



TANOI
MACHINE TAPS FORMING

MACHINE TAPS FORMING




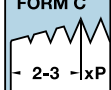

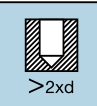




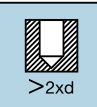


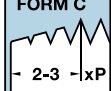

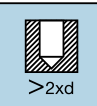


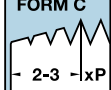

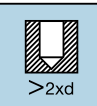


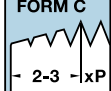

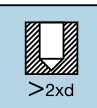


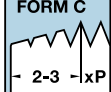

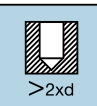


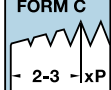

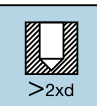


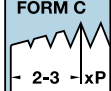

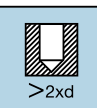


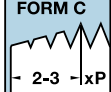

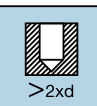


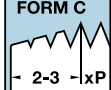

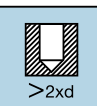


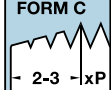

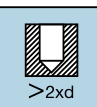


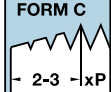

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Metric Taps / Metric Fine Taps	- For General Use	2
G Taps	- For General Use	5
Product Details		: 7-32

For General Use

Aluminium, Copper,

Steels < 800 N/mm², Stainless Steels < 1200 N/mm²

M/MF




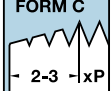




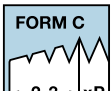




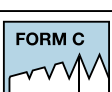
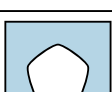

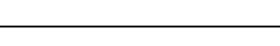

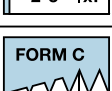


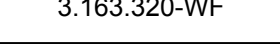

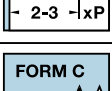
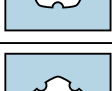

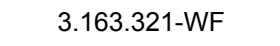

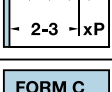
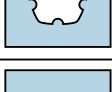

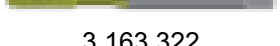

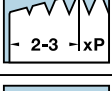
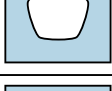



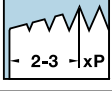




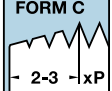

Hole	Picture / No.	Standard	Form	Flutes	Tol.	Coating	Page
 >2xd	 6.153.329-IT-Micro	 TANOI	FORM C  - 2-3 -xP		4HX	C-COAT PM 38	240
 >2xd	 6.158.929-IT-Micro	 TANOI	FORM E  -1.5-2-xP		4HX	C-COAT PM 38	240
 >2xd	 3.153.323-IT-Micro	 TANOI	FORM C  - 2-3 -xP		4HX	TiCN PM 38	241
 >2xd	 3.158.923-IT-Micro	 TANOI	FORM C  - 2-3 -xP		4HX	TiCN PM 38	241
 >2xd	 6.153.329-IT	 DIN 2174	FORM C  - 2-3 -xP		5HX 6HX	C-COAT HSSE Co8	242
 >2xd	 3.153.323-IT	 DIN 2174	FORM C  - 2-3 -xP		5HX 6HX	TiCN HSSE V3	243
 >2xd	 1.153.323-SL	 DIN 2174	FORM C  - 2-3 -xP		6HX	TiCN HSSE V3	11
 >2xd	 3.153.320	 DIN 2174	FORM C  - 2-3 -xP		6HX	HSSE V3	244
 >2xd	 3.153.320-WF	 DIN 2174	FORM C  - 2-3 -xP		6HX	HSSE V3	246
 >2xd	 3.153.321-WF	 DIN 2174	FORM C  - 2-3 -xP		6HX	OX HSSE V3	248
 >2xd	 3.153.322	 DIN 2174	FORM C  - 2-3 -xP		6HX	C-COAT HSSE V3	250
 >2xd	 3.153.322-WF	 DIN 2174	FORM C  - 2-3 -xP		6HX	C-COAT HSSE V3	252

For General Use

Aluminium, Copper,

Steels < 800 N/mm², Stainless Steels < 1200 N/mm²

M/MF

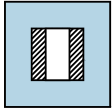


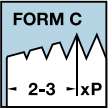
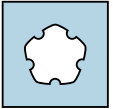
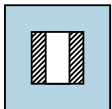

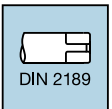
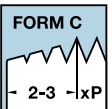
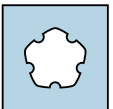
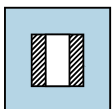

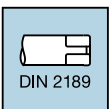
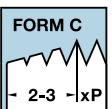
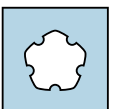
Hole	Picture / No.	Standard	Form	Flutes	Tol.	Coating	Page
 >2xd	 3.153.323	 DIN 2174	FORM C 		6HX	TiCN HSSE V3	254
 >2xd	 3.153.323-WF	 DIN 2174	FORM C 		6HX	TiCN HSSE V3	256
 >2xd	 3.163.320	 DIN 2174	FORM C 		6GX	HSSE V3	258
 >2xd	 3.163.320-WF	 DIN 2174	FORM C 		6GX	HSSE V3	259
 >2xd	 3.163.321-WF	 DIN 2174	FORM C 		6GX	OX HSSE V3	260
 >2xd	 3.163.322	 DIN 2174	FORM C 		6GX	C-COAT HSSE V3	262
 >2xd	 3.163.322-WF	 DIN 2174	FORM C 		6GX	C-COAT HSSE V3	263
 >2xd	 3.163.323	 DIN 2174	FORM C 		6GX	TiCN HSSE V3	264
 >2xd	 3.163.323-WF	 DIN 2174	FORM C 		6GX	TiCN HSSE V3	265

For General Use

Aluminium, Copper,

Steels < 800 N/mm², Stainless Steels < 1200 N/mm²

G

Hole	Picture / No.	Standard	Form	Flutes	Tol.	Coating	Page
	 3.693.920-WF	 DIN 2189	 FORM C - 2-3 -XP		6HX	HSSE V3	266
	 3.693.922-WF	 DIN 2189	 FORM C - 2-3 -XP		6HX	C-COAT HSSE V3	267
	 3.693.923-WF	 DIN 2189	 FORM C - 2-3 -XP		6HX	TiCN HSSE V3	268

FORMING TAPS

ADVANTAGES OF IT-TAFLET

Technical Features

- IT-Taflet forming taps have a unique chamfer section with reduced full profile threads (Picture 1.1).
- Unlike common forming taps the pitch between all chamfer threads is constant. All threads have symmetric profile. These features eliminate axial forces on the work piece (Picture 2.1).
- The thread root is designed to create a rounded thread crest on the formed thread (Picture 2.2).

Advantages in Production

- Tool life is dramatically increased because of the reduced forming torque.
- Burrs at the entry and exit of holes are nearly completely avoided due to the largely reduced axial forces.
- IT-Taflet may be used on thin work pieces as well as very small threads down to S0.5 due to the low torque generated.

Available in 3 executions:

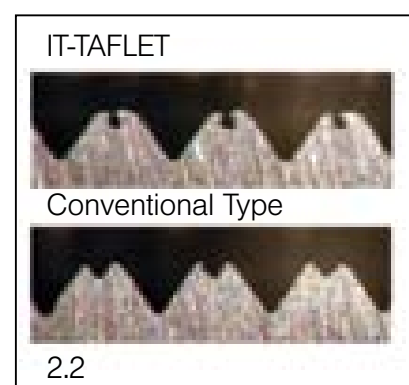
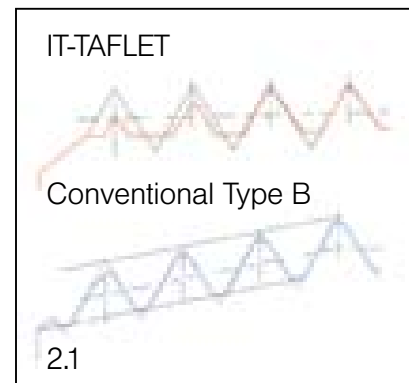
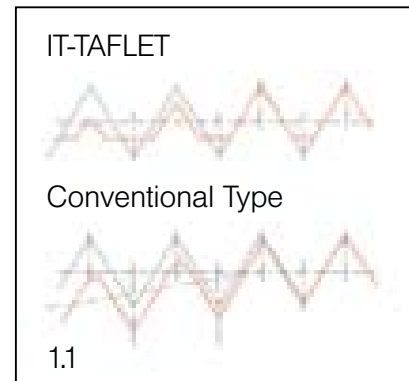
- MICRO - S0.5 ~ S0.9
- MINI - M1 ~ M1.8
- STANDARD - from size M2

IT-Taps are patented:

Japan patent no. 3457248

US patent no. 6386954

Europa patent no. 0953396



Available sizes

- IT-Taflets are also available in sizes from S0.5. These are used for manufacturing miniature screw threads in clocks, watches, optical instruments, measuring instruments and similar products requiring very small size threads of highest precision.
- The application of miniature IT-Taflets requires spindle speeds of 3'000 rpm. Both executions TiCN and C-Coating are suitable for these speeds and should be applied according to the work material.
- For tapping at speeds below 1'000 rpm - as may be required on automatic machines - TANOI offers a special steam oxide treatment (OX).

See application details on page XX

Size	Pitch	Drill hole diameter (mm)			
		4H5		4H6	
		Min.	Max.	Min.	Max.
S0.5	0.125	0.437	0.455	0.437	0.466
S0.6	0.150	0.525	0.549	0.525	0.559
S0.7	0.175	0.612	0.640	0.612	0.650
S0.8	0.200	0.699	0.729	0.699	0.740
S0.9	0.225	0.787	0.819	0.787	0.829

See application details on page XX

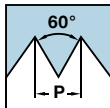


STEEL
INOX

STEEL
500-800
N/mm²

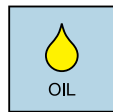
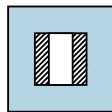
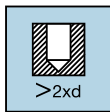
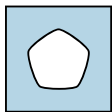
STEEL
≤ 500
N/mm²

S
MINI

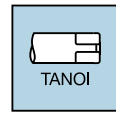
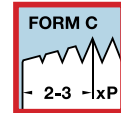
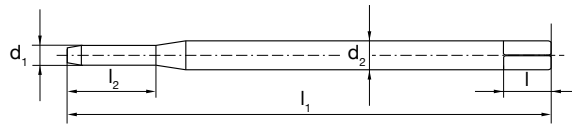


4HX

C-COAT
PM 38

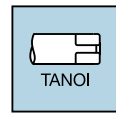
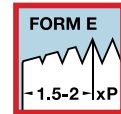
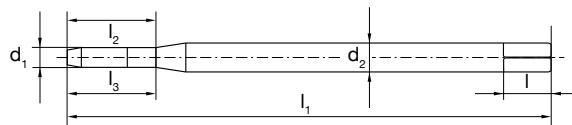


6.153.329-IT

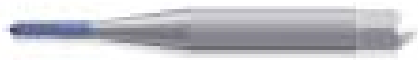


d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	R / F	Code	€
S0.5	0.125	50	2.0	7.0	2.8	5	2.1	4 / -	795.005	108.00
S0.6	0.150	50	2.5	7.5	2.8	5	2.1	4 / -	795.010	96.60
S0.7	0.175	50	2.5	7.5	2.8	5	2.1	4 / -	795.015	94.50
S0.8	0.200	50	3.0	8.0	2.8	5	2.1	4 / -	795.020	90.80
S0.9	0.225	50	3.0	8.0	2.8	5	2.1	4 / -	795.025	89.30

6.158.929-IT



S0.5	0.125	30	2.0	7.0	3.0	5	2.5	4 / -	790.005	108.00
S0.6	0.150	30	2.5	7.5	3.0	5	2.5	4 / -	790.010	96.60
S0.7	0.175	30	2.5	7.5	3.0	5	2.5	4 / -	790.015	94.50
S0.8	0.200	30	3.0	8.0	3.0	5	2.5	4 / -	790.020	90.80
S0.9	0.225	30	3.0	8.0	3.0	5	2.5	4 / -	790.025	89.30



ALU	ALU Si <10%
ALU Si >10%	CU
STEEL 500-800 N/mm ²	STEEL ≤ 500 N/mm ²

S MINI	60° -P-	4HX	TiCN PM 38	

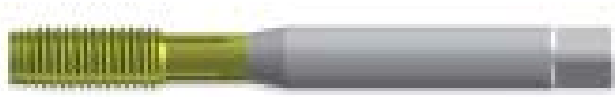
3.153.323-IT

d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	R / F	Code	€
S0.5	0.125	50	2.0	7.0	2.8	5	2.1	4 / -	796.005	108.00
S0.6	0.150	50	2.5	7.5	2.8	5	2.1	4 / -	796.010	96.60
S0.7	0.175	50	2.5	7.5	2.8	5	2.1	4 / -	796.015	94.50
S0.8	0.200	50	3.0	8.0	2.8	5	2.1	4 / -	796.020	90.80
S0.9	0.225	50	3.0	8.0	2.8	5	2.1	4 / -	796.025	89.30

3.158.923-IT

S0.5	0.125	30	2.0	7.0	3.0	5	2.5	4 / -	791.005	108.00
S0.6	0.150	30	2.5	7.5	3.0	5	2.5	4 / -	791.010	96.60
S0.7	0.175	30	2.5	7.5	3.0	5	2.5	4 / -	791.015	94.50
S0.8	0.200	30	3.0	8.0	3.0	5	2.5	4 / -	791.020	90.80
S0.9	0.225	30	3.0	8.0	3.0	5	2.5	4 / -	791.025	89.30

FORMING TAPS

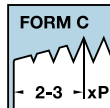
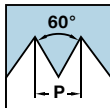


STEEL
INOX

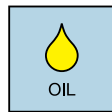
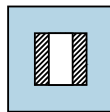
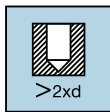
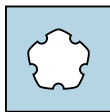
STEEL
500-800
N/mm²

STEEL
≤ 500
N/mm²

M



C-COAT
HSSE
Co8



6.153.329-IT

5HX

d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	R / F	Code	€
M1	0.25	40	5	7	2.8	5	2.1	4 / -	795.030	66.70
M1.1	0.25	40	5	7	2.8	5	2.1	4 / -	795.035	67.70
M1.2	0.25	40	5	7	2.8	5	2.1	4 / -	795.040	67.70
M1.4	0.30	40	7	9	2.8	5	2.1	4 / -	795.045	57.20
M1.6	0.35	40	8	9.5	2.8	5	2.1	4 / -	795.050	55.10
M1.8	0.35	40	8	10.5	2.8	5	2.1	4 / -	795.060	55.10

6.153.329-IT

6HX

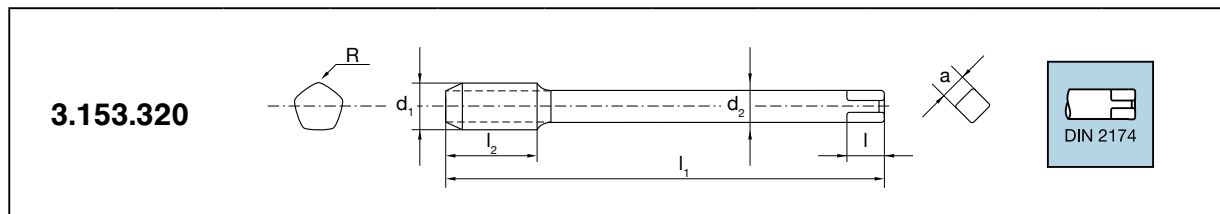
M2	0.40	45	8	10	2.8	5	2.1	4 / -	795.065	47.30
M2.2	0.45	45	9	11	2.8	5	2.1	4 / -	795.070	47.30
M2.5	0.45	50	9	12.5	2.8	5	2.1	4 / -	795.080	41.20
M3	0.50	56	11	18	3.5	6	2.7	5 / 1	795.090	35.80
M3.5	0.60	56	12	20	4.0	6	3.0	5 / 1	795.095	37.60
M4	0.70	63	13	21	4.5	6	3.4	5 / 1	795.100	37.30
M5	0.80	70	16	25	6.0	8	4.9	5 / 1	795.110	39.40
M6	1.00	80	19	30	6.0	8	4.9	5 / 1	795.115	41.00
M8	1.25	90	22	35	8.0	9	6.2	6 / 3	795.125	47.80
M10	1.50	100	24	39	10.0	11	8.0	8 / 4	795.135	67.70



STEEL ≤ 500 N/mm ²	STEEL 500-800 N/mm ²
STEEL 800-1200 N/mm ²	STEEL INOX
ALU	ALU Si <10%
	CU

MACHINE TAP

M	MF		6HX	FORM C 	HSSE V3



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	R	Code	€
M12	• 1.50	100	22	40	9.0	10	7.0	8	650.143	55.10
M12	• 1.75	110	28	44	9.0	10	7.0	8	650.145	55.70
M14	• 2.00	110	30	44	11.0	12	9.0	8	650.150	74.60
M16	• 1.50	100	22	40	12.0	12	9.0	8	650.152	91.90
M16	• 2.00	110	32	44	12.0	12	9.0	8	650.155	85.60

- METRIC
- METRIC FINE PITCH

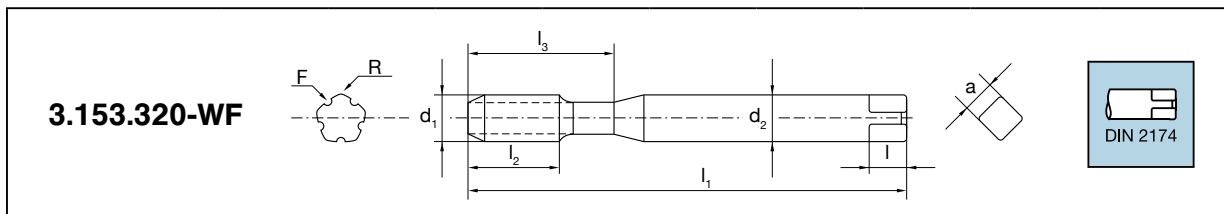
FORMING TAPS



STEEL ≤ 500 N/mm ²	STEEL 500-800 N/mm ²
STEEL 800-1200 N/mm ²	STEEL INOX
ALU	ALU Si <10%
	CU

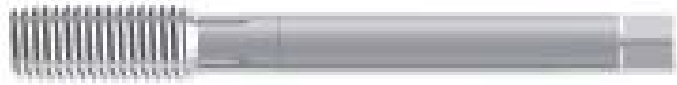
MACHINE TAP

M	MF	60° -P-	6HX	FORM C - 2-3 -xP	HSSE V3



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	R / F	Code	€
M2	• 0.40	45	8	10	2.8	5	2.1	4 / 2	655.065	29.60
M2.5	• 0.45	50	9	12.5	2.8	5	2.1	4 / 2	655.080	29.60
M3	• 0.35	56	8	18	3.5	6	2.7	4 / 2	655.086	49.50
M3	• 0.50	56	11	18	3.5	6	2.7	4 / 2	655.090	22.80
M4	• 0.50	63	10	21	4.5	6	3.4	4 / 2	655.097	48.50
M4	• 0.70	63	13	21	4.5	6	3.4	4 / 2	655.100	22.80
M5	• 0.50	70	12	25	6.0	8	4.9	4 / 2	655.106	53.00
M5	• 0.80	70	16	25	6.0	8	4.9	4 / 2	655.110	24.40
M6	• 0.75	80	14	30	6.0	8	4.9	4 / 2	655.112	53.00
M6	• 1.00	80	19	30	6.0	8	4.9	4 / 2	655.115	25.20
M8	• 1.00	90	22	35	8.0	9	6.2	6 / 3	655.123	52.10
M8	• 1.25	90	22	35	8.0	9	6.2	6 / 3	655.125	29.60
M10	• 1.00	90	20	35	8.0	11	8.0	8 / 4	655.132	55.10
M10	• 1.50	100	24	39	10.0	11	8.0	8 / 4	655.135	37.50

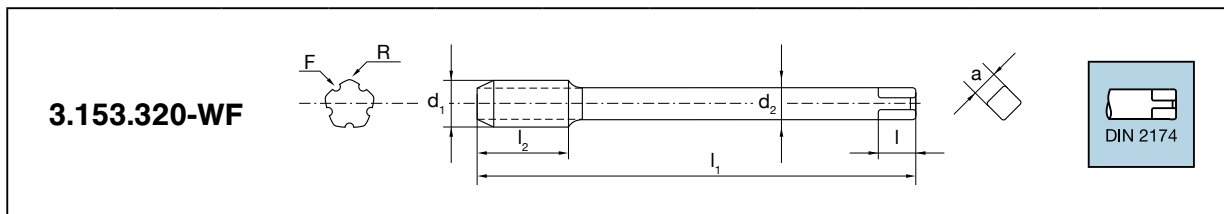
- METRIC
- METRIC FINE PITCH



STEEL ≤ 500 N/mm ²	STEEL 500-800 N/mm ²
STEEL 800-1200 N/mm ²	STEEL INOX
ALU	ALU Si <10%
	CU

MACHINE TAP

M	MF	60° -P-	6HX	FORM C - 2-3 -xP	HSSE V3



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	R / F	Code	€
M12	• 1.50	100	22	40	9.0	10	7.0	8 / 4	655.143	60.40
M12	• 1.75	110	28	44	9.0	10	7.0	8 / 4	655.145	60.90
M14	• 2.00	110	30	44	11.0	12	9.0	8 / 4	655.150	79.80
M16	• 1.50	100	22	40	12.0	12	9.0	8 / 4	655.152	101.00
M16	• 2.00	110	32	44	12.0	12	9.0	8 / 4	655.155	94.00

- METRIC
- METRIC FINE PITCH

FORMING TAPS



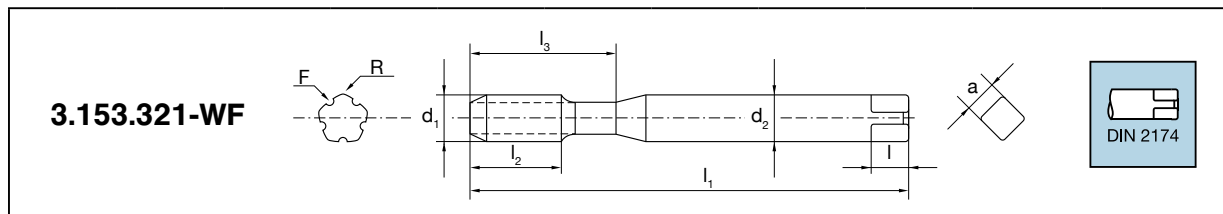
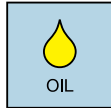
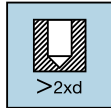
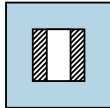
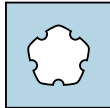
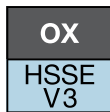
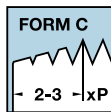
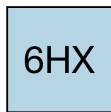
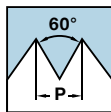
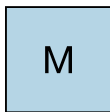
STEEL
≤ 500
N/mm²

STEEL
500-800
N/mm²

STEEL
800-1200
N/mm²

STEEL
INOX

MACHINE TAP



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	R / F	Code	€
M2	• 0.40	45	8	10	2.8	5	2.1	4 / 2	656.065	29.60
M2.5	• 0.45	50	9	12.5	2.8	5	2.1	4 / 2	656.080	29.60
M3	• 0.35	56	8	18	3.5	6	2.7	4 / 2	656.086	49.50
M3	• 0.50	56	11	18	3.5	6	2.7	4 / 2	656.090	22.80
M4	• 0.50	63	10	21	4.5	6	3.4	4 / 2	656.097	48.50
M4	• 0.70	63	13	21	4.5	6	4.9	4 / 2	656.100	22.80
M5	• 0.50	70	12	25	6.0	8	4.9	4 / 2	656.106	53.00
M5	• 0.80	70	16	25	6.0	8	4.9	4 / 2	656.110	24.40
M6	• 0.75	80	14	30	6.0	8	4.9	4 / 2	656.112	53.00
M6	• 1.00	80	19	30	6.0	8	6.2	4 / 2	656.115	25.20
M8	• 1.00	90	22	35	8.0	9	6.2	6 / 3	656.123	52.10
M8	• 1.25	90	22	35	8.0	9	8.0	6 / 3	656.125	29.60
M10	• 1.00	90	20	35	8.0	11	8.0	8 / 4	656.132	55.10
M10	• 1.50	100	24	39	10.0	11	8.0	8 / 4	656.135	37.50

- METRIC
- METRIC FINE PITCH



STEEL
≤ 500
N/mm²

STEEL
500-800
N/mm²

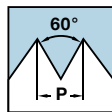
STEEL
800-1200
N/mm²

STEEL
INOX

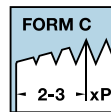
MACHINE TAP

M

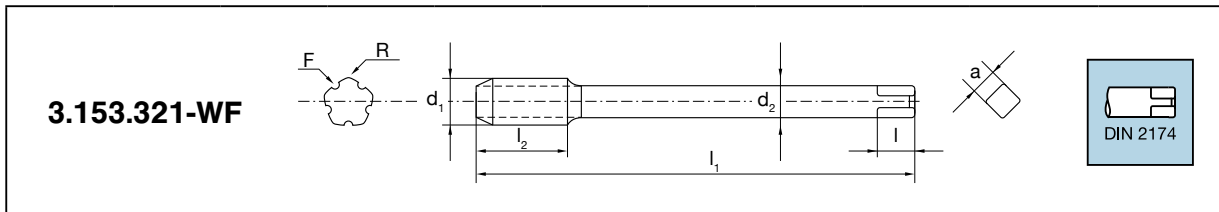
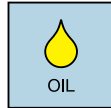
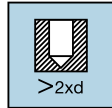
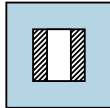
MF



6HX



OX
HSSE
V3



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	R / F	Code	€
M12	• 1.50	100	22	40	9.0	10	7.0	8 / 4	656.143	60.40
M12	• 1.75	110	28	44	9.0	10	7.0	8 / 4	656.145	60.90
M14	• 2.00	110	30	44	11.0	12	9.0	8 / 4	656.150	79.80
M16	• 1.50	100	22	40	12.0	12	9.0	8 / 4	656.152	101.00
M16	• 2.00	110	32	44	12.0	12	9.0	8 / 4	656.155	94.00

- METRIC
- METRIC FINE PITCH

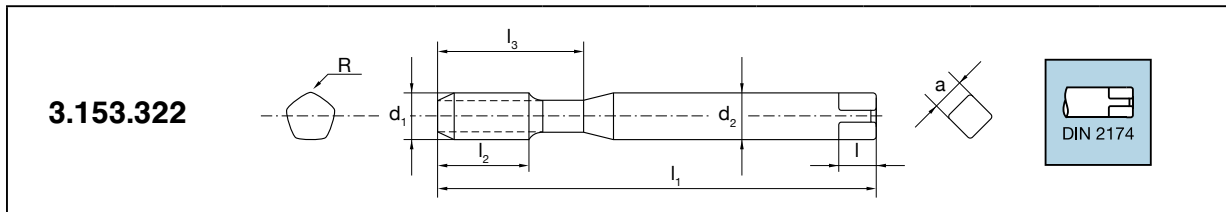
FORMING TAPS



STEEL ≤ 500 N/mm ²	STEEL 500-800 N/mm ²
STEEL 800-1200 N/mm ²	STEEL INOX
ALU	ALU Si <10%
	CU

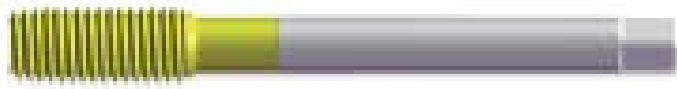
MACHINE TAP

M	MF	60° -P-	6HX	FORM C -2-3-xP	C-COAT HSSE V3



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	R	Code	€
M2	• 0.40	45	8	10	2.8	5	2.1	4	660.065	33.10
M2.5	• 0.45	50	9	12.5	2.8	5	2.1	4	660.080	31.50
M3	• 0.35	56	8	18	3.5	6	2.7	4	660.086	49.50
M3	• 0.50	56	11	18	3.5	6	2.7	4	660.090	26.80
M4	• 0.50	63	10	21	4.5	6	3.4	4	660.097	50.30
M4	• 0.70	63	13	21	4.5	6	3.4	4	660.100	26.80
M5	• 0.50	70	12	25	6.0	8	4.9	4	660.106	55.70
M5	• 0.80	70	16	25	6.0	8	4.9	4	660.110	28.80
M6	• 0.75	80	14	30	6.0	8	4.9	4	660.112	55.70
M6	• 1.00	80	19	30	6.0	8	4.9	4	660.115	29.60
M8	• 1.00	90	22	35	8.0	9	6.2	6	660.123	58.30
M8	• 1.25	90	22	35	8.0	9	6.2	6	660.125	34.70
M10	• 1.00	90	20	35	8.0	11	8	8	660.132	58.30
M10	• 1.50	100	24	39	10.0	11	8	8	660.135	44.10

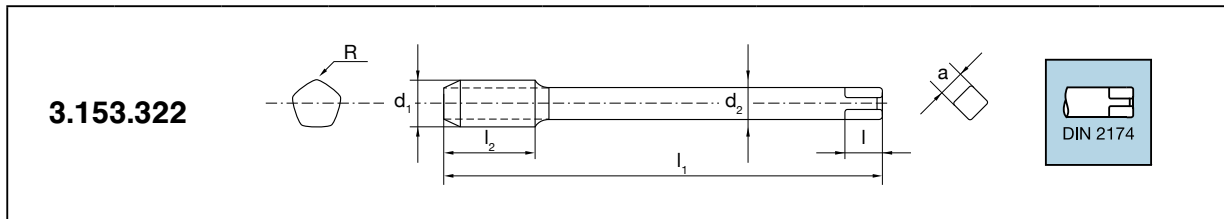
- METRIC
- METRIC FINE PITCH



STEEL ≤ 500 N/mm ²	STEEL 500-800 N/mm ²
STEEL 800-1200 N/mm ²	STEEL INOX
ALU	ALU Si <10%
	CU

MACHINE TAP

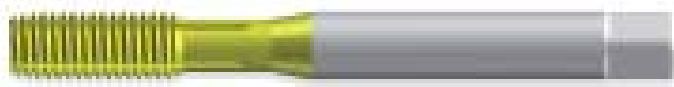
M	MF		6HX	FORM C 	C-COAT HSSE V3



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	R	Code	€
M12	• 1.50	100	22	40	9.0	10	7	8	660.143	66.20
M12	• 1.75	110	28	44	9.0	10	7	8	660.145	68.30
M14	• 2.00	110	30	44	11.0	12	9	8	660.150	88.20
M16	• 1.50	100	22	40	12.0	12	9	8	660.152	111.00
M16	• 2.00	110	32	44	12.0	12	9	8	660.155	95.60

- METRIC
- METRIC FINE PITCH

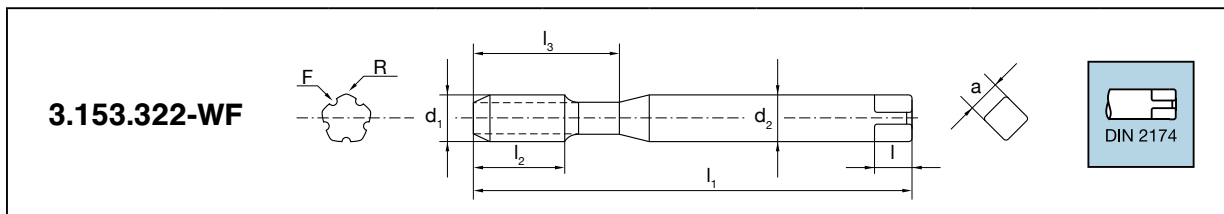
FORMING TAPS



STEEL ≤ 500 N/mm ²	STEEL 500-800 N/mm ²
STEEL 800-1200 N/mm ²	STEEL INOX
ALU	ALU Si <10%
	CU

MACHINE TAP

M	MF		6HX	FORM C - 2-3 -xP	C-COAT HSSE V3



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	R / F	Code	€
M2	• 0.40	45	8	10	2.8	5	2.1	4 / 2	665.065	35.90
M2.5	• 0.45	50	9	12.5	2.8	5	2.1	4 / 2	665.080	35.90
M3	• 0.35	56	8	18	3.5	6	2.7	4 / 2	665.086	54.10
M3	• 0.50	56	11	18	3.5	6	2.7	4 / 2	665.090	29.20
M4	• 0.50	63	10	21	4.5	6	3.4	4 / 2	665.097	57.80
M4	• 0.70	63	13	21	4.5	6	3.4	4 / 2	665.100	29.20
M5	• 0.50	70	12	25	6.0	8	4.9	4 / 2	665.106	60.40
M5	• 0.80	70	16	25	6.0	8	4.9	4 / 2	665.110	30.80
M6	• 0.75	80	14	30	6.0	8	4.9	4 / 2	665.112	57.80
M6	• 1.00	80	19	30	6.0	8	4.9	4 / 2	665.115	31.50
M8	• 1.00	90	22	35	8.0	9	6.2	6 / 3	665.123	63.00
M8	• 1.25	90	22	35	8.0	9	6.2	6 / 3	665.125	37.50
M10	• 1.00	90	20	35	8.0	11	8.0	8 / 4	665.132	66.20
M10	• 1.50	100	24	39	10.0	11	8.0	8 / 4	665.135	47.70

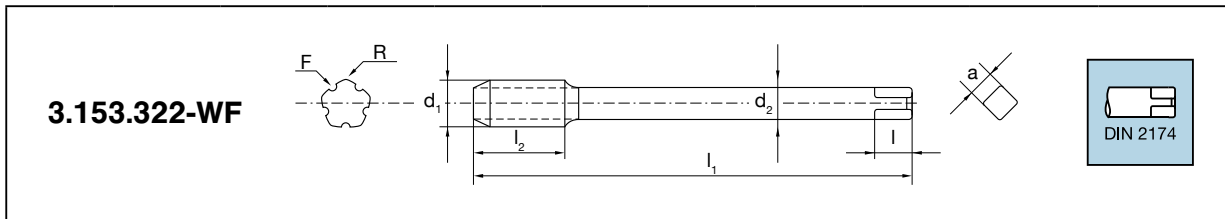
- METRIC
- METRIC FINE PITCH



STEEL ≤ 500 N/mm ²	STEEL 500-800 N/mm ²
STEEL 800-1200 N/mm ²	STEEL INOX
ALU	ALU Si <10%
	CU

MACHINE TAP

M	MF	60° -P-	6HX	FORM C - 2-3 -xP	C-COAT HSSE V3



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	R / F	Code	€
M12	• 1.50	100	22	40	9.0	10	7.0	8 / 4	665.143	71.90
M12	• 1.75	110	28	44	9.0	10	7.0	8 / 4	665.145	73.50
M14	• 2.00	110	30	44	11.0	12	9.0	8 / 4	665.150	94.00
M16	• 1.50	100	22	40	12.0	12	9.0	8 / 4	665.152	117.00
M16	• 2.00	110	32	44	12.0	12	9.0	8 / 4	665.155	113.00

- METRIC
- METRIC FINE PITCH

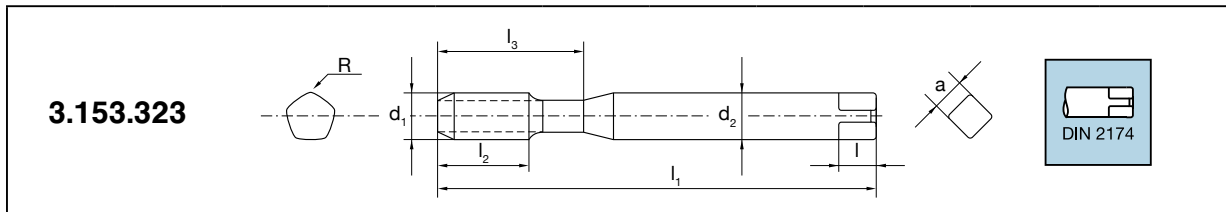
FORMING TAPS



STEEL ≤ 500 N/mm ²	STEEL 500-800 N/mm ²
STEEL 800-1200 N/mm ²	STEEL INOX
ALU	ALU Si <10%
	CU

MACHINE TAP

M	MF		6HX	FORM C - 2-3 -xP	TiCN HSSE V3



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	R	Code	€
M2	• 0.40	45	8	10	2.8	5	2.1	4	670.065	33.90
M2.5	• 0.45	50	9	12.5	2.8	5	2.1	4	670.080	33.90
M3	• 0.35	56	8	18	3.5	6	2.7	4	670.086	50.30
M3	• 0.50	56	11	18	3.5	6	2.7	4	670.090	27.60
M3.5	• 0.60	56	12	21	4.0	6	3.0	3	670.095	29.70
M4	• 0.50	63	10	21	4.5	6	3.4	4	670.097	51.20
M4	• 0.70	63	13	21	4.5	6	3.4	4	670.100	27.60
M5	• 0.50	70	12	25	6.0	8	4.9	4	670.106	54.10
M5	• 0.80	70	16	25	6.0	8	4.9	4	670.110	29.60
M6	• 0.75	80	14	30	6.0	8	4.9	4	670.112	56.70
M6	• 1.00	80	19	30	6.0	8	4.9	4	670.115	30.30
M8	• 1.00	90	22	35	8.0	9	6.2	6	670.123	56.70
M8	• 1.25	90	22	35	8.0	9	6.2	6	670.125	35.50
M10	• 1.00	90	20	35	8.0	11	8.0	8	670.132	60.90
M10	• 1.50	100	24	39	10.0	11	8.0	8	670.135	45.70

• METRIC

• METRIC FINE PITCH



- STEEL
≤ 500
N/mm²
- STEEL
500-800
N/mm²
- STEEL
800-1200
N/mm²
- STEEL
INOX
- ALU
Si <10%
- CU

MACHINE TAP

M

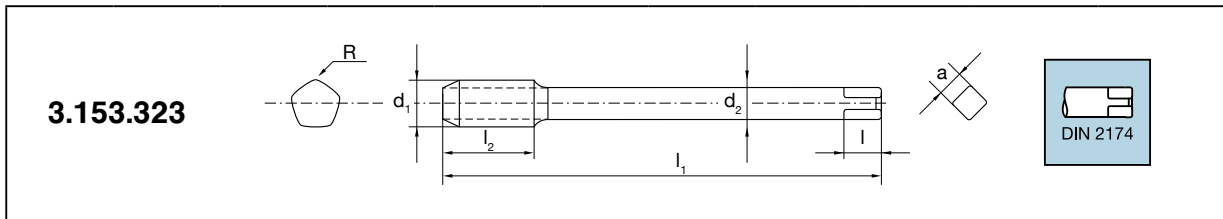
MF

6HX

TiCN
 HSSE
 V3

OIL

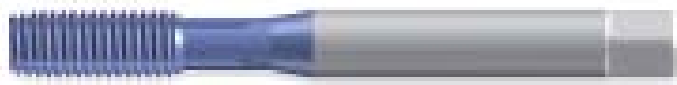
EMULSION



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	R	Code	€
M12	• 1.50	100	22	40	9.0	10	7.0	8	670.143	68.30
M12	• 1.75	110	28	44	9.0	10	7.0	8	670.145	69.80
M14	• 2.00	110	30	44	11.0	12	9.0	8	670.150	90.30
M16	• 1.50	100	22	40	12.0	12	9.0	8	670.152	113.00
M16	• 2.00	110	32	44	12.0	12	9.0	8	670.155	107.00

- METRIC
- METRIC FINE PITCH

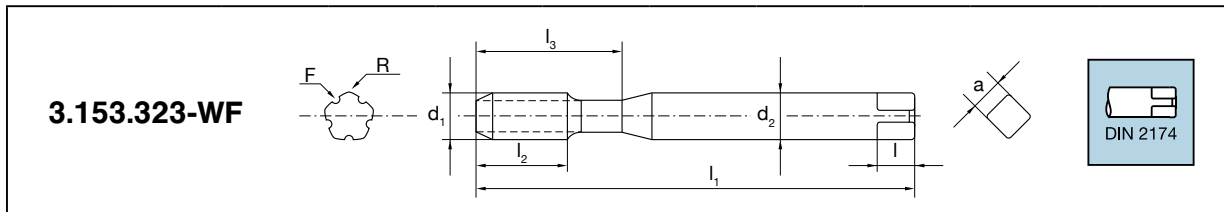
FORMING TAPS



STEEL ≤ 500 N/mm ²	STEEL 500-800 N/mm ²
STEEL 800-1200 N/mm ²	STEEL INOX
ALU	ALU Si <10%
	CU

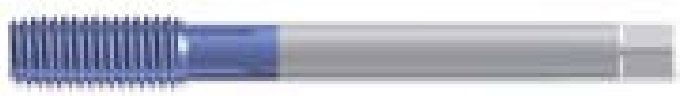
MACHINE TAP

M	MF	60° -P-	6HX	FORM C - 2-3 -xP	TiCN HSSE V3



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	R / F	Code	€
M2	• 0.40	45	8	10	2.8	5	2.1	4 / 2	675.065	36.60
M2.5	• 0.45	50	9	12.5	2.8	5	2.1	4 / 2	675.080	36.60
M3	• 0.35	56	8	18	3.5	6	2.7	4 / 2	675.086	55.10
M3	• 0.50	56	11	18	3.5	6	2.7	4 / 2	675.090	29.90
M3.5	• 0.60	56	12	18	4.0	6	3.0	4 / 2	675.095	32.00
M4	• 0.50	63	10	21	4.5	6	3.4	4 / 2	675.097	55.70
M4	• 0.70	63	13	21	4.5	6	3.4	4 / 2	675.100	29.90
M5	• 0.50	70	12	25	6.0	8	4.9	4 / 2	675.106	58.30
M5	• 0.80	70	16	25	6.0	8	4.9	4 / 2	675.110	31.50
M6	• 0.75	80	14	30	6.0	8	4.9	4 / 2	675.112	60.90
M6	• 1.00	80	19	30	6.0	8	4.9	4 / 2	675.115	32.30
M8	• 1.00	90	22	35	8.0	9	6.2	6 / 3	675.123	62.00
M8	• 1.25	90	22	35	8.0	9	6.2	6 / 3	675.125	38.20
M10	• 1.00	90	20	35	8.0	11	8.0	8 / 4	675.132	68.30
M10	• 1.50	100	24	39	10.0	11	8.0	8 / 4	675.135	49.20

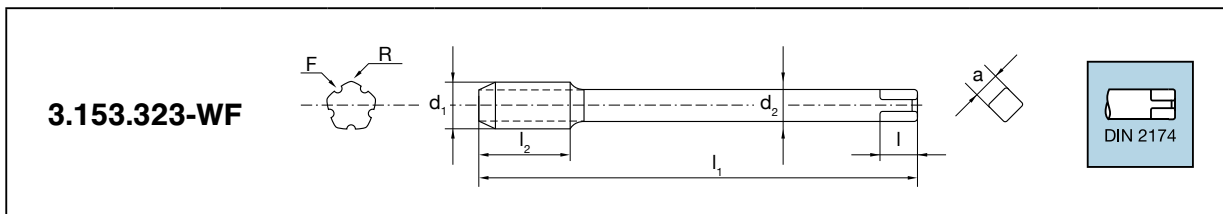
- METRIC
- METRIC FINE PITCH



STEEL ≤ 500 N/mm ²	STEEL 500-800 N/mm ²
STEEL 800-1200 N/mm ²	STEEL INOX
ALU	ALU Si <10%
	CU

MACHINE TAP

M	MF	60° -P-	6HX	FORM C - 2-3 -xP	TiCN HSSE V3



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	R / F	Code	€
M12	• 1.50	100	22	40	9.0	10	7.0	8 / 4	675.143	74.60
M12	• 1.75	110	28	44	9.0	10	7.0	8 / 4	675.145	75.10
M14	• 2.00	110	30	44	11.0	12	9.0	8 / 4	675.150	95.60
M16	• 1.50	100	22	40	12.0	12	9.0	8 / 4	675.152	121.00
M16	• 2.00	110	32	44	12.0	12	9.0	8 / 4	675.155	116.00

- METRIC
- METRIC FINE PITCH

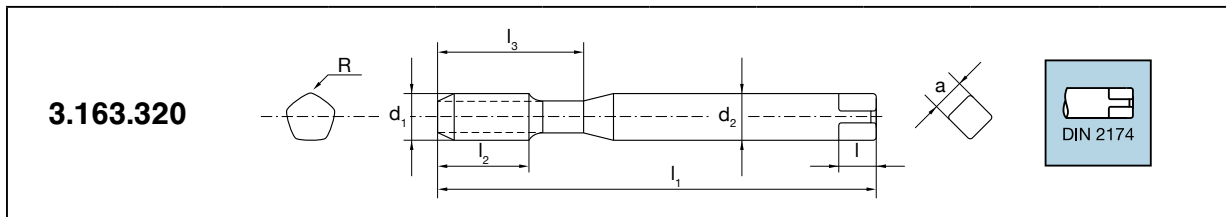
FORMING TAPS



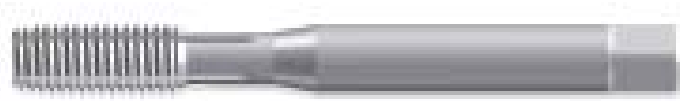
STEEL ≤ 500 N/mm ²	STEEL 500-800 N/mm ²
STEEL 800-1200 N/mm ²	STEEL INOX
ALU	ALU Si <10%
	CU

MACHINE TAP

M	60° -P-	6GX	FORM C - 2-3 -xP	HSSE V3



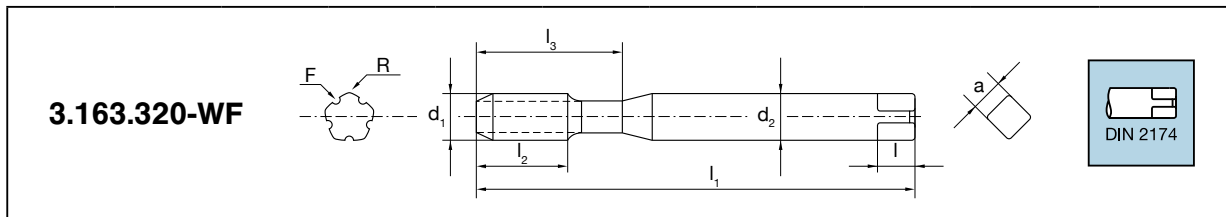
d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	R	Code	€
M2	0.40	45	8	10	2.8	5	2.1	4	680.065	28.40
M2.5	0.45	50	9	12.5	2.8	5	2.1	4	680.080	28.40
M3	0.50	56	11	18	3.5	6	2.7	4	680.090	21.70
M4	0.70	63	13	21	4.5	6	3.4	4	680.100	21.70
M5	0.80	70	16	25	6.0	8	4.9	4	680.110	23.60
M6	1.00	80	19	30	6.0	8	4.9	4	680.115	24.40
M8	1.25	90	22	35	8.0	9	6.2	6	680.125	27.20
M10	1.50	100	24	39	10.0	11	8.0	8	680.135	34.30



STEEL ≤ 500 N/mm ²	STEEL 500-800 N/mm ²
STEEL 800-1200 N/mm ²	STEEL INOX
ALU	ALU Si <10%
	CU

MACHINE TAP

M	60° P	6GX	FORM C 2-3 -xP	HSSE V3



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	R / F	Code	€
M2	0.40	45	8	10	2.8	5	2.1	4 / 2	695.065	32.80
M2.5	0.45	50	9	12.5	2.8	5	2.1	4 / 2	695.080	32.80
M3	0.50	56	11	18	3.5	6	2.7	4 / 2	695.090	24.80
M4	0.70	63	13	21	4.5	6	3.4	4 / 2	695.100	24.80
M5	0.80	70	16	25	6.0	8	4.9	4 / 2	695.110	27.20
M6	1.00	80	19	30	6.0	8	4.9	4 / 2	695.115	28.40
M8	1.25	90	22	35	8.0	9	6.2	6 / 3	695.125	32.80
M10	1.50	100	24	39	10.0	11	8.0	8 / 4	695.135	39.40

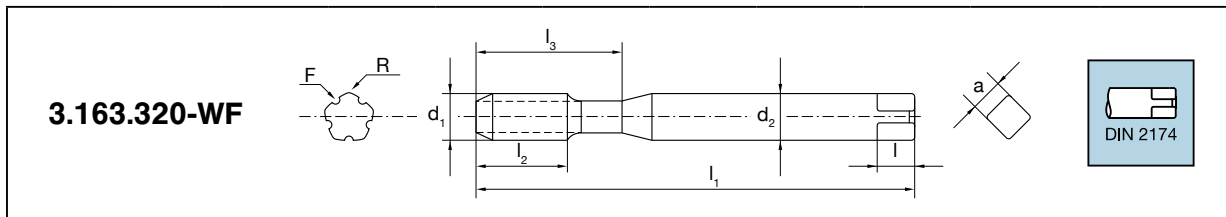
FORMING TAPS



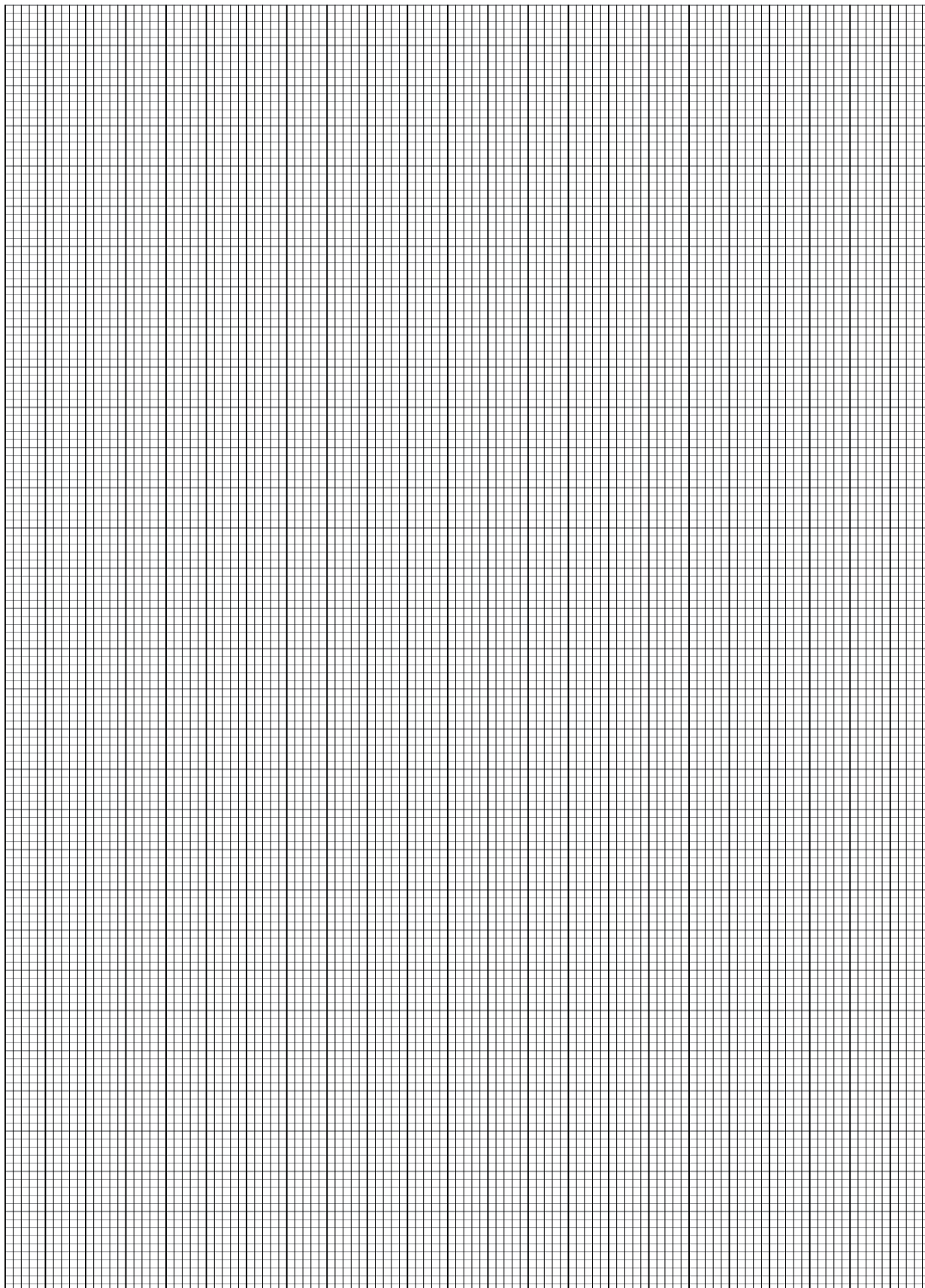
STEEL ≤ 500 N/mm ²	STEEL 500-800 N/mm ²
STEEL 800-1200 N/mm ²	STEEL INOX
ALU	ALU Si <10%
	CU

MACHINE TAP

M	60° -P-	6GX	FORM C - 2-3 -xP	OX HSSE V3



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	R / F	Code	€
M2	0.40	45	8	10	2.8	5	2.1	4 / 2	696.065	32.80
M2.5	0.45	50	9	12.5	2.8	5	2.1	4 / 2	696.080	32.80
M3	0.50	56	11	18	3.5	6	2.7	4 / 2	696.090	24.80
M4	0.70	63	13	21	4.5	6	3.4	4 / 2	696.100	24.80
M5	0.80	70	16	25	6.0	8	4.9	4 / 2	696.110	27.20
M6	1.00	80	19	30	6.0	8	4.9	4 / 2	696.115	28.40
M8	1.25	90	22	35	8.0	9	6.2	6 / 3	696.125	32.80
M10	1.50	100	24	39	10.0	11	8.0	8 / 4	696.135	39.40

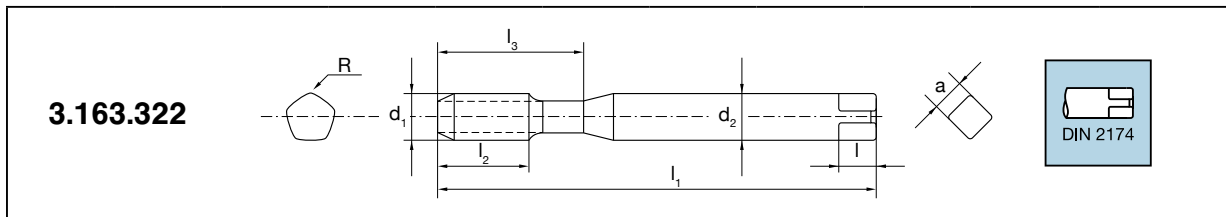




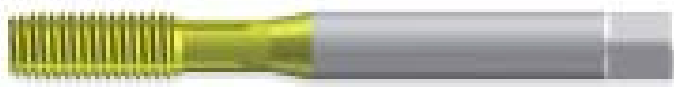
STEEL ≤ 500 N/mm ²	STEEL 500-800 N/mm ²
STEEL 800-1200 N/mm ²	STEEL INOX
ALU	ALU Si <10%
	CU

MACHINE TAP

M	60° -P-	6GX	FORM C - 2-3 -xP	C-COAT HSSE V3



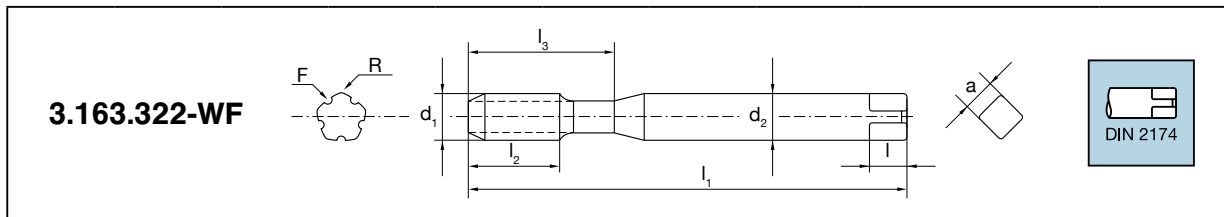
d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	R	Code	€
M2	0.40	45	8	10	2.8	5	2.1	4	685.065	33.10
M2.5	0.45	50	9	12.5	2.8	5	2.1	4	685.080	33.10
M3	0.50	56	11	18	3.5	6	2.7	4	685.090	28.00
M4	0.70	63	13	21	4.5	6	3.4	4	685.100	28.00
M5	0.80	70	16	25	6.0	8	4.9	4	685.110	29.90
M6	1.00	80	19	30	6.0	8	4.9	4	685.115	30.80
M8	1.25	90	22	35	8.0	9	6.2	6	685.125	36.20
M10	1.50	100	24	39	10.0	11	8.0	8	685.135	45.70



STEEL ≤ 500 N/mm ²	STEEL 500-800 N/mm ²
STEEL 800-1200 N/mm ²	STEEL INOX
ALU	ALU Si <10%
	CU

MACHINE TAP

M	60° P	6GX	FORM C 2-3 -xP	C-COAT HSSE V3



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	R / F	Code	€
M2	0.40	45	8	10	2.8	5	2.1	4 / 2	700.065	39.10
M2.5	0.45	50	9	12.5	2.8	5	2.1	4 / 2	700.080	39.10
M3	0.50	56	11	18	3.5	6	2.7	4 / 2	700.090	31.20
M4	0.70	63	13	21	4.5	6	3.4	4 / 2	700.100	31.20
M5	0.80	70	16	25	6.0	8	4.9	4 / 2	700.110	33.50
M6	1.00	80	19	30	6.0	8	4.9	4 / 2	700.115	34.70
M8	1.25	90	22	35	8.0	9	6.2	6 / 3	700.125	40.60
M10	1.50	100	24	39	10.0	11	8.0	8 / 4	700.135	51.20

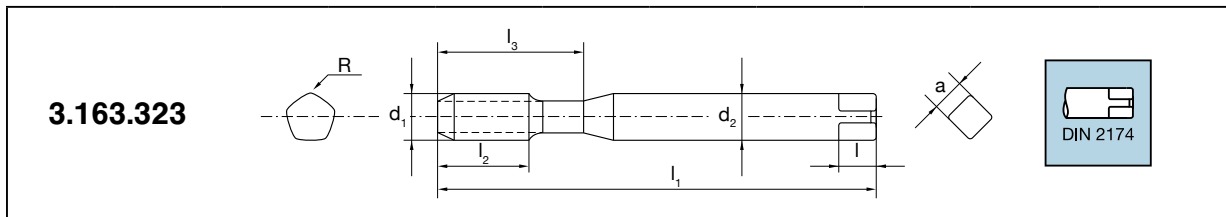
FORMING TAPS



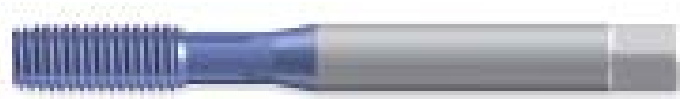
STEEL ≤ 500 N/mm ²	STEEL 500-800 N/mm ²
STEEL 800-1200 N/mm ²	STEEL INOX
ALU	ALU Si <10%
	CU

MACHINE TAP

M	60° -P-	6GX	FORM C - 2-3 -xP	TiCN HSSE V3



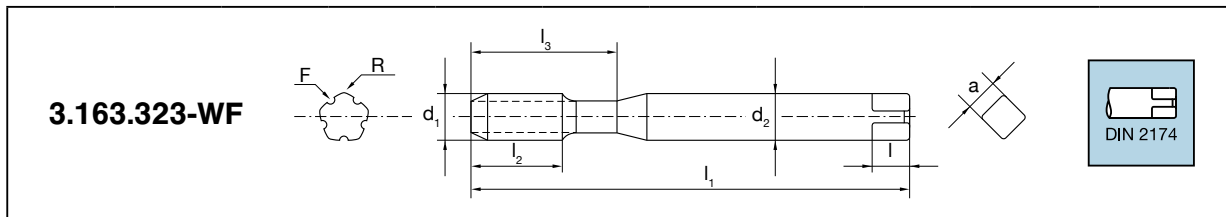
d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	R	Code	€
M2	0.40	45	8	10	2.8	5	2.1	4	690.065	33.90
M2.5	0.45	50	9	12.5	2.8	5	2.1	4	690.080	33.90
M3	0.50	56	11	18	3.5	6	2.7	4	690.090	28.80
M4	0.70	63	13	21	4.5	6	3.4	4	690.100	28.80
M5	0.80	70	16	25	6.0	8	4.9	4	690.110	30.80
M6	1.00	80	19	30	6.0	8	4.9	4	690.115	31.50
M8	1.25	90	22	35	8.0	9	6.2	6	690.125	37.10
M10	1.50	100	24	39	10.0	11	8.0	8	690.135	47.30



STEEL ≤ 500 N/mm ²	STEEL 500-800 N/mm ²
STEEL 800-1200 N/mm ²	STEEL INOX
ALU	ALU Si <10%
	CU

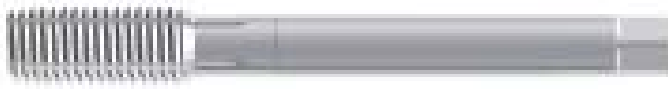
MACHINE TAP

M	60° P	6GX	FORM C 2-3 -xP	TiCN HSSE V3
		>2xd	OIL	EMULSION



d ₁	P	l ₁	l ₂	l ₃	d ₂	l	a	R / F	Code	€
M2	0.40	45	8	10	2.8	5	2.1	4 / 2	676.065	39.80
M2.5	0.45	50	9	12.5	2.8	5	2.1	4 / 2	676.080	39.80
M3	0.50	56	11	18	3.5	6	2.7	4 / 2	676.090	31.90
M3.5	0.60	56	12	18	4.0	6	2.7	4 / 2	676.095	34.10
M4	0.70	63	13	21	4.5	6	3.0	4 / 2	676.100	31.90
M5	0.80	70	16	25	6.0	8	4.9	4 / 2	676.110	34.30
M6	1.00	80	19	30	6.0	8	4.9	4 / 2	676.115	35.50
M8	1.25	90	22	35	8.0	9	6.2	6 / 3	676.125	41.40
M10	1.50	100	24	39	10.0	11	8.0	8 / 4	676.135	53.00

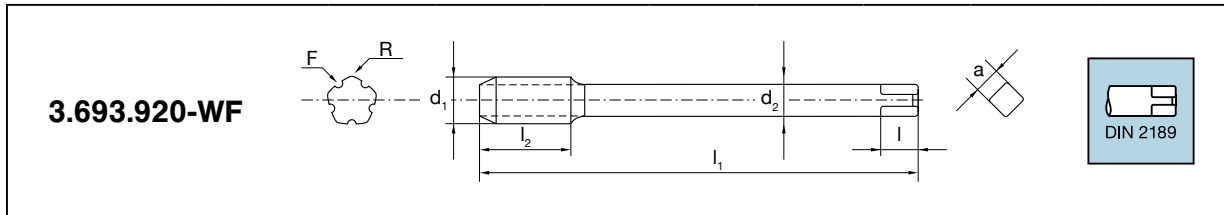
FORMING TAPS



STEEL ≤ 500 N/mm ²	STEEL 500-800 N/mm ²
STEEL 800-1200 N/mm ²	STEEL INOX
ALU	ALU Si <10%
	CU

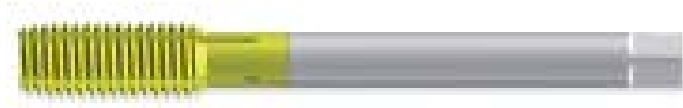
MACHINE TAP

G	55° -P-	6HX	FORM C - 2-3 -xP	HSSE V3



d ₁	P TPi	l ₁	l ₂	l ₃	d ₂	l	a	R / F	Code	€
1/8	28	90	20		7.0	8	5.5	8 / 4	770.005	52.10
1/4	19	100	22		11.0	12	9	8 / 4	770.010	70.90
3/8	19	100	22		12.0	12	9	8 / 4	770.015	82.40

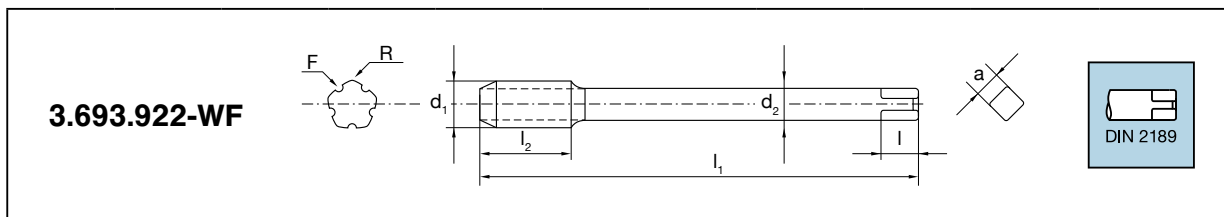
FORMING TAPS



STEEL ≤ 500 N/mm ²	STEEL 500-800 N/mm ²
STEEL 800-1200 N/mm ²	STEEL INOX
ALU	ALU Si <10%
	CU

MACHINE TAP

G		6HX	FORM C - 2-3 -xP	C-COAT HSSE V3
		>2xd	OIL	EMULSION



d ₁	P TPI	l ₁	l ₂	l ₃	d ₂	l	a	R / F	Code	€
1/8	28	90	20		7.0	8	5.5	8 / 4	775.005	63.50
1/4	19	100	22		11.0	12	9	8 / 4	775.010	85.10
3/8	19	100	22		12.0	12	9	8 / 4	775.015	111.00

FORMING TAPS

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