

SUPERIOR PERFORMANCE



HARDSLICK SP/POINT & SP/FLUTE

APPLICATION TAPS



IDEAL FOR MATERIAL GROUPS



Clarkson GmbH
Heinrich-Hertz Str.52
40699 Erkrath
Tel.: 0211/72003-0 Fax: 0211/72003-33
Email: info@clarkson.de
Web: www.clarkson.de

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●: Excellent ○: Good

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► CONTINUED OVERLEAF

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- ▶ For full material group tables, refer to pages 140 - 145

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●: Excellent ○: Good

- ▶ For material group examples, refer to page 2
- ▶ For full material group tables, refer to pages 140 - 145

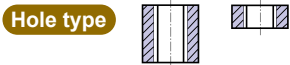
M METRIC COARSE THREADS



Series No. TM0516, TM0616

► cutting conditions : p.89

Spiral point.
Interrupted thread for reduced torque.
Aluminium and Aluminium alloys.



Ød ₁ mm	X	P mm	l ₂	l ₁	d ₂	sq	Tapping drill diameter	EUROPA CODE
M 2	X	0.4	8	45	2.8	2.1	1.6	TM05160200
M 2.5	X	0.45	9	50	2.8	2.1	2.05	TM05160250
M 3	X	0.5	6	56	3.5	2.7	2.5	TM05160300
M 4	X	0.7	7	63	4.5	3.4	3.3	TM05160400
M 5	X	0.8	8	70	6	4.9	4.2	TM05160500
M 6	X	1.0	10	80	6	4.9	5	TM05160600
M 8	X	1.25	13	90	8	6.2	6.8	TM05160800
M 10	X	1.5	15	100	10	8	8.5	TM05161000
M 12	X	1.75	18	110	9	7	10.2	TM06161200
M 14	X	2.0	26	110	11	9	12	TM06161400
M 16	X	2.0	20	110	12	9	14	TM06161600
M 18	X	2.5	30	125	14	11	15.5	TM06161800
M 20	X	2.5	32	140	16	12	17.5	TM06162000

► DIN 371(M2-M10) DIN 376(M12-M20)

●: Excellent ○: Good															
P		H		M		K		S		N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
○	○						○			●					
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
○										●	●	●			

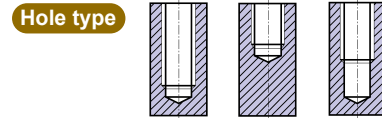
M METRIC COARSE THREADS



Series No. TM3716

► cutting conditions : p.89

Spiral flute.
Excellent chip evacuation due to
45° helix angle.
Aluminium and Aluminium alloys.



Ød ₁ mm	X	P mm	l ₂	l ₁	d ₂	sq	Tapping drill diameter	EUROPA CODE
M 2	X	0.4	8	45	2.8	2.1	1.6	TM37160200
M 2.5	X	0.45	9	50	2.8	2.1	2.05	TM37160250
M 3	X	0.5	6	56	3.5	2.7	2.5	TM37160300
M 3.5	X	0.6	7	56	4	3	2.9	TM37160350
M 4	X	0.7	7	63	4.5	3.4	3.3	TM37160400
M 5	X	0.8	8	70	6	4.9	4.2	TM37160500
M 6	X	1.0	10	80	6	4.9	5	TM37160600
M 8	X	1.25	13	90	8	6.2	6.8	TM37160800
M 10	X	1.5	15	100	10	8	8.5	TM37161000
M 12	X	1.75	18	110	9	7	10.2	TM37161200
M 14	X	2.0	20	110	11	9	12	TM37161400
M 16	X	2.0	20	110	12	9	14	TM37161600
M 18	X	2.5	25	125	14	11	15.5	TM37161800
M 20	X	2.5	25	140	16	12	17.5	TM37162000

► DIN 371(M2-M10) DIN 376(M12-M20)

●: Excellent ○: Good															
P		H		M		K		S		N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
○	○						○			●					
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
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METRIC COARSE THREADS



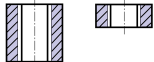
Series No. TM3130, TM3230

▶ cutting conditions : p.89

Spiral point.
Thick web for higher cutting speed.
Stainless steel and tough materials.



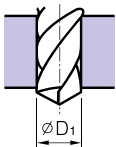
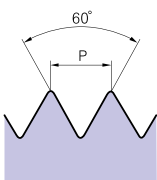
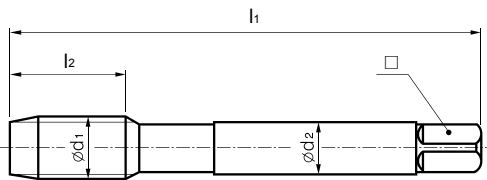
Hole type



DIN 371



DIN 376



Ød ₁ mm	X	P mm	l ₂	l ₁	d ₂	sq	Tapping drill diameter	EUROPA CODE
M 2	X	0.4	8	45	2.8	2.1	1.6	TM31300200
M 2.5	X	0.45	9	50	2.8	2.1	2.05	TM31300250
M 3	X	0.5	11	56	3.5	2.7	2.5	TM31300300
M 4	X	0.7	13	63	4.5	3.4	3.3	TM31300400
M 5	X	0.8	15	70	6	4.9	4.2	TM31300500
M 6	X	1.0	17	80	6	4.9	5	TM31300600
M 8	X	1.25	20	90	8	6.2	6.8	TM31300800
M 10	X	1.5	22	100	10	8	8.5	TM31301000
M 12	X	1.75	24	110	9	7	10.2	TM32301200
M 14	X	2.0	26	110	11	9	12	TM32301400
M 16	X	2.0	27	110	12	9	14	TM32301600
M 18	X	2.5	30	125	14	11	15.5	TM32301800
M 20	X	2.5	32	140	16	12	17.5	TM32302000

▶ DIN 371(M2-M10) DIN 376(M12-M20)

●: Excellent ○: Good

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
●	●		●	●				○							
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
			●					○							

METRIC COARSE THREADS

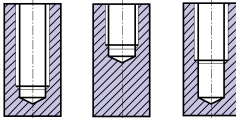


Series No. TM2530, TM2630

▶ cutting conditions : p.89

Spiral flute.
Recessed threads for tapping deep
holes.
Stainless steel and tough materials.

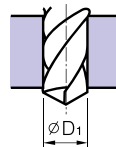
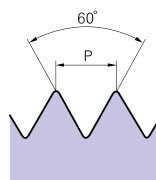
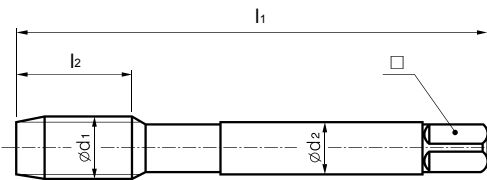
Hole type



DIN 371



DIN 376



Ød ₁ mm	X	P mm	l ₂	l ₁	d ₂	sq	Tapping drill diameter	EUROPA CODE
M 3	X	0.5	6	56	3.5	2.7	2.5	TM25300300
M 4	X	0.7	7	63	4.5	3.4	3.3	TM25300400
M 5	X	0.8	8	70	6	4.9	4.2	TM25300500
M 6	X	1.0	10	80	6	4.9	5	TM25300600
M 8	X	1.25	13	90	8	6.2	6.8	TM25300800
M 10	X	1.5	15	100	10	8	8.5	TM25301000
M 12	X	1.75	18	110	9	7	10.2	TM26301200
M 14	X	2.0	20	110	11	9	12	TM26301400
M 16	X	2.0	20	110	12	9	14	TM26301600
M 18	X	2.5	25	125	14	11	15.5	TM26301800
M 20	X	2.5	25	140	16	12	17.5	TM26302000

▶ DIN 371(M3-M10) DIN 376(M12-M20)

●: Excellent ○: Good

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
●	●		●	●				○							
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
			●					○							

METRIC COARSE THREADS



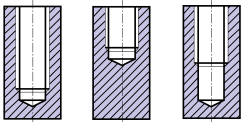
Series No. TM8153

▶ cutting conditions : p.88

Spiral flute.
Recessed threads for tapping deep holes.
Stainless steel and tough materials.
Hardslick coated for increased tool life.



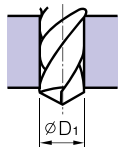
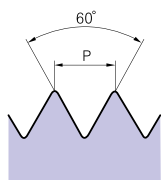
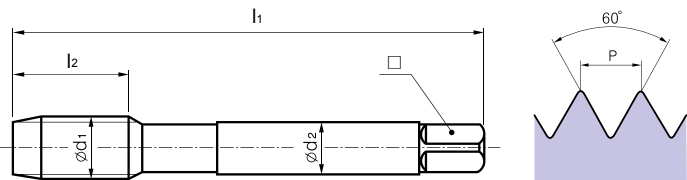
Hole type



DIN 371



DIN 376



Ød ₁ mm	X	P mm	l ₂	l ₁	d ₂	sq	Tapping drill diameter	EUROPA CODE
M 3	X	0.5	11	56	3.5	2.7	2.5	TM81530300
M 4	X	0.7	13	63	4.5	3.4	3.3	TM81530400
M 5	X	0.8	15	70	6	4.9	4.2	TM81530500
M 6	X	1.0	17	80	6	4.9	5	TM81530600
M 8	X	1.25	20	90	8	6.2	6.8	TM81530800
M 10	X	1.5	22	100	10	8	8.5	TM81531000
M 12	X	1.75	24	110	9	7	10.2	TM81531200
M 14	X	2.0	20	110	11	9	12	TM81531400
M 16	X	2.0	27	110	12	9	14	TM81531600
M 18	X	2.5	30	125	14	11	15.5	TM81531800
M 20	X	2.5	25	140	16	12	17.5	TM81532000
M 22	X	2.5	25	140	18	14.5	19.5	TM81532200
M 24	X	3.0	30	160	18	14.5	21	TM81532400
M 27	X	3.0	30	160	20	16	24	TM81532700
M 30	X	3.5	35	180	22	18	26.5	TM81533000

▶ DIN 371(M3-M10) DIN 376(M12-M30)

●: Excellent ○: Good

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
●	●		●	●				○							
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
			●					○							

METRIC COARSE THREADS



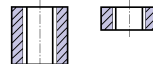
Series No. TM8053

▶ cutting conditions : p.88

Spiral point.
Thick web for higher cutting speed.
Stainless steel and tough materials.
Hardslick coated for increased tool life.



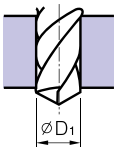
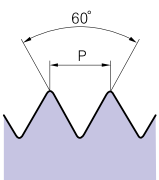
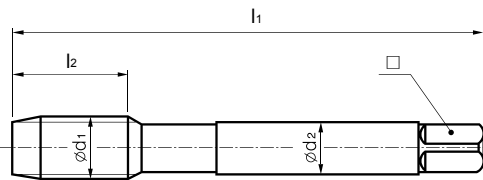
Hole type



DIN 371



DIN 376



Ød ₁ mm	X	P mm	l ₂	l ₁	d ₂	sq	Tapping drill diameter	EUROPA CODE
M 3	X	0.5	11	56	3.5	2.7	2.5	TM80530300
M 4	X	0.7	13	63	4.5	3.4	3.3	TM80530400
M 5	X	0.8	15	70	6	4.9	4.2	TM80530500
M 6	X	1.0	17	80	6	4.9	5	TM80530600
M 8	X	1.25	20	90	8	6.2	6.8	TM80530800
M 10	X	1.5	22	100	10	8	8.5	TM80531000
M 12	X	1.75	24	110	9	7	10.2	TM80531200
M 14	X	2.0	26	110	11	9	12	TM80531400
M 16	X	2.0	27	110	12	9	14	TM80531600
M 18	X	2.5	30	125	14	11	15.5	TM80531800
M 20	X	2.5	32	140	16	12	17.5	TM80532000
M 22	X	2.5	32	140	18	14.5	19.5	TM80532200
M 24	X	3.0	34	160	18	14.5	21	TM80532400
M 27	X	3.0	36	160	20	16	24	TM80532700
M 30	X	3.5	40	180	22	18	26.5	TM80533000

▶ DIN 371(M3-M10) DIN 376(M12-M30)

●: Excellent ○: Good

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
●	●		●	●				○							
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
			●					○							

MF METRIC FINE THREADS



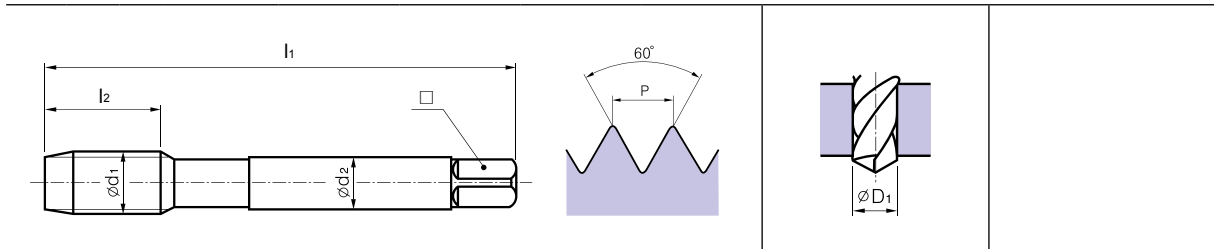
Series No. TM3830

▶ cutting conditions : p.89

Spiral flute.
Stainless steel and tough materials.



DIN 374



Ød ₁ mm	X	P mm	l ₂	l ₁	d ₂	sq	Tapping drill diameter	EUROPA CODE
M 4	X	0.5	5	63	2.8	2.1	3.5	TM38300400
M 5	X	0.5	5	70	3.5	2.7	4.5	TM38300500
M 6	X	0.5	5	80	4.5	3.4	5.5	TM38300600
M 6	X	0.75	8	80	4.5	3.4	5.2	TM38300601
M 8	X	0.75	8	80	6	4.9	7.2	TM38300800
M 8	X	1.0	10	90	6	4.9	7	TM38300801
M 10	X	0.75	10	90	7	5.5	9.2	TM38301000
M 10	X	1.0	10	90	7	5.5	9	TM38301001
M 10	X	1.25	16	100	7	5.5	8.8	TM38301002
M 12	X	1.0	11	100	9	7	11	TM38301200
M 12	X	1.25	15	100	9	7	10.8	TM38301201
M 12	X	1.5	15	100	9	7	10.5	TM38301202
M 14	X	1.25	15	100	11	9	12.8	TM38301400
M 14	X	1.5	15	100	11	9	12.5	TM38301401
M 16	X	1.5	15	100	12	9	14.5	TM38301600
M 18	X	1.5	17	110	14	11	16.5	TM38301800
M 20	X	1.5	17	125	16	12	18.5	TM38302000
M 22	X	1.5	17	125	18	14.5	20.5	TM38302200
M 24	X	1.5	20	140	18	14.5	22.5	TM38302400

▶ DIN 374(M4-M24)

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
●	●		●	●				○							
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
			●					○							

MF METRIC FINE THREADS



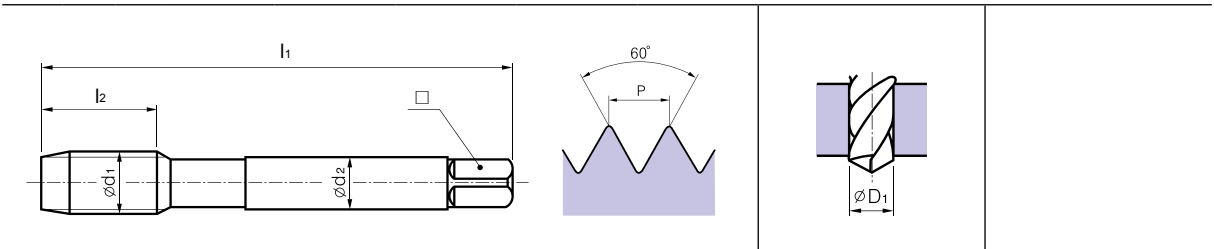
Series No. TM3630

▶ cutting conditions : p.89

Spiral point.
Thick web for higher cutting speed.
Stainless steel and tough materials.



DIN 374



Ød ₁ mm	X	P mm	l ₂	l ₁	d ₂	sq	Tapping drill diameter	EUROPA CODE
M 4	X	0.5	10	63	2.8	2.1	3.5	TM36300400
M 5	X	0.5	11	70	3.5	2.7	4.5	TM36300500
M 6	X	0.5	13	80	4.5	3.4	5.5	TM36300600
M 6	X	0.75	13	80	4.5	3.4	5.2	TM36300601
M 8	X	0.75	14	80	6	4.9	7.2	TM36300800
M 8	X	1.0	17	90	6	4.9	7	TM36300801
M 10	X	0.75	18	90	7	5.5	9.2	TM36301000
M 10	X	1.0	18	90	7	5.5	9	TM36301001
M 10	X	1.25	22	100	7	5.5	8.8	TM36301002
M 12	X	1.0	18	100	9	7	11	TM36301200
M 12	X	1.25	22	100	9	7	10.8	TM36301201
M 12	X	1.5	22	100	9	7	10.5	TM36301202
M 14	X	1.25	22	100	11	9	12.8	TM36301400
M 14	X	1.5	22	100	11	9	12.5	TM36301401
M 16	X	1.5	22	100	12	9	14.5	TM36301600
M 18	X	1.5	25	110	14	11	16.5	TM36301800
M 20	X	1.5	25	125	16	12	18.5	TM36302000
M 22	X	1.5	25	125	18	14.5	20.5	TM36302200
M 24	X	1.5	27	140	18	14.5	22.5	TM36302400

▶ DIN 374(M4-M24)

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
●	●		●	●				○							
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
			●					○							

UNC UNIFIED COARSE THREADS



Series No. TM6530

▶ cutting conditions : p.89

Spiral flute.
Stainless steel and tough materials.



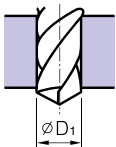
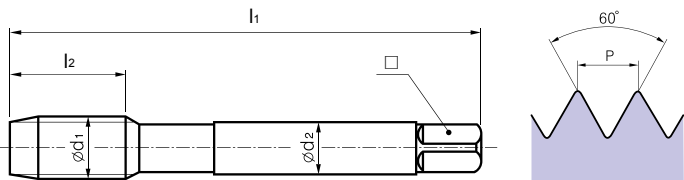
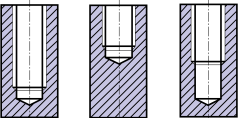
DIN 371



DIN 376



Hole type



Ød ₁ inch	X	P inch	l ₂	l ₁	d ₂	sq	Tapping drill diameter	EUROPA CODE
No.4	X	40	6	56	3.5	2.7	2.3	TM65300400
No.5	X	40	7	56	3.5	2.7	2.6	TM65300500
No.6	X	32	7	56	4	3	2.85	TM65300600
No.8	X	32	8	63	4.5	3.4	3.5	TM65300800
No.10	X	24	10	70	6	4.9	3.9	TM65301000
No.12	X	24	10	80	6	4.9	4.5	TM65301200
1/4	X	20	13	80	7	5.5	5.2	TM65309160
5/16	X	18	14	90	8	6.2	6.6	TM65309200
3/8	X	16	16	100	9	7	8	TM65309240
7/16	X	14	17	100	8	6.2	9.4	TM65309280
1/2	X	13	20	110	9	7	10.75	TM65309320
9/16	X	12	20	110	11	9	12.25	TM65309360
5/8	X	11	22	110	12	9	13.5	TM65309400
3/4	X	10	25	125	14	11	16.5	TM65309480
7/8	X	9	27	140	18	14.5	19.5	TM65309560
1"	X	8	30	160	20	16	22.25	TM65309640

▶ DIN 371(No.4-3/8") DIN 376(7/16"-1")

●: Excellent ○: Good

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
●	●		●	●				○							
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
			●					○							

UNC UNIFIED COARSE THREADS



Series No. TM6430

▶ cutting conditions : p.89

Spiral point.
Thick web for higher cutting speed.
Stainless steel and tough materials.



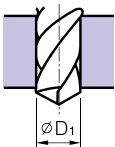
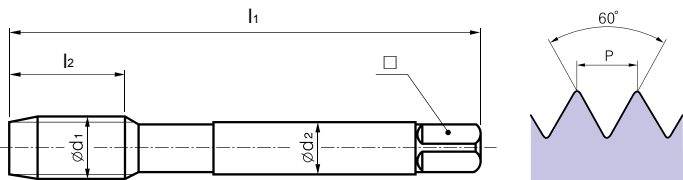
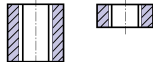
DIN 371



DIN 376



Hole type



Ød ₁ inch	X	P inch	l ₂	l ₁	d ₂	sq	Tapping drill diameter	EUROPA CODE
No.4	X	40	11	56	3.5	2.7	2.3	TM64300400
No.5	X	40	11	56	3.5	2.7	2.6	TM64300500
No.6	X	32	12	56	4	3	2.85	TM64300600
No.8	X	32	13	63	4.5	3.4	3.5	TM64300800
No.10	X	24	15	70	6	4.9	3.9	TM64301000
No.12	X	24	16	80	6	4.9	4.5	TM64301200
1/4	X	20	17	80	7	5.5	5.2	TM64309160
5/16	X	18	20	90	8	6.2	6.6	TM64309200
3/8	X	16	22	100	9	7	8	TM64309240
7/16	X	14	22	100	8	6.2	9.4	TM64309280
1/2	X	13	25	110	9	7	10.75	TM64309320
9/16	X	12	26	110	11	9	12.25	TM64309360
5/8	X	11	27	110	12	9	13.5	TM64309400
3/4	X	10	30	125	14	11	16.5	TM64309480
7/8	X	9	32	140	18	14.5	19.5	TM64309560
1"	X	8	36	160	20	16	22.25	TM64309640

▶ DIN 371(No.4-3/8") DIN 376(7/16"-1")

●: Excellent ○: Good

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
●	●		●	●				○							
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
			●					○							

UNF UNIFIED FINE THREADS



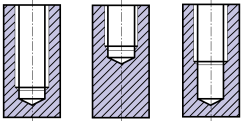
Series No. TM6830

▶ cutting conditions : p.89

Spiral flute.
Stainless steel and tough materials.



Hole type



Ød ₁ inch	X	P inch	l ₂	l ₁	d ₂	sq	Tapping drill diameter	EUROPA CODE
No.4	X	48	9	56	3.5	2.7	2.4	TM68300400
No.5	X	44	7	56	3.5	2.7	2.7	TM68300500
No.6	X	40	7	56	4	3	3	TM68300600
No.8	X	36	8	63	4.5	3.4	3.5	TM68300800
No.10	X	32	10	70	6	4.9	4.1	TM68301000
No.12	X	28	10	80	6	4.9	4.7	TM68301200
1/4	X	28	10	80	7	5.5	5.5	TM68309160
5/16	X	24	10	90	8	6.2	6.9	TM68309200
3/8	X	24	10	100	9	7	8.5	TM68309240
7/16	X	20	13	100	8	6.2	9.9	TM68309280
1/2	X	20	13	100	9	7	11.5	TM68309320
9/16	X	18	15	100	11	9	12.9	TM68309360
5/8	X	18	15	100	12	9	14.5	TM68309400
3/4	X	16	17	110	14	11	17.5	TM68309480
7/8	X	14	17	125	18	14.5	20.5	TM68309560
1"	X	12	20	140	20	16	23.25	TM68309640

▶ DIN 371(No.4-3/8") DIN 374(7/16"-1")

●: Excellent ○: Good															
P	H	M	K	S	N	O									
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
●	●		●	●				○							
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
			●					○							

UNF UNIFIED FINE THREADS



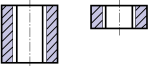
Series No. TM6730

▶ cutting conditions : p.89

Spiral point.
Thick web for higher cutting speed.
Stainless steel and tough materials.



Hole type



Ød ₁ inch	X	P inch	l ₂	l ₁	d ₂	sq	Tapping drill diameter	EUROPA CODE
No.4	X	48	11	56	3.5	2.7	2.4	TM67300400
No.5	X	44	11	56	3.5	2.7	2.7	TM67300500
No.6	X	40	12	56	4	3	3	TM67300600
No.8	X	36	13	63	4.5	3.4	3.5	TM67300800
No.10	X	32	13	70	6	4.9	4.1	TM67301000
No.12	X	28	16	80	6	4.9	4.7	TM67301200
1/4	X	28	17	80	7	5.5	5.5	TM67309160
5/16	X	24	17	90	8	6.2	6.9	TM67309200
3/8	X	24	18	100	9	7	5.8	TM67309240
7/16	X	20	22	100	8	6.2	9.9	TM67309280
1/2	X	20	22	100	9	7	11.5	TM67309320
9/16	X	18	22	100	11	9	12.9	TM67309360
5/8	X	18	22	100	12	9	14.5	TM67309400
3/4	X	16	25	110	14	11	17.5	TM67309480
7/8	X	14	26	125	18	14.5	20.5	TM67309560
1"	X	12	28	140	20	16	23.25	TM67309640

▶ DIN 371(No.4-3/8") DIN 374(7/16"-1")

●: Excellent ○: Good															
P	H	M	K	S	N	O									
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
●	●		●	●				○							
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
			●					○							

M METRIC COARSE THREADS

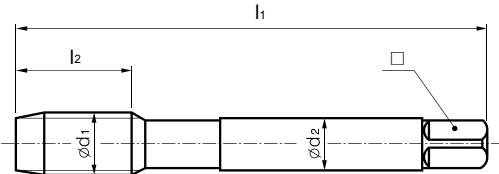
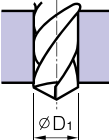


Series No. TM1730, TM1830

► cutting conditions : p.89

Spiral flute.
Low carbon steels.



								
Ød ₁ mm	X	P mm	l ₂	l ₁	d ₂	sq	Tapping drill diameter	EUROPA CODE
M 3	X	0.5	6	45	3.5	2.7	2.5	TM17300300
M 4	X	0.7	7	63	4.5	3.4	3.3	TM17300400
M 5	X	0.8	8	70	6	4.9	4.2	TM17300500
M 6	X	1.0	10	80	6	4.9	5	TM17300600
M 8	X	1.25	13	90	8	6.2	6.8	TM17300800
M 10	X	1.5	15	100	10	8	8.5	TM17301000
M 12	X	1.75	18	110	9	7	10.2	TM18301200
M 14	X	2.0	20	110	11	9	12	TM18301400
M 16	X	2.0	20	110	12	9	14	TM18301600
M 18	X	2.5	25	125	14	11	15.5	TM18301800
M 20	X	2.0	25	140	16	12	17.5	TM18302000

► DIN 371(M3-M10) DIN 376(M12-M20)

●: Excellent ○: Good															
P	H	M	K	S	N				O						
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
●	●									○					
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
										○					

M METRIC COARSE THREADS

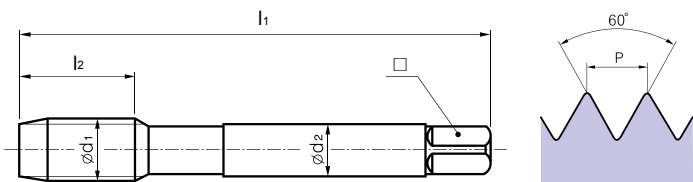
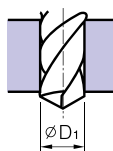


Series No. TM2330, TM2430

► cutting conditions : p.87

Spiral flute.
High tensile steels >1200N/mm²
and hardened materials.



								
Ød ₁ mm	X	P mm	l ₂	l ₁	d ₂	sq	Tapping drill diameter	EUROPA CODE
M 2	X	0.4	8	45	2.8	2.1	1.6	TM23300200
M 2.5	X	0.45	9	50	2.8	2.1	2.05	TM23300250
M 3	X	0.5	6	56	3.5	2.7	2.5	TM23300300
M 4	X	0.7	7	663	4.5	3.4	3.3	TM23300400
M 5	X	0.8	8	70	6	4.9	4.2	TM23300500
M 6	X	1.0	10	80	6	4.9	5	TM23300600
M 8	X	1.25	13	90	8	6.2	6.8	TM23300800
M 10	X	1.5	15	100	10	8	8.5	TM23301000
M 12	X	1.75	18	110	9	7	10.2	TM24301200
M 14	X	2.0	20	110	11	9	12	TM24301400
M 16	X	2.0	20	110	12	9	14	TM24301600
M 18	X	2.5	25	125	14	11	15.5	TM24301800
M 20	X	2.5	25	140	16	12	17.5	TM24302000

► DIN 371(M2-M10) DIN 376(M12-M20)

●: Excellent ○: Good															
P	H	M	K	S	N				O						
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
		○								○		●			○
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
		●	○											○	

M METRIC COARSE THREADS



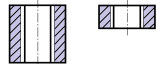
Series No. TM2716, TM2816

► cutting conditions : p.87

Spiral point.
Thick web for higher cutting speed.
High tensile steels <1200N/mm² and hardened materials.



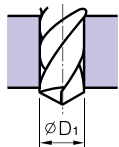
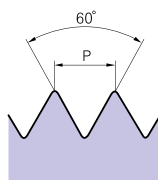
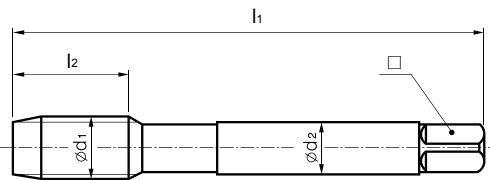
Hole type



DIN 371



DIN 376



Ød ₁ mm	X	P mm	l ₂	l ₁	d ₂	sq	Tapping drill diameter	EUROPA CODE
M 2	X	0.4	8	45	2.8	2.1	1.6	TM27160200
M 2.5	X	0.45	9	50	2.8	2.1	2.05	TM27160250
M 3	X	0.5	11	56	3.5	2.7	2.5	TM27160300
M 3.5	X	0.6	12	56	4	3	2.9	TM27160350
M 4	X	0.7	13	63	4.5	3.4	3.3	TM27160400
M 4.5	X	0.75	14	70	6	4.9	3.7	TM27160450
M 5	X	0.8	15	70	6	4.9	4.2	TM27160500
M 6	X	1.0	17	80	6	4.9	5	TM27160600
M 8	X	1.25	20	90	8	6.2	6.8	TM27160800
M 10	X	1.5	22	100	10	8	8.5	TM27161000
M 12	X	1.75	24	110	9	7	10.2	TM28161200
M 14	X	2.0	26	110	11	9	12	TM28161400
M 16	X	2.0	27	110	12	9	14	TM28161600
M 18	X	2.5	30	125	14	11	15.5	TM28161800
M 20	X	2.5	32	140	16	12	17.5	TM28162000
M 22	X	2.5	32	140	18	14.5	19.5	TM28162200
M 24	X	3.0	34	160	18	14.5	21	TM28162400
M 27	X	3.0	36	160	20	16	24	TM28162700
M 30	X	3.5	40	180	22	18	26.5	TM28163000

► DIN 371(M2-M10) DIN 376(M12-M30)

●: Excellent ○: Good

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
		●						○							
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
	○		○					○							

M METRIC COARSE THREADS

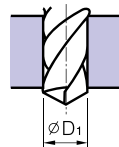
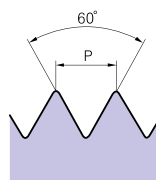
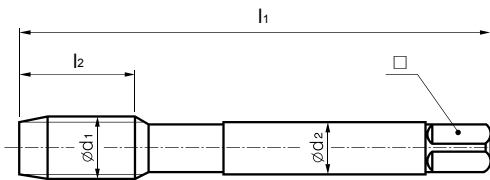
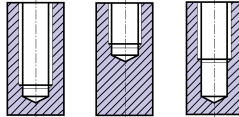


Series No. TM6316

► cutting conditions : p.87

Spiral flute.
High tensile steels <1200N/mm²
and hardened materials.

Hole type



Ød ₁ mm	X	P mm	l ₂	l ₁	d ₂	sq	Tapping drill diameter	EUROPA CODE
M 2	X	0.4	8	45	2.8	2.1	1.6	TM63160200
M 2.2	X	0.45	8	45	2.8	2.1	1.75	TM63160220
M 2.5	X	0.45	9	50	2.8	2.1	2.05	TM63160250
M 3	X	0.5	6	56	3.5	2.7	2.5	TM63160300
M 3.5	X	0.6	7	56	4	3	2.9	TM63160350
M 4	X	0.7	7	63	4.5	3.4	3.3	TM63160400
M 5	X	0.8	8	70	6	4.9	4.2	TM63160500
M 6	X	1.0	10	80	6	4.9	5	TM63160600
M 8	X	1.25	13	90	8	6.2	6.8	TM63160800
M 10	X	1.5	15	100	10	8	8.5	TM63161000
M 12	X	1.75	18	110	9	7	10.2	TM63161200
M 14	X	2.0	20	110	11	9	12	TM63161400
M 16	X	2.0	20	110	12	9	14	TM63161600
M 18	X	2.5	25	125	14	11	15.5	TM63161800
M 20	X	2.5	25	140	16	12	17.5	TM63162000

► DIN 371(M3-M10) DIN 376(M12-M20)

●: Excellent ○: Good

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
		●						○							
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
	○		○					○							

M METRIC COARSE THREADS



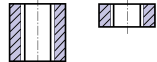
Series No. TM2917, TM3017

► cutting conditions : p.87

Spiral point.
Thick web for higher cutting speed.
High tensile steels >1200N/mm² and
hardened materials.
TiN coated for increased tool life.



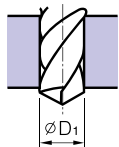
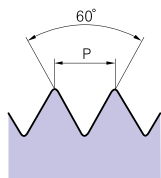
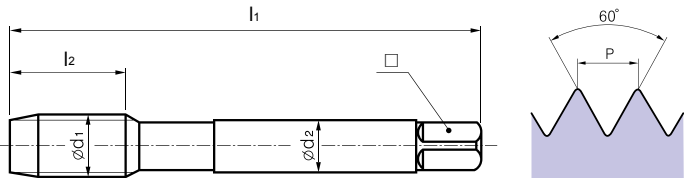
Hole type



DIN 371



DIN 376



Ød ₁ mm	X	P mm	l ₂	l ₁	d ₂	sq	Tapping drill diameter	EUROPA CODE
M 3	X	0.5	6	56	3.5	2.7	2.5	TM29170300
M 4	X	0.7	7	63	4.5	3.4	3.3	TM29170400
M 5	X	0.8	8	70	6	4.9	4.2	TM29170500
M 6	X	1.0	10	80	6	4.9	5	TM29170600
M 8	X	1.25	13	90	8	6.2	6.8	TM29170800
M 10	X	1.5	15	100	10	8	8.5	TM29171000
M 12	X	1.75	18	110	9	7	10.2	TM30171200
M 14	X	2.0	20	110	11	9	12	TM30171400
M 16	X	2.0	20	110	12	9	14	TM30171600
M 20	X	2.5	25	140	16	12	17.5	TM30172000

► DIN 371(M3-M10) DIN 376(M12-M20)

●: Excellent ○: Good

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
		●						○							
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
	○		○					○							

M METRIC COARSE THREADS

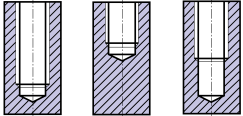


Series No. TM2817

► cutting conditions : p.87

Spiral flute.
High tensile steels >1200N/mm²
and hardened materials.
TiN coated for increased tool life.

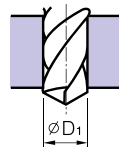
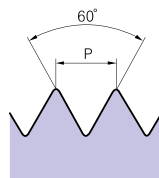
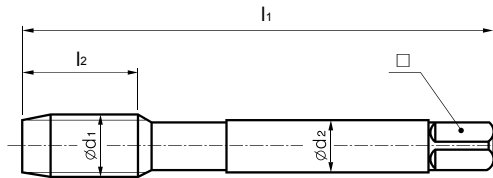
Hole type



DIN 371



DIN 376



Ød ₁ mm	X	P mm	l ₂	l ₁	d ₂	sq	Tapping drill diameter	EUROPA CODE
M 2	X	0.4	8	45	2.8	2.1	1.6	TM28170200
M 3	X	0.5	6	56	3.5	2.7	2.5	TM28170300
M 4	X	0.7	7	63	4.5	3.4	3.3	TM28170400
M 5	X	0.8	8	70	6	4.9	4.2	TM28170500
M 6	X	1.0	10	80	6	4.9	5	TM28170600
M 8	X	1.25	13	90	8	6.2	6.8	TM28170800
M 10	X	1.5	15	100	10	8	8.5	TM28171000
M 12	X	1.75	18	110	9	7	10.2	TM28171200
M 14	X	2.0	20	110	11	9	12	TM28171400
M 16	X	2.0	20	110	12	9	14	TM28171600
M 20	X	2.5	25	140	16	12	17.5	TM28172000

► DIN 371(M2-M10) DIN 376(M12-M20)

●: Excellent ○: Good

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
		●						○							
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
	○		○					○							

METRIC COARSE THREADS



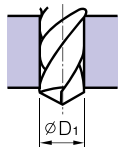
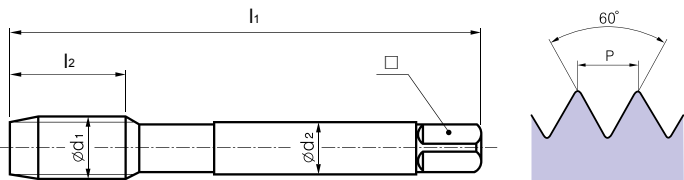
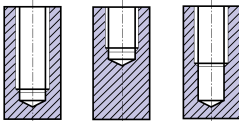
Series No. TM2130, TM2230

▶ cutting conditions : p.87

Spiral flute
Recessed threads for tapping deep holes.
High tensile steels <1200N/mm² and
hardened materials



Hole type



Ød ₁ mm	X	P mm	l ₂	l ₁	d ₂	sq	Tapping drill diameter	EUROPA CODE
M 3	X	0.5	6	56	3.5	2.7	2.5	TM21300300
M 4	X	0.7	7	63	4.5	3.4	3.3	TM21300400
M 5	X	0.8	8	70	6	4.9	4.2	TM21300500
M 6	X	1.0	10	80	6	4.9	5	TM21300600
M 8	X	1.25	13	90	8	6.2	6.8	TM21300800
M 10	X	1.5	15	100	10	8	8.5	TM21301000
M 12	X	1.75	18	110	9	7	10.2	TM22301200
M 14	X	2.0	20	110	11	9	12	TM22301400
M 16	X	2.0	20	110	12	9	14	TM22301600
M 18	X	2.5	25	125	14	11	15.5	TM22301800
M 20	X	2.5	25	140	16	12	17.5	TM22302000

▶ DIN 371(M3-M10) DIN 376(M12-M20)

●: Excellent ○: Good

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
		●						○							
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
	○		○					○							

METRIC COARSE THREADS



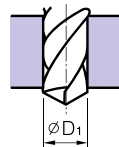
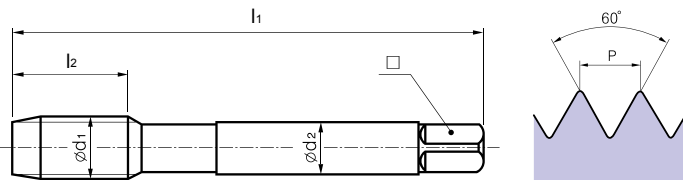
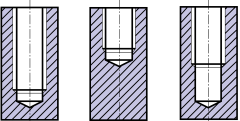
Series No. TM1530, TM1630

▶ cutting conditions : p.87

Spiral flute.
High tensile steels <1200N/mm²
and hardened materials.



Hole type



Ød ₁ mm	X	P mm	l ₂	l ₁	d ₂	sq	Tapping drill diameter	EUROPA CODE
M 2	X	0.4	8	45	2.8	2.1	1.6	TM15300200
M 2.5	X	0.45	9	50	2.8	2.1	2.05	TM15300250
M 3	X	0.5	6	56	3.5	2.7	2.5	TM15300300
M 4	X	0.7	7	63	4.5	3.4	3.3	TM15300400
M 5	X	0.8	8	70	6	4.9	4.2	TM15300500
M 6	X	1.0	10	80	6	4.9	5	TM15300600
M 8	X	1.25	13	90	8	6.2	6.8	TM15300800
M 10	X	1.5	15	100	10	8	8.5	TM15301000
M 12	X	1.75	18	110	9	7	10.2	TM16301200
M 14	X	2.0	20	110	11	9	12	TM16301400
M 16	X	2.0	20	110	12	9	14	TM16301600
M 18	X	2.5	25	125	14	11	15.5	TM16301800
M 20	X	2.5	25	140	16	12	17.5	TM16302000
M 24	X	3.0	30	160	18	14.5	21	TM16302400
M 27	X	3.0	30	160	20	16	24	TM16302700
M 30	X	3.5	35	180	22	18	26.5	TM16303000

▶ DIN 371(M2-M10) DIN 376(M12-M30)

●: Excellent ○: Good

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
		●						○							
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
	○		○					○							

M METRIC COARSE THREADS



HSS-E

DIN 352

6H

Bright



DIN 352

Series No. TM0116

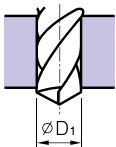
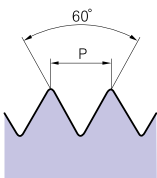
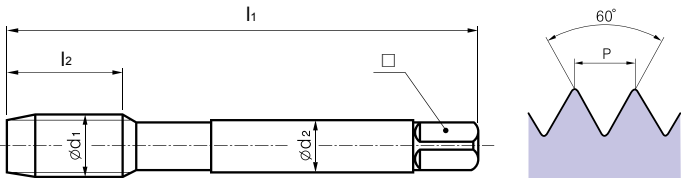
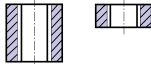
► cutting conditions : p.86

Spiral point.
Thick web for higher cutting speed.
Short machine taps for automatic lathes.
General steels <750N/mm².

Material groups

GS

Hole type



Ød ₁ mm	X	P mm	l ₂	l ₁	d ₂	sq	Tapping drill diameter	EUROPA CODE
M 2	X	0.4	8	36	2.8	2.1	1.6	TM01160200
M 2.5	X	0.45	9	40	2.8	2.1	2.05	TM01160250
M 3	X	0.5	11	40	3.5	2.7	2.5	TM01160300
M 4	X	0.7	13	45	4.5	3.4	3.3	TM01160400
M 5	X	0.8	16	52	6	4.9	4.2	TM01160500
M 6	X	1.0	18	56	6	4.9	5	TM01160600
M 8	X	1.25	20	63	6	4.9	6.8	TM01160800
M 10	X	1.5	22	70	7	5.5	8.5	TM01161000
M 12	X	1.75	24	80	9	7	10.2	TM01161200
M 14	X	2.0	26	80	11	9	12	TM01161400
M 16	X	2.0	27	80	12	9	14	TM01161600

► DIN 352 (M2-M16)

●: Excellent ○: Good

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
	●						○			○		●		○	
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
●	●				●	●	○			○	○	○	●		

M METRIC COARSE THREADS



HSS-E

DIN 352

6H

Bright



DIN 352

Series No. TM0216

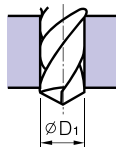
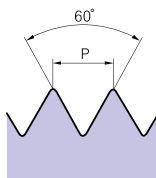
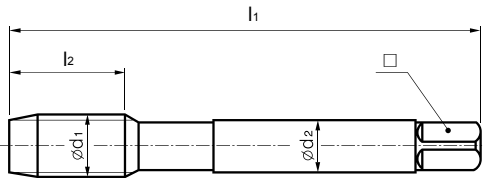
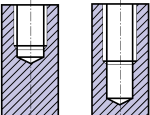
► cutting conditions : p.87

Spiral flute.
Short machine taps for automatic lathes.
General steels <750N/mm².

Material groups

GS

Hole type



Ød ₁ mm	X	P mm	l ₂	l ₁	d ₂	sq	Tapping drill diameter	EUROPA CODE
M 3	X	0.5	11	40	3.5	2.7	2.5	TM02160300
M 4	X	0.7	13	45	4.5	3.4	3.3	TM02160400
M 5	X	0.8	16	52	6	4.9	4.2	TM02160500
M 6	X	1.0	18	56	6	4.9	5	TM02160600
M 8	X	1.25	20	63	6	4.9	6.8	TM02160800
M 10	X	1.5	22	70	7	5.5	8.5	TM02161000
M 12	X	1.75	24	80	9	7	10.2	TM02161200
M 14	X	2.0	26	80	11	9	12	TM02161400
M 16	X	2.0	27	80	12	9	14	TM02161600
M 18	X	2.5	30	95	14	11	15.5	TM02161800
M 20	X	2.5	32	95	16	12	17.5	TM02162000

► DIN 352 (M3-M20)

●: Excellent ○: Good

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
	●						○			○		●		○	
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
●	●				●	●	○			○	○	○	●		

M METRIC COARSE THREADS



HSS-E

DIN 371

6H

Bright



DIN 371

Series No. TM0316

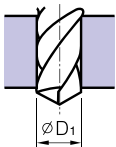
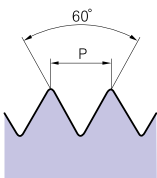
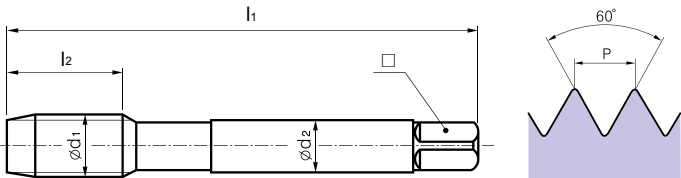
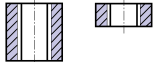
► cutting conditions : p.86

Spiral point.
Thick web for higher cutting speed.
General steels <750N/mm².

Material groups

GS

Hole type



Ød ₁ mm	X	P mm	l ₂	l ₁	d ₂	sq	Tapping drill diameter	EUROPA CODE
M 2	X	0.4	8	45	2.8	2.1	1.6	TM03160200
M 2.5	X	0.45	9	50	2.8	2.1	2.05	TM03160250
M 3	X	0.5	11	56	3.5	2.7	2.5	TM03160300
M 3.5	X	0.6	12	56	4	3	2.9	TM03160350
M 4	X	0.7	13	63	4.5	3.4	3.3	TM03160400
M 4.5	X	0.75	14	70	6	4.9	3.7	TM03160450
M 5	X	0.8	15	70	6	4.9	4.2	TM03160500
M 6	X	1.0	17	80	6	4.9	5	TM03160600
M 7	X	1.0	17	80	7	5.5	6	TM03160700
M 8	X	1.25	20	90	8	6.2	6.8	TM03160800
M 10	X	1.5	22	100	10	8	8.5	TM03161000
M 12	X	1.75	24	110	12	9	10.2	TM03161200

► DIN 371 (M2-M12)

●: Excellent ○: Good

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
	●						○			○		●		○	
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
●	●				●	●	○			○	○	○	●		

M METRIC COARSE THREADS



HSS-E

DIN 371/376

6H

Bright



DIN 371



DIN 376

Series No. TM1316, TM1416

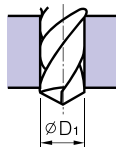
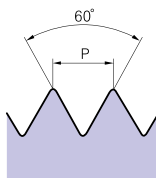
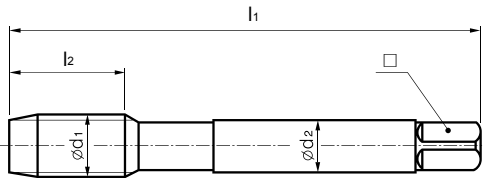
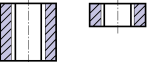
► cutting conditions : p.87

Spiral flute.
20° spiral for good chip evacuation.
General steels <750N/mm².

Material groups

GS

Hole type



Ød ₁ mm	X	P mm	l ₂	l ₁	d ₂	sq	Tapping drill diameter	EUROPA CODE
M 2	X	0.4	8	45	2.8	2.1	1.6	TM13160200
M 2.5	X	0.45	9	50	2.8	2.1	2.05	TM13160250
M 3	X	0.5	6	56	3.5	2.7	2.5	TM13160300
M 4	X	0.7	7	63	4.5	3.4	3.3	TM13160400
M 5	X	0.8	8	70	6	4.9	4.2	TM13160500
M 6	X	1.0	10	80	6	4.9	5	TM13160600
M 8	X	1.25	13	90	8	6.2	6.8	TM13160800
M 10	X	1.5	15	100	10	8	8.5	TM13161000
M 12	X	1.75	18	110	9	7	10.2	TM14161200
M 14	X	2.0	20	110	11	9	12	TM14161400
M 16	X	2.0	20	110	12	9	14	TM14161600
M 20	X	2.5	25	140	16	12	17.5	TM14162000

► DIN 371(M2-M10) DIN 376(M12-M20)

●: Excellent ○: Good

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
	●						O			O		●		O	
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
●	●				●	●	O			O	O	O	●		

M METRIC COARSE THREADS



HSS-E

DIN 376

6H

Bright

Series No. TM0416

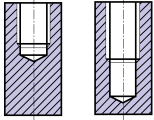
► cutting conditions : p.87

Spiral point.
Thick web for higher cutting speed.
General steels <750N/mm².

Material groups

GS

Hole type



DIN 376

Ød ₁ mm	X	P mm	l ₂	l ₁	d ₂	sq	Tapping drill diameter	EUROPA CODE	
M 3	X	0.5	11	56	2.2	1.8	2.5	TM04160300	
M 4	X	0.7	13	63	2.8	2.1	3.3	TM04160400	
M 5	X	0.8	15	70	3.5	2.7	4.2	TM04160500	
M 6	X	1.0	17	80	4.5	3.4	5	TM04160600	
M 8	X	1.25	20	90	6	4.9	6.8	TM04160800	
M 10	X	1.5	22	100	7	5.5	8.5	TM04161000	
M 12	X	1.75	24	110	9	7	10.2	TM04161200	
M 14	X	2.0	26	110	11	9	12	TM04161400	
M 16	X	2.0	27	110	12	9	14	TM04161600	
M 18	X	2.5	30	125	14	11	15.5	TM04161800	
M 20	X	2.5	32	140	16	12	17.5	TM04162000	
M 22	X	2.5	32	140	18	14.5	19.5	TM04162200	
M 24	X	3.0	34	160	18	14.5	21	TM04162400	
M 27	X	3.0	36	160	20	16	24	TM04162700	

► DIN 376 (M3-M27)

●: Excellent ○: Good															
P	H	M	K	S	N				O						
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
	●						○			○		●		○	
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
●	●				●	●	○			○	○	○	●		

M METRIC COARSE THREADS



HSS-E

DIN 371/376

6H

Bright

Series No. TM1716

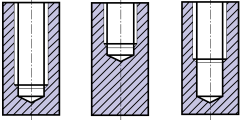
► cutting conditions : p.86

Spiral flute.
General steels <750N/mm².

Material groups

GS

Hole type



DIN 371



DIN 376

Ød ₁ mm	X	P mm	l ₂	l ₁	d ₂	sq	Tapping drill diameter	EUROPA CODE	
M 2	X	0.4	5	45	2.8	2.1	1.6	TM17160200	
M 3	X	0.5	6	56	3.5	2.7	2.5	TM17160300	
M 4	X	0.7	7	63	4.5	3.4	3.3	TM17160400	
M 5	X	0.8	8	70	6	4.9	4.2	TM17160500	
M 6	X	1.0	10	80	6	4.9	5	TM17160600	
M 8	X	1.25	13	90	8	6.2	6.8	TM17160800	
M 10	X	1.5	15	100	10	8	8.5	TM17161000	
M 12	X	1.75	18	110	9	7	10.2	TM17161200	
M 14	X	2.0	20	110	11	9	12	TM17161400	
M 16	X	2.0	20	110	12	9	14	TM17161600	
M 18	X	2.5	25	125	14	11	15.5	TM17161800	
M 20	X	2.5	25	140	16	12	17.5	TM17162000	

► DIN 371(M2-M10) DIN 376(M12-M20)

●: Excellent ○: Good															
P	H	M	K	S	N				O						
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
	●						○			○		●		○	
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
●	●				●	●	○			○	○	○	●		

M METRIC COARSE THREADS



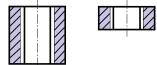
Series No. TM1817

► cutting conditions : p.87

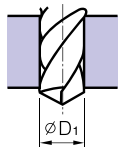
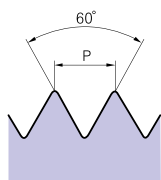
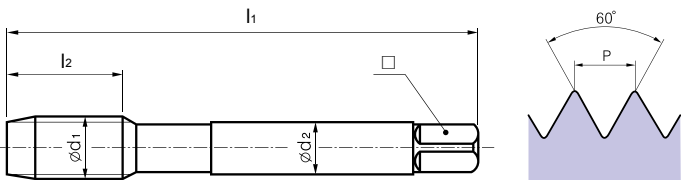
Spiral point.
Thick web for higher cutting speed.
General steels 900-1000N/mm².
TiN coated for increased tool life.



Hole type



DIN 371



Ød ₁ mm	X	P mm	l ₂	l ₁	d ₂	sq	Tapping drill diameter	EUROPA CODE
M 2	X	0.4	8	45	2.8	2.1	1.6	TM18170200
M 3	X	0.5	11	56	3.5	2.7	2.5	TM18170300
M 4	X	0.7	13	63	4.5	3.4	3.3	TM18170400
M 5	X	0.8	15	70	6	4.9	4.2	TM18170500
M 6	X	1.0	17	80	6	4.9	5	TM18170600
M 8	X	1.25	20	90	8	6.2	6.8	TM18170800
M 10	X	1.5	22	100	10	8	8.5	TM18171000
M 12	X	1.75	24	110	12	9	10.2	TM18171200

► DIN 371(M2-M12)

●: Excellent ○: Good

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
	●						○			○		●		○	
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
●	●				●	●	○			○	○	○	●		

M METRIC COARSE THREADS



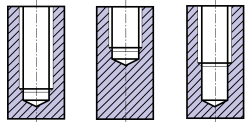
Series No. TM1917, TM2017

► cutting conditions : p.87

Spiral flute.
General steels 900-1000N/mm².
TiN coated for increased tool life.



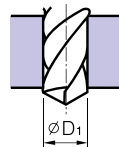
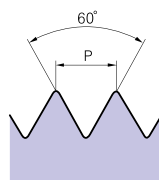
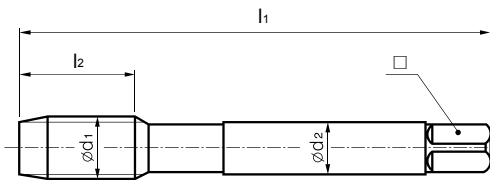
Hole type



DIN 371



DIN 376



Ød ₁ mm	X	P mm	l ₂	l ₁	d ₂	sq	Tapping drill diameter	EUROPA CODE
M 2	X	0.4	8	45	2.8	2.1	1.6	TM19170200
M 2.5	X	0.45	9	50	2.8	2.1	2.05	TM19170250
M 3	X	0.5	6	56	3.5	2.7	2.5	TM19170300
M 4	X	0.7	7	63	4.5	3.4	3.3	TM19170400
M 5	X	0.8	8	70	6	4.9	4.2	TM19170500
M 6	X	1.0	10	80	6	4.9	5	TM19170600
M 8	X	1.25	13	90	8	6.2	6.8	TM19170800
M 10	X	1.5	15	100	10	8	8.5	TM19171000
M 12	X	1.75	18	110	9	7	10.2	TM20171200
M 14	X	2.0	20	110	11	9	12	TM20171400
M 16	X	2.0	20	110	12	9	14	TM20171600
M 18	X	2.5	25	125	14	11	15.5	TM20171800
M 20	X	2.5	25	140	16	12	17.5	TM20172000
M 22	X	2.5	25	140	18	14.5	19.5	TM20172200
M 24	X	3.0	30	160	18	14.5	21	TM20172400
M 27	X	3.0	30	160	20	16	24	TM20172700
M 30	X	3.5	35	180	22	18	26.5	TM20173000

► DIN 371(M2-M10) DIN 376(M12-M30)

●: Excellent ○: Good

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
	●						O			O		●		O	
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
●	●				●	●	O			O	O	O	●		

MF METRIC FINE THREADS



HSS-E

DIN 374

6H

Bright



DIN 374

Series No. TM3316

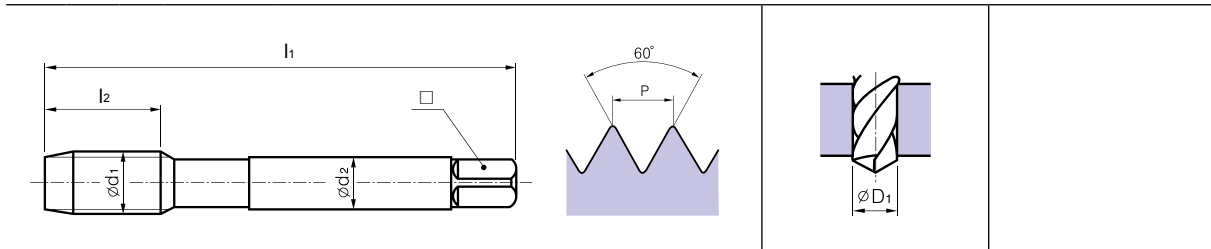
▶ cutting conditions : p.86

Spiral point.
Thick web for higher cutting speed.
General steels <750N/mm².

Material groups

GS

Hole type



Ød ₁ mm	X	P mm	l ₂	l ₁	d ₂	sq	Tapping drill diameter	EUROPA CODE
M 4	X	0.5	10	63	2.8	2.1	3.5	TM33160400
M 5	X	0.5	11	70	3.5	2.7	4.5	TM33160500
M 6	X	0.5	13	80	4.5	3.4	5.5	TM33160600
M 6	X	0.75	13	80	4.5	3.4	5.2	TM33160601
M 8	X	0.5	14	80	6	4.9	7.5	TM33160800
M 8	X	0.75	14	80	6	4.9	7.2	TM33160801
M 8	X	1.0	17	90	6	4.9	7	TM33160802
M 10	X	1.75	18	90	7	5.5	9.2	TM33161000
M 10	X	1.0	18	90	7	5.5	9	TM33161001
M 10	X	1.25	22	100	7	5.5	8.8	TM33161002
M 12	X	1.0	18	100	9	7	11	TM33161200
M 12	X	1.25	22	100	9	7	10.8	TM33161201
M 12	X	1.5	22	100	9	7	10.5	TM33161202
M 14	X	1.0	18	100	11	9	13	TM33161400
M 14	X	1.25	22	100	11	9	12.8	TM33161401
M 14	X	1.5	22	100	11	9	12.5	TM33161402
M 16	X	1.0	18	100	12	9	15	TM33161600
M 16	X	1.5	22	100	12	9	14.5	TM33161601
M 18	X	1.0	20	110	14	11	17	TM33161800
M 18	X	1.5	25	110	14	11	16.5	TM33161801

▶ DIN 374(M4-M30)

●: Excellent ○: Good

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
	●						○			○		●		○	
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
●	●				●	●	○			○	○	○	●		

MF METRIC FINE THREADS



HSS-E

DIN 374

6H

Bright



DIN 374

Series No. TM3316

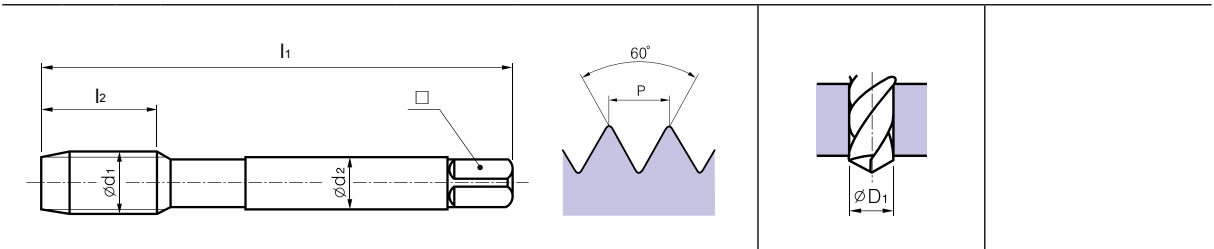
▶ cutting conditions : p.86

Spiral point.
Thick web for higher cutting speed.
General steels <750N/mm².

Material groups

GS

Hole type



Ød ₁ mm	X	P mm	l ₂	l ₁	d ₂	sq	Tapping drill diameter	EUROPA CODE
M 20	X	1.0	20	125	16	12	19	TM33162000
M 20	X	1.5	25	125	16	12	18.5	TM33162001
M 22	X	1.0	20	125	18	14.5	21	TM33162200
M 22	X	1.5	25	125	18	14.5	20.5	TM33162201
M 24	X	1.5	27	140	18	14.5	22.5	TM33162400
M 24	X	2.0	27	140	18	14.5	22	TM33162401
M 26	X	1.5	28	140	18	14.5	24.5	TM33162600
M 27	X	1.5	28	140	20	16	25.5	TM33162700
M 27	X	2.0	28	140	20	16	25	TM33162701
M 28	X	1.5	28	140	20	16	26.5	TM33162800
M 30	X	1.5	30	150	22	18	28.5	TM33163000
M 30	X	2.0	30	150	22	18	28	TM33163001

▶ DIN 374(M4-M30)

●: Excellent ○: Good

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
	●						○			○		●		○	
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
●	●				●	●	○			○	○	○	●		

MF METRIC FINE THREADS



Series No. TM3416

▶ cutting conditions : p.86

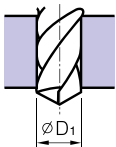
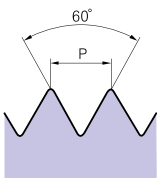
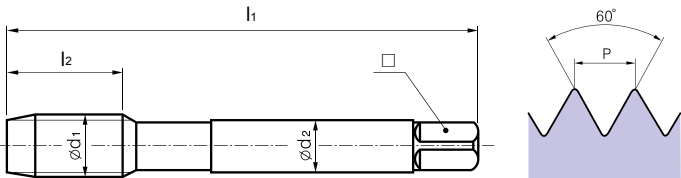
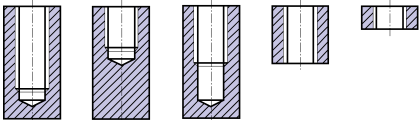
Spiral flute.
General steels <750N/mm².



DIN 374



Hole type



Ød ₁ mm	X	P mm	l ₂	l ₁	d ₂	sq	Tapping drill diameter	EUROPA CODE
M 4	X	0.5	10	63	2.8	2.1	3.5	TM34160400
M 5	X	0.5	11	70	3.5	2.7	4.5	TM34160500
M 6	X	0.5	13	80	4.5	3.4	5.5	TM34160600
M 6	X	0.75	13	80	4.5	3.4	5.2	TM34160601
M 8	X	0.5	14	80	6	4.9	7.5	TM34160800
M 8	X	0.75	14	80	6	4.9	7.2	TM34160801
M 8	X	1.0	17	90	6	4.9	7	TM34160802
M 10	X	1.75	18	90	7	5.5	9.2	TM34161000
M 10	X	1.0	18	90	7	5.5	9	TM34161001
M 10	X	1.25	22	100	7	5.5	8.8	TM34161002
M 12	X	1.0	18	100	9	7	11	TM34161200
M 12	X	1.25	22	100	9	7	10.8	TM34161201
M 12	X	1.5	22	100	9	7	10.5	TM34161202
M 14	X	1.0	18	100	11	9	13	TM34161400
M 14	X	1.25	22	100	11	9	12.8	TM34161401
M 14	X	1.5	22	100	11	9	12.5	TM34161402
M 16	X	1.0	18	100	12	9	15	TM34161600
M 16	X	1.5	22	100	12	9	14.5	TM34161601
M 18	X	1.0	20	110	14	11	17	TM34161800
M 18	X	1.5	25	110	14	11	16.5	TM34161801

▶ DIN 374(M4-M30)

●: Excellent ○: Good

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
	●						○			○		●		○	
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
●	●				●	●	○			○	○	○	●		

MF METRIC FINE THREADS



Series No. TM3416

▶ cutting conditions : p.86

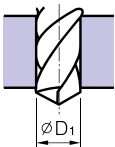
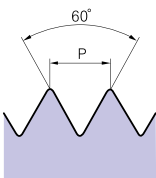
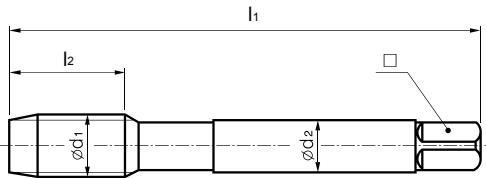
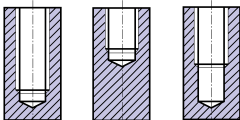
Spiral flute.
General steels <750N/mm².



DIN 374



Hole type



Ød ₁ mm	X	P mm	l ₂	l ₁	d ₂	sq	Tapping drill diameter	EUROPA CODE
M 20	X	1.0	14	125	16	12	19	TM34162000
M 20	X	1.5	17	125	16	12	18.5	TM34162001
M 22	X	1.0	14	125	18	14.5	21	TM34162200
M 22	X	1.5	17	125	18	14.5	20.5	TM34162201
M 24	X	1.5	20	140	18	14.5	22.5	TM34162400
M 24	X	2.0	20	140	18	14.5	22	TM34162401
M 26	X	1.5	20	140	18	14.5	24.5	TM34162600
M 27	X	1.5	20	140	20	16	25.5	TM34162700
M 27	X	2.0	20	140	20	16	25	TM34162701
M 28	X	1.5	20	140	20	16	26.5	TM34162800
M 30	X	1.5	22	150	22	18	28.5	TM34163000
M 30	X	2.0	22	150	22	18	28	TM34163001

▶ DIN 374(M4-M30)

●: Excellent ○: Good

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
	●						O			O		●		O	
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
●	●				●	●	O			O	O	O	●		

UNC UNIFIED COARSE THREADS



HSS-E

DIN 371/376

2B

Bright

Series No. TM6516

▶ cutting conditions : p.86

Spiral flute.
General steels <750N/mm².



DIN 371

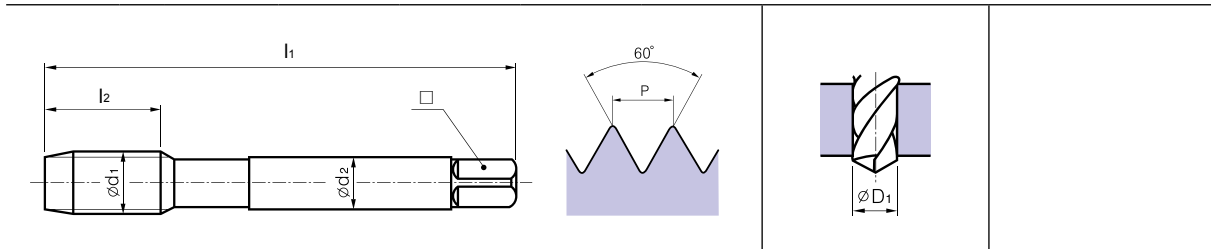
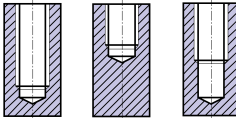


DIN 376

Material groups

GS

Hole type



Ød ₁ inch	X	P inch	l ₂	l ₁	d ₂	sq	Tapping drill diameter	EUROPA CODE
No.4	X	40	6	56	3.5	2.7	2.3	TM65160400
No.5	X	40	7	56	3.5	2.7	2.6	TM65160500
No.6	X	32	7	56	4	3	2.85	TM65160600
No.8	X	32	8	63	4.5	3.4	3.5	TM65160800
No.10	X	24	10	70	6	4.9	3.9	TM65161000
No.12	X	24	10	80	6	4.9	4.5	TM65161200
1/4	X	20	13	80	7	5.5	5.2	TM65169160
5/16	X	18	14	90	8	6.2	6.6	TM65169200
3/8	X	16	16	100	9	7	8	TM65169240
7/16	X	14	17	100	8	6.2	9.4	TM65169280
1/2	X	13	20	110	9	7	10.75	TM65169320
9/16	X	12	20	110	11	9	12.25	TM65169360
5/8	X	11	22	110	12	9	13.5	TM65169400
3/4	X	10	25	125	14	11	16.5	TM65169480
7/8	X	9	27	140	18	14.5	19.5	TM65169560
1"	X	8	30	160	20	16	22.25	TM65169640

▶ DIN 371(No.4-3/8") DIN376(7/16"-1")

●: Excellent ○: Good

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
	●						○			○		●		○	
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
●	●				●	●	○			○	○	○	●		

UNC UNIFIED COARSE THREADS



HSS-E

DIN 371/376

2B

Bright

Series No. TM6416

▶ cutting conditions : p.86

Spiral point.
Thick web for higher cutting speed.
General steels <750N/mm².



DIN 371

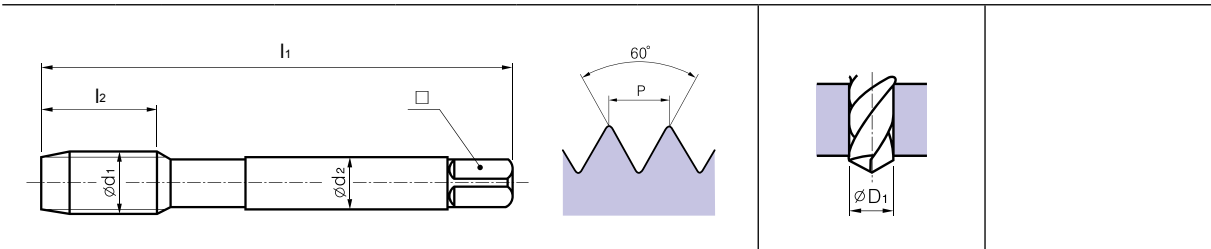
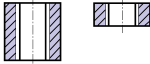


DIN 376

Material groups

GS

Hole type



Ød ₁ inch	X	P inch	l ₂	l ₁	d ₂	sq	Tapping drill diameter	EUROPA CODE
No.4	X	40	11	56	3.5	2.7	2.3	TM64160400
No.5	X	40	11	56	3.5	2.7	2.6	TM64160500
No.6	X	32	12	56	4	3	2.85	TM64160600
No.8	X	32	13	63	4.5	3.4	3.5	TM64160800
No.10	X	24	15	70	6	4.9	3.9	TM64161000
No.12	X	24	16	80	6	4.9	4.5	TM64161200
1/4	X	20	17	80	7	5.5	5.2	TM64169160
5/16	X	18	20	90	8	6.2	6.6	TM64169200
3/8	X	16	22	100	9	7	8	TM64169240
7/16	X	14	22	100	8	6.2	9.4	TM64169280
1/2	X	13	25	110	9	7	10.75	TM64169320
9/16	X	12	26	110	11	9	12.25	TM64169360
5/8	X	11	27	110	12	9	13.5	TM64169400
3/4	X	10	30	125	14	11	16.5	TM64169480
7/8	X	9	32	140	18	14.5	19.5	TM64169560
1"	X	8	36	160	20	16	22.25	TM64169640

▶ DIN 371(No.4-3/8") DIN376(7/16"-1")

●: Excellent ○: Good

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
	●						○			○		●		○	
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
●	●				●	●	○			○	○	○	●		

UNF UNIFIED FINE THREADS



Series No. TM6816

▶ cutting conditions : p.86

Spiral flute.
General steels <750N/mm².



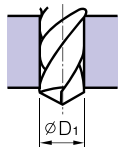
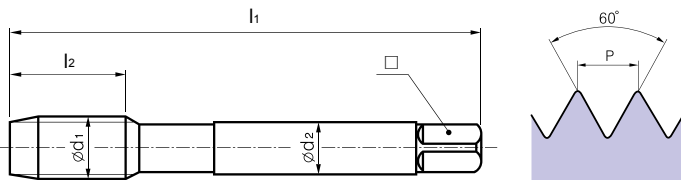
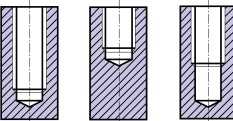
DIN 371



DIN 374



Hole type



Ød ₁ inch	X	P inch	l ₂	l ₁	d ₂	sq	Tapping drill diameter	EUROPA CODE
No.4	X	48	6	56	3.5	2.7	2.4	TM68160400
No.5	X	44	7	56	3.5	2.7	2.7	TM68160500
No.6	X	40	7	56	4	3	3	TM68160600
No.8	X	36	8	63	4.5	3.4	3.5	TM68160800
No.10	X	32	10	70	6	4.9	4.1	TM68161000
No.12	X	28	10	80	6	4.9	4.7	TM68161200
1/4	X	28	10	80	7	5.5	5.5	TM68169160
5/16	X	24	10	90	8	6.2	6.9	TM68169200
3/8	X	24	10	100	9	7	8.5	TM68169240
7/16	X	20	13	100	8	6.2	9.9	TM68169280
1/2	X	20	13	100	9	7	11.5	TM68169320
9/16	X	18	15	100	11	9	12.9	TM68169360
5/8	X	18	15	100	12	9	14.5	TM68169400
3/4	X	16	17	110	14	11	17.5	TM68169480
7/8	X	14	17	125	18	14.5	20.5	TM68169560
1"	X	12	20	140	20	16	23.25	TM68169640

▶ DIN 371(No.4-3/8") DIN374(7/16"-1")

●: Excellent ○: Good

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
	●						○			○		●		○	
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
●	●				●	●	○			○	○	○	●		

UNF UNIFIED FINE THREADS



Series No. TM6716

▶ cutting conditions : p.86

Spiral point.
Thick web for higher cutting speed.
General steels <750N/mm².



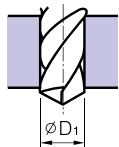
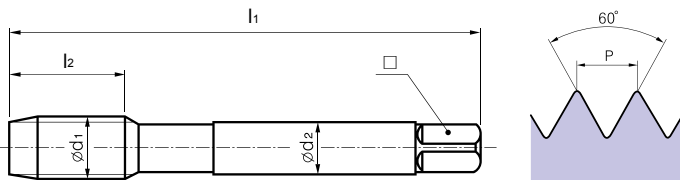
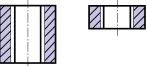
DIN 371



DIN 374



Hole type



Ød ₁ inch	X	P inch	l ₂	l ₁	d ₂	sq	Tapping drill diameter	EUROPA CODE
No.4	X	48	11	56	3.5	2.7	2.4	TM67160400
No.5	X	44	11	56	3.5	2.7	2.7	TM67160500
No.6	X	40	12	56	4	3	3	TM67160600
No.8	X	36	13	63	4.5	3.4	3.5	TM67160800
No.10	X	32	13	70	6	4.9	4.1	TM67161000
No.12	X	28	16	80	6	4.9	4.7	TM67161200
1/4	X	28	17	80	7	5.5	5.5	TM67169160
5/16	X	24	17	90	8	6.2	6.9	TM67169200
3/8	X	24	18	100	9	7	8.5	TM67169240
7/16	X	20	22	100	8	6.2	9.9	TM67169280
1/2	X	20	22	100	9	7	11.5	TM67169320
9/16	X	18	22	100	11	9	12.9	TM67169360
5/8	X	18	22	100	12	9	14.5	TM67169400
3/4	X	16	25	110	14	11	17.5	TM67169480
7/8	X	14	26	125	18	14.5	20.5	TM67169560
1"	X	12	28	140	20	16	23.25	TM67169640

▶ DIN 371(No.4-3/8") DIN374(7/16"-1")

●: Excellent ○: Good

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
	●						○			○		●		○	
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
●	●				●	●	○			○	○	○	●		

BSP WHITWORTH PIPE THREADS



HSS-E

DIN 5156

Bright



DIN 5156

Series No. TB0116

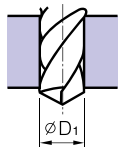
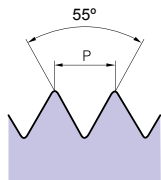
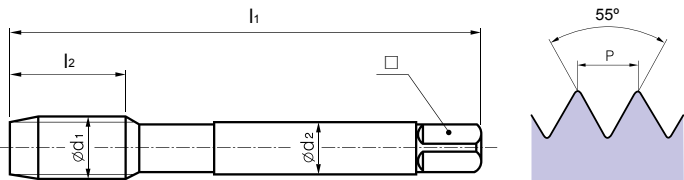
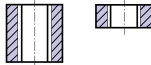
► cutting conditions : p.86

Spiral point.
Thick web for higher cutting speed.
General steels <750N/mm².

Material groups

GS

Hole type



Ød ₁ inch	X	P inch	l ₂	l ₁	d ₂	sq	Tapping drill diameter	EUROPA CODE
1/8	X	28	18	90	7	5.5	8.8	TB01160080
1/4	X	19	22	100	11	9	11.8	TB01160160
3/8	X	19	22	100	12	9	15.25	TB01160240
1/2	X	14	25	125	16	12	19	TB01160320
3/4	X	14	28	140	20	16	24.5	TB01160480
1"	X	11	32	160	25	20	30.75	TB01160640

► DIN 5156

●: Excellent ○: Good

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
	●						○			○		●		○	
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
●	●				●	●	○			○	○	○	●		

BSP WHITWORTH PIPE THREADS



HSS-E

DIN 5156

Bright



DIN 5156

Series No. TB0216

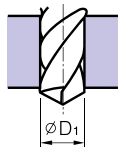
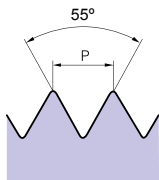
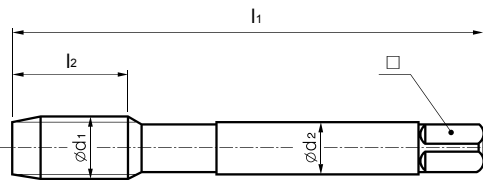
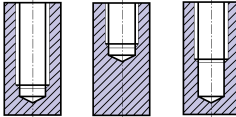
► cutting conditions : p.86

Spiral flute.
General steels <750N/mm².

Material groups

GS

Hole type



Ød ₁ inch	X	P inch	l ₂	l ₁	d ₂	sq	Tapping drill diameter	EUROPA CODE
1/8	X	28	10	90	7	5.5	8.8	TB02160080
1/4	X	19	14	100	11	9	11.8	TB02160160
3/8	X	19	15	100	12	9	15.25	TB02160240
1/2	X	14	17	125	16	12	19	TB02160320
3/4	X	14	20	140	20	16	24.5	TB02160480
1"	X	11	24	160	25	20	30.75	TB02160640

► DIN 5156

●: Excellent ○: Good

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
	●						○			○		●		○	
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
●	●				●	●	○			○	○	○	●		

M METRIC COARSE THREADS



HSS
PM

DIN
371/376

6H

Bright

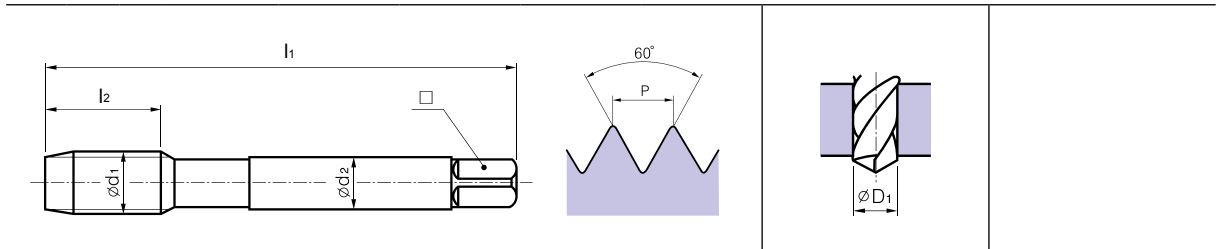
Series No. TM7210

► cutting conditions : p.89

Spiral flute.
Titanium, Nickel alloys and hard materials.

Material groups
Ti
Ni

Hole type



Ød ₁ mm	X	P mm	l ₂	l ₁	d ₂	sq	Tapping drill diameter	EUROPA CODE
M 2	X	0.4	8	45	2.8	2.1	1.6	TM72100200
M 2.2	X	0.45	8	45	2.8	2.1	1.75	TM72100220
M 2.5	X	0.45	9	50	2.8	2.1	2.05	TM72100250
M 3	X	0.5	6	56	3.5	2.7	2.5	TM72100300
M 3.5	X	0.6	7	56	4	3	2.9	TM72100350
M 4	X	0.7	7	63	4.5	3.4	3.3	TM72100400
M 4.5	X	0.75	8	70	6	4.9	3.7	TM72100450
M 5	X	0.8	8	70	6	4.9	4.2	TM72100500
M 6	X	1.0	10	80	6	4.9	5	TM72100600
M 7	X	1.0	10	80	7	5.5	6	TM72100700
M 8	X	1.25	13	90	8	6.2	6.8	TM72100800
M 10	X	1.5	15	100	10	8	8.5	TM72101000
M 12	X	1.75	18	110	9	7	10.2	TM72101200

► DIN 371(M2-M10) DIN 376(M12)

●: Excellent ○: Good

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
		●					○	●	●				○		
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
		●						●	●						

M METRIC COARSE THREADS



HSS
PM

DIN
371/376

6H

Bright

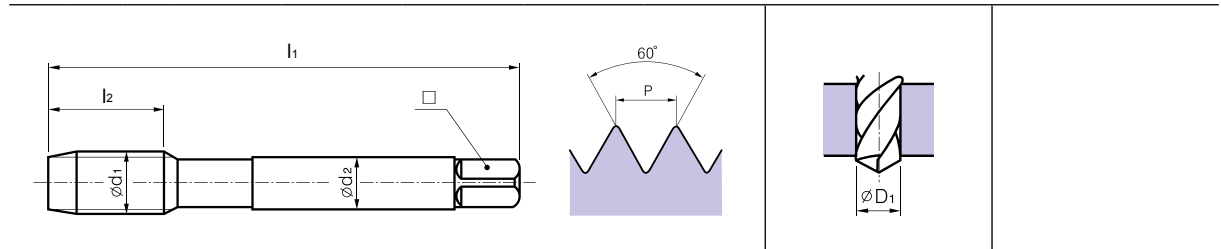
Series No. TM7110

► cutting conditions : p.89

Spiral point.
Thick web for higher cutting speed.
Titanium, Nickel alloys and hard materials.

Material groups
Ti
Ni

Hole type



Ød ₁ mm	X	P mm	l ₂	l ₁	d ₂	sq	Tapping drill diameter	EUROPA CODE
M 2	X	0.4	8	45	2.8	2.1	1.6	TM71100200
M 2.2	X	0.45	8	45	2.8	2.1	1.75	TM71100220
M 2.5	X	0.45	9	50	2.8	2.1	2.05	TM71100250
M 3	X	0.5	11	56	3.5	2.7	2.5	TM71100300
M 3.5	X	0.6	12	56	4	3	2.9	TM71100350
M 4	X	0.7	13	63	4.5	3.4	3.3	TM71100400
M 4.5	X	0.75	14	70	6	4.9	3.7	TM71100450
M 5	X	0.8	15	70	6	4.9	4.2	TM71100500
M 6	X	1.0	17	80	6	4.9	5	TM71100600
M 7	X	1.0	17	80	7	5.5	6	TM71100700
M 8	X	1.25	20	90	8	6.2	6.8	TM71100800
M 10	X	1.5	22	100	10	8	8.5	TM71101000
M 12	X	1.75	24	110	9	7	10.2	TM71101200

► DIN 371(M2-M10) DIN 376(M12)

●: Excellent ○: Good

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
		●					○	●	●				○		
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
		●						●	●						

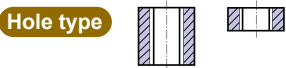
M METRIC COARSE THREADS



Series No. TM7328

▶ cutting conditions : p.89

Spiral point.
Thick web for higher cutting speed.
Nickel alloys and hard materials.
TiAlN coated for increased tool life.



DIN 371

DIN 376

Ød ₁ mm	X	P mm	l ₂	l ₁	d ₂	sq	Tapping drill diameter	EUROPA CODE	
M 2	X	0.4	8	45	2.8	2.1	1.6	TM73280200	
M 2.2	X	0.45	8	45	2.8	2.1	1.75	TM73280220	
M 2.3	X	0.4	8	45	2.8	2.1	1.9	TM73280230	
M 2.5	X	0.45	9	50	2.8	2.1	2.05	TM73280250	
M 2.6	X	0.45	9	50	2.8	2.1	2.1	TM73280260	
M 3	X	0.5	11	56	3.5	2.7	2.5	TM73280300	
M 3.5	X	0.6	12	56	4	3	2.9	TM73280350	
M 4	X	0.7	13	63	4.5	3.4	3.3	TM73280400	
M 4.5	X	0.75	14	70	6	4.9	3.7	TM73280450	
M 5	X	0.8	15	70	6	4.9	4.2	TM73280500	
M 6	X	1.0	17	80	6	4.9	5	TM73280600	
M 7	X	1.0	17	80	7	5.5	6	TM73280700	
M 8	X	1.25	20	90	8	6.2	6.8	TM73280800	
M 9	X	1.25	20	90	9	7	7.8	TM73280900	
M 10	X	1.5	22	100	10	8	8.5	TM73281000	

▶ DIN 371(M2-M10) DIN 376(M11-M30)

●: Excellent ○: Good															
P		H		M		K		S		N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
		●							○				○		
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
		●						●	●						

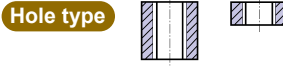
M METRIC COARSE THREADS



Series No. TM7328

▶ cutting conditions : p.89

Spiral point.
Thick web for higher cutting speed.
Nickel alloys and hard materials.
TiAlN coated for increased tool life.



DIN 371

DIN 376

Ød ₁ mm	X	P mm	l ₂	l ₁	d ₂	sq	Tapping drill diameter	EUROPA CODE	
M 11	X	1.5	22	100	8	6.2	9.5	TM73281100	
M 12	X	1.75	24	110	9	7	10.2	TM73281200	
M 14	X	2.0	26	110	11	9	12	TM73281400	
M 16	X	2.0	27	110	12	9	14	TM73281600	
M 18	X	2.5	30	125	14	11	15.5	TM73281800	
M 20	X	2.5	32	140	16	12	17.5	TM73282000	
M 22	X	2.5	32	140	18	14.5	19.5	TM73282200	
M 24	X	3.0	34	160	18	14.5	21	TM73282400	
M 27	X	3.0	36	160	20	16	24	TM73282700	
M 30	X	3.5	40	180	22	18	26.5	TM73283000	

▶ DIN 371(M2-M10) DIN 376(M11-M30)

●: Excellent ○: Good															
P		H		M		K		S		N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
		●							○				○		
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
		●						●	●						

M METRIC COARSE THREADS



HSS PM

DIN 371/376

6H

60°

C

TiAlN

R40

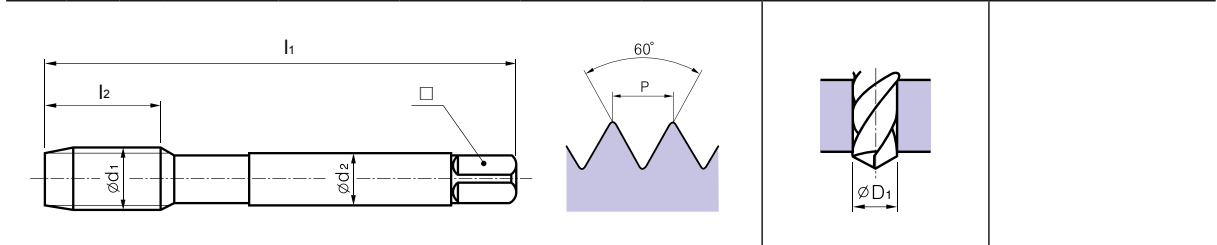
Series No. TM7428

▶ cutting conditions : p.89

Spiral flute.
Nickel alloys and hard materials.
TiAlN coated for increased tool life.

Material groups
Ni

Hole type



Ød ₁ mm	X	P mm	l ₂	l ₁	d ₂	sq	Tapping drill diameter	EUROPA CODE
M 2	X	0.4	8	45	2.8	2.1	1.6	TM74280200
M 2.2	X	0.45	8	45	2.8	2.1	1.75	TM74280220
M 2.3	X	0.4	8	45	2.8	2.1	1.9	TM74280230
M 2.5	X	0.45	9	50	2.8	2.1	2.05	TM74280250
M 2.6	X	0.45	9	50	2.8	2.1	2.1	TM74280260
M 3	X	0.5	6	56	3.5	2.7	2.5	TM74280300
M 3.5	X	0.6	7	56	4	3	2.9	TM74280350
M 4	X	0.7	7	63	4.5	3.4	3.3	TM74280400
M 4.5	X	0.75	8	70	6	4.9	3.7	TM74280450
M 5	X	0.8	8	70	6	4.9	4.2	TM74280500
M 6	X	1.0	10	80	6	4.9	5	TM74280600
M 7	X	1.0	10	80	7	5.5	6	TM74280700
M 8	X	1.25	13	90	8	6.2	6.8	TM74280800
M 9	X	1.25	13	90	9	7	7.8	TM74280900
M 10	X	1.5	15	100	10	8	8.5	TM74281000

▶ DIN 371(M2-M10) DIN 376(M11-M30)

●: Excellent ○: Good

P	H	M	K	S	N	O
11 12	15	21 22	31 32	41 42 43	61 62 63 64	81 82
	●			○	○	
13 14	16	23	33 34	51 52 53	71 72 73 74	83
	●			● ●		

M METRIC COARSE THREADS



HSS PM

DIN 371/376

6H

60°

C

TiAlN

R40

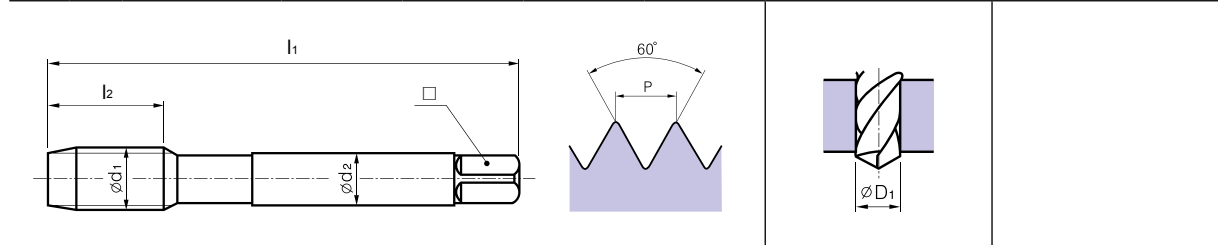
Series No. TM7428

▶ cutting conditions : p.89

Spiral flute.
Nickel alloys and hard materials.
TiAlN coated for increased tool life.

Material groups
Ni

Hole type



Ød ₁ mm	X	P mm	l ₂	l ₁	d ₂	sq	Tapping drill diameter	EUROPA CODE
M 11	X	1.5	17	100	8	6.2	9.5	TM74281100
M 12	X	1.75	18	110	9	7	10.2	TM74281200
M 14	X	2.0	20	110	11	9	12	TM74281400
M 16	X	2.0	20	110	12	9	14	TM74281600
M 18	X	2.5	25	125	14	11	15.5	TM74281800
M 20	X	2.5	25	140	16	12	17.5	TM74282000
M 22	X	2.5	25	140	18	14.5	19.5	TM74282200
M 24	X	3.0	30	160	18	14.5	21	TM74282400
M 27	X	3.0	30	160	20	16	24	TM74282700
M 30	X	3.5	35	180	22	18	26.5	TM74283000

▶ DIN 371(M2-M10) DIN 376(M11-M30)

●: Excellent ○: Good

P	H	M	K	S	N	O
11 12	15	21 22	31 32	41 42 43	61 62 63 64	81 82
	●			○	○	
13 14	16	23	33 34	51 52 53	71 72 73 74	83
	●			● ●		

M METRIC COARSE THREADS



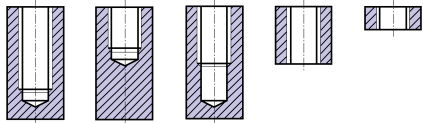
Series No. TM3827

▶ cutting conditions : p.87

Cold forming tap with oil grooves.
For materials with at least 10% elongation.
TiAlN coated for increased tool life.



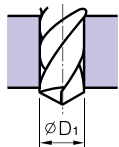
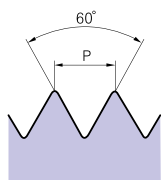
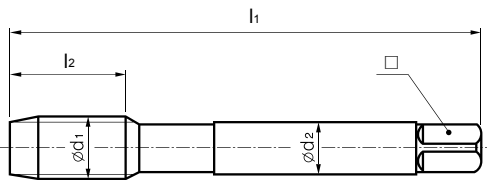
Hole type



DIN 371



DIN 376



Ød ₁ mm	X	P mm	l ₂	l ₁	d ₂	sq	Tapping drill diameter	EUROPA CODE
M 2	X	0.4	8	45	2.8	2.1	1.83	TM38270200
M 2.5	X	0.45	9	50	2.8	2.1	2.3	TM38270250
M 3	X	0.5	11	56	3.5	2.7	2.8	TM38270300
M 4	X	0.7	13	63	4.5	3.4	3.7	TM38270400
M 5	X	0.8	15	70	6	4.9	4.65	TM38270500
M 6	X	1.0	17	80	6	4.9	5.55	TM38270600
M 8	X	1.25	20	90	8	6.2	7.4	TM38270800
M 10	X	1.5	22	100	10	8	9.3	TM38271000
M 12	X	1.75	24	110	9	7	11.2	TM38271200
M 14	X	2.0	26	110	11	9	13	TM38271400
M 16	X	2.0	27	110	12	9	15	TM38271600
M 20	X	2.5	32	140	16	12	18.8	TM38272000

▶ DIN 371(M2-M10) DIN 376(M12-M20)

●: Excellent ○: Good

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
●	●						●			●		○			
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
●	●						●			●		○			

M METRIC COARSE THREADS



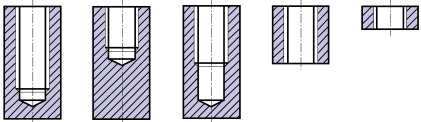
Series No. TM3817

▶ cutting conditions : p.87

Cold forming tap with oil grooves.
For materials with at least 10% elongation.
TiN coated for increased tool life.



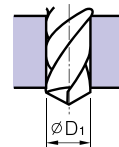
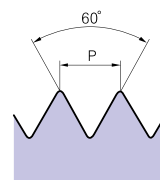
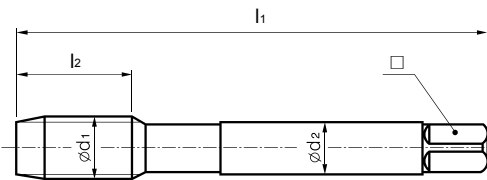
Hole type



DIN 371



DIN 376



Ød ₁ mm	X	P mm	l ₂	l ₁	d ₂	sq	Tapping drill diameter	EUROPA CODE
M 2	X	0.4	8	45	2.8	2.1	1.83	TM38170200
M 3	X	0.5	11	56	3.5	2.7	2.8	TM38170300
M 4	X	0.7	13	63	4.5	.4	3.7	TM38170400
M 5	X	0.8	15	70	6	4.9	4.65	TM38170500
M 6	X	1.0	17	80	6	4.9	5.55	TM38170600
M 8	X	1.25	20	90	8	6.2	7.4	TM38170800
M 10	X	1.5	22	100	10	8	9.3	TM38171000
M 12	X	1.75	24	110	9	7	11.2	TM38171200
M 14	X	2.0	26	110	11	9	13	TM38171400
M 16	X	2.0	27	110	12	9	15	TM38171600
M 20	X	2.5	32	140	16	12	18.8	TM38172000

▶ DIN 371(M2-M10) DIN 376(M12-M20)

●: Excellent ○: Good

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
●	●		●	●			●			●		○			
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
●	●						●			●		○			

M METRIC COARSE THREADS



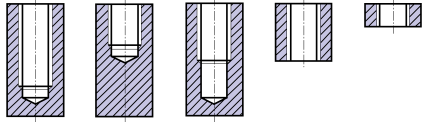
Series No. TM0731, TM0831

▶ cutting conditions : p.89

Straight flute.
Grey cast iron and fibre reinforced plastic.
Nitrited for increased wear resistance.



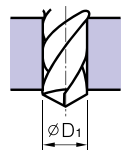
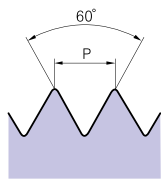
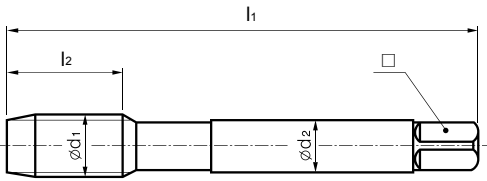
Hole type



DIN 371



DIN 376



Ød ₁ mm	X	P mm	l ₂	l ₁	d ₂	sq	Tapping drill diameter	EUROPA CODE
M 3	X	0.5	11	56	3.5	2.7	2.5	TM07310300
M 4	X	0.7	13	63	4.5	3.4	3.3	TM07310400
M 5	X	0.8	15	70	6	4.9	4.2	TM07310500
M 6	X	1.0	17	80	6	4.9	5	TM07310600
M 7	X	1.0	17	80	7	5.5	6	TM07310700
M 8	X	1.25	20	90	8	6.2	6.8	TM07310800
M 10	X	1.5	22	100	10	8	8.5	TM07311000
M 12	X	1.75	24	110	9	7	10.2	TM08311200
M 14	X	2.0	26	110	11	9	12	TM08311400
M 16	X	2.0	27	110	12	9	14	TM08311600
M 18	X	2.5	30	125	14	11	15.5	TM08311800
M 20	X	2.5	32	140	16	12	17.5	TM08312000

▶ DIN 371(M3-M10) DIN 376(M12-M20)

●: Excellent ○: Good

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
					●	●					○				
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
														●	

M METRIC COARSE THREADS



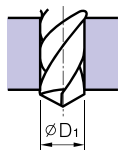
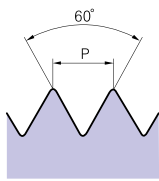
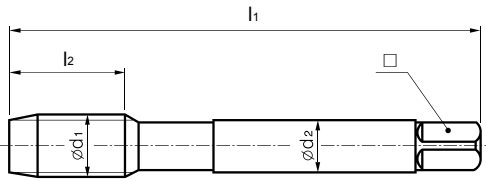
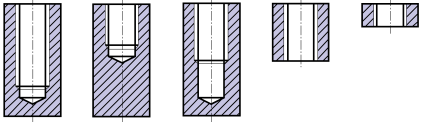
Series No. TM0917, TM1017

▶ cutting conditions : p.89

Straight flute.
Grey cast iron and fibre reinforced
plastic.
TiN coated for increased tool life.



Hole type



Ød ₁ mm	X	P mm	l ₂	l ₁	d ₂	sq	Tapping drill diameter	EUROPA CODE
M 2	X	0.4	8	45	2.8	2.1	1.6	TM09170200
M 3	X	0.5	11	56	3.5	2.7	2.5	TM09170300
M 4	X	0.7	13	63	4.5	3.4	3.3	TM09170400
M 5	X	0.8	15	70	6	4.9	4.2	TM09170500
M 6	X	1.0	17	80	6	4.9	5	TM09170600
M 8	X	1.25	20	90	8	6.2	6.8	TM09170800
M 10	X	1.5	22	100	10	8	8.5	TM09171000
M 12	X	1.75	24	110	9	7	10.2	TM10171200
M 16	X	2.0	27	110	12	9	14	TM10171600

▶ DIN 371(M3-M10) DIN 376(M12-M16)

●: Excellent ○: Good

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
					●	●					●				
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
														●	

M METRIC COARSE THREADS



HSS-E

DIN 357

6H

LONG

Bright



Series No. TM5016

DIN 357

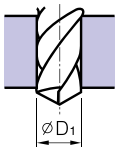
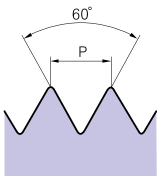
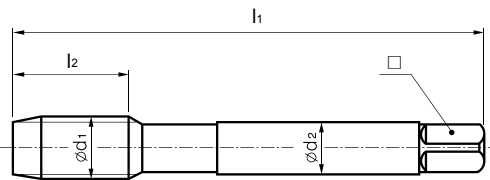
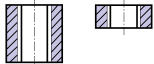
▶ cutting conditions : p.87

Straight flute.
Nut tap.
General steels <750N/mm².

Material groups

GS

Hole type



Ød ₁ mm	X	P mm	l ₂	l ₁	d ₂	sq	Tapping drill diameter	EUROPA CODE
M 4	X	0.7	25	90	2.8	2.1	3.3	TM50160400
M 5	X	0.8	28	100	3.5	2.7	4.2	TM50160500
M 6	X	1.0	32	110	4.5	3.4	5	TM50160600
M 8	X	1.25	40	125	6	4.9	6.8	TM50160800
M 10	X	1.5	45	140	7	5.5	8.5	TM50161000
M 12	X	1.75	50	180	9	7	10.2	TM50161200

▶ DIN 357(M4-M12)

●: Excellent ○: Good

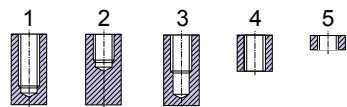
P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
○	○										○	○		○	
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
○	○				○	○							○		

APPLICATION TAPS
CUTTING DATA



Cutting data shown is for guidance and should be used as a starting point. Adjustments may be needed according to your set up.

HOLE TYPES:



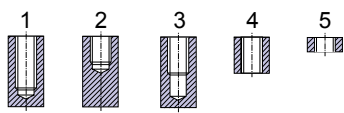
COOLANT TYPES

N - Neat Oil
E - Emulsion
N/E - Neat Oil or Emulsion
D - Dry
D/E - Dry or Emulsion

TAP TYPE			GS	GS
DIN 371/376	M	Series No.	TM0316	TM1716
DIN 371/376	EG-M	Series No.		
DIN 352	M	Series No.	TM0116	
DIN 374	MF	Series No.	TM3316	TM3416
DIN 371/376	UNC	Series No.	TM6416	TM6516
DIN 371/376	EG-UNC	Series No.		
DIN 371/374	UNF	Series No.	TM6716	TM6816
DIN 371/376	EG-UNF	Series No.		
DIN 2182/2183	W(BSW)	Series No.		
DIN 357/5156	M/G(BSP)	Series No.	TB0116	TB0216
SURFACE TREATMENT / COATING				
SPIRAL FLUTE ANGLE				R40
CHAMFER LEAD ACC. DIN 2197			B	C
HOLE TYPE			4-5	1-2-3
				

HARDNESS HB	TENSILE STRENGTH N/mm²	CHIP TYPE	COOLANT TYPE	V _c (m/min)	
< 120	< 400	Extra long	E		
< 200	< 700	Medium/long	E	18	18
< 250	< 850	Long	E	15	15
< 250	< 850	Long	N/E	12	12
< 350	< 1,200	Long	N/E		
> 350	> 1,200	Long	N		
< 250	< 850	Medium	N		
< 250	< 850	Long	N		
< 300	< 1,000	Long	N		
< 150	< 500	Extra short	N/E		
< 300	< 1,000	Extra short	E		
< 200	< 700	Short	N/E	12	12
< 300	< 1,000	Short	N/E	6	6
< 200	< 700	Extra long	E	12	12
< 270	< 900	Medium/Short	N		
< 350	< 1,250	Medium/Short	N		
< 150	< 500	Extra long	N	10	10
< 270	< 900	Long	N		
< 350	< 1,250	Long	N		
< 100	< 350	Extra long	E	10	10
< 200	< 700	Medium/Short	E		
< 200	< 700	Long	E	15	15
< 470	< 1,500	Short	N		
< 100	< 350	Extra long	E	10	10
< 150	< 500	Medium	E	25	25
< 120	< 400	Medium/Short	E	15	15
< 120	< 400	Short	E	10	10
		Extra long	E	20	20
		Short	D/E		
		Extra short	D/E		

[illegible]

  MACHINE TAPS CUTTING SPEEDS Cutting data shown is for guidance and should be used as a starting point. Adjustments may be needed according to your set up. HOLE TYPES: 		TAP TYPE			VA/CS	VA/CS		
		DIN 371/376	M	Series No.	TM8053	TM8153		
		DIN 371/376	EG-M	Series No.				
		DIN 352	M	Series No.				
		DIN 374	MF	Series No.				
		DIN 371/376	UNC	Series No.				
		DIN 371/376	EG-UNC	Series No.				
		DIN 371/374	UNF	Series No.				
		DIN 371/376	EG-UNF	Series No.				
		DIN 2182/2183	W(BSW)	Series No.				
		DIN 357/5156	M/G(BSP)	Series No.				
SURFACE TREATMENT / COATING				Hardslick	Hardslick			
SPIRAL FLUTE ANGLE					R40			
CHAMFER LEAD ACC. DIN 2197				B	C			
HOLE TYPE				4-5	1-2-3			
COOLANT TYPES								
N - Neat Oil								
E - Emulsion								
N/E - Neat Oil or Emulsion								
D - Dry								
D/E - Dry or Emulsion								
MATERIAL GROUP			HARDNESS HB	TENSILE STRENGTH N/mm²	CHIP TYPE	COOLANT TYPE	V _c (m/min)	
P	11	Magnetic soft steels	< 120	< 400	Extra long	E	40	40
	12	Structural steels, case carburizing steels	< 200	< 700	Medium/long	E	30	30
	13	Plain carbon steels	< 250	< 850	Long	E		
	14	Alloy steels	< 250	< 850	Long	N/E		
H	15	Alloy steels/Hardened & Tempered steels	< 350	< 1,200	Long	N/E		
	16	Alloy steels/Hardened & Tempered steels	> 350	> 1,200	Long	N		
M	21	Free machining stainless steel	< 250	< 850	Medium	N	20	20
	22	Austenitic stainless steel	< 250	< 850	Long	N	15	15
	23	Ferritic, Ferritic+Austenitic,Martensitic	< 300	< 1,000	Long	N	12	12
K	31	Grey cast irons	< 150	< 500	Extra short	N/E		
	32	Grey cast irons	< 300	< 1,000	Extra short	E		
	33	Nodular graphite, Malleable cast irons	< 200	< 700	Short	N/E		
	34	Nodular graphite, Malleable cast irons	< 300	< 1,000	Short	N/E		
S	41	Titanium, unalloyed	< 200	< 700	Extra long	E		
	42	Titanium, alloyed	< 270	< 900	Medium/Short	N	10	10
	43	Titanium, alloyed	< 350	< 1,250	Medium/Short	N		
	51	Nickel, unalloyed	< 150	< 500	Extra long	N		
	52	Nickel, alloyed	< 270	< 900	Long	N	12	12
	53	Nickel, alloyed	< 350	< 1,250	Long	N		
N	61	Copper, unalloyed	< 100	< 350	Extra long	E		
	62	Short chipping Brass, Bronze, Copper	< 200	< 700	Medium/Short	E		
	63	Long chipping Brass, Bronze, Copper	< 200	< 700	Long	E		
	64	AMPCO (Cu-Al-Fe alloys)	< 470	< 1,500	Short	N		
	71	Aluminium, Magnesium, unalloyed	< 100	< 350	Extra long	E		
	72	Aluminium, alloyed Si < 0.5%	< 150	< 500	Medium	E		
	73	Aluminium, alloyed, Si < 10%	< 120	< 400	Medium/Short	E		
	74	Aluminium, alloyed, Si > 10%	< 120	< 400	Short	E		
O	81	Thermoplastics			Extra long	E		
	82	Thermosetting Plastics			Short	D/E		
	83	Reinforced plastic materials			Extra short	D/E		

VA/CS	VA/CS	CS	GG	GG	Ti/Ni	Ti/Ni	Ni	Ni	Al	Al
TM3130	TM2530	TM1730	TM0731	TM0917	TM7110	TM7210	TM7328	TM7428	TM0516	TM3716
TM3630	TM3830									
TM6430	TM6530									
TM6730	TM6830									
VAP	VAP	VAP	NI	TiN			TiAIN	TiAIN		
	R40	R40				R40		R25		R45/40
B	C	C	C	C	B	C	B	C	B	C
4-5	1-2-3	1-2-3	1-2-3 4-5	1-2-3 4-5	4-5	1-2-3	4-5	1-2-3	4-5	1-2-3
										
V _c (m/min)										
30	30	30							20	20
20	20	20							15	15
									12	12
					6	6	12	12		
					4	4	8	8		
15	15									
12	12	12								
10	10									
			15	20						
			8	15						
					12	12			10	10
8	8				12	12				
					6	6	8	8		
10	10				12	12	20	20		
					3	3	8	8		
		8							10	10
			30	40						
					4	4	10	10		
		10							15	15
									35	35
									20	20
			6	10						