

Taps



HSS-E taps can be used universally for almost all materials. For heavy duty requirements we offer types in HSS-E powder metal grades (PM). Solid carbide taps are made out of a special extra fine grain. These tools are specifically for machining high silicon aluminium alloys, brittle materials, such as grey cast iron or short chipping brass and heavy-duty materials.

Compared to HSS-E taps carbide taps have substantial advantages:

- Up to 20x longer tool life than HSS-E taps
- Fewer tool change times due to longer tool life
- Higher cutting speeds - so shorter cycle times
- Significant reduction in production costs due to longer tool life, higher cutting speeds and fewer tool changes



M	HSS-E Taps	DOREX, DOREX VAV, DOREX TiN, DOREX TiCN, TINIB, FEDUB		96
M	HSS-E Taps	GG, GG TiN, SIREX		97
M	HSS-E Taps	SIREX SR, TINIC, FEDUC		98
M	HSS-E Taps	TAREX, TAREX VAV, TAREX TiN, TAREX TiCN, TAREX OT TiN		99
M	HSS-E Taps	TAREX AL		100
MF	HSS-E Taps	DOREX, DOREX VAV, DOREX TiN		101
MF	HSS-E Taps	GG, SIREX		102
MF	HSS-E Taps	SIREX SR		103
MF	HSS-E Taps	TAREX, TAREX VAV, TAREX TiN		104
M	HSS-E Taps with central coolant supply	SIREX SR IK, SIREX SR IK TiN, SIREX SR IK TiCN		105
M	HSS-E Taps with central coolant supply	TAREX IK, TAREX IK TiN		106
M	HSS-E Taps with central coolant supply	GG IK, GG IK TiN		107
M	Solid Carbide Taps	SIREX, GG		108
M	Solid Carbide Taps	SIREX SR		109
M	Solid Carbide Taps	DOREX		110
M	Solid Carbide Taps	SIREX XH		111
MF	Solid Carbide Taps	SIREX, SIREX SR		112



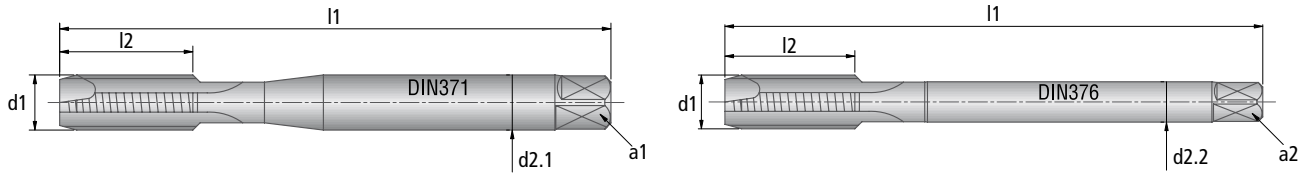
M HSS-E Taps

DOREX, DOREX VAV, DOREX TiN, DOREX TiCN, TINIB, FEDUB

For metric ISO thread DIN 13

Cutting material: HSS-E / PM

* up to and including M6 without neck



Type								DOREX	DOREX VAV	DOREX TiN	DOREX TiCN	TINIB	FEDUB
Tolerance field								ISO 2	ISO 2	ISO 2	ISO 2	ISO 2	ISO 2
Dimensions (DIN)								371 to M10	371 to M10	371 to M10	371 to M10	371 to M10 *	371 to M10 *
								376 from M11	376 from M11	376 from M11	376 from M11	376 from M11	376 from M11
Material								HSS-E	HSS-E	HSS-E	HSS - E	PM	PM
Chamfer form								B	B	B	B	B	B
Version								uncoated	vaporized	TiN	TiCN	vaporized	vaporized
Nominal Ø d1	P	l1	l2	d2.1	a1	d2.2	a2						
								Order No.	Order No.	Order No.	Order No.	Order No.	Order No.
M 1,4	0,30	40	7,0	2,5	2,1								
M 1,6	0,35	40	8,0	2,5	2,1		20122001000005	20136001000005					
M 1,7	0,35	40	8,0	2,5	2,1								
M 1,8	0,35	40	8,0	2,5	2,1								
M 2	0,40	45	8,0	2,8	2,1		20122001000008	20136001000008			20194001000008		
M 2,2	0,45	45	9,0	2,8	2,1								
M 2,3	0,40	45	9,0	2,8	2,1								
M 2,5	0,45	50	9,0	2,8	2,1		20122001000011	20136001000011			20194001000011		
M 2,6	0,45	50	9,0	2,8	2,1								
M 3	0,50	56	11,0	3,5	2,7		20122001000013	20136001000013	20322001000013	20622001000013	20194001000013	20186001000013	
M 3,5	0,60	56	13,0	4,0	3,0								
M 4	0,70	63	13,0	4,5	3,4		20122001000015	20136001000015	20322001000015	20622001000015	20194001000015	20186001000015	
M 4,5	0,75	70	15,0	6,0	4,9								
M 5	0,80	70	16,0	6,0	4,9		20122001000017	20136001000017	20322001000017	20622001000017	20194001000017	20186001000017	
M 6	1,00	80	18,0	6,0	4,9		20122001000018	20136001000018	20322001000018	20622001000018	20194001000018	20186001000018	
M 7	1,00	80	18,0	7,0	5,5		20122001000019						
M 8	1,25	90	18,0	8,0	6,2		20122001000020	20136001000020	20322001000020	20622001000020	20194001000020	20186001000020	
M 9	1,25	90	18,0	9,0	7,0								
M10	1,50	100	21,0	10,0	8,0		20122001000022	20136001000022	20322001000022	20622001000022	20194001000022	20186001000022	
M11	1,50	100	21,0			8,0	6,2						
M12	1,75	110	24,0			9,0	7,0	20123001000024	20137001000024	20323001000024	20623001000024		20187001000024
M14	2,00	110	24,0			11,0	9,0	20123001000025	20137001000025				
M16	2,00	110	27,0			12,0	9,0	20123001000026	20137001000026				
M18	2,50	125	32,0			14,0	11,0	20123001000027	20137001000027				
M20	2,50	140	32,0			16,0	12,0	20123001000028	20137001000028				
M22	2,50	140	32,0			18,0	14,5	20123001000029					
M24	3,00	160	38,0			18,0	14,5	20123001000030					
M27	3,00	160	38,0			20,0	16,0						
M30	3,50	180	42,0			22,0	18,0						

M HSS-E Taps

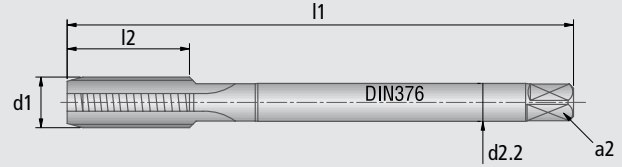
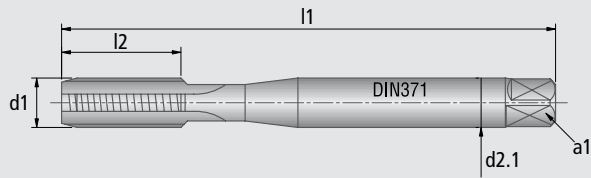


GG, GG TiN, SIREX

For metric ISO thread DIN 13

Cutting material: HSS-E

* up to and including M6 without neck



Type		GG		GG TiN		SIREX				
Tolerance field		ISO 2X		ISO 2X		ISO 2				
Dimensions (DIN)		371 to M10		371 to M10		371 to M10				
		376 from M11		376 from M11		376 from M11				
Material		HSS - E		HSS - E		HSS - E				
Chamfer form		C		C		C				
Version		nitrided		TiN		uncoated				
Nominal Ø d1	P	l1	l2	d2.1	a1	d2.2	a2			
								Order No.	Order No.	Order No.
M 1,4	0,30	40	7,0	2,5	2,1					
M 1,6	0,35	40	8,0	2,5	2,1					
M 1,7	0,35	40	8,0	2,5	2,1					
M 1,8	0,35	40	8,0	2,5	2,1					
M 2	0,40	45	8,0	2,8	2,1					20120001000008
M 2,2	0,45	45	9,0	2,8	2,1					
M 2,3	0,40	45	9,0	2,8	2,1					
M 2,5	0,45	50	9,0	2,8	2,1					20120001000011
M 2,6	0,45	50	9,0	2,8	2,1					
M 3	0,50	56	11,0	3,5	2,7			20356001000013		20120001000013
M 3,5	0,60	56	13,0	4,0	3,0					20120001000014
M 4	0,70	63	13,0	4,5	3,4			20156001000015	20356001000015	20120001000015
M 4,5	0,75	70	15,0	6,0	4,9					
M 5	0,80	70	16,0	6,0	4,9			20156001000017	20356001000017	20120001000017
M 6	1,00	80	18,0	6,0	4,9			20156001000018	20356001000018	20120001000018
M 7	1,00	80	18,0	7,0	5,5					
M 8	1,25	90	18,0	8,0	6,2			20156001000020	20356001000020	20120001000020
M 9	1,25	90	18,0	9,0	7,0					
M10	1,50	100	21,0	10,0	8,0			20156001000022	20356001000022	20120001000022
M11	1,50	100	21,0			8,0	6,2			
M12	1,75	110	24,0			9,0	7,0	20157001000024	20357001000024	20121001000024
M14	2,00	110	24,0			11,0	9,0	20157001000025		20121001000025
M16	2,00	110	27,0			12,0	9,0	20157001000026		20121001000026
M18	2,50	125	32,0			14,0	11,0	20157001000027		
M20	2,50	140	32,0			16,0	12,0	20157001000028		
M22	2,50	140	32,0			18,0	14,5			
M24	3,00	160	38,0			18,0	14,5			
M27	3,00	160	38,0			20,0	16,0			
M30	3,50	180	42,0			22,0	18,0			

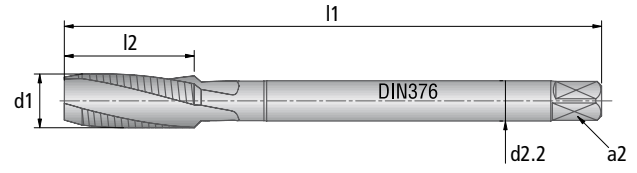
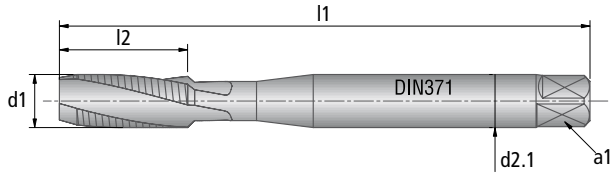
M HSS-E Taps

SIREX SR, TINIC, FEDUC

For metric ISO thread DIN 13

Cutting material: HSS-E / PM

* up to and including M6 without neck



Type									SIREX SR	TINIC	FEDUC
Tolerance field									ISO 2	ISO 2	ISO 2
Dimensions (DIN)									371 to M10	371 to M10 *	371 to M10 *
									376 from M11	376 from M11	376 from M11
Material									HSS - E	PM	PM
Chamfer form									C	C	C
Version									uncoated	vaporized	vaporized
Nominal Ø d1	P	l1	l2	d2.1	a1	d2.2	a2				
								Order No.	Order No.	Order No.	
M 1,4	0,30	40	7,0	2,5	2,1						
M 1,6	0,35	40	8,0	2,5	2,1						
M 1,7	0,35	40	8,0	2,5	2,1						
M 1,8	0,35	40	8,0	2,5	2,1						
M 2	0,40	45	8,0	2,8	2,1			2014400100008	2019000100008	2019200100008	
M 2,2	0,45	45	9,0	2,8	2,1						
M 2,3	0,40	45	9,0	2,8	2,1						
M 2,5	0,45	50	9,0	2,8	2,1			2014400100011	2019000100011	2019200100011	
M 2,6	0,45	50	9,0	2,8	2,1						
M 3	0,50	56	11,0	3,5	2,7			2014400100013	2019000100013	2019200100013	
M 3,5	0,60	56	13,0	4,0	3,0			2014400100014			
M 4	0,70	63	13,0	4,5	3,4			2014400100015	2019000100015	2019200100015	
M 4,5	0,75	70	15,0	6,0	4,9						
M 5	0,80	70	16,0	6,0	4,9			2014400100017	2019000100017	2019200100017	
M 6	1,00	80	18,0	6,0	4,9			2014400100018	2019000100018	2019200100018	
M 7	1,00	80	18,0	7,0	5,5						
M 8	1,25	90	18,0	8,0	6,2			2014400100020	2019000100020	2019200100020	
M 9	1,25	90	18,0	9,0	7,0						
M10	1,50	100	21,0	10,0	8,0			2014400100022	2019000100022	2019200100022	
M11	1,50	100	21,0			8,0	6,2				
M12	1,75	110	24,0			9,0	7,0	2014500100024	2019100100024	2019300100024	
M14	2,00	110	24,0			11,0	9,0	2014500100025			
M16	2,00	110	27,0			12,0	9,0	2014500100026			
M18	2,50	125	32,0			14,0	11,0	2014500100027			
M20	2,50	140	32,0			16,0	12,0	2014500100028			
M22	2,50	140	32,0			18,0	14,5				
M24	3,00	160	38,0			18,0	14,5				
M27	3,00	160	38,0			20,0	16,0				
M30	3,50	180	42,0			22,0	18,0				

M HSS-E Taps

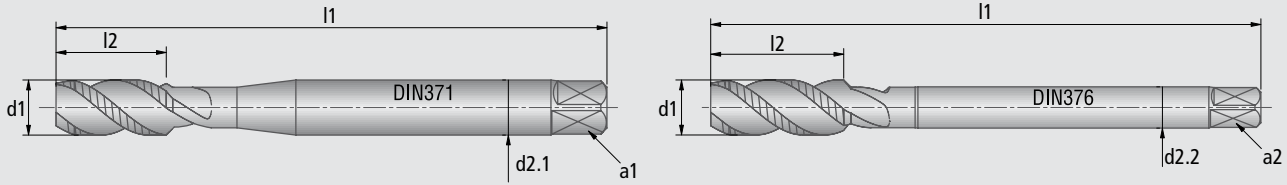


TAREX, TAREX VAV, TAREX TiN, TAREX TiCN, TAREX OT TiN

For metric ISO thread DIN 13

Cutting material: HSS-E / PM

* up to and including M6 without neck



Type								TAREX	TAREX VAV	TAREX TiN	TAREX TiCN	TAREX OT TiN					
Tolerance field								ISO 2	ISO 2	ISO 2	ISO 2	ISO 2					
Dimensions (DIN)								371 to M10	371 to M10	371 to M10	371 to M10	371 to M10 *					
								376 from M11	376 from M11	376 from M11	376 from M11	376 from M11					
Material								HSS - E	HSS - E	HSS - E	HSS - E	PM					
Chamfer form								C	C	C	C	C					
Version								uncoated	vaporized	TiN	TiCN	vaporized					
								Nominal Ø d1	P	l1	l2	d2.1	a1	d2.2	a2	Order No.	Order No.
M 1,4	0,30	40	4,0	2,5	2,1												
M 1,6	0,35	40	4,0	2,5	2,1												
M 1,7	0,35	40	4,0	2,5	2,1												
M 1,8	0,35	40	4,0	2,5	2,1												
M 2	0,40	45	4,0	2,8	2,1			20146001000008	20170001000008								
M 2,2	0,45	45	4,0	2,8	2,1												
M 2,3	0,40	45	4,0	2,8	2,1												
M 2,5	0,45	50	4,0	2,8	2,1			20146001000011	20170001000011								
M 2,6	0,45	50	4,0	2,8	2,1												
M 3	0,50	56	5,0	3,5	2,7			20146001000013	20170001000013	20346001000013	20646001000013	20342001000013					
M 3,5	0,60	56	5,0	4,0	3,0			20146001000014	20170001000014								
M 4	0,70	63	7,0	4,5	3,4			20146001000015	20170001000015	20346001000015	20646001000015	20342001000015					
M 4,5	0,75	70	7,0	6,0	4,9												
M 5	0,80	70	8,0	6,0	4,9			20146001000017	20170001000017	20346001000017	20646001000017	20342001000017					
M 6	1,00	80	10,0	6,0	4,9			20146001000018	20170001000018	20346001000018	20646001000018	20342001000018					
M 7	1,00	80	10,0	7,0	5,5												
M 8	1,25	90	12,0	8,0	6,2			20146001000020	20170001000020	20346001000020	20646001000020	20342001000020					
M 9	1,25	90	12,0	9,0	7,0												
M10	1,50	100	14,0	10,0	8,0			20146001000022	20170001000022	20346001000022	20646001000022	20342001000022					
M11	1,50	100	14,0			8,0	6,2										
M12	1,75	110	16,0			9,0	7,0	20147001000024	20171001000024	20347001000024	20647001000024	20343001000024					
M14	2,00	110	20,0			11,0	9,0	20147001000025	20171001000025	20347001000025							
M16	2,00	110	20,0			12,0	9,0	20147001000026	20171001000026	20347001000026							
M18	2,50	125	24,0			14,0	11,0	20147001000027	20171001000027	20347001000027							
M20	2,50	140	24,0			16,0	12,0	20147001000028	20171001000028	20347001000028							
M22	2,50	140	24,0			18,0	14,5	20147001000029									
M24	3,00	160	28,0			18,0	14,5	20147001000030									
M27	3,00	160	28,0			20,0	16,0										
M30	3,50	180	36,0			22,0	18,0										

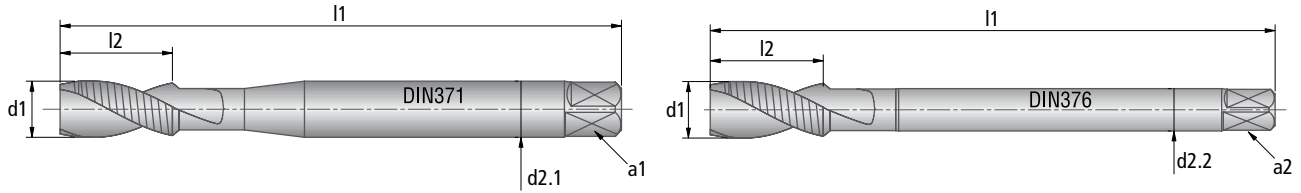
M HSS-E Taps

TAREX AL

For metric ISO thread DIN 13

Cutting material: HSS-E

* up to and including M6 without neck



Type								TAREX AL	
Tolerance field								ISO 2	
Dimensions (DIN)								371 to M10	
								376 from M11	
Material								HSS - E	
Chamfer form								C	
Version								uncoated	
Nominal Ø d1	P	l1	l2	d2.1	a1	d2.2	a2	Order No.	
M 1,4	0,30	40	7,0	2,5	2,1				
M 1,6	0,35	40	8,0	2,5	2,1				
M 1,7	0,35	40	8,0	2,5	2,1				
M 1,8	0,35	40	8,0	2,5	2,1				
M 2	0,40	45	8,0	2,8	2,1			20154001000008	
M 2,2	0,45	45	9,0	2,8	2,1				
M 2,3	0,40	45	9,0	2,8	2,1				
M 2,5	0,45	50	9,0	2,8	2,1			20154001000011	
M 2,6	0,45	50	9,0	2,8	2,1				
M 3	0,50	56	11,0	3,5	2,7			20154001000013	
M 3,5	0,60	56	13,0	4,0	3,0				
M 4	0,70	63	13,0	4,5	3,4			20154001000015	
M 4,5	0,75	70	15,0	6,0	4,9				
M 5	0,80	70	16,0	6,0	4,9			20154001000017	
M 6	1,00	80	18,0	6,0	4,9			20154001000018	
M 7	1,00	80	18,0	7,0	5,5				
M 8	1,25	90	18,0	8,0	6,2			20154001000020	
M 9	1,25	90	18,0	9,0	7,0				
M10	1,50	100	21,0	10,0	8,0			20154001000022	
M11	1,50	100	21,0			8,0	6,2		
M12	1,75	110	24,0			9,0	7,0	20155001000024	
M14	2,00	110	24,0			11,0	9,0		
M16	2,00	110	27,0			12,0	9,0		
M18	2,50	125	32,0			14,0	11,0		
M20	2,50	140	32,0			16,0	12,0		
M22	2,50	140	32,0			18,0	14,5		
M24	3,00	160	38,0			18,0	14,5		
M27	3,00	160	38,0			20,0	16,0		
M30	3,50	180	42,0			22,0	18,0		

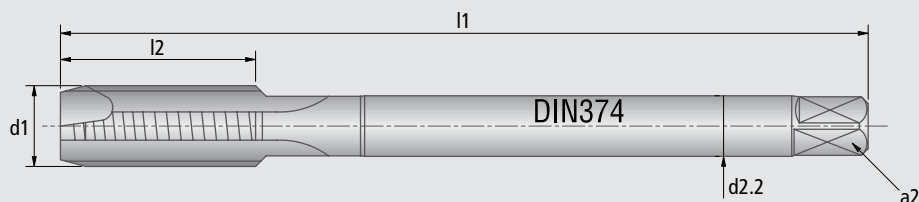
MF HSS-E Taps

DOREX, DOREX VAV, DOREX TiN



For metric fine ISO thread DIN 13

Cutting material: HSS-E



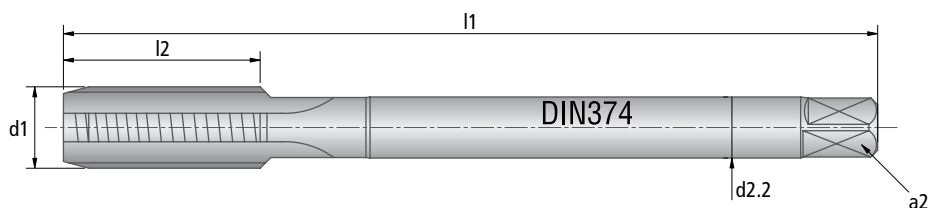
Type						DOREX	DOREX VAV	DOREX TiN	
Tolerance field						ISO 2	ISO 2	ISO 2	
Dimensions (DIN)						374	374	374	
Thread length						l2.1	l2.1	l2.1	
Material						HSS - E	HSS - E	HSS - E	
Chamfer form						B	B	B	
Version						uncoated	vaporized	TiN	
Nominal Ø x P d1	l1	l2	d2.2	a2	Order No.	Order No.	Order No.		
M 4x0,5	63	10	2,8	2,1	20123002000029				
M 5x0,5	70	12	3,5	2,7					
M 6x0,5	80	14	4,5	3,4					
M 6x0,75	80	14	4,5	3,4	20123002000048				
M 7x0,75	80	14	5,5	4,3					
M 8x0,5	80	14	6,0	4,9					
M 8x0,75	80	14	6,0	4,9					
M 8x1	90	18	6,0	4,9	20123002000070	20137002000070	20323002000070		
M 9x1	90	18	7,0	5,5					
M10x0,75	90	14	7,0	5,5					
M10x1	90	18	7,0	5,5	20123002000094	20137002000094	20323002000094		
M10x1,25	100	21	7,0	5,5					
M11x1	90	18	8,0	6,2					
M12x1	100	20	9,0	7,0	20123002000111				
M12x1,25	100	20	9,0	7,0					
M12x1,5	100	20	9,0	7,0	20123002000113	20137002000113	20323002000113		
M14x1	100	20	11,0	9,0					
M14x1,25	100	20	11,0	9,0					
M14x1,5	100	20	11,0	9,0		20137002000131	20323002000131		
M15x1	100	20	12,0	9,0					
M15x1,5	100	20	12,0	9,0					
M16x1	100	20	12,0	9,0					
M16x1,5	100	20	12,0	9,0	20123002000147	20137002000147	20323002000147		
M18x1	110	24	14,0	11,0					
M18x1,5	110	24	14,0	11,0	20123002000160				
M20x1,5	125	24	16,0	12,0	20123002000174				
M22x1,5	125	24	18,0	14,5	20123002000188				
M24x1,5	140	24	18,0	14,5	20123002000202				
M26x1,5	140	24	18,0	14,5	20123002000216				
M28x1,5	140	28	20,0	16,0	20123002000230				
M30x1,5	150	28	22,0	18,0	20123002000244				


MF HSS-E Taps

GG, SIREX

For metric fine ISO thread DIN 13

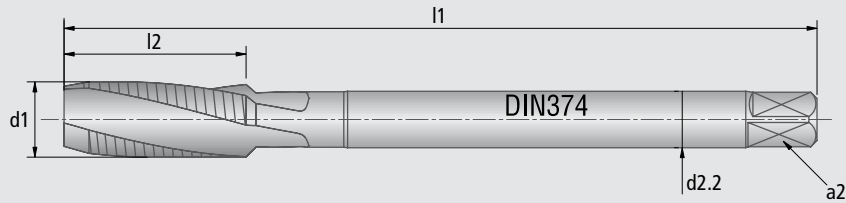
Cutting material: HSS-E




Type					GG	SIREX
Tolerance field					ISO 2X	ISO 2
Dimensions (DIN)					374	374
Thread length					l2.1	l2.1
Material					HSS - E	HSS - E
Chamfer form					C	C
Version					nitrided	uncoated
						
					Order No.	Order No.
Nominal Ø x P d1	l1	l2	d2.2	a2		
M 4x0,5	63	10	2,8	2,1		20121002000029
M 5x0,5	70	12	3,5	2,7		
M 6x0,5	80	14	4,5	3,4		
M 6x0,75	80	14	4,5	3,4		20121002000048
M 7x0,75	80	14	5,5	4,3		
M 8x0,5	80	14	6,0	4,9		
M 8x0,75	80	14	6,0	4,9		
M 8x1	90	18	6,0	4,9	20157002000070	20121002000070
M 9x1	90	18	7,0	5,5		
M10x0,75	90	14	7,0	5,5		
M10x1	90	18	7,0	5,5	20157002000094	20121002000094
M10x1,25	100	21	7,0	5,5		
M11x1	90	18	8,0	6,2		
M12x1	100	20	9,0	7,0		20121002000111
M12x1,25	100	20	9,0	7,0		
M12x1,5	100	20	9,0	7,0	20157002000113	20121002000113
M14x1	100	20	11,0	9,0		
M14x1,25	100	20	11,0	9,0		
M14x1,5	100	20	11,0	9,0	20157002000131	20121002000131
M15x1	100	20	12,0	9,0		
M15x1,5	100	20	12,0	9,0		
M16x1	100	20	12,0	9,0		
M16x1,5	100	20	12,0	9,0	20157002000147	20121002000147
M18x1	110	24	14,0	11,0		
M18x1,5	110	24	14,0	11,0		20121002000160
M20x1,5	125	24	16,0	12,0	20157002000174	20121002000174
M22x1,5	125	24	18,0	14,5		
M24x1,5	140	24	18,0	14,5		
M26x1,5	140	24	18,0	14,5		
M28x1,5	140	28	20,0	16,0		
M30x1,5	150	28	22,0	18,0		

SIREX SR

For metric fine ISO thread DIN 13
Cutting material: HSS-E



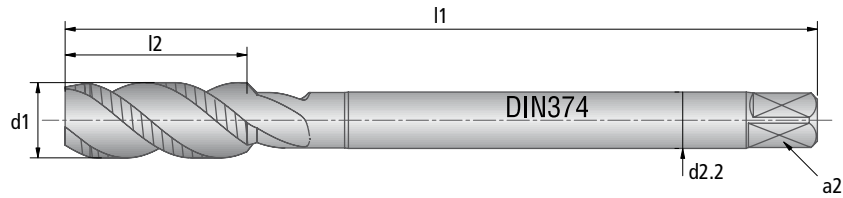
Type		SIREX SR				
Tolerance field		ISO 2				
Dimensions (DIN)		374				
Thread length		l2.2				
Material		HSS - E				
Chamfer form		C				
Version		uncoated				
						
Nominal Ø x P d1	l1	l2	d2.2	a2	Order No.	
M 4x0,5	63	10	2,8	2,1	20145002000029	
M 5x0,5	70	12	3,5	2,7		
M 6x0,5	80	14	4,5	3,4		
M 6x0,75	80	14	4,5	3,4	20145002000048	
M 7x0,75	80	14	5,5	4,3		
M 8x0,5	80	14	6,0	4,9		
M 8x0,75	80	14	6,0	4,9		
M 8x1	90	18	6,0	4,9	20145002000070	
M 9x1	90	18	7,0	5,5		
M10x0,75	90	14	7,0	5,5		
M10x1	90	18	7,0	5,5	20145002000094	
M10x1,25	100	21	7,0	5,5		
M11x1	90	18	8,0	6,2		
M12x1	100	20	9,0	7,0	20145002000111	
M12x1,25	100	20	9,0	7,0		
M12x1,5	100	20	9,0	7,0	20145002000113	
M14x1	100	20	11,0	9,0		
M14x1,25	100	20	11,0	9,0		
M14x1,5	100	20	11,0	9,0	20145002000131	
M15x1	100	20	12,0	9,0		
M15x1,5	100	20	12,0	9,0		
M16x1	100	20	12,0	9,0		
M16x1,5	100	20	12,0	9,0	20145002000147	
M18x1	110	24	14,0	11,0		
M18x1,5	110	24	14,0	11,0	20145002000160	
M20x1,5	125	24	16,0	12,0	20145002000174	
M22x1,5	125	24	18,0	14,5		
M24x1,5	140	24	18,0	14,5		
M26x1,5	140	24	18,0	14,5		
M28x1,5	140	28	20,0	16,0		
M30x1,5	150	28	22,0	18,0		

MF HSS-E Taps

TAREX, TAREX VAV, TAREX TiN

For metric fine ISO thread DIN 13

Cutting material: HSS-E



Type	TAREX	TAREX VAV	TAREX TiN				
Tolerance field	ISO 2	ISO 2	ISO 2				
Dimensions (DIN)	374	374	374				
Thread length	l2.2	l2.2	l2.2				
Material	HSS - E	HSS - E	HSS - E				
Chamfer form	C	C	C				
Version	uncoated	vaporized	TiN				
Nominal Ø x P d1							
	l1	l2	d2.2	a2	Order No.	Order No.	Order No.
M 4x0,5	63	7,0	2,8	2,1	20147002000029		
M 5x0,5	70	8,0	3,5	2,7			
M 6x0,5	80	10,0	4,5	3,4			
M 6x0,75	80	10,0	4,5	3,4	20147002000048		
M 7x0,75	80	10,0	5,5	4,3			
M 8x0,5	80	12,0	6,0	4,9			
M 8x0,75	80	12,0	6,0	4,9			
M 8x1	90	12,0	6,0	4,9	20147002000070	20171002000070	20347002000070
M 9x1	90	12,0	7,0	5,5			
M10x0,75	90	14,0	7,0	5,5			
M10x1	90	14,0	7,0	5,5	20147002000094	20171002000094	20347002000094
M10x1,25	100	14,0	7,0	5,5			
M11x1	90	14,0	8,0	6,2			
M12x1	100	14,0	9,0	7,0	20147002000111		
M12x1,25	100	14,0	9,0	7,0			
M12x1,5	100	14,0	9,0	7,0	20147002000113	20171002000113	20347002000113
M14x1	100	16,0	11,0	9,0			
M14x1,25	100	16,0	11,0	9,0			
M14x1,5	100	16,0	11,0	9,0	20147002000131	20171002000131	20347002000131
M15x1	100	16,0	12,0	9,0			
M15x1,5	100	16,0	12,0	9,0			
M16x1	100	16,0	12,0	9,0			
M16x1,5	100	16,0	12,0	9,0	20147002000147	20171002000147	20347002000147
M18x1	110	18,0	14,0	11,0			
M18x1,5	110	18,0	14,0	11,0	20147002000160	20171002000160	
M20x1,5	125	20,0	16,0	12,0	20147002000174	20171002000174	
M22x1,5	125	20,0	18,0	14,5	20147002000188		
M24x1,5	140	20,0	18,0	14,5	20147002000202		
M26x1,5	140	20,0	18,0	14,5	20147002000216		
M28x1,5	140	22,0	20,0	16,0	20147002000230		
M30x1,5	150	24,0	22,0	18,0	20147002000244		

M HSS-E Taps

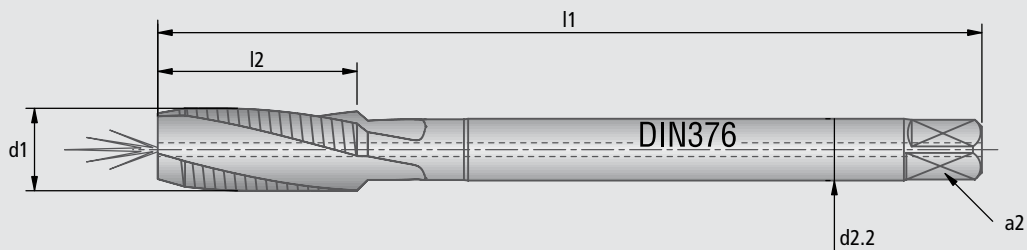
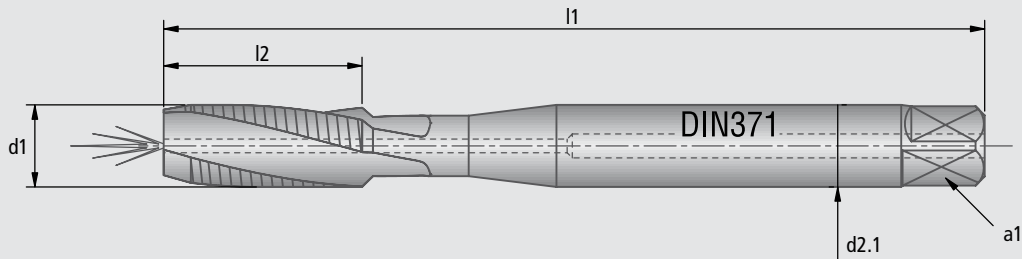
with central coolant supply

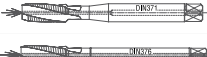
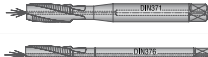
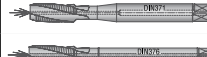


SIREX SR IK, SIREX SR IK TiN, SIREX SR IK TiCN

For metric ISO thread DIN 13

Cutting material: HSS-E



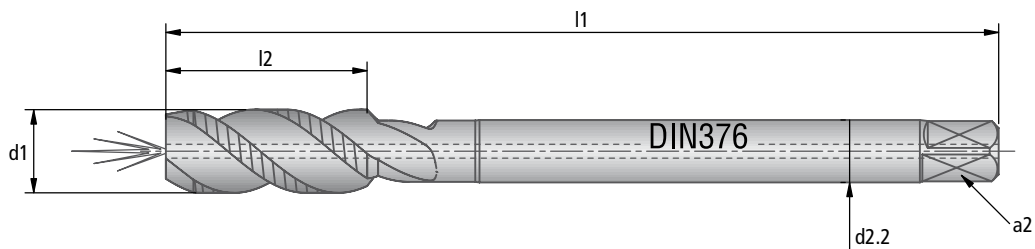
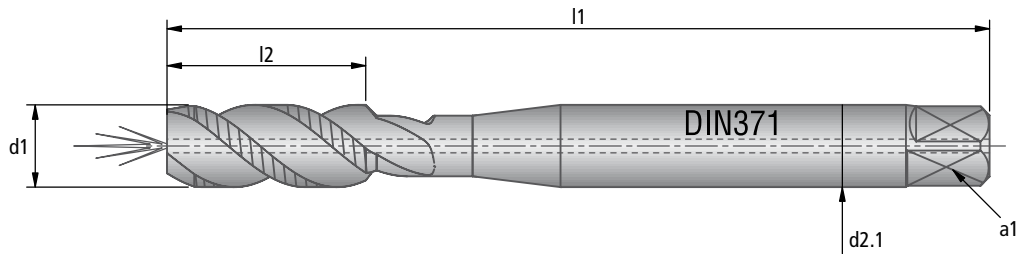
Type		SIREX SR IK	SIREX SR IK TiN	SIREX SR IK TiCN						
Tolerance field		ISO 2	ISO 2	ISO 2						
Dimensions (DIN)		371 to M10	371 to M10	371 to M10						
		376 from M11	376 from M11	376 from M11						
Material		HSS - E	HSS - E	HSS - E						
Chamfer form		C	C	C						
Version		uncoated	TiN	TiCN						
Nominal Ø d1	P	l1	l2	d2.1	a1	d2.2	a2			
								Order No.	Order No.	Order No.
M 4	0,70	63	13,0	4,5	3,4					
M 4,5	0,75	70	15,0	6,0	4,9					
M 5	0,80	70	16,0	6,0	4,9					
M 6	1,00	80	18,0	6,0	4,9			20444001000018	20544001000018	20744001000018
M 7	1,00	80	18,0	7,0	5,5					
M 8	1,25	90	18,0	8,0	6,2			20444001000020	20544001000020	20744001000020
M 9	1,25	90	18,0	9,0	7,0					
M10	1,50	100	21,0	10,0	8,0			20444001000022	20544001000022	20744001000022
M11	1,50	100	21,0			8,0	6,2			
M12	1,75	110	24,0			9,0	7,0	20445001000024	20545001000024	20745001000024
M14	2,00	110	24,0			11,0	9,0			
M16	2,00	110	27,0			12,0	9,0			







M HSS-E Taps with central coolant supply

TAREX IK, TAREX IK TiN

For metric ISO thread DIN 13
Cutting material: HSS-E



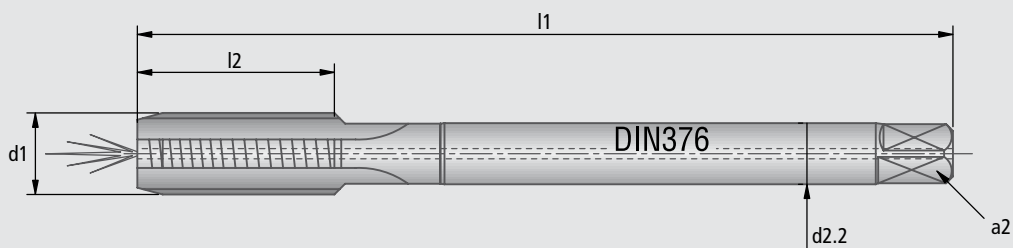
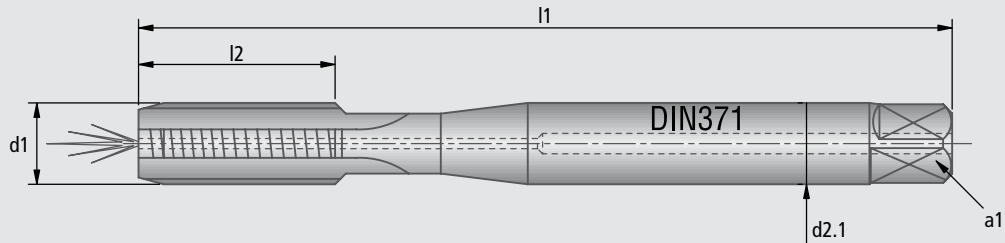
Type		TAREX IK		TAREX IK TiN					
Tolerance field		ISO 2		ISO 2					
Dimensions (DIN)		371 to M10		371 to M10					
		376 from M11		376 from M11					
Material		HSS - E		HSS - E					
Chamfer form		C		C					
Version		uncoated		TiN					
Nominal Ø d1	P	l1	l2	d2.1	a1	d2.2	a2		
									
								Order No.	Order No.
M 4	0,70	63	7,0	4,5	3,4				
M 4,5	0,75	70	7,0	6,0	4,9				
M 5	0,80	70	8,0	6,0	4,9				
M 6	1,00	80	10,0	6,0	4,9			20446001000018	20546001000018
M 7	1,00	80	10,0	7,0	5,5				
M 8	1,25	90	12,0	8,0	6,2			20446001000020	20546001000020
M 9	1,25	90	12,0	9,0	7,0				
M10	1,50	100	14,0	10,0	8,0			20446001000022	20546001000022
M11	1,50	100	14,0			8,0	6,2		
M12	1,75	110	16,0			9,0	7,0	20447001000024	20547001000024
M14	2,00	110	20,0			11,0	9,0		
M16	2,00	110	20,0			12,0	9,0		

M HSS-E Taps with central coolant supply



GG IK, GG IK TiN

For metric ISO thread DIN 13
Cutting material: HSS-E



Type		GG IK		GG IK TiN					
Tolerance field		ISO 2X		ISO 2X					
Dimensions (DIN)		371 to M10		371 to M10					
		376 from M11		376 from M11					
Material		HSS - E		HSS - E					
Chamfer form		C		C					
Version		nitrided		TiN					
Nominal Ø d1	P	l1	l2	d2.1	a1	d2.2	a2		
								Order No.	Order No.
M 4	0,70	63	13,0	4,5	3,4				
M 4,5	0,75	70	15,0	6,0	4,9				
M 5	0,80	70	16,0	6,0	4,9				
M 6	1,00	80	18,0	6,0	4,9			20456001000018	20556001000018
M 7	1,00	80	18,0	7,0	5,5				
M 8	1,25	90	18,0	8,0	6,2			20456001000020	20556001000020
M 9	1,25	90	18,0	9,0	7,0				
M10	1,50	100	21,0	10,0	8,0			20456001000022	20556001000022
M11	1,50	100	21,0			8,0	6,2		
M12	1,75	110	24,0			9,0	7,0	20457001000024	20557001000024
M14	2,00	110	24,0			11,0	9,0		
M16	2,00	110	27,0			12,0	9,0		

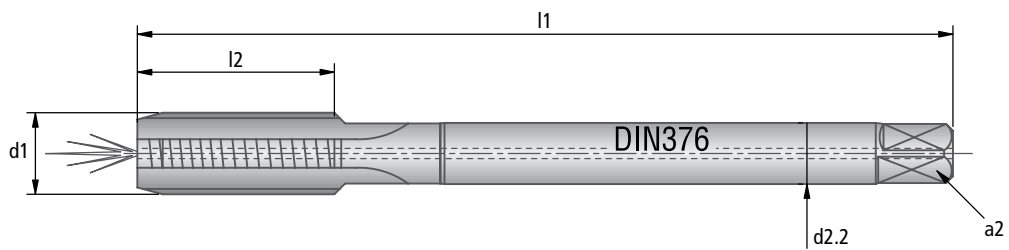
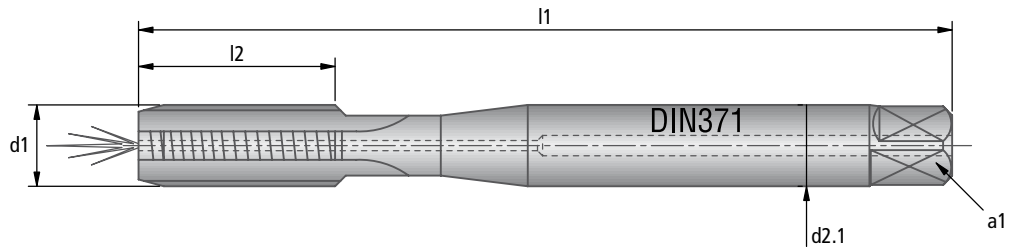
M Solid Carbide Taps

SIREX, GG

For metric ISO thread DIN 13

Cutting material: solid carbide

From nominal Ø M4 with internal coolant supply



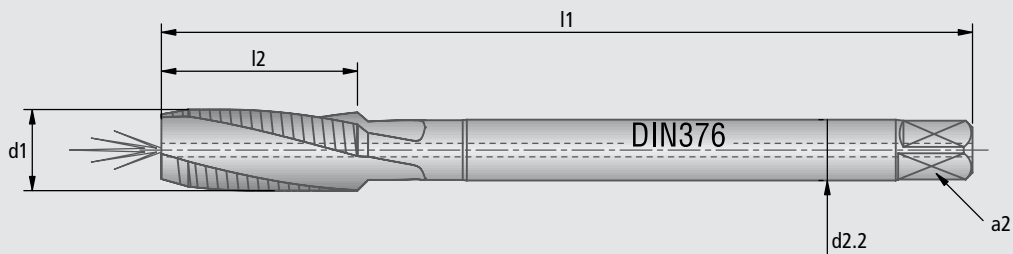
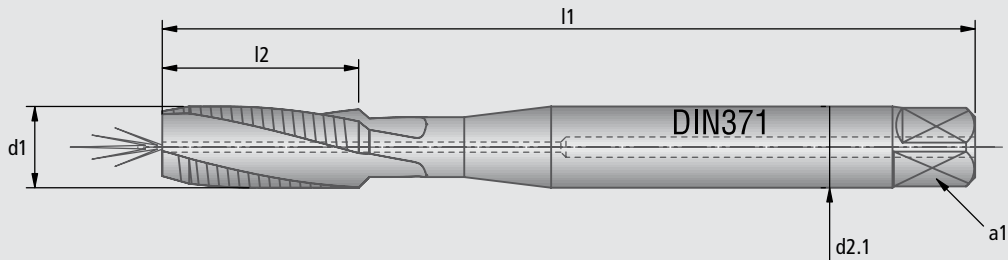
Type		SIREX		GG					
Tolerance field		ISO 2		ISO 2X					
Dimensions (DIN)		371 to M10		371 to M10					
		376 from M11		376 from M11					
Material		solid carbide		solid carbide					
Chamfer form		C		C					
Version		uncoated		uncoated					
Nominal Ø d1	P	l1	l2	d2.1	a1	d2.2	a2		
								Order No.	Order No.
M 3	0,50	56	11,0	3,5	2,7			80420001000013	
M 3,5	0,60	56	13,0	4,0	3,0				
M 4	0,70	63	13,0	4,5	3,4			80420001000015	80456001000015
M 5	0,80	70	16,0	6,0	4,9			80420001000017	80456001000017
M 6	1,00	80	18,0	6,0	4,9			80420001000018	80456001000018
M 7	1,00	80	18,0	7,0	5,5				
M 8	1,25	90	18,0	8,0	6,2			80420001000020	80456001000020
M 9	1,25	90	18,0	9,0	7,0				
M10	1,50	100	21,0	10,0	8,0			80420001000022	80456001000022
M11	1,50	100	21,0			8,0	6,2		
M12	1,75	110	24,0			9,0	7,0	80421001000024	80457001000024
M14	2,00	110	24,0			11,0	9,0		
M16	2,00	110	27,0			12,0	9,0		

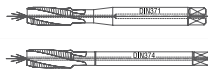
M Solid Carbide Taps



SIREX SR

For metric ISO thread DIN 13
Cutting material: solid carbide
From nominal Ø M4 with internal coolant supply



Type		SIREX SR						
Tolerance field		ISO 2						
Dimensions (DIN)		371 to M10 376 from M11						
Material		solid carbide						
Chamfer form		C						
Version		uncoated						
								
Nominal Ø d1	P	l1	l2	d2.1	a1	d2.2	a2	Order No.
M 3	0,50	56	11,0	3,5	2,7			80444001000013
M 3,5	0,60	56	13,0	4,0	3,0			
M 4	0,70	63	13,0	4,5	3,4			80444001000015
M 5	0,80	70	16,0	6,0	4,9			80444001000017
M 6	1,00	80	18,0	6,0	4,9			80444001000018
M 7	1,00	80	18,0	7,0	5,5			
M 8	1,25	90	18,0	8,0	6,2			80444001000020
M 9	1,25	90	18,0	9,0	7,0			
M10	1,50	100	21,0	10,0	8,0			80444001000022
M11	1,50	100	21,0			8,0	6,2	
M12	1,75	110	24,0			9,0	7,0	80445001000024
M14	2,00	110	24,0			11,0	9,0	
M16	2,00	110	27,0			12,0	9,0	

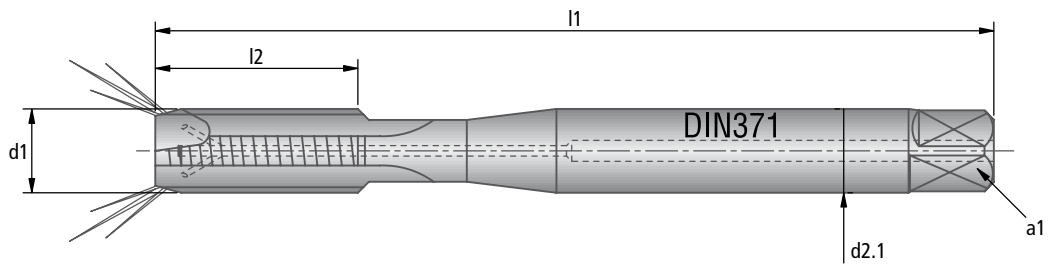
M Solid Carbide Taps

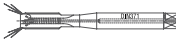
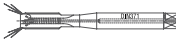
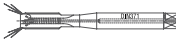
DOREX

For metric ISO thread DIN 13

Cutting material: solid carbide

From nominal Ø M4 with internal coolant supply



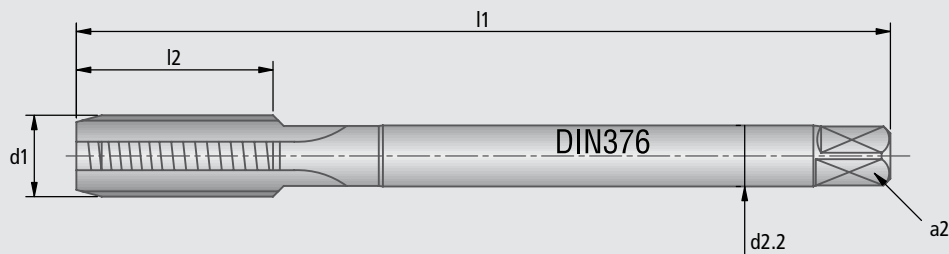
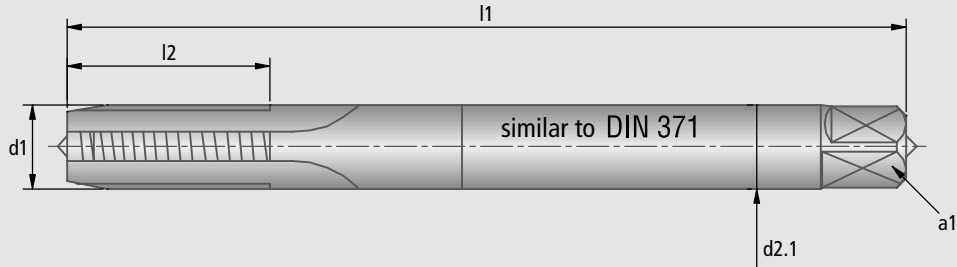
Type								DOREX																																																																																																																															
Tolerance field								ISO 2																																																																																																																															
Dimensions (DIN)								371 to M10																																																																																																																															
								376 from M11																																																																																																																															
Material								solid carbide																																																																																																																															
Chamfer form								B																																																																																																																															
Version								uncoated																																																																																																																															
<table border="1"> <thead> <tr> <th>Nominal Ø d1</th> <th>P</th> <th>l1</th> <th>l2</th> <th>d2.1</th> <th>a1</th> <th>d2.2</th> <th>a2</th> <th rowspan="2">  Order No. </th> </tr> </thead> <tbody> <tr> <td>M 3</td> <td>0,50</td> <td>56</td> <td>11,0</td> <td>3,5</td> <td>2,7</td> <td></td> <td></td> <td></td> </tr> <tr> <td>M 3,5</td> <td>0,60</td> <td>56</td> <td>13,0</td> <td>4,0</td> <td>3,0</td> <td></td> <td></td> <td></td> </tr> <tr> <td>M 4</td> <td>0,70</td> <td>63</td> <td>13,0</td> <td>4,5</td> <td>3,4</td> <td></td> <td></td> <td></td> </tr> <tr> <td>M 5</td> <td>0,80</td> <td>70</td> <td>16,0</td> <td>6,0</td> <td>4,9</td> <td></td> <td></td> <td></td> </tr> <tr> <td>M 6</td> <td>1,00</td> <td>80</td> <td>18,0</td> <td>6,0</td> <td>4,9</td> <td></td> <td></td> <td>80418001000018</td> </tr> <tr> <td>M 7</td> <td>1,00</td> <td>80</td> <td>18,0</td> <td>7,0</td> <td>5,5</td> <td></td> <td></td> <td></td> </tr> <tr> <td>M 8</td> <td>1,25</td> <td>90</td> <td>18,0</td> <td>8,0</td> <td>6,2</td> <td></td> <td></td> <td>80418001000020</td> </tr> <tr> <td>M 9</td> <td>1,25</td> <td>90</td> <td>18,0</td> <td>9,0</td> <td>7,0</td> <td></td> <td></td> <td></td> </tr> <tr> <td>M10</td> <td>1,50</td> <td>100</td> <td>21,0</td> <td>10,0</td> <td>8,0</td> <td></td> <td></td> <td>80418001000022</td> </tr> <tr> <td>M11</td> <td>1,50</td> <td>100</td> <td>21,0</td> <td></td> <td></td> <td>8,0</td> <td>6,2</td> <td></td> </tr> <tr> <td>M12</td> <td>1,75</td> <td>110</td> <td>24,0</td> <td></td> <td></td> <td>9,0</td> <td>7,0</td> <td></td> </tr> <tr> <td>M14</td> <td>2,00</td> <td>110</td> <td>24,0</td> <td></td> <td></td> <td>11,0</td> <td>9,0</td> <td></td> </tr> <tr> <td>M16</td> <td>2,00</td> <td>110</td> <td>27,0</td> <td></td> <td></td> <td>12,0</td> <td>9,0</td> <td></td> </tr> </tbody> </table>								Nominal Ø d1	P	l1	l2	d2.1	a1	d2.2	a2	 Order No.	M 3	0,50	56	11,0	3,5	2,7				M 3,5	0,60	56	13,0	4,0	3,0				M 4	0,70	63	13,0	4,5	3,4				M 5	0,80	70	16,0	6,0	4,9				M 6	1,00	80	18,0	6,0	4,9			80418001000018	M 7	1,00	80	18,0	7,0	5,5				M 8	1,25	90	18,0	8,0	6,2			80418001000020	M 9	1,25	90	18,0	9,0	7,0				M10	1,50	100	21,0	10,0	8,0			80418001000022	M11	1,50	100	21,0			8,0	6,2		M12	1,75	110	24,0			9,0	7,0		M14	2,00	110	24,0			11,0	9,0		M16	2,00	110	27,0			12,0	9,0			
								Nominal Ø d1	P	l1	l2	d2.1	a1	d2.2	a2		 Order No.																																																																																																																						
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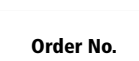
M Solid Carbide Taps

SIREX XH

For metric ISO thread DIN 13
For hard machining from 45 HRC hardness

Cutting material: solid carbide



Type		SIREX XH		SIREX XH					
Tolerance field		ISO 2X		ISO 2X					
Dimensions (DIN)		similar to 371 to M10		similar to 371 to M10					
		376 from M11		376 from M11					
Material		solid carbide		solid carbide					
Hardness		to 58HRC		to 52HRC					
Chamfer form		D		C					
Version		TiAlN		TiAlN					
		 		 					
Nominal Ø d1	P	l1	l2	d2.1	a1	d2.2	a2	Order No.	Order No.
M 3	0,50	56	14,0	3,5	2,7				
M 3,5	0,60	56	18,0	4,0	3,0				
M 4	0,70	63	18,0	4,5	3,4			80126001000015	80128001000015
M 5	0,80	70	20,0	6,0	4,9			80126001000017	80128001000017
M 6	1,00	80	24,0	6,0	4,9			80126001000018	80128001000018
M 7	1,00	80	24,0	7,0	5,5				
M 8	1,25	90	24,0	8,0	6,2			80126001000020	80128001000020
M 9	1,25	90	24,0	9,0	7,0				
M10	1,50	100	26,0	10,0	8,0			80126001000022	80128001000022
M11	1,50	100	26,0			8,0	6,2		
M12	1,75	110	26,0			9,0	7,0	80127001000024	80129001000024
M14	2,00	110	26,0			11,0	9,0	80127001000025	80129001000025
M16	2,00	110	27,0			12,0	9,0	80127001000026	80129001000026

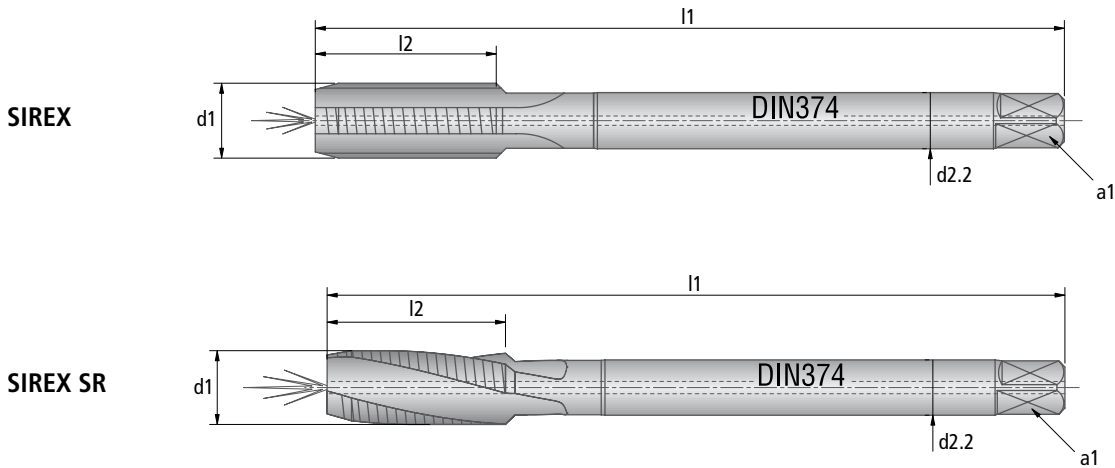
MF Solid Carbide Taps


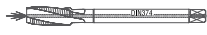
SIREX, SIREX SR

For metric fine ISO thread DIN 13

Cutting material: solid carbide

From nominal Ø M4 with internal coolant supply



Type	SIREX						SIREX SR	
Tolerance field	ISO 2						ISO 2	
Dimensions (DIN)	374						374	
Material	solid carbide						solid carbide	
Chamfer form	C						C	
Version	uncoated						uncoated	
Nominal Ø x P d1								
	l1	l2	d2.1	a1	d2.2	a2	Order No.	Order No.
M 4x0,5	63	10	4,5	3,4			80420002000029	80444002000029
M 5x0,5	70	12	6,0	4,9				
M 6x0,5	80	14	6,0	4,9				
M 6x0,75	80	14	6,0	4,9			80420002000048	80444002000048
M 8x0,5	80	14	8,0	4,9				
M 8x0,75	80	14	8,0	4,9				
M 8x1	90	18	8,0	4,9			80420002000070	80444002000070
M10x0,75	90	14			7,0	5,5		
M10x1	90	18			7,0	5,5	80421002000094	80445002000094
M10x1,25	100	21			7,0	5,5		
M11x1	90	18			8,0	6,2		
M12x1	100	20			9,0	7,0		
M12x1,25	100	20			9,0	7,0		
M12x1,5	100	20			9,0	7,0	80421002000113	80445002000113
M14x1	100	20			11,0	9,0		
M14x1,25	100	20			11,0	9,0		
M14x1,5	100	20			11,0	9,0	80421002000131	80445002000131
M15x1	100	20			12,0	9,0		
M15x1,5	100	20			12,0	9,0		
M16x1	100	20			12,0	9,0		
M16x1,5	100	20			12,0	9,0	80421002000147	80445002000147
M18x1	110	24			14,0	11,0		
M18x1,5	110	24			14,0	11,0		
M20x1,5	125	24			16,0	12,0		

Roll Form Taps and Cut Taps

Roll Form Taps

Chip-less manufacturing by thread forming

Depending on the application in question, we offer the following cutting materials: HSS-E, powder metal and solid carbide.



Roll Form Taps with carbide strips

The combination of elastic tool body and hard carbide strips produce a high degree of bending strength and wear resistance in the tool. This produces extremely long tool life and economic results.

Taps

Chip-producing thread manufacturing

JEL tap drills open up a wide range of applications in the chip-producing thread manufacturing. Whether you choose flood coolant, internal coolant supply, minimal lubrication or dry machining, we can provide the suitable tool.