

HSS



HAND TAPS

HANDGEWINDEBOHRER

- General Tapping, HSS & HSS-E
- Für normales Gewindeschneiden. HSS und HSS-E



ISO metric coarse threads DIN 13

- Metrisches ISO-Gewinde DIN 13
- ISO MÉTRIQUE DIN13
- ISO Metrico passo grosso DIN 13

Sets of taps
Gewindebohrer -Satz

- This tap is a serial hand tap in set, First, Second and Bottoming.
- Bottoming tap of set has final internal thread dimensions only.

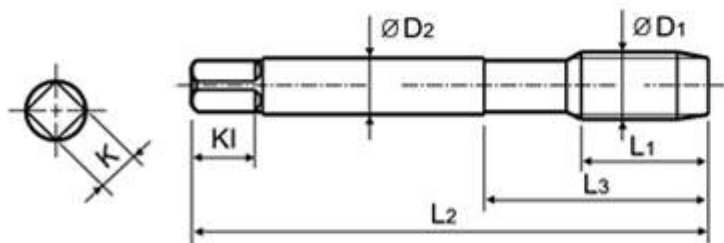
First



Second



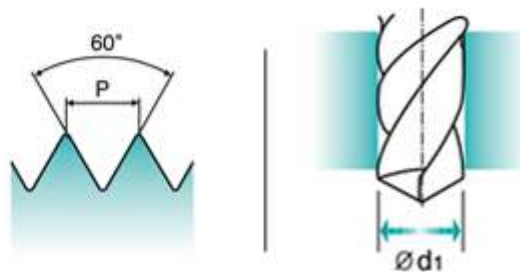
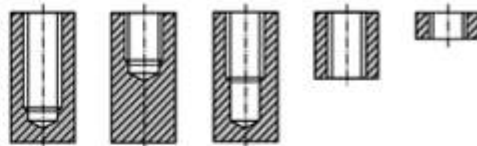
Bottoming



- Dies ist ein Handgewindebohrer im Satz mit Vor-, Mittel- und Fertigschneider.
- Nur der Fertigschneider kann das gewünschte Gewinde schneiden

Hole type

2.0xD



Material groups

GS

HSS

DIN 352

6H



Bright

Unit : mm

SIZE	Pitch	EDP No.	Tapping Drill Diameter
ØD1	P	Bright	Ød1
M2	× 0.4	T7109139	1.6
M2.2	× 0.45	T7109159	1.75
*M2.3	× 0.4	T7109199	1.9
M2.5	× 0.45	T7109179	2.05
*M2.6	× 0.45	T7109499	2.1
M3	× 0.5	T7109209	2.5
M3.5	× 0.6	T7109229	2.9
M4	× 0.7	T7109249	3.3
M4.5	× 0.75	T7109269	3.7
M5	× 0.8	T7109289	4.2
M5.5	× 0.9	T7109N69	4.6
M6	× 1	T7109319	5
M7	× 1	T7109349	6
M8	× 1.25	T7109369	6.8
M9	× 1.25	T7109399	7.8
M10	× 1.5	T7109429	8.5
M11	× 1.5	T7109469	9.5
M12	× 1.75	T7109509	10.2
M14	× 2	T7109549	12
M16	× 2	T7109609	14
M18	× 2.5	T7109659	15.5
M20	× 2.5	T7109709	17.5

SIZE	Pitch	EDP No.	Tapping Drill Diameter
ØD1	P	Bright	Ød1
M22	× 2.5	T7109749	19.5
M24	× 3	T7109789	21
M27	× 3	T7109869	24
M30	× 3.5	T7109949	26.5
M33	× 3.5	T7109A49	29.5
M36	× 4	T7109B39	32
M39	× 4	T7109C09	35
M42	× 4.5	T7109C89	37.5
M45	× 4.5	T7109D59	40.5
M48	× 5	T7109E29	43
M52	× 5	T7109F39	47

MF

ISO metric fine threads DIN 13

- 🇩🇪 **Metrisches ISO-Gewinde DIN 13**
- 🇫🇷 **ISO MÉTRIQUE PAS FINS DIN13**
- 🇮🇹 **ISO Metrico passo fine DIN 13**

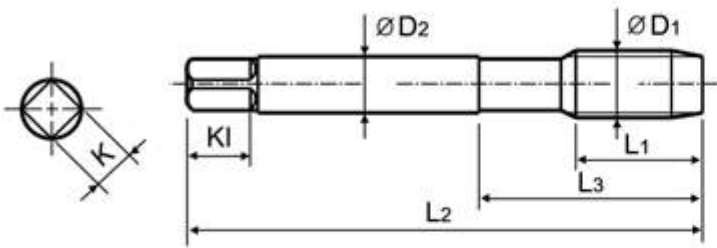
Sets of taps
Gewindebohrer-Satz

- ▶ This tap is a serial hand tap in set, First and Bottoming.
- ▶ Bottoming tap of set has final internal thread dimensions only.

First

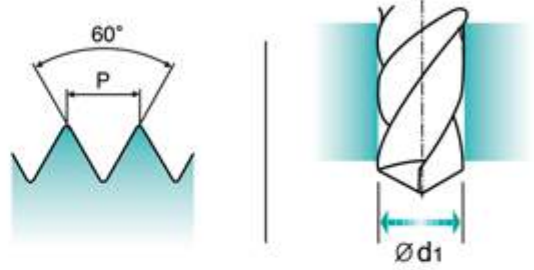
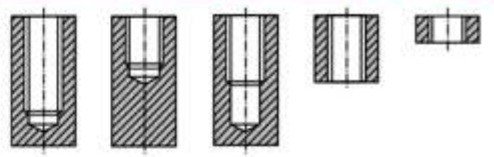


Bottoming



- ▶ Handgewindebohrersatz mit Vor- und Fertigschneider.
- ▶ Nur der Fertigschneider kann das gewünschte Gewinde schneiden.

Hole type
2.0×D



Material groups

GS HSS DIN 2181 6H 60° I/III Bright


Unit : mm

SIZE	Pitch	EDP No.	Tapping Drill Diameter
ØD1	P	Bright	Ød1
M3	× 0.35	T7309219	2.65
M4	× 0.5	T7309259	3.5
M5	× 0.5	T7309299	4.5
M6	× 0.75	T7309329	5.2
M6	× 0.5	T7309339	5.5
M7	× 0.75	T7309359	6.2
M8	× 1	T7309379	7
M8	× 0.75	T7309389	7.2
M8	× 0.5	T7309939	7.5
M9	× 1	T7309409	8
M10	× 1.25	T7309439	8.8
M10	× 1	T7309449	9
M10	× 0.75	T7309459	9.2
M11	× 1	T7309479	10
M12	× 1.5	T7309519	10.5
M12	× 1.25	T7309529	10.8
M12	× 1	T7309539	11
M13	× 1.5	T7309N19	11.5
M13	× 1	T7309N29	12
M14	× 1.5	T7309559	12.5
M14	× 1.25	T7309569	12.8
M14	× 1	T7309579	13
M15	× 1.5	T7309589	13.5
M15	× 1	T7309599	14
M16	× 1.5	T7309619	14.5

SIZE	Pitch	EDP No.	Tapping Drill Diameter
ØD1	P	Bright	Ød1
M16	× 1	T7309629	15
M18	× 2	T7309669	16
M18	× 1.5	T7309679	16.5
M18	× 1	T7309689	17
M20	× 2	T7309719	18
M20	× 1.5	T7309729	18.5
M20	× 1	T7309739	19
M22	× 2	T7309759	20
M22	× 1.5	T7309769	20.5
M22	× 1	T7309779	21
M24	× 2	T7309799	22
M24	× 1.5	T7309809	22.5
M24	× 1	T7309819	23
M25	× 1.5	T7309839	23.5
M25	× 1	T7309849	24
M26	× 1.5	T7309859	24.5
M26	× 1	T7309N59	25
M27	× 2	T7309879	25
M27	× 1.5	T7309889	25.5
M27	× 1	T7309899	26
M28	× 2	T7309909	26
M28	× 1.5	T7309919	26.5
M30	× 2	T7309969	28
M30	× 1.5	T7309979	28.5
M30	× 1	T7309989	29

UNC

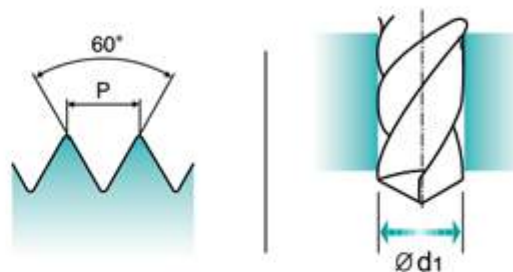
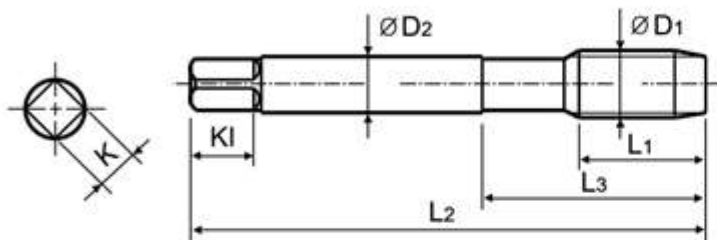
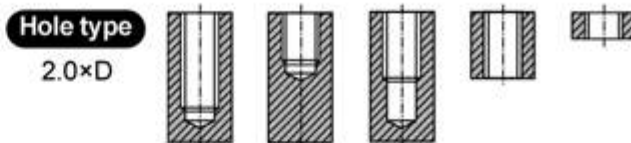
Unified coarse threads

-  Unified Grobgewinde
-  UNC
-  Unificato passo grosso

Sets of taps
Gewindebohrer-Satz

- ▶ This tap is a serial hand tap in set, First, Second and Bottoming.
- ▶ Bottoming tap of set has final internal thread dimensions only.

- ▶ Dies ist ein Handgewindebohrer im Satz mit Vor-, Mittel- und Fertigschneider.
- ▶ Nur der Fertigschneider kann das gewünschte Gewinde schneiden.



Material groups

GS HSS DIN 351 2B 60° I/II/III Bright

Unit : mm

SIZE	TPI	EDP No.	Tapping Drill Diameter
ØD ₁	P	Bright	Ød ₁
#2	- 56UNC	T7363089	1.8
#3	- 48UNC	T7363129	2.1
#4	- 40UNC	T7363169	2.3
#5	- 40UNC	T7363209	2.6
#6	- 32UNC	T7363249	2.85
#8	- 32UNC	T7363289	3.5
#10	- 24UNC	T7363329	3.9
#12	- 24UNC	T7363369	4.5
1/4	- 20UNC	T7363409	5.2
5/16	- 18UNC	T7363449	6.6
3/8	- 16UNC	T7363489	8
7/16	- 14UNC	T7363529	9.4

SIZE	TPI	EDP No.	Tapping Drill Diameter
ØD ₁	P	Bright	Ød ₁
1/2	- 13UNC	T7363569	10.75
9/16	- 12UNC	T7363609	12.25
5/8	- 11UNC	T7363649	13.5
3/4	- 10UNC	T7363709	16.5
7/8	- 9UNC	T7363749	19.5
1	- 8UNC	T7363789	22.25
1-1/8	- 7UNC	T7363829	25
1-1/4	- 7UNC	T7363869	28.25
1-1/8	- 6UNC	T7363909	30.75
1-1/2	- 6UNC	T7363949	34
1-3/4	- 5UNC	T7363889	39.5
2	- 4½UNC	T7363D29	45.25

UNF

Unified fine threads

-  Unified Feingewinde
-  UNF
-  Unificato passo fine

Sets of taps
Gewindebohrer-Satz

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First



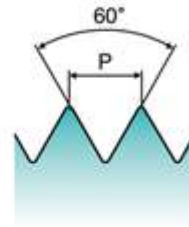
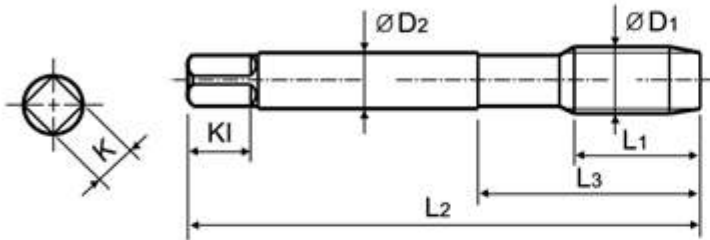
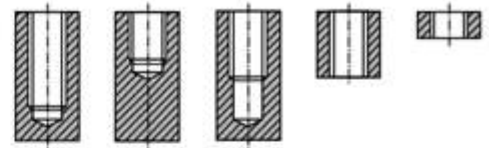
Bottoming



- ▶ Handgewindebohrersatz mit Vor- und Fertigschneider.
- ▶ Nur der Fertigschneider kann das gewünschte Gewinde schneiden.

Hole type

2.0×D



Material groups

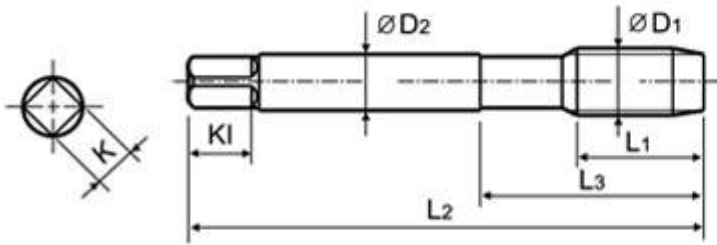
GS HSS DIN 2181 2B 60° I/III Bright

Unit : mm

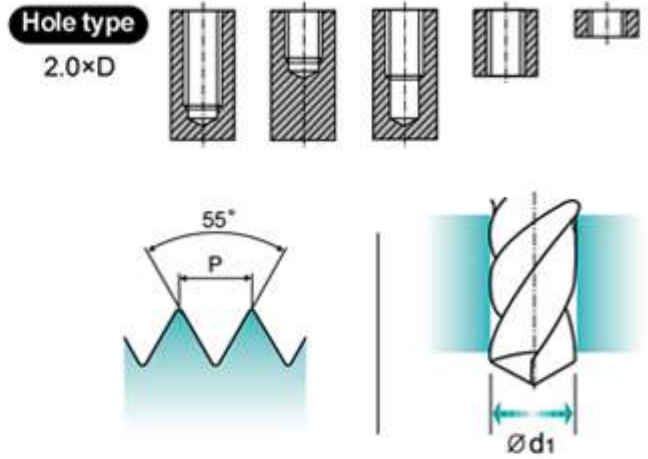
SIZE	TPI	EDP No.	Tapping Drill Diameter
ØD ₁	P	Bright	Ød ₁
#4	- 48 UNF	T7509189	2.4
#5	- 44 UNF	T7509229	2.7
#6	- 40 UNF	T7509269	3
#8	- 36 UNF	T7509309	3.5
#10	- 32 UNF	T7509349	4.1
#12	- 28 UNF	T7509389	4.7
1/4	- 28 UNF	T7509429	5.5
5/16	- 24 UNF	T7509469	6.9
3/8	- 24 UNF	T7509509	8.5

SIZE	TPI	EDP No.	Tapping Drill Diameter
ØD ₁	P	Bright	Ød ₁
7/16	- 20 UNF	T7509549	9.9
1/2	- 20 UNF	T7509589	11.5
9/16	- 18 UNF	T7509629	12.9
5/8	- 18 UNF	T7509669	14.5
3/4	- 16 UNF	T7509729	17.5
7/8	- 14 UNF	T7509769	20.5
1	- 12 UNF	T7509809	23.25
1-1/8	- 12 UNF	T7509849	26.5

- ▶ This tap is a serial hand tap in set, First, Second and Bottoming.
- ▶ Bottoming tap of set has final internal thread dimensions only.



- ▶ Dies ist ein Handgewindebohrer im Satz mit Vor-, Mittel- und Fertigschneider.
- ▶ Nur der Fertigschneider kann das gewünschte Gewinde schneiden.



Material groups

GS

HSS

DIN
351

55°

I/II/III

Bright

Unit : mm

SIZE	TPI	EDP No.	Tapping Drill Diameter
ØD ₁	P	Bright	Ød ₁
W3/32	- 48	T7609129	1.8
W1/8	- 40	T7609209	2.5
W5/32	- 32	T7609289	3.1
W3/16	- 24	T7609329	3.6
W7/32	- 24	T7609369	4.4
W1/4	- 20	T7609409	5.1
W5/16	- 18	T7609449	6.5
W3/8	- 16	T7609489	7.9
W7/16	- 14	T7609529	9.3
W1/2	- 12	T7609569	10.5
W9/16	- 12	T7609609	12

SIZE	TPI	EDP No.	Tapping Drill Diameter
ØD ₁	P	Bright	Ød ₁
W5/8	- 11	T7609649	13.5
W3/4	- 10	T7609709	16.5
W7/8	- 9	T7609749	19.25
W1	- 8	T7609789	22
W1-1/8	- 7	T7609829	24.75
W1-1/4	- 7	T7609869	27.75
W1-3/8	- 6	T7609909	30.5
W1-1/2	- 6	T7609949	33.5
W1-5/8	- 5	T7609989	35.5
W1-3/4	- 5	T7609B89	39
W1-7/8	- 4½	T7609C69	41.5
W2	- 4½	T7609D29	44.5

G(BSP)

Whitworth Pipe threads DIN ISO 228/1

Whitworth Rohrgewinde DIN ISO 228/1

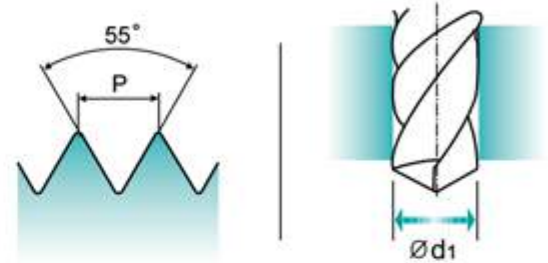
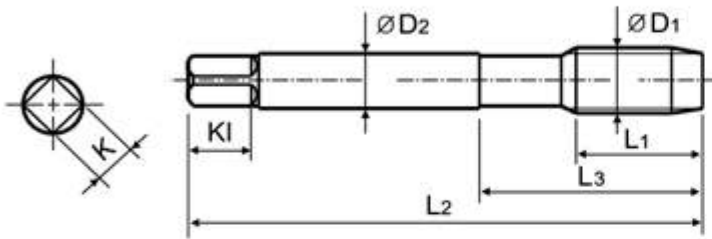
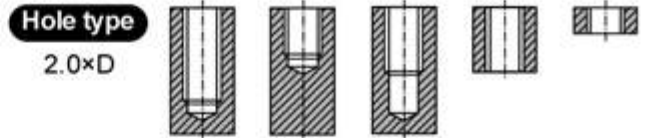
G(BSP) PROFIL 55° DIN ISO 228/1

Filettatura Whitworth per tubi DIN ISO 228/1

Sets of taps
Gewindebohrer-Satz

- ▶ Serial hand tap set in First and Bottoming.
- ▶ Bottoming tap of set has final internal thread dimensions only.

- ▶ Handgewindebohrersatz mit Vor- und Fertigschneider.
- ▶ Nur der Fertigschneider kann das gewünschte Gewinde schneiden.

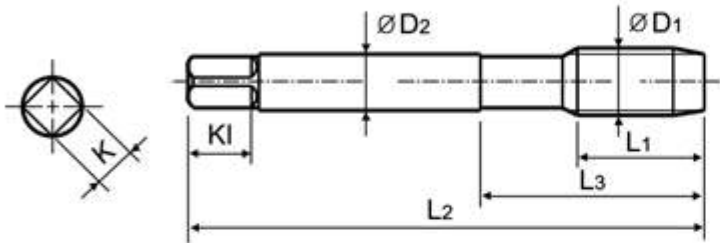
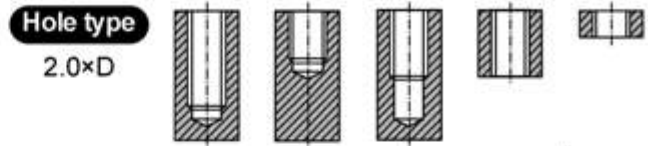


Unit : mm

SIZE	TPI	EDP No.	Tapping Drill Diameter
ØD1	P	Bright	Ød1
G1/16 - 28		T7709029	6.8
G1/8 - 28		T7709209	8.8
G1/4 - 19		T7709409	11.8
G3/8 - 19		T7709489	15.25
G1/2 - 14		T7709569	19
G3/4 - 14		T7709709	24.5
G1 - 11		T7709789	30.75
G1-1/4 - 11		T7709869	39.5
G1-1/2 - 11		T7709949	45.2

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- ▶ Dies ist ein Handgewindebohrer im Satz mit Vor-, Mittel- und Fertigschneider.
- ▶ Nur der Fertigschneider kann das gewünschte Gewinde schneiden.



Material groups: **GS** HSS DIN 352 6H 60° I/II/III Bright

Unit : mm

SIZE	Pitch	EDP No.	Tapping Drill Diameter
ØD ₁	P	Bright	Ød ₁
M3	× 0.5	T7343209	2.5
M3.5	× 0.6	T7343229	2.9
M4	× 0.7	T7343249	3.3
M4.5	× 0.75	T7343269	3.7
M5	× 0.8	T7343289	4.2
M6	× 1	T7343319	5
M8	× 1.25	T7343369	6.8
M10	× 1.5	T7343429	8.5

SIZE	Pitch	EDP No.	Tapping Drill Diameter
ØD ₁	P	Bright	Ød ₁
M12	× 1.75	T7343509	10.2
M14	× 2	T7343549	12
M16	× 2	T7343609	14
M18	× 2.5	T7343659	15.5
M20	× 2.5	T7343709	17.5
M22	× 2.5	T7343749	19.5
M24	× 3	T7343789	21
M27	× 3	T7343869	24
M30	× 3.5	T7343949	26.5

M ISO metric coarse threads DIN 13

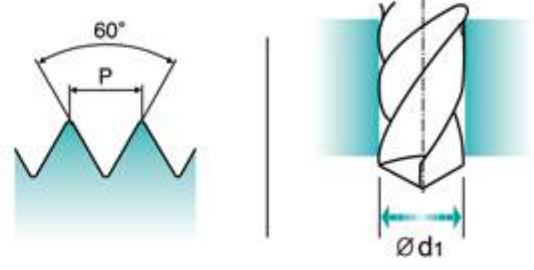
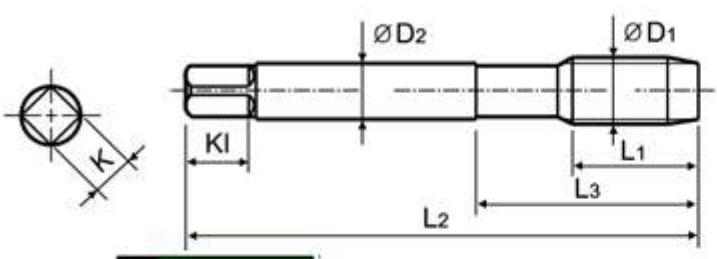
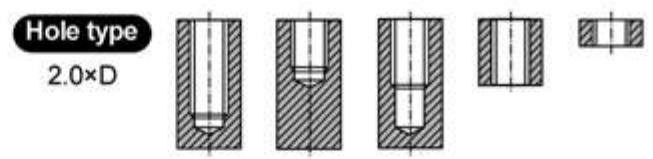
- Metrisches ISO-Gewinde DIN 13
- ISO MÉTRIQUE DIN13
- ISO Metrico passo grosso DIN 13

Sets of taps
Gewindebohrer-Satz

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Material groups: **GS** **VA** **HSS-E** **DIN 352** **6HX** **60°** **I/II/III** **Vap**

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	Vap	L1	L2	L3	ØD2	K	KI	Z	Ød1
M3	× 0.5	TB373209	11	40	18	3.5	2.7	6	3	2.5
M3.5	× 0.6	TB373229	13	45	21	4	3	6	3	2.9
M4	× 0.7	TB373249	13	45	21	4.5	3.4	6	3	3.3
M4.5	× 0.75	TB373269	16	50	25	6	4.9	8	3	3.7
M5	× 0.8	TB373289	16	52	26	6	4.9	8	3	4.2
M6	× 1	TB373319	18	56	27	6	4.9	8	3	5
M8	× 1.25	TB373369	20	63	34	6	4.9	8	3	6.8
M10	× 1.5	TB373429	22	70	38	7	5.5	8	4	8.5
M12	× 1.75	TB373509	24	80	45	9	7	10	4	10.2
M14	× 2	TB373549	26	80	45	11	9	12	4	12
M16	× 2	TB373609	27	80	45	12	9	12	4	14
M18	× 2.5	TB373659	30	95	58	14	11	14	4	15.5
M20	× 2.5	TB373709	32	95	58	16	12	15	4	17.5



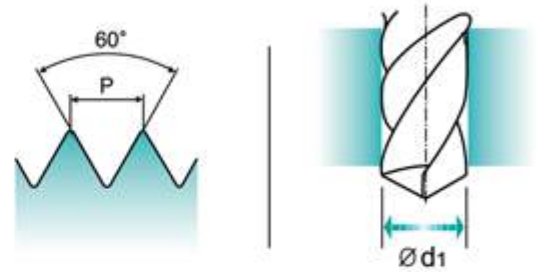
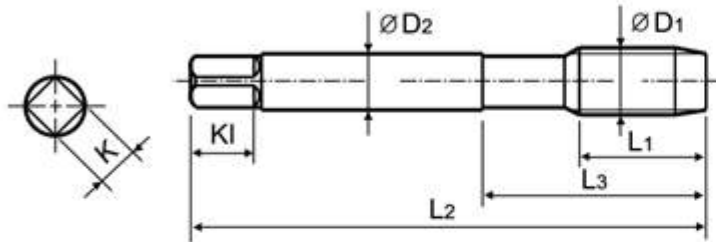
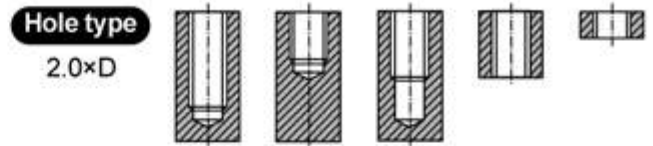
ISO metric coarse threads DIN 13

- Metrisches ISO-Gewinde DIN 13
- ISO MÉTRIQUE DIN13
- ISO Metrico passo grosso DIN 13

Sets of taps
Gewindebohrer-Satz

- This tap is a serial hand tap in set, First, Second and Bottoming.
- Bottoming tap of set has final internal thread dimensions only..

- Dies ist ein Handgewindebohrer im Satz mit Vor-, Mittel- und Fertigschneider.
- Nur der Fertigschneider kann das gewünschte Gewinde schneiden.



Material groups

VG HSS-E DIN 352 6H 60° I/II/III Bright

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	Bright	L1	L2	L3	ØD2	K	KI	Z	Ød1
M3	× 0.5	TC353209	11	40	18	3.5	2.7	6	3	2.5
M3.5	× 0.6	TC353229	13	45	21	4	3	6	3	2.9
M4	× 0.7	TC353249	13	45	21	4.5	3.4	6	3	3.3
M4.5	× 0.75	TC353269	16	50	25	6	4.9	8	3	3.7
M5	× 0.8	TC353289	16	52	26	6	4.9	8	3	4.2
M6	× 1	TC353319	18	56	27	6	4.9	8	3	5
M8	× 1.25	TC353369	20	63	34	6	4.9	8	3	6.8
M10	× 1.5	TC353429	22	70	38	7	5.5	8	4	8.5
M12	× 1.75	TC353509	24	80	45	9	7	10	4	10.2
M14	× 2	TC353549	26	80	45	11	9	12	4	12
M16	× 2	TC353609	27	80	45	12	9	12	4	14
M18	× 2.5	TC353659	30	95	58	14	11	14	4	15.5
M20	× 2.5	TC353709	32	95	58	16	12	15	4	17.5