Gangzahl** Chamfer form / No. of threads
							Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material
6663	**6663 VP**	**6663 6G**	**6663 TN**	**6663 XP**	**6872**	**6872 TN**	**Ø mm**	**Steigung** Pitch	**Kernloch Ø** Tap drill Ø
-	-	-	-	-	-	-	MF 20	1,00	19,00
●	●	●	●	●	●	●	MF 20	1,50	18,50
●	●	-	●	-	-	-	MF 20	2,00	18,00
-	-	-	-	-	-	-	MF 22	1,00	21,00
●	●	-	●	-	●	●	MF 22	1,50	20,50
●	●	-	●	-	-	-	MF 22	2,00	20,00
-	-	-	-	-	-	-	MF 24	1,00	23,00
●	●	●	●	●	●	●	MF 24	1,50	22,50
●	●	-	●	-	-	-	MF 24	2,00	22,00
●	●	-	●	-	-	-	MF 26	1,50	24,50
●	●	-	●	-	-	-	MF 27	1,50	25,50
●	●	-	●	-	-	-	MF 27	2,00	25,00
-	-	-	-	-	-	-	MF 28	1,50	26,50
-	-	-	-	-	-	-	MF 30	1,00	29,00
●	●	-	●	-	-	-	MF 30	1,50	28,50
●	●	-	●	-	-	-	MF 30	2,00	28,00
-	-	-	-	-	-	-	MF 32	1,50	30,50
-	-	-	-	-	-	-	MF 33	1,50	31,50
-	-	-	-	-	-	-	MF 34	1,50	32,50
-	-	-	-	-	-	-	MF 35	1,50	33,50
-	-	-	-	-	-	-	MF 36	1,50	34,50
-	-	-	-	-	-	-	MF 38	1,50	36,50
-	-	-	-	-	-	-	MF 40	1,50	38,50
-	-	-	-	-	-	-	MF 42	1,50	40,50
-	-	-	-	-	-	-	MF 45	1,50	43,50
-	-	-	-	-	-	-	MF 48	1,50	46,50
-	-	-	-	-	-	-	MF 50	1,50	48,50
-	-	-	-	-	-	-	MF 52	1,50	50,50

VA: **Für rostfreien Stahl**
for stainless steel

VAP: **vaporisiert**
vaporized

HD : **für zähe Werkstoffe**
for tough materials

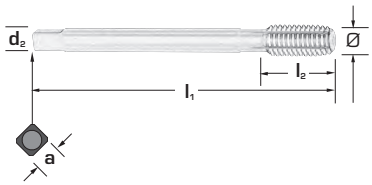
● Standardartikel / Items available ex stock

DIN 374

Maschinen-Gewindeformer mit Überlaufschaft
für Metrisches ISO-Feingewinde nach DIN 13
Cold forming taps with reduced shank
for ISO metric fine thread as per DIN 13

Ref. **6721** ohne Schmiernuten / without coolant grooves
Ref. **6720** mit Schmiernuten / with coolant grooves

M



Typ / Type								Former	Former	Former-S	Former-S
Toleranz / Tolerance								6 HX	6 GX	6 HX	6 GX
Anschnitt / Gangzahl / Chamfer form / No. of threads								C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3
Schneidrichtung / Cutting direction											
Schneidstoff / Material								HSS-Co	HSS-Co	HSS-Co	HSS-Co
Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a h12	6721	6721 6G	6720	6720 6G
M	8	1,00	7,50	90	22	6	4,9	●	●	●	●
M	10	1,00	9,50	90	20	7	5,5	●	●	●	●
M	10	1,25	9,40	100	24	7	5,5	●	●	●	●
M	12	1,00	11,50	100	22	9	7,0	●	●	●	●
M	12	1,50	11,30	100	22	9	7,0	●	●	●	●
M	14	1,50	13,30	100	22	11	9,0	●	●	●	●
M	16	1,00	15,50	100	22	12	9,0	●	●	●	●
M	16	1,50	15,30	100	22	12	9,0	●	●	●	●

Former S: **mit Schmiernuten** with coolant grooves
Former : **ohne Schmiernuten** without coolant grooves

● Standardartikel / Items available ex stock