



Tap AL Fluteless tap AL

No chance for built-up edges & material adhesion

Extra smooth coating
for maximum tool lives

**Whether you are thread tapping or fluteless tapping –
with these aluminium specialists, you can produce
perfect threads at the highest cutting speeds.**

Thanks to the optimum combination of geometry and
coating, almost all aluminium and cast aluminium alloys
can be easily processed with AL taps and fluteless taps.

The new Carbo+ coating prevents built-up edges
and material adhesion – and ensures high durability
and process reliability.

- x **Cycle time** reduced by 25 %
- x **Tool life** increased by 30 %

- X maximum process reliability & tool life thanks to Carbo+ coating
- X fewer built-up edges & less material adhesion
- X high cutting speeds during aluminium machining
- X targeted lubricant distribution through internal cooling with radial coolant ducts



radial coolant ducts
for optimum distribution of the lubricant during fluteless tapping

new Carbo+ coating Cb+ 鍍層 刃口不沾黏 高壽命
ensures long tool lives

M3-M16

adapted solid carbide
for maximum cutting performance

Application example

Component: Connection block pneumatics, EN AW-6063 (AlMg0,7Si)

Tool: #4671 Tap AL, M3

Customer target: Reliable threading with the highest performance in terms of tool life and cycle time

Difficulty: Prevent material adhesion and remove chips reliably

| | | |
|----------------------|----------------|--------------------|
| Cutting data: | Gühring | Competition |
| | v_c 20 m/min | v_c 15 m/min |

| | | |
|-------------------|--------------|--------------|
| Tool life: | 3250 threads | 2500 threads |
|-------------------|--------------|--------------|



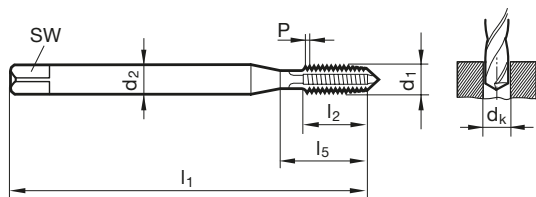
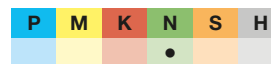
Through-hole thread tap AL

Taps for ISO metric threads

Article no. **8082**



cutting data see page 146



Standard **DIN 371/DIN 376**
Article no. **8082**

Taps

| d1 | P mm | d2 mm | SW mm | dk mm | l1 mm | l2 mm | l5 mm | Standard | Order no. |
|------|---------|----------|----------|----------|----------|----------|----------|----------|-------------|
| M2 | 0.400 | 2.80 | 2.10 | 1.60 | 45.00 | 8.00 | 13.50 | DIN 371 | 8082 2.000 |
| M2,5 | 0.450 | 2.80 | 2.10 | 2.05 | 50.00 | 9.00 | 14.50 | DIN 371 | 8082 2.500 |
| M3 | 0.500 | 3.50 | 2.70 | 2.50 | 56.00 | 10.00 | 18.00 | DIN 371 | 8082 3.000 |
| M4 | 0.700 | 4.50 | 3.40 | 3.30 | 63.00 | 12.00 | 21.00 | DIN 371 | 8082 4.000 |
| M5 | 0.800 | 6.00 | 4.90 | 4.20 | 70.00 | 14.00 | 25.00 | DIN 371 | 8082 5.000 |
| M6 | 1.000 | 6.00 | 4.90 | 5.00 | 80.00 | 16.00 | 30.00 | DIN 371 | 8082 6.000 |
| M8 | 1.250 | 8.00 | 6.20 | 6.80 | 90.00 | 17.00 | 35.00 | DIN 371 | 8082 8.000 |
| M10 | 1.500 | 10.00 | 8.00 | 8.50 | 100.00 | 20.00 | 39.00 | DIN 371 | 8082 10.000 |
| M12 | 1.750 | 9.00 | 7.00 | 10.20 | 110.00 | 24.00 | 49.00 | DIN 376 | 8082 12.000 |
| M14 | 2.000 | 11.00 | 9.00 | 12.00 | 110.00 | 26.00 | 53.00 | DIN 376 | 8082 14.000 |
| M16 | 2.000 | 12.00 | 9.00 | 14.00 | 110.00 | 26.00 | 54.00 | DIN 376 | 8082 16.000 |



Taps with coolant ducts for ISO metric threads

Article no. 8085

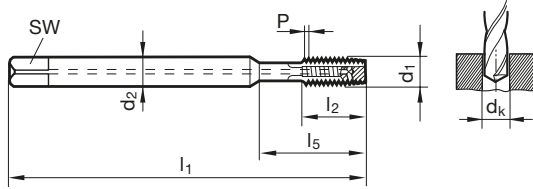


cutting data see page 146



with internal cooling \geq M5

| | | | | | |
|---|---|---|---|---|---|
| P | M | K | N | S | H |
| | | | • | | |



| | | | | | | | | | Standard | DIN 371/DIN 376 |
|-----|-------|-------|------|-------|--------|-------|-------|---------|-------------|-----------------|
| | | | | | | | | | Article no. | 8085 |
| d1 | P | d2 | SW | dk | l1 | l2 | l5 | | | Order no. |
| M3 | 0.500 | 3.50 | 2.70 | 2.50 | 56.00 | 8.00 | 18.00 | DIN 371 | | 8085 3.000 |
| M4 | 0.700 | 4.50 | 3.40 | 3.30 | 63.00 | 10.00 | 21.00 | DIN 371 | | 8085 4.000 |
| M5 | 0.800 | 6.00 | 4.90 | 4.20 | 70.00 | 10.00 | 25.00 | DIN 371 | | 8085 5.000 |
| M6 | 1.000 | 6.00 | 4.90 | 5.00 | 80.00 | 12.00 | 30.00 | DIN 371 | | 8085 6.000 |
| M8 | 1.250 | 8.00 | 6.20 | 6.80 | 90.00 | 16.00 | 35.00 | DIN 371 | | 8085 8.000 |
| M10 | 1.500 | 10.00 | 8.00 | 8.50 | 100.00 | 18.00 | 39.00 | DIN 371 | | 8085 10.000 |
| M12 | 1.750 | 9.00 | 7.00 | 10.20 | 110.00 | 18.00 | 49.00 | DIN 376 | | 8085 12.000 |
| M14 | 2.000 | 11.00 | 9.00 | 12.00 | 110.00 | 20.00 | 53.00 | DIN 376 | | 8085 14.000 |
| M16 | 2.000 | 12.00 | 9.00 | 14.00 | 110.00 | 20.00 | 54.00 | DIN 376 | | 8085 16.000 |

Taps

Taps with coolant ducts for ISO metric threads

Article no. 6575

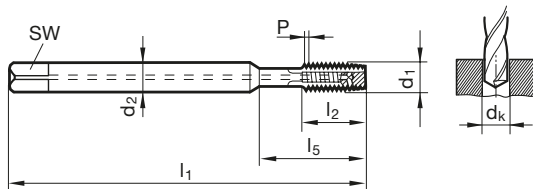


cutting data see page 146



with internal cooling \geq M5 • with internal cooling: radial and axial exits • short cutting form

| | | | | | |
|---|---|---|---|---|---|
| P | M | K | N | S | H |
| | | | • | | |



| | | | | | | | | | Standard | DIN 371/DIN 376 |
|-----|-------|-------|------|-------|--------|-------|-------|---------|-------------|-----------------|
| | | | | | | | | | Article no. | 6575 |
| d1 | P | d2 | SW | dk | l1 | l2 | l5 | | | Order no. |
| M3 | 0.500 | 3.50 | 2.70 | 2.50 | 56.00 | 8.00 | 18.00 | DIN 371 | | 6575 3.000 |
| M4 | 0.700 | 4.50 | 3.40 | 3.30 | 63.00 | 10.00 | 21.00 | DIN 371 | | 6575 4.000 |
| M5 | 0.800 | 6.00 | 4.90 | 4.20 | 70.00 | 10.00 | 25.00 | DIN 371 | | 6575 5.000 |
| M6 | 1.000 | 6.00 | 4.90 | 5.00 | 80.00 | 12.00 | 30.00 | DIN 371 | | 6575 6.000 |
| M8 | 1.250 | 8.00 | 6.20 | 6.80 | 90.00 | 16.00 | 35.00 | DIN 371 | | 6575 8.000 |
| M10 | 1.500 | 10.00 | 8.00 | 8.50 | 100.00 | 18.00 | 39.00 | DIN 371 | | 6575 10.000 |
| M12 | 1.750 | 9.00 | 7.00 | 10.20 | 110.00 | 18.00 | 49.00 | DIN 376 | | 6575 12.000 |
| M14 | 2.000 | 11.00 | 9.00 | 12.00 | 110.00 | 20.00 | 53.00 | DIN 376 | | 6575 14.000 |
| M16 | 2.000 | 12.00 | 9.00 | 14.00 | 110.00 | 20.00 | 54.00 | DIN 376 | | 6575 16.000 |



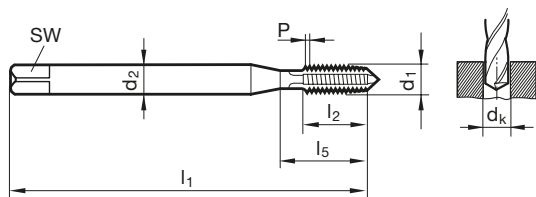
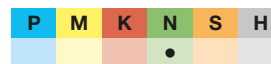
Through-hole thread tap AL

Taps for ISO metric fine threads

Article no. **6555**



cutting data see page 146



Standard
Article no.

DIN 374
6555

Taps

| d1 | P | d2 | SW | dk | l1 | l2 | l5 | Order no. |
|------------|-------|-------|-------|-------|--------|-------|-------|-------------|
| mm | mm | mm | mm | mm | mm | mm | mm | |
| M4 x 0,5 | 0.500 | 2.80 | 2.10 | 3.50 | 63.00 | 8.00 | 21.00 | 6555 4.003 |
| M5 x 0,5 | 0.500 | 3.50 | 2.70 | 4.50 | 70.00 | 10.00 | 25.00 | 6555 5.003 |
| M6 x 0,5 | 0.500 | 4.50 | 3.40 | 5.50 | 80.00 | 13.00 | 30.00 | 6555 6.003 |
| M6 x 0,75 | 0.750 | 4.50 | 3.40 | 5.20 | 80.00 | 13.00 | 30.00 | 6555 6.004 |
| M8 x 1 | 1.000 | 6.00 | 4.90 | 7.00 | 90.00 | 17.00 | 35.00 | 6555 8.005 |
| M10 x 1 | 1.000 | 7.00 | 5.50 | 9.00 | 90.00 | 16.00 | 35.00 | 6555 10.005 |
| M10 x 1,25 | 1.250 | 7.00 | 5.50 | 8.80 | 100.00 | 20.00 | 39.00 | 6555 10.006 |
| M12 x 1 | 1.000 | 9.00 | 7.00 | 11.00 | 100.00 | 20.00 | 40.00 | 6555 12.005 |
| M12 x 1,25 | 1.250 | 9.00 | 7.00 | 10.80 | 100.00 | 20.00 | 40.00 | 6555 12.006 |
| M12 x 1,5 | 1.500 | 9.00 | 7.00 | 10.50 | 100.00 | 20.00 | 40.00 | 6555 12.007 |
| M14 x 1,25 | 1.250 | 11.00 | 9.00 | 12.80 | 100.00 | 20.00 | 40.00 | 6555 14.006 |
| M14 x 1,5 | 1.500 | 11.00 | 9.00 | 12.50 | 100.00 | 20.00 | 40.00 | 6555 14.007 |
| M16 x 1,5 | 1.500 | 12.00 | 9.00 | 14.50 | 100.00 | 22.00 | 44.00 | 6555 16.007 |
| M18 x 1,5 | 1.500 | 14.00 | 11.00 | 16.50 | 110.00 | 25.00 | 44.00 | 6555 18.007 |
| M20 x 1,5 | 1.500 | 16.00 | 12.00 | 18.50 | 125.00 | 25.00 | 44.00 | 6555 20.007 |
| M22 x 1,5 | 1.500 | 18.00 | 14.50 | 20.50 | 125.00 | 25.00 | 44.00 | 6555 22.007 |
| M24 x 1,5 | 1.500 | 18.00 | 14.50 | 22.50 | 140.00 | 28.00 | 48.00 | 6555 24.007 |

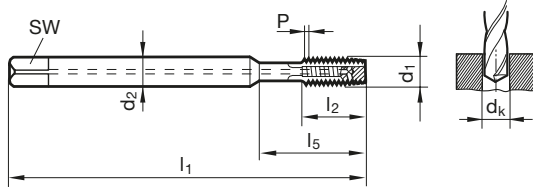


Taps with coolant ducts for ISO metric fine threads

Article no. 6574



cutting data see page 146



| | |
|-------------|-----------------|
| Standard | DIN 371/DIN 374 |
| Article no. | 6574 |

| d1 | P mm | d2 mm | SW mm | dk mm | l1 mm | l2 mm | l5 mm | | Order no. |
|-----------|-------|-------|-------|-------|--------|-------|-------|---------|-------------|
| M8 x 1 | 1.000 | 8.00 | 6.20 | 7.00 | 90.00 | 16.00 | 35.00 | DIN 371 | 6574 8.005 |
| M10 x 1 | 1.000 | 10.00 | 8.00 | 9.00 | 90.00 | 18.00 | 35.00 | DIN 371 | 6574 10.005 |
| M12 x 1,5 | 1.500 | 9.00 | 7.00 | 10.50 | 100.00 | 15.00 | 40.00 | DIN 374 | 6574 12.007 |
| M14 x 1,5 | 1.500 | 11.00 | 9.00 | 12.50 | 100.00 | 15.00 | 40.00 | DIN 374 | 6574 14.007 |
| M16 x 1,5 | 1.500 | 12.00 | 9.00 | 14.50 | 100.00 | 15.00 | 44.00 | DIN 374 | 6574 16.007 |

Taps with coolant ducts for ISO metric fine threads

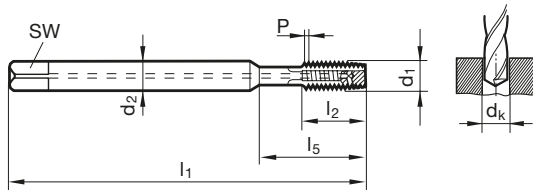
Article no. 6576



cutting data see page 146



with internal cooling: radial and axial exits • short cutting form



| | |
|-------------|-----------------|
| Standard | DIN 371/DIN 374 |
| Article no. | 6576 |

| d1 | P mm | d2 mm | SW mm | dk mm | l1 mm | l2 mm | l5 mm | | Order no. |
|-----------|-------|-------|-------|-------|--------|-------|-------|---------|-------------|
| M8 x 1 | 1.000 | 8.00 | 6.20 | 7.00 | 90.00 | 16.00 | 35.00 | DIN 371 | 6576 8.005 |
| M10 x 1 | 1.000 | 10.00 | 8.00 | 9.00 | 90.00 | 18.00 | 35.00 | DIN 371 | 6576 10.005 |
| M12 x 1,5 | 1.500 | 9.00 | 7.00 | 10.50 | 100.00 | 15.00 | 40.00 | DIN 374 | 6576 12.007 |
| M14 x 1,5 | 1.500 | 11.00 | 9.00 | 12.50 | 100.00 | 15.00 | 40.00 | DIN 374 | 6576 14.007 |
| M16 x 1,5 | 1.500 | 12.00 | 9.00 | 14.50 | 100.00 | 15.00 | 44.00 | DIN 374 | 6576 16.007 |

Taps



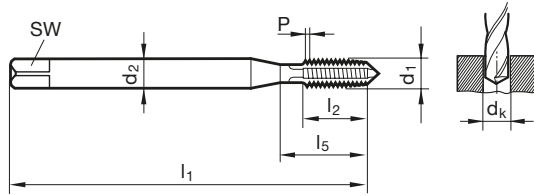
Through-hole thread tap AL

Taps for UNC threads

Article no. **6556**



cutting data see page 146



Standard **DIN 371/DIN 376**
Article no. **6556**

Taps

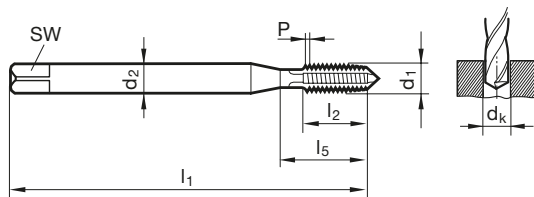
| d1 | P G/inch | d2 mm | SW mm | dk mm | l1 mm | l2 mm | l5 mm | | Order no. |
|-----------|-------------|----------|----------|----------|----------|----------|----------|----------|-------------|
| 2 - 56 | 56 | 2.80 | 2.10 | 1.85 | 45.00 | 9.00 | 14.50 | ~DIN 371 | 6556 2.184 |
| 4 - 40 | 40 | 3.50 | 2.70 | 2.35 | 56.00 | 11.00 | 18.00 | ~DIN 371 | 6556 2.845 |
| 6 - 32 | 32 | 4.00 | 3.00 | 2.85 | 56.00 | 12.00 | 20.00 | ~DIN 371 | 6556 3.505 |
| 8 - 32 | 32 | 4.50 | 3.40 | 3.50 | 63.00 | 12.00 | 21.00 | ~DIN 371 | 6556 4.166 |
| 10 - 24 | 24 | 6.00 | 4.90 | 3.90 | 70.00 | 14.00 | 25.00 | ~DIN 371 | 6556 4.826 |
| 12 - 24 | 24 | 6.00 | 4.90 | 4.50 | 80.00 | 16.00 | 30.00 | ~DIN 371 | 6556 5.486 |
| 1/4 - 20 | 20 | 7.00 | 5.50 | 5.10 | 80.00 | 16.00 | 30.00 | ~DIN 371 | 6556 6.350 |
| 5/16 - 18 | 18 | 8.00 | 6.20 | 6.60 | 90.00 | 18.00 | 35.00 | ~DIN 371 | 6556 7.938 |
| 3/8 - 16 | 16 | 10.00 | 8.00 | 8.00 | 100.00 | 20.00 | 39.00 | ~DIN 371 | 6556 9.525 |
| 7/16 - 14 | 14 | 8.00 | 6.20 | 9.40 | 100.00 | 22.00 | 42.00 | ~DIN 376 | 6556 11.113 |
| 1/2 - 13 | 13 | 9.00 | 7.00 | 10.80 | 110.00 | 25.00 | 49.00 | ~DIN 376 | 6556 12.700 |
| 9/16 - 12 | 12 | 11.00 | 9.00 | 12.20 | 110.00 | 28.00 | 53.00 | ~DIN 376 | 6556 14.288 |
| 5/8 - 11 | 11 | 12.00 | 9.00 | 13.50 | 110.00 | 30.00 | 53.00 | ~DIN 376 | 6556 15.875 |
| 3/4 - 10 | 10 | 14.00 | 11.00 | 16.50 | 125.00 | 33.00 | 62.00 | ~DIN 376 | 6556 19.050 |
| 7/8 - 9 | 9 | 18.00 | 14.50 | 19.50 | 140.00 | 35.00 | 62.00 | ~DIN 376 | 6556 22.225 |
| 1 - 8 | 8 | 18.00 | 14.50 | 22.25 | 160.00 | 38.00 | 73.00 | ~DIN 376 | 6556 25.400 |

Taps for UNF threads

Article no. **6557**



cutting data see page 146



Standard **DIN 371/DIN 374**
Article no. **6557**

| d1 | P G/inch | d2 mm | SW mm | dk mm | l1 mm | l2 mm | l5 mm | | Order no. |
|-----------|-------------|----------|----------|----------|----------|----------|----------|----------|-------------|
| 2 - 64 | 64 | 2.80 | 2.10 | 1.85 | 45.00 | 9.00 | 14.50 | ~DIN 371 | 6557 2.184 |
| 4 - 48 | 48 | 3.50 | 2.70 | 2.40 | 56.00 | 10.00 | 18.00 | ~DIN 371 | 6557 2.845 |
| 6 - 40 | 40 | 4.00 | 3.00 | 2.95 | 56.00 | 11.00 | 20.00 | ~DIN 371 | 6557 3.505 |
| 8 - 36 | 36 | 4.50 | 3.40 | 3.50 | 63.00 | 12.00 | 21.00 | ~DIN 371 | 6557 4.166 |
| 10 - 32 | 32 | 6.00 | 4.90 | 4.10 | 70.00 | 14.00 | 25.00 | ~DIN 371 | 6557 4.826 |
| 12 - 28 | 28 | 6.00 | 4.90 | 4.60 | 80.00 | 16.00 | 30.00 | ~DIN 371 | 6557 5.486 |
| 1/4 - 28 | 28 | 7.00 | 5.50 | 5.50 | 80.00 | 16.00 | 30.00 | ~DIN 371 | 6557 6.350 |
| 5/16 - 24 | 24 | 8.00 | 6.20 | 6.90 | 90.00 | 17.00 | 35.00 | ~DIN 371 | 6557 7.938 |
| 3/8 - 24 | 24 | 10.00 | 8.00 | 8.50 | 90.00 | 18.00 | 35.00 | ~DIN 371 | 6557 9.525 |
| 7/16 - 20 | 20 | 8.00 | 6.20 | 9.90 | 100.00 | 22.00 | 42.00 | ~DIN 374 | 6557 11.113 |
| 1/2 - 20 | 20 | 9.00 | 7.00 | 11.50 | 100.00 | 20.00 | 40.00 | ~DIN 374 | 6557 12.700 |
| 9/16 - 18 | 18 | 11.00 | 9.00 | 12.90 | 100.00 | 22.00 | 40.00 | ~DIN 374 | 6557 14.288 |
| 5/8 - 18 | 18 | 12.00 | 9.00 | 14.50 | 100.00 | 22.00 | 44.00 | ~DIN 374 | 6557 15.875 |
| 3/4 - 16 | 16 | 14.00 | 11.00 | 17.50 | 110.00 | 25.00 | 44.00 | ~DIN 374 | 6557 19.050 |
| 7/8 - 14 | 14 | 18.00 | 14.50 | 20.40 | 125.00 | 25.00 | 44.00 | ~DIN 374 | 6557 22.225 |
| 1 - 12 | 12 | 18.00 | 14.50 | 23.25 | 140.00 | 28.00 | 50.00 | ~DIN 374 | 6557 25.400 |

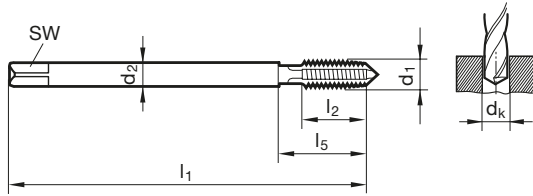


Taps for BSP threads

Article no. 6558



cutting data see page 146



| | | | | | | | | Standard | DIN 5156 |
|-------|-----------|---------|---------|---------|----------|----------|----------|-------------|----------|
| | | | | | | | | Article no. | 6558 |
| d1 | P | d2 | SW | dk | l1 | l2 | l5 | Order no. | |
| G1/16 | 28 G/inch | 6.00 mm | 4.90 mm | 6.80 mm | 90.00 mm | 18.00 mm | 30.00 mm | 6558 7.723 | |
| G1/8 | 28 | 7.00 | 5.50 | 8.80 | 90.00 | 18.00 | 35.00 | 6558 9.728 | |
| G1/4 | 19 | 11.00 | 9.00 | 11.80 | 100.00 | 20.00 | 40.00 | 6558 13.157 | |
| G3/8 | 19 | 12.00 | 9.00 | 15.25 | 100.00 | 22.00 | 44.00 | 6558 16.662 | |
| G1/2 | 14 | 16.00 | 12.00 | 19.00 | 125.00 | 25.00 | 44.00 | 6558 20.955 | |
| G5/8 | 14 | 18.00 | 14.50 | 21.00 | 125.00 | 25.00 | 48.00 | 6558 22.911 | |
| G3/4 | 14 | 20.00 | 16.00 | 24.50 | 140.00 | 28.00 | 53.00 | 6558 26.441 | |
| G7/8 | 14 | 22.00 | 18.00 | 28.25 | 150.00 | 28.00 | 53.00 | 6558 30.201 | |
| G1 | 11 | 25.00 | 20.00 | 30.75 | 160.00 | 30.00 | 56.00 | 6558 33.249 | |

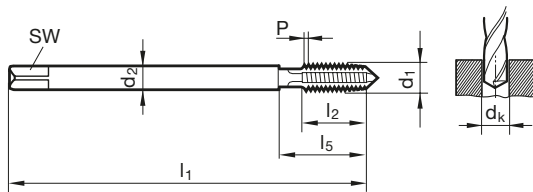
Taps

Tap for EG/STI thread

Article no. 6559



cutting data see page 146



| | | | | | | | | Standard | DIN 40435 |
|-------------|----------|---------|---------|---------|----------|---------|----------|-------------|-----------|
| | | | | | | | | Article no. | 6559 |
| d1 | P | d2 | SW | dk | l1 | l2 | l5 | Order no. | |
| EG/STI M2 | 0.400 mm | 2.80 mm | 2.10 mm | 2.10 mm | 50.00 mm | 9.00 mm | 14.00 mm | 6559 2.000 | |
| EG/STI M2,5 | 0.450 | 3.50 | 2.70 | 2.65 | 56.00 | 10.00 | 18.00 | 6559 2.500 | |
| EG/STI M3 | 0.500 | 4.50 | 3.40 | 3.15 | 63.00 | 12.00 | 21.00 | 6559 3.000 | |
| EG/STI M4 | 0.700 | 6.00 | 4.90 | 4.20 | 70.00 | 12.00 | 25.00 | 6559 4.000 | |
| EG/STI M5 | 0.800 | 6.00 | 4.90 | 5.25 | 80.00 | 14.00 | 30.00 | 6559 5.000 | |
| EG/STI M6 | 1.000 | 8.00 | 6.20 | 6.30 | 90.00 | 17.00 | 35.00 | 6559 6.000 | |
| EG/STI M8 | 1.250 | 10.00 | 8.00 | 8.40 | 100.00 | 20.00 | 39.00 | 6559 8.000 | |
| EG/STI M10 | 1.500 | 9.00 | 7.00 | 10.50 | 100.00 | 20.00 | 40.00 | 6559 10.000 | |
| EG/STI M12 | 1.750 | 11.00 | 9.00 | 12.50 | 110.00 | 28.00 | 53.00 | 6559 12.000 | |
| EG/STI M14 | 2.000 | 12.00 | 9.00 | 14.50 | 110.00 | 26.00 | 54.00 | 6559 14.000 | |
| EG/STI M16 | 2.000 | 14.00 | 11.00 | 16.50 | 125.00 | 33.00 | 62.00 | 6559 16.000 | |



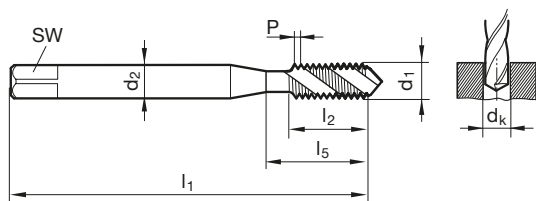
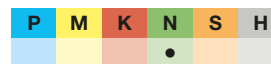
Blind hole thread tap AL

Taps for ISO metric threads

Article no. **8080**



cutting data see page 146



Standard **DIN 371/DIN 376**
Article no. **8080**

Taps

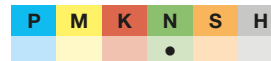
| d1 | P mm | d2 mm | SW mm | dk mm | l1 mm | l2 mm | l5 mm | Standard | Order no. |
|------|-------|-------|-------|-------|--------|-------|-------|----------|-------------|
| M2 | 0.400 | 2.80 | 2.10 | 1.60 | 45.00 | 4.50 | 13.50 | DIN 371 | 8080 2.000 |
| M2,5 | 0.450 | 2.80 | 2.10 | 2.05 | 50.00 | 5.00 | 14.50 | DIN 371 | 8080 2.500 |
| M3 | 0.500 | 3.50 | 2.70 | 2.50 | 56.00 | 6.00 | 18.00 | DIN 371 | 8080 3.000 |
| M4 | 0.700 | 4.50 | 3.40 | 3.30 | 63.00 | 7.50 | 21.00 | DIN 371 | 8080 4.000 |
| M5 | 0.800 | 6.00 | 4.90 | 4.20 | 70.00 | 8.50 | 25.00 | DIN 371 | 8080 5.000 |
| M6 | 1.000 | 6.00 | 4.90 | 5.00 | 80.00 | 11.00 | 30.00 | DIN 371 | 8080 6.000 |
| M8 | 1.250 | 8.00 | 6.20 | 6.80 | 90.00 | 14.00 | 35.00 | DIN 371 | 8080 8.000 |
| M10 | 1.500 | 10.00 | 8.00 | 8.50 | 100.00 | 16.00 | 39.00 | DIN 371 | 8080 10.000 |
| M12 | 1.750 | 9.00 | 7.00 | 10.20 | 110.00 | 18.50 | 49.00 | DIN 376 | 8080 12.000 |
| M14 | 2.000 | 11.00 | 9.00 | 12.00 | 110.00 | 20.00 | 53.00 | DIN 376 | 8080 14.000 |
| M16 | 2.000 | 12.00 | 9.00 | 14.00 | 110.00 | 20.00 | 54.00 | DIN 376 | 8080 16.000 |

Taps for ISO metric threads

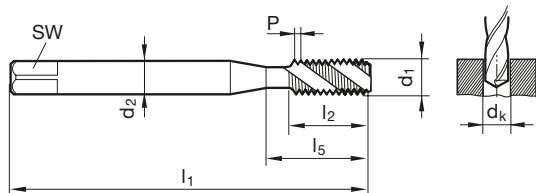
Article no. **8081**



cutting data see page 146



short cutting form



Standard **DIN 371/DIN 376**
Article no. **8081**

| d1 | P mm | d2 mm | SW mm | dk mm | l1 mm | l2 mm | l5 mm | Standard | Order no. |
|------|-------|-------|-------|-------|--------|-------|-------|----------|-------------|
| M2 | 0.400 | 2.80 | 2.10 | 1.60 | 45.00 | 4.50 | 13.50 | DIN 371 | 8081 2.000 |
| M2,5 | 0.450 | 2.80 | 2.10 | 2.05 | 50.00 | 5.00 | 14.50 | DIN 371 | 8081 2.500 |
| M3 | 0.500 | 3.50 | 2.70 | 2.50 | 56.00 | 6.00 | 18.00 | DIN 371 | 8081 3.000 |
| M4 | 0.700 | 4.50 | 3.40 | 3.30 | 63.00 | 7.50 | 21.00 | DIN 371 | 8081 4.000 |
| M5 | 0.800 | 6.00 | 4.90 | 4.20 | 70.00 | 8.50 | 25.00 | DIN 371 | 8081 5.000 |
| M6 | 1.000 | 6.00 | 4.90 | 5.00 | 80.00 | 11.00 | 30.00 | DIN 371 | 8081 6.000 |
| M8 | 1.250 | 8.00 | 6.20 | 6.80 | 90.00 | 14.00 | 35.00 | DIN 371 | 8081 8.000 |
| M10 | 1.500 | 10.00 | 8.00 | 8.50 | 100.00 | 16.00 | 39.00 | DIN 371 | 8081 10.000 |
| M12 | 1.750 | 9.00 | 7.00 | 10.20 | 110.00 | 18.50 | 49.00 | DIN 376 | 8081 12.000 |
| M14 | 2.000 | 11.00 | 9.00 | 12.00 | 110.00 | 20.00 | 53.00 | DIN 376 | 8081 14.000 |
| M16 | 2.000 | 12.00 | 9.00 | 14.00 | 110.00 | 20.00 | 54.00 | DIN 376 | 8081 16.000 |

Taps for ISO metric threads

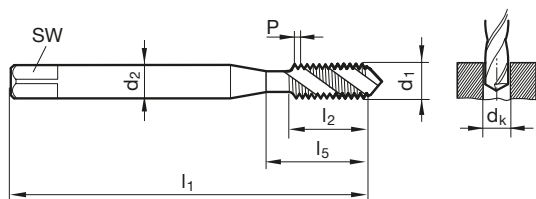
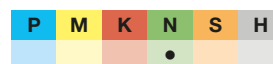
Article no. 6565



cutting data see page 146



with extra-long shank



| | | | | | | | | Standard | Company std. |
|-----|-------|-------|-------|-------|--------|-------|--------|-------------|--------------|
| | | | | | | | | Article no. | 6565 |
| d1 | P | d2 | SW | dk | l1 | l2 | l5 | Order no. | |
| M3 | 0.500 | 3.50 | 2.70 | 2.50 | 90.00 | 6.00 | 18.00 | 6565 3.000 | |
| M4 | 0.700 | 4.50 | 3.40 | 3.30 | 125.00 | 7.50 | 21.00 | 6565 4.000 | |
| M5 | 0.800 | 6.00 | 4.90 | 4.20 | 140.00 | 8.50 | 25.00 | 6565 5.000 | |
| M6 | 1.000 | 6.00 | 4.90 | 5.00 | 160.00 | 11.00 | 30.00 | 6565 6.000 | |
| M8 | 1.250 | 8.00 | 6.20 | 6.80 | 180.00 | 14.00 | 35.00 | 6565 8.010 | |
| M10 | 1.500 | 10.00 | 8.00 | 8.50 | 200.00 | 16.00 | 39.00 | 6565 10.010 | |
| M12 | 1.750 | 9.00 | 7.00 | 10.20 | 220.00 | 18.50 | 158.00 | 6565 12.000 | |
| M14 | 2.000 | 11.00 | 9.00 | 12.00 | 220.00 | 20.00 | 160.00 | 6565 14.000 | |
| M16 | 2.000 | 12.00 | 9.00 | 14.00 | 220.00 | 20.00 | 160.00 | 6565 16.000 | |
| M20 | 2.500 | 16.00 | 12.00 | 17.50 | 280.00 | 25.00 | 217.00 | 6565 20.000 | |

Taps



Blind hole thread tap AL

Taps with coolant ducts for ISO metric threads

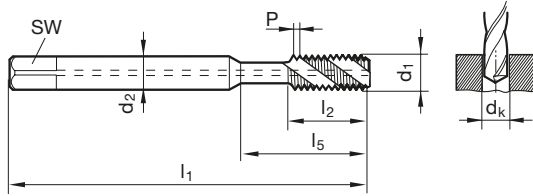
Article no. **8083**



cutting data see page 146



with internal cooling \geq M5



Standard **DIN 371/DIN 376**
Article no. **8083**

Taps

| d1 | P mm | d2 mm | SW mm | dk mm | l1 mm | l2 mm | l5 mm | Standard | Order no. |
|-----|-------|-------|-------|-------|--------|-------|-------|----------|-------------|
| M3 | 0.500 | 3.50 | 2.70 | 2.50 | 56.00 | 8.00 | 18.00 | DIN 371 | 8083 3.000 |
| M4 | 0.700 | 4.50 | 3.40 | 3.30 | 63.00 | 10.00 | 21.00 | DIN 371 | 8083 4.000 |
| M5 | 0.800 | 6.00 | 4.90 | 4.20 | 70.00 | 10.00 | 25.00 | DIN 371 | 8083 5.000 |
| M6 | 1.000 | 6.00 | 4.90 | 5.00 | 80.00 | 12.00 | 30.00 | DIN 371 | 8083 6.000 |
| M8 | 1.250 | 8.00 | 6.20 | 6.80 | 90.00 | 16.00 | 35.00 | DIN 371 | 8083 8.000 |
| M10 | 1.500 | 10.00 | 8.00 | 8.50 | 100.00 | 18.00 | 39.00 | DIN 371 | 8083 10.000 |
| M12 | 1.750 | 9.00 | 7.00 | 10.20 | 110.00 | 18.00 | 49.00 | DIN 376 | 8083 12.000 |
| M14 | 2.000 | 11.00 | 9.00 | 12.00 | 110.00 | 20.00 | 53.00 | DIN 376 | 8083 14.000 |
| M16 | 2.000 | 12.00 | 9.00 | 14.00 | 110.00 | 20.00 | 54.00 | DIN 376 | 8083 16.000 |

Taps with coolant ducts for ISO metric threads

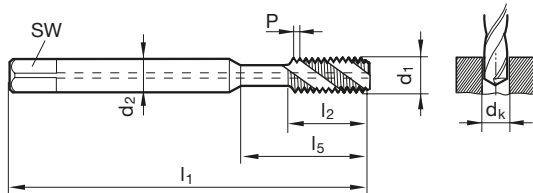
Article no. **8084**



cutting data see page 146



short cutting form • with internal cooling \geq M5



Standard **DIN 371/DIN 376**
Article no. **8084**

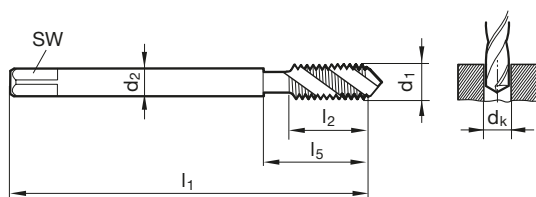
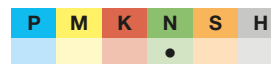
| d1 | P mm | d2 mm | SW mm | dk mm | l1 mm | l2 mm | l5 mm | Standard | Order no. |
|-----|-------|-------|-------|-------|--------|-------|-------|----------|-------------|
| M3 | 0.500 | 3.50 | 2.70 | 2.50 | 56.00 | 8.00 | 18.00 | DIN 371 | 8084 3.000 |
| M4 | 0.700 | 4.50 | 3.40 | 3.30 | 63.00 | 10.00 | 21.00 | DIN 371 | 8084 4.000 |
| M5 | 0.800 | 6.00 | 4.90 | 4.20 | 70.00 | 10.00 | 25.00 | DIN 371 | 8084 5.000 |
| M6 | 1.000 | 6.00 | 4.90 | 5.00 | 80.00 | 12.00 | 30.00 | DIN 371 | 8084 6.000 |
| M8 | 1.250 | 8.00 | 6.20 | 6.80 | 90.00 | 16.00 | 35.00 | DIN 371 | 8084 8.000 |
| M10 | 1.500 | 10.00 | 8.00 | 8.50 | 100.00 | 18.00 | 39.00 | DIN 371 | 8084 10.000 |
| M12 | 1.750 | 9.00 | 7.00 | 10.20 | 110.00 | 18.00 | 49.00 | DIN 376 | 8084 12.000 |
| M14 | 2.000 | 11.00 | 9.00 | 12.00 | 110.00 | 20.00 | 53.00 | DIN 376 | 8084 14.000 |
| M16 | 2.000 | 12.00 | 9.00 | 14.00 | 110.00 | 20.00 | 54.00 | DIN 376 | 8084 16.000 |

Taps for ISO metric fine threads

Article no. 6560



cutting data see page 146



Standard

DIN 374

Article no.

6560

| d1 | P | d2 | SW | dk | l1 | l2 | l5 | Order no. |
|------------|-------|-------|-------|-------|--------|-------|-------|-------------|
| M4 x 0,5 | 0.500 | 2.80 | 2.10 | 3.50 | 63.00 | 5.00 | 21.00 | 6560 4.003 |
| M5 x 0,5 | 0.500 | 3.50 | 2.70 | 4.50 | 70.00 | 5.00 | 25.00 | 6560 5.003 |
| M6 x 0,5 | 0.500 | 4.50 | 3.40 | 5.50 | 80.00 | 5.00 | 30.00 | 6560 6.003 |
| M6 x 0,75 | 0.750 | 4.50 | 3.40 | 5.20 | 80.00 | 8.00 | 30.00 | 6560 6.004 |
| M8 x 1 | 1.000 | 6.00 | 4.90 | 7.00 | 90.00 | 11.00 | 35.00 | 6560 8.005 |
| M10 x 1 | 1.000 | 7.00 | 5.50 | 9.00 | 90.00 | 11.00 | 35.00 | 6560 10.005 |
| M10 x 1,25 | 1.250 | 7.00 | 5.50 | 8.80 | 100.00 | 14.00 | 39.00 | 6560 10.006 |
| M12 x 1 | 1.000 | 9.00 | 7.00 | 11.00 | 100.00 | 11.00 | 40.00 | 6560 12.005 |
| M12 x 1,25 | 1.250 | 9.00 | 7.00 | 10.80 | 100.00 | 15.00 | 40.00 | 6560 12.006 |
| M12 x 1,5 | 1.500 | 9.00 | 7.00 | 10.50 | 100.00 | 15.00 | 40.00 | 6560 12.007 |
| M14 x 1,25 | 1.250 | 11.00 | 9.00 | 12.80 | 100.00 | 15.00 | 40.00 | 6560 14.006 |
| M14 x 1,5 | 1.500 | 11.00 | 9.00 | 12.50 | 100.00 | 15.00 | 40.00 | 6560 14.007 |
| M16 x 1,5 | 1.500 | 12.00 | 9.00 | 14.50 | 100.00 | 15.00 | 44.00 | 6560 16.007 |
| M18 x 1,5 | 1.500 | 14.00 | 11.00 | 16.50 | 110.00 | 16.00 | 44.00 | 6560 18.007 |
| M20 x 1,5 | 1.500 | 16.00 | 12.00 | 18.50 | 125.00 | 16.00 | 44.00 | 6560 20.007 |
| M22 x 1,5 | 1.500 | 18.00 | 14.50 | 20.50 | 125.00 | 16.00 | 44.00 | 6560 22.007 |
| M24 x 1,5 | 1.500 | 18.00 | 14.50 | 22.50 | 140.00 | 16.00 | 48.00 | 6560 24.007 |

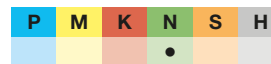
Taps

Taps for ISO metric fine threads

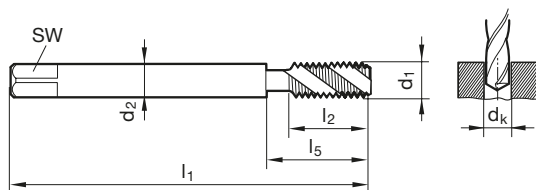
Article no. 6568



cutting data see page 146



short cutting form



Standard

DIN 374

Article no.

6568

| d1 | P | d2 | SW | dk | l1 | l2 | l5 | Order no. |
|------------|-------|-------|-------|-------|--------|-------|-------|-------------|
| M6 x 0,75 | 0.750 | 4.50 | 3.40 | 5.20 | 80.00 | 8.00 | 30.00 | 6568 6.004 |
| M8 x 0,75 | 0.750 | 6.00 | 4.90 | 7.20 | 80.00 | 8.00 | 30.00 | 6568 8.004 |
| M8 x 1 | 1.000 | 6.00 | 4.90 | 7.00 | 90.00 | 11.00 | 35.00 | 6568 8.005 |
| M10 x 1 | 1.000 | 7.00 | 5.50 | 9.00 | 90.00 | 11.00 | 35.00 | 6568 10.005 |
| M10 x 1,25 | 1.250 | 7.00 | 5.50 | 8.80 | 100.00 | 14.00 | 39.00 | 6568 10.006 |
| M12 x 1 | 1.000 | 9.00 | 7.00 | 11.00 | 100.00 | 11.00 | 40.00 | 6568 12.005 |
| M12 x 1,25 | 1.250 | 9.00 | 7.00 | 10.80 | 100.00 | 15.00 | 40.00 | 6568 12.006 |
| M14 x 1,5 | 1.500 | 11.00 | 9.00 | 12.50 | 100.00 | 15.00 | 40.00 | 6568 14.007 |
| M16 x 1,5 | 1.500 | 12.00 | 9.00 | 14.50 | 100.00 | 15.00 | 44.00 | 6568 16.007 |
| M18 x 1,5 | 1.500 | 14.00 | 11.00 | 16.50 | 110.00 | 16.00 | 44.00 | 6568 18.007 |
| M20 x 1,5 | 1.500 | 16.00 | 12.00 | 18.50 | 125.00 | 16.00 | 44.00 | 6568 20.007 |
| M24 x 1,5 | 1.500 | 18.00 | 14.50 | 22.50 | 140.00 | 16.00 | 48.00 | 6568 24.007 |



Blind hole thread tap AL

Taps for ISO metric fine threads

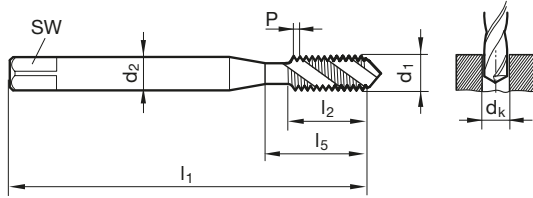
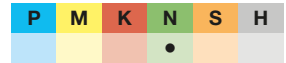
Article no. **6566**



cutting data see page 146



with extra-long shank



Standard **Company std.**
Article no. **6566**

| d1 | P | d2 | SW | dk | l1 | l2 | l5 | Order no. |
|-----------|-------|-------|-------|-------|--------|-------|--------|-------------|
| M8 x 1 | 1.000 | 6.00 | 4.90 | 7.00 | 180.00 | 14.00 | 120.00 | 6566 8.005 |
| M10 x 1 | 1.000 | 7.00 | 5.50 | 9.00 | 200.00 | 16.00 | 140.00 | 6566 10.005 |
| M12 x 1,5 | 1.500 | 9.00 | 7.00 | 10.50 | 220.00 | 18.50 | 158.00 | 6566 12.007 |
| M14 x 1,5 | 1.500 | 11.00 | 9.00 | 12.50 | 220.00 | 20.00 | 160.00 | 6566 14.007 |
| M16 x 1,5 | 1.500 | 12.00 | 9.00 | 14.50 | 220.00 | 20.00 | 160.00 | 6566 16.007 |
| M20 x 1,5 | 1.500 | 16.00 | 12.00 | 18.50 | 280.00 | 25.00 | 217.00 | 6566 20.007 |

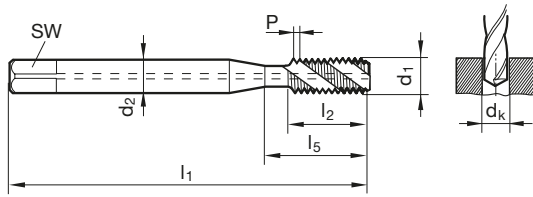
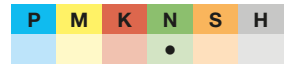
Taps

Taps with coolant ducts for ISO metric fine threads

Article no. **6577**



cutting data see page 146



Standard **DIN 371/DIN 374**
Article no. **6577**

| d1 | P | d2 | SW | dk | l1 | l2 | l5 | Order no. |
|-----------|-------|-------|------|-------|--------|-------|-------|-------------|
| M8 x 1 | 1.000 | 8.00 | 6.20 | 7.00 | 90.00 | 16.00 | 35.00 | 6577 8.005 |
| M10 x 1 | 1.000 | 10.00 | 8.00 | 9.00 | 90.00 | 18.00 | 35.00 | 6577 10.005 |
| M12 x 1,5 | 1.500 | 9.00 | 7.00 | 10.50 | 100.00 | 15.00 | 40.00 | 6577 12.007 |
| M14 x 1,5 | 1.500 | 11.00 | 9.00 | 12.50 | 100.00 | 15.00 | 40.00 | 6577 14.007 |
| M16 x 1,5 | 1.500 | 12.00 | 9.00 | 14.50 | 100.00 | 15.00 | 44.00 | 6577 16.007 |

Taps with coolant ducts for ISO metric fine threads

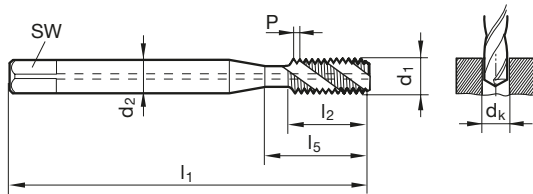
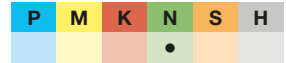
Article no. **6578**



cutting data see page 146



short cutting form



Standard **DIN 371/DIN 374**
Article no. **6578**

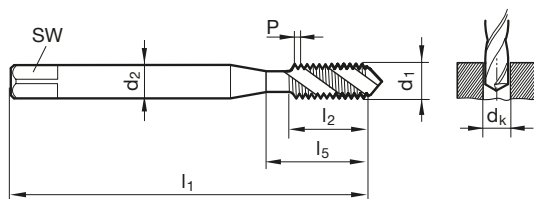
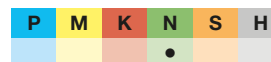
| d1 | P | d2 | SW | dk | l1 | l2 | l5 | Order no. |
|-----------|-------|-------|------|-------|--------|-------|-------|-------------|
| M8 x 1 | 1.000 | 8.00 | 6.20 | 7.00 | 90.00 | 16.00 | 35.00 | 6578 8.005 |
| M10 x 1 | 1.000 | 10.00 | 8.00 | 9.00 | 90.00 | 18.00 | 35.00 | 6578 10.005 |
| M12 x 1,5 | 1.500 | 9.00 | 7.00 | 10.50 | 100.00 | 15.00 | 40.00 | 6578 12.007 |
| M14 x 1,5 | 1.500 | 11.00 | 9.00 | 12.50 | 100.00 | 15.00 | 40.00 | 6578 14.007 |
| M16 x 1,5 | 1.500 | 12.00 | 9.00 | 14.50 | 100.00 | 15.00 | 44.00 | 6578 16.007 |

Taps for UNC threads

Article no. 6561



cutting data see page 146

Standard **DIN 371/DIN 376**
Article no. **6561**

| d1 | P G/inch | d2 mm | SW mm | dk mm | l1 mm | l2 mm | l5 mm | | Order no. |
|-----------|-------------|----------|----------|----------|----------|----------|----------|----------|-------------|
| 2 - 56 | 56 | 2.80 | 2.10 | 1.85 | 45.00 | 5.00 | 14.50 | ~DIN 371 | 6561 2.184 |
| 4 - 40 | 40 | 3.50 | 2.70 | 2.35 | 56.00 | 7.00 | 18.00 | ~DIN 371 | 6561 2.845 |
| 6 - 32 | 32 | 4.00 | 3.00 | 2.85 | 56.00 | 8.00 | 20.00 | ~DIN 371 | 6561 3.505 |
| 8 - 32 | 32 | 4.50 | 3.40 | 3.50 | 63.00 | 8.00 | 21.00 | ~DIN 371 | 6561 4.166 |
| 10 - 24 | 24 | 6.00 | 4.90 | 3.90 | 70.00 | 11.00 | 25.00 | ~DIN 371 | 6561 4.826 |
| 12 - 24 | 24 | 6.00 | 4.90 | 4.50 | 80.00 | 11.00 | 30.00 | ~DIN 371 | 6561 5.486 |
| 1/4 - 20 | 20 | 7.00 | 5.50 | 5.10 | 80.00 | 13.00 | 30.00 | ~DIN 371 | 6561 6.350 |
| 5/16 - 18 | 18 | 8.00 | 6.20 | 6.60 | 90.00 | 14.00 | 35.00 | ~DIN 371 | 6561 7.938 |
| 3/8 - 16 | 16 | 10.00 | 8.00 | 8.00 | 100.00 | 16.00 | 39.00 | ~DIN 371 | 6561 9.525 |
| 7/16 - 14 | 14 | 8.00 | 6.20 | 9.40 | 100.00 | 18.00 | 42.00 | ~DIN 376 | 6561 11.113 |
| 1/2 - 13 | 13 | 9.00 | 7.00 | 10.80 | 110.00 | 20.00 | 49.00 | ~DIN 376 | 6561 12.700 |
| 9/16 - 12 | 12 | 11.00 | 9.00 | 12.20 | 110.00 | 21.00 | 53.00 | ~DIN 376 | 6561 14.288 |
| 5/8 - 11 | 11 | 12.00 | 9.00 | 13.50 | 110.00 | 24.00 | 53.00 | ~DIN 376 | 6561 15.875 |
| 3/4 - 10 | 10 | 14.00 | 11.00 | 16.50 | 125.00 | 25.00 | 62.00 | ~DIN 376 | 6561 19.050 |
| 7/8 - 9 | 9 | 18.00 | 14.50 | 19.50 | 140.00 | 28.00 | 62.00 | ~DIN 376 | 6561 22.225 |
| 1 - 8 | 8 | 18.00 | 14.50 | 22.25 | 160.00 | 32.00 | 73.00 | ~DIN 376 | 6561 25.400 |

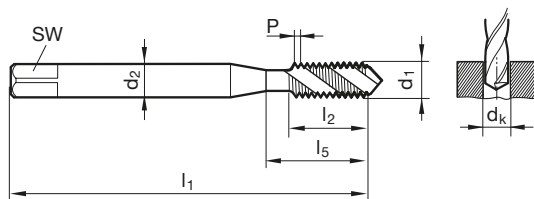
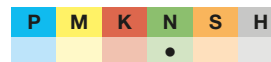
Taps

Taps for UNF threads

Article no. 6562



cutting data see page 146

Standard **DIN 371/DIN 374**
Article no. **6562**

| d1 | P G/inch | d2 mm | SW mm | dk mm | l1 mm | l2 mm | l5 mm | | Order no. |
|-----------|-------------|----------|----------|----------|----------|----------|----------|----------|-------------|
| 2 - 64 | 64 | 2.80 | 2.10 | 1.85 | 45.00 | 5.00 | 14.50 | ~DIN 371 | 6562 2.184 |
| 4 - 48 | 48 | 3.50 | 2.70 | 2.40 | 56.00 | 6.00 | 18.00 | ~DIN 371 | 6562 2.845 |
| 6 - 40 | 40 | 4.00 | 3.00 | 2.95 | 56.00 | 6.50 | 20.00 | ~DIN 371 | 6562 3.505 |
| 8 - 36 | 36 | 4.50 | 3.40 | 3.50 | 63.00 | 7.00 | 21.00 | ~DIN 371 | 6562 4.166 |
| 10 - 32 | 32 | 6.00 | 4.90 | 4.10 | 70.00 | 8.50 | 25.00 | ~DIN 371 | 6562 4.826 |
| 12 - 28 | 28 | 6.00 | 4.90 | 4.60 | 80.00 | 9.50 | 30.00 | ~DIN 371 | 6562 5.486 |
| 1/4 - 28 | 28 | 7.00 | 5.50 | 5.50 | 80.00 | 9.50 | 30.00 | ~DIN 371 | 6562 6.350 |
| 5/16 - 24 | 24 | 8.00 | 6.20 | 6.90 | 90.00 | 11.50 | 35.00 | ~DIN 371 | 6562 7.938 |
| 3/8 - 24 | 24 | 10.00 | 8.00 | 8.50 | 90.00 | 11.50 | 35.00 | ~DIN 371 | 6562 9.525 |
| 7/16 - 20 | 20 | 8.00 | 6.20 | 9.90 | 100.00 | 13.00 | 42.00 | ~DIN 374 | 6562 11.113 |
| 1/2 - 20 | 20 | 9.00 | 7.00 | 11.50 | 100.00 | 13.00 | 40.00 | ~DIN 374 | 6562 12.700 |
| 9/16 - 18 | 18 | 11.00 | 9.00 | 12.90 | 100.00 | 14.00 | 40.00 | ~DIN 374 | 6562 14.288 |
| 5/8 - 18 | 18 | 12.00 | 9.00 | 14.50 | 100.00 | 15.00 | 44.00 | ~DIN 374 | 6562 15.875 |
| 3/4 - 16 | 16 | 14.00 | 11.00 | 17.50 | 110.00 | 16.00 | 44.00 | ~DIN 374 | 6562 19.050 |
| 7/8 - 14 | 14 | 18.00 | 14.50 | 20.40 | 125.00 | 19.00 | 44.00 | ~DIN 374 | 6562 22.225 |
| 1 - 12 | 12 | 18.00 | 14.50 | 23.25 | 140.00 | 22.00 | 50.00 | ~DIN 374 | 6562 25.400 |

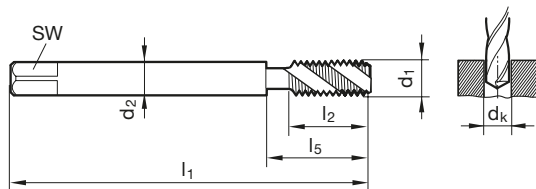
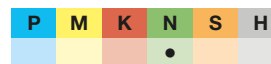


Taps for BSP threads

Article no. **6563**



cutting data see page 146



Standard **DIN 5156**
Article no. **6563**

| d1 | P G/inch | d2 mm | SW mm | dk mm | l1 mm | l2 mm | l5 mm | Order no. |
|-------|-------------|----------|----------|----------|----------|----------|----------|-------------|
| G1/16 | 28 | 6.00 | 4.90 | 6.80 | 90.00 | 11.00 | 30.00 | 6563 7.723 |
| G1/8 | 28 | 7.00 | 5.50 | 8.80 | 90.00 | 11.00 | 35.00 | 6563 9.728 |
| G1/4 | 19 | 11.00 | 9.00 | 11.80 | 100.00 | 14.00 | 40.00 | 6563 13.157 |
| G3/8 | 19 | 12.00 | 9.00 | 15.25 | 100.00 | 14.00 | 44.00 | 6563 16.662 |
| G1/2 | 14 | 16.00 | 12.00 | 19.00 | 125.00 | 18.00 | 44.00 | 6563 20.955 |
| G5/8 | 14 | 18.00 | 14.50 | 21.00 | 125.00 | 18.00 | 48.00 | 6563 22.911 |
| G3/4 | 14 | 20.00 | 16.00 | 24.50 | 140.00 | 20.00 | 53.00 | 6563 26.441 |
| G7/8 | 14 | 22.00 | 18.00 | 28.25 | 150.00 | 22.00 | 53.00 | 6563 30.201 |
| G1 | 11 | 25.00 | 20.00 | 30.75 | 160.00 | 24.00 | 56.00 | 6563 33.249 |

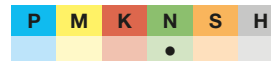
Taps

Taps for BSP threads

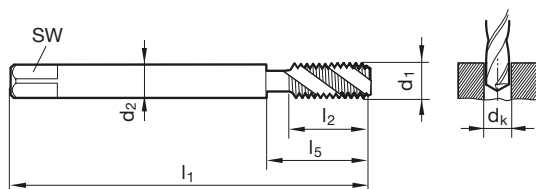
Article no. **6569**



cutting data see page 146



short cutting form



Standard **DIN 5156**
Article no. **6569**

| d1 | P G/inch | d2 mm | SW mm | dk mm | l1 mm | l2 mm | l5 mm | Order no. |
|-------|-------------|----------|----------|----------|----------|----------|----------|-------------|
| G1/16 | 28 | 6.00 | 4.90 | 6.80 | 90.00 | 11.00 | 30.00 | 6569 7.723 |
| G1/8 | 28 | 7.00 | 5.50 | 8.80 | 90.00 | 11.00 | 35.00 | 6569 9.728 |
| G1/4 | 19 | 11.00 | 9.00 | 11.80 | 100.00 | 14.00 | 40.00 | 6569 13.157 |
| G3/8 | 19 | 12.00 | 9.00 | 15.25 | 100.00 | 14.00 | 44.00 | 6569 16.662 |
| G1/2 | 14 | 16.00 | 12.00 | 19.00 | 125.00 | 18.00 | 44.00 | 6569 20.955 |
| G5/8 | 14 | 18.00 | 14.50 | 21.00 | 125.00 | 18.00 | 48.00 | 6569 22.911 |
| G3/4 | 14 | 20.00 | 16.00 | 24.50 | 140.00 | 20.00 | 53.00 | 6569 26.441 |
| G7/8 | 14 | 22.00 | 18.00 | 28.25 | 150.00 | 22.00 | 53.00 | 6569 30.201 |
| G1 | 11 | 25.00 | 20.00 | 30.75 | 160.00 | 24.00 | 56.00 | 6569 33.249 |

Taps for BSP threads

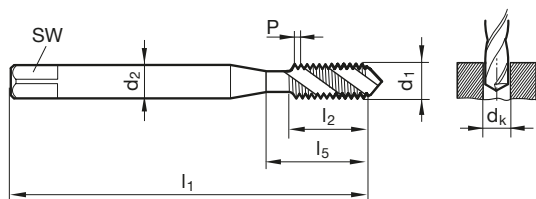
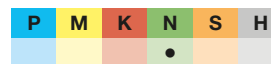
Article no. 6567



cutting data see page 146



with extra-long shank



Standard

Company std.

Article no.

6567

| d1 | P | d2 | SW | dk | l1 | l2 | l5 |
|------|--------|-------|-------|-------|--------|-------|--------|
| | G/inch | mm | mm | mm | mm | mm | mm |
| G1/8 | 28 | 7.00 | 5.50 | 8.80 | 200.00 | 16.00 | 140.00 |
| G1/4 | 19 | 11.00 | 9.00 | 11.80 | 220.00 | 20.00 | 160.00 |
| G3/8 | 19 | 12.00 | 9.00 | 15.25 | 250.00 | 25.00 | 160.00 |
| G1/2 | 14 | 16.00 | 12.00 | 19.00 | 280.00 | 27.00 | 217.00 |

Order no.

6567 9.728

6567 13.157

6567 16.662

6567 20.955

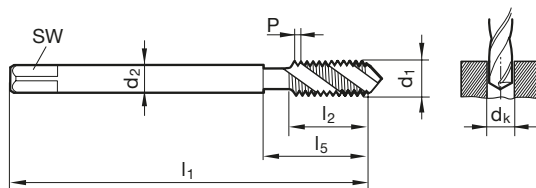
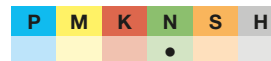
Taps

Tap for EG/STI thread

Article no. 6564



cutting data see page 146



Standard

DIN 40435

Article no.

6564

| d1 | P | d2 | SW | dk | l1 | l2 | l5 |
|-------------|-------|-------|-------|-------|--------|-------|-------|
| | mm | mm | mm | mm | mm | mm | mm |
| EG/STI M2 | 0.400 | 2.80 | 2.10 | 2.10 | 50.00 | 4.50 | 14.00 |
| EG/STI M2,5 | 0.450 | 3.50 | 2.70 | 2.65 | 56.00 | 5.00 | 18.00 |
| EG/STI M3 | 0.500 | 4.50 | 3.40 | 3.15 | 63.00 | 6.00 | 21.00 |
| EG/STI M4 | 0.700 | 6.00 | 4.90 | 4.20 | 70.00 | 7.50 | 25.00 |
| EG/STI M5 | 0.800 | 6.00 | 4.90 | 5.25 | 80.00 | 8.50 | 30.00 |
| EG/STI M6 | 1.000 | 8.00 | 6.20 | 6.30 | 90.00 | 11.00 | 35.00 |
| EG/STI M8 | 1.250 | 10.00 | 8.00 | 8.40 | 100.00 | 14.00 | 39.00 |
| EG/STI M10 | 1.500 | 9.00 | 7.00 | 10.50 | 100.00 | 16.00 | 40.00 |
| EG/STI M12 | 1.750 | 11.00 | 9.00 | 12.50 | 110.00 | 18.50 | 53.00 |
| EG/STI M14 | 2.000 | 12.00 | 9.00 | 14.50 | 110.00 | 20.00 | 54.00 |
| EG/STI M16 | 2.000 | 14.00 | 11.00 | 16.50 | 125.00 | 20.00 | 62.00 |

Order no.

6564 2.000

6564 2.500

6564 3.000

6564 4.000

6564 5.000

6564 6.000

6564 8.000

6564 10.000

6564 12.000

6564 14.000

6564 16.000



Fluteless taps for ISO metric threads

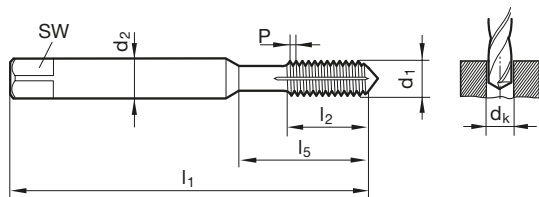
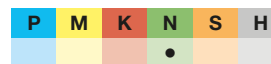
Article no. **8088**



cutting data see page 146



for thread depths up to 3xD



Standard ~DIN 371/~DIN 376
Article no. **8088**

| d1 | P mm | d2 mm | SW mm | dk mm | l1 mm | l2 mm | l5 mm | | Order no. |
|------|-------|-------|-------|-------|--------|-------|-------|----------|-------------|
| M2 | 0.400 | 2.80 | 2.10 | 1.85 | 45.00 | 8.00 | 13.50 | ~DIN 371 | 8088 2.000 |
| M2,5 | 0.450 | 2.80 | 2.10 | 2.30 | 50.00 | 9.00 | 14.50 | ~DIN 371 | 8088 2.500 |
| M3 | 0.500 | 3.50 | 2.70 | 2.80 | 56.00 | 10.00 | 18.00 | ~DIN 371 | 8088 3.000 |
| M4 | 0.700 | 4.50 | 3.40 | 3.70 | 63.00 | 12.00 | 21.00 | ~DIN 371 | 8088 4.000 |
| M5 | 0.800 | 6.00 | 4.90 | 4.65 | 70.00 | 14.00 | 25.00 | ~DIN 371 | 8088 5.000 |
| M6 | 1.000 | 6.00 | 4.90 | 5.55 | 80.00 | 16.00 | 30.00 | ~DIN 371 | 8088 6.000 |
| M8 | 1.250 | 8.00 | 6.20 | 7.40 | 90.00 | 17.00 | 35.00 | ~DIN 371 | 8088 8.000 |
| M10 | 1.500 | 10.00 | 8.00 | 9.30 | 100.00 | 20.00 | 39.00 | ~DIN 371 | 8088 10.000 |
| M12 | 1.750 | 9.00 | 7.00 | 11.20 | 110.00 | 24.00 | 49.00 | ~DIN 376 | 8088 12.000 |
| M14 | 2.000 | 11.00 | 9.00 | 13.10 | 110.00 | 26.00 | 53.00 | ~DIN 376 | 8088 14.000 |
| M16 | 2.000 | 12.00 | 9.00 | 15.10 | 110.00 | 26.00 | 54.00 | ~DIN 376 | 8088 16.000 |

Fluteless taps



Fluteless taps with coolant ducts for ISO metric threads

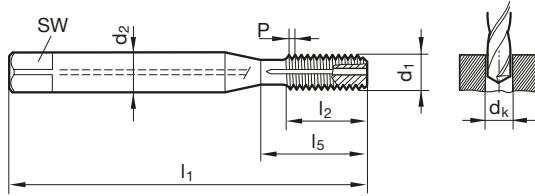
Article no. 8089



cutting data see page 147



with internal cooling \geq M5 • short cutting form • for thread depths up to 3xD



Standard ~DIN 371/~DIN 376
Article no. 8089

| d1 | P mm | d2 mm | SW mm | dk mm | l1 mm | l2 mm | l5 mm | | Order no. |
|------|-------|-------|-------|-------|--------|-------|-------|----------|-------------|
| M2 | 0.400 | 2.80 | 2.10 | 1.85 | 45.00 | 8.00 | 13.50 | ~DIN 371 | 8089 2.000 |
| M2,5 | 0.450 | 2.80 | 2.10 | 2.30 | 50.00 | 9.00 | 14.50 | ~DIN 371 | 8089 2.500 |
| M3 | 0.500 | 3.50 | 2.70 | 2.80 | 56.00 | 10.00 | 18.00 | ~DIN 371 | 8089 3.000 |
| M4 | 0.700 | 4.50 | 3.40 | 3.70 | 63.00 | 12.00 | 21.00 | ~DIN 371 | 8089 4.000 |
| M5 | 0.800 | 6.00 | 4.90 | 4.65 | 70.00 | 14.00 | 25.00 | ~DIN 371 | 8089 5.000 |
| M6 | 1.000 | 6.00 | 4.90 | 5.55 | 80.00 | 16.00 | 30.00 | ~DIN 371 | 8089 6.000 |
| M8 | 1.250 | 8.00 | 6.20 | 7.40 | 90.00 | 17.00 | 35.00 | ~DIN 371 | 8089 8.000 |
| M10 | 1.500 | 10.00 | 8.00 | 9.30 | 100.00 | 20.00 | 39.00 | ~DIN 371 | 8089 10.000 |
| M12 | 1.750 | 9.00 | 7.00 | 11.20 | 110.00 | 24.00 | 49.00 | ~DIN 376 | 8089 12.000 |
| M14 | 2.000 | 11.00 | 9.00 | 13.10 | 110.00 | 26.00 | 53.00 | ~DIN 376 | 8089 14.000 |
| M16 | 2.000 | 12.00 | 9.00 | 15.10 | 110.00 | 26.00 | 54.00 | ~DIN 376 | 8089 16.000 |

Fluteless taps

Fluteless taps with coolant ducts for ISO metric threads

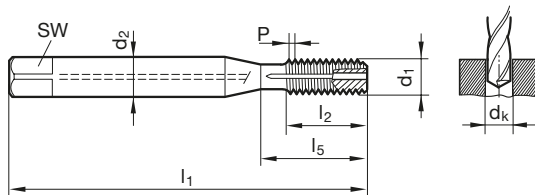
Article no. 8090



cutting data see page 147



for thread depths up to 3xD



Standard DIN 371/DIN 376
Article no. 8090

| d1 | P mm | d2 mm | SW mm | dk mm | l1 mm | l2 mm | l5 mm | | Order no. |
|-----|-------|-------|-------|-------|--------|-------|-------|----------|-------------|
| M5 | 0.800 | 6.00 | 4.90 | 4.65 | 70.00 | 8.50 | 25.00 | ~DIN 371 | 8090 5.000 |
| M6 | 1.000 | 6.00 | 4.90 | 5.55 | 80.00 | 11.00 | 30.00 | ~DIN 371 | 8090 6.000 |
| M8 | 1.250 | 8.00 | 6.20 | 7.40 | 90.00 | 14.00 | 35.00 | ~DIN 371 | 8090 8.000 |
| M10 | 1.500 | 10.00 | 8.00 | 9.30 | 100.00 | 16.00 | 39.00 | ~DIN 371 | 8090 10.000 |
| M12 | 1.750 | 9.00 | 7.00 | 11.20 | 110.00 | 18.50 | 49.00 | ~DIN 376 | 8090 12.000 |
| M16 | 2.000 | 12.00 | 9.00 | 15.10 | 110.00 | 20.00 | 54.00 | ~DIN 376 | 8090 16.000 |
| M20 | 2.500 | 16.00 | 12.00 | 18.90 | 140.00 | 25.00 | 62.00 | ~DIN 376 | 8090 20.000 |



Fluteless tap AL

Fluteless taps with coolant ducts for ISO metric threads

Article no. **8091**

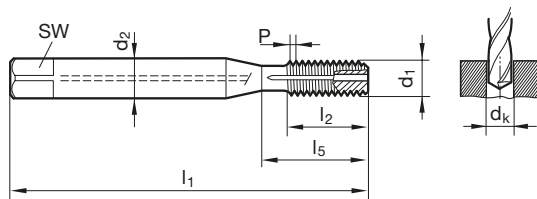


cutting data see page 147



for thread depths up to 3xD

| | | | | | |
|---|---|---|---|---|---|
| P | M | K | N | S | H |
| | | | • | | |



Standard ~DIN 371/~DIN 376
Article no. **8091**

| d1 | P mm | d2 mm | SW mm | dk mm | l1 mm | l2 mm | l5 mm | | Order no. |
|-----|-------|-------|-------|-------|--------|-------|-------|----------|-------------|
| M5 | 0.800 | 6.00 | 4.90 | 4.65 | 70.00 | 8.50 | 25.00 | ~DIN 371 | 8091 5.000 |
| M6 | 1.000 | 6.00 | 4.90 | 5.55 | 80.00 | 11.00 | 30.00 | ~DIN 371 | 8091 6.000 |
| M8 | 1.250 | 8.00 | 6.20 | 7.40 | 90.00 | 14.00 | 35.00 | ~DIN 371 | 8091 8.000 |
| M10 | 1.500 | 10.00 | 8.00 | 9.30 | 100.00 | 16.00 | 39.00 | ~DIN 371 | 8091 10.000 |
| M12 | 1.750 | 9.00 | 7.00 | 11.20 | 110.00 | 18.50 | 49.00 | ~DIN 376 | 8091 12.000 |
| M16 | 2.000 | 12.00 | 9.00 | 15.10 | 110.00 | 20.00 | 54.00 | ~DIN 376 | 8091 16.000 |
| M20 | 2.500 | 16.00 | 12.00 | 18.90 | 140.00 | 25.00 | 62.00 | ~DIN 376 | 8091 20.000 |

Fluteless taps

Fluteless taps with coolant ducts for ISO metric threads

Article no. **8094**

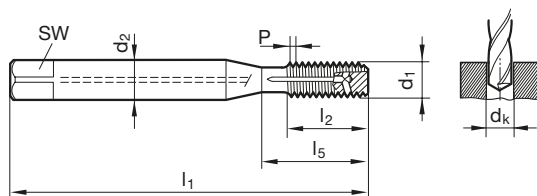


cutting data see page 147



with internal cooling ≥ M5 • for thread depths up to 3xD

| | | | | | |
|---|---|---|---|---|---|
| P | M | K | N | S | H |
| | | | • | | |



Standard ~DIN 371/~DIN 376
Article no. **8094**

| d1 | P mm | d2 mm | SW mm | dk mm | l1 mm | l2 mm | l5 mm | | Order no. |
|-----|-------|-------|-------|-------|--------|-------|-------|----------|-------------|
| M3 | 0.500 | 3.50 | 2.70 | 2.80 | 56.00 | 6.00 | 18.00 | ~DIN 371 | 8094 3.000 |
| M4 | 0.700 | 4.50 | 3.40 | 3.70 | 63.00 | 7.50 | 21.00 | ~DIN 371 | 8094 4.000 |
| M5 | 0.800 | 6.00 | 4.90 | 4.65 | 70.00 | 8.50 | 25.00 | ~DIN 371 | 8094 5.000 |
| M6 | 1.000 | 6.00 | 4.90 | 5.55 | 80.00 | 11.00 | 30.00 | ~DIN 371 | 8094 6.000 |
| M8 | 1.250 | 8.00 | 6.20 | 7.40 | 90.00 | 14.00 | 35.00 | ~DIN 371 | 8094 8.000 |
| M10 | 1.500 | 10.00 | 8.00 | 9.30 | 100.00 | 16.00 | 39.00 | ~DIN 371 | 8094 10.000 |
| M12 | 1.750 | 9.00 | 7.00 | 11.20 | 110.00 | 18.50 | 49.00 | ~DIN 376 | 8094 12.000 |
| M14 | 2.000 | 11.00 | 9.00 | 13.10 | 110.00 | 20.00 | 53.00 | ~DIN 376 | 8094 14.000 |
| M16 | 2.000 | 12.00 | 9.00 | 15.10 | 110.00 | 20.00 | 54.00 | ~DIN 376 | 8094 16.000 |



Fluteless taps with coolant ducts for ISO metric threads

Article no. 6580

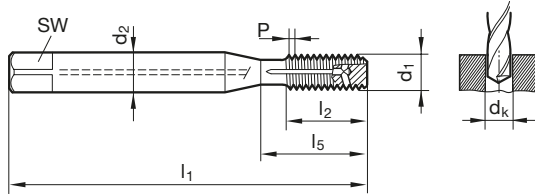


cutting data see page 147



for thread depths up to 3xD • short cutting form • with internal cooling ≥ M5

| | | | | | |
|---|---|---|---|---|---|
| P | M | K | N | S | H |
| | | | • | | |



| | | | | | | | | | Standard | ~DIN 371/~DIN 376 |
|-----|-------|-------|------|-------|--------|-------|-------|----------|-------------|-------------------|
| | | | | | | | | | Article no. | 6580 |
| d1 | P | d2 | SW | dk | l1 | l2 | l5 | | Order no. | |
| M3 | 0.500 | 3.50 | 2.70 | 2.80 | 56.00 | 6.00 | 18.00 | ~DIN 371 | 6580 3.000 | |
| M4 | 0.700 | 4.50 | 3.40 | 3.70 | 63.00 | 7.50 | 21.00 | ~DIN 371 | 6580 4.000 | |
| M5 | 0.800 | 6.00 | 4.90 | 4.65 | 70.00 | 8.50 | 25.00 | ~DIN 371 | 6580 5.000 | |
| M6 | 1.000 | 6.00 | 4.90 | 5.55 | 80.00 | 11.00 | 30.00 | ~DIN 371 | 6580 6.000 | |
| M8 | 1.250 | 8.00 | 6.20 | 7.40 | 90.00 | 14.00 | 35.00 | ~DIN 371 | 6580 8.000 | |
| M10 | 1.500 | 10.00 | 8.00 | 9.30 | 100.00 | 16.00 | 39.00 | ~DIN 371 | 6580 10.000 | |
| M12 | 1.750 | 9.00 | 7.00 | 11.20 | 110.00 | 18.50 | 49.00 | ~DIN 376 | 6580 12.000 | |
| M14 | 2.000 | 11.00 | 9.00 | 13.10 | 110.00 | 20.00 | 53.00 | ~DIN 376 | 6580 14.000 | |
| M16 | 2.000 | 12.00 | 9.00 | 15.10 | 110.00 | 20.00 | 54.00 | ~DIN 376 | 6580 16.000 | |

Fluteless taps

Fluteless taps for ISO metric fine threads

Article no. 6570

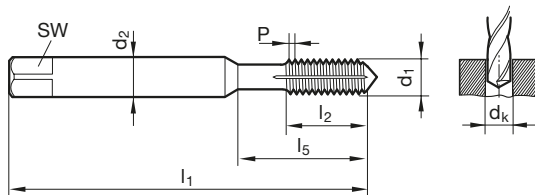


cutting data see page 147



for thread depths up to 3xD

| | | | | | |
|---|---|---|---|---|---|
| P | M | K | N | S | H |
| | | | • | | |



| | | | | | | | | | Standard | ~DIN 374 |
|------------|-------|-------|-------|-------|--------|-------|-------|--|-------------|----------|
| | | | | | | | | | Article no. | 6570 |
| d1 | P | d2 | SW | dk | l1 | l2 | l5 | | Order no. | |
| M8 x 1 | 1.000 | 6.00 | 4.90 | 7.55 | 90.00 | 17.00 | 35.00 | | 6570 8.005 | |
| M10 x 1 | 1.000 | 7.00 | 5.50 | 9.55 | 90.00 | 16.00 | 35.00 | | 6570 10.005 | |
| M10 x 1,25 | 1.250 | 7.00 | 5.50 | 9.40 | 100.00 | 20.00 | 39.00 | | 6570 10.006 | |
| M12 x 1 | 1.000 | 9.00 | 7.00 | 11.55 | 100.00 | 20.00 | 40.00 | | 6570 12.005 | |
| M12 x 1,25 | 1.250 | 9.00 | 7.00 | 11.40 | 100.00 | 20.00 | 40.00 | | 6570 12.006 | |
| M12 x 1,5 | 1.500 | 9.00 | 7.00 | 11.30 | 100.00 | 20.00 | 40.00 | | 6570 12.007 | |
| M14 x 1,5 | 1.500 | 11.00 | 9.00 | 13.30 | 100.00 | 20.00 | 40.00 | | 6570 14.007 | |
| M16 x 1,5 | 1.500 | 12.00 | 9.00 | 15.30 | 100.00 | 22.00 | 44.00 | | 6570 16.007 | |
| M20 x 1,5 | 1.500 | 16.00 | 12.00 | 19.30 | 125.00 | 25.00 | 44.00 | | 6570 20.007 | |



Fluteless tap AL

Fluteless taps with coolant ducts for ISO metric fine threads

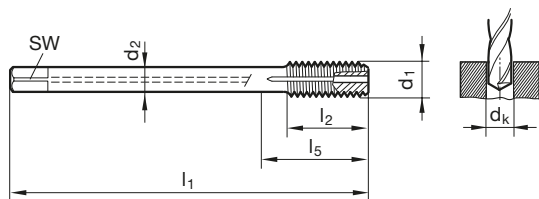
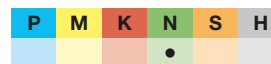
Article no. **6572**



cutting data see page 147



for thread depths up to 3xD • short cutting form



Standard ~DIN 371/~DIN 374
Article no. **6572**

| d1 | P mm | d2 mm | SW mm | dk mm | l1 mm | l2 mm | l5 mm | | Order no. |
|------------|-------|-------|-------|-------|--------|-------|-------|----------|-------------|
| M8 x 1 | 1.000 | 8.00 | 6.20 | 7.55 | 90.00 | 11.00 | 35.00 | ~DIN 371 | 6572 8.005 |
| M10 x 1 | 1.000 | 10.00 | 8.00 | 9.55 | 90.00 | 11.00 | 35.00 | ~DIN 371 | 6572 10.005 |
| M10 x 1,25 | 1.250 | 10.00 | 8.00 | 9.40 | 100.00 | 14.00 | 39.00 | ~DIN 371 | 6572 10.006 |
| M12 x 1 | 1.000 | 9.00 | 7.00 | 11.55 | 100.00 | 11.00 | 40.00 | ~DIN 374 | 6572 12.005 |
| M12 x 1,25 | 1.250 | 9.00 | 7.00 | 11.40 | 100.00 | 15.00 | 40.00 | ~DIN 374 | 6572 12.006 |
| M12 x 1,5 | 1.500 | 9.00 | 7.00 | 11.30 | 100.00 | 15.00 | 40.00 | ~DIN 374 | 6572 12.007 |
| M14 x 1,5 | 1.500 | 11.00 | 9.00 | 13.30 | 100.00 | 15.00 | 40.00 | ~DIN 374 | 6572 14.007 |
| M16 x 1,5 | 1.500 | 12.00 | 9.00 | 15.30 | 100.00 | 15.00 | 44.00 | ~DIN 374 | 6572 16.007 |
| M20 x 1,5 | 1.500 | 16.00 | 12.00 | 19.30 | 125.00 | 16.00 | 44.00 | ~DIN 374 | 6572 20.007 |

Fluteless taps

Fluteless taps with coolant ducts for ISO metric fine threads

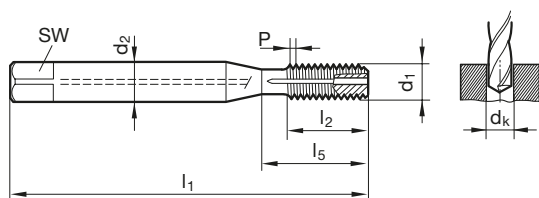
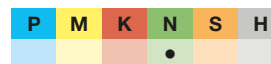
Article no. **8092**



cutting data see page 147



for thread depths up to 3xD



Standard ~DIN 371/~DIN 374
Article no. **8092**

| d1 | P mm | d2 mm | SW mm | dk mm | l1 mm | l2 mm | l5 mm | | Order no. |
|------------|-------|-------|-------|-------|--------|-------|-------|----------|-------------|
| M8 x 1 | 1.000 | 8.00 | 6.20 | 7.55 | 90.00 | 11.00 | 35.00 | ~DIN 371 | 8092 8.005 |
| M10 x 1 | 1.000 | 10.00 | 8.00 | 9.55 | 90.00 | 11.00 | 35.00 | ~DIN 371 | 8092 10.005 |
| M10 x 1,25 | 1.250 | 10.00 | 8.00 | 9.40 | 100.00 | 14.00 | 39.00 | ~DIN 371 | 8092 10.006 |
| M12 x 1 | 1.000 | 9.00 | 7.00 | 11.55 | 100.00 | 11.00 | 40.00 | ~DIN 374 | 8092 12.005 |
| M12 x 1,5 | 1.500 | 9.00 | 7.00 | 11.30 | 100.00 | 15.00 | 40.00 | ~DIN 374 | 8092 12.007 |
| M14 x 1,5 | 1.500 | 11.00 | 9.00 | 13.30 | 100.00 | 15.00 | 40.00 | ~DIN 374 | 8092 14.007 |
| M16 x 1,5 | 1.500 | 12.00 | 9.00 | 15.30 | 100.00 | 15.00 | 44.00 | ~DIN 374 | 8092 16.007 |



Fluteless taps with coolant ducts for ISO metric fine threads

Article no. 6579

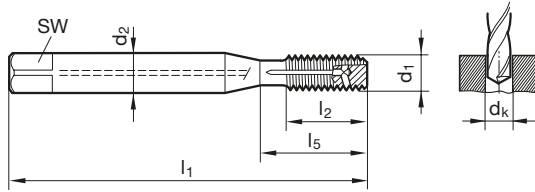


cutting data see page 147



for thread depths up to 3xD

| | | | | | |
|---|---|---|---|---|---|
| P | M | K | N | S | H |
| | | | • | | |



| | |
|-------------|-------------------|
| Standard | ~DIN 371/~DIN 374 |
| Article no. | 6579 |

| d1 | P | d2 | SW | dk | l1 | l2 | l5 | | Order no. |
|-----------|-------|-------|------|-------|--------|-------|-------|----------|-------------|
| M8 x 1 | 1.000 | 8.00 | 6.20 | 7.55 | 90.00 | 11.00 | 35.00 | ~DIN 371 | 6579 8.005 |
| M10 x 1 | 1.000 | 10.00 | 8.00 | 9.55 | 90.00 | 11.00 | 35.00 | ~DIN 371 | 6579 10.005 |
| M12 x 1,5 | 1.500 | 9.00 | 7.00 | 11.30 | 100.00 | 15.00 | 40.00 | ~DIN 374 | 6579 12.007 |
| M14 x 1,5 | 1.500 | 11.00 | 9.00 | 13.30 | 100.00 | 15.00 | 40.00 | ~DIN 374 | 6579 14.007 |
| M16 x 1,5 | 1.500 | 12.00 | 9.00 | 15.30 | 100.00 | 15.00 | 44.00 | ~DIN 374 | 6579 16.007 |

Fluteless taps with coolant ducts for ISO metric fine threads

Article no. 6581

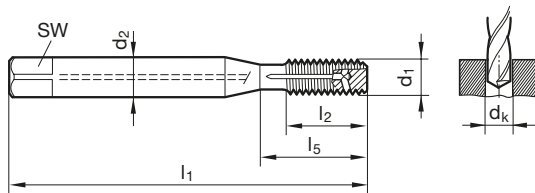


cutting data see page 147



for thread depths up to 3xD • short cutting form

| | | | | | |
|---|---|---|---|---|---|
| P | M | K | N | S | H |
| | | | • | | |



| | |
|-------------|-------------------|
| Standard | ~DIN 371/~DIN 374 |
| Article no. | 6581 |

| d1 | P | d2 | SW | dk | l1 | l2 | l5 | | Order no. |
|-----------|-------|-------|------|-------|--------|-------|-------|----------|-------------|
| M8 x 1 | 1.000 | 8.00 | 6.20 | 7.55 | 90.00 | 11.00 | 35.00 | ~DIN 371 | 6581 8.005 |
| M10 x 1 | 1.000 | 10.00 | 8.00 | 9.55 | 90.00 | 11.00 | 35.00 | ~DIN 371 | 6581 10.005 |
| M12 x 1,5 | 1.500 | 9.00 | 7.00 | 11.30 | 100.00 | 15.00 | 40.00 | ~DIN 374 | 6581 12.007 |
| M14 x 1,5 | 1.500 | 11.00 | 9.00 | 13.30 | 100.00 | 15.00 | 40.00 | ~DIN 374 | 6581 14.007 |
| M16 x 1,5 | 1.500 | 12.00 | 9.00 | 15.30 | 100.00 | 15.00 | 44.00 | ~DIN 374 | 6581 16.007 |

Fluteless taps



Fluteless taps for BSP threads

Article no. **6571**

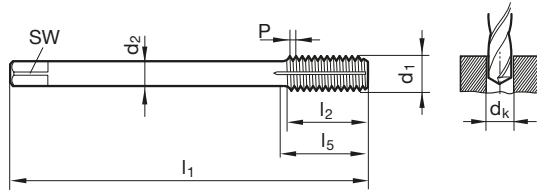


cutting data see page 147



for thread depths up to 3xD

| | | | | | |
|---|---|---|---|---|---|
| P | M | K | N | S | H |
| | | | • | | |



| | |
|-------------|-----------------|
| Standard | DIN 2189 |
| Article no. | 6571 |

| d1 | P | d2 | SW | dk | l1 | l2 | l5 | Order no. |
|------|--------|-------|-------|-------|--------|-------|-------|-------------|
| | G/inch | mm | mm | mm | mm | mm | mm | |
| G1/8 | 28 | 7.00 | 5.50 | 9.30 | 90.00 | 18.00 | 35.00 | 6571 9.728 |
| G1/4 | 19 | 11.00 | 9.00 | 12.50 | 100.00 | 20.00 | 40.00 | 6571 13.157 |
| G3/8 | 19 | 12.00 | 9.00 | 16.00 | 100.00 | 22.00 | 44.00 | 6571 16.662 |
| G1/2 | 14 | 16.00 | 12.00 | 20.00 | 125.00 | 25.00 | 44.00 | 6571 20.955 |
| G3/4 | 14 | 20.00 | 16.00 | 25.50 | 140.00 | 28.00 | 53.00 | 6571 26.441 |

Fluteless taps

Fluteless taps with coolant ducts for BSP threads

Article no. **6573**

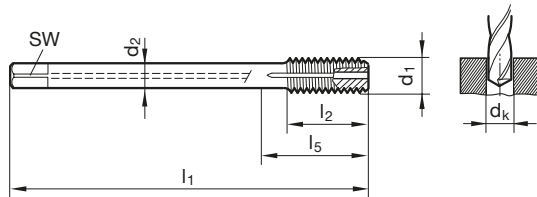


cutting data see page 147



for thread depths up to 3xD • short cutting form

| | | | | | |
|---|---|---|---|---|---|
| P | M | K | N | S | H |
| | | | • | | |



| | |
|-------------|-----------------|
| Standard | DIN 2189 |
| Article no. | 6573 |

| d1 | P | d2 | SW | dk | l1 | l2 | l5 | Order no. |
|------|--------|-------|-------|-------|--------|-------|-------|-------------|
| | G/inch | mm | mm | mm | mm | mm | mm | |
| G1/8 | 28 | 7.00 | 5.50 | 9.30 | 90.00 | 11.00 | 35.00 | 6573 9.728 |
| G1/4 | 19 | 11.00 | 9.00 | 12.50 | 100.00 | 14.00 | 40.00 | 6573 13.157 |
| G3/8 | 19 | 12.00 | 9.00 | 16.00 | 100.00 | 14.00 | 44.00 | 6573 16.662 |
| G1/2 | 14 | 16.00 | 12.00 | 20.00 | 125.00 | 18.00 | 44.00 | 6573 20.955 |
| G3/4 | 14 | 20.00 | 16.00 | 25.50 | 140.00 | 20.00 | 53.00 | 6573 26.441 |

Fluteless taps with coolant ducts for BSP threads

Article no. **8093**

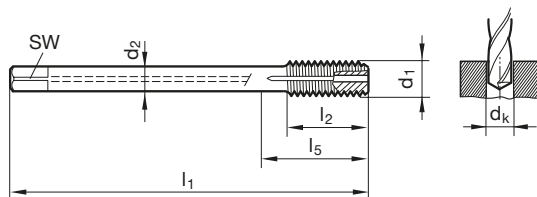


cutting data see page 147



for thread depths up to 3xD

| | | | | | |
|---|---|---|---|---|---|
| P | M | K | N | S | H |
| | | | • | | |



| | |
|-------------|-----------------|
| Standard | DIN 2189 |
| Article no. | 8093 |

| d1 | P | d2 | SW | dk | l1 | l2 | l5 | Order no. |
|------|--------|-------|-------|-------|--------|-------|-------|-------------|
| | G/inch | mm | mm | mm | mm | mm | mm | |
| G1/8 | 28 | 7.00 | 5.50 | 9.30 | 90.00 | 11.00 | 35.00 | 8093 9.728 |
| G1/4 | 19 | 11.00 | 9.00 | 12.50 | 100.00 | 14.00 | 40.00 | 8093 13.157 |
| G3/8 | 19 | 12.00 | 9.00 | 16.00 | 100.00 | 14.00 | 44.00 | 8093 16.662 |
| G1/2 | 14 | 16.00 | 12.00 | 20.00 | 125.00 | 18.00 | 44.00 | 8093 20.955 |
| G3/4 | 14 | 20.00 | 16.00 | 25.50 | 140.00 | 20.00 | 53.00 | 8093 26.441 |



ALL

NEW