



PRECISION THREADING TECHNOLOGY



WWW.THREADING-TOOLS.COM



Precision and Quality

Good quality is the best marketing, because satisfied customers underline our success. Our most important principle which inspires us is the commitment for products of the highest standards to meet the requirements of our customers to their utmost satisfaction - a mission we try to fulfill for our corporate philosophy every day.

Our quality check starts with the receipt of goods and continues until the outgoing of the products. At BAER Company customer satisfaction does not come by chance. Ongoing quality testings also influence all new product developments. New ideas and the most modern production facilities improve our products and make them even more precise.



Development and Improvement

Essential for the sustainability of our work is to invest continuously the long-term in new innovative products. Highest efforts in research and development focus on the needs of our customers. Our tools represent practical and reliable solutions which support an efficient and easy application.

Our cooperations with other industries, companies and research institutes make a strong networking possible. New inspirations are created in innovations, are produced, tested and adapted for practice. This way we are always up to the latest standards of knowledge related to thread technologies. All members of our company contribute to our innovations with their individual know-how.



Tradition and Experience

For more than 35 years we have been engaged in what we can do best: threading technology. With this far-reaching treasure trove of experience we have established ourselves as an expert by whom our customers can profit. We are proud to be a family company. Our identification with the company is even stronger and more distinctive. Each customer, each modernization is at the same time an affair of the heart.

Tradition combined with innovation and progress - make us a flexible and competent partner when it is about threading tools. Our claim: to contribute to a successful future and to develop tools which meet all kinds of requirements of our customers.



Distributors

For ensure further deliveries to the customer as soon as possible at home and abroad, we are expanding our distributor network.

BAER-distributors benefit from:

- The largest full range of products - for best price performance ratio
- Quality and reliability - for the highest demands
- Decades of experience in threading technology
- Reliable partnership - flexible and easy
- Sale supporting materials
- Exclusive products
- Exclusive sale territories
- Qualified product and sales trainings
- Attractive terms and conditions
- Innovative products



Content

M Metric coarse thread ISO DIN 13



MF Metric fine thread ISO DIN 13



G(BSP) British standard whitworth pipe thread DIN ISO 228



UNC Unified coarse thread ANSI B1.1



UNF Unified fine thread ANSI B1.1



UNS Unified thread with special threads per inch (TPI)



UNEF Unified extra fine thread ANSI B1.1



8-UN Unified thread series with 8-threads per inch (TPI)



Content

12-UN Unified thread series with 12-threads per inch (TPI)



BSW British standard BS 84 whitworth coarse thread



BSF British standard BS 84 whitworth fine thread



TR Trapezoidal thread DIN 103



NPT National standard taper 1:16 pipe thread ANSI B 1.20.1 & NPTF National standard sealing pipe thread ANSI B 1.20.3



NPS National standard straight pipe thread



RC (BSPT) Whitworth tapered pipe thread DIN 2999 & RP(BSPP) British standard whitworth pipe thread ISO 7-1



BA British Association thread BS 93



W Tapered whitworth DIN 477 for screw sockets taper 3:25



Content

PG Steel Conduit Thread DIN 40430



FG Bicycle thread DIN 79012 & BSC British bicycle thread RS 811



RD Knuckle thread DIN 405 & RMS Royal Microscopical Society DIN 58888



MINI Metric Mini-thread and Nano-thread



CAMERA-Tripod Camera tripod and C-Mount thread DIN 4503



VG Valve thread DIN 7756



Holding Tools & Cutting Oil



Technical Information

p. 142	Tap Geometries	p. 146	Troubleshooting guide for tapping
p. 142	Tap Centering	p. 147	Tap Cutting speeds
p. 143	Tap Construction dimensions	p. 147	Lubrication and cooling
p. 143	Tap Chamfer Forms	p. 148	Formula
p. 144	Tap flutes	p. 149	Round Dies Geometries
p. 145	Tolerances	p. 149	Tolerances for Round Dies
p. 146	Tap Surface Treatments	p. 150	Cutting speeds for Machine Forming Taps

UNiTap

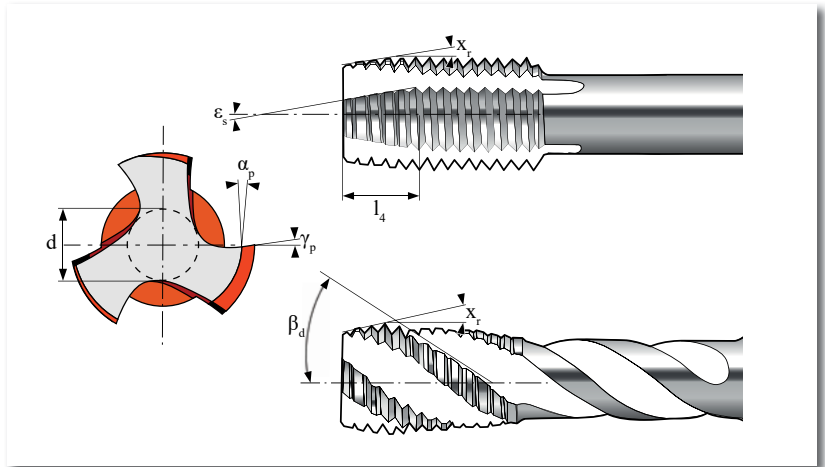
UNiTap - Universal High-End Threading Tap
A real revolution in the production of internal threads

UNiTap - Unique cutting geometry

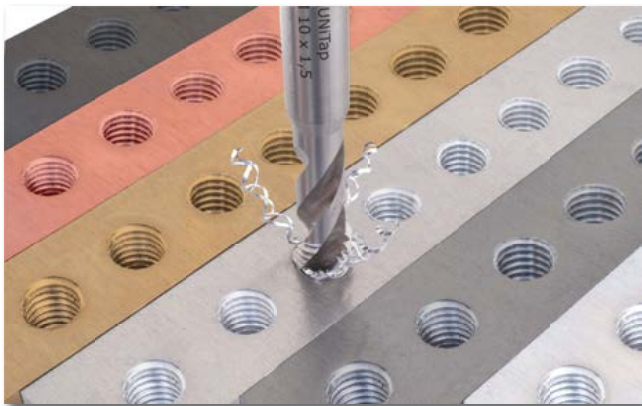
The unique geometry of UNiTap Taps is the result of years of research, which enables the user to machine all materials and makes the tap universally suitable for almost all applications.

During threading an internal thread, the major forces occur at the lead-in chamfer, which is strikingly relieved by structural changes in the UNiTap. The consequence is a reduced torque and a longer life time of the tap. In addition, the areas directly after the lead-in chamfer have been changed to lead the chip optimally and avoid possible jamming. An over-feeding of the thread is also not possible with this profile change.

The design sets new standards in ease of use, durability, and versatility



- for nearly all materials
- for nearly all applications
- excellent cut results
- high tool life time
- unique patented cutting geometry
- ideal tap for all workshops and industrial productions with changing requirements
- huge cost savings - only one threading tool for all applications



A professional for all applications and materials

- Steels and Steel alloys up to 1200 N/mm²
- Stainless Steels; Inoxidable Steels up to 1000 N/mm²; -VA-Steels; INOX; V2A; V4A
- Pure Aluminium; Aluminium Cast and Wrought Alloys
- Grey Cast Iron; Ductile/Nodular/Spheroidal Graphite Cast Iron; Malleable Cast Iron up to 1000 N/mm²
- Pure Titanium and Titanium alloys up to 900 N/mm²
- Pure Nickel and Nickel alloys up 900 N/mm²
- Pure Copper; Copper alloys; Brass; Bronze (all chip lengths)

Cost savings and flexibility

Due to its universal application possibilities, one UNiTap can do the work of several conventional taps. As a result you can save about 90% of expenses.

Comparison of expenses:

Machine Taps M6 for	EUR / pc.
normal steels	6,98
stainless steels	11,68
aluminium and alloys	34,57
cast and grey cast iron	19,64
titanium and alloys	47,30
brass and copper	11,81
total:	131,98

same result with

UNiTap BAER HSSE UNiTap Machine Tap for through holes M 6 x 1,0

17,33 EUR over 85% savings

Coatings

On request, taps are also available with a TIN or TiAlN coating.

The TIN surface treatment (titanium-nitride gold-yellow) increases the surface hardness (approx. 2300 HV) and the sliding properties. As a result, it provides a better cutting performance and an increased tool life time.

The TiAlN surface treatment increases the surface hardness (approx. 3300 HV), the sliding properties (friction coefficient: 0,25) and with the temperature resistance up to 800°C. As a result, it provides a better cutting performance and an increased tool life time.



Examples of application materials and cutting speeds

Soft Iron, Constructional Steel, Free Cutting Steel, Cementation Steel		cutting speed v_c in m/min for machine taps for through holes	cutting speed v_c in m/min for machine taps for blind holes
1.1014	RFe80	25 - 50	25 - 50
1.0570	St52-3	25 - 50	25 - 50
1.0718	9SMnPb28	25 - 50	25 - 50
1.6523	20NiCrMo2	6 - 30	6 - 30

Stainless Steel, Innoxable Steel (ferritic, austenitic, martensitic)		cutting speed v_c in m/min for machine taps for through holes	cutting speed v_c in m/min for machine taps for blind holes
1.4104	X14CrMoS17	12 - 35	12 - 35
1.4301	X5CrNi18-10 (V2A)	12 - 15	12 - 15
1.4571	X6CrNiMoTi17-12-2 (V4A)	12 - 15	12 - 15
1.4125	X105CrMo17	12 - 15	12 - 15

Grey Cast Iron		cutting speed v_c in m/min for machine taps for through holes	cutting speed v_c in m/min for machine taps for blind holes
0.6010	GG10	35 - 50	35 - 50
0.6020	GG20	35 - 50	35 - 50
0.6030	GG30	35 - 50	35 - 50
0.6040	GG40	35 - 50	35 - 50

Pure Titanium and Titanium alloys		cutting speed v_c in m/min for machine taps for through holes	cutting speed v_c in m/min for machine taps for blind holes
3.7024	Ti99.5	3 - 15	3 - 15
3.7034	Ti99.7	3 - 15	3 - 15
3.7165	TiAl6V4	1 - 5	1 - 5
3.7174	TiAl6V4Sn2	1 - 5	1 - 5

Pure Aluminium, Aluminium Cast and Wrought Alloys (all chip lengths)		cutting speed v_c in m/min for machine taps for through holes	cutting speed v_c in m/min for machine taps for blind holes
3.0205	Al99	50 - 65	50 - 65
3.1645	AlCuMgPb	50 - 65	50 - 65
3.2373	G-AlSi9Mg	40 - 65	40 - 65
3.2583	G-AlSi12(Cu)	40 - 65	40 - 65

Carbon Steel, Spring Steel, Alloy Steel, Heat-treatable Steel		cutting speed v_c in m/min for machine taps for through holes	cutting speed v_c in m/min for machine taps for blind holes
1.0503	C45	20 - 30	20 - 30
1.1269	Ck85	20 - 30	20 - 30
1.7218	25CrMo4	6 - 30	6 - 30
1.2344	X40CrMoV5-1	6 - 30	6 - 30

Pure Nickel and Nickel alloys		cutting speed v_c in m/min for machine taps for through holes	cutting speed v_c in m/min for machine taps for blind holes
1.3926	RNi12	3 - 10	3 - 10
2.4668	NiCr19Fe19NbMo (Inconel 718)	3 - 10	3 - 10
2.4630	Ni-Cr20Ti (Nimonic 75)	1 - 5	1 - 5
2.4665	NiCr22Fe18Mo (Hastelloy X)	1 - 5	1 - 5

Ductile/Nodular/Spheroidal Graphite Cast Iron, Malleable Cast Iron		cutting speed v_c in m/min for machine taps for through holes	cutting speed v_c in m/min for machine taps for blind holes
0.7040	GGG40	12 - 45	12 - 45
0.7060	GGG60	12 - 45	12 - 45
0.7070	GGG70	12 - 45	12 - 45
0.8035	GTW35-04	10 - 25	10 - 25

Pure Copper and Copper alloys, Brass, Bronze (all chip lengths)		cutting speed v_c in m/min for machine taps for through holes	cutting speed v_c in m/min for machine taps for blind holes
2.0065	E-Cu 58	50 - 60	50 - 60
2.1247	CuBe2	30 - 65	30 - 65
2.0360	CuZn40	30 - 65	30 - 65
2.1020	CuSn6	12 - 20	12 - 20

cutting speed v_c [m/min] = (diameter * π * number of rotations) / 1000

number of rotations n [1/min] = (cutting speed in m/min * 1000) / (diameter * π)

feed programming [mm/min] = number of rotations * pitch

Please keep in mind that the cutting speeds as stated above serve only as guidelines. The right cutting speed depends on lubrication and application.

Cutting paste, cutting oil or emulsion is recommended.

Custom-made products

Special tools on request

Our customers benefit from our flexibility and our technical know-how when it comes to design and manufacture special threading tools.

- | | |
|-------------------------|---------------------|
| special thread profiles | special Taps |
| special sizes | special Dies |
| intermediate sizes | special material |
| special geometries | express-productions |

Examples of our custom-made products



Custom-made products



Send us your inquiry



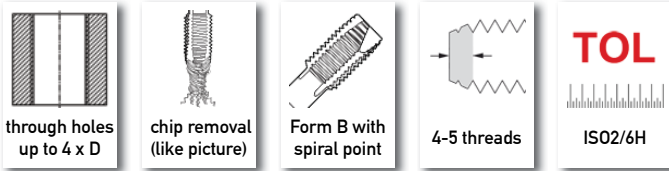
BAER Vertriebs GmbH
Robert-Bosch-Str. 5
68542 Heddesheim
Germany

Tel: +49 (0) 6203 4048 790
Fax: +49 (0) 6203 4048 791
E-Mail: info@gewindebohrer.de
www.threading-tools.com

Thread Cutting Kits UNiTAP

M metric coarse thread
ISO DIN 13

BAER UNiTAP Set M 3 - M 12
HSSE UNiTAP Machine Taps for through holes
incl. HSSE/Co extreme drill bits for core holes



Set Content

BAER UNiTAP HSSE Machine Taps for through holes	M 3 x 0,5 M 4 x 0,7 M 5 x 0,8 M 6 x 1,0 M 8 x 1,25 M 10 x 1,5 M 12 x 1,75
BAER HSSE/Co extreme drill bits for core holes	2,5 mm 3,3 mm 4,2 mm 5,0 mm 6,8 mm 8,5 mm 10,2 mm

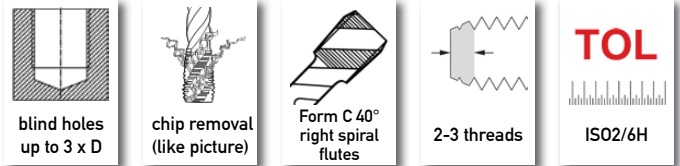


184,00 €
Item No.: UNISD312
net prices without VAT or tax



186,00 €
Item No.: UNISS312
net prices without VAT or tax

BAER UNiTAP Set M 3 - M 12
HSSE UNiTAP Machine Taps for blind holes
incl. HSSE/Co Extreme drill bits for core holes



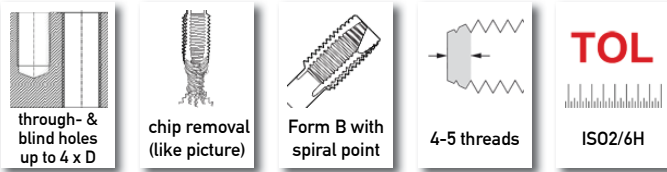
Set Content

BAER UNiTAP HSSE Machine Taps for blind holes	M 3 x 0,5 M 4 x 0,7 M 5 x 0,8 M 6 x 1,0 M 8 x 1,25 M 10 x 1,5 M 12 x 1,75
BAER HSSE/Co extreme drill bits for core holes	2,5 mm 3,3 mm 4,2 mm 5,0 mm 6,8 mm 8,5 mm 10,2 mm

Thread Cutting Kits with Taps

M metric coarse thread
ISO DIN 13

BAER Short Machine Taps Set M 3 - M 12
HSSG Short Machine Taps
incl. HSS drill bits for core holes and tap wrench



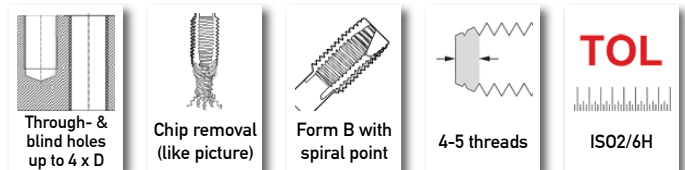
Set Content

BAER HSSG Short Machine Taps	M 3 x 0,5 M 4 x 0,7 M 5 x 0,8 M 6 x 1,0 M 8 x 1,25 M 10 x 1,5 M 12 x 1,75
BAER HSSG Drill bits for core holes	2,5 mm 3,3 mm 4,2 mm 5,0 mm 6,8 mm 8,5 mm 10,2 mm
BAER adjustable Tap Wrenches - zinc die cast	M 1-12 1/16-1/2 G 1/8



54,60 €
Item No.: B1928
net prices without VAT or tax

BAER Short Machine Taps Set M 3 - M 12
HSSG Short Machine Taps (3 pcs. each dimension)
incl. HSS drill bits for core holes



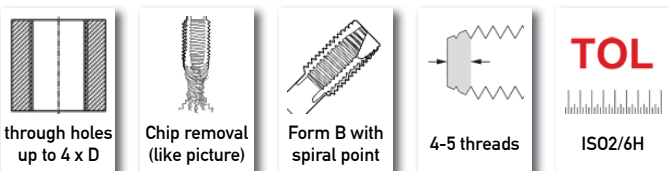
Set Content

BAER HSSG Short Machine Taps 3 pieces each dimension	M 3 x 0,5 M 4 x 0,7 M 5 x 0,8 M 6 x 1,0 M 8 x 1,25 M 10 x 1,5 M 12 x 1,75
BAER HSSG Drill bits for core holes	2,5 mm 3,3 mm 4,2 mm 5,0 mm 6,8 mm 8,5 mm 10,2 mm



100,00 €
Item No.: B1929
net prices without VAT or tax

BAER Machine Taps Set M 3 - M 12
HSSE Machine Taps for through hole
incl. HSS Drill bits for core holes



Set Content

BAER HSSE Machine Taps through hole	M 3 x 0,5 M 4 x 0,7 M 5 x 0,8 M 6 x 1,0 M 8 x 1,25 M 10 x 1,5 M 12 x 1,75
BAER HSSG Drill bits for core holes	2,5 mm 3,3 mm 4,2 mm 5,0 mm 6,8 mm 8,5 mm 10,2 mm



71,60 €
Item No.: B1933E
net prices without VAT or tax

Thread Cutting Kits with Taps

M Metric coarse thread
ISO DIN 13

BAER Machine Taps Set M 3 - M 12
HSSE Machine Taps for blind holes
incl. HSS Drill bits for core holes

blind holes up to 3 x D	Chip removal (like picture)	Form C with right spiral flutes	2-3 threads	ISO2/6H

Set Content

BAER HSSE Machine Taps for blind holes	M 3 x 0,5 M 4 x 0,7 M 5 x 0,8 M 6 x 1,0 M 8 x 1,25 M 10 x 1,5 M 12 x 1,75
BAER HSSG Drill bits for core holes	2,5 mm 3,3 mm 4,2 mm 5,0 mm 6,8 mm 8,5 mm 10,2 mm



82,10 €
Item No.: B1935E
Net prices without VAT or tax



117,90 €
Item No.: B1932
Net prices without VAT or tax

BAER Machine Taps Set M 3 - M 12
HSSE-TIN Machine Taps for through hole
incl. HSS-TIN Drill bits for core holes

through holes up to 4 x D	Chip removal (like picture)	Form B with spiral point	4-5 threads	ISO2/6H

Set Content

BAER HSSE-TIN Machine Taps through hole	M 3 x 0,5 M 4 x 0,7 M 5 x 0,8 M 6 x 1,0 M 8 x 1,25 M 10 x 1,5 M 12 x 1,75
BAER HSSG-TIN Drill bits for core holes	2,5 mm 3,3 mm 4,2 mm 5,0 mm 6,8 mm 8,5 mm 10,2 mm

BAER Machine Taps Set M 3 - M 12
HSSE-TIN Machine Taps for blind holes
incl. HSS-TIN Drill bits for core holes

blind holes up to 3 x D	Chip removal (like picture)	Form C with right spiral flutes	2-3 threads	ISO2/6H

Set Content

BAER HSSE-TIN Machine Taps for blind holes	M 3 x 0,5 M 4 x 0,7 M 5 x 0,8 M 6 x 1,0 M 8 x 1,25 M 10 x 1,5 M 12 x 1,75
BAER HSSG-TIN Drill bits for core holes	2,5 mm 3,3 mm 4,2 mm 5,0 mm 6,8 mm 8,5 mm 10,2 mm

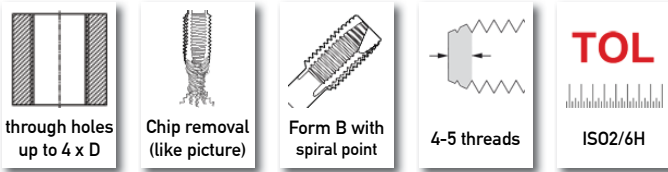


122,10 €
Item No.: B1934
Net prices without VAT or tax

Thread Cutting Kits with Taps

M Metric coarse thread
ISO DIN 13

BAER Machine Taps Set M 3 - M 12 for stainless steel
HSSE Machine Taps for through hole
incl. HSSE/Co Extreme drill bits for core holes



Set Content

BAER HSSE Stainless steel Machine Taps through hole M 3 x 0,5 | M 4 x 0,7 | M 5 x 0,8
M 6 x 1,0 | M 8 x 1,25 | M 10 x 1,5
M 12 x 1,75

BAER HSSE/Co Extreme drill bits for core holes 2,5 mm | 3,3 mm | 4,2 mm | 5,0 mm |
6,8 mm | 8,5 mm | 10,2 mm



118,95 €

Item No.: B1931

Net prices without VAT or tax

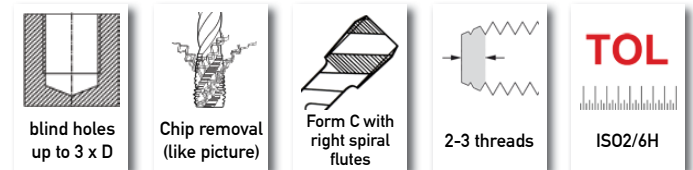


142,10 €

Item No.: B1930

Net prices without VAT or tax

BAER Machine Taps Set M 3 - M 12 for stainless steel
HSSE Machine Taps for blind holes
incl. HSSE/Co Extreme drill bits for core holes

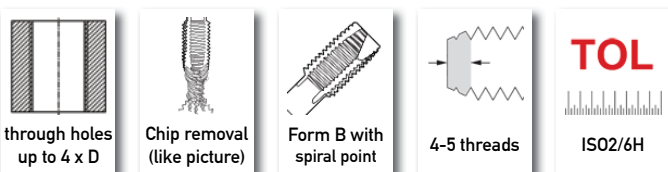


Set Content

BAER HSSE Stainless steel Machine Taps for blind holes M 3 x 0,5 | M 4 x 0,7 | M 5 x 0,8
M 6 x 1,0 | M 8 x 1,25 | M 10 x 1,5
M 12 x 1,75

BAER HSSE/Co Extreme drill bits for core holes 2,5 mm | 3,3 mm | 4,2 mm | 5,0 mm |
6,8 mm | 8,5 mm | 10,2 mm

BAER Machine Taps Set M 3 - M 12 Left Hand
HSSE Machine Taps for through hole
incl. HSS Drill bits for core holes



Set Content

BAER HSSE Left Machine Taps through hole M 3 x 0,5 | M 4 x 0,7 | M 5 x 0,8
M 6 x 1,0 | M 8 x 1,25 | M 10 x 1,5
M 12 x 1,75

BAER HSSG Drill bits for core holes 2,5 mm | 3,3 mm | 4,2 mm | 5,0 mm |
6,8 mm | 8,5 mm | 10,2 mm



163,00 €

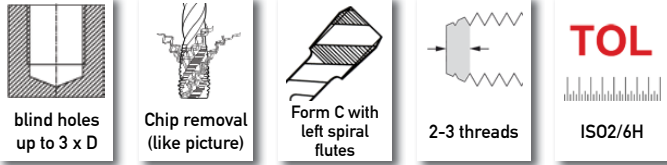
Item No.: B1936E

Net prices without VAT or tax

Thread Cutting Kits with Taps

M Metric coarse thread
ISO DIN 13

BAER Machine Taps Set M 3 - M 12 Left Hand
HSSE Machine Taps for blind holes
incl. HSS Drill bits for core holes



Set Content

BAER HSSE Left Machine Taps for blind holes
M 3 x 0,5 | M 4 x 0,7 | M 5 x 0,8
M 6 x 1,0 | M 8 x 1,25 | M 10 x 1,5
M 12 x 1,75

BAER HSSG Drill bits for core holes
2,5 mm | 3,3 mm | 4,2 mm | 5,0 mm |
6,8 mm | 8,5 mm | 10,2 mm



171,00 €
Item No.: B1937E
Net prices without VAT or tax



42,00 €
Item No.: B1938
Net prices without VAT or tax

BAER Bit Short Machine Taps Set M 3 - M 10
HSSG-Bit Taps
incl. Bit-Adapter

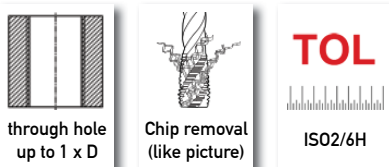


Set Content

BAER HSSG-Bit Short Machine Taps
M 3 x 0,5 | M 4 x 0,7 | M 5 x 0,8
M 6 x 1,0 | M 8 x 1,25 | M 10 x 1,5

1/4" Hexagonal-Bit-Adapter

BAER Combined Bit Taps Set M 3 - M 10
HSSG-Combined Bit Taps
incl. Bit-Adapter



Set Content

BAER HSSG-Combined Bit-Taps
M 3 x 0,5 | M 4 x 0,7 | M 5 x 0,8
M 6 x 1,0 | M 8 x 1,25 | M 10 x 1,5

1/4" Hexagonal-Bit-Adapter



60,00 €
Item No.: B1939
Net prices without VAT or tax

Thread Cutting Kits with Taps and Dies

M Metric coarse thread
ISO DIN 13

BAER Taps and Dies Sets M 3 - M 12 (example picture)



BAER UNITap Set M 3 - M 12 HSSE UNITap Machine Taps through hole & blind hole HSSE Round Dies				€/Set
BAER UNITap HSSE Machine Taps for through hole (up to 4 x D)	M 3 x 0,5 M 4 x 0,7 M 5 x 0,8 M 6 x 1,0 M 8 x 1,25 M 10 x 1,5 M 12 x 1,75	483,00 € No.: BB12U		
BAER UNITap HSSE Machine Taps for blind holes (up to 3 x D)	M 3 x 0,5 M 4 x 0,7 M 5 x 0,8 M 6 x 1,0 M 8 x 1,25 M 10 x 1,5 M 12 x 1,75			
BAER HSSE Round Dies with spiral entry	M 3 x 0,5 M 4 x 0,7 M 5 x 0,8 M 6 x 1,0 M 8 x 1,25 M 10 x 1,5 M 12 x 1,75			

BAER Set M 3 - M 12 HSSE Machine Taps & Drill bits for core holes HSS Round Dies				€/Set
BAER HSSE Machine Taps Form C for through hole & blind hole (up to 2 x D)	M 3 x 0,5 M 4 x 0,7 M 5 x 0,8 M 6 x 1,0 M 8 x 1,25 M 10 x 1,5 M 12 x 1,75	173,00 € No.: BB2E		
BAER HSSG Drill bits for core holes	2,5 mm 3,3 mm 4,2 mm 5,0 mm 6,8 mm 8,5 mm 10,2 mm			
BAER HSS Round Dies	M 3 x 0,5 M 4 x 0,7 M 5 x 0,8 M 6 x 1,0 M 8 x 1,25 M 10 x 1,5 M 12 x 1,75			

BAER Set M 3 - M 12 HSSE Machine Taps through hole & blind hole HSS Round Dies				€/Set
BAER HSSE Machine Taps Form B with spiral point for through hole (up to 4 x D)	M 3 x 0,5 M 4 x 0,7 M 5 x 0,8 M 6 x 1,0 M 8 x 1,25 M 10 x 1,5 M 12 x 1,75	220,00 € No.: BB1E		
BAER HSSE Machine Taps Form C with right spiral flutes for blind holes (up to 3 x D)	M 3 x 0,5 M 4 x 0,7 M 5 x 0,8 M 6 x 1,0 M 8 x 1,25 M 10 x 1,5 M 12 x 1,75			
BAER HSS Round Dies	M 3 x 0,5 M 4 x 0,7 M 5 x 0,8 M 6 x 1,0 M 8 x 1,25 M 10 x 1,5 M 12 x 1,75			

BAER Left Hand Set M 3 - M 12 HSSE Left Hand Machine Taps & Drill bits for core holes HSS Left Hand Round Dies				€/Set
BAER HSSE Machine Taps Left Form C for through hole & blind hole (up to 2 x D)	M 3 x 0,5 M 4 x 0,7 M 5 x 0,8 M 6 x 1,0 M 8 x 1,25 M 10 x 1,5 M 12 x 1,75	241,00 € No.: BB7E		
BAER HSSG Drill bits for core holes	2,5 mm 3,3 mm 4,2 mm 5,0 mm 6,8 mm 8,5 mm 10,2 mm			
BAER HSS Round Dies Left	M 3 x 0,5 M 4 x 0,7 M 5 x 0,8 M 6 x 1,0 M 8 x 1,25 M 10 x 1,5 M 12 x 1,75			

BAER TIN Set M 3 - M 12 HSSE-TIN Machine Taps through hole & blind hole HSS Round Dies				€/Set
BAER HSSE-TIN Machine Taps Form B with spiral point for through hole (up to 4 x D)	M 3 x 0,5 M 4 x 0,7 M 5 x 0,8 M 6 x 1,0 M 8 x 1,25 M 10 x 1,5 M 12 x 1,75	250,00 € No.: BB4		
BAER HSSE-TIN Machine Taps Form C with right spiral flutes for blind holes (up to 3 x D)	M 3 x 0,5 M 4 x 0,7 M 5 x 0,8 M 6 x 1,0 M 8 x 1,25 M 10 x 1,5 M 12 x 1,75			
BAER HSS Round Dies	M 3 x 0,5 M 4 x 0,7 M 5 x 0,8 M 6 x 1,0 M 8 x 1,25 M 10 x 1,5 M 12 x 1,75			

BAER Stainless steel Set M 3 - M 12 HSSE-Stainless steel Machine Taps through hole & blind hole HSSE-Stainless steel Round Dies				€/Set
BAER HSSE Stainless steel Machine Taps for through hole (up to 4 x D)	M 3 x 0,5 M 4 x 0,7 M 5 x 0,8 M 6 x 1,0 M 8 x 1,25 M 10 x 1,5 M 12 x 1,75	345,00 € No.: BB9		
BAER HSSE Stainless steel Machine Taps for blind holes (up to 3 x D)	M 3 x 0,5 M 4 x 0,7 M 5 x 0,8 M 6 x 1,0 M 8 x 1,25 M 10 x 1,5 M 12 x 1,75			
BAER HSSE Stainless steel Round Dies	M 3 x 0,5 M 4 x 0,7 M 5 x 0,8 M 6 x 1,0 M 8 x 1,25 M 10 x 1,5 M 12 x 1,75			

Thread Cutting Kits with Taps, Dies and Tools

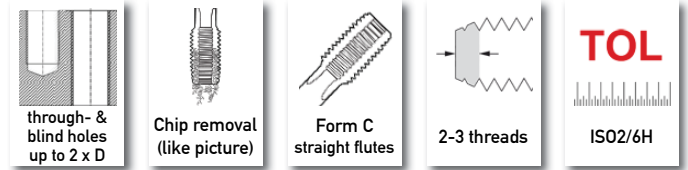
M Metric coarse thread
ISO DIN 13

BAER Hand-Tap Sets, Round Dies and Tools Sets



M 3 - 12 Standard	M 3 - 12 Left	M 3 - 12 stainless steels*
230,00 €	276,80 €	460,00 €
Item No.: 10360009046	Item No.: 10360009046LH	Item No.: 10360009046VA

* contains HSSE Taps and Dies



Set Content M 3 - M 12

BAER HSSG Hand Tap Sets (3 parts)	M 3 x 0,5 M 4 x 0,7 M 5 x 0,8 M 6 x 1,0 M 8 x 1,25 M 10 x 1,5 M 12 x 1,75
BAER HSS Round Dies acc. to DIN	M 3 x 0,5 M 4 x 0,7 M 5 x 0,8 M 6 x 1,0 M 8 x 1,25 M 10 x 1,5 M 12 x 1,75
BAER HSSG Drill bits for core holes	2,5 mm 3,3 mm 4,2 mm 5,0 mm 6,8 mm 8,5 mm 10,2 mm
BAER adjustable Tap Wrenches	M 1-10 1/16-3/8 G 1/8 M 4-12 5/32-1/2 G 1/8
BAER Die Stocks	20 x 5 20 x 7 25 x 9 30 x 11 38 x 14
BAER Tap Holder Ratchet	M 3-10 M 5-12
Thread pitch gauge	for metric threads
Screw extractor	



M 3 - 20 Standard	M 3 - 20 Left	M 3 - 20 stainless steels*
362,00 €	579,00 €	950,00 €
Item No.: 10360009146	Item No.: 10360009146LH	Item No.: 10360009146VA

* contains HSSE Taps and Dies

Set Content M 3 - M 20

BAER HSSG Hand Tap Sets (3 parts)	M 3 x 0,5 M 4 x 0,7 M 5 x 0,8 M 6 x 1,0 M 8 x 1,25 M 10 x 1,5 M 12 x 1,75 M 14 x 2,0 M 16 x 2,0 M 18 x 2,5 M 20 x 2,5
BAER HSS Round Dies acc. to DIN	M 3 x 0,5 M 4 x 0,7 M 5 x 0,8 M 6 x 1,0 M 8 x 1,25 M 10 x 1,5 M 12 x 1,75 M 14 x 2,0 M 16 x 2,0 M 18 x 2,5 M 20 x 2,5
BAER adjustable Tap Wrenches	M 1-10 1/16-3/8 G 1/8 M 5-20 7/32-3/4 G 1/8-G 1/2
BAER Die Stocks	20 x 5 20 x 7 25 x 9 30 x 11 38 x 14 45 x 18
BAER Tap Holder Ratchet	M 3-10 M 5-12
Thread pitch gauge	for metric threads
Screw extractor	

Thread Cutting Kits with Taps, Dies and Tools

M Metric coarse thread
ISO DIN 13

BAER Hand-Tap Sets, Round Dies and Tools Sets (example picture)



BAER Set M 3 - M 12 (incl. intermediate sizes) HSSG Hand Tap Sets & HSS Round Dies & Tools

		€/Set
BAER HSSG Hand Tap Sets (3 parts)	M 3 x 0,5 M 4 x 0,7 M 5 x 0,8 M 6 x 1,0 M 7 x 1,0 M 8 x 1,25 M 9 x 1,25 M 10 x 1,5 M 11 x 1,5 M 12 x 1,75	374,00 € Item No.: 264800301
BAER HSS Round Dies	M 3 x 0,5 M 4 x 0,7 M 5 x 0,8 M 6 x 1,0 M 7 x 1,0 M 8 x 1,25 M 9 x 1,25 M 10 x 1,5 M 11 x 1,5 M 12 x 1,75	
BAER adjustable Tap Wrenches - zinc die cast	M 1-10 1/16-3/8 G 1/8 & M 4-12 5/32-1/2 G 1/8	
BAER Die Stocks - zinc die cast	20 x 5 20 x 7 25 x 9 30 x 11 38 x 14	
Screw extractor		

BAER Set M 5 - M 12 (incl. intermediate sizes) HSSG Hand Tap Sets & HSS Round Dies & Tools

		€/Set
BAER HSSG Hand Tap Sets (3 parts)	M 5 x 0,8 M 6 x 1,0 M 7 x 1,0 M 8 x 1,25 M 9 x 1,25 M 10 x 1,5 M 11 x 1,5 M 12 x 1,75	434,80 € Item No.: 264800401
BAER HSS Round Dies	M 5 x 0,8 M 6 x 1,0 M 7 x 1,0 M 8 x 1,25 M 9 x 1,25 M 10 x 1,5 M 11 x 1,5 M 12 x 1,75	
BAER adjustable Tap Wrenches - zinc die cast	M 1-10 1/16-3/8 G 1/8 & M 4-12 5/32-1/2 G 1/8	
BAER Die Stocks - zinc die cast	20 x 7 25 x 9 30 x 11 38 x 14	
Screw extractor		

BAER Set M 5 - M 20 (incl. intermediate sizes) HSSG Hand Tap Sets & HSS Round Dies & Tools

		€/Set
BAER HSSG Hand Tap Sets (3 parts)	M 5 x 0,8 M 6 x 1,0 M 7 x 1,0 M 8 x 1,25 M 9 x 1,25 M 10 x 1,5 M 11 x 1,5 M 12 x 1,75 M 14 x 2,0 M 16 x 2,0 M 18 x 2,5 M 20 x 2,5	564,80 € Item No.: 264800501
BAER HSS Round Dies	M 5 x 0,8 M 6 x 1,0 M 7 x 1,0 M 8 x 1,25 M 9 x 1,25 M 10 x 1,5 M 11 x 1,5 M 12 x 1,75 M 14 x 2,0 M 16 x 2,0 M 18 x 2,5 M 20 x 2,5	
BAER adjustable Tap Wrenches - zinc die cast	M 1-10 1/16-3/8 G 1/8 & M 5-20 7/32-3/4 G 1/8-G 1/2	
BAER Die Stocks - zinc die cast	20 x 7 25 x 9 30 x 11 38 x 14 45 x 18	
Screw extractor		

BAER Set M 3 - M 24 HSSG Hand Tap Sets & HSS Round Dies & Tools

		€/Set
BAER HSSG Hand Tap Sets (3 parts)	M 3 x 0,5 M 4 x 0,7 M 5 x 0,8 M 6 x 1,0 M 8 x 1,25 M 10 x 1,5 M 12 x 1,75 M 14 x 2,0 M 16 x 2,0 M 18 x 2,5 M 20 x 2,5 M 22 x 2,5 M 24 x 3,0	764,80 € Item No.: 264800601
BAER HSS Round Dies	M 3 x 0,5 M 4 x 0,7 M 5 x 0,8 M 6 x 1,0 M 8 x 1,25 M 10 x 1,5 M 12 x 1,75 M 14 x 2,0 M 16 x 2,0 M 18 x 2,5 M 20 x 2,5 M 22 x 2,5 M 24 x 3,0	
BAER adjustable Tap Wrenches - zinc die cast	M 1-10 1/16-3/8 G 1/8 & M 11-27 7/16-1" G 1/4-G 3/4	
BAER Die Stocks - zinc die cast	20 x 5 20 x 7 25 x 9 30 x 11 38 x 14 45 x 18 55 x 22	
Screw extractor		

BAER Set M 5 - M 30 HSSG Hand Tap Sets & HSS Round Dies & Tools

		€/Set
BAER HSSG Hand Tap Sets (3 parts)	M 5 x 0,8 M 6 x 1,0 M 8 x 1,25 M 10 x 1,5 M 12 x 1,75 M 14 x 2,0 M 16 x 2,0 M 18 x 2,5 M 20 x 2,5 M 22 x 2,5 M 24 x 3,0 M 27 x 3,0 M 30 x 3,5	1345,00 € Item No.: 264800701
BAER HSS Round Dies	M 5 x 0,8 M 6 x 1,0 M 8 x 1,25 M 10 x 1,5 M 12 x 1,75 M 14 x 2,0 M 16 x 2,0 M 18 x 2,5 M 20 x 2,5 M 22 x 2,5 M 24 x 3,0 M 27 x 3,0 M 30 x 3,5	
BAER adjustable Tap Wrenches - zinc die cast	M 1-10 1/16-3/8 G 1/8 & M 5-20 7/32-3/4" G 1/8-G 1/2 & M 13-32 1/2-1.1/4" G 1/4-1"	
BAER Die Stocks - zinc die cast	20 x 7 25 x 9 30 x 11 38 x 14 45 x 18 55 x 22 65 x 25	
Screw extractor		

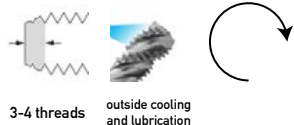
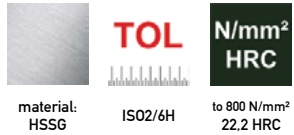
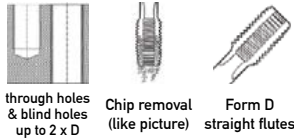
Short Machine Taps

M Metric coarse thread
ISO DIN 13

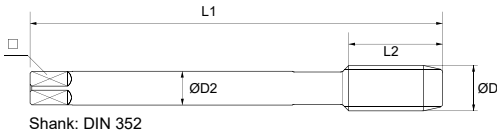
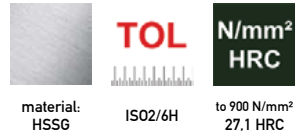
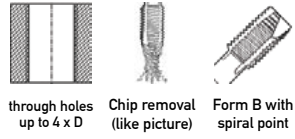
Efficient internal thread cutting.
The short structural type makes that tap usable by machine and hand.

Application:
non abrasive material up to 900 N/mm²
unalloyed and low alloyed steel

Short Machine Taps Form D for through holes and blind holes



Short Machine Taps Form B for through holes



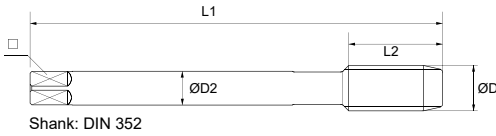
M	D1	D2	L1	L2	□		No.	€	No.	€
M 2 x 0,4	2,0	2,8	36	8	2,1	1,60	110101001	7,14	110201001	7,26
M 2,5 x 0,45	2,5	2,8	40	9	2,1	2,05	110101002	7,14	110201002	7,26
M 3 x 0,5	3,0	3,5	40	11	2,7	2,50	110101003	3,85	110201003	4,10
M 3,5 x 0,6	3,5	4,0	45	13	3,0	2,90	110101004	4,24	110201004	4,50
M 4 x 0,7	4,0	4,5	45	13	3,4	3,30	110101005	3,85	110201005	4,10
M 5 x 0,8	5,0	6,0	50	16	4,9	4,20	110101006	3,96	110201006	4,21
M 6 x 1,0	6,0	6,0	50	19	4,9	5,00	110101007	4,29	110201007	4,56
M 8 x 1,25	8,0	6,0	56	22	4,9	6,80	110101008	5,49	110201008	5,38
M 10 x 1,5	10,0	7,0	70	24	5,5	8,50	110101009	6,42	110201009	6,44
M 12 x 1,75	12,0	9,0	75	29	7,0	10,20	110101010	9,07	110201010	9,12
M 14 x 2,0	14,0	11,0	80	30	9,0	12,00	110101011	11,15	110201011	11,11
M 16 x 2,0	16,0	12,0	80	32	9,0	14,00	110101012	15,25	110201012	15,20
M 18 x 2,5	18,0	14,0	95	40	11,0	15,50	110101013	19,25	110201013	18,71
M 20 x 2,5	20,0	16,0	95	40	12,0	17,50	110101014	21,12	110201014	20,58
M 22 x 2,5	22,0	18,0	100	40	14,5	19,50	110101015	29,46	110201015	29,23
M 24 x 3,0	24,0	18,0	110	50	14,5	21,00	110101016	34,65	110201016	32,75
M 27 x 3,0	27,0	20,0	110	50	16,0	24,00	110101017	44,75	110201017	45,02
M 30 x 3,5	30,0	22,0	125	56	18,0	26,50	110101018	62,70	110201018	59,64

Hand Tap Sets

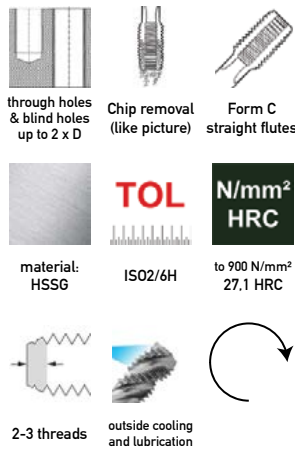
M Metric coarse thread
ISO DIN 13

Efficient internal thread cutting.
The short structural type makes that tap usable by hand.

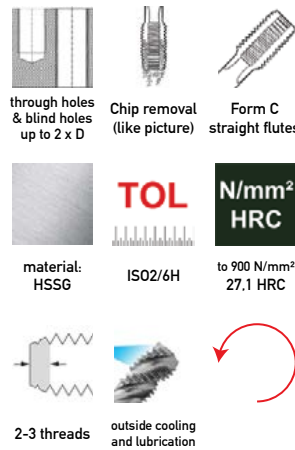
A Hand-Tap-Set includes 3 taps:
Taper Tap
Intermediate Tap
Finish Tap



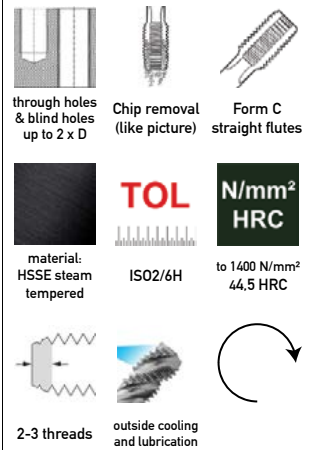
Hand Tap Sets for general use



Hand Tap Sets for general use Left Hand



Hand Tap Sets for stainless steels



M	D1	D2	L1	L2	□		No.	€	No.	€	No.	€
M 1 x 0,25	1,0	2,5	32	6	2,1	0,75	110301001	20,05				
M 1,1 x 0,25	1,1	2,5	32	6	2,1	0,85	110301002	20,05				
M 1,2 x 0,25	1,2	2,5	32	6	2,1	0,95	110301003	20,05				
M 1,4 x 0,3	1,4	2,5	32	7	2,1	1,10	110301004	20,05				
M 1,6 x 0,35	1,6	2,5	32	8	2,1	1,25	110301005	20,05				
M 1,7 x 0,35	1,7	2,5	32	8	2,1	1,30	110301006	20,05				
M 1,8 x 0,35	1,8	2,5	32	8	2,1	1,45	110301007	20,05				
M 2 x 0,4	2,0	2,8	36	8	2,1	1,60	110301008	14,68				
M 2,2 x 0,45	2,2	2,8	36	9	2,1	1,75	110301009	14,68				
M 2,3 x 0,4	2,3	2,8	36	9	2,1	1,90	110301010	14,68				
M 2,5 x 0,45	2,5	2,8	40	9	2,1	2,05	110301011	14,68				
M 2,6 x 0,45	2,6	2,8	40	9	2,1	2,10	110301012	14,68				
M 3 x 0,5	3,0	3,5	40	11	2,7	2,50	110301013	7,60	110302001	13,02	110305001	23,05
M 3 x 0,6 *	3,0	3,5	40	11	2,7	2,40	110301014	39,60				
M 3,5 x 0,6	3,5	4,0	45	13	3,0	2,90	110301015	11,35				
M 3,5 x 0,75 *	3,5	4,0	45	13	3,0	2,75	110301016	196,35				
M 4 x 0,7	4,0	4,5	45	13	3,4	3,30	110301017	7,60	110302002	13,02	110305002	23,40
M 4 x 0,75	4,0	4,5	45	13	3,4	3,25	110301018	41,00				
M 4,5 x 0,75	4,5	6,0	50	16	4,9	3,70	110301019	11,35				
M 5 x 0,8	5,0	6,0	50	16	4,9	4,20	110301020	8,25	110302003	15,03	110305003	24,70
M 5 x 0,9 *	5,0	6,0	50	16	4,9	4,10	110301021	45,00				
M 5,5 x 0,9	5,5	6,0	50	18	4,9	4,60	110301022	13,70				
M 6 x 1,0	6,0	6,0	50	19	4,9	5,00	110301023	8,25	110302004	15,68	110305004	24,70
M 7 x 1,0	7,0	6,0	50	19	4,9	6,00	110301024	13,69				
M 8 x 1,25	8,0	6,0	56	22	4,9	6,80	110301025	10,68	110302005	17,69	110305005	33,70
M 9 x 1,25	9,0	7,0	63	22	5,5	7,80	110301026	18,36				
M 10 x 1,5	10,0	7,0	70	24	5,5	8,50	110301027	14,36	110302006	24,36	110305006	44,10
M 11 x 1,5	11,0	8,0	70	24	6,2	9,50	110301028	23,37				
M 12 x 1,75	12,0	9,0	75	29	7,0	10,20	110301029	18,70	110302007	31,71	110305007	54,30
M 14 x 2,0	14,0	11,0	80	30	9,0	12,00	110301030	21,36	110302008	35,38		

* special pitch

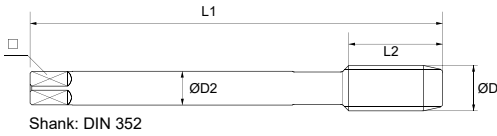
M	MF	G (BSP)	UNC	UNF	UNS	UNEF	8 UN	12 UN	BSW	BSF	TR	NPT	NPS	RC	BA	W	PG	FG BSC	RD RMS	MINI	Camera (Tripod)	VG	Tools	Techn. Information
---	----	---------	-----	-----	-----	------	------	-------	-----	-----	----	-----	-----	----	----	---	----	--------	--------	------	-----------------	----	-------	--------------------

Hand Tap Sets

M Metric coarse thread
ISO DIN 13

Efficient internal thread cutting.
The short structural type makes that tap usable by hand.

A Hand-Tap-Set includes 3 taps:
Taper Tap
Intermediate Tap
Finish Tap



Hand Tap Sets for general use

through holes & blind holes up to 2 x D

Chip removal (like picture)

Form C straight flutes

material: HSSG ISO2/6H

N/mm² HRC to 900 N/mm² 27,1 HRC

2-3 threads outside cooling and lubrication

Hand Tap Sets for general use **Left Hand**

through holes & blind holes up to 2 x D

Chip removal (like picture)

Form C straight flutes

material: HSSG ISO2/6H

N/mm² HRC to 900 N/mm² 27,1 HRC

2-3 threads outside cooling and lubrication

Hand Tap Sets for stainless steels

through holes & blind holes up to 2 x D

Chip removal (like picture)

Form C straight flutes

material: HSSE steam tempered ISO2/6H

N/mm² HRC to 1400 N/mm² 44,5 HRC

2-3 threads outside cooling and lubrication



M	D1	D2	L1	L2	□		No.	€	No.	€	No.	€
M 15 x 2,0	15,0	12,0	80	32	9,0	13,00	110301031	25,37				
M 16 x 2,0	16,0	12,0	80	32	9,0	14,00	110301032	26,70	110302009	44,06		
M 18 x 2,5	18,0	14,0	95	40	11,0	15,50	110301033	35,05	110302010	56,74		
M 20 x 2,5	20,0	16,0	95	40	12,0	17,50	110301034	40,06	110302011	63,43		
M 22 x 2,5	22,0	18,0	100	40	14,5	19,50	110301035	50,06	110302012	77,44		
M 24 x 3,0	24,0	18,0	110	50	14,5	21,00	110301036	60,08	110302013	96,80		
M 27 x 3,0	27,0	20,0	110	50	16,0	24,00	110301037	93,46	110302014	156,88		
M 30 x 3,5	30,0	22,0	125	56	18,0	26,50	110301038	126,84	110302015	193,59		
M 33 x 3,5	33,0	25,0	125	56	20,0	29,50	110301039	163,56	110302016	260,37		
M 36 x 4,0	36,0	28,0	150	63	22,0	32,00	110301040	196,93	110302017	313,77		
M 39 x 4,0	39,0	32,0	150	63	24,0	35,00	110301041	253,68	110302018	400,53		
M 42 x 4,5	42,0	32,0	150	63	24,0	37,50	110301042	283,73	110302019	520,20		
M 45 x 4,5	45,0	36,0	160	70	29,0	40,50	110301043	343,79	110302020	550,77		
M 48 x 5,0	48,0	36,0	180	75	29,0	43,00	110301044	487,35	110302021	781,10		
M 52 x 5,0	52,0	40,0	180	75	32,0	47,00	110301045	487,35	110302022	781,10		
M 56 x 5,5	56,0	45,0	200	85	35,0	50,50	110301046	617,52				
M 60 x 5,5	60,0	45,0	200	85	35,0	54,50	110301047	841,17				
M 64 x 6,0	64,0	50,0	220	90	39,0	58,00	110301048	934,60				
M 68 x 6,0	68,0	50,0	220	90	39,0	62,00	110301049	1168,21				
M 72 x 6,0	72,0	50,0	240	80	39,0	66,00	110301050	*				
M 76 x 6,0	76,0	50,0	240	80	39,0	70,00	110301051	*				
M 80 x 6,0	80,0	50,0	260	85	39,0	74,00	110301052	*				
M 84 x 6,0	84,0	50,0	260	85	39,0	78,00	110301053	*				
M 88 x 6,0	88,0	50,0	260	85	39,0	82,00	110301054	*				
M 90 x 6,0	90,0	50,0	260	85	39,0	84,00	110301055	*				
M 92 x 6,0	92,0	56,0	280	90	44,0	86,00	110301056	*				
M 96 x 6,0	96,0	56,0	280	90	44,0	90,00	110301057	*				
M 100 x 6,0	100,0	56,0	280	90	44,0	94,00	110301058	*				

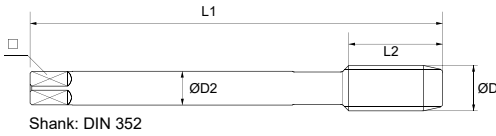
* on request

Hand Tap Sets

M Metric coarse thread
ISO DIN 13

Efficient internal thread cutting.
The short structural type makes that tap usable by hand.

A Hand-Tap-Set includes 3 taps:
Taper Tap
Intermediate Tap
Finish Tap



Hand Tap Sets with conical profile

through holes & blind holes up to 2 x D

Chip removal (like picture)

Form C straight flutes

material: HSSG

ISO2/6H

to 900 N/mm² 27,1 HRC

2-3 threads

outside cooling and lubrication

Hand Tap Sets for higher demands

HSSE

through holes & blind holes up to 2 x D

Chip removal (like picture)

Form C straight flutes

material: HSSE

ISO2/6H

to 1000 N/mm² 32 HRC

2-3 threads

outside cooling and lubrication



M	D1	D2	L1	L2	□		No.	€	No.	€
M 2 x 0,4	2,0	2,8	36	8	2,1	1,60	110313001	14,85		
M 2,5 x 0,45	2,5	2,8	40	9	2,1	2,05	110313002	14,85		
M 3 x 0,5	3,0	3,5	40	11	2,7	2,50	110313003	7,76	110304001	14,30
M 4 x 0,7	4,0	4,5	45	13	3,4	3,30	110313004	7,76	110304002	14,63
M 5 x 0,8	5,0	6,0	50	16	4,9	4,20	110313005	8,44	110304003	15,29
M 6 x 1,0	6,0	6,0	50	19	4,9	5,00	110313006	8,44	110304004	15,29
M 8 x 1,25	8,0	6,0	56	22	4,9	6,80	110313007	10,80	110304005	20,94
M 9 x 1,25	9,0	7,0	63	22	5,5	7,80	110313008	18,56		
M 10 x 1,5	10,0	7,0	70	24	5,5	8,50	110313009	14,51	110304006	27,27
M 11 x 1,5	11,0	8,0	70	24	6,2	9,50	110313010	23,63		
M 12 x 1,75	12,0	9,0	75	29	7,0	10,20	110313011	18,90	110304007	33,90
M 13 x 1,75	12,0	9,0	75	29	7,0	11,20	110313012	26,33		
M 14 x 2,0	14,0	11,0	80	30	9,0	12,00	110313013	21,60	110304008	38,57
M 16 x 2,0	16,0	12,0	80	32	9,0	14,00	110313014	27,00	110304009	49,87
M 18 x 2,5	18,0	14,0	95	40	11,0	15,50	110313015	35,44	110304010	63,17
M 19 x 2,5	18,0	14,0	95	40	11,0	16,50	110313016	48,93		
M 20 x 2,5	20,0	16,0	95	40	12,0	17,50	110313017	40,50	110304011	73,13
M 22 x 2,5	22,0	18,0	100	40	14,5	19,50	110313018	50,63	110304012	88,10
M 24 x 3,0	24,0	18,0	110	50	14,5	21,00	110313019	60,75	110304013	109,70
M 27 x 3,0	27,0	20,0	110	50	16,0	24,00	110313020	94,50	110304014	166,21
M 30 x 3,5	30,0	22,0	125	56	18,0	26,50	110313021	128,24	110304015	226,07
M 33 x 3,5	33,0	25,0	125	56	20,0	29,50	110313022	165,37		
M 36 x 4,0	36,0	28,0	150	63	22,0	32,00	110313023	199,13		
M 39 x 4,0	39,0	32,0	150	63	24,0	35,00	110313024	256,51		
M 42 x 4,5	42,0	32,0	150	63	24,0	37,50	110313025	286,88		

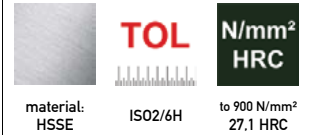
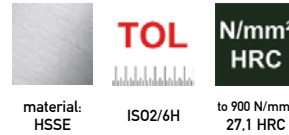
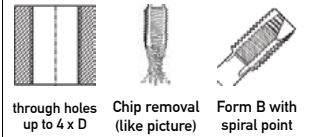
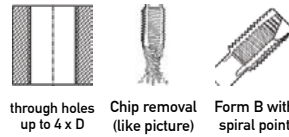
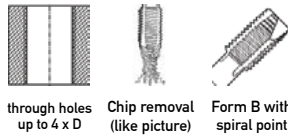
Machine Taps - Form B for through holes

M Metric coarse thread
ISO DIN 13

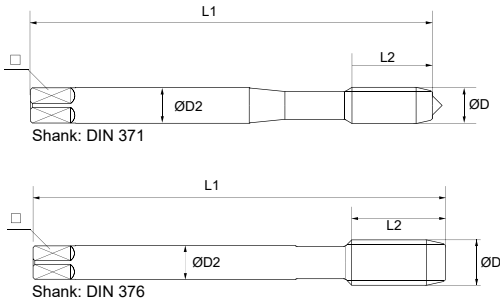
Machine Tap
UNITAP for universal use

Machine Tap
for general use

Machine Tap
for general use
Left-hand thread



Tap for machine use in through hole.
The spiral point pushes the chips ahead.



M	D1	D2	L1	L2	□		No.	€	No.	€	No.	€
DIN 371												
M 2 x 0,4	2,0	2,8	45	8	2,1	1,60	110403001	25,90	110401001	8,31		
M 2,2 x 0,45	2,2	2,8	45	8	2,1	1,75	110403002	28,78				
M 2,5 x 0,45	2,5	2,8	50	9	2,1	2,05	110403003	21,99	110401002	8,31		
M 3 x 0,5	3,0	3,5	56	11	2,7	2,50	110403004	16,80	110401003	6,53	110402001	12,25
M 3,5 x 0,6	3,5	4,0	56	13	3,0	2,90	110403005	19,90	110401004	7,20		
M 4 x 0,7	4,0	4,5	63	13	3,4	3,30	110403006	16,17	110401005	6,53	110402002	12,25
M 5 x 0,8	5,0	6,0	70	16	4,9	4,20	110403007	16,80	110401006	6,98	110402003	12,80
M 6 x 1,0	6,0	6,0	80	19	4,9	5,00	110403008	17,33	110401007	6,98	110402004	12,80
M 7 x 1,0	7,0	7,0	80	19	5,5	6,00			110401008	9,98	110402005	16,60
M 8 x 1,25	8,0	8,0	90	22	6,2	6,80	110403009	20,20	110401009	8,65	110402006	15,59
M 10 x 1,5	10,0	10,0	100	24	8,0	8,50	110403010	24,75	110401010	10,86	110402007	17,60
DIN 376												
M 3 x 0,5	3,0	2,2	56	11	-	2,50			110401011	7,09	110402008	12,25
M 4 x 0,7	4,0	2,8	63	13	2,1	3,30			110401012	7,09	110402009	12,25
M 5 x 0,8	5,0	3,5	70	16	2,7	4,20			110401013	7,64	110402010	12,80
M 6 x 1,0	6,0	4,5	80	19	3,4	5,00			110401014	7,64	110402011	12,80
M 8 x 1,25	8,0	6,0	90	22	4,9	6,80			110401015	9,42	110402012	15,59
M 10 x 1,5	10,0	7,0	100	24	5,5	8,50			110401016	11,30	110402013	17,60
M 12 x 1,75	12,0	9,0	110	29	7,0	10,20	110403011	30,00	110401017	13,08	110402014	22,17
M 14 x 2,0	14,0	11,0	110	30	9,0	12,00	110403012	43,42	110401018	16,62	110402015	28,07
M 16 x 2,0	16,0	12,0	110	32	9,0	14,00	110403013	54,42	110401019	18,84	110402016	32,52
M 18 x 2,5	18,0	14,0	125	34	11,0	15,50	110403014	71,39	110401020	26,60	110402017	44,22
M 20 x 2,5	20,0	16,0	140	34	12,0	17,50	110403015	84,86	110401021	35,46	110402018	62,59
M 22 x 2,5	22,0	18,0	140	34	14,5	19,50	110403016	109,32	110401022	41,00	110402019	69,05
M 24 x 3,0	24,0	18,0	160	38	14,5	21,00	110403017	115,33	110401023	43,21	110402020	74,63
M 27 x 3,0	27,0	20,0	160	38	16,0	24,00	110403018	184,02	110401024	72,03	110402021	122,52
M 30 x 3,5	30,0	22,0	180	45	18,0	26,50	110403019	222,78	110401025	74,24	110402022	128,08
M 33 x 3,5	33,0	25,0	180	50	20,0	29,50			110401026	104,16	110402023	173,75
M 36 x 4,0	36,0	28,0	200	56	22,0	32,00			110401027	169,54	110402024	290,68
M 39 x 4,0	39,0	32,0	200	60	24,0	35,00			110401028	218,31	110402025	365,32
M 42 x 4,5	42,0	32,0	200	60	24,0	37,50			110401029	254,88	110402026	434,36
M 45 x 4,5	45,0	36,0	220	65	29,0	40,50			110401030	288,13	110402027	478,89
M 48 x 5,0	48,0	36,0	250	70	29,0	43,00			110401031	315,81	110402028	529,02
M 52 x 5,0	52,0	40,0	250	70	32,0	47,00			110401032	385,64	110402029	625,94

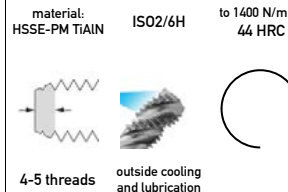
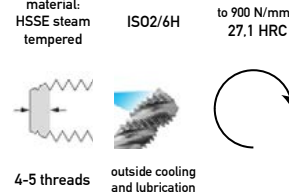
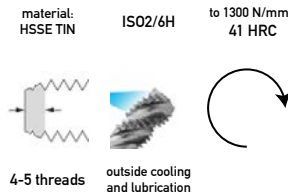
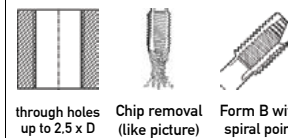
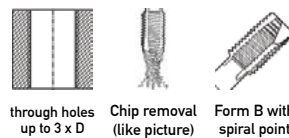
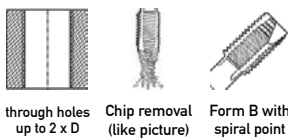
Machine Taps - Form B for through holes

M Metric coarse thread
ISO DIN 13

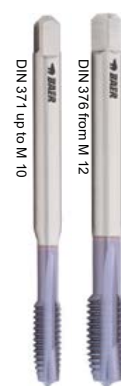
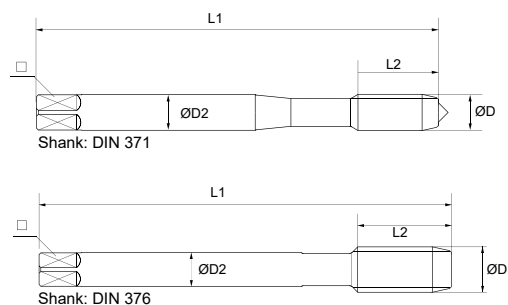
Machine Tap
for high-alloyed steels
and longer tool life time

Machine Tap
ECO for stainless steels
with high tool life time

Machine Tap
for high alloyed stainless steels
and high-tensile materials



Tap for machine use in through hole.
The spiral point pushes the chips ahead.



M	D1	D2	L1	L2	□		No.	€	No.	€	No.	€
M 2 x 0,4	2,0	2,8	45	8	2,1	1,60	110404001	13,51	110405001	*	110406001	*
M 2,5 x 0,45	2,5	2,8	50	9	2,1	2,05	110404002	13,51	110405002	*	110406002	*
M 3 x 0,5	3,0	3,5	56	11	2,7	2,50	110404003	10,45	110405003	10,69	110406003	21,92
M 3,5 x 0,6	3,5	4,0	56	13	3,0	2,90	110404004	*				
M 4 x 0,7	4,0	4,5	63	13	3,4	3,30	110404005	10,45	110405004	10,69	110406004	21,92
M 5 x 0,8	5,0	6,0	70	16	4,9	4,20	110404006	10,92	110405005	11,68	110406005	23,14
M 6 x 1,0	6,0	6,0	80	19	4,9	5,00	110404007	11,68	110405006	11,68	110406006	25,58
M 7 x 1,0	7,0	7,0	80	19	5,5	6,00	110404008	16,74				
M 8 x 1,25	8,0	8,0	90	22	6,2	6,80	110404009	14,43	110405007	13,89	110406007	30,45
M 9 x 1,25	9,0	9,0	90	18	6,2	7,80	110404010	*				
M 10 x 1,5	10,0	10,0	100	24	8,0	8,50	110404011	18,89	110405008	19,62	110406008	37,70
M 12 x 1,75	12,0	9,0	110	29	7,0	10,20	110404012	25,23	110405009	24,80	110406009	44,10
M 14 x 2,0	14,0	11,0	110	30	9,0	12,00	110404013	30,47	110405010	28,11	110406010	57,33
M 16 x 2,0	16,0	12,0	110	32	9,0	14,00	110404014	33,74	110405011	30,32	110406011	63,50
M 18 x 2,5	18,0	14,0	125	34	11,0	15,50	110404015	46,65	110405012	40,79	110406012	*
M 20 x 2,5	20,0	16,0	140	34	12,0	17,50	110404016	56,27	110405013	57,36	110406013	*
M 22 x 2,5	22,0	18,0	140	34	14,5	19,50	110404017	*	110405014	86,31	110406014	*
M 24 x 3,0	24,0	18,0	160	38	14,5	21,00	110404018	*	110405015	93,77	110406015	*
M 27 x 3,0	27,0	20,0	160	38	16,0	24,00	110404019	*				
M 30 x 3,5	30,0	22,0	180	45	18,0	26,50	110404020	*				

* on request

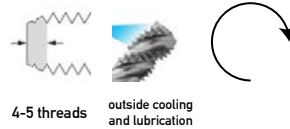
Machine Taps - Form B for through holes

M Metric coarse thread
ISO DIN 13

Machine Tap for aluminum



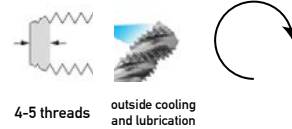
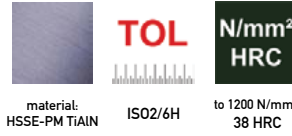
through holes up to 2.5 x D
Chip removal (like picture)
Form B with spiral point



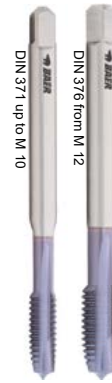
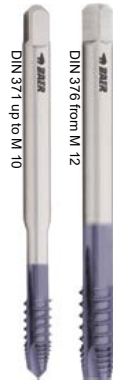
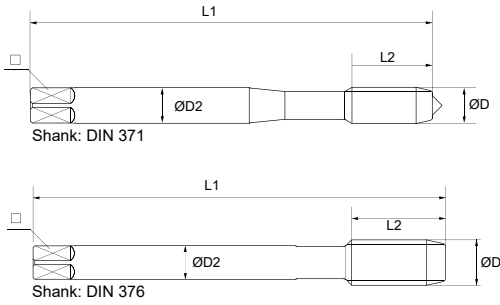
Machine Tap for special alloys (Inconel, Hastelloy etc.)



through holes up to 2.5 x D
Chip removal (like picture)
Form B with spiral point



Tap for machine use in through hole.
The spiral point pushes the chips ahead.

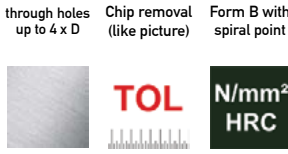


M	D1	D2	L1	L2	□		No.	€	No.	€
M 2 x 0,4	2,0	2,8	45	8	2,1	1,60			110412001	57,24
M 2,5 x 0,45	2,5	2,8	50	9	2,1	2,05			110412002	54,50
M 3 x 0,5	3,0	3,5	56	11	2,7	2,50	110407001	33,80	110412003	51,59
M 4 x 0,7	4,0	4,5	63	13	3,4	3,30	110407002	33,80	110412004	51,59
M 5 x 0,8	5,0	6,0	70	16	4,9	4,20	110407003	34,57	110412005	51,59
M 6 x 1,0	6,0	6,0	80	19	4,9	5,00	110407004	34,57	110412006	51,59
M 8 x 1,25	8,0	8,0	90	22	6,2	6,80	110407005	43,75	110412007	63,93
M 10 x 1,5	10,0	10,0	100	24	8,0	8,50	110407006	52,59	110412008	78,67
M 12 x 1,75	12,0	9,0	110	29	7,0	10,20	110407007	61,82	110412009	100,60
M 14 x 2,0	14,0	11,0	110	30	9,0	12,00	110407008	69,41	110412010	133,17
M 16 x 2,0	16,0	12,0	110	32	9,0	14,00	110407009	80,67	110412011	149,62
M 18 x 2,5	18,0	14,0	125	34	11,0	15,50			110412012	200,52
M 20 x 2,5	20,0	16,0	140	34	12,0	17,50			110412013	257,59
M 24 x 3,0	24,0	18,0	160	38	14,5	21,00			110412014	366,08
M 27 x 3,0	27,0	20,0	160	38	16,0	24,00			110412015	400,87
M 30 x 3,5	30,0	22,0	180	45	18,0	26,50			110412016	461,03

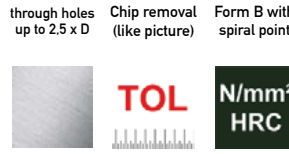
Machine Taps - Form B for through holes

M Metric coarse thread
ISO DIN 13

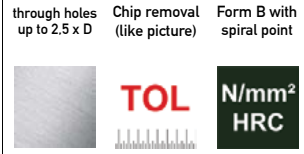
Machine Tap
for general use
overlengthed (long shank)



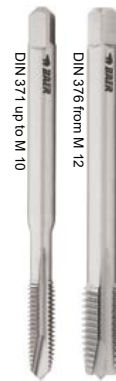
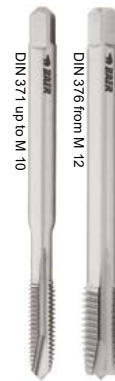
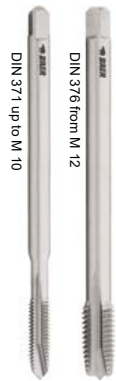
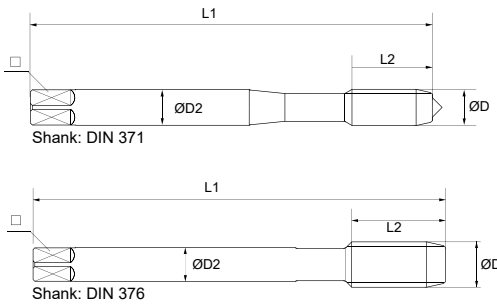
Machine Tap
for general use
oversized (diameter)



Machine Tap
for general use
undersized (diameter)



Tap for machine use in through hole.
The spiral point pushes the chips ahead.

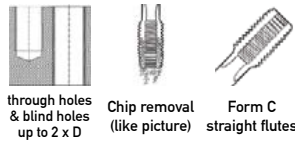


M	D1	D2	L1	L2	□	🔧	No.	€	No.	€	No.	€
							Total length L1 = 100 mm		Tol. 6G: threads with large clearance		Tol. 4H: threads with small clearance	
M 2 x 0,4	2,0	2,8	45	8	2,1	1,60			110417001	11,55	110420001	28,72
M 2,5 x 0,45	2,5	2,8	50	9	2,1	2,05			110417002	11,55	110420002	27,94
M 3 x 0,5	3,0	3,5	56	11	2,7	2,50	110414001	9,36	110417003	11,55	110420003	24,44
M 4 x 0,7	4,0	4,5	63	13	3,4	3,30	110414002	9,36	110417004	11,99	110420004	25,22
M 5 x 0,8	5,0	6,0	70	16	4,9	4,20	110414003	9,91	110417005	11,99	110420005	26,39
M 6 x 1,0	6,0	6,0	80	19	4,9	5,00	110414004	9,91	110417006	14,78	110420006	26,39
M 8 x 1,25	8,0	8,0	90	22	6,2	6,80	110414005	11,91	110417007	16,97	110420007	29,88
M 10 x 1,5	10,0	10,0	100	24	8,0	8,50	110414006	12,47	110417008	20,33	110420008	36,12
M 12 x 1,75	12,0	9,0	110	29	7,0	10,20	110414007	14,04	110417009	29,26	110420009	47,23
M 14 x 2,0	14,0	11,0	110	30	9,0	12,00			110417010	33,78	110420010	58,15
M 16 x 2,0	16,0	12,0	110	32	9,0	14,00			110417011	46,07	110420011	73,83
M 18 x 2,5	18,0	14,0	125	34	11,0	15,50			110417012	64,50		
M 20 x 2,5	20,0	16,0	140	34	12,0	17,50						
							Total length L1 = 120 mm		Tol. 7G: for disorted threads (heat treatment)			
M 3 x 0,5	3,0	3,5	56	11	2,7	2,50			110418001	14,10		
M 4 x 0,7	4,0	4,5	63	13	3,4	3,30	110415001	9,91	110418002	14,10		
M 5 x 0,8	5,0	6,0	70	16	4,9	4,20	110415002	10,80	110418003	15,15		
M 6 x 1,0	6,0	6,0	80	19	4,9	5,00	110415003	10,80	110418004	15,15		
M 8 x 1,25	8,0	8,0	90	22	6,2	6,80	110415004	12,59	110418005	19,52		
M 10 x 1,5	10,0	10,0	100	24	8,0	8,50	110415005	14,26	110418006	22,89		
M 12 x 1,75	12,0	9,0	110	29	7,0	10,20	110415006	16,60	110418007	24,70		
							Total length L1 = 150 mm		Tol. 6H +0,1 mm: for electroplating allowance			
M 3 x 0,5	3,0	3,5	56	11	2,7	2,50			110419001	14,10		
M 4 x 0,7	4,0	4,5	63	13	3,4	3,30	110416001	10,47	110419002	14,10		
M 5 x 0,8	5,0	6,0	70	16	4,9	4,20	110416002	11,58	110419003	15,15		
M 6 x 1,0	6,0	6,0	80	19	4,9	5,00	110416003	11,58	110419004	15,15		
M 8 x 1,25	8,0	8,0	90	22	6,2	6,80	110416004	14,15	110419005	19,52		
M 10 x 1,5	10,0	10,0	100	24	8,0	8,50	110416005	17,26	110419006	22,89		
M 12 x 1,75	12,0	9,0	110	29	7,0	10,20	110416006	20,27	110419007	24,87		

Machine Taps - Form C (straight flutes) for through holes and blind holes

M Metric coarse thread
ISO DIN 13

Machine Tap
for general use



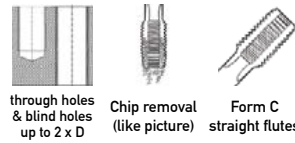
through holes & blind holes up to 2 x D
Chip removal (like picture)
Form C straight flutes

TOL **N/mm² HRC**

material: HSSE ISO2/6H to 900 N/mm² 27.1 HRC



Machine Tap
for general use
Left-hand thread



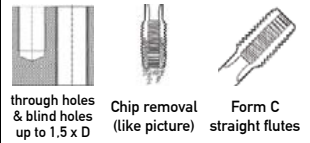
through holes & blind holes up to 2 x D
Chip removal (like picture)
Form C straight flutes

TOL **N/mm² HRC**

material: HSSE ISO2/6H to 900 N/mm² 27.1 HRC



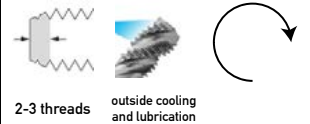
Machine Tap
with longer tool life time



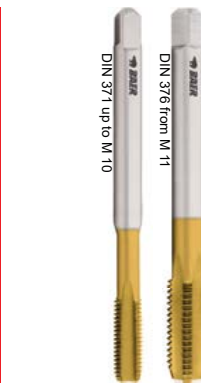
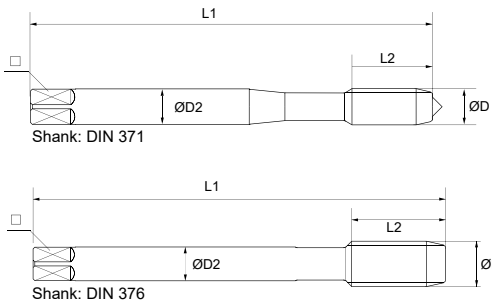
through holes & blind holes up to 1.5 x D
Chip removal (like picture)
Form C straight flutes

TOL **N/mm² HRC**

material: HSSE TIN ISO2/6H to 900 N/mm² 27.1 HRC



Tap for machine use in through hole and blind hole. The short lead-in chamfer makes that tap universal in application. The flutes can hold the most part of the chips.

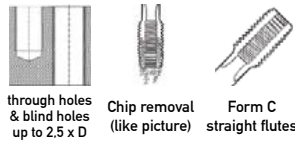


M	D1	D2	L1	L2	□	☑	No.	€	No.	€	No.	€
DIN 371												
M 2 x 0,4	2,0	2,8	45	8	2,1	1,60	110501001	7,75			110504001	25,33
M 2,2 x 0,45	2,2	2,8	45	8	2,1	1,75					110504002	27,70
M 2,3 x 0,4	2,3	2,8	45	9	2,1	1,90	110501002	7,75			110504003	30,45
M 2,5 x 0,45	2,5	2,8	50	9	2,1	2,05	110501003	7,75			110504004	22,00
M 2,6 x 0,45	2,6	2,8	50	9	2,1	2,10	110501004	7,75			110504005	21,20
M 3 x 0,5	3,0	3,5	56	11	2,7	2,50	110501005	6,20	110502001	10,80	110504006	16,32
M 3,5 x 0,6	3,5	4,0	56	13	3,0	2,90	110501006	6,98			110504007	20,79
M 4 x 0,7	4,0	4,5	63	13	3,4	3,30	110501007	6,20	110502002	10,80	110504008	16,52
M 5 x 0,8	5,0	6,0	70	16	4,9	4,20	110501008	6,65	110502003	11,25	110504009	17,96
M 6 x 1,0	6,0	6,0	80	19	4,9	5,00	110501009	6,65	110502004	11,25	110504010	19,51
M 7 x 1,0	7,0	7,0	80	19	5,5	6,00	110501010	9,19			110504011	23,28
M 8 x 1,25	8,0	8,0	90	22	6,2	6,80	110501011	8,32	110502005	13,48	110504012	27,04
M 9 x 1,25	9,0	9,0	90	18	6,2	7,80					110504013	31,37
M 10 x 1,5	10,0	10,0	100	24	8,0	8,50	110501012	10,31	110502006	15,37	110504014	32,54
DIN 376												
M 3 x 0,5	3,0	2,2	56	11	-	2,50	110501013	6,87				
M 4 x 0,7	4,0	2,8	63	13	2,1	3,30	110501014	6,87				
M 5 x 0,8	5,0	3,5	70	16	2,7	4,20	110501015	7,20				
M 6 x 1,0	6,0	4,5	80	19	3,4	5,00	110501016	7,20				
M 8 x 1,25	8,0	6,0	90	22	4,9	6,80	110501017	8,64				
M 10 x 1,5	10,0	7,0	100	24	5,5	8,50	110501018	10,86				
M 11 x 1,5	11,0	8,0	100	22	6,2	9,50					110504015	40,99
M 12 x 1,75	12,0	9,0	110	29	7,0	10,20	110501019	12,19	110502007	18,26	110504016	40,16
M 14 x 2,0	14,0	11,0	110	30	9,0	12,00	110501020	16,07	110502008	27,06	110504017	49,35
M 16 x 2,0	16,0	12,0	110	32	9,0	14,00	110501021	17,73	110502009	30,62	110504018	57,33
M 18 x 2,5	18,0	14,0	125	34	11,0	15,50	110501022	25,49	110502010	41,77	110504019	76,47
M 20 x 2,5	20,0	16,0	140	34	12,0	17,50	110501023	35,46	110502011	59,03	110504020	85,47
M 22 x 2,5	22,0	18,0	140	34	14,5	19,50	110501024	38,78	110502012	61,59	110504021	114,14
M 24 x 3,0	24,0	18,0	160	38	14,5	21,00	110501025	42,10	110502013	64,05	110504022	118,31
M 27 x 3,0	27,0	20,0	160	38	16,0	24,00	110501026	66,49			110504023	149,88
M 30 x 3,5	30,0	22,0	180	45	18,0	26,50	110501027	70,92			110504024	177,62
M 33 x 3,5	33,0	25,0	180	50	20,0	29,50	110501028	99,73			110504025	251,46
M 36 x 4,0	36,0	28,0	200	56	22,0	32,00	110501029	161,79			110504026	337,98
M 39 x 4,0	39,0	32,0	200	60	24,0	35,00	110501030	205,00				
M 42 x 4,5	42,0	32,0	200	60	24,0	37,50	110501031	240,45				
M 45 x 4,5	45,0	36,0	220	65	29,0	40,50	110501032	277,05				
M 48 x 5,0	48,0	36,0	250	70	29,0	43,00	110501033	299,20				
M 52 x 5,0	52,0	40,0	250	70	32,0	47,00	110501034	365,70				

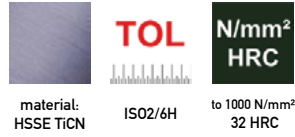
Machine Taps - Form C (straight flutes) for through holes and blind holes

M Metric coarse thread
ISO DIN 13

Machine Tap for cast materials



through holes & blind holes up to 2,5 x D
Chip removal (like picture)
Form C straight flutes

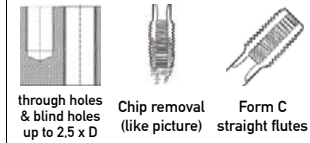


material: HSSE TiCN
ISO2/6H
to 1000 N/mm²
32 HRC

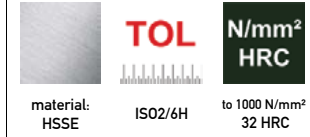


2-3 threads
outside cooling and lubrication

Machine Tap for titanium and titanium alloys



through holes & blind holes up to 2,5 x D
Chip removal (like picture)
Form C straight flutes

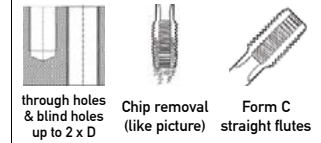


material: HSSE
ISO2/6H
to 1000 N/mm²
32 HRC

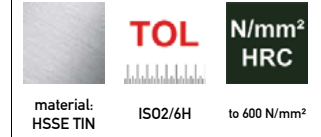


2-3 threads
outside cooling and lubrication

Machine Tap for brass (short-chipping)



through holes & blind holes up to 2 x D
Chip removal (like picture)
Form C straight flutes

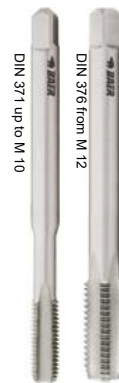
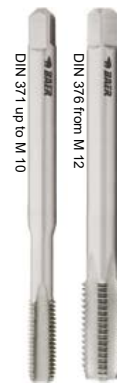
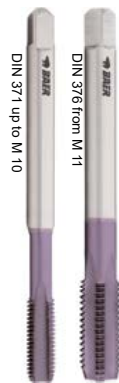
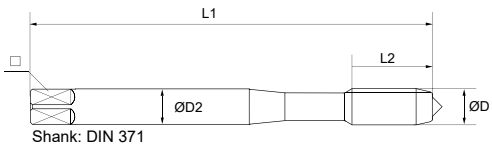


material: HSSE TiN
ISO2/6H
to 600 N/mm²



2-3 threads
outside cooling and lubrication

Tap for machine use in through hole and blind hole. The short lead-in chamfer makes that tap universal in application. The flutes can hold the most part of the chips.



M	D1	D2	L1	L2	□		No.	€	No.	€	No.	€
M 2 x 0,4	2,0	2,8	45	8	2,1	1,60			110511001	44,73		
M 2,5 x 0,45	2,5	2,8	50	9	2,1	2,05			110511002	44,73		
M 3 x 0,5	3,0	3,5	56	11	2,7	2,50	110510001	17,09	110511003	43,36	110509001	10,80
M 3,5 x 0,6	3,5	4,0	56	13	3,0	2,90	110510002	25,21				
M 4 x 0,7	4,0	4,5	63	13	3,4	3,30	110510003	17,29	110511004	46,10	110509002	10,80
M 5 x 0,8	5,0	6,0	70	16	4,9	4,20	110510004	18,85	110511005	46,79	110509003	11,81
M 6 x 1,0	6,0	6,0	80	19	4,9	5,00	110510005	19,64	110511006	47,30	110509004	11,81
M 7 x 1,0	7,0	7,0	80	19	5,5	6,00	110510006	33,75				
M 8 x 1,25	8,0	8,0	90	22	6,2	6,80	110510007	23,63	110511007	55,02	110509005	13,81
M 9 x 1,25	9,0	9,0	90	18	6,2	7,80	110510008	40,73				
M 10 x 1,5	10,0	10,0	100	24	8,0	8,50	110510009	31,23	110511008	65,81	110509006	18,93
M 11 x 1,5	11,0	8,0	100	22	6,2	9,50	110510010	50,24				
M 12 x 1,75	12,0	9,0	110	29	7,0	10,20	110510011	43,22	110511009	94,26	110509007	24,50
M 14 x 2,0	14,0	11,0	110	30	9,0	12,00	110510012	56,72	110511010	119,97	110509008	27,85
M 16 x 2,0	16,0	12,0	110	32	9,0	14,00	110510013	61,68	110511011	135,57	110509009	30,07
M 18 x 2,5	18,0	14,0	125	34	11,0	15,50	110510014	81,42	110511012	193,15		
M 20 x 2,5	20,0	16,0	140	34	12,0	17,50	110510015	89,50	110511013	213,89		
M 22 x 2,5	22,0	18,0	140	34	14,5	19,50	110510016	151,38				
M 24 x 3,0	24,0	18,0	160	38	14,5	21,00	110510017	126,00				
M 27 x 3,0	27,0	20,0	160	38	16,0	24,00	110510018	220,73				
M 30 x 3,5	30,0	22,0	180	45	18,0	26,50	110510019	285,90				
M 33 x 3,5	33,0	25,0	180	50	20,0	29,50	110510020	439,74				

Machine Taps - Form C (with spiral flutes) for blind holes

M Metric coarse thread
ISO DIN 13

Machine Tap
UNITAP for universal use

Machine Tap
for general use

Machine Tap
for general use
Left-hand thread



blind holes up to 3 x D
Chip removal (like picture)
Form C 40° spiral flute



material: HSSE-TiAlN
ISO2/6H
to 1200 N/mm²
38 HRC



2-3 threads
outside cooling and lubrication



blind holes up to 3 x D
Chip removal (like picture)
Form C 35° spiral flute



material: HSSE
ISO2/6H
to 900 N/mm²
27.1 HRC



2-3 threads
outside cooling and lubrication



blind holes up to 3 x D
Chip removal (like picture)
Form C 35° left spir. flute

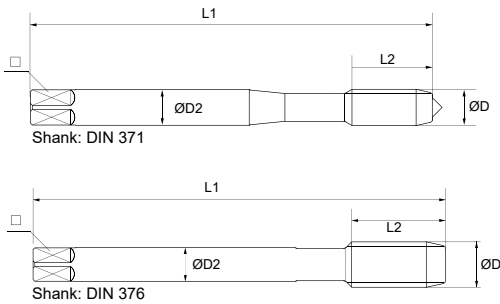


material: HSSE
ISO2/6H
to 900 N/mm²
27.1 HRC



2-3 threads
outside cooling and lubrication

Tap for machine use in blind holes.
The fast spiral flutes provide good chip removal from the blind hole.



M	D1	D2	L1	L2	□		No.	€	No.	€	No.	€
DIN 371												
M 2 x 0,4	2,0	2,8	45	6	2,1	1,60	110603001	26,24	110601001	9,09		
M 2,2 x 0,45	2,2	2,8	45	6	2,1	1,75	110603002	29,07				
M 2,5 x 0,45	2,5	2,8	50	6	2,1	2,05	110603003	22,09	110601002	9,09		
M 3 x 0,5	3,0	3,5	56	6	2,7	2,50	110603004	17,33	110601003	7,86	110602001	14,37
M 3,5 x 0,6	3,5	4,0	56	13	3,0	2,90	110603005	20,16	110601004	8,64		
M 4 x 0,7	4,0	4,5	63	7	3,4	3,30	110603006	17,64	110601005	7,86	110602002	14,37
M 5 x 0,8	5,0	6,0	70	8	4,9	4,20	110603007	17,85	110601006	8,65	110602003	15,37
M 6 x 1,0	6,0	6,0	80	10	4,9	5,00	110603008	18,63	110601007	8,65	110602004	15,37
M 7 x 1,0	7,0	7,0	80	19	5,5	6,00			110601008	11,97		
M 8 x 1,25	8,0	8,0	90	14	6,2	6,80	110603009	21,95	110601009	10,42	110602005	18,38
M 10 x 1,5	10,0	10,0	100	16	8,0	8,50	110603010	26,57	110601010	13,08	110602006	20,94
DIN 376												
M 3 x 0,5	3,0	2,2	56	6	-	2,50			110601011	8,64	110602007	14,37
M 4 x 0,7	4,0	2,8	63	7	2,1	3,30			110601012	8,64	110602008	14,37
M 5 x 0,8	5,0	3,5	70	8	2,7	4,20			110601013	9,08	110602009	15,37
M 6 x 1,0	6,0	4,5	80	10	3,4	5,00			110601014	9,08	110602010	15,37
M 8 x 1,25	8,0	6,0	90	14	4,9	6,80			110601015	11,08	110602011	18,38
M 10 x 1,5	10,0	7,0	100	16	5,5	8,50			110601016	13,30	110602012	20,94
M 12 x 1,75	12,0	9,0	110	18	7,0	10,20	110603011	33,60	110601017	15,51	110602013	23,84
M 14 x 2,0	14,0	11,0	110	20	9,0	12,00	110603012	43,00	110601018	19,94	110602014	30,40
M 16 x 2,0	16,0	12,0	110	22	9,0	14,00	110603013	54,12	110601019	22,16	110602015	35,08
M 18 x 2,5	18,0	14,0	125	25	11,0	15,50	110603014	73,59	110601020	32,68	110602016	46,78
M 20 x 2,5	20,0	16,0	140	25	12,0	17,50	110603015	88,22	110601021	43,22	110602017	66,83
M 22 x 2,5	22,0	18,0	140	27	14,5	19,50	110603016	111,49	110601022	50,97	110602018	74,85
M 24 x 3,0	24,0	18,0	160	30	14,5	21,00	110603017	117,81	110601023	53,19	110602019	77,19
M 27 x 3,0	27,0	20,0	160	30	16,0	24,00	110603018	188,87	110601024	86,43	110602020	132,54
M 30 x 3,5	30,0	22,0	180	35	18,0	26,50	110603019	230,55	110601025	90,86	110602021	136,99
M 33 x 3,5	33,0	25,0	180	35	20,0	29,50			110601026	129,65	110602022	190,46
M 36 x 4,0	36,0	28,0	200	40	22,0	32,00			110601027	205,00	110602023	320,76
M 39 x 4,0	39,0	32,0	200	40	24,0	35,00			110601028	260,42	110602024	394,28
M 42 x 4,5	42,0	32,0	200	45	24,0	37,50			110601029	310,28	110602025	459,99
M 45 x 4,5	45,0	36,0	220	45	29,0	40,50			110601030	349,07	110602026	522,36
M 48 x 5,0	48,0	36,0	250	50	29,0	43,00			110601031	382,30	110602027	570,22
M 52 x 5,0	52,0	40,0	250	50	32,0	47,00			110601032	454,33	110602028	666,04

Machine Taps - Form C (with spiral flutes) for blind holes

M Metric coarse thread
ISO DIN 13

Machine Tap
for high-alloyed steels
and longer tool life time

Machine Tap
ECO for stainless steels
with high tool life time

Machine Tap
for high alloyed stainless steels
and high-tensile materials



blind holes up to 2.5 x D
Chip removal (like picture)
Form C 35° spiral flute



blind holes up to 2.5 x D
Chip removal (like picture)
Form C 35° spiral flute



blind holes up to 2 x D
Chip removal (like picture)
Form C 15° spiral flute



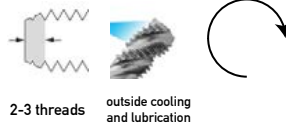
material: HSSE TIN
ISO2/6H
to 1300 N/mm² 41 HRC



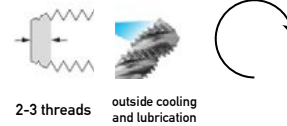
material: HSSE steam tempered
ISO2/6H
to 900 N/mm² 27,1 HRC



material: HSSE-PM TiAlN
ISO2/6H
to 1400 N/mm² 44 HRC



2-3 threads
outside cooling and lubrication

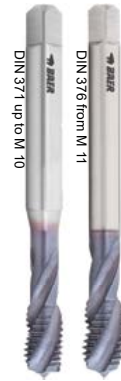
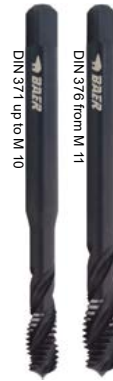
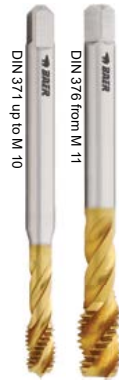
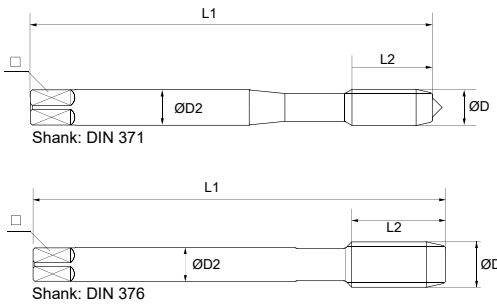


2-3 threads
outside cooling and lubrication



2-3 threads
outside cooling and lubrication

Tap for machine use in blind holes.
The fast spiral flutes provide good chip removal from the blind hole.



M	D1	D2	L1	L2	□		No.	€	No.	€	No.	€
M 2 x 0,4	2,0	2,8	45	6	2,1	1,60	110604001	13,38			110606001	*
M 2,5 x 0,45	2,5	2,8	50	6	2,1	2,05	110604002	13,38			110606002	*
M 3 x 0,5	3,0	3,5	56	6	2,7	2,50	110604003	11,98	110605001	12,92	110606003	23,75
M 3,5 x 0,6	3,5	4,0	56	13	3,0	2,90	110604004	*				
M 4 x 0,7	4,0	4,5	63	7	3,4	3,30	110604005	11,98	110605002	12,92	110606004	23,75
M 5 x 0,8	5,0	6,0	70	8	4,9	4,20	110604006	12,80	110605003	14,15	110606005	25,58
M 6 x 1,0	6,0	6,0	80	10	4,9	5,00	110604007	13,50	110605004	14,15	110606006	28,62
M 7 x 1,0	7,0	7,0	80	19	5,5	6,00	110604008	18,64				
M 8 x 1,25	8,0	8,0	90	14	6,2	6,80	110604009	16,55	110605005	16,82	110606007	35,32
M 9 x 1,25	9,0	9,0	90	15	7,0	7,80	110604010	*				
M 10 x 1,5	10,0	10,0	100	16	8,0	8,50	110604011	21,48	110605006	23,83	110606008	44,46
M 11 x 1,5	11,0	8,0	100	18	6,2	9,50	110604012	*				
M 12 x 1,75	12,0	9,0	110	18	7,0	10,20	110604013	28,05	110605007	30,08	110606009	62,73
M 14 x 2,0	14,0	11,0	110	20	9,0	12,00	110604014	34,23	110605008	34,08	110606010	97,44
M 16 x 2,0	16,0	12,0	110	22	9,0	14,00	110604015	38,05	110605009	36,75	110606011	111,45
M 18 x 2,5	18,0	14,0	125	25	11,0	15,50	110604016	52,84	110605010	49,45	110606012	*
M 20 x 2,5	20,0	16,0	140	25	12,0	17,50	110604017	63,91	110605011	69,50	110606013	*
M 22 x 2,5	22,0	18,0	140	27	14,5	19,50	110604018	*	110605012	84,99	110606014	*
M 24 x 3,0	24,0	18,0	160	30	14,5	21,00	110604019	*	110605013	91,88	110606015	*
M 27 x 3,0	27,0	20,0	160	30	16,0	24,00	110604020	*				
M 30 x 3,5	30,0	22,0	180	35	18,0	26,50	110604021	*				

* on request

Machine Taps - Form C (with spiral flutes) for blind holes

M Metric coarse thread
ISO DIN 13

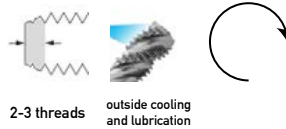
Machine Tap for aluminum (long-chipping)



blind holes up to 3 x D
Chip removal (like picture)
Form C 40° spiral flute



material: HSSE
ISO2/6H
to 350 N/mm²



2-3 threads
outside cooling and lubrication

Machine Tap for long-chipping materials



blind holes up to 3 x D
Chip removal (like picture)
Form C 15° spiral flute



material: HSSE
ISO2/6H
to 900 N/mm² 27,1 HRC



2-3 threads
outside cooling and lubrication

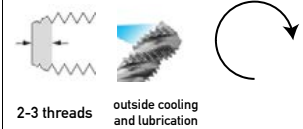
Machine Tap for special alloys (Inconel, Hastelloy etc.)



blind holes up to 2 x D
Chip removal (like picture)
Form C 15° spiral flute

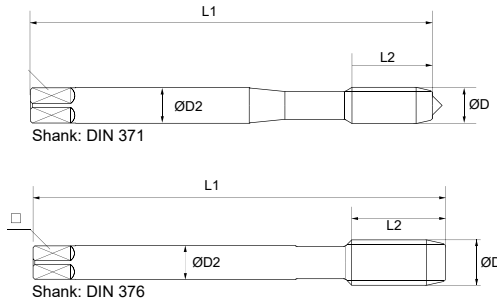


Material: HSSE-PM TiAlN
ISO2/6H
to 1000 N/mm² 32 HRC



2-3 threads
outside cooling and lubrication

Tap for machine use in blind holes. The fast spiral flutes provide good chip removal from the blind hole.



M	D1	D2	L1	L2	□		No.	€	No.	€	No.	€
DIN 371												
M 3 x 0,5	3,0	3,5	56	6	2,7	2,50	110607001	11,92	110608001	9,80	110612001	52,27
M 3,5 x 0,6	3,5	4,0	56	13	3,0	2,90			110608002	10,14		
M 4 x 0,7	4,0	4,5	63	7	3,4	3,30	110607002	11,92	110608003	9,80	110612002	54,67
M 5 x 0,8	5,0	6,0	70	8	4,9	4,20	110607003	13,03	110608004	10,47	110612003	56,90
M 6 x 1,0	6,0	6,0	80	10	4,9	5,00	110607004	13,03	110608005	10,47	110612004	58,44
M 7 x 1,0	7,0	7,0	80	19	5,5	6,00			110608006	13,26		
M 8 x 1,25	8,0	8,0	90	14	6,2	6,80	110607005	15,04	110608007	12,92	110612005	66,67
M 10 x 1,5	10,0	10,0	100	16	8,0	8,50	110607006	22,28	110608008	14,93	110612006	76,78
DIN 376												
M 3 x 0,5	3,0	2,2	56	11	-	2,50			110608009	9,80		
M 4 x 0,7	4,0	2,8	63	13	2,1	3,30			110608010	9,80		
M 5 x 0,8	5,0	3,5	70	16	2,7	4,20			110608011	10,46		
M 6 x 1,0	6,0	4,5	80	19	3,4	5,00			110608012	10,46		
M 8 x 1,25	8,0	6,0	90	22	4,9	6,80			110608013	12,92		
M 10 x 1,5	10,0	7,0	100	24	5,5	8,50			110608014	14,93		
M 12 x 1,75	12,0	9,0	110	18	7,0	10,20	110607007	28,95	110608015	17,82	110612007	98,38
M 14 x 2,0	14,0	11,0	110	20	9,0	12,00	110607008	31,19	110608016	23,95	110612008	120,31
M 16 x 2,0	16,0	12,0	110	22	9,0	14,00	110607009	34,53	110608017	25,96	110612009	135,22
M 18 x 2,5	18,0	14,0	125	25	11,0	15,50			110608018	37,31	110612010	177,90
M 20 x 2,5	20,0	16,0	140	25	12,0	17,50			110608019	48,45	110612011	197,44
M 22 x 2,5	22,0	18,0	140	27	14,5	19,50			110608020	55,69		
M 24 x 3,0	24,0	18,0	160	30	14,5	21,00			110608021	59,03		

Machine Taps - Form C (with spiral flutes) for blind holes

M Metric coarse thread
ISO DIN 13

Machine Tap
for general use
overlengthed (long shank)



blind holes up to 3 x D
Chip removal (like picture)
Form C 35° spiral flute



material: HSSE
ISO2/6H
to 900 N/mm²
27,1 HRC



2-3 threads
outside cooling and lubrication

Machine Tap
for general use
oversized (diameter)



blind holes up to 3 x D
Chip removal (like picture)
Form C 35° spiral flute



material: HSSE
6G
7G
6H +0,1 mm
to 900 N/mm²
27,1 HRC



2-3 threads
outside cooling and lubrication

Machine Tap
for general use
undersized (diameter)



blind holes up to 3 x D
Chip removal (like picture)
Form C 35° spiral flute

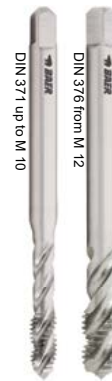
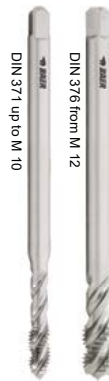
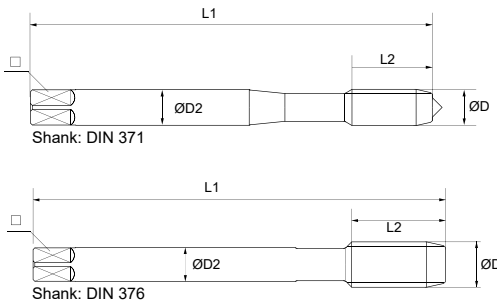


material: HSSE
4H
to 900 N/mm²
27,1 HRC



2-3 threads
outside cooling and lubrication

Tap for machine use in blind holes.
The fast spiral flutes provide good chip removal from the blind hole.

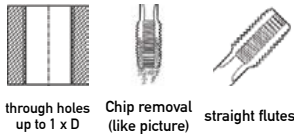


M	D1	D2	L1	L2	□		No.	€	No.	€	No.	€	
							Total length L1 = 100 mm			Tol. 6G: threads with large clearance		Tol. 4H: threads with small clearance	
M 2 x 0,4	2,0	2,8	45	6	2,1	1,60					110620001	29,30	
M 2,5 x 0,45	2,5	2,8	50	6	2,1	2,05					110620002	28,19	
M 3 x 0,5	3,0	3,5	56	6	2,7	2,50	110614001	11,25	110617001	13,90	110620003	25,46	
M 4 x 0,7	4,0	4,5	63	7	3,4	3,30	110614002	11,25	110617002	13,90	110620004	25,99	
M 5 x 0,8	5,0	6,0	70	8	4,9	4,20	110614003	12,14	110617003	14,48	110620005	26,36	
M 6 x 1,0	6,0	6,0	80	10	4,9	5,00	110614004	12,14	110617004	14,48	110620006	27,09	
M 8 x 1,25	8,0	8,0	90	14	6,2	6,80	110614005	14,04	110617005	17,70	110620007	31,29	
M 10 x 1,5	10,0	10,0	100	16	8,0	8,50	110614006	15,15	110617006	20,47	110620008	37,70	
M 12 x 1,75	12,0	9,0	110	18	7,0	10,20	110614007	15,37	110617007	22,24	110620009	46,88	
M 14 x 2,0	14,0	11,0	110	20	9,0	12,00			110617008	32,17			
M 16 x 2,0	16,0	12,0	110	22	9,0	14,00			110617009	33,64			
M 18 x 2,5	18,0	14,0	125	25	11,0	15,50			110617010	50,46			
M 20 x 2,5	20,0	16,0	140	25	12,0	17,50			110617011	70,20			
							Total length L1 = 120 mm			Tol. 7G: for disorted threads (heat treatment)			
M 3 x 0,5	3,0	3,5	56	6	2,7	2,50			110618001	14,19			
M 4 x 0,7	4,0	4,5	63	7	3,4	3,30	110615001	11,69	110618002	14,19			
M 5 x 0,8	5,0	6,0	70	8	4,9	4,20	110615002	12,91	110618003	15,21			
M 6 x 1,0	6,0	6,0	80	10	4,9	5,00	110615003	12,91	110618004	15,21			
M 8 x 1,25	8,0	8,0	90	14	6,2	6,80	110615004	14,82	110618005	19,60			
M 10 x 1,5	10,0	10,0	100	16	8,0	8,50	110615005	16,93	110618006	23,10			
M 12 x 1,75	12,0	9,0	110	18	7,0	10,20	110615006	17,93	110618007	24,86			
							Total length L1 = 150 mm			Tol. 6H +0,1 mm: for electroplating allowance			
M 3 x 0,5	3,0	3,5	56	6	2,7	2,50			110619001	14,19			
M 4 x 0,7	4,0	4,5	63	7	3,4	3,30	110616001	12,14	110619002	14,19			
M 5 x 0,8	5,0	6,0	70	8	4,9	4,20	110616002	13,81	110619003	15,21			
M 6 x 1,0	6,0	6,0	80	10	4,9	5,00	110616003	13,81	110619004	15,21			
M 8 x 1,25	8,0	8,0	90	14	6,2	6,80	110616004	16,37	110619005	19,60			
M 10 x 1,5	10,0	10,0	100	16	8,0	8,50	110616005	19,82	110619006	23,10			
M 12 x 1,75	12,0	9,0	110	18	7,0	10,20	110616006	21,49	110619007	24,86			

Machine Nut Taps and Combined Machine Taps

M Metric coarse thread
ISO DIN 13

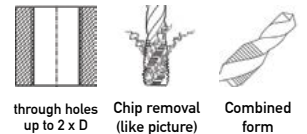
Machine Nut Tap for general use



material: HSSE
ISO2/6H
TOL
N/mm² HRC
to 850 N/mm²
25,5 HRC



Combined Machine Tap for general use



material: HSSE
ISO2/6H
TOL
N/mm² HRC
up to 600 N/mm²

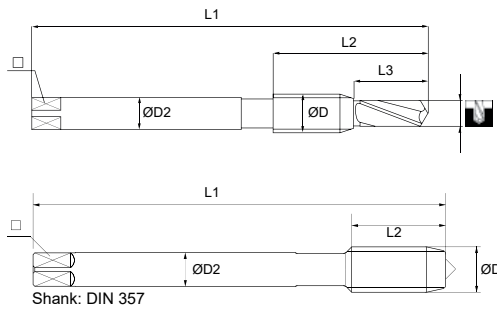


Machine Nut Tap

Machine Tap for threading nuts up to 1,0 D. The flutes can hold the most part of the chips.

Combined Machine Tap

Machine Tap, which allows core hole drilling and thread tapping in one fluent process without changing tools.



M	D1	D2	L1	L2	□	□	No.	€	D2	L1	L2	L3	□	No.	€
M 3 x 0,5	3,0	2,2	70	22	-	2,50	110901001	15,89	3,0	56	22	11	2,4	111001001	18,79
M 4 x 0,7	4,0	2,8	90	25	2,1	3,30	110901002	15,89	4,0	63	28	14	3,0	111001002	18,79
M 5 x 0,8	5,0	3,5	100	28	2,7	4,20	110901003	17,05	5,0	71	36	18	3,8	111001003	18,79
M 6 x 1,0	6,0	4,5	110	32	3,4	5,00	110901004	17,05	6,0	80	44	22	4,9	111001004	20,88
M 8 x 1,25	8,0	6,0	125	40	4,9	6,80	110901005	19,49	8,0	95	50	25	6,2	111001005	23,90
M 10 x 1,5	10,0	7,0	140	45	5,5	8,50	110901006	25,52	10,0	106	62	31	8,0	111001006	26,22
M 12 x 1,75	12,0	9,0	180	50	7,0	10,20	110901007	35,96	12,0	115	70	35	9,0	111001007	30,74
M 14 x 2,0	14,0	11,0	200	56	9,0	12,00	110901008	45,01							
M 16 x 2,0	16,0	12,0	200	63	9,0	14,00	110901009	54,87							
M 18 x 2,5	18,0	14,0	220	63	11,0	15,50	110901010	62,06							
M 20 x 2,5	20,0	16,0	250	70	12,0	17,50	110901011	68,21							
M 22 x 2,5	22,0	18,0	280	80	14,5	19,50	110901012	81,66							
M 24 x 3,0	24,0	18,0	280	80	14,5	21,00	110901013	91,64							

UNiForm Machine Forming Taps

M Metric coarse thread
ISO DIN 13

Machine Forming Taps have following advantages:

- No chips
- Up to 20 times longer lifetime (compared to taps)
- Same forming tap for through and blind hole
- Wide range of materials can be processed
- Intersection of the thread is impossible
- Very high trueness
- Increased strength of the thread
- Higher surface quality
- Much higher cutting speed

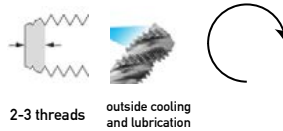
Machine Forming Taps for universal use



through holes & blind holes up to 2,5 x D
Threading with no chips
with oil grooves

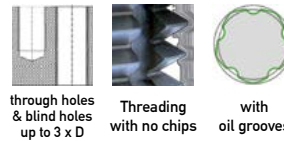


material: HSSE TIN
ISO2/6HX
to 850 N/mm²
25,5 HRC



2-3 threads
outside cooling and lubrication

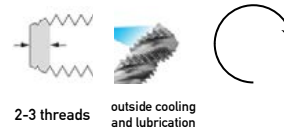
Machine Forming Taps for higher demands



through holes & blind holes up to 3 x D
Threading with no chips
with oil grooves

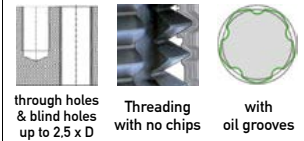


material: HSSE-PM TIN
ISO2/6HX
to 1200 N/mm²
37,1 HRC



2-3 threads
outside cooling and lubrication

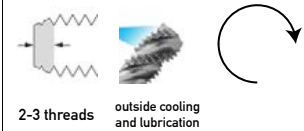
Machine Forming Taps for universal use oversized (diameter)



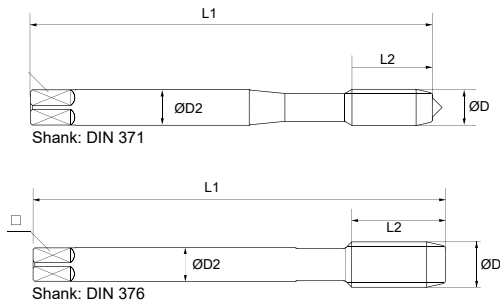
through holes & blind holes up to 2,5 x D
Threading with no chips
with oil grooves



material: HSSE TIN
ISO3/6GX
to 850 N/mm²
25,5 HRC



2-3 threads
outside cooling and lubrication



M	D1	D2	L1	L2	□	🔧	No.	€	No.	€	No.	€
							Tol. 6HX: standard tolerance		Tol. 6HX: standard tolerance		Tol. 6GX: threads with large clearance	
M 2 x 0,4	2,0	2,8	45	8	2,1	1,85	111101001	47,23	111104001	61,70	111117001	49,87
M 2,2 x 0,45	2,2	2,8	45	8	2,1	2,03	111101002	51,93				
M 2,3 x 0,4	2,3	2,8	45	8	2,1	2,15	111101003	40,73				
M 2,5 x 0,45	2,5	2,8	50	9	2,1	2,33	111101004	40,73	111104002	58,79	111117002	47,82
M 2,6 x 0,45	2,6	2,8	50	9	2,1	2,43	111101005	38,94				
M 3 x 0,5	3,0	3,5	56	11	2,7	2,80	111101006	13,90	111104003	55,70	111117003	45,07
M 3,5 x 0,6	3,5	4,0	56	13	3,0	3,25	111101007	38,05	111104004	55,70	111117004	45,07
M 4 x 0,7	4,0	4,5	63	13	3,4	3,70	111101008	15,90	111104005	58,96	111117005	48,16
M 4,5 x 0,75	4,5	6,0	70	14	4,9	4,20	111101009	35,36				
M 5 x 0,8	5,0	6,0	70	16	4,9	4,65	111101010	17,16	111104006	58,96	111117006	48,16
M 6 x 1,0	6,0	6,0	80	19	4,9	5,10	111101011	17,79	111104007	58,96	111117007	48,16
M 8 x 1,25	8,0	8,0	90	22	6,2	7,45	111101012	21,68	111104008	73,70	111117008	59,99
M 10 x 1,5	10,0	10,0	100	24	8,0	9,35	111101013	26,42	111104009	89,98	111117009	73,01
M 12 x 1,75	12,0	9,0	110	29	7,0	11,25	111101014	35,47	111104010	117,40	111117010	95,29
M 14 x 2,0	14,0	11,0	110	30	9,0	13,10	111101015	53,68	111104011	159,56	111117011	131,45
M 16 x 2,0	16,0	12,0	110	32	9,0	15,10	111101016	63,16	111104012	202,75	111117012	167,10
M 18 x 2,5	18,0	14,0	125	34	11,0	16,85	111101017	164,06	111104013	285,87		
M 20 x 2,5	20,0	16,0	140	34	12,0	18,85	111101018	214,86	111104014	399,50		

1/4" Bit-Short Machine Taps

M Metric coarse thread
ISO DIN 13

Efficient internal thread cutting with battery-powered screwdriver (min. 7,5 Volt).

Application:
non abrasive material up to 900 N/mm²
unalloyed and low alloyed steel

Bit-Taps
Form D for through holes
and blind holes

through holes & blind holes up to 2 x D

Chip removal (like picture)

Form D straight flutes

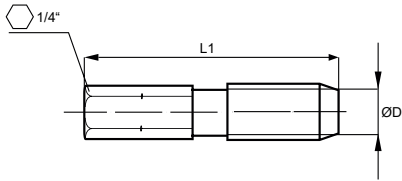
material: HSSG

ISO2/6H

to 800 N/mm²
22.2 HRC

4-5 threads

outside cooling and lubrication

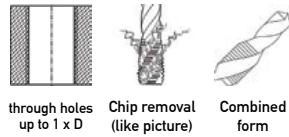


M	D1	L1	L2	Hex	ØD	No.	€
M 3 x 0,5	3,0	33	11	1/4"	2,50	111201001	3,79
M 3,5 x 0,6	3,5	34	10	1/4"	2,90	111201002	5,12
M 4 x 0,7	4,0	35	12	1/4"	3,30	111201003	3,79
M 4,5 x 0,75	4,5	35	12	1/4"	3,70	111201004	5,12
M 5 x 0,8	5,0	36	15	1/4"	4,20	111201005	4,79
M 5,5 x 0,9	5,5	35	15	1/4"	4,60	111201006	5,79
M 6 x 1,0	6,0	39	18	1/4"	5,00	111201007	4,79
M 7 x 1,0	7,0	38	16	1/4"	6,00	111201008	6,35
M 8 x 1,25	8,0	40	19	1/4"	6,80	111201009	6,79
M 9 x 1,25	9,0	41	18	1/4"	7,80	111201010	9,80
M 10 x 1,5	10,0	41	21	1/4"	8,50	111201011	8,01

1/4" Combined-Bit-Taps

M Metric coarse thread
ISO DIN 13

Kombi-Bit-Taps for through holes



through holes
up to 1 x D

Chip removal
(like picture)

Combined
form



material:
HSSG



ISO2/6H



to 600 N/mm²



4-5 threads

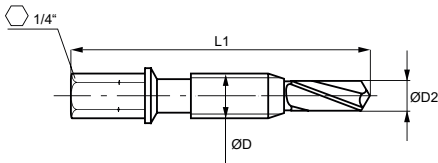


outside cooling
and lubrication



Efficient internal thread cutting with battery-powered screwdriver (min. 7,5 Volt). Core hole drilling and thread tapping in one fluent process.

Application:
non abrasive material up to 600 N/mm² unalloyed and low alloyed steel

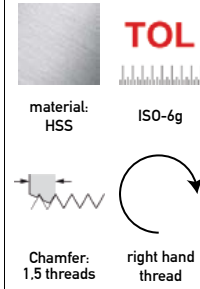


M	D1	D2	L1	Hex	No.	€
M 3 x 0,5	3,0	2,5	36	1/4"	111301001	7,13
M 4 x 0,7	4,0	3,3	39	1/4"	111301002	7,13
M 5 x 0,8	5,0	4,2	41	1/4"	111301003	7,13
M 6 x 1,0	6,0	5,0	44	1/4"	111301004	7,13
M 8 x 1,25	8,0	6,8	50	1/4"	111301005	9,80
M 10 x 1,5	10,0	8,5	59	1/4"	111301006	11,81

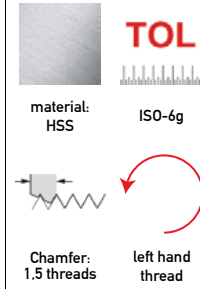
Round Dies

M Metric coarse thread
ISO DIN 13

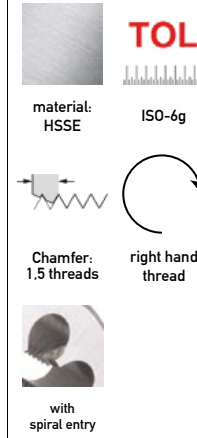
Round Dies
for general use



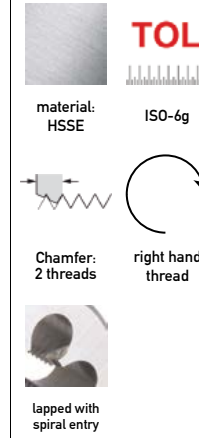
Round Dies
for general use
Left Hand



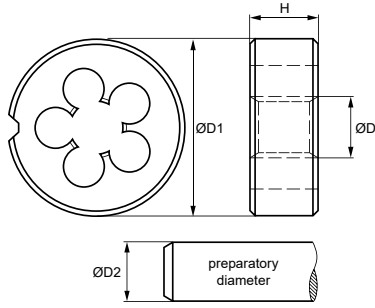
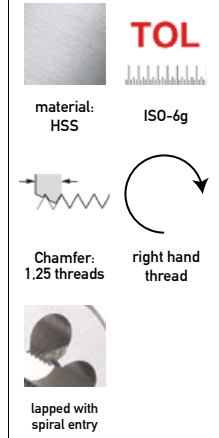
Round Dies
for higher demands



Round Dies
for stainless steels



Round Dies
for brass

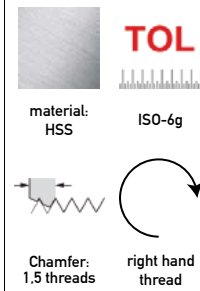


M	D	D1	H	D2	No.	€	No.	€	No.	€	No.	€	No.	€
M 1 x 0,25	1,0	16	5	0,96	111401001	12,74								
M 1,1 x 0,25	1,1	16	5	1,05	111401002	12,74								
M 1,2 x 0,25	1,2	16	5	1,15	111401003	12,74								
M 1,4 x 0,3	1,4	16	5	1,36	111401004	12,74					111405001	94,47		
M 1,6 x 0,35	1,6	16	5	1,55	111401005	12,74					111405002	91,47		
M 1,7 x 0,35	1,7	16	5	1,64	111401006	12,74					111405003	91,47		
M 1,8 x 0,35	1,8	16	5	1,75	111401007	12,74								
M 2 x 0,4	2,0	16	5	1,95	111401008	11,08	111402001	19,94			111405004	74,36	111409001	71,66
M 2,2 x 0,45	2,2	16	5	2,15	111401009	11,08								
M 2,3 x 0,4	2,3	16	5	2,23	111401010	11,08					111405005	74,36		
M 2,5 x 0,45	2,5	16	5	2,42	111401011	11,08					111405006	64,75	111409002	62,06
M 2,6 x 0,45	2,6	16	5	2,53	111401012	11,08					111405007	67,45	111409003	62,06
M 3 x 0,5	3,0	20	5	2,92	111401013	5,32	111402002	9,19	111404001	9,02	111405008	22,84	111409004	46,53
M 3,5 x 0,6	3,5	20	5	3,41	111401014	8,20					111405009	45,69	111409005	63,84
M 4 x 0,7	4,0	20	5	3,90	111401015	5,32	111402003	9,19	111404002	9,02	111405010	22,52	111409006	44,30
M 4,5 x 0,75	4,5	20	7	4,40	111401016	8,20								
M 5 x 0,8	5,0	20	7	4,90	111401017	5,65	111402004	9,87	111404003	9,35	111405011	23,26	111409007	39,84
M 5 x 0,9	5,0	20	7	4,89	111401018	8,36								
M 5,5 x 0,9	5,5	20	7	5,44	111401019	5,65								
M 6 x 1,0	6,0	20	7	5,88	111401020	5,65	111402005	9,87	111404004	9,35	111405012	23,26	111409008	39,84
M 7 x 1,0	7,0	25	9	6,88	111401021	8,87					111405013	66,31	111409009	55,72
M 8 x 1,25	8,0	25	9	7,86	111401022	5,98	111402006	11,42	111404005	13,26	111405014	25,99	111409010	44,30
M 9 x 1,25	9,0	25	9	8,86	111401023	10,08								
M 10 x 1,5	10,0	30	11	9,85	111401024	8,86	111402007	14,96	111404006	18,82	111405015	33,81	111409011	53,50
M 11 x 1,5	11,0	30	11	10,85	111401025	12,19								
M 12 x 1,75	12,0	38	14	11,83	111401026	14,41	111402008	21,28	111404007	29,73	111405016	38,64	111409012	71,05
M 14 x 2,0	14,0	38	14	13,82	111401027	14,41	111402009	24,38	111404008	29,73	111405017	38,64	111409013	88,60
M 15 x 2,0	15,0	38	14	14,91	111401028	22,17								
M 16 x 2,0	16,0	45	18	15,82	111401029	22,17	111402010	33,79	111404009	44,88	111405018	61,95		
M 18 x 2,5	18,0	45	18	17,79	111401030	22,17	111402011	33,79	111404010	44,88	111405019	64,05		
M 19 x 2,5	19,0	45	18	18,89	111401031	32,14								
M 20 x 2,5	20,0	45	18	19,79	111401032	22,17	111402012	33,79	111404011	44,88	111405020	65,10		
M 22 x 2,5	22,0	55	22	21,79	111401033	43,22	111402013	50,97	111404012	79,74	111405021	145,16		

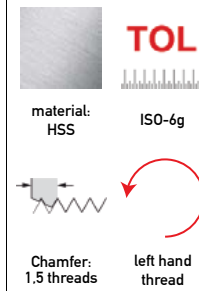
Round Dies

M Metric coarse thread
ISO DIN 13

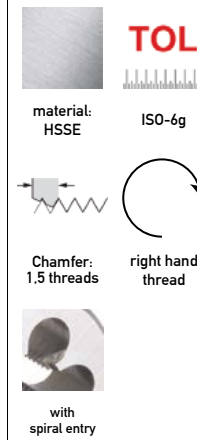
Round Dies
for general use



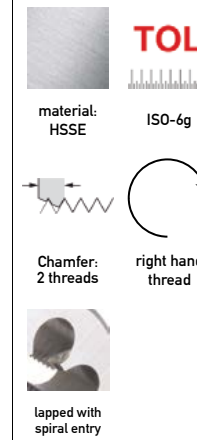
Round Dies
for general use
Left Hand



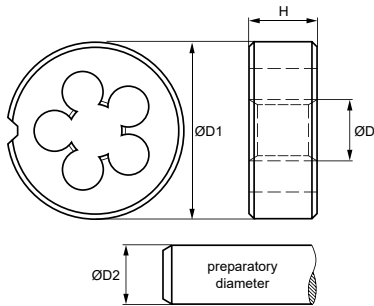
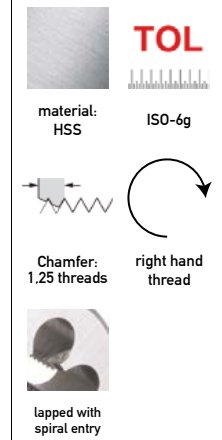
Round Dies
for higher demands



Round Dies
for stainless steels



Round Dies
for brass



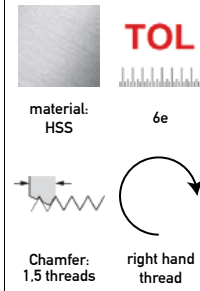
M	D	D1	H	D2	No.	€	No.	€	No.	€	No.	€	No.	€
M 24 x 3,0	24,0	55	22	23,76	111401034	43,22	111402014	51,24	111404013	79,74	111405022	145,16		
M 27 x 3,0	27,0	65	25	26,76	111401035	58,17	111402015	92,44	111404014	118,06	111405023	250,76		
M 30 x 3,5	30,0	65	25	29,73	111401036	58,17	111402016	92,44	111404015	118,06	111405024	194,25		
M 33 x 3,5	33,0	65	25	32,73	111401037	62,05	111402017	92,44						
M 36 x 4,0	36,0	65	25	35,70	111401038	62,05	111402018	92,44						
M 39 x 4,0	39,0	75	30	38,70	111401039	100,85	111402019	155,93						
M 42 x 4,5	42,0	75	30	41,68	111401040	100,85	111402020	155,93						
M 45 x 4,5	45,0	90	36	44,68	111401041	172,86	111402021	245,01						
M 48 x 5,0	48,0	90	36	47,66	111401042	172,86	111402022	245,01						
M 52 x 5,0	52,0	90	36	51,66	111401043	172,86	111402023	245,01						
M 56 x 5,5	56,0	105	36	55,65	111401044	346,84								
M 60 x 5,5	60,0	105	36	59,65	111401045	346,84								
M 64 x 6,0	64,0	120	36	63,62	111401046	459,86								
M 68 x 6,0	68,0	120	36	67,62	111401047	459,86								
M 72 x 6,0	72,0	120	36		111401048	*								
M 76 x 6,0	76,0	120	36		111401049	*								
M 80 x 6,0	80,0	120	36		111401050	*								
M 84 x 6,0	84,0	130	36		111401051	*								
M 88 x 6,0	88,0	140	36		111401052	*								
M 90 x 6,0	90,0	140	36		111401053	*								
M 92 x 6,0	92,0	140	36		111401054	*								
M 96 x 6,0	96,0	140	36		111401055	*								
M 100 x 6,0	100,0	150	36		111401056	*								

* on request

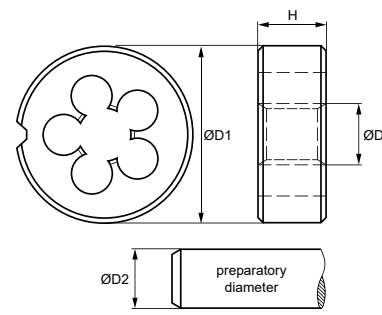
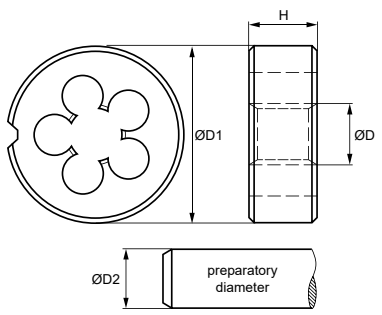
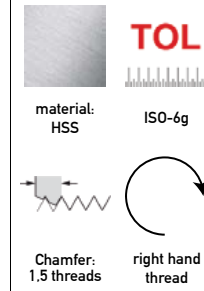
Round Dies

M Metric coarse thread ISO DIN 13

Round Dies for general use undersized



Round Dies for general use dimensions: 25 x 9



M	D	D1	H	D2	No.	€
M 3 x 0,5	3,0	20	5	2,89	111421001	8,87
M 4 x 0,7	4,0	20	5	3,87	111421002	8,87
M 5 x 0,8	5,0	20	7	4,86	111421003	9,20
M 6 x 1,0	6,0	20	7	5,85	111421004	9,20
M 8 x 1,25	8,0	25	9	7,83	111421005	9,87
M 10 x 1,5	10,0	30	11	9,81	111421006	12,75
M 12 x 1,75	12,0	38	14	11,81	111421007	19,72
M 14 x 2,0	14,0	38	14	13,87	111421008	25,49
M 16 x 2,0	16,0	45	18	15,87	111421009	38,34
M 18 x 2,5	18,0	45	18	17,75	111421010	38,34
M 20 x 2,5	20,0	45	18	19,75	111421011	38,34

M	D	D1	H	D2	No.	€
M 3 x 0,5	3,0	25	9	2,92	111422001	6,09
M 4 x 0,7	4,0	25	9	3,90	111422002	6,09
M 5 x 0,8	5,0	25	9	4,90	111422003	6,09
M 6 x 1,0	6,0	25	9	5,88	111422004	6,09
M 8 x 1,25	8,0	25	9	7,86	111422005	6,09
M 10 x 1,5	10,0	25	9	9,85	111422006	6,09
M 12 x 1,75	12,0	25	9	11,83	111422007	6,09

Hexagon Die Nuts

M Metric coarse thread
ISO DIN 13

Hexagon Die Nuts
for general use

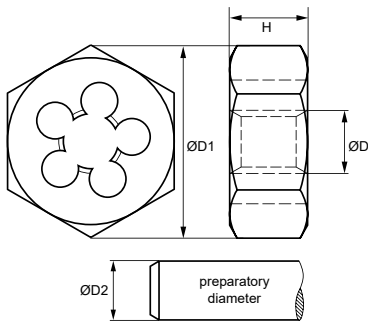
material: HSS
ISO-6g

Chamfer: 1.5 threads
right hand thread

Hexagon Die Nuts
for general use
Left Hand

material: HSS
ISO-6g

Chamfer: 1.5 threads
left hand thread



M	D	D1	H	D2	No.	€	No.	€
M 3 x 0,5	3,0	19	5	2,92	111501001	11,08	111502001	13,36
M 3,5 x 0,6	3,5	19	5	3,41	111501002	11,08		
M 4 x 0,7	4,0	19	5	3,90	111501003	11,08	111502002	13,36
M 5 x 0,8	4,5	19	7	4,40	111501004	11,08	111502003	14,48
M 6 x 1,0	6,0	19	7	5,88	111501005	11,08	111502004	14,48
M 7 x 1,0	7,0	22	9	6,88	111501006	12,19		
M 8 x 1,25	8,0	22	9	7,86	111501007	12,19	111502005	16,15
M 9 x 1,25	9,0	22	9	8,86	111501008	12,19		
M 10 x 1,5	10,0	27	11	9,85	111501009	14,41	111502006	22,83
M 11 x 1,5	11,0	27	11	10,85	111501010	14,41		
M 12 x 1,75	12,0	36	14	11,83	111501011	19,95	111502007	35,08
M 14 x 2,0	14,0	36	14	13,82	111501012	19,95	111502008	35,08
M 16 x 2,0	16,0	41	18	15,82	111501013	28,25	111502009	54,57
M 18 x 2,5	18,0	41	18	17,79	111501014	28,25	111502010	54,57
M 20 x 2,5	20,0	41	18	19,79	111501015	28,25	111502011	54,57
M 22 x 2,5	22,0	50	22	21,79	111501016	47,65	111502012	74,06
M 24 x 3,0	24,0	50	22	23,76	111501017	57,62	111502013	74,06
M 27 x 3,0	27,0	60	25	26,76	111501018	87,54	111502014	113,60
M 30 x 3,5	30,0	60	25	29,73	111501019	87,54	111502015	113,60
M 33 x 3,5	33,0	60	25	32,73	111501020	87,54	111502016	113,60
M 36 x 4,0	36,0	60	25	35,70	111501021	87,54	111502017	113,60
M 39 x 4,0	39,0	70	30	38,70	111501022	145,18	111502018	189,34
M 42 x 4,5	42,0	70	30	41,68	111501023	145,18	111502019	189,34
M 45 x 4,5	45,0	85	36	44,68	111501024	200,57	111502020	268,41
M 48 x 5,0	48,0	85	36	47,66	111501025	200,57	111502021	268,41
M 52 x 5,0	52,0	85	36	51,66	111501026	200,57	111502022	268,41
M 56 x 5,5	56,0	100	36	55,65	111501027	354,59		
M 60 x 5,5	60,0	100	36	59,65	111501028	354,59		
M 64 x 6,0	64,0	100	36	63,62	111501029	354,59		
M 68 x 6,0	68,0	115	36	67,62	111501030	459,87		

Thread Cutting Kits with Taps, Dies and Tools

MF

Metric fine thread
ISO DIN 13

BAER Hand-Tap Sets, Round Dies and Tools Sets (example picture)



BAER Set MF 3 - MF 12 HSSG Hand Tap Sets & HSS Round Dies & Tools		€/Set
BAER HSSG Hand Tap Sets (2 parts)	MF 3 x 0,35 MF 4 x 0,5 MF 5 x 0,5 6 x 0,75 MF 8 x 0,75 MF 8 x 1,0 MF 10 x 1,0 MF 12 x 1,5	289,58 € Item No.: 264801002
BAER HSS Round Dies	MF 3 x 0,35 MF 4 x 0,5 MF 5 x 0,5 6 x 0,75 MF 8 x 0,75 MF 8 x 1,0 MF 10 x 1,0 MF 12 x 1,5	
BAER adjustable Tap Wrenches - zinc die cast	M 1-10 1/16-3/8 G 1/8 & M 4-12 5/32-1/2 G 1/8	
BAER Die Stocks - zinc die cast	20 x 5 20 x 7 25 x 9 30 x 11 38 x 10	
Screw extractor		

BAER Set MF 6 - MF 20 HSSG Hand Tap Sets & HSS Round Dies & Tools		€/Set
BAER HSSG Hand Tap Sets (2 parts)	MF 6 x 0,75 MF 8 x 0,75 MF 8 x 1,0 MF 10 x 1,0 MF 12 x 1,0 MF 12 x 1,5 MF 14 x 1,25 MF 14 x 1,5 MF 16 x 1,5 MF 18 x 1,5 MF 20 x 1,5	517,89 € Item No.: 264801102
BAER HSS Round Dies	MF 6 x 0,75 MF 8 x 0,75 MF 8 x 1,0 MF 10 x 1,0 MF 12 x 1,0 MF 12 x 1,5 MF 14 x 1,25 MF 14 x 1,5 MF 16 x 1,5 MF 18 x 1,5 MF 20 x 1,5	
BAER adjustable Tap Wrenches - zinc die cast	M 1-10 1/16-3/8 G 1/8 & M 5-20 7/32-3/4 G 1/8-G 1/2	
BAER Die Stocks - zinc die cast	20 x 7 25 x 9 30 x 11 38 x 10 45 x 14	
Screw extractor		

BAER Set MF 6 - MF 24 HSSG Hand Tap Sets & HSS Round Dies & Tools		€/Set
BAER HSSG Hand Tap Sets (2 parts)	MF 6 x 0,75 MF 8 x 0,75 MF 8 x 1,0 MF 10 x 1,0 MF 12 x 1,0 MF 12 x 1,5 MF 14 x 1,25 MF 14 x 1,5 MF 16 x 1,5 MF 18 x 1,5 MF 20 x 1,5 MF 22 x 1,5 MF 24 x 1,5	757,38 € Item No.: 264801202
BAER HSS Round Dies	MF 6 x 0,75 MF 8 x 0,75 MF 8 x 1,0 MF 10 x 1,0 MF 12 x 1,0 MF 12 x 1,5 MF 14 x 1,25 MF 14 x 1,5 MF 16 x 1,5 MF 18 x 1,5 MF 20 x 1,5 MF 22 x 1,5 MF 24 x 1,5	
BAER adjustable Tap Wrenches - zinc die cast	M 1-10 1/16-3/8 G 1/8 & M 11-27 7/16-1" G 1/4-G 3/4	
BAER Die Stocks - zinc die cast	20 x 7 25 x 9 30 x 11 38 x 10 45 x 14 55 x 16	
Screw extractor		

Thread Cutting Kits with Taps and Dies

MF Metric fine thread
ISO DIN 13

BAER Short Machine Taps und Round Dies Sets MF 5 - MF 12 (example picture)



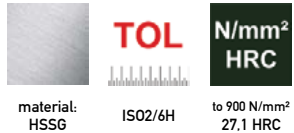
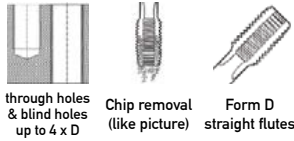
BAER Set MF 5 - MF 12
HSSG Short Machine Taps & Drill bits for core holes
HSS Round Dies

BAER HSSG Short Machine Tap Form D for through hole & blind hole (up to 4 x D)	M 5 x 0,5 M 6 x 0,75 M 8 x 1,0 M 10 x 1,0 M 12 x 1,5	€/Set 172,73 €
BAER HSSG Drill bits for core holes	4,3 mm 5,2 mm 7,0 mm 9,0 mm 10,5 mm	
BAER HSS Round Dies	M 5 x 0,5 M 6 x 0,75 M 8 x 1,0 M 10 x 1,0 M 12 x 1,5	

Short Machine Taps

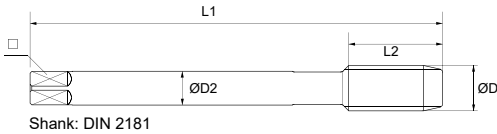
MF Metric fine thread ISO DIN 13

Short Machine Taps Form D for through holes and blind holes



Efficient internal thread cutting.
The short structural type makes that tap usable by machine and hand.

Application:
non abrasive material up to 900 N/mm²
unalloyed and low alloyed steel



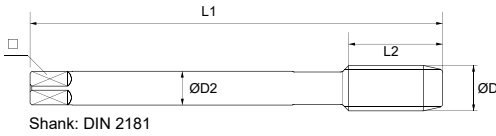
MF	D1	D2	L1	L2	□	✎	No.	€
MF 6 x 0,75	6,0	6,0	50	14	4,9	5,20	120101001	6,64
MF 8 x 0,75	8,0	6,0	50	19	4,9	6,20	120101002	6,64
MF 8 x 1,0	8,0	6,0	56	22	4,9	7,00	120101003	6,64
MF 9 x 0,75	9,0	7,0	56	19	5,5	8,20	120101004	7,43
MF 9 x 1,0	9,0	7,0	63	20	5,5	8,00	120101005	7,43
MF 10 x 0,75	10,0	7,0	63	20	5,5	9,20	120101006	7,43
MF 10 x 1,0	10,0	7,0	63	20	5,5	9,00	120101007	6,64
MF 10 x 1,25	10,0	7,0	70	24	5,5	8,80	120101008	7,43
MF 12 x 1,0	12,0	9,0	70	22	7,0	11,00	120101009	9,64
MF 12 x 1,25	12,0	9,0	70	22	7,0	10,80	120101010	9,64
MF 12 x 1,5	12,0	9,0	70	22	7,0	10,50	120101011	8,75
MF 13 x 1,0	13,0	11,0	70	22	9,0	12,00	120101012	14,74
MF 13 x 1,5	13,0	11,0	70	22	9,0	11,50	120101013	14,74
MF 14 x 1,0	14,0	11,0	70	22	9,0	13,00	120101014	14,74
MF 14 x 1,25	14,0	11,0	70	22	9,0	12,80	120101015	11,08
MF 14 x 1,5	14,0	11,0	70	22	9,0	12,50	120101016	9,53
MF 15 x 1,5	15,0	12,0	70	22	9,0	13,50	120101017	16,29
MF 16 x 1,5	16,0	12,0	70	22	9,0	14,50	120101018	11,64
MF 18 x 1,0	18,0	14,0	80	22	11,0	17,00	120101019	17,84
MF 18 x 1,5	18,0	14,0	80	22	11,0	16,50	120101020	13,41
MF 20 x 1,5	20,0	16,0	80	22	12,0	18,50	120101021	16,29
MF 20 x 2,0	20,0	16,0	80	22	12,0	18,00	120101022	22,39
MF 22 x 1,5	22,0	18,0	80	22	14,5	20,50	120101023	23,16
MF 22 x 2,0	22,0	18,0	80	22	14,5	20,00	120101024	23,16
MF 24 x 1,5	24,0	18,0	90	22	14,5	22,50	120101025	24,38
MF 24 x 2,0	24,0	18,0	90	22	14,5	22,00	120101026	31,03
MF 25 x 1,5	25,0	18,0	90	22	14,5	23,50	120101027	45,43
MF 26 x 1,5	26,0	18,0	90	22	14,5	24,50	120101028	45,43
MF 27 x 1,5	27,0	20,0	90	22	16,0	25,50	120101029	45,43
MF 28 x 1,5	28,0	20,0	90	22	16,0	26,50	120101030	53,74
MF 30 x 1,5	30,0	22,0	90	22	18,0	28,50	120101031	63,16
MF 30 x 2,0	30,0	22,0	90	22	18,0	28,00	120101032	63,16
MF 32 x 1,5	32,0	22,0	90	22	18,0	30,50	120101033	63,16

Hand Tap Sets

MF Metric fine thread
ISO DIN 13

Efficient internal thread cutting.
The short structural type makes that tap usable by hand.

A Hand-Tap-Set includes 2 taps:
Taper Tap
Finish Tap



Hand Tap Sets for general use

through holes & blind holes up to 2 x D
Chip removal (like picture)
Form C straight flutes

material: HSSG ISO2/6H
TOL
N/mm² HRC to 900 N/mm² 27,1 HRC

2-3 threads outside cooling and lubrication

Hand Tap Sets for general use

through holes & blind holes up to 2 x D
Chip removal (like picture)
Form C straight flutes

material: HSSG ISO2/6H
TOL
N/mm² HRC to 900 N/mm² 27,1 HRC

2-3 threads outside cooling and lubrication

Left Hand

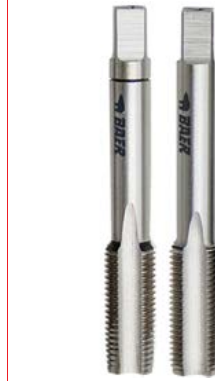
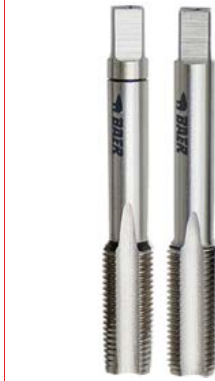
Hand Tap Sets for higher demands

HSSE

through holes & blind holes up to 2 x D
Chip removal (like picture)
Form C straight flutes

material: HSSE ISO2/6H
TOL
N/mm² HRC bis 1000 N/mm² 31 HRC

2-3 threads outside cooling and lubrication



MF	D1	D2	L1	L2	□	✎	No.	€	No.	€	No.	€
MF 2,5 x 0,35	2,5	2,8	40	9	2,1	2,15	120301001	14,85				
MF 2,6 x 0,35	2,6	2,8	40	9	2,1	2,25	120301002	14,85				
MF 3 x 0,35	3,0	3,5	40	9	2,7	2,65	120301003	14,85				
MF 3,5 x 0,35	3,5	4,0	45	10	3,0	3,15	120301004	14,85				
MF 4 x 0,35	4,0	4,5	45	10	3,4	3,65	120301005	14,85				
MF 4 x 0,5	4,0	4,5	45	10	3,4	3,50	120301006	14,85				
MF 4,5 x 0,5	4,5	6,0	50	12	4,9	4,00	120301007	14,85				
MF 5 x 0,5	5,0	6,0	50	12	4,9	4,50	120301008	14,85				
MF 5 x 0,75	5,0	6,0	50	12	4,9	4,25	120301009	14,85				
MF 5,5 x 0,5	5,5	6,0	50	12	4,9	5,00	120301010	14,85				
MF 6 x 0,5	6,0	6,0	50	14	4,9	5,50	120301011	14,85				
MF 6 x 0,75	6,0	6,0	50	14	4,9	5,20	120301012	13,30	120302001	19,83	120304001	17,82
MF 7 x 0,5	7,0	6,0	50	14	4,9	6,50	120301013	13,30				
MF 7 x 0,75	7,0	6,0	50	14	4,9	6,20	120301014	13,30				
MF 8 x 0,5	8,0	6,0	50	19	4,9	7,50	120301015	13,30				
MF 8 x 0,75	8,0	6,0	50	19	4,9	7,20	120301016	13,30	120302002	19,83	120304002	17,82
MF 8 x 1	8,0	6,0	56	22	4,9	7,00	120301017	13,30	120302003	19,83	120304003	17,82
MF 9 x 0,5	9,0	7,0	56	19	5,5	8,50	120301018	14,85				
MF 9 x 0,75	9,0	7,0	56	19	5,5	8,25	120301019	14,85				
MF 9 x 1	9,0	7,0	63	20	5,5	8,00	120301020	14,85				
MF 10 x 0,5	10,0	7,0	63	20	5,5	9,50	120301021	14,85				
MF 10 x 0,75	10,0	7,0	63	20	5,5	9,20	120301022	14,85				
MF 10 x 1,0	10,0	7,0	63	20	5,5	9,00	120301023	13,30	120302004	19,83	120304004	19,38
MF 10 x 1,25	10,0	7,0	70	24	5,5	8,80	120301024	14,85	120302005	22,27	120304005	22,27
MF 11 x 0,75	11,0	8,0	63	20	6,2	10,20	120301025	19,28				
MF 11 x 1,0	11,0	8,0	63	20	6,2	10,00	120301026	19,28				
MF 11 x 1,25	11,0	8,0	63	22	6,2	10,80	120301027	19,28				
MF 12 x 0,5	12,0	9,0	70	22	7,0	11,50	120301028	19,28				
MF 12 x 0,75	12,0	9,0	70	22	7,0	10,20	120301029	19,28				
MF 12 x 1,0	12,0	9,0	70	22	7,0	11,00	120301030	19,28	120302006	29,41	120304006	26,95
MF 12 x 1,25	12,0	9,0	70	22	7,0	10,80	120301031	19,28	120302007	29,41	120304007	26,95
MF 12 x 1,5	12,0	9,0	70	22	7,0	10,50	120301032	17,51	120302008	26,95	120304008	26,95
MF 13 x 0,5	13,0	11,0	70	22	9,0	12,50	120301033	29,48				

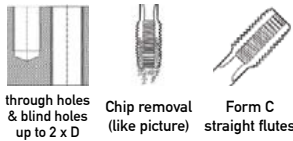
Hand Tap Sets

MF Metric fine thread ISO DIN 13

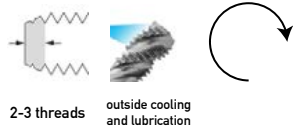
Efficient internal thread cutting.
The short structural type makes that tap usable by hand.

A Hand-Tap-Set includes 2 taps:
Taper Tap
Finish Tap

Hand Tap Sets for general use

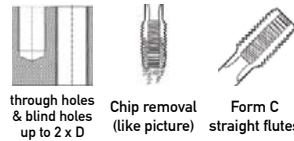


through holes & blind holes up to 2 x D
Chip removal (like picture)
Form C straight flutes

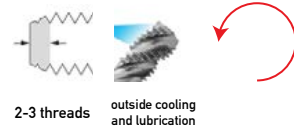


Hand Tap Sets for general use

Left Hand

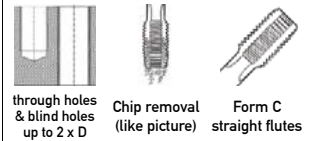


through holes & blind holes up to 2 x D
Chip removal (like picture)
Form C straight flutes

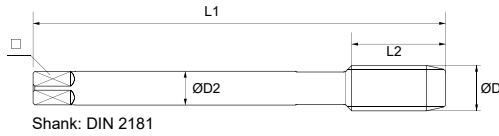


Hand Tap Sets for higher demands

HSSE



through holes & blind holes up to 2 x D
Chip removal (like picture)
Form C straight flutes



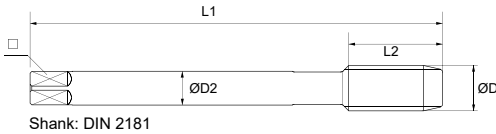
MF	D1	D2	L1	L2	□		No.	€	No.	€	No.	€
MF 13 x 0,75	13,0	11,0	70	22	9,0	12,20	120301034	29,62				
MF 13 x 1,0	13,0	11,0	70	22	9,0	12,00	120301035	29,62				
MF 13 x 1,5	13,0	11,0	70	22	9,0	11,50	120301036	29,62				
MF 14 x 0,5	14,0	11,0	70	22	9,0	13,50	120301037	29,62				
MF 14 x 0,75	14,0	11,0	70	22	9,0	13,20	120301038	29,62				
MF 14 x 1,0	14,0	11,0	70	22	9,0	13,00	120301039	29,62				
MF 14 x 1,25	14,0	11,0	70	22	9,0	12,80	120301040	22,27	120302009	32,75	120304009	31,18
MF 14 x 1,5	14,0	11,0	70	22	9,0	12,50	120301041	19,16	120302010	29,41	120304010	28,29
MF 15 x 0,75	15,0	12,0	70	22	9,0	14,20	120301042	32,74				
MF 15 x 1,0	15,0	12,0	70	22	9,0	14,00	120301043	32,74				
MF 15 x 1,5	15,0	12,0	70	22	9,0	13,50	120301044	32,74				
MF 16 x 0,5	16,0	12,0	70	22	9,0	15,50	120301045	32,74				
MF 16 x 0,75	16,0	12,0	70	22	9,0	15,20	120301046	32,74				
MF 16 x 1,0	16,0	12,0	70	22	9,0	15,00	120301047	32,74	120302011	49,01	120304011	35,86
MF 16 x 1,25	16,0	12,0	70	22	9,0	14,80	120301048	32,74				
MF 16 x 1,5	16,0	12,0	70	22	9,0	14,50	120301049	23,39	120302012	35,19	120304012	41,21
MF 17 x 1	17,0	12,0	70	22	9,0	16,00	120301050	35,86				
MF 17 x 1,5	17,0	12,0	70	22	9,0	15,50	120301051	35,86				
MF 18 x 0,5	18,0	14,0	80	22	11,0	17,50	120301052	35,86				
MF 18 x 0,75	18,0	14,0	80	22	11,0	17,20	120301053	35,86				
MF 18 x 1,0	18,0	14,0	80	22	11,0	17,00	120301054	35,86				
MF 18 x 1,25	18,0	14,0	80	22	11,0	16,80	120301055	35,86				
MF 18 x 1,5	18,0	14,0	80	22	11,0	16,50	120301056	26,95	120302013	41,21	120304013	49,90
MF 18 x 2,0	18,0	14,0	80	22	11,0	16,00	120301057	35,86				
MF 19 x 1	19,0	16,0	80	22	12,0	18,00	120301058	44,99				
MF 19 x 1,5	19,0	14,0	80	22	11,0	17,50	120301059	44,99				
MF 20 x 0,5	20,0	16,0	80	22	12,0	19,50	120301060	44,99				
MF 20 x 0,75	20,0	16,0	80	22	12,0	19,20	120301061	44,99				
MF 20 x 1,0	20,0	16,0	80	22	12,0	19,00	120301062	44,99				
MF 20 x 1,25	20,0	16,0	80	22	12,0	18,80	120301063	44,99				
MF 20 x 1,5	20,0	16,0	80	22	12,0	18,50	120301064	32,74	120302014	49,01	120304014	46,78
MF 20 x 2,0	20,0	16,0	80	22	12,0	18,00	120301065	44,99			120304015	62,37
MF 21 x 1	21,0	16,0	80	22	12,0	20,00	120301066	46,55				

Hand Tap Sets

MF Metric fine thread
ISO DIN 13

Efficient internal thread cutting.
The short structural type makes that tap usable by hand.

A Hand-Tap-Set includes 2 taps:
Taper Tap
Finish Tap



Hand Tap Sets for general use

through holes & blind holes up to 2 x D
Chip removal (like picture)
Form C straight flutes

material: HSSG
ISO2/6H

TOL

N/mm² HRC
to 900 N/mm²
27,1 HRC

2-3 threads
outside cooling and lubrication

Hand Tap Sets for general use

Left Hand

through holes & blind holes up to 2 x D
Chip removal (like picture)
Form C straight flutes

material: HSSG
ISO2/6H

TOL

N/mm² HRC
to 900 N/mm²
27,1 HRC

2-3 threads
outside cooling and lubrication

Hand Tap Sets for higher demands

HSSE

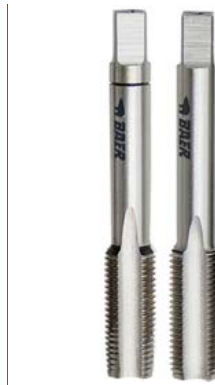
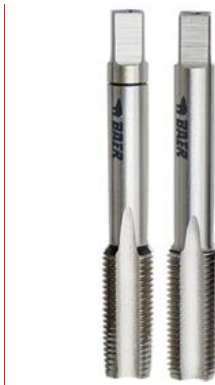
through holes & blind holes up to 2 x D
Chip removal (like picture)
Form C straight flutes

material: HSSE
ISO2/6H

TOL

N/mm² HRC
bis 1000 N/mm²
31 HRC

2-3 threads
outside cooling and lubrication



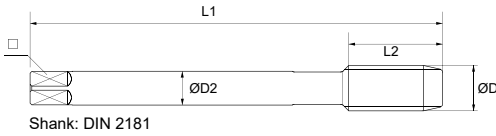
MF	D1	D2	L1	L2	□		No.	€	No.	€	No.	€
MF 21 x 1,5	21,0	16,0	80	22	12,0	19,50	120301067	46,55				
MF 22 x 0,5	22,0	18,0	80	22	14,5	21,50	120301068	46,55				
MF 22 x 0,75	22,0	18,0	80	22	14,5	21,20	120301069	46,55				
MF 22 x 1,0	22,0	18,0	80	22	14,5	21,00	120301070	46,55				
MF 22 x 1,25	22,0	18,0	80	22	14,5	20,80	120301071	46,55				
MF 22 x 1,5	22,0	18,0	80	22	14,5	20,50	120301072	46,55	120302015	64,60	120304016	58,36
MF 22 x 2,0	22,0	18,0	80	22	14,5	20,00	120301073	46,55			120304017	62,37
MF 23 x 1	23,0	18,0	80	22	14,5	22,00	120301074	62,37				
MF 23 x 1,5	23,0	18,0	80	22	14,5	21,50	120301075	62,37				
MF 24 x 0,5	24,0	18,0	90	22	14,5	23,50	120301076	62,37				
MF 24 x 0,75	24,0	18,0	90	22	14,5	23,20	120301077	62,37				
MF 24 x 1,0	24,0	18,0	90	22	14,5	23,00	120301078	62,37				
MF 24 x 1,25	24,0	18,0	90	22	14,5	23,80	120301079	62,37				
MF 24 x 1,5	24,0	18,0	90	22	14,5	22,50	120301080	49,00	120302016	71,28	120304018	77,96
MF 24 x 2,0	24,0	18,0	90	22	14,5	22,00	120301081	62,37	120302017	93,56		
MF 25 x 1,0	25,0	18,0	90	22	14,5	24,00	120301082	91,33				
MF 25 x 1,5	25,0	18,0	90	22	14,5	23,50	120301083	91,33				
MF 26 x 1,0	26,0	18,0	90	22	14,5	25,00	120301084	91,33				
MF 26 x 1,5	26,0	18,0	90	22	14,5	24,50	120301085	91,33				
MF 26 x 2,0	26,0	18,0	90	22	14,5	24,00	120301086	91,33				
MF 27 x 1	27,0	20,0	90	22	16,0	26,00	120301087	91,33				
MF 27 x 1,5	27,0	20,0	90	22	16,0	25,50	120301088	91,33				
MF 27 x 2,0	27,0	20,0	90	22	16,0	25,00	120301089	108,03				
MF 28 x 1,0	28,0	20,0	90	22	16,0	27,00	120301090	108,03				
MF 28 x 1,5	28,0	20,0	90	22	16,0	26,50	120301091	108,03				
MF 28 x 2,0	28,0	20,0	90	22	16,0	26,00	120301092	108,03				
MF 29 x 1,5	29,0	22,0	90	22	18,0	27,50	120301093	108,03				
MF 30 x 1,0	30,0	22,0	90	22	18,0	29,00	120301094	126,97				
MF 30 x 1,5	30,0	22,0	90	22	18,0	28,50	120301095	126,97	120302018	189,34		
MF 30 x 2,0	30,0	22,0	90	22	18,0	28,00	120301096	126,97	120302019	189,34		
MF 30 x 2,5	30,0	22,0	125	56	18,0	27,50	120301097	126,97				
MF 30 x 3,0	30,0	22,0	125	56	18,0	27,00	120301098	126,97				
MF 32 x 1	32,0	22,0	90	22	18,0	31,00	120301099	126,97				

Hand Tap Sets

MF Metric fine thread ISO DIN 13

Efficient internal thread cutting.
The short structural type makes that tap usable by hand.

A Hand-Tap-Set includes 2 taps:
Taper Tap
Finish Tap



Hand Tap Sets for general use

through holes & blind holes up to 2 x D
Chip removal (like picture)
Form C straight flutes

material: HSSG
ISO2/6H

TOL

N/mm² HRC
to 900 N/mm² 27,1 HRC

2-3 threads
outside cooling and lubrication

Hand Tap Sets for general use

Left Hand

through holes & blind holes up to 2 x D
Chip removal (like picture)
Form C straight flutes

material: HSSG
ISO2/6H

TOL

N/mm² HRC
to 900 N/mm² 27,1 HRC

2-3 threads
outside cooling and lubrication

Hand Tap Sets for higher demands

HSSE

through holes & blind holes up to 2 x D
Chip removal (like picture)
Form C straight flutes

material: HSSE
ISO2/6H

TOL

N/mm² HRC
bis 1000 N/mm² 31 HRC

2-3 threads
outside cooling and lubrication



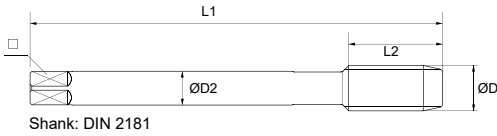
MF	D1	D2	L1	L2	□		No.	€	No.	€	No.	€
MF 32 x 1,5	32,0	22,0	90	22	18,0	30,50	120301100	126,97				
MF 32 x 2,0	32,0	22,0	90	22	18,0	30,00	120301101	126,97				
MF 32 x 3,0	32,0	22,0	125	56	18,0	29,00	120301102	126,97				
MF 33 x 1,5	33,0	25,0	100	25	20,0	31,50	120301103	126,97				
MF 33 x 2,0	33,0	25,0	100	25	20,0	31,00	120301104	155,92				
MF 33 x 3,0	33,0	25,0	125	56	20,0	30,00	120301105	155,92				
MF 34 x 1	34,0	28,0	100	25	22,0	33,00	120301106	155,92				
MF 34 x 1,5	34,0	28,0	100	25	22,0	32,50	120301107	155,92				
MF 34 x 2,0	34,0	28,0	125	40	22,0	32,00	120301108	155,92				
MF 35 x 1	35,0	28,0	100	25	22,0	34,00	120301109	155,92				
MF 35 x 1,5	35,0	28,0	100	25	22,0	33,50	120301110	155,92				
MF 35 x 2	35,0	28,0	125	40	22,0	33,00	120301111	155,92				
MF 36 x 1	36,0	28,0	100	25	22,0	35,00	120301112	162,61				
MF 36 x 1,5	36,0	28,0	100	25	22,0	34,50	120301113	162,61				
MF 36 x 2,0	36,0	28,0	125	40	22,0	34,00	120301114	162,61				
MF 36 x 3,0	36,0	28,0	125	40	22,0	33,00	120301115	162,61				
MF 37 x 1,5	37,0	28,0	100	25	22,0	35,50	120301116	202,70				
MF 38 x 1	38,0	28,0	100	25	22,0	37,00	120301117	202,70				
MF 38 x 1,5	38,0	28,0	100	25	22,0	36,50	120301118	202,70				
MF 38 x 2	38,0	28,0	125	40	22,0	36,00	120301119	202,70				
MF 38 x 3	38,0	28,0	125	40	22,0	35,00	120301120	202,70				
MF 39 x 1,5	39,0	32,0	110	25	24,0	37,50	120301121	202,70				
MF 39 x 2,0	39,0	32,0	125	40	24,0	37,00	120301122	202,70				
MF 39 x 3,0	39,0	32,0	125	40	24,0	36,00	120301123	202,70				
MF 40 x 1	40,0	32,0	110	25	24,0	39,00	120301124	202,70				
MF 40 x 1,5	40,0	32,0	110	25	24,0	38,50	120301125	202,70				
MF 40 x 2,0	40,0	32,0	125	40	24,0	38,00	120301126	202,70				
MF 40 x 3,0	40,0	32,0	125	40	24,0	37,00	120301127	202,70				
MF 42 x 1	42,0	32,0	110	25	24,0	41,00	120301128	202,70				
MF 42 x 1,5	42,0	32,0	110	25	24,0	40,50	120301129	202,70				
MF 42 x 2,0	42,0	32,0	125	40	24,0	40,00	120301130	211,63				
MF 42 x 3,0	42,0	32,0	125	40	24,0	39,00	120301131	211,63				
MF 44 x 1,5	44,0	36,0	110	25	29,0	42,50	120301132	238,35				

Hand Tap Sets

MF Metric fine thread ISO DIN 13

Efficient internal thread cutting.
The short structural type makes that tap usable by hand.

A Hand-Tap-Set includes 2 taps:
Taper Tap
Finish Tap



Hand Tap Sets for general use

through holes & blind holes up to 2 x D
Chip removal (like picture)
Form C straight flutes

material: HSSG
ISO2/6H

TOL

N/mm² HRC
to 900 N/mm² 27,1 HRC

2-3 threads
outside cooling and lubrication

Hand Tap Sets for general use Left Hand

through holes & blind holes up to 2 x D
Chip removal (like picture)
Form C straight flutes

material: HSSG
ISO2/6H

TOL

N/mm² HRC
to 900 N/mm² 27,1 HRC

2-3 threads
outside cooling and lubrication

Hand Tap Sets for higher demands HSSE

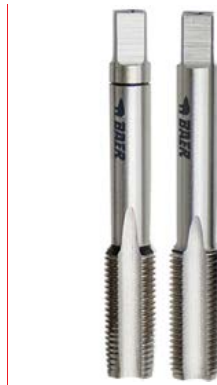
through holes & blind holes up to 2 x D
Chip removal (like picture)
Form C straight flutes

material: HSSE
ISO2/6H

TOL

N/mm² HRC
bis 1000 N/mm² 31 HRC

2-3 threads
outside cooling and lubrication



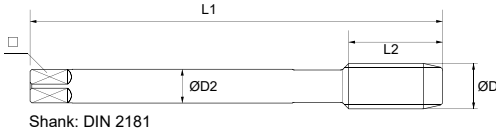
MF	D1	D2	L1	L2	□		No.	€	No.	€	No.	€
MF 44 x 2	44,0	36,0	125	40	29,0	42,00	120301133	238,35				
MF 45 x 1	45,0	36,0	110	25	29,0	44,00	120301134	238,35				
MF 45 x 1,5	45,0	36,0	110	25	29,0	43,50	120301135	238,35				
MF 45 x 2,0	45,0	36,0	125	40	29,0	43,00	120301136	238,35				
MF 45 x 3,0	45,0	36,0	125	40	29,0	42,00	120301137	238,35				
MF 46 x 1,5	46,0	36,0	140	40	29,0	45,50	120301138	238,35				
MF 48 x 1	48,0	36,0	140	40	29,0	47,00	120301139	285,13				
MF 48 x 1,5	48,0	36,0	140	40	29,0	46,50	120301140	285,13				
MF 48 x 2,0	48,0	36,0	140	40	29,0	46,00	120301141	285,13				
MF 48 x 3,0	48,0	36,0	140	40	29,0	45,00	120301142	285,13				
MF 50 x 1,5	50,0	36,0	140	40	29,0	48,50	120301143	311,84				
MF 50 x 2,0	50,0	36,0	140	40	29,0	48,00	120301144	311,84				
MF 50 x 3,0	50,0	36,0	140	40	29,0	47,00	120301145	311,84				
MF 52 x 1,5	52,0	40,0	140	40	32,0	50,50	120301146	374,22				
MF 52 x 2,0	52,0	40,0	140	40	32,0	50,00	120301147	374,22				
MF 52 x 3,0	52,0	40,0	140	40	32,0	49,00	120301148	374,22				
MF 54 x 1	54,0	40,0	140	32	32,0	53,00	120301149	405,40				
MF 54 x 1,5	54,0	40,0	140	32	32,0	52,50	120301150	405,40				
MF 54 x 2,0	54,0	40,0	140	36	32,0	52,00	120301151	405,40				
MF 54 x 3,0	54,0	40,0	140	40	32,0	51,00	120301152	405,40				
MF 54 x 4,0	54,0	40,0	180	50	32,0	50,00	120301153	405,40				
MF 55 x 1,5	55,0	40,0	140	32	32,0	53,50	120301154	463,30				
MF 55 x 2,0	55,0	40,0	140	36	32,0	53,00	120301155	463,30				
MF 55 x 3,0	55,0	40,0	140	40	32,0	52,00	120301156	463,30				
MF 55 x 4,0	55,0	40,0	180	50	32,0	51,00	120301157	463,30				
MF 56 x 1	56,0	40,0	140	32	32,0	55,00	120301158	514,56				
MF 56 x 1,5	56,0	40,0	140	32	32,0	54,50	120301159	521,22				
MF 56 x 2,0	56,0	40,0	140	36	32,0	54,00	120301160	521,22				
MF 56 x 3,0	56,0	40,0	140	40	32,0	53,00	120301161	521,22				
MF 56 x 4,0	56,0	40,0	180	50	32,0	52,00	120301162	521,22				
MF 58 x 1	58,0	45,0	160	32	35,0	57,00	120301163	556,87				
MF 58 x 1,5	58,0	45,0	160	32	35,0	56,50	120301164	530,15				
MF 58 x 2,0	58,0	45,0	160	36	35,0	56,00	120301165	530,15				

Hand Tap Sets

MF Metric fine thread ISO DIN 13

Efficient internal thread cutting.
The short structural type makes that tap usable by hand.

A Hand-Tap-Set includes 2 taps:
Taper Tap
Finish Tap



Hand Tap Sets for general use

through holes & blind holes up to 2 x D
Chip removal (like picture)
Form C straight flutes

material: HSSG
ISO2/6H
TOL
N/mm² HRC
to 900 N/mm² 27,1 HRC

2-3 threads
outside cooling and lubrication

Hand Tap Sets for general use

Left Hand

through holes & blind holes up to 2 x D
Chip removal (like picture)
Form C straight flutes

material: HSSG
ISO2/6H
TOL
N/mm² HRC
to 900 N/mm² 27,1 HRC

2-3 threads
outside cooling and lubrication

Hand Tap Sets for higher demands

HSSE

through holes & blind holes up to 2 x D
Chip removal (like picture)
Form C straight flutes

material: HSSE
ISO2/6H
TOL
N/mm² HRC
bis 1000 N/mm² 31 HRC

2-3 threads
outside cooling and lubrication



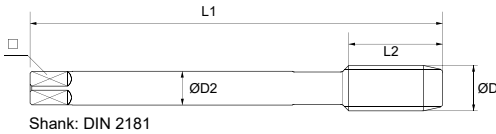
MF	D1	D2	L1	L2	□		No.	€	No.	€	No.	€
MF 58 x 3,0	58,0	45,0	160	40	35,0	55,00	120301166	530,15				
MF 58 x 4,0	58,0	45,0	200	55	35,0	54,00	120301167	530,15				
MF 60 x 1,5	60,0	45,0	160	34	35,0	58,50	120301168	554,66				
MF 60 x 2,0	60,0	45,0	160	36	35,0	58,00	120301169	554,66				
MF 60 x 3,0	60,0	45,0	160	40	35,0	57,00	120301170	554,66				
MF 60 x 4,0	60,0	45,0	200	55	35,0	56,00	120301171	554,66				
MF 62 x 1,5	62,0	50,0	160	34	39,0	60,50	120301172	634,87				
MF 62 x 2,0	62,0	50,0	160	36	39,0	60,00	120301173	634,87				
MF 62 x 3,0	62,0	50,0	180	45	39,0	59,00	120301174	634,87				
MF 62 x 4,0	62,0	50,0	220	55	39,0	58,00	120301175	634,87				
MF 63 x 1,5	63,0	50,0	160	32	39,0	61,50	120301176	652,68				
MF 64 x 1,5	64,0	50,0	160	34	39,0	62,50	120301177	652,68				
MF 64 x 2,0	64,0	50,0	160	36	39,0	62,00	120301178	652,68				
MF 64 x 3,0	64,0	50,0	180	45	39,0	61,00	120301179	652,68				
MF 64 x 4,0	64,0	50,0	220	60	39,0	60,00	120301180	663,80				
MF 65 x 1,5	65,0	50,0	160	34	39,0	63,50	120301181	690,50				
MF 65 x 2,0	65,0	50,0	160	36	39,0	63,00	120301182	690,50				
MF 65 x 3,0	65,0	50,0	180	45	39,0	62,00	120301183	690,50				
MF 65 x 4,0	65,0	50,0	220	60	39,0	61,00	120301184	690,50				
MF 68 x 1,5	68,0	50,0	160	36	39,0	66,50	120301185	712,80				
MF 68 x 2,0	68,0	50,0	160	40	39,0	66,00	120301186	712,80				
MF 68 x 3,0	68,0	50,0	180	50	39,0	65,00	120301187	712,80				
MF 68 x 4,0	68,0	50,0	220	60	39,0	64,00	120301188	712,80				
MF 70 x 1,5	70,0	50,0	160	36	39,0	68,50	120301189	1247,45				
MF 70 x 2,0	70,0	50,0	160	40	39,0	68,00	120301190	1247,45				
MF 70 x 3,0	70,0	50,0	200	50	39,0	67,00	120301191	1414,50				
MF 70 x 4,0	70,0	50,0	240	60	39,0	66,00	120301192	1414,50				
MF 72 x 1,5	72,0	50,0	160	36	39,0	70,50	120301193	1247,45				
MF 72 x 2,0	72,0	50,0	160	40	39,0	70,00	120301194	1247,45				
MF 72 x 3,0	72,0	50,0	200	50	39,0	69,00	120301195	1414,50				
MF 72 x 4,0	72,0	50,0	240	60	39,0	68,00	120301196	1414,50				
MF 74 x 1,5	74,0	50,0	160	36	39,0	72,50	120301197	1381,02				
MF 74 x 2,0	74,0	50,0	160	40	39,0	72,00	120301198	1381,02				

Hand Tap Sets

MF Metric fine thread ISO DIN 13

Efficient internal thread cutting.
The short structural type makes that tap usable by hand.

A Hand-Tap-Set includes 2 taps:
Taper Tap
Finish Tap



Hand Tap Sets for general use

through holes & blind holes up to 2 x D
Chip removal (like picture)
Form C straight flutes

material: HSSG
ISO2/6H

TOL

N/mm² HRC
to 900 N/mm² 27,1 HRC

2-3 threads
outside cooling and lubrication

Hand Tap Sets for general use

Left Hand

through holes & blind holes up to 2 x D
Chip removal (like picture)
Form C straight flutes

material: HSSG
ISO2/6H

TOL

N/mm² HRC
to 900 N/mm² 27,1 HRC

2-3 threads
outside cooling and lubrication

Hand Tap Sets for higher demands

HSSE

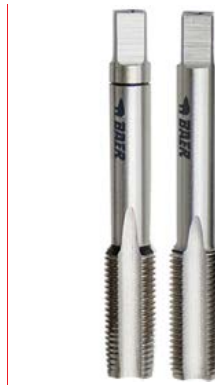
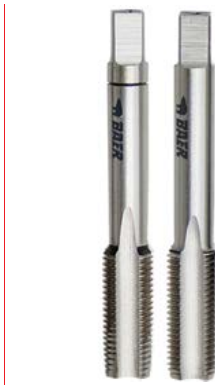
through holes & blind holes up to 2 x D
Chip removal (like picture)
Form C straight flutes

material: HSSE
ISO2/6H

TOL

N/mm² HRC
bis 1000 N/mm² 31 HRC

2-3 threads
outside cooling and lubrication



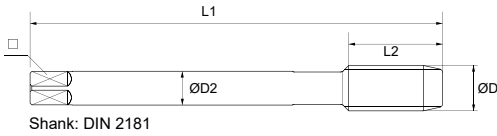
MF	D1	D2	L1	L2	□		No.	€	No.	€	No.	€
MF 74 x 3,0	74,0	50,0	200	50	39,0	71,00	120301199	1626,09				
MF 74 x 4,0	74,0	50,0	240	60	39,0	70,00	120301200	1626,09				
MF 75 x 1,5	75,0	50,0	160	36	39,0	73,50	120301201	1392,21				
MF 75 x 2,0	75,0	50,0	160	40	39,0	73,00	120301202	1392,21				
MF 75 x 3,0	75,0	50,0	200	50	39,0	72,00	120301203	1637,21				
MF 75 x 4,0	75,0	50,0	240	60	39,0	71,00	120301204	1637,21				
MF 76 x 1,5	76,0	50,0	160	36	39,0	74,50	120301205	1414,50				
MF 76 x 2,0	76,0	50,0	160	40	39,0	74,00	120301206	1414,50				
MF 76 x 3,0	76,0	50,0	220	50	39,0	73,00	120301207	1748,61				
MF 76 x 4,0	76,0	50,0	260	60	39,0	72,00	120301208	1748,61				
MF 78 x 1,5	78,0	50,0	160	36	39,0	76,50	120301209	1414,50				
MF 78 x 2,0	78,0	50,0	160	40	39,0	76,00	120301210	1414,50				
MF 78 x 3,0	78,0	50,0	220	55	39,0	75,00	120301211	1748,61				
MF 78 x 4,0	78,0	50,0	260	65	39,0	74,00	120301212	1748,61				
MF 80 x 1,5	80,0	50,0	160	36	39,0	78,50	120301213	1536,93				
MF 80 x 2,0	80,0	50,0	160	40	39,0	78,00	120301214	1536,93				
MF 80 x 3,0	80,0	50,0	220	55	39,0	77,00	120301215	1915,72				
MF 80 x 4,0	80,0	50,0	260	65	39,0	76,00	120301216	1915,72				
MF 82 x 1,5	82,0	50,0	160	36	39,0	80,50	120301217	1536,93				
MF 82 x 2,0	82,0	50,0	160	40	39,0	80,00	120301218	1536,93				
MF 82 x 3,0	82,0	50,0	220	55	39,0	79,00	120301219	1915,72				
MF 82 x 4,0	82,0	50,0	260	65	39,0	78,00	120301220	1915,72				
MF 84 x 1,5	84,0	50,0	160	36	39,0	82,50	120301221	1793,12				
MF 84 x 2,0	84,0	50,0	160	40	39,0	82,00	120301222	1793,12				
MF 84 x 3,0	84,0	50,0	220	55	39,0	81,00	120301223	2165,03				
MF 84 x 4,0	84,0	50,0	260	65	39,0	80,00	120301224	2165,03				
MF 85 x 1,5	85,0	50,0	160	36	39,0	83,50	120301225	2338,95				
MF 85 x 2,0	85,0	50,0	160	40	39,0	83,00	120301226	2338,95				
MF 85 x 3,0	85,0	50,0	220	55	39,0	82,00	120301227	2895,69				
MF 85 x 4,0	85,0	50,0	260	65	39,0	81,00	120301228	2895,69				
MF 86 x 1,5	86,0	50,0	160	36	39,0	84,50	120301229	2338,95				
MF 86 x 2,0	86,0	50,0	160	40	39,0	84,00	120301230	2338,95				
MF 86 x 3,0	86,0	50,0	220	55	39,0	83,00	120301231	2851,10				

Hand Tap Sets

MF Metric fine thread ISO DIN 13

Efficient internal thread cutting.
The short structural type makes that tap usable by hand.

A Hand-Tap-Set includes 2 taps:
Taper Tap
Finish Tap



Hand Tap Sets for general use

through holes & blind holes up to 2 x D
Chip removal (like picture)
Form C straight flutes

material: HSSG
ISO2/6H
TOL
N/mm² HRC
to 900 N/mm² 27,1 HRC

2-3 threads
outside cooling and lubrication

Hand Tap Sets for general use Left Hand

through holes & blind holes up to 2 x D
Chip removal (like picture)
Form C straight flutes

material: HSSG
ISO2/6H
TOL
N/mm² HRC
to 900 N/mm² 27,1 HRC

2-3 threads
outside cooling and lubrication

Hand Tap Sets for higher demands HSSE

through holes & blind holes up to 2 x D
Chip removal (like picture)
Form C straight flutes

material: HSSE
ISO2/6H
TOL
N/mm² HRC
bis 1000 N/mm² 31 HRC

2-3 threads
outside cooling and lubrication



MF	D1	D2	L1	L2	□		No.	€	No.	€	No.	€
MF 86 x 4,0	86,0	50,0	260	65	39,0	82,00	120301232	2851,10				
MF 88 x 1,5	88,0	50,0	160	38	39,0	86,50	120301233	2561,72				
MF 88 x 2,0	88,0	50,0	160	40	39,0	86,00	120301234	2561,72				
MF 88 x 3,0	88,0	50,0	220	55	39,0	85,00	120301235	2940,18				
MF 88 x 4,0	88,0	50,0	260	65	39,0	84,00	120301236	2940,18				
MF 90 x 1,5	90,0	50,0	160	38	39,0	88,50	120301237	2672,97				
MF 90 x 2,0	90,0	50,0	160	40	39,0	88,00	120301238	2628,34				
MF 90 x 3,0	90,0	50,0	220	55	39,0	87,00	120301239	3140,74				
MF 90 x 4,0	90,0	50,0	260	65	39,0	86,00	120301240	3140,74				
MF 92 x 1,5	92,0	56,0	180	40	44,0	90,50	120301241	2673,00				
MF 92 x 2,0	92,0	56,0	180	45	44,0	90,00	120301242	2673,00				
MF 92 x 3,0	92,0	56,0	240	60	44,0	89,00	120301243	3385,77				
MF 92 x 4,0	92,0	56,0	280	70	44,0	88,00	120301244	3385,77				
MF 95 x 1,5	95,0	56,0	180	40	44,0	93,50	120301245	2873,52				
MF 95 x 2,0	95,0	56,0	180	45	44,0	93,00	120301246	2873,52				
MF 95 x 3,0	95,0	56,0	240	60	44,0	92,00	120301247	3786,64				
MF 95 x 4,0	95,0	56,0	280	70	44,0	91,00	120301248	3697,48				
MF 96 x 1,5	96,0	56,0	180	40	44,0	94,50	120301249	2895,86				
MF 96 x 2,0	96,0	56,0	180	45	44,0	94,00	120301250	2895,86				
MF 96 x 3,0	96,0	56,0	240	60	44,0	93,00	120301251	3786,64				
MF 96 x 4,0	96,0	56,0	280	70	44,0	92,00	120301252	3786,64				
MF 98 x 1,5	98,0	56,0	180	40	44,0	96,50	120301253	3118,45				
MF 98 x 2,0	98,0	56,0	180	45	44,0	96,00	120301254	3118,45				
MF 98 x 3,0	98,0	56,0	240	60	44,0	95,00	120301255	4120,83				
MF 98 x 4,0	98,0	56,0	280	70	44,0	94,00	120301256	4120,83				
MF 100 x 1,5	100,0	56,0	180	45	44,0	98,50	120301257	3564,15				
MF 100 x 2,0	100,0	56,0	180	50	44,0	98,00	120301258	3564,15				
MF 100 x 3,0	100,0	56,0	240	65	44,0	97,00	120301259	4343,82				
MF 100 x 4,0	100,0	56,0	280	75	44,0	96,00	120301260	4343,82				
MF 105 x 1,5	105,0	56,0	180	45	44,0	103,50	120301261	3853,64				
MF 105 x 2,0	105,0	56,0	180	50	44,0	103,00	120301262	3853,64				
MF 105 x 3,0	105,0	56,0	240	65	44,0	102,00	120301263	4677,55				
MF 105 x 4,0	105,0	56,0	280	75	44,0	101,00	120301264	4677,55				

Machine Taps - Form B for through holes

MF Metric fine thread
ISO DIN 13

Machine Tap for general use



through holes up to 4 x D
Chip removal (like picture)
Form B with spiral point



material: HSSE
ISO2/6H
to 900 N/mm²
27.1 HRC



4-5 threads
outside cooling and lubrication

Machine Tap for general use

Left-hand thread



through holes up to 4 x D
Chip removal (like picture)
Form B with spiral point

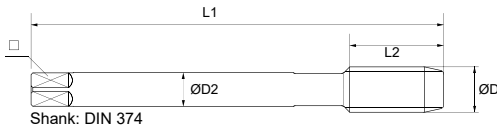


material: HSSE
ISO2/6H
to 900 N/mm²
27.1 HRC



4-5 threads
outside cooling and lubrication

Tap for machine use in through hole.
The spiral point pushes the chips ahead.

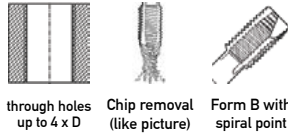


MF	D1	D2	L1	L2	□		No.	€	No.	€
MF 3 x 0,35	3,0	2,2	56	9	-	2,65	120401001	13,59	120402001	29,18
MF 4 x 0,35	4,0	2,8	63	10	2,1	3,65	120401002	13,59	120402002	29,18
MF 4 x 0,5	4,0	2,8	63	10	2,1	3,50	120401003	13,59	120402003	29,18
MF 5 x 0,5	5,0	3,5	70	12	2,7	4,50	120401004	13,59	120402004	29,18
MF 5 x 0,75	5,0	3,5	70	12	2,7	4,25	120401005	13,59	120402005	29,18
MF 6 x 0,5	6,0	4,5	80	14	3,4	5,50	120401006	13,59	120402006	29,18
MF 6 x 0,75	6,0	4,5	80	14	3,4	5,20	120401007	13,59	120402007	29,18
MF 7 x 0,75	7,0	5,5	80	14	4,3	6,20	120401008	13,59	120402008	29,18
MF 8 x 0,5	8,0	6,0	80	19	4,9	7,50	120401009	13,59	120402009	29,18
MF 8 x 0,75	8,0	6,0	80	19	4,9	7,20	120401010	13,59	120402010	29,18
MF 8 x 1,0	8,0	6,0	90	22	4,9	7,00	120401011	13,59	120402011	29,18
MF 9 x 0,75	9,0	7,0	80	19	5,5	8,25	120401012	13,59	120402012	29,18
MF 9 x 1,0	9,0	7,0	90	22	5,5	8,00	120401013	13,59	120402013	29,18
MF 10 x 0,75	10,0	7,0	90	20	5,5	9,20	120401014	15,71	120402014	32,52
MF 10 x 1,0	10,0	7,0	90	20	5,5	9,00	120401015	15,71	120402015	32,52
MF 10 x 1,25	10,0	7,0	100	24	5,5	8,80	120401016	15,71	120402016	32,52
MF 11 x 1,0	11,0	8,0	90	20	6,2	10,00	120401017	21,60	120402017	45,44
MF 11 x 1,25	11,0	8,0	90	22	6,2	10,80	120401018	21,60	120402018	45,44
MF 12 x 0,75	12,0	9,0	100	22	7,0	10,20	120401019	21,60	120402019	45,44
MF 12 x 1,0	12,0	9,0	100	22	7,0	11,00	120401020	21,60	120402020	45,44
MF 12 x 1,25	12,0	9,0	100	22	7,0	10,80	120401021	21,60	120402021	45,44
MF 12 x 1,5	12,0	9,0	100	22	7,0	10,50	120401022	21,60	120402022	45,44
MF 13 x 1,0	13,0	11,0	100	22	9,0	12,00	120401023	27,84	120402023	55,24
MF 13 x 1,5	13,0	11,0	100	22	9,0	11,50	120401024	27,84	120402024	55,24
MF 14 x 0,75	14,0	11,0	100	22	9,0	13,20	120401025	27,84	120402025	55,24
MF 14 x 1,0	14,0	11,0	100	22	9,0	13,00	120401026	27,84	120402026	55,24
MF 14 x 1,25	14,0	11,0	100	22	9,0	12,80	120401027	27,84	120402027	55,24
MF 14 x 1,5	14,0	11,0	100	22	9,0	12,50	120401028	27,84	120402028	55,24
MF 15 x 1,0	15,0	12,0	100	22	9,0	14,00	120401029	30,63	120402029	64,04
MF 15 x 1,5	15,0	12,0	100	22	9,0	13,50	120401030	30,63	120402030	64,04
MF 16 x 1,0	16,0	12,0	100	22	9,0	15,00	120401031	31,19	120402031	64,04
MF 16 x 1,25	16,0	12,0	100	22	9,0	14,80	120401032	31,19	120402032	64,04
MF 16 x 1,5	16,0	12,0	100	22	9,0	14,50	120401033	30,99	120402033	64,04
MF 18 x 1,0	18,0	14,0	110	25	11,0	17,00	120401034	37,86	120402034	76,85
MF 18 x 1,25	18,0	14,0	110	25	11,0	16,80	120401035	37,86	120402035	76,85

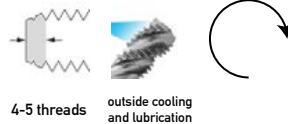
Machine Taps - Form B for through holes

MF Metric fine thread
ISO DIN 13

Machine Tap for general use

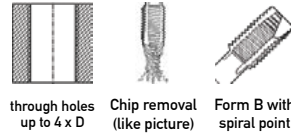


material: **HSSE**
ISO2/6H
TOL
N/mm² HRC
to 900 N/mm²
27.1 HRC

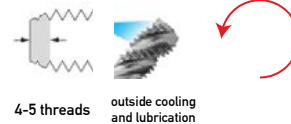


Machine Tap for general use

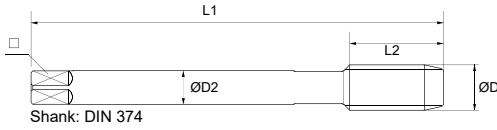
Left-hand thread



material: **HSSE**
ISO2/6H
TOL
N/mm² HRC
to 900 N/mm²
27.1 HRC



Tap for machine use in through hole.
The spiral point pushes the chips ahead.

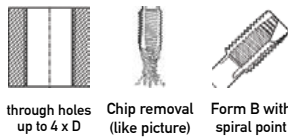


MF	D1	D2	L1	L2	□		No.	€	No.	€
MF 18 x 1,5	18,0	14,0	110	25	11,0	16,50	120401036	37,86	120402036	76,85
MF 18 x 2,0	18,0	14,0	125	34	11,0	16,00	120401037	37,86	120402037	76,85
MF 20 x 1,0	20,0	16,0	125	25	12,0	19,00	120401038	42,33	120402038	84,64
MF 20 x 1,25	20,0	16,0	125	25	12,0	18,80	120401039	42,33	120402039	84,64
MF 20 x 1,5	20,0	16,0	125	25	12,0	18,50	120401040	42,33	120402040	84,64
MF 20 x 2,0	20,0	16,0	140	34	12,0	18,00	120401041	42,33	120402041	84,64
MF 21 x 1,5	21,0	16,0	125	25	12,0	19,50	120401042	42,33	120402042	84,64
MF 22 x 1,0	22,0	18,0	125	25	14,5	21,00	120401043	51,23	120402043	105,80
MF 22 x 1,25	22,0	18,0	125	25	14,5	20,80	120401044	51,23	120402044	105,80
MF 22 x 1,5	22,0	18,0	125	25	14,5	20,50	120401045	51,23	120402045	105,80
MF 22 x 2,0	22,0	18,0	140	34	14,5	20,00	120401046	51,23	120402046	105,80
MF 23 x 1,5	23,0	18,0	125	25	14,5	21,50	120401047	60,15	120402047	122,52
MF 24 x 1,0	24,0	18,0	140	28	14,5	23,00	120401048	60,15	120402048	122,52
MF 24 x 1,25	24,0	18,0	140	28	14,5	23,80	120401049	60,15	120402049	122,52
MF 24 x 1,5	24,0	18,0	140	28	14,5	22,50	120401050	60,15	120402050	122,52
MF 24 x 2,0	24,0	18,0	140	28	14,5	22,00	120401051	60,15	120402051	122,52
MF 25 x 1,0	25,0	18,0	140	28	14,5	24,00	120401052	63,49	120402052	122,52
MF 25 x 1,5	25,0	18,0	140	28	14,5	23,50	120401053	63,49	120402053	122,52
MF 26 x 1,0	26,0	18,0	140	28	14,5	25,00	120401054	63,49	120402054	122,52
MF 26 x 1,5	26,0	18,0	140	28	14,5	24,50	120401055	63,49	120402055	122,52
MF 26 x 2,0	26,0	18,0	140	28	14,5	24,00	120401056	63,49	120402056	122,52
MF 27 x 1,0	27,0	20,0	140	28	16,0	26,00	120401057	75,74	120402057	154,80
MF 27 x 1,5	27,0	20,0	140	28	16,0	25,50	120401058	75,74	120402058	154,80
MF 27 x 2,0	27,0	20,0	140	28	16,0	25,00	120401059	75,74	120402059	154,80
MF 28 x 1,0	28,0	20,0	140	28	16,0	27,00	120401060	75,74	120402060	154,80
MF 28 x 1,5	28,0	20,0	140	28	16,0	26,50	120401061	75,74	120402061	154,80
MF 28 x 2,0	28,0	20,0	140	28	16,0	26,00	120401062	75,74	120402062	154,80
MF 29 x 1,5	29,0	22,0	150	28	18,0	27,50	120401063	85,75	120402063	176,53
MF 30 x 1,0	30,0	22,0	150	28	18,0	29,00	120401064	85,75	120402064	176,53
MF 30 x 1,5	30,0	22,0	150	28	18,0	28,50	120401065	85,75	120402065	176,53
MF 30 x 2,0	30,0	22,0	150	28	18,0	28,00	120401066	85,75	120402066	176,53
MF 30 x 2,5	30,0	22,0	180	45	18,0	27,50	120401067	85,75	120402067	176,53
MF 30 x 3,0	30,0	22,0	180	45	18,0	27,00	120401068	85,75	120402068	176,53
MF 32 x 1,5	32,0	22,0	150	28	18,0	30,50	120401069	104,69	120402069	218,31
MF 32 x 2,0	32,0	22,0	150	28	18,0	30,00	120401070	104,69	120402070	218,31

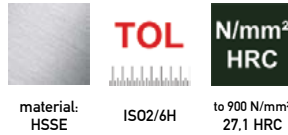
Machine Taps - Form B for through holes

MF Metric fine thread
ISO DIN 13

Machine Tap for general use



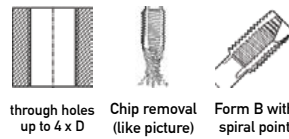
through holes up to 4 x D
Chip removal (like picture)
Form B with spiral point



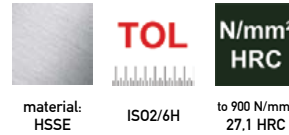
4-5 threads
outside cooling and lubrication

Machine Tap for general use

Left-hand thread

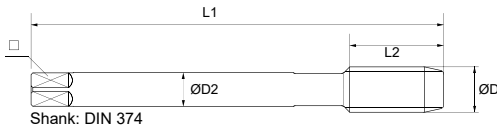


through holes up to 4 x D
Chip removal (like picture)
Form B with spiral point



4-5 threads
outside cooling and lubrication

Tap for machine use in through hole.
The spiral point pushes the chips ahead.



MF	D1	D2	L1	L2	□		No.	€	No.	€
MF 32 x 3,0	32,0	22,0	180	50	18,0		120401071	104,69	120402071	218,31
MF 33 x 1,5	33,0	25,0	160	30	20,0		120401072	104,69	120402072	218,31
MF 33 x 2,0	33,0	25,0	160	30	20,0		120401073	104,69	120402073	218,31
MF 33 x 3,0	33,0	25,0	180	50	20,0		120401074	104,69	120402074	218,31
MF 34 x 1,5	34,0	28,0	170	30	22,0		120401075	104,69	120402075	218,31
MF 34 x 2,0	34,0	28,0	170	30	22,0		120401076	104,69	120402076	218,31
MF 35 x 1,5	35,0	28,0	170	30	22,0		120401077	104,69	120402077	218,31
MF 36 x 1,5	36,0	28,0	170	30	22,0		120401078	131,43	120402078	273,99
MF 36 x 2,0	36,0	28,0	170	30	22,0		120401079	131,43	120402079	273,99
MF 36 x 3,0	36,0	28,0	200	56	22,0		120401080	131,43	120402080	273,99
MF 38 x 1,5	38,0	28,0	170	30	22,0		120401081	139,21	120402081	289,57
MF 39 x 1,5	39,0	32,0	170	30	24,0		120401082	139,21	120402082	289,57
MF 39 x 2,0	39,0	32,0	170	30	24,0		120401083	139,21	120402083	289,57
MF 39 x 3,0	39,0	32,0	200	60	24,0		120401084	139,21	120402084	289,57
MF 40 x 1,5	40,0	32,0	170	30	24,0		120401085	153,69	120402085	317,42
MF 40 x 2,0	40,0	32,0	170	30	24,0		120401086	153,69	120402086	317,42
MF 40 x 3,0	40,0	32,0	200	60	24,0		120401087	153,69	120402087	317,42
MF 42 x 1,5	42,0	32,0	170	30	24,0		120401088	173,75	120402088	354,18
MF 42 x 2,0	42,0	32,0	170	30	24,0		120401089	173,75	120402089	354,18
MF 42 x 3,0	42,0	32,0	200	60	24,0		120401090	173,75	120402090	354,18
MF 45 x 1,5	45,0	36,0	180	32	29,0		120401091	202,70	120402091	417,65
MF 45 x 2,0	45,0	36,0	180	32	29,0		120401092	202,70	120402092	417,65
MF 45 x 3,0	45,0	36,0	200	50	29,0		120401093	202,70	120402093	417,65
MF 48 x 1,5	48,0	36,0	190	32	29,0		120401094	242,79	120402094	503,44
MF 48 x 2,0	48,0	36,0	190	32	29,0		120401095	242,79	120402095	503,44
MF 48 x 3,0	48,0	36,0	225	50	29,0		120401096	242,79	120402096	503,44
MF 50 x 1,5	50,0	36,0	190	32	29,0		120401097	285,14	120402097	584,71
MF 50 x 2,0	50,0	36,0	190	32	29,0		120401098	285,14	120402098	584,71
MF 50 x 3,0	50,0	36,0	225	50	29,0		120401099	285,14	120402099	584,71
MF 52 x 1,5	52,0	40,0	190	32	32,0		120401100	309,90	120402100	645,96
MF 52 x 2,0	52,0	40,0	190	32	32,0		120401101	309,90	120402101	645,96
MF 52 x 3,0	52,0	40,0	225	50	32,0		120401102	309,90	120402102	645,96
MF 63 x 1,5	63,0	50,0	275	50	39,0		120401103	554,65		

Machine Taps - Form B for through holes

MF Metric fine thread
ISO DIN 13

Machine Tap
for high-alloyed steels



through holes up to 2.5 x D
Chip removal (like picture)
Form B with spiral point



material: HSSE TIN
ISO2/6H
to 1300 N/mm²
41 HRC



4-5 threads
outside cooling and lubrication

Machine Tap
for stainless steels



through holes up to 2.5 x D
Chip removal (like picture)
Form B with spiral point



material: HSSE TiAlN
ISO2/6H
to 1300 N/mm²
41 HRC



4-5 threads
outside cooling and lubrication

Machine Tap
for aluminum



through holes up to 3 x D
Chip removal (like picture)
Form B with spiral point

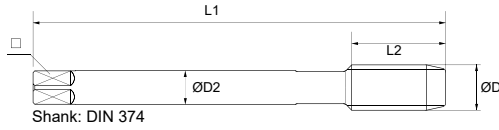


material: HSSE TIN
ISO2/6H
to 900 N/mm²
27.1 HRC



4-5 threads
outside cooling and lubrication

Tap for machine use in through hole.
The spiral point pushes the chips ahead.



MF	D1	D2	L1	L2	□		No.	€	No.	€	No.	€
MF 6 x 0,75	6,0	4,5	80	14	3,4	5,20	120404001	30,95	120405001	41,77	120407001	41,77
MF 8 x 1,0	8,0	6,0	90	22	4,9	7,00	120404002	36,36	120405002	44,85	120407002	44,85
MF 10 x 1,0	10,0	7,0	90	20	5,5	9,00	120404003	41,77	120405003	46,99	120407003	46,99
MF 10 x 1,25	10,0	7,0	100	24	5,5	8,80	120404004	44,08	120405004	52,52	120407004	52,52
MF 12 x 1,0	12,0	9,0	100	22	7,0	11,00	120404005	49,70	120405005	58,66	120407005	58,66
MF 12 x 1,25	12,0	9,0	100	22	7,0	10,80	120404006	51,62	120405006	63,58	120407006	63,58
MF 12 x 1,5	12,0	9,0	100	22	7,0	10,50	120404007	48,25	120405007	56,05	120407007	56,05
MF 14 x 1,25	14,0	11,0	100	22	9,0	12,80	120404008	61,09	120405008	72,94	120407008	72,94
MF 14 x 1,5	14,0	11,0	100	22	9,0	12,50	120404009	57,39	120405009	72,94	120407009	72,94
MF 16 x 1,5	16,0	12,0	100	22	9,0	14,50	120404010	72,67	120405010	81,08	120407010	81,08
MF 18 x 1,5	18,0	14,0	110	25	11,0	16,50	120404011	92,85	120405011	100,58	120407011	100,58
MF 20 x 1,5	20,0	16,0	125	25	12,0	18,50	120404012	104,96	120405012	109,96	120407012	109,96

Machine Taps - Form B for through holes

MF Metric fine thread
ISO DIN 13

Machine Tap
for special alloys
(Inconel, Hastelloy etc.)

Machine Tap
with longer tool life time

Machine Tap
for general use
oversized (diameter)



through holes
up to 2.5 x D



Chip removal
(like picture)



Form B with
spiral point



through holes
up to 2.5 x D



Chip removal
(like picture)



Form B with
spiral point



through holes
up to 3 x D



Chip removal
(like picture)



Form B with
spiral point



material:
HSSE-PM TiAlN



TOL
ISO2/6H



N/mm²
HRC
to 1200 N/mm²
38 HRC



4-5 threads



outside cooling
and lubrication



material:
HSSE TiN



TOL
ISO2/6H



N/mm²
HRC
to 900 N/mm²
27.1 HRC



4-5 threads



outside cooling
and lubrication



material:
HSSE



TOL
ISO3/6G



N/mm²
HRC
to 900 N/mm²
27.1 HRC

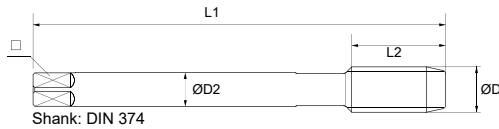


4-5 threads



outside cooling
and lubrication

Tap for machine use in through hole.
The spiral point pushes the chips ahead.



MF

D1 D2 L1 L2 □

No.

€

No.

€

No.

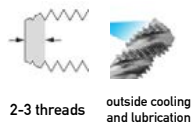
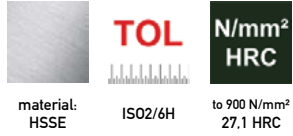
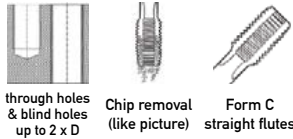
€

MF	D1	D2	L1	L2	□		No.	€	No.	€	No.	€
MF 6 x 0,75	6,0	4,5	80	14	3,4	5,20			120425001	30,84	Tol. 6G: threads with large clearance	
MF 8 x 1,0	8,0	6,0	90	22	4,9	7,00	120412001	65,81	120425002	36,18	120417001	39,76
MF 10 x 1,0	10,0	7,0	90	20	5,5	9,00	120412002	70,10	120425003	42,30	120417002	40,10
MF 10 x 1,25	10,0	7,0	100	24	5,5	8,80	120412003	70,10	120425004	54,00	120417003	41,65
MF 12 x 1,0	12,0	9,0	100	22	7,0	11,00	120412004	110,89	120425005	57,31	120417004	50,39
MF 12 x 1,25	12,0	9,0	100	22	7,0	10,80	120412005	101,80	120425006	54,00		
MF 12 x 1,5	12,0	9,0	100	22	7,0	10,50	120412006	101,80	120425007	65,95	120417005	44,90
MF 14 x 1,25	14,0	11,0	100	22	9,0	12,80			120425008	70,52		
MF 14 x 1,5	14,0	11,0	100	22	9,0	12,50	120412007	137,97	120425009	73,87	120417006	62,73
MF 16 x 1,5	16,0	12,0	100	22	9,0	14,50	120412008	151,33	120425010	81,91		
MF 18 x 1,5	18,0	14,0	110	25	11,0	16,50	120412009	201,72	120425011	96,61		
MF 20 x 1,5	20,0	16,0	125	25	12,0	18,50	120412010	265,31	120425012	109,96		

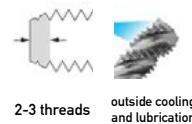
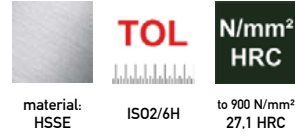
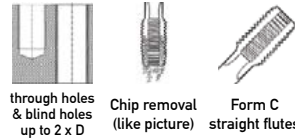
Machine Taps - Form C (straight flutes) for through holes and blind holes

MF Metric fine thread
ISO DIN 13

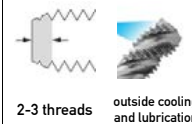
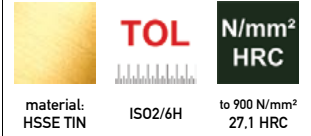
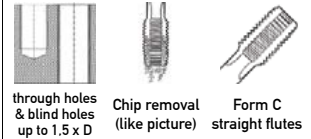
Machine Tap
for general use



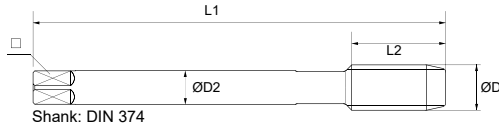
Machine Tap
for general use
Left-hand thread



Machine Tap
with longer tool life time



Tap for machine use in through hole and blind hole. The short lead-in chamfer makes that tap universal in application. The flutes can hold the most part of the chips.

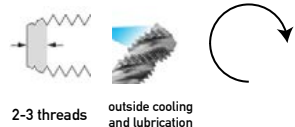
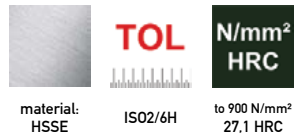
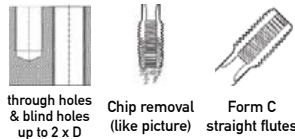


MF	D1	D2	L1	L2	□	✂	No.	€	No.	€	No.	€
MF 4 x 0,35	4,0	2,8	63	10	2,1	3,65	120501001	12,14				
MF 5 x 0,5	5,0	3,5	70	12	2,7	4,50	120501002	12,14				
MF 6 x 0,5	6,0	4,5	80	14	3,4	5,50				120504001	44,98	
MF 6 x 0,75	6,0	4,5	80	14	3,4	5,20	120501003	12,14	120502001	47,65	120504002	27,05
MF 7 x 0,75	7,0	5,5	80	14	4,3	6,20					120504003	50,84
MF 8 x 0,75	8,0	6,0	80	19	4,9	7,20	120501004	12,14				
MF 8 x 1,0	8,0	6,0	90	22	4,9	7,00	120501005	12,14	120502002	47,65	120504004	47,25
MF 10 x 0,5	10,0	7,0	90	20	5,5	9,50					120504005	77,68
MF 10 x 1,0	10,0	7,0	90	20	5,5	9,00	120501006	14,59	120502003	48,33	120504006	39,24
MF 10 x 1,25	10,0	7,0	100	24	5,5	8,80	120501007	14,59	120502004	63,24	120504007	59,72
MF 12 x 0,75	12,0	9,0	100	22	7,0	10,20					120504008	81,27
MF 12 x 1,0	12,0	9,0	100	22	7,0	11,00	120501008	18,93			120504009	44,74
MF 12 x 1,25	12,0	9,0	100	22	7,0	10,80	120501009	19,49	120502005	64,96	120504010	47,60
MF 12 x 1,5	12,0	9,0	100	22	7,0	10,50	120501010	18,93	120502006	57,24	120504011	44,74
MF 14 x 1,0	14,0	11,0	100	22	9,0	13,00	120501011	23,50			120504012	79,00
MF 14 x 1,25	14,0	11,0	100	22	9,0	12,80	120501012	23,50			120504013	75,03
MF 14 x 1,5	14,0	11,0	100	22	9,0	12,50	120501013	23,50	120502007	76,10	120504014	59,07
MF 16 x 1,0	16,0	12,0	100	22	9,0	15,00	120501014	27,84			120504015	68,26
MF 16 x 1,25	16,0	12,0	100	22	9,0	14,80					120504016	114,91
MF 16 x 1,5	16,0	12,0	100	22	9,0	14,50	120501015	27,84	120502008	76,10	120504017	62,01
MF 18 x 1,0	18,0	14,0	110	25	11,0	17,00	120501016	33,08				
MF 18 x 1,5	18,0	14,0	110	25	11,0	16,50	120501017	33,08	120502009	83,29	120504018	75,57
MF 18 x 2,0	18,0	14,0	125	34	11,0	16,00	120501018	33,08				
MF 20 x 1,0	20,0	16,0	125	25	12,0	19,00	120501019	35,97				
MF 20 x 1,25	20,0	16,0	125	25	12,0	18,80	120501020	35,97				
MF 20 x 1,5	20,0	16,0	125	25	12,0	18,50	120501021	35,97	120502010	121,51	120504019	89,17
MF 20 x 2,0	20,0	16,0	140	34	12,0	18,00	120501022	35,97				
MF 22 x 1,0	22,0	18,0	125	25	14,5	21,00	120501023	45,67				
MF 22 x 1,5	22,0	18,0	125	25	14,5	20,50	120501024	45,67			120504020	110,99
MF 22 x 2,0	22,0	18,0	140	34	14,5	20,00	120501025	45,67				

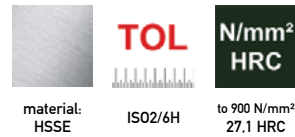
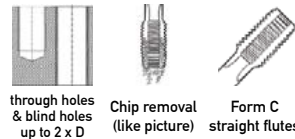
Machine Taps - Form C (straight flutes) for through holes and blind holes

MF Metric fine thread
ISO DIN 13

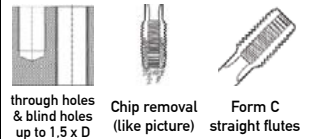
Machine Tap for general use



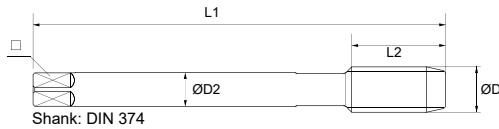
Machine Tap for general use Left-hand thread



Machine Tap with longer tool life time



Tap for machine use in through hole and blind hole. The short lead-in chamfer makes that tap universal in application. The flutes can hold the most part of the chips.

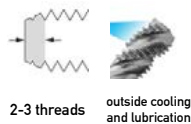
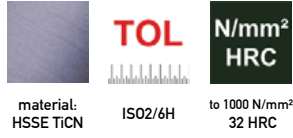
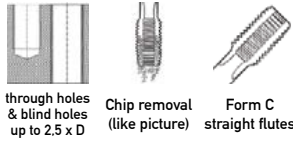


MF	D1	D2	L1	L2	□	✂	No.	€	No.	€	No.	€
MF 24 x 1,0	24,0	18,0	140	28	14,5	23,00	120501026	53,47				
MF 24 x 1,5	24,0	18,0	140	28	14,5	22,50	120501027	53,47				
MF 24 x 2,0	24,0	18,0	140	28	14,5	22,00	120501028	53,47				
MF 25 x 1,0	25,0	18,0	140	28	14,5	24,00	120501029	53,47				
MF 26 x 1,5	26,0	18,0	140	28	14,5	24,50	120501030	53,47				
MF 27 x 1,5	27,0	20,0	140	28	16,0	25,50	120501031	66,82				
MF 27 x 2,0	27,0	20,0	140	28	16,0	25,00	120501032	66,82				
MF 28 x 1,5	28,0	20,0	140	28	16,0	26,50	120501033	66,82				
MF 30 x 1,5	30,0	22,0	150	28	18,0	28,50	120501034	76,84				
MF 30 x 2,0	30,0	22,0	150	28	18,0	28,00	120501035	76,84				
MF 32 x 1,5	32,0	22,0	150	28	18,0	30,50	120501036	98,01				
MF 32 x 2,0	32,0	22,0	150	28	18,0	30,00	120501037	98,01				
MF 33 x 2,0	33,0	25,0	160	30	20,0	31,00	120501038	98,01				
MF 35 x 1,5	35,0	28,0	170	30	22,0	33,50	120501039	98,01				
MF 36 x 1,5	36,0	28,0	170	30	22,0	34,50	120501040	122,51				
MF 36 x 2,0	36,0	28,0	170	30	22,0	34,00	120501041	122,51				
MF 38 x 1,5	38,0	28,0	170	30	22,0	36,50	120501042	131,43				
MF 40 x 1,5	40,0	32,0	170	30	24,0	38,50	120501043	142,57				
MF 42 x 1,5	42,0	32,0	170	30	24,0	40,50	120501044	158,15				
MF 45 x 1,5	45,0	36,0	180	32	29,0	43,50	120501045	184,88				
MF 48 x 1,5	48,0	36,0	190	32	29,0	46,50	120501046	224,98				
MF 50 x 1,5	50,0	36,0	190	32	29,0	48,50	120501047	259,51				
MF 52 x 1,5	52,0	40,0	190	32	32,0	50,50	120501048	285,12				

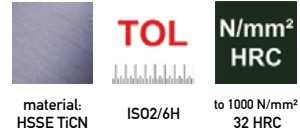
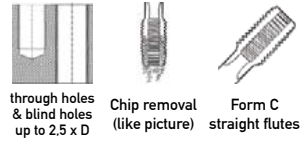
Machine Taps - Form C (straight flutes) for through holes and blind holes

MF Metric fine thread
ISO DIN 13

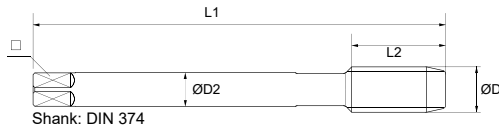
Machine Tap
for cast materials



Machine Tap
for brass (short-chipping)



Tap for machine use in through hole and blind hole. The short lead-in chamfer makes that tap universal in application. The flutes can hold the most part of the chips.



MF	D1	D2	L1	L2	□		No.	€	No.	€
MF 4 x 0,5	4,0	2,8	63	10	2,1	3,50	120510001	47,25	120509001	44,30
MF 5 x 0,5	5,0	3,5	70	12	2,7	4,50	120510002	47,25	120509002	44,30
MF 6 x 0,75	6,0	4,5	80	14	3,4	5,20	120510003	47,82	120509003	44,82
MF 8 x 1,0	8,0	6,0	90	22	4,9	7,00	120510004	50,84	120509004	47,66
MF 10 x 1,0	10,0	7,0	90	20	5,5	9,00	120510005	41,09	120509005	50,33
MF 10 x 1,25	10,0	7,0	100	24	5,5	8,80	120510006	53,68	120509006	50,33
MF 12 x 1,25	12,0	9,0	100	22	7,0	10,80	120510007	55,37	120509007	60,95
MF 12 x 1,5	12,0	9,0	100	22	7,0	10,50	120510008	52,26	120509008	60,95
MF 14 x 1,25	14,0	11,0	100	22	9,0	12,80	120510009	90,72	120509009	85,05
MF 14 x 1,5	14,0	11,0	100	22	9,0	12,50	120510010	61,93	120509010	78,32
MF 16 x 1,5	16,0	12,0	100	22	9,0	14,50	120510011	65,01	120509011	86,47
MF 18 x 1,5	18,0	14,0	110	25	11,0	16,50	120510012	79,15	120509012	103,30
MF 20 x 1,5	20,0	16,0	125	25	12,0	18,50	120510013	93,44	120509013	115,00

Machine Taps - Form C (with spiral flutes) for blind holes

MF Metric fine thread
ISO DIN 13

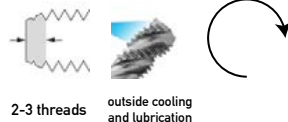
Machine Tap for general use



blind holes up to 3 x D
Chip removal (like picture)
Form C 35° spiral flute



material: HSSE
ISO2/6H
to 900 N/mm²
27,1 HRC



2-3 threads
outside cooling and lubrication

Machine Tap for general use

Left-hand thread



blind holes up to 3 x D
Chip removal (like picture)
Form C 35° left spir. flute

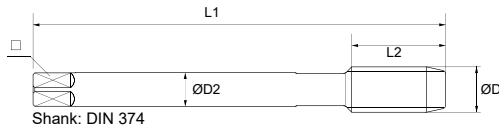


material: HSSE
ISO2/6H
to 900 N/mm²
27,1 HRC



2-3 threads
outside cooling and lubrication

Tap for machine use in blind holes. The fast spiral flutes provide good chip removal from the blind hole.



MF	D1	D2	L1	L2	□		No.	€	No.	€
MF 3 x 0,35	3,0	2,2	56	5	-	2,65	120601001	15,37	120602001	32,52
MF 4 x 0,35	4,0	2,8	63	5	2,1	3,65	120601002	15,37	120602002	32,52
MF 4 x 0,5	4,0	2,8	63	5	2,1	3,50	120601003	15,37	120602003	32,52
MF 5 x 0,5	5,0	3,5	70	5	2,7	4,50	120601004	15,37	120602004	32,52
MF 5 x 0,75	5,0	3,5	70	8	2,7	4,25	120601005	15,37	120602005	32,52
MF 6 x 0,5	6,0	4,5	80	5	3,4	5,50	120601006	15,37	120602006	32,52
MF 6 x 0,75	6,0	4,5	80	8	3,4	5,20	120601007	15,37	120602007	32,52
MF 7 x 0,75	7,0	5,5	80	8	4,3	6,20	120601008	15,37	120602008	32,52
MF 8 x 0,5	8,0	6,0	80	8	4,9	7,50	120601009	15,37	120602009	32,52
MF 8 x 0,75	8,0	6,0	80	8	4,9	7,20	120601010	15,37	120602010	32,52
MF 8 x 1,0	8,0	6,0	90	10	4,9	7,00	120601011	15,37	120602011	32,52
MF 9 x 0,75	9,0	7,0	80	10	5,5	8,25	120601012	15,37	120602012	32,52
MF 9 x 1,0	9,0	7,0	90	10	5,5	8,00	120601013	15,37	120602013	32,52
MF 10 x 0,75	10,0	7,0	90	10	5,5	9,20	120601014	18,15	120602014	39,32
MF 10 x 1,0	10,0	7,0	90	10	5,5	9,00	120601015	18,15	120602015	39,32
MF 10 x 1,25	10,0	7,0	100	16	5,5	8,80	120601016	18,15	120602016	39,32
MF 11 x 1,0	11,0	8,0	90	11	6,2	10,00	120601017	23,39	120602017	50,34
MF 11 x 1,25	11,0	8,0	90	14	6,2	10,80	120601018	23,39	120602018	50,34
MF 12 x 0,75	12,0	9,0	100	10	7,0	10,20	120601019	23,39	120602019	50,34
MF 12 x 1,0	12,0	9,0	100	11	7,0	11,00	120601020	23,39	120602020	50,34
MF 12 x 1,25	12,0	9,0	100	15	7,0	10,80	120601021	23,39	120602021	50,34
MF 12 x 1,5	12,0	9,0	100	15	7,0	10,50	120601022	23,39	120602022	50,34
MF 13 x 1,0	13,0	11,0	100	11	9,0	12,00	120601023	28,62	120602023	61,48
MF 13 x 1,5	13,0	11,0	100	15	9,0	11,50	120601024	28,62	120602024	61,48
MF 14 x 0,75	14,0	11,0	100	10	9,0	13,20	120601025	28,62	120602025	61,48
MF 14 x 1,0	14,0	11,0	100	11	9,0	13,00	120601026	28,62	120602026	61,48
MF 14 x 1,25	14,0	11,0	100	15	9,0	12,80	120601027	28,62	120602027	61,48
MF 14 x 1,5	14,0	11,0	100	15	9,0	12,50	120601028	28,62	120602028	61,48
MF 15 x 1,0	15,0	12,0	100	12	9,0	14,00	120601029	33,19	120602029	70,50
MF 15 x 1,5	15,0	12,0	100	15	9,0	13,50	120601030	33,19	120602030	70,50
MF 16 x 1,0	16,0	12,0	100	12	9,0	15,00	120601031	33,19	120602031	70,50
MF 16 x 1,25	16,0	12,0	100	15	9,0	14,80	120601032	33,19	120602032	70,50
MF 16 x 1,5	16,0	12,0	100	15	9,0	14,50	120601033	33,19	120602033	70,50
MF 18 x 1,0	18,0	14,0	110	13	11,0	17,00	120601034	42,21	120602034	87,43
MF 18 x 1,25	18,0	14,0	110	15	11,0	16,80	120601035	42,21	120602035	87,43

Machine Taps - Form C (with spiral flutes) for blind holes

MF Metric fine thread
ISO DIN 13

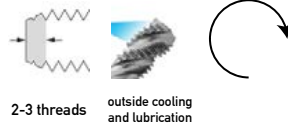
Machine Tap
for general use



blind holes up to 3 x D
Chip removal (like picture)
Form C 35° spiral flute



material: HSSE
ISO2/6H
to 900 N/mm²
27,1 HRC



2-3 threads
outside cooling and lubrication

Machine Tap
for general use

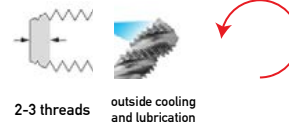
Left-hand thread



blind holes up to 3 x D
Chip removal (like picture)
Form C 35° left spir. flute

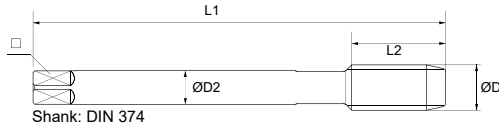


material: HSSE
ISO2/6H
to 900 N/mm²
27,1 HRC



2-3 threads
outside cooling and lubrication

Tap for machine use in blind holes.
The fast spiral flutes provide good chip removal from the blind hole.



MF	D1	D2	L1	L2	□		No.	€	No.	€
MF 18 x 1,5	18,0	14,0	110	17	11,0	16,50	120601036	42,21	120602036	87,43
MF 18 x 2,0	18,0	14,0	125	20	11,0	16,00	120601037	42,21	120602037	87,43
MF 20 x 1,0	20,0	16,0	125	14	12,0	19,00	120601038	46,78	120602038	97,56
MF 20 x 1,25	20,0	16,0	125	17	12,0	18,80	120601039	46,78	120602039	97,56
MF 20 x 1,5	20,0	16,0	125	17	12,0	18,50	120601040	46,78	120602040	97,56
MF 20 x 2,0	20,0	16,0	140	20	12,0	18,00	120601041	46,78	120602041	97,56
MF 21 x 1,5	21,0	16,0	125	17	12,0	19,50	120601042	46,78	120602042	97,56
MF 22 x 1,0	22,0	18,0	125	14	14,5	21,00	120601043	56,80	120602043	116,94
MF 22 x 1,25	22,0	18,0	125	17	14,5	20,80	120601044	56,80	120602044	116,94
MF 22 x 1,5	22,0	18,0	125	17	14,5	20,50	120601045	56,80	120602045	116,94
MF 22 x 2,0	22,0	18,0	140	20	14,5	20,00	120601046	56,80	120602046	116,94
MF 23 x 1,5	23,0	18,0	125	17	14,5	21,50	120601047	67,94	120602047	140,33
MF 24 x 1,0	24,0	18,0	140	15	14,5	23,00	120601048	67,94	120602048	140,33
MF 24 x 1,25	24,0	18,0	140	17	14,5	23,80	120601049	67,94	120602049	140,33
MF 24 x 1,5	24,0	18,0	140	20	14,5	22,50	120601050	67,94	120602050	140,33
MF 24 x 2,0	24,0	18,0	140	20	14,5	22,00	120601051	67,94	120602051	140,33
MF 25 x 1,0	25,0	18,0	140	15	14,5	24,00	120601052	71,29	120602052	140,33
MF 25 x 1,5	25,0	18,0	140	20	14,5	23,50	120601053	71,29	120602053	140,33
MF 26 x 1,0	26,0	18,0	140	15	14,5	25,00	120601054	71,29	120602054	140,33
MF 26 x 1,5	26,0	18,0	140	20	14,5	24,50	120601055	71,29	120602055	140,33
MF 26 x 2,0	26,0	18,0	140	20	14,5	24,00	120601056	71,29	120602056	140,33
MF 27 x 1,0	27,0	20,0	140	15	16,0	26,00	120601057	82,42	120602057	170,41
MF 27 x 1,5	27,0	20,0	140	20	16,0	25,50	120601058	81,31	120602058	170,41
MF 27 x 2,0	27,0	20,0	140	20	16,0	25,00	120601059	81,31	120602059	170,41
MF 28 x 1,0	28,0	20,0	140	15	16,0	27,00	120601060	81,31	120602060	170,41
MF 28 x 1,5	28,0	20,0	140	20	16,0	26,50	120601061	81,31	120602061	170,41
MF 28 x 2,0	28,0	20,0	140	20	16,0	26,00	120601062	81,31	120602062	170,41
MF 29 x 1,5	29,0	22,0	150	22	18,0	27,50	120601063	93,55	120602063	193,78
MF 30 x 1,0	30,0	22,0	150	17	18,0	29,00	120601064	93,55	120602064	193,78
MF 30 x 1,5	30,0	22,0	150	22	18,0	28,50	120601065	93,55	120602065	193,78
MF 30 x 2,0	30,0	22,0	150	22	18,0	28,00	120601066	93,55	120602066	193,78
MF 30 x 2,5	30,0	22,0	180	27	18,0	27,50	120601067	93,55	120602067	193,78
MF 30 x 3,0	30,0	22,0	180	30	18,0	27,00	120601068	93,55	120602068	193,78
MF 32 x 1,5	32,0	22,0	150	22	18,0	30,50	120601069	115,83	120602069	241,69
MF 32 x 2,0	32,0	22,0	150	22	18,0	30,00	120601070	115,83	120602070	241,69

Machine Taps - Form C (with spiral flutes) for blind holes

MF Metric fine thread
ISO DIN 13

Machine Tap for general use



blind holes up to 3 x D
Chip removal (like picture)
Form C 35° spiral flute



material: HSSE
ISO2/6H
to 900 N/mm²
27,1 HRC



2-3 threads
outside cooling and lubrication

Machine Tap for general use

Left-hand thread



blind holes up to 3 x D
Chip removal (like picture)
Form C 35° left spir. flute

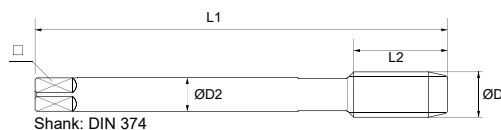


material: HSSE
ISO2/6H
to 900 N/mm²
27,1 HRC



2-3 threads
outside cooling and lubrication

Tap for machine use in blind holes. The fast spiral flutes provide good chip removal from the blind hole.



MF	D1	D2	L1	L2	□		No.	€	No.	€
MF 32 x 3,0	32,0	22,0	180	30	18,0		120601071	115,83	120602071	241,69
MF 33 x 1,5	33,0	25,0	160	24	20,0		120601072	115,83	120602072	241,69
MF 33 x 2,0	33,0	25,0	160	24	20,0		120601073	115,83	120602073	241,69
MF 33 x 3,0	33,0	25,0	180	30	20,0		120601074	115,83	120602074	241,69
MF 34 x 1,5	34,0	28,0	170	24	22,0		120601075	115,83	120602075	241,69
MF 34 x 2,0	34,0	28,0	170	24	22,0		120601076	115,83	120602076	241,69
MF 35 x 1,5	35,0	28,0	170	24	22,0		120601077	115,83	120602077	241,69
MF 36 x 1,5	36,0	28,0	170	24	22,0		120601078	147,02	120602078	306,28
MF 36 x 2,0	36,0	28,0	170	24	22,0		120601079	147,02	120602079	306,28
MF 36 x 3,0	36,0	28,0	200	30	22,0		120601080	147,02	120602080	306,28
MF 38 x 1,5	38,0	28,0	170	24	22,0		120601081	154,82	120602081	319,66
MF 39 x 1,5	39,0	32,0	170	25	24,0		120601082	154,82	120602082	319,66
MF 39 x 2,0	39,0	32,0	170	25	24,0		120601083	154,82	120602083	319,66
MF 39 x 3,0	39,0	32,0	200	30	24,0		120601084	154,82	120602084	319,66
MF 40 x 1,5	40,0	32,0	170	25	24,0		120601085	171,53	120602085	347,49
MF 40 x 2,0	40,0	32,0	170	25	24,0		120601086	171,53	120602086	347,49
MF 40 x 3,0	40,0	32,0	200	30	24,0		120601087	171,53	120602087	347,49
MF 42 x 1,5	42,0	32,0	170	25	24,0		120601088	191,56	120602088	393,16
MF 42 x 2,0	42,0	32,0	170	25	24,0		120601089	191,56	120602089	393,16
MF 42 x 3,0	42,0	32,0	200	30	24,0		120601090	191,56	120602090	393,16
MF 45 x 1,5	45,0	36,0	180	27	29,0		120601091	223,87	120602091	462,21
MF 45 x 2,0	45,0	36,0	180	27	29,0		120601092	223,87	120602092	462,21
MF 45 x 3,0	45,0	36,0	200	30	29,0		120601093	223,87	120602093	462,21
MF 48 x 1,5	48,0	36,0	190	27	29,0		120601094	267,29	120602094	551,31
MF 48 x 2,0	48,0	36,0	190	27	29,0		120601095	267,29	120602095	551,31
MF 48 x 3,0	48,0	36,0	225	33	29,0		120601096	267,29	120602096	551,31
MF 50 x 1,5	50,0	36,0	190	27	29,0		120601097	311,86	120602097	641,53
MF 50 x 2,0	50,0	36,0	190	27	29,0		120601098	311,86	120602098	641,53
MF 50 x 3,0	50,0	36,0	225	33	29,0		120601099	311,86	120602099	641,53
MF 52 x 1,5	52,0	40,0	190	27	32,0		120601100	345,26	120602100	702,77
MF 52 x 2,0	52,0	40,0	190	27	32,0		120601101	345,26	120602101	702,77
MF 52 x 3,0	52,0	40,0	225	33	32,0		120601102	345,26	120602102	702,77
MF 63 x 1,5	63,0	50,0	275	40	39,0		120601103	590,29		

Machine Taps - Form C (with spiral flutes) for blind holes

MF Metric fine thread
ISO DIN 13

Machine Tap
und for high-alloyed steels



blind holes up to 2.5 x D
Chip removal (like picture)
Form C 40° spiral flute



material: HSSE TIN
ISO2/6H
to 1300 N/mm²
41 HRC



Machine Tap
PRO for stainless steels
with high tool life time



blind holes up to 2.5 x D
Chip removal (like picture)
Form C 35° spiral flute



material: HSSE TiAlN
ISO2/6H
to 1300 N/mm²
41 HRC



Machine Tap
for special alloys
(Inconel, Hastelloy etc.)



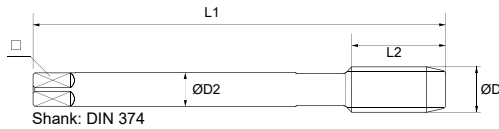
blind holes up to 2.5 x D
Chip removal (like picture)
Form C 45° spiral flute



material: HSSE-PM TiAlN
ISO2/6H
to 1200 N/mm²
38 HRC



Tap for machine use in blind holes.
The fast spiral flutes provide good chip removal from the blind hole.



MF	D1	D2	L1	L2	□		No.	€	No.	€	No.	€
MF 6 x 0,75	6,0	4,5	80	8	3,4	5,20	120604001	46,59	120605001	46,59		
MF 8 x 1,0	8,0	6,0	90	10	4,9	7,00	120604002	50,01	120605002	50,01	120612001	81,58
MF 10 x 1,0	10,0	7,0	90	10	5,5	9,00	120604003	52,42	120605003	52,42	120612002	89,64
MF 10 x 1,25	10,0	7,0	100	16	5,5	8,80	120604004	58,58	120605004	58,58	120612003	94,26
MF 12 x 1,0	12,0	9,0	100	11	7,0	11,00	120604005	65,43	120605005	65,43	120612004	126,48
MF 12 x 1,25	12,0	9,0	100	15	7,0	10,80	120604006	70,91	120605006	70,91	120612005	109,52
MF 12 x 1,5	12,0	9,0	100	15	7,0	10,50	120604007	62,52	120605007	62,52	120612006	106,95
MF 14 x 1,5	14,0	11,0	100	15	9,0	12,50	120604008	81,35	120605008	81,35	120612007	135,57
MF 16 x 1,5	16,0	12,0	100	15	9,0	14,50	120604009	81,35	120605009	81,35	120612008	162,13
MF 18 x 1,5	18,0	14,0	110	17	11,0	16,50	120604010	90,44	120605010	90,44	120612009	180,30
MF 20 x 1,5	20,0	16,0	125	17	12,0	18,50	120604011	112,19	120605011	112,19	120612010	208,06
MF 22 x 1,5	22,0	18,0	125	17	14,5	20,50	120604012	122,64	120605012	122,64		

Machine Taps - Form C (with spiral flutes) for blind holes

MF Metric fine thread
ISO DIN 13

Machine Tap
for general use
oversized (diameter)



blind holes up to 3 x D Chip removal (like picture) Form C 40° spiral flute

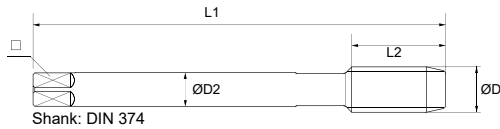


material: HSSE ISO3/6G to 900 N/mm² 27,1 HRC



2-3 threads outside cooling and lubrication

Tap for machine use in blind holes. The fast spiral flutes provide good chip removal from the blind hole.



MF

D1 D2 L1 L2 □

No. €

Tol. 6G:
threads with large clearance

MF	D1	D2	L1	L2	□		No.	€
MF 6 x 0,75	6,0	4,5	80	8	3,4	5,20	120617001	42,50
MF 8 x 1,0	8,0	6,0	90	10	4,9	7,00	120617002	42,50
MF 10 x 1,0	10,0	7,0	90	10	5,5	9,00	120617003	44,39
MF 10 x 1,25	10,0	7,0	100	16	5,5	8,80	120617004	62,04
MF 12 x 1,5	12,0	9,0	100	15	7,0	10,50	120617005	50,39
MF 14 x 1,5	14,0	11,0	100	15	9,0	12,50	120617006	69,07

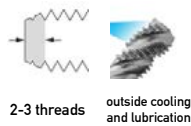
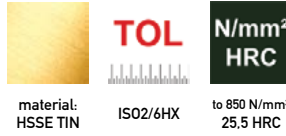
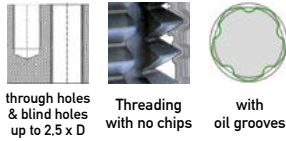
UNiForm Machine Forming Taps

MF Metric fine thread
ISO DIN 13

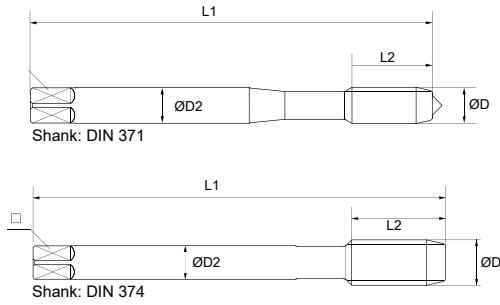
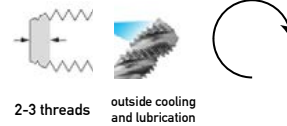
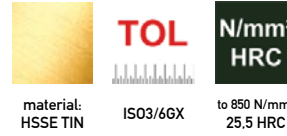
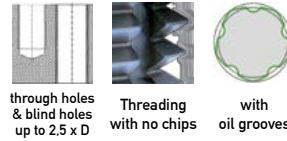
Machine Forming Taps have following advantages:

- No chips
- Up to 20 times longer lifetime (compared to taps)
- Same forming tap for through and blind hole
- Wide range of materials can be processed
- Intersection of the thread is impossible
- Very high trueness
- Increased strength of the thread
- Higher surface quality
- Much higher cutting speed

Machine Forming Taps for universal use



Machine Forming Taps for universal use oversized (diameter)



MF D1 D2 L1 L2 □

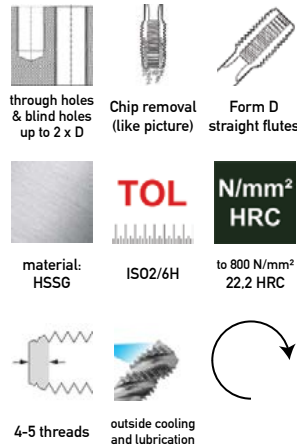
No. € No. €

MF	D1	D2	L1	L2	□		Tol. 6HX: standard tolerance		Tol. 6GX: threads with large clearance	
							No.	€	No.	€
MF 3 x 0,35	3,0	3,5	56	10	2,7	2,85	121101001	85,52	121117001	104,45
MF 4 x 0,5	4,0	4,5	63	12	3,4	3,80	121101002	53,93	121117002	96,06
MF 5 x 0,5	5,0	6,0	70	14	4,9	4,80	121101003	54,62	121117003	96,06
MF 6 x 0,75	6,0	6,0	80	16	4,9	5,65	121101004	53,93	121117004	94,64
MF 8 x 1,0	8,0	8,0	90	18	6,2	7,55	121101005	62,16	121117005	102,61
MF 10 x 1,0	10,0	10,0	90	18	8,0	9,55	121101006	71,98	121117006	108,95
MF 10 x 1,25	10,0	10,0	100	20	8,0	9,45	121101007	75,64	121117007	108,95
MF 12 x 1,0	12,0	9,0	100	22	7,0	11,55	121101008	85,01	121117008	134,90
MF 12 x 1,25	12,0	9,0	100	22	7,0	11,45	121101009	88,66	121117009	134,90
MF 12 x 1,5	12,0	9,0	100	22	7,0	11,30	121101010	82,49	121117010	134,90
MF 14 x 1,25	14,0	11,0	100	22	9,0	13,45	121101011	105,35	121117011	176,81
MF 14 x 1,5	14,0	11,0	100	22	9,0	13,30	121101012	98,72	121117012	176,81
MF 16 x 1,5	16,0	12,0	100	22	9,0	15,30	121101013	125,00	121117013	215,44
MF 18 x 1,5	18,0	14,0	110	22	11,0	17,30	121101014	160,42	121117014	255,51
MF 20 x 1,5	20,0	16,0	125	25	12,0	19,30	121101015	180,53	121117015	348,72

1/4" Bit-Short Machine Taps

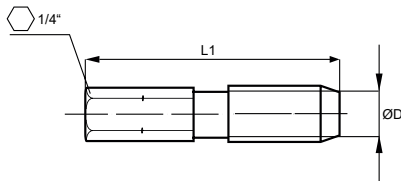
MF Metric fine thread
ISO DIN 13

Bit-Taps
Form D for through holes
and blind holes



Efficient internal thread cutting with battery-powered screwdriver (min. 7,5 Volt).

Application:
non abrasive material up to 900 N/mm²
unalloyed and low alloyed steel



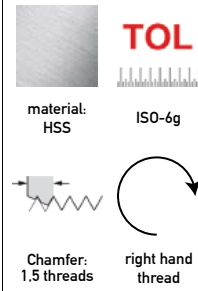
MF	D1	L1	L2	Hex	ØD	No.	€
MF 3 x 0,35	3,0	33,0	11	1/4"	2,65	121201001	*
MF 3,5 x 0,35	3,5	33,5	10	1/4"	3,15	121201002	*
MF 4 x 0,35	4,0	35,0	12	1/4"	3,65	121201003	*
MF 4 x 0,5	4,0	35,0	12	1/4"	3,50	121201004	*
MF 4,5 x 0,5	4,5	35,0	12	1/4"	4,00	121201005	*
MF 5 x 0,5	5,0	36,0	15	1/4"	4,50	121201006	*
MF 5 x 0,75	5,0	36,0	15	1/4"	4,25	121201007	*
MF 5,5 x 0,5	5,5	35,0	15	1/4"	5,00	121201008	*
MF 6 x 0,5	6,0	39,0	18	1/4"	5,50	121201009	*
MF 6 x 0,75	6,0	39,0	18	1/4"	5,20	121201010	*
MF 7 x 0,5	7,0	37,5	16	1/4"	6,50	121201011	*
MF 7 x 0,75	7,0	37,5	16	1/4"	6,20	121201012	*
MF 8 x 0,5	8,0	40,0	19	1/4"	7,50	121201013	*
MF 8 x 0,75	8,0	40,0	19	1/4"	7,20	121201014	*
MF 8 x 1	8,0	40,0	19	1/4"	7,00	121201015	*
MF 9 x 0,5	9,0	40,5	18	1/4"	8,50	121201016	*
MF 9 x 0,75	9,0	40,5	18	1/4"	8,25	121201017	*
MF 9 x 1	9,0	40,5	18	1/4"	8,00	121201018	*
MF 10 x 0,5	10,0	41,0	21	1/4"	9,50	121201019	*
MF 10 x 0,75	10,0	41,0	21	1/4"	9,20	121201020	*
MF 10 x 1,0	10,0	41,0	21	1/4"	9,00	121201021	*
MF 10 x 1,25	10,0	41,0	21	1/4"	8,80	121201022	*

* on request

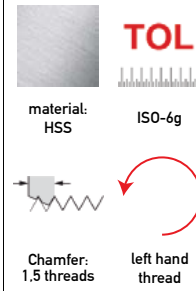
Round Dies

MF Metric fine thread ISO DIN 13

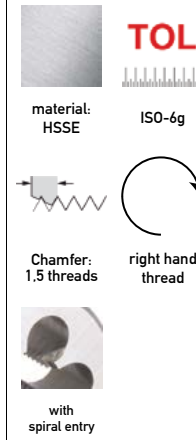
Round Dies for general use



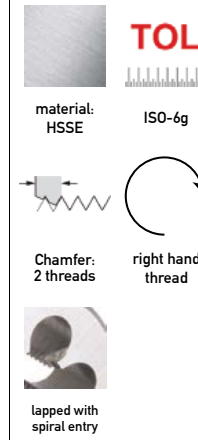
Round Dies for general use Left Hand



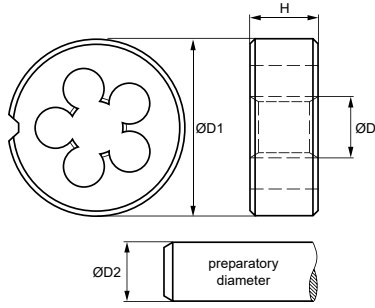
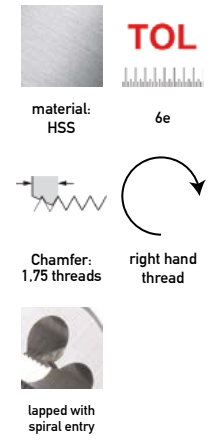
Round Dies for higher demands



Round Dies for stainless steels



Round Dies undersized

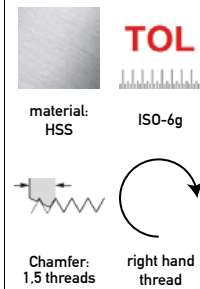


MF	D	D1	H	D2	No.	€	No.	€	No.	€	No.	€	No.	€	D2
															Tot. 6e
MF 2,5 x 0,35	2,5	16	5	2,44	121401001	13,48									
MF 2,6 x 0,35	2,6	16	5	2,54	121401002	13,48									
MF 3 x 0,35	3,0	20	5	2,94	121401003	12,25					121405001	33,73			
MF 3,5 x 0,35	3,5	20	5	3,44	121401004	12,25					121405002	41,77			
MF 4 x 0,35	4,0	20	5	3,94	121401005	12,25									
MF 4 x 0,5	4,0	20	5	3,93	121401006	12,25					121405003	23,94	121421001	82,71	3,84 mm
MF 4,5 x 0,5	4,5	20	5	4,43	121401007	12,25									
MF 5 x 0,5	5,0	20	5	4,93	121401008	12,25					121405004	65,99	121421002	82,71	4,83 mm
MF 5 x 0,75	5,0	20	7	4,91	121401010	12,25									
MF 5,5 x 0,5	5,5	20	5	5,43	121401009	12,25									
MF 6 x 0,5	6,0	20	5	5,93	121401011	12,25					121405005	24,66	121421003	68,39	5,83 mm
MF 6 x 0,75	6,0	20	7	5,90	121401012	10,58	121402001	15,59	121404001	13,36	121405006	24,66	121421004	63,62	5,81 mm
MF 7 x 0,5	7,0	25	9	6,93	121401013	13,36							121421005	84,29	6,83 mm
MF 7 x 0,75	7,0	25	9	6,90	121401014	13,36					121405007	30,26			
MF 8 x 0,5	8,0	25	9	7,93	121401015	13,36					121405008	27,32	121421006	110,70	7,82 mm
MF 8 x 0,75	8,0	25	9	7,90	121401016	11,14	121402002	18,71	121404002	17,60	121405009	27,32	121421007	79,53	7,80 mm
MF 8 x 1,0	8,0	25	9	7,83	121401017	11,14	121402003	18,71	121404003	17,60	121405010	27,26	121421008	60,44	7,78 mm
MF 9 x 0,5	9,0	25	9	8,93	121401018	16,71									
MF 9 x 0,75	9,0	25	9	8,90	121401019	16,71									
MF 9 x 1,0	9,0	25	9	8,88	121401020	16,71									
MF 10 x 0,5	10,0	30	11	9,93	121401021	16,71									
MF 10 x 0,75	10,0	30	11	9,90	121401022	16,71					121405011	80,54	121421009	109,75	9,79 mm
MF 10 x 1,0	10,0	30	11	9,88	121401023	12,81	121402004	23,39	121404004	19,94	121405012	32,34	121421010	67,76	9,77 mm
MF 10 x 1,25	10,0	30	11	9,86	121401024	12,81	121402005	23,39	121404005	19,94	121405013	30,72			
MF 11 x 1,0	11,0	30	11	10,88	121401025	19,27									
MF 11 x 1,25	11,0	30	11	10,86	121401026	19,27									
MF 12 x 0,5	12,0	38	10	11,93	121401027	16,84									
MF 12 x 0,75	12,0	38	10	11,90	121401028	19,27							121421011	113,88	11,78 mm
MF 12 x 1,0	12,0	38	10	11,88	121401029	18,73	121402006	30,41	121404006	34,52	121405014	40,72	121421012	89,07	11,76 mm
MF 12 x 1,25	12,0	38	10	11,86	121401030	16,37	121402007	30,41	121404007	34,52	121405015	38,99			
MF 12 x 1,5	12,0	38	10	11,85	121401031	25,77	121402008	30,41	121404008	34,52	121405016	38,99	121421013	83,66	11,73 mm
MF 13 x 0,5	13,0	38	10	12,93	121401032	26,84									
MF 13 x 1,0	13,0	38	10	12,88	121401033	21,49									

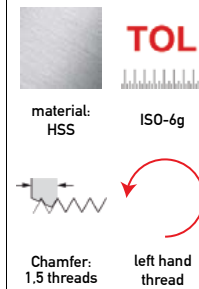
Round Dies

MF Metric fine thread
ISO DIN 13

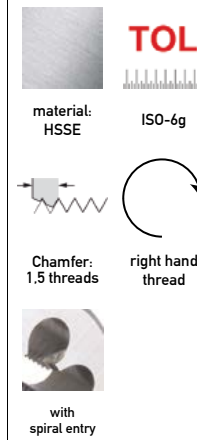
Round Dies
for general use



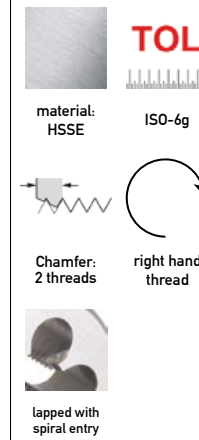
Round Dies
for general use
Left Hand



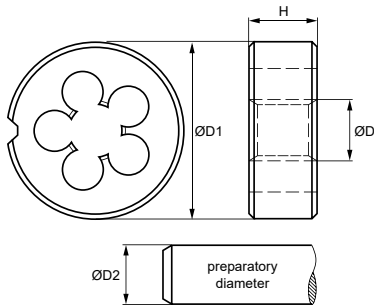
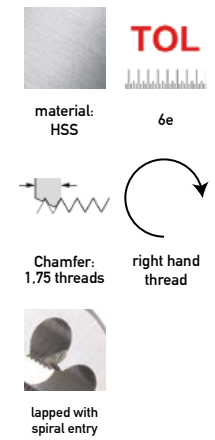
Round Dies
for higher demands



Round Dies
for stainless steels



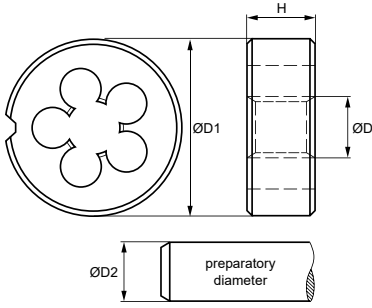
Round Dies
undersized



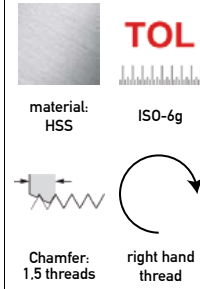
MF	D	D1	H	D2	No.	€	No.	€	No.	€	No.	€	No.	€	D2 Tol. 6e
MF 13 x 1,5	13,0	38	10	12,85	121401034	21,49									
MF 14 x 0,5	14,0	38	10	13,93	121401035	18,79									
MF 14 x 0,75	14,0	38	10	13,90	121401036	26,87									
MF 14 x 1,0	14,0	38	10	13,88	121401037	21,49					121405017	38,86	121421014	97,02	13,76 mm
MF 14 x 1,25	14,0	38	10	13,86	121401038	20,62	121402009	30,41	121404009	34,52	121405018	63,78			
MF 14 x 1,5	14,0	38	10	13,85	121401039	18,04	121402010	30,41	121404010	34,52	121405019	37,21	121421015	83,66	13,73 mm
MF 15 x 0,75	15,0	38	10	14,90	121401040	33,97									
MF 15 x 1,0	15,0	38	10	14,88	121401041	29,29									
MF 15 x 1,5	15,0	38	10	14,85	121401042	29,29									
MF 16 x 0,5	16,0	45	14	15,93	121401043	37,43									
MF 16 x 0,75	16,0	45	14	15,90	121401044	37,43									
MF 16 x 1,0	16,0	45	14	15,88	121401045	29,29	121402011	45,66			121405020	70,51	121421016	130,42	15,76 mm
MF 16 x 1,25	16,0	45	14	15,86	121401046	29,29									
MF 16 x 1,5	16,0	45	14	15,85	121401047	23,06	121402012	45,66	121404011	54,57	121405021	66,93	121421017	113,24	15,73 mm
MF 17 x 1,0	17,0	45	14	16,88	121401048	39,76									
MF 17 x 1,5	17,0	45	14	16,85	121401049	39,76									
MF 18 x 0,5	18,0	45	14	17,93	121401050	39,76									
MF 18 x 0,75	18,0	45	14	17,90	121401051	39,76									
MF 18 x 1,0	18,0	45	14	17,88	121401052	26,84					121405022	70,51	121421018	194,04	17,74 mm
MF 18 x 1,25	18,0	45	14	17,86	121401053	26,84									
MF 18 x 1,5	18,0	45	14	17,85	121401054	23,06	121402013	45,66	121404012	54,57	121405023	66,93	121421019	113,24	17,71 mm
MF 18 x 2,0	18,0	45	14	17,82	121401055	27,51			121404013	54,57					
MF 19 x 1,0	19,0	45	14	18,88	121401056	39,76									
MF 19 x 1,5	19,0	45	14	18,85	121401057	26,84									
MF 20 x 0,5	20,0	45	14	19,93	121401058	39,76									
MF 20 x 0,75	20,0	45	14	19,90	121401059	39,76									
MF 20 x 1,0	20,0	45	14	19,88	121401060	27,51					121405024	70,61	121421020	194,04	19,66 mm
MF 20 x 1,25	20,0	45	14	19,86	121401061	27,51									
MF 20 x 1,5	20,0	45	14	19,85	121401062	23,06	121402014	45,66	121404014	54,57	121405025	66,93	121421021	130,42	19,71 mm
MF 20 x 2,0	20,0	45	14	19,82	121401063	27,51			121404015	54,57					
MF 21 x 1,0	21,0	45	14	20,88	121401064	41,54									
MF 21 x 1,5	21,0	45	14	20,85	121401065	41,54									
MF 22 x 0,5	22,0	55	16	21,93	121401066	57,35									

Round Dies

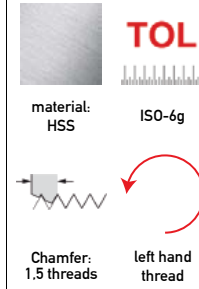
MF Metric fine thread ISO DIN 13



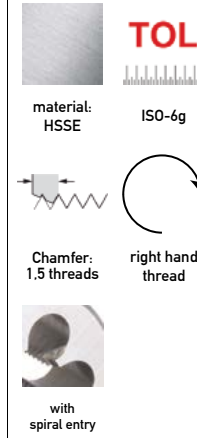
Round Dies for general use



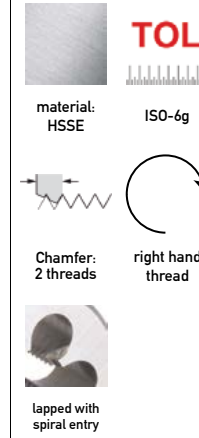
Round Dies for general use Left Hand



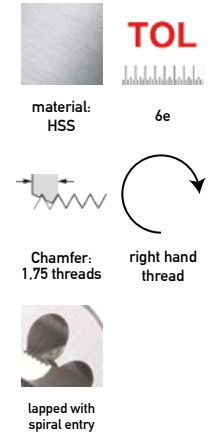
Round Dies for higher demands



Round Dies for stainless steels



Round Dies undersized

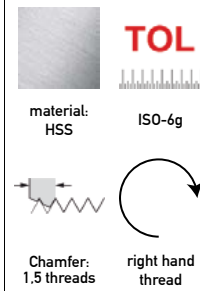


MF	D	D1	H	D2	No.	€	No.	€	No.	€	No.	€	No.	€	D2 Tot. 6e
MF 22 x 0,75	22,0	55	16	21,90	121401067	57,35									
MF 22 x 1,0	22,0	55	16	21,88	121401068	44,44									
MF 22 x 1,25	22,0	55	16	21,86	121401069	44,44									
MF 22 x 1,5	22,0	55	16	21,85	121401070	40,10	121402015	72,40	121404016	95,78	121405026	126,62	121421022	162,23	21,71 mm
MF 22 x 2,0	22,0	55	16	21,82	121401071	44,44									
MF 23 x 1,0	23,0	55	16	22,88	121401072	58,25									
MF 23 x 1,5	23,0	55	16	22,85	121401073	44,44									
MF 24 x 0,5	24,0	55	16	23,93	121401074	57,35									
MF 24 x 0,75	24,0	55	16	23,90	121401075	57,35									
MF 24 x 1,0	24,0	55	16	23,88	121401076	44,44							121421023	270,39	21,74 mm
MF 24 x 1,25	24,0	55	16	23,86	121401077	44,44									
MF 24 x 1,5	24,0	55	16	23,85	121401078	40,10	121402016	72,40	121404017	95,78	121405027	126,62	121421024	209,95	23,70 mm
MF 24 x 2,0	24,0	55	16	22,82	121401079	44,44	121402017	72,40			121405028	132,42			
MF 25 x 1,0	25,0	55	16	24,88	121401080	57,35									
MF 25 x 1,5	25,0	55	16	24,85	121401081	57,35									
MF 26 x 1,0	26,0	55	16	25,88	121401082	57,35									
MF 26 x 1,5	26,0	55	16	25,85	121401083	57,35					121405029	186,00	121421025	238,57	25,69 mm
MF 26 x 2,0	26,0	55	16	25,82	121401084	57,35									
MF 27 x 1,0	27,0	65	18	26,88	121401085	65,49									
MF 27 x 1,5	27,0	65	18	26,85	121401086	65,49									
MF 27 x 2,0	27,0	65	18	26,82	121401087	65,49									
MF 28 x 1,0	28,0	65	18	27,88	121401088	65,49									
MF 28 x 1,5	28,0	65	18	27,85	121401089	65,49									
MF 28 x 2,0	28,0	65	18	27,82	121401090	65,49									
MF 29 x 1,5	29,0	65	18	28,85	121401091	65,49									
MF 30 x 1,0	30,0	65	18	29,88	121401092	65,49									
MF 30 x 1,5	30,0	65	18	29,85	121401093	65,49					121405030	204,90			
MF 30 x 2,0	30,0	65	18	29,82	121401094	65,49	121402018	114,72			121405031	214,71			
MF 30 x 2,5	30,0	65	18	29,79	121401095	65,49	121402019	*							
MF 30 x 3,0	30,0	65	25	29,76	121401096	65,49	121402020	*							
MF 32 x 1,0	32,0	65	18	31,88	121401098	92,44	121402021	*							
MF 32 x 1,5	32,0	65	18	31,85	121401097	65,49	121402022	*							
MF 32 x 2,0	32,0	65	18	31,82	121401099	65,49	121402023	*							

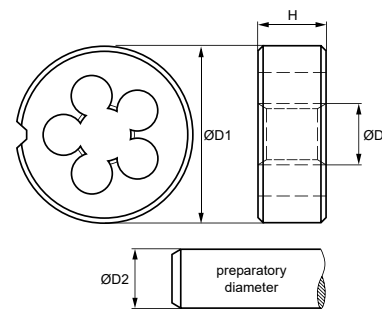
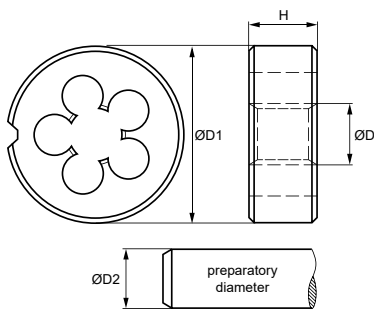
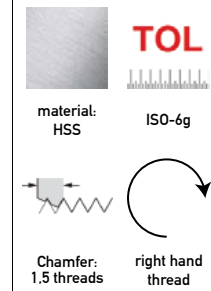
Round Dies

MF Metric fine thread ISO DIN 13

Round Dies for general use



Round Dies for general use



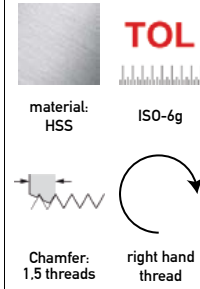
MF	D	D1	H	D2	No.	€
MF 32 x 3,0	32,0	65	25	31,77	121401100	65,49
MF 33 x 1,5	33,0	65	18	32,85	121401101	65,49
MF 33 x 2,0	33,0	65	18	32,82	121401102	65,49
MF 33 x 3,0	33,0	65	25	32,76	121401103	65,49
MF 34 x 1,0	34,0	65	18	33,88	121401104	92,44
MF 34 x 1,5	34,0	65	18	33,85	121401105	65,49
MF 34 x 2,0	34,0	65	18	33,82	121401106	65,49
MF 35 x 1,0	35,0	65	18	34,88	121401107	92,44
MF 35 x 1,5	35,0	65	18	34,85	121401108	65,49
MF 35 x 2,0	35,0	65	18	34,82	121401109	92,44
MF 36 x 1,0	36,0	65	18	35,88	121401110	92,44
MF 36 x 1,5	36,0	65	18	35,85	121401111	65,49
MF 36 x 2,0	36,0	65	18	35,82	121401112	65,49
MF 36 x 3,0	36,0	65	25	35,76	121401113	65,49
MF 37 x 1,5	37,0	65	18	36,85	121401114	139,22
MF 38 x 1,0	38,0	75	20	37,88	121401115	139,22
MF 38 x 1,5	38,0	75	20	37,85	121401116	105,81
MF 38 x 2,0	38,0	75	20	37,82	121401117	105,81
MF 38 x 3,0	38,0	75	30	37,77	121401118	139,22
MF 39 x 1,5	39,0	75	20	38,85	121401119	105,81
MF 39 x 2,0	39,0	75	20	38,82	121401120	105,81
MF 39 x 3,0	39,0	75	30	38,76	121401121	105,81
MF 40 x 1,0	40,0	75	20	39,88	121401122	139,22
MF 40 x 1,5	40,0	75	20	39,85	121401123	105,81
MF 40 x 2,0	40,0	75	20	39,82	121401124	105,81
MF 40 x 3,0	40,0	75	30	39,76	121401125	105,81
MF 42 x 1,0	42,0	75	20	41,88	121401126	139,22
MF 42 x 1,5	42,0	75	20	41,85	121401127	105,81
MF 42 x 2,0	42,0	75	20	41,82	121401128	105,81
MF 42 x 3,0	42,0	75	30	41,76	121401129	105,81
MF 44 x 1,5	44,0	90	22	43,85	121401130	227,20
MF 44 x 2,0	44,0	90	22	43,82	121401131	227,20
MF 45 x 1,0	45,0	90	22	44,88	121401132	227,20

MF	D	D1	H	D2	No.	€
MF 45 x 1,5	45,0	90	22	44,85	121401133	175,97
MF 45 x 2,0	45,0	90	22	44,82	121401134	175,97
MF 45 x 3,0	45,0	90	36	44,76	121401135	175,97
MF 46 x 1,5	46,0	90	22	45,85	121401136	227,20
MF 48 x 1,0	48,0	90	22	47,88	121401137	227,20
MF 48 x 1,5	48,0	90	22	47,85	121401138	175,97
MF 48 x 2,0	48,0	90	22	47,82	121401139	175,97
MF 48 x 3,0	48,0	90	36	47,46	121401140	175,97
MF 50 x 1,5	50,0	90	22	49,85	121401141	175,97
MF 50 x 2,0	50,0	90	22	49,82	121401142	175,97
MF 50 x 3,0	50,0	90	36	49,76	121401143	175,97
MF 52 x 1,5	52,0	90	22	51,85	121401144	175,97
MF 52 x 2,0	52,0	90	22	51,82	121401145	175,97
MF 52 x 3,0	52,0	90	36	51,76	121401146	175,97
MF 54 x 1,5	54,0	105	22	53,92	121401147	311,84
MF 54 x 2,0	54,0	105	22	53,91	121401148	311,84
MF 54 x 3,0	54,0	105	36	53,88	121401149	311,84
MF 54 x 4,0	54,0	105	36	53,85	121401150	311,84
MF 55 x 1,5	55,0	105	22	54,85	121401151	311,84
MF 55 x 2,0	55,0	105	22	54,82	121401152	311,84
MF 55 x 3,0	55,0	105	36	54,76	121401153	311,84
MF 55 x 4,0	55,0	105	36	54,73	121401154	311,84
MF 56 x 1,5	56,0	105	22	55,85	121401155	311,84
MF 56 x 2,0	56,0	105	22	55,82	121401156	311,84
MF 56 x 3,0	56,0	105	36	55,76	121401157	311,84
MF 56 x 4,0	56,0	105	36	55,73	121401158	311,84
MF 58 x 1,5	58,0	105	22	57,92	121401159	311,84
MF 58 x 2,0	58,0	105	22	57,91	121401160	311,84
MF 58 x 3,0	58,0	105	36	57,88	121401161	311,84
MF 58 x 4,0	58,0	105	36	57,85	121401162	311,84
MF 60 x 1,5	60,0	105	22	59,92	121401163	311,84
MF 60 x 2,0	60,0	105	22	59,91	121401164	311,84
MF 60 x 3,0	60,0	105	36	59,88	121401165	311,84

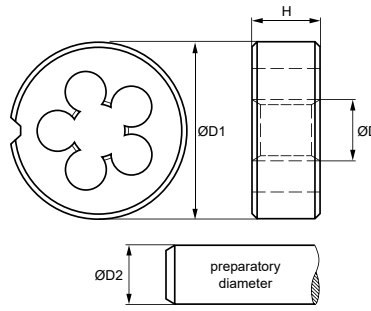
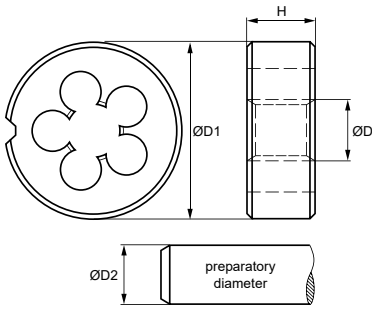
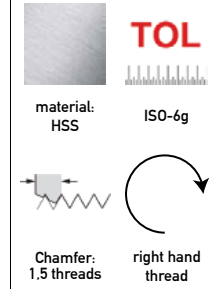
Round Dies

MF Metric fine thread ISO DIN 13

Round Dies for general use



Round Dies for general use



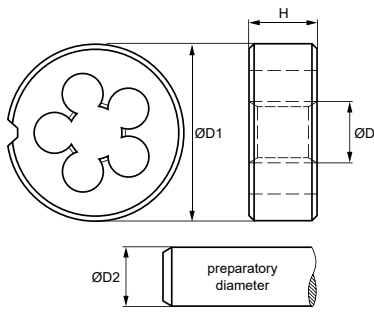
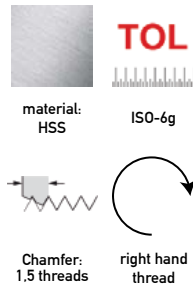
MF	D	D1	H	D2	No.	€
MF 60 x 4,0	60,0	105	36	59,85	121401166	311,84
MF 62 x 1,5	62,0	105	22	61,92	121401167	311,84
MF 62 x 2,0	62,0	105	22	61,91	121401168	311,84
MF 62 x 3,0	62,0	105	36	61,88	121401169	311,84
MF 62 x 4,0	62,0	105	36	61,85	121401170	311,84
MF 63 x 1,5	63,0	105	22	62,92	121401171	311,84
MF 64 x 1,5	64,0	120	22	63,92	121401172	354,18
MF 64 x 2,0	64,0	120	22	63,91	121401173	354,18
MF 64 x 3,0	64,0	120	36	63,88	121401174	354,18
MF 64 x 4,0	64,0	120	36	63,85	121401175	354,18
MF 65 x 1,5	65,0	120	22	64,92	121401176	354,18
MF 65 x 2,0	65,0	120	22	64,91	121401177	354,18
MF 65 x 3,0	65,0	120	36	64,88	121401178	354,18
MF 65 x 4,0	65,0	120	36	64,85	121401179	354,18
MF 68 x 1,5	68,0	120	22	67,92	121401180	354,18
MF 68 x 2,0	68,0	120	22	67,91	121401181	354,18
MF 68 x 3,0	68,0	120	36	67,88	121401182	354,18
MF 68 x 4,0	68,0	120	36	67,85	121401183	354,18
MF 70 x 1,5	70,0	120	22	69,92	121401184	354,18
MF 70 x 2,0	70,0	120	22	69,91	121401185	354,18
MF 70 x 3,0	70,0	120	36	69,88	121401186	354,18
MF 70 x 4,0	70,0	120	36	69,85	121401187	354,18
MF 72 x 1,5	72,0	120	22	71,92	121401188	354,18
MF 72 x 2,0	72,0	120	22	71,91	121401189	354,18
MF 72 x 3,0	72,0	120	36	71,88	121401190	354,18
MF 72 x 4,0	72,0	120	36	71,85	121401191	354,18
MF 74 x 1,5	74,0	120	22	73,92	121401192	354,18
MF 74 x 2,0	74,0	120	22	73,91	121401193	354,18
MF 74 x 3,0	74,0	120	36	73,88	121401194	354,18
MF 74 x 4,0	74,0	120	36	73,85	121401195	354,18
MF 75 x 1,5	75,0	120	22	74,92	121401196	354,18
MF 75 x 2,0	75,0	120	22	74,91	121401197	354,18
MF 75 x 3,0	75,0	120	36	74,88	121401198	354,18

MF	D	D1	H	D2	No.	€
MF 75 x 4,0	75,0	120	36	74,85	121401199	354,18
MF 76 x 1,5	76,0	120	22	75,92	121401200	354,18
MF 76 x 2,0	76,0	120	22	75,91	121401201	354,18
MF 76 x 3,0	76,0	120	36	75,88	121401202	354,18
MF 76 x 4,0	76,0	120	36	75,85	121401203	354,18
MF 78 x 1,5	78,0	120	22	77,92	121401204	354,18
MF 78 x 2,0	78,0	120	22	77,91	121401205	354,18
MF 78 x 3,0	78,0	120	36	77,88	121401206	354,18
MF 78 x 4,0	78,0	120	36	77,85	121401207	354,18
MF 80 x 1,5	80,0	120	22	79,92	121401208	354,18
MF 80 x 2,0	80,0	120	22	79,91	121401209	354,18
MF 80 x 3,0	80,0	120	36	79,88	121401210	354,18
MF 80 x 4,0	80,0	120	36	79,85	121401211	354,18
MF 82 x 1,5	82,0	130	25	81,92	121401212	447,73
MF 82 x 2,0	82,0	130	25	81,91	121401213	447,73
MF 82 x 3,0	82,0	130	36	81,88	121401214	447,73
MF 82 x 4,0	82,0	130	36	81,85	121401215	447,73
MF 84 x 1,5	84,0	130	25	83,92	121401216	447,73
MF 84 x 2,0	84,0	130	25	83,91	121401217	447,73
MF 84 x 3,0	84,0	130	36	83,88	121401218	447,73
MF 84 x 4,0	84,0	130	36	83,85	121401219	447,73
MF 85 x 1,5	85,0	130	25	84,92	121401220	447,73
MF 85 x 2,0	85,0	130	25	84,91	121401221	447,73
MF 85 x 3,0	85,0	130	36	84,88	121401222	447,73
MF 85 x 4,0	85,0	130	36	84,85	121401223	447,73
MF 86 x 1,5	86,0	140	22	85,92	121401224	557,99
MF 86 x 2,0	86,0	140	22	85,91	121401225	557,99
MF 86 x 3,0	86,0	140	22	85,88	121401226	557,99
MF 86 x 4,0	86,0	140	22	85,85	121401227	557,99
MF 88 x 1,5	88,0	140	22	87,92	121401228	557,99
MF 88 x 2,0	88,0	140	22	87,91	121401229	557,99
MF 88 x 3,0	88,0	140	22	87,88	121401230	557,99
MF 88 x 4,0	88,0	140	22	87,85	121401231	557,99

Round Dies

MF Metric fine thread
ISO DIN 13

Round Dies
for general use

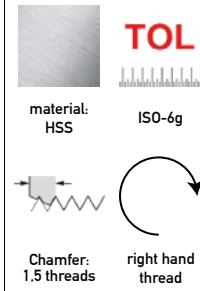


MF	D	D1	H	D2	No.	€
MF 90 x 1,5	90,0	140	22	89,92	121401232	557,99
MF 90 x 2,0	90,0	140	22	89,91	121401233	557,99
MF 90 x 3,0	90,0	140	22	89,88	121401234	557,99
MF 90 x 4,0	90,0	140	22	89,85	121401235	557,99
MF 92 x 1,5	92,0	140	22	91,92	121401236	557,99
MF 92 x 2,0	92,0	140	22	91,91	121401237	557,99
MF 92 x 3,0	92,0	140	22	91,88	121401238	557,99
MF 92 x 4,0	92,0	140	22	91,85	121401239	557,99
MF 95 x 1,5	95,0	140	22	94,92	121401240	557,99
MF 95 x 2,0	95,0	140	22	94,91	121401241	557,99
MF 95 x 3,0	95,0	140	22	94,88	121401242	557,99
MF 95 x 4,0	95,0	140	22	94,85	121401243	557,99
MF 96 x 1,5	96,0	140	22	95,92	121401244	557,99
MF 96 x 2,0	96,0	140	22	95,91	121401245	557,99
MF 96 x 3,0	96,0	140	22	95,88	121401246	557,99
MF 96 x 4,0	96,0	140	22	95,85	121401247	557,99
MF 98 x 1,5	98,0	150	25	94,92	121401248	671,58
MF 98 x 2,0	98,0	150	25	97,91	121401249	671,58
MF 98 x 3,0	98,0	150	25	97,88	121401250	671,58
MF 98 x 4,0	98,0	150	25	97,85	121401251	671,58
MF 100 x 1,5	100,0	150	25	99,92	121401252	671,58
MF 100 x 2,0	100,0	150	25	99,91	121401253	671,58
MF 100 x 3,0	100,0	150	25	99,88	121401254	671,58
MF 100 x 4,0	100,0	150	25	99,85	121401255	671,58
MF 105 x 1,5	105,0	150	25	104,92	121401256	671,58
MF 105 x 2,0	105,0	150	25	104,91	121401257	671,58
MF 105 x 3,0	105,0	150	25	104,88	121401258	671,58
MF 105 x 4,0	105,0	150	25	104,85	121401259	671,58
MF 110 x 1,5	110,0	160	25	109,92	121401260	733,95
MF 110 x 2,0	110,0	160	25	109,91	121401261	733,95
MF 110 x 3,0	110,0	160	25	109,88	121401262	733,95
MF 110 x 4,0	110,0	160	25	109,85	121401263	733,95

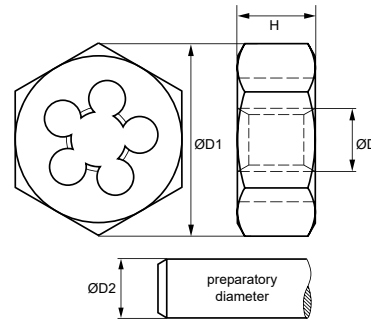
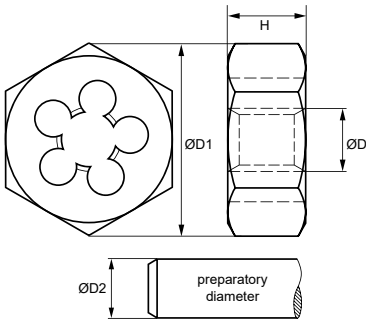
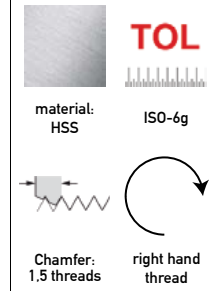
Hexagon Die Nuts

MF Metric fine thread ISO DIN 13

Hexagon Die Nuts for general use



Hexagon Die Nuts for general use



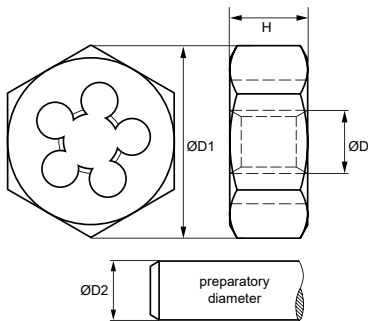
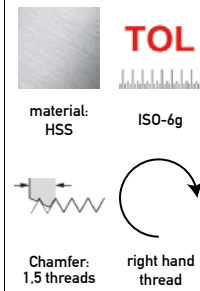
MF	D	D1	H	D2	No.	€
MF 3 x 0,35	3,0	19	5	2,94	121501001	21,72
MF 4 x 0,35	3,5	19	5	3,44	121501002	21,72
MF 4 x 0,5	4,0	19	5	3,93	121501003	21,72
MF 5 x 0,5	5,0	19	5	4,93	121501004	21,72
MF 5 x 0,75	5,0	19	7	4,91	121501005	21,72
MF 6 x 0,5	6,0	19	5	5,93	121501006	21,72
MF 6 x 0,75	6,0	19	7	5,90	121501007	21,72
MF 7 x 0,75	7,0	22	9	6,90	121501008	23,39
MF 8 x 0,5	8,0	22	9	7,93	121501009	23,39
MF 8 x 0,75	8,0	22	9	7,90	121501010	23,39
MF 8 x 1,0	8,0	22	9	7,83	121501011	23,39
MF 9 x 0,75	9,0	22	9	8,90	121501012	23,39
MF 9 x 1,0	9,0	22	9	8,88	121501013	23,39
MF 10 x 0,75	10,0	27	11	9,90	121501014	23,39
MF 10 x 1,0	10,0	27	11	9,88	121501015	23,39
MF 10 x 1,25	10,0	27	11	9,86	121501016	23,39
MF 11 x 1,0	11,0	27	11	10,88	121501017	32,74
MF 11 x 1,25	11,0	27	11	10,86	121501018	32,74
MF 12 x 0,75	12,0	36	10	11,90	121501019	32,74
MF 12 x 1,0	12,0	36	10	11,88	121501020	32,74
MF 12 x 1,25	12,0	36	10	11,86	121501021	32,74
MF 12 x 1,5	12,0	36	10	11,85	121501022	32,74
MF 13 x 1,0	13,0	36	10	12,88	121501023	37,31
MF 13 x 1,5	13,0	36	10	12,85	121501024	37,31
MF 14 x 0,75	14,0	36	10	13,90	121501025	37,31
MF 14 x 1,0	14,0	36	10	13,88	121501026	37,31
MF 14 x 1,25	14,0	36	10	13,86	121501027	37,31
MF 14 x 1,5	14,0	36	10	13,85	121501028	37,31
MF 15 x 1,0	15,0	36	10	14,88	121501029	43,43
MF 15 x 1,5	15,0	36	10	14,85	121501030	43,43
MF 16 x 1,0	16,0	41	14	15,88	121501031	45,67
MF 16 x 1,25	16,0	41	14	15,86	121501032	45,67
MF 16 x 1,5	16,0	41	14	15,85	121501033	45,67
MF 18 x 1,0	18,0	41	14	17,88	121501034	47,89

MF	D	D1	H	D2	No.	€
MF 18 x 1,25	18,0	41	14	17,86	121501035	47,89
MF 18 x 1,5	18,0	41	14	17,85	121501036	47,89
MF 18 x 2,0	18,0	41	14	17,82	121501037	47,89
MF 20 x 1,0	20,0	41	14	19,88	121501038	47,89
MF 20 x 1,25	20,0	41	14	19,86	121501039	47,89
MF 20 x 1,5	20,0	41	14	19,85	121501040	47,89
MF 20 x 2,0	20,0	41	14	19,82	121501041	47,89
MF 21 x 1,5	21,0	41	14	20,85	121501042	70,17
MF 22 x 1,0	22,0	50	16	21,88	121501043	70,17
MF 22 x 1,25	22,0	50	16	21,86	121501044	70,17
MF 22 x 1,5	22,0	50	16	21,85	121501045	70,17
MF 22 x 2,0	22,0	50	16	21,82	121501046	70,17
MF 23 x 1,5	23,0	50	16	22,85	121501047	70,17
MF 24 x 1,0	24,0	50	16	23,88	121501048	70,17
MF 24 x 1,25	24,0	50	16	23,86	121501049	70,17
MF 24 x 1,5	24,0	50	16	23,85	121501050	70,17
MF 24 x 2,0	24,0	50	16	22,82	121501051	70,17
MF 25 x 1,0	25,0	50	16	24,88	121501052	101,35
MF 25 x 1,5	25,0	50	16	24,85	121501053	101,35
MF 26 x 1,0	26,0	50	16	25,88	121501054	101,35
MF 26 x 1,5	26,0	50	16	25,85	121501055	101,35
MF 26 x 2,0	26,0	50	16	25,82	121501056	101,35
MF 27 x 1,0	27,0	60	18	26,88	121501057	105,81
MF 27 x 1,5	27,0	60	18	26,85	121501058	105,81
MF 27 x 2,0	27,0	60	18	26,82	121501059	105,81
MF 28 x 1,0	28,0	60	18	27,88	121501060	105,81
MF 28 x 1,5	28,0	60	18	27,85	121501061	105,81
MF 28 x 2,0	28,0	60	18	27,82	121501062	105,81
MF 29 x 1,5	29,0	60	18	28,85	121501063	105,81
MF 30 x 1,0	30,0	60	18	29,88	121501064	105,81
MF 30 x 1,5	30,0	60	18	29,85	121501065	105,81
MF 30 x 2,0	30,0	60	18	29,82	121501066	105,81
MF 30 x 3,0	30,0	60	25	29,76	121501067	105,81
MF 32 x 1,5	32,0	60	18	31,85	121501068	105,81

Hexagon Die Nuts

MF Metric fine thread
ISO DIN 13

Hexagon Die Nuts
for general use



MF	D	D1	H	D2	No.	€
MF 32 x 2,0	32,0	60	18	31,82	121501069	105,81
MF 32 x 3,0	32,0	60	25	31,77	121501070	105,81
MF 33 x 1,5	33,0	60	18	32,85	121501071	105,81
MF 33 x 2,0	33,0	60	18	32,82	121501072	105,81
MF 33 x 3,0	33,0	60	25	32,76	121501073	105,81
MF 34 x 1,5	34,0	60	18	33,85	121501074	105,81
MF 34 x 2,0	34,0	60	18	33,82	121501075	105,81
MF 35 x 1,5	35,0	60	18	34,85	121501076	105,81
MF 36 x 1,5	36,0	60	18	35,85	121501077	105,81
MF 36 x 2,0	36,0	60	18	35,82	121501078	105,81
MF 36 x 3,0	36,0	60	25	35,76	121501079	105,81
MF 38 x 1,5	38,0	70	20	37,85	121501080	175,97
MF 39 x 1,5	39,0	70	20	38,85	121501081	175,97
MF 39 x 2,0	39,0	70	20	38,82	121501082	175,97
MF 39 x 3,0	39,0	70	30	38,76	121501083	175,97
MF 40 x 1,5	40,0	70	20	39,85	121501084	175,97
MF 40 x 2,0	40,0	70	20	39,82	121501085	175,97
MF 40 x 3,0	40,0	70	30	39,76	121501086	175,97
MF 42 x 1,5	42,0	70	20	41,85	121501087	175,97
MF 42 x 2,0	42,0	70	20	41,82	121501088	175,97
MF 42 x 3,0	42,0	70	30	41,76	121501089	175,97
MF 45 x 1,5	45,0	85	22	44,85	121501090	259,51
MF 45 x 2,0	45,0	85	22	44,82	121501091	259,51
MF 45 x 3,0	45,0	85	36	44,76	121501092	259,51
MF 48 x 1,5	48,0	85	22	47,85	121501093	259,51
MF 48 x 2,0	48,0	85	22	47,82	121501094	259,51
MF 48 x 3,0	48,0	85	36	47,46	121501095	259,51
MF 50 x 1,5	50,0	85	22	49,85	121501096	259,51
MF 50 x 2,0	50,0	85	22	49,82	121501097	259,51
MF 50 x 3,0	50,0	85	36	49,76	121501098	259,51
MF 52 x 1,5	52,0	85	22	51,85	121501099	259,51
MF 52 x 2,0	52,0	85	22	51,82	121501100	233,47
MF 52 x 3,0	52,0	85	36	51,76	121501101	233,47

Thread Cutting Kits with Taps, Dies and Tools

G-Rohr (BSP) British standard whitworth pipe thread DIN ISO 228

BAER Hand-Tap Sets, Round Dies and Tools Sets (example picture)



BAER Set G(BSP) 1/8" - 1"		€/Set
HSSG Hand Tap Sets & HSS Round Dies & Tools		
BAER HSSG Hand Tap Sets (2 parts)	G 1/8 x 28 G 1/4 x 19 G 3/8 x 19 G 1/2 x 14 G 3/4 x 14 G 1" x 11	631,50 € Item No.: 264802014
BAER HSS Round Dies	G 1/8 x 28 G 1/4 x 19 G 3/8 x 19 G 1/2 x 14 G 3/4 x 14 G 1" x 11	
BAER adjustable Tap Wrenches - zinc die cast	M 1-10 1/16-3/8 G 1/8 & M 5-20 7/32-3/4" G 1/8-1/2 & M 13-32 1/2-1.1/4" G 1/4-1"	
BAER Die Stocks - zinc die cast	30 x 11 38 x 10 45 x 14 55 x 16 68 x 18	
Screw extractor		

BAER Set G(BSP) 1/8" - 1" (incl. intermediate sizes)		€/Set
HSSG Hand Tap Sets & HSS Round Dies & Tools		
BAER HSSG Hand Tap Sets (2 parts)	G 1/8 x 28 G 1/4 x 19 G 3/8 x 19 G 1/2 x 14 G 5/8 x 14 G 3/4 x 14 G 7/8 x 14 G 1" x 11	846,50 € Item No.: 264802114
BAER HSS Round Dies	G 1/8 x 28 G 1/4 x 19 G 3/8 x 19 G 1/2 x 14 G 5/8 x 14 G 3/4 x 14 G 7/8 x 14 G 1" x 11	
BAER adjustable Tap Wrenches - zinc die cast	M 1-10 1/16-3/8 G 1/8 & M 5-20 7/32-3/4" G 1/8-1/2 & M 13-32 1/2-1.1/4" G 1/4-1"	
BAER Die Stocks - zinc die cast	30 x 11 38 x 10 45 x 14 55 x 16 68 x 18	
Screw extractor		

BAER Set G(BSP) 1/4" - 1.1/2"		€/Set
HSSG Hand Tap Sets & HSS Round Dies & Tools		
BAER HSSG Hand Tap Sets (2 parts)	G 1/4 x 19 G 3/8 x 19 G 1/2 x 14 G 3/4 x 14 G 1" x 11 G 1.1/4" x 11 G 1.1/2" x 11	1700,00 € Item No.: 264802214
BAER HSS Round Dies	G 1/4 x 19 G 3/8 x 19 G 1/2 x 14 G 3/4 x 14 G 1" x 11 G 1.1/4" x 11 G 1.1/2" x 11	
BAER adjustable Tap Wrenches - zinc die cast	M 4-12 5/32-1/2 G 1/8 & M 11-27 7/16-1" G 1/4-3/4 & M 27-52 1.1/8"-2" G 3/4-1.3/4"	
BAER Die Stocks - zinc die cast	38 x 10 45 x 14 55 x 16 68 x 18 75 x 20 90 x 22	
Screw extractor		

Thread Cutting Kits with Taps and Dies

G-Rohr (BSP) British standard whitworth pipe thread DIN ISO 228

BAER Taps and Dies Sets (example picture)



BAER Set G(BSP) 1/8" - 3/4" Short Machine Taps through hole & blind hole HSSG Hexagonal-Die-Nuts			€/Set
BAER HSSG Short Machine Taps Form D for through holes and blind holes (up to 4 x D)	G 1/8 x 28 G 1/4 x 19 G 3/8 x 19 G 1/2 x 14 G 3/4 x 14		199,08 € Item No.: BSR1
BAER HSSG Hexagonal-Die-Nuts	G 1/8 x 28 G 1/4 x 19 G 3/8 x 19 G 1/2 x 14 G 3/4 x 14		

BAER Set G(BSP) 1/8" - 1/2" Short Machine Taps through hole & blind hole HSSG Hexagonal-Die-Nuts			€/Set
BAER HSSG Short Machine Taps Form D for through holes and blind holes (up to 4 x D)	G 1/8 x 28 G 1/4 x 19 G 3/8 x 19 G 1/2 x 14		151,73 € Item No.: BSR2
BAER HSSG Hexagonal-Die-Nuts	G 1/8 x 28 G 1/4 x 19 G 3/8 x 19 G 1/2 x 14		

Attention: the box two empty spaces/ recesses for BSP3/4 Tap and Round Die in case of adding them later

BAER Set G(BSP) 1/8" - 3/4" Short Machine Taps through hole & blind hole HSSG Round Dies			€/Set
BAER HSSG Short Machine Taps Form D for through holes and blind holes (up to 4 x D)	G 1/8 x 28 G 1/4 x 19 G 3/8 x 19 G 1/2 x 14 G 3/4 x 14		233,10 € Item No.: BSR1
BAER HSSG Round Dies	G 1/8 x 28 G 1/4 x 19 G 3/8 x 19 G 1/2 x 14 G 3/4 x 14		

Short Machine Taps

G-Rohr (BSP)

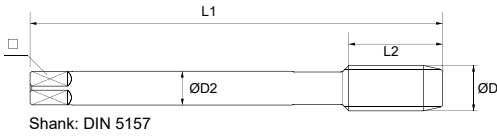
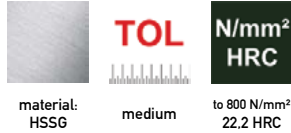
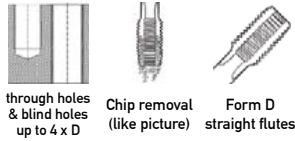
British standard whitworth pipe thread
DIN ISO 228

Efficient internal thread cutting.
The short structural type makes that tap usable by machine and hand.

Application:
non abrasive material up to 900 N/mm²
unalloyed and low alloyed steel

Short Machine Taps

Form D for through holes and blind holes



G(BSP)	D1	D2	L1	L2	□		No.	€
BSP 1/8 x 28	9,73	7,0	63	20	5,5	8,80	130101001	6,09
BSP 1/4 x 19	13,16	11,0	70	22	9,0	11,80	130101002	6,86
BSP 3/8 x 19	16,66	12,0	70	22	9,0	15,25	130101003	9,98
BSP 1/2 x 14	20,95	16,0	80	22	12,0	19,00	130101004	14,18
BSP 3/4 x 14	26,44	20,0	90	22	16,0	24,50	130101005	20,05
BSP 1" x 11	33,25	25,0	100	25	20,0	30,75	130101006	33,80
BSP 1.1/4 x 11	41,91	32,0	125	40	24,0	39,50	130101007	58,73
BSP 1.1/2 x 11	47,80	36,0	140	40	29,0	45,25	130101008	80,34
BSP 1.3/4 x 11	53,74	40,0	140	40	32,0	51,20	130101009	160,67
BSP 2" x 11	59,61	45,0	160	40	35,0	57,00	130101010	166,22
BSP 2.1/4 x 11	65,71	50,0	160	40	39,0	63,10	130101011	363,47
BSP 2.1/2 x 11	75,18	50,0	160	40	39,0	72,60	130101012	509,75
BSP 2.3/4 x 11	81,53	50,0	160	40	39,0	79,00	130101013	851,08
BSP 3" x 11	87,88	50,0	160	40	39,0	85,50	130101014	991,73
BSP 3.1/2 x 11	100,3	56,0	180	45	44,0	98,00	130101015	1562,40
BSP 4" x 11	113,0	56,0	180	45	44,0	110,50	130101016	1950,32

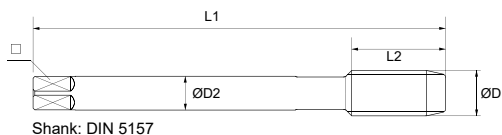
Hand Tap Sets

G-Rohr (BSP)

British standard whitworth pipe thread
DIN ISO 228

Efficient internal thread cutting.
The short structural type makes that tap usable by hand.

A Hand-Tap-Set includes 2 taps:
Taper Tap
Finish Tap



Hand Tap Sets for general use

through holes & blind holes up to 2 x D

Chip removal (like picture)

Form C straight flutes

material: HSSG medium to 900 N/mm² 27.1 HRC

2-3 threads outside cooling and lubrication

Hand Tap Sets for general use

through holes & blind holes up to 2 x D

Chip removal (like picture)

Form C straight flutes

material: HSSG medium to 900 N/mm² 27.1 HRC

2-3 threads outside cooling and lubrication

Left Hand for high tensile materials

through holes & blind holes up to 2 x D

Chip removal (like picture)

Form C straight flutes

material: HSSE medium bis 1200 N/mm² 38.2 HRC

2-3 threads outside cooling and lubrication



G(BSP)	D1	D2	L1	L2	□		No.	€	No.	€	No.	€
BSP 1/8 x 28	9,73	7,0	63	20	5,5	8,80	130301001	12,19	130302001	18,62	130304001	17,73
BSP 1/4 x 19	13,16	11,0	70	22	9,0	11,80	130301002	13,74	130302002	21,05	130304002	22,16
BSP 3/8 x 19	16,66	12,0	70	22	9,0	15,25	130301003	19,94	130302003	30,37	130304003	31,47
BSP 1/2 x 14	20,95	16,0	80	22	12,0	19,00	130301004	28,36	130302004	39,45	130304004	48,76
BSP 5/8 x 14	22,91	18,0	80	22	14,5	21,00	130301005	40,12	130302005	60,51		
BSP 3/4 x 14	26,44	20,0	90	22	16,0	24,50	130301006	40,12	130302006	60,51	130304005	59,17
BSP 7/8 x 14	30,20	22,0	90	22	18,0	28,25	130301007	67,60				
BSP 1" x 11	33,25	25,0	100	25	20,0	30,75	130301008	67,60	130302007	102,39	130304006	101,94
BSP 1.1/8 x 11	37,90	28,0	125	40	22,0	35,30	130301009	117,46	130302008	177,30		
BSP 1.1/4 x 11	41,91	32,0	125	40	24,0	39,50	130301010	117,46	130302009	177,30		
BSP 1.3/8 x 11	44,32	36,0	140	40	29,0	41,70	130301011	160,67	130302010	234,92		
BSP 1.1/2 x 11	47,80	36,0	140	40	29,0	45,25	130301012	160,67	130302011	234,92		
BSP 1.5/8 x 11	52,00	40,0	140	40	32,0	49,60	130301013	321,36				
BSP 1.3/4 x 11	53,74	40,0	140	40	32,0	51,20	130301014	321,35	130302012	483,13		
BSP 2" x 11	59,61	45,0	160	40	35,0	57,00	130301015	332,46	130302013	483,13		
BSP 2.1/4 x 11	65,71	50,0	160	40	39,0	63,10	130301016	726,96				
BSP 2.1/2 x 11	75,18	50,0	160	40	39,0	72,60	130301017	1019,50				
BSP 2.3/4 x 11	81,53	50,0	160	40	39,0	79,00	130301018	1702,15				
BSP 3" x 11	87,88	50,0	160	40	39,0	85,50	130301019	1983,46				
BSP 3.1/2 x 11	100,3	56,0	180	45	44,0	98,00	130301020	3124,80				
BSP 4" x 11	113,0	56,0	180	45	44,0	110,50	130301021	3900,62				

Machine Taps - Form B for through holes and Form C Left-hand thread

G-Rohr (BSP)

British standard whitworth pipe thread
DIN ISO 228

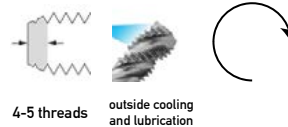
Tap for machine use in through hole and for left-hand thread in through and blind holes.
The spiral point pushes the chips ahead.

Machine Tap for general use



through holes up to 4 x D
Chip removal (like picture)
Form B with spiral point

TOL
material: HSSE
medium
N/mm² HRC
to 900 N/mm²
27,1 HRC



Machine Tap for stainless steels



through holes up to 2.5 x D
Chip removal (like picture)
Form B with spiral point

TOL
material: HSSE TiAIN
medium
N/mm² HRC
to 1300 N/mm²
41 HRC

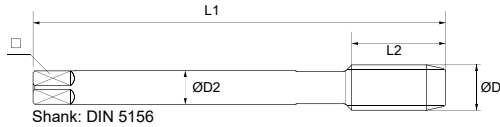


Machine Tap for general use Left-hand thread



through holes & blind holes up to 2 x D
Chip removal (like picture)
Form C straight flutes

TOL
material: HSSE
medium
N/mm² HRC
to 900 N/mm²
27,1 HRC



G(BSP)	D1	D2	L1	L2	□		No.	€	No.	€	No.	€
BSP 1/8 x 28	9,73	7,0	90	20	5,5	8,80	130401001	15,59	130405001	35,33	130502001	22,27
BSP 1/4 x 19	13,16	11,0	100	22	9,0	11,80	130401002	19,71	130405002	51,61	130502002	27,51
BSP 3/8 x 19	16,66	12,0	100	22	9,0	15,25	130401003	23,39	130405003	59,37	130502003	34,52
BSP 1/2 x 14	20,95	16,0	125	25	12,0	19,00	130401004	34,53	130405004	77,19	130502004	48,56
BSP 5/8 x 14	22,91	18,0	125	25	14,5	21,00	130401005	40,09	130405005	87,90	130502005	56,13
BSP 3/4 x 14	26,44	20,0	140	28	16,0	24,50	130401006	51,23	130405006	102,72	130502006	71,28
BSP 7/8 x 14	30,20	22,0	150	28	18,0	28,25	130401007	64,59	130405007	178,24		
BSP 1" x 11	33,25	25,0	160	30	20,0	30,75	130401008	80,19	130405008	219,88	130502007	71,84
BSP 1.1/8 x 11	37,90	28,0	170	30	22,0	35,30	130401009	118,06	130405009	274,46		
BSP 1.1/4 x 11	41,91	32,0	170	30	24,0	39,50	130401010	140,33	130405010	309,84		
BSP 1.3/8 x 11	44,32	36,0	180	32	29,0	41,70	130401011	186,00	130405011	377,44		
BSP 1.1/2 x 11	47,80	36,0	190	32	29,0	45,25	130401012	201,58	130405012	411,77		
BSP 1.3/4 x 11	53,74	40,0	190	32	32,0	51,20	130401013	291,79	130405013	529,78		
BSP 2" x 11	59,61	45,0	220	40	35,0	57,00	130401014	322,99	130405014	551,46		

Machine Taps - Form C (with spiral flutes) for blind holes

G-Rohr (BSP)

British standard whitworth pipe thread
DIN ISO 228

Machine Tap for general use



blind holes up to 3 x D
Chip removal (like picture)
Form C 35° spiral flute



material: HSSE
medium
to 900 N/mm²
27.1 HRC



2-3 threads
outside cooling and lubrication

Machine Tap for stainless steels



blind holes up to 2.5 x D
Chip removal (like picture)
Form C 40° spiral flute

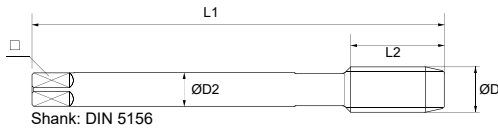


material: HSSE TiAlN
medium
to 1300 N/mm²
41 HRC



2-3 threads
outside cooling and lubrication

Tap for machine use in blind holes. The fast spiral flutes provide good chip removal from the blind hole.



G(BSP)	D1	D2	L1	L2	□		No.	€	No.	€
BSP 1/8 x 28	9,73	7,0	90	20	5,5	8,80	130601001	17,16	130605001	35,02
BSP 1/4 x 19	13,16	11,0	100	22	9,0	11,80	130601002	21,72	130605002	53,41
BSP 3/8 x 19	16,66	12,0	100	22	9,0	15,25	130601003	27,84	130605003	62,75
BSP 1/2 x 14	20,95	16,0	125	25	12,0	19,00	130601004	38,98	130605004	80,22
BSP 5/8 x 14	22,91	18,0	125	25	14,5	21,00	130601005	45,67	130605005	91,88
BSP 3/4 x 14	26,44	20,0	140	28	16,0	24,50	130601006	57,91	130605006	107,64
BSP 7/8 x 14	30,20	22,0	150	28	18,0	28,25	130601007	58,67	130605007	168,88
BSP 1" x 11	33,25	25,0	160	30	20,0	30,75	130601008	89,09	130605008	222,57
BSP 1.1/8 x 11	37,90	28,0	170	30	22,0	35,30	130601009	130,31	130605009	277,37
BSP 1.1/4 x 11	41,91	32,0	170	30	24,0	39,50	130601010	155,92	130605010	321,55
BSP 1.3/8 x 11	44,32	36,0	180	32	29,0	41,70	130601011	204,94	130605011	378,62
BSP 1.1/2 x 11	47,80	36,0	190	32	29,0	45,25	130601012	222,74	130605012	426,97
BSP 1.3/4 x 11	53,74	40,0	190	32	32,0	51,20	130601013	320,76	130605013	521,59
BSP 2" x 11	59,61	45,0	220	40	35,0	57,00	130601014	356,39	130605014	544,44

UNiForm Machine Forming Taps

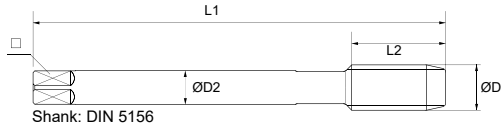
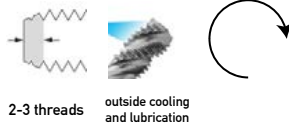
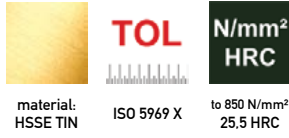
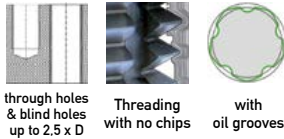
G-Rohr (BSP)

British standard whitworth pipe thread
DIN ISO 228

Machine Forming Taps have following advantages:

- No chips
- Up to 20 times longer lifetime (compared to taps)
- Same forming tap for through and blind hole
- Wide range of materials can be processed
- Intersection of the thread is impossible
- Very high trueness
- Increased strength of the thread
- Higher surface quality
- Much higher cutting speed

Machine Forming Taps for universal use



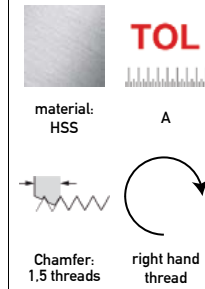
G(BSP)	D1	D2	L1	L2	□		No.	€
BSP 1/8 x 28	9,73	7,0	90	18	5,5	9,25	131101001	97,18
BSP 1/4 x 19	13,16	11,0	100	22	9,0	12,50	131101002	122,20
BSP 3/8 x 19	16,66	12,0	100	22	9,0	16,00	131101003	153,05
BSP 1/2 x 14	20,95	16,0	125	25	12,0	20,00	131101004	179,61
BSP 3/4 x 14	26,44	20,0	140	28	20,0	25,50	131101005	371,91

Round Dies

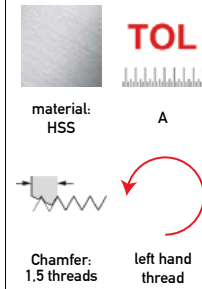
G-Rohr (BSP)

British standard whitworth pipe thread
DIN ISO 228

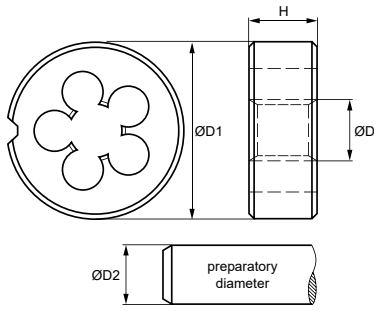
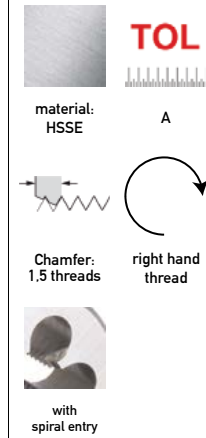
Round Dies
for general use



Round Dies
for general use
Left Hand



Round Dies
for stainless steels



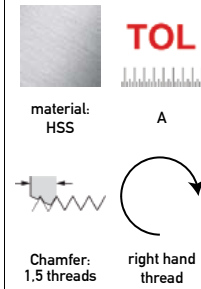
G(BSP)	D	D1	H	D2	No.	€	No.	€	No.	€
BSP 1/8 x 28	9,73	30	11	9,62	131401001	17,26	131402001	31,18	131405001	27,28
BSP 1/4 x 19	13,16	38	10	13,03	131401002	17,60	131402002	35,64	131405002	27,28
BSP 3/8 x 19	16,66	45	14	16,54	131401003	23,38	131402003	52,34	131405003	40,65
BSP 1/2 x 14	20,95	45	14	20,81	131401004	23,38	131402004	52,34	131405004	40,65
BSP 5/8 x 14	22,91	55	16	22,77	131401005	42,32	131402005	70,72		
BSP 3/4 x 14	26,44	55	16	26,30	131401006	42,32	131402006	87,98	131405005	74,63
BSP 7/8 x 14	30,20	65	18	30,06	131401007	56,80	131402007	96,89		
BSP 1" x 11	33,25	65	18	33,07	131401008	56,80	131402008	96,89	131405006	106,92
BSP 1.1/8 x 11	37,90	75	20	37,72	131401009	95,79	131402009	122,51		
BSP 1.1/4 x 11	41,91	75	20	41,73	131401010	95,79	131402010	122,51		
BSP 1.3/8 x 11	44,32	90	22	44,14	131401011	167,07	131402011	202,70		
BSP 1.1/2 x 11	47,80	90	22	47,62	131401012	167,07	131402012	202,70		
BSP 1.5/8 x 11	52,00	90	22	51,82	131401013	167,07	131402013	202,70		
BSP 1.3/4 x 11	53,74	105	22	53,57	131401014	286,24	131402014	347,49		
BSP 2" x 11	59,61	90	22	59,43	131401015	167,07	131402015	347,49		
BSP 2" x 11	59,61	105	22	59,43	131401016	286,24				
BSP 2.1/4 x 11	65,71	120	22	65,49	131401017	389,82				
BSP 2.1/2 x 11	75,18	120	22	74,97	131401018	521,24				
BSP 2.3/4 x 11	81,53	120	22	81,32	131401019	521,24				
BSP 3" x 11	87,88	130	25	87,67	131401020	576,91				
BSP 3.1/2 x 11	100,33	150	25	100,11	131401021	935,52				
BSP 4" x 11	113,03	160	25	112,81	131401022	1158,31				

Hexagon Die Nuts

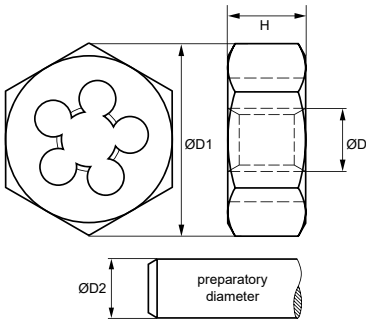
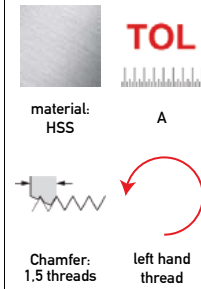
G-Rohr (BSP)

British standard whitworth pipe thread
DIN ISO 228

Hexagon Die Nuts for general use



Hexagon Die Nuts for general use Left Hand



G(BSP)

	D	D1	H	D2	No.	€	No.	€
BSP 1/8 x 28	9,73	27	11	9,62	131501001	19,95	131502001	34,52
BSP 1/4 x 19	13,16	36	10	13,03	131501002	23,82	131502002	38,98
BSP 3/8 x 19	16,66	41	14	16,54	131501003	35,46	131502003	58,48
BSP 1/2 x 14	20,95	41	14	20,81	131501004	35,46	131502004	58,48
BSP 5/8 x 14	22,91	50	16	22,77	131501005	59,28	131502005	77,96
BSP 3/4 x 14	26,44	50	16	26,30	131501006	59,28	131502006	77,96
BSP 7/8 x 14	30,20	60	18	30,06	131501007	80,34		
BSP 1" x 11	33,25	60	18	33,07	131501008	80,34	131502007	100,24
BSP 1.1/8 x 11	37,90	70	20	37,72	131501009	118,57	131502008	155,92
BSP 1.1/4 x 11	41,91	70	20	41,73	131501010	118,57	131502009	155,92
BSP 1.3/8 x 11	44,32	85	22	44,14	131501011	197,26	131502010	257,28
BSP 1.1/2 x 11	47,80	85	22	47,62	131501012	197,26	131502011	257,28
BSP 1.5/8 x 11	52,00	85	22	51,82	131501013	197,26		
BSP 1.3/4 x 11	53,74	100	22	53,57	131501014	295,88	131502012	386,46
BSP 2" x 11	59,61	100	22	59,43	131501015	295,88	131502013	386,46

M	MF	G (BSP)	UNC	UNF	UNS	UNEF	8 UN	12 UN	BSW	BSF	TR	NPT NPTF	NPS NPSM	RC RP	BA	W	PG	FG BSC	RD RMS	MINI	Camera (Tripod)	VG	Tools	Techn. Information
---	----	-------------------	-----	-----	-----	------	---------	----------	-----	-----	----	-------------	-------------	----------	----	---	----	-----------	-----------	------	--------------------	----	-------	-----------------------

Thread Cutting Kits with Taps, Dies and Tools

UNC

Unified coarse thread
ANSI B1.1

BAER Hand-Tap Sets, Round Dies and Tools Sets

(example picture)



BAER Set UNC 1/4" - 1/2" HSSG Hand Tap Sets & HSS Round Dies & Tools		€/Set
BAER HSSG Hand Tap Sets (3 parts)	UNC 1/4 x 20 UNC 5/16 x 18 UNC 3/8 x 16 UNC 7/16 x 14 UNC 1/2 x 13	276,00 € Item No.: 264805003
BAER HSS Round Dies	UNC 1/4 x 20 UNC 5/16 x 18 UNC 3/8 x 16 UNC 7/16 x 14 UNC 1/2 x 13	
BAER adjustable Tap Wrenches - zinc die cast	M 1-10 1/16-3/8 G 1/8 & M 4-12 5/32-1/2 G 1/8	
BAER Die Stocks - zinc die cast	20 x 7 25 x 9 30 x 11 38 x 14	
Screw extractor		

BAER Set UNC 1/4" - 3/4" HSSG Hand Tap Sets & HSS Round Dies & Tools		€/Set
BAER HSSG Hand Tap Sets (3 parts)	UNC 1/4 x 20 UNC 5/16 x 18 UNC 3/8 x 16 UNC 7/16 x 14 UNC 1/2 x 13 UNC 5/8 x 11 UNC 3/4 x 10	485,00 € Item No.: 264805103
BAER HSS Round Dies	UNC 1/4 x 20 UNC 5/16 x 18 UNC 3/8 x 16 UNC 7/16 x 14 UNC 1/2 x 13 UNC 5/8 x 11 UNC 3/4 x 10	
BAER adjustable Tap Wrenches - zinc die cast	M 1-10 1/16-3/8 G 1/8 & M 5-20 7/32-3/4" G 1/8-1/2	
BAER Die Stocks - zinc die cast	20 x 7 25 x 9 30 x 11 38 x 14 45 x 18	
Screw extractor		

BAER Set UNC 1/4" - 1" HSSG Hand Tap Sets & HSS Round Dies & Tools		€/Set
BAER HSSG Hand Tap Sets (3 parts)	UNC 1/4 x 20 UNC 5/16 x 18 UNC 3/8 x 16 UNC 7/16 x 14 UNC 1/2 x 13 UNC 5/8 x 11 UNC 3/4 x 10 UNC 7/8 x 9 UNC 1" x 8	725,00 € Item No.: 264805303
BAER HSS Round Dies	UNC 1/4 x 20 UNC 5/16 x 18 UNC 3/8 x 16 UNC 7/16 x 14 UNC 1/2 x 13 UNC 5/8 x 11 UNC 3/4 x 10 UNC 7/8 x 9 UNC 1" x 8	
BAER adjustable Tap Wrenches - zinc die cast	M 1-10 1/16-3/8 G 1/8 & M 11-27 7/16-1" G 1/4-3/4	
BAER Die Stocks - zinc die cast	20 x 7 25 x 9 30 x 11 38 x 14 45 x 18 55 x 22	
Screw extractor		

BAER Set UNC 1/4" - 1.1/2" HSSG Hand Tap Sets & HSS Round Dies & Tools		€/Set
BAER HSSG Hand Tap Sets (3 parts)	UNC 1/4 x 20 UNC 5/16 x 18 UNC 3/8 x 16 UNC 7/16 x 14 UNC 1/2 x 13 UNC 5/8 x 11 UNC 3/4 x 10 UNC 7/8 x 9 UNC 1" x 8 UNC 1.1/8" x 7 UNC 1.1/4" x 7 UNC 1.1/2" x 6	1836,00 € Item No.: 264805403
BAER HSS Round Dies	UNC 1/4 x 20 UNC 5/16 x 18 UNC 3/8 x 16 UNC 7/16 x 14 UNC 1/2 x 13 UNC 5/8 x 11 UNC 3/4 x 10 UNC 7/8 x 9 UNC 1" x 8 UNC 1.1/8" x 7 UNC 1.1/4" x 7 UNC 1.1/2" x 6	
BAER adjustable Tap Wrenches - zinc die cast	M 1-10 1/16-3/8 G 1/8 & M 5-20 7/32-3/4" G 1/8-1/2 & M 13-32 1/2 - 1.1/4" G 1/4-1"	
BAER Die Stocks - zinc die cast	20 x 7 25 x 9 30 x 11 38 x 14 45 x 18 55 x 22 65 x 25	
Screw extractor		

BAER Set UNC & UNF 1/4" - 3/4" HSSG Hand Tap Sets & HSS Round Dies & Tools		€/Set
BAER HSSG Hand Tap Sets (3 parts) UNC	UNC 1/4 UNC 5/16 UNC 3/8 UNC 7/16 UNC 1/2 UNC 5/8 UNC 3/4	777,00 € Item No.: 2648066203
BAER HSSG Hand Tap Sets (2 parts) UNF	UNF 1/4 UNF 5/16 UNF 3/8 UNF 7/16 UNF 1/2 UNF 5/8 UNF 3/4	
BAER HSS Round Dies UNC	UNC 1/4 UNC 5/16 UNC 3/8 UNC 7/16 UNC 1/2 UNC 5/8 UNC 3/4	
BAER HSS Round Dies UNF	UNF 1/4 UNF 5/16 UNF 3/8 UNF 7/16 UNF 1/2 UNF 5/8 UNF 3/4	
BAER adjustable Tap Wrenches - zinc die cast	M 1-10 1/16-3/8 G 1/8 & M 5-20 7/32-3/4" G 1/8-1/2	
BAER Die Stocks - zinc die cast	20 x 7 25 x 9 30 x 11 38 x 14 45 x 18	
Screw extractor		

Thread Cutting Kits with Taps and Dies

UNC Unified coarse thread
ANSI B1.1

BAER Short Machine Taps und Round Dies Sets UNC 1/4" - 1/2" (example picture)



BAER Set UNC 1/4" - 1/2"
HSSG Short Machine Taps & Drill bits for core holes
HSS Round Dies

BAER HSSG Short Machine Tap Form D for through hole & blind hole (up to 4 x D)	UNC 1/4 x 20 UNC 5/16 x 18 UNC 3/8 x 16 UNC 7/16 x 14 UNC 1/2 x 13	€/Set 168,21 €
BAER HSSG Drill bits for core holes	5,2 mm 6,6 mm 8,0 mm 9,4 mm 10,8 mm	
BAER HSS Round Dies	UNC 1/4 x 20 UNC 5/16 x 18 UNC 3/8 x 16 UNC 7/16 x 14 UNC 1/2 x 13	
		Item No.: BES2

Short Machine Taps and Hand Tap Sets

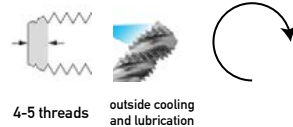
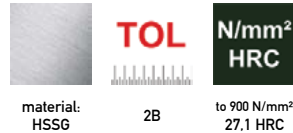
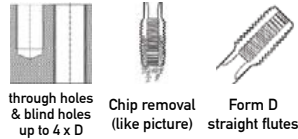
UNC Unified coarse thread ANSI B1.1

Efficient internal thread cutting. The short structural type makes that tap usable by hand. The Short-Machine-Tap is also usable by machine.

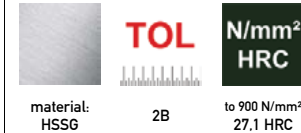
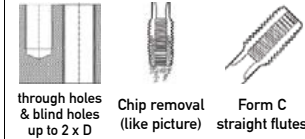
A Hand-Tap-Set includes 3 taps:
Taper Tap
Intermediate Tap
Finish Tap

Short Machine Taps

Form D for through holes and blind holes

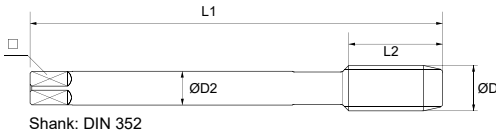
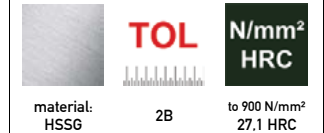
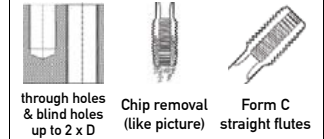


Hand Tap Sets for general use



Hand Tap Sets for general use

Left Hand



UNC	D1	D2	L1	L2	□		No.	€	No.	€	No.	€
UNC No 1 x 64	1,85	2,5	32	10	2,1	1,50			140301001	19,95		
UNC No 2 x 56	2,18	2,8	36	11	2,1	1,80			140301002	19,95		
UNC No 3 x 48	2,52	2,8	36	11	2,1	2,10			140301003	19,95		
UNC No 4 x 40	2,85	3,5	40	12	2,7	2,30			140301004	16,65		
UNC No 5 x 40	3,18	3,5	40	12	2,7	2,60			140301005	14,00		
UNC No 6 x 32	3,51	4,0	45	14	3,0	2,85			140301006	14,00	140302001	36,42
UNC No 8 x 32	4,17	4,5	45	14	3,4	3,50			140301007	14,00	140302002	36,42
UNC No 10 x 24	4,83	6,0	50	16	4,9	3,90			140301008	14,00	140302003	36,42
UNC No 12 x 24	5,49	6,0	50	18	4,9	4,50			140301009	14,00	140302004	36,42
UNC 1/4 x 20	6,35	6,0	50	19	4,9	5,20	140101001	4,67	140301010	14,00	140302005	23,06
UNC 5/16 x 18	7,94	6,0	56	22	4,9	6,60	140101002	5,24	140301011	15,60	140302006	24,06
UNC 3/8 x 16	9,53	7,0	70	24	5,5	8,00	140101003	5,79	140301012	17,30	140302007	28,07
UNC 7/16 x 14	11,11	8,0	70	24	6,2	9,40	140101004	7,35	140301013	21,95	140302008	34,42
UNC 1/2 x 13	12,70	9,0	75	29	7,0	10,80	140101005	8,91	140301014	26,60	140302009	41,10
UNC 9/16 x 12	14,29	11,0	80	30	9,0	12,20	140101006	11,69	140301015	34,90	140302010	53,46
UNC 5/8 x 11	15,88	12,0	80	32	9,0	13,50	140101007	13,14	140301016	39,23	140302011	60,81
UNC 3/4 x 10	19,05	14,0	95	40	11,0	16,50	140101008	17,60	140301017	52,53	140302012	81,19
UNC 7/8 x 9	22,23	18,0	100	40	14,5	19,50	140101009	23,39	140301018	69,81	140302013	101,24
UNC 1" x 8	25,40	18,0	110	50	14,5	22,25	140101010	26,95	140301019	80,46	140302014	121,62
UNC 1.1/8 x 7	28,58	22,0	132	56	18,0	25,00			140301020	124,00		
UNC 1.1/4 x 7	31,75	22,0	132	56	18,0	28,25			140301021	139,63		
UNC 1.3/8 x 6	34,93	28,0	150	63	22,0	30,75			140301022	181,51		
UNC 1.1/2 x 6	38,10	32,0	150	63	24,0	34,00			140301023	209,43		
UNC 1.5/8 x 5	41,28	32,0	160	70	24,0	37,10			140301024	418,88		
UNC 1.3/4 x 5	44,45	36,0	160	70	29,0	39,50			140301025	418,88		
UNC 1.7/8 x 4,5	47,63	36,0	190	80	29,0	42,00			140301026	545,21		
UNC 2" x 4,5	50,80	40,0	190	80	32,0	45,00			140301027	545,21		
UNC 2.1/4 x 4,5	57,15	45,0	220	80	35,0	51,50			140301028	1357,20		
UNC 2.1/2 x 4	63,50	50,0	220	80	39,0	57,25			140301029	1809,57		
UNC 2.3/4 x 4	69,85	50,0	240	80	39,0	63,50			140301030	4524,11		
UNC 3" x 4	73,20	50,0	260	80	39,0	70,00			140301031	5567,83		

Machine Taps - Form B for through holes

UNC

Unified coarse thread
ANSI B1.1

Machine Tap for general use



through holes up to 4 x D
Chip removal (like picture)
Form B with spiral point



material: HSSE 2B to 900 N/mm² 27.1 HRC



4-5 threads outside cooling and lubrication

Machine Tap for stainless steels



through holes up to 2.5 x D
Chip removal (like picture)
Form B with spiral point

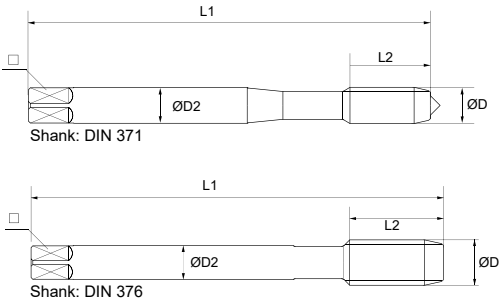


material: HSSE-TiAlN 2B to 1300 N/mm² 41 HRC



4-5 threads outside cooling and lubrication

Tap for machine use in through hole.
The spiral point pushes the chips ahead.



UNC

D1 D2 L1 L2 □

No. € No. €

UNC	D1	D2	L1	L2	□	No.	€	No.	€	
DIN 371										
UNC No 2 x 56	2,18	2,8	45	8	2,1	1,85		140405001	57,75	
UNC No 3 x 48	2,52	2,8	50	9	2,1	2,10		140405002	55,00	
UNC No 4 x 40	2,85	3,5	50	10	2,7	2,30	140401001	9,58	140405003	35,52
UNC No 5 x 40	3,18	3,5	56	11	2,7	2,60	140401002	9,58	140405004	29,46
UNC No 6 x 32	3,51	4,0	56	12	3,0	2,85	140401003	9,58	140405005	29,46
UNC No 8 x 32	4,17	4,5	63	13	3,4	3,50	140401004	9,58	140405006	29,46
UNC No 10 x 24	4,83	6,0	70	15	4,9	3,90	140401005	9,58	140405007	30,24
UNC No 12 x 24	5,49	6,0	70	16	4,9	4,50	140401006	9,58	140405008	30,24
UNC 1/4 x 20	6,35	7,0	80	17	5,5	5,20	140401007	9,58	140405009	30,24
UNC 5/16 x 18	7,94	8,0	90	20	6,2	6,60	140401008	12,14		
UNC 3/8 x 16	9,53	9,0	100	22	7,0	8,00	140401009	13,58		
DIN 376										
UNC No 4 x 40	2,85	1,8	50	10	-	2,30	140401010	9,58		
UNC No 5 x 40	3,18	2,2	56	11	1,8	2,60	140401011	9,58		
UNC No 6 x 32	3,51	2,5	56	12	2,1	2,85	140401012	9,58		
UNC No 8 x 32	4,17	2,8	63	13	2,1	3,50	140401013	9,58		
UNC No 10 x 24	4,83	3,5	70	15	2,7	3,90	140401014	9,58		
UNC No 12 x 24	5,49	3,5	70	16	2,7	4,50	140401015	9,58		
UNC 1/4 x 20	6,35	4,5	80	17	3,4	5,20	140401016	9,58		
UNC 5/16 x 18	7,94	6,0	90	20	4,9	6,60	140401017	12,14	140405010	37,66
UNC 3/8 x 16	9,53	7,0	100	22	5,5	8,00	140401018	13,58	140405011	44,23
UNC 7/16 x 14	11,11	8,0	100	22	6,2	9,40	140401019	16,15	140405012	57,75
UNC 1/2 x 13	12,70	9,0	110	25	7,0	10,80	140401020	16,15	140405013	57,75
UNC 9/16 x 12	14,29	11,0	110	26	9,0	12,20	140401021	24,62	140405014	75,62
UNC 5/8 x 11	15,88	12,0	110	27	9,0	13,50	140401022	24,62	140405015	84,95
UNC 3/4 x 10	19,05	14,0	125	30	11,0	16,50	140401023	47,89	140405016	145,46
UNC 7/8 x 9	22,23	18,0	140	32	14,5	19,50	140401024	57,92	140405017	179,12
UNC 1" x 8	25,40	20,0	160	36	16,0	22,25	140401025	65,71	140405018	235,84
UNC 1.1/4 x 7	31,75	22,0	180	40	18,0	28,25	140401026	91,88		
UNC 1.1/2 x 6	38,10	32,0	200	50	24,0	34,00	140401027	191,56		
UNC 1.3/4 x 5	44,45	36,0	220	65	29,0	39,50	140401028	328,57		
UNC 2" x 4,5	50,80	40,0	250	70	32,0	45,00	140401029	474,47		

Machine Taps - Form C (with spiral flutes) for blind holes

UNC Unified coarse thread ANSI B1.1

Machine Tap for general use



blind holes up to 3 x D
Chip removal (like picture)
Form C 35° spiral flute



material: HSSE 2B to 900 N/mm² 27,1 HRC



2-3 threads outside cooling and lubrication

Machine Tap for stainless steels



blind holes up to 2.5 x D
Chip removal (like picture)
Form C 40° spiral flute

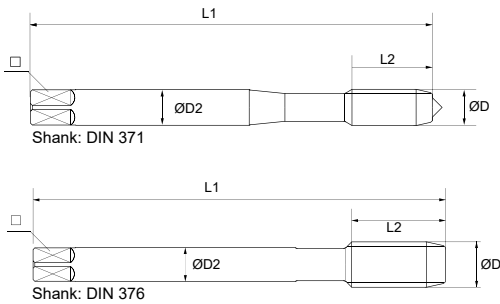


material: HSSE-TiAlN 2B to 1300 N/mm² 41 HRC



2-3 threads outside cooling and lubrication

Tap for machine use in blind holes.
The fast spiral flutes provide good chip removal from the blind hole.



UNC

	D1	D2	L1	L2	□		No.	€	No.	€
DIN 371										
UNC No 2 x 56	2,18	2,8	45	6	2,1	1,85			140605001	62,69
UNC No 3 x 48	2,52	2,8	50	7	2,1	2,10			140605002	56,49
UNC No 4 x 40	2,85	3,5	50	6	2,7	2,30	140601001	11,92	140605003	37,88
UNC No 5 x 40	3,18	3,5	56	7	2,7	2,60	140601002	11,92	140605004	31,83
UNC No 6 x 32	3,51	4,0	56	7	3,0	2,85	140601003	11,92	140605005	31,83
UNC No 8 x 32	4,17	4,5	63	8	3,4	3,50	140601004	11,92	140605006	31,83
UNC No 10 x 24	4,83	6,0	70	10	4,9	3,90	140601005	11,92	140605007	32,60
UNC No 12 x 24	5,49	6,0	70	10	4,9	4,50	140601006	11,92	140605008	32,60
UNC 1/4 x 20	6,35	7,0	80	13	5,5	5,20	140601007	11,92	140605009	32,60
UNC 5/16 x 18	7,94	8,0	90	14	6,2	6,60	140601008	14,93		
UNC 3/8 x 16	9,53	9,0	100	16	7,0	8,00	140601009	16,37		
DIN 376										
UNC No 4 x 40	2,85	1,8	50	10	-	2,30	140601010	11,92		
UNC No 5 x 40	3,18	2,2	56	11	1,8	2,60	140601011	11,92		
UNC No 6 x 32	3,51	2,5	56	12	2,1	2,85	140601012	11,92		
UNC No 8 x 32	4,17	2,8	63	13	2,1	3,50	140601013	11,92		
UNC No 10 x 24	4,83	3,5	70	15	2,7	3,90	140601014	11,92		
UNC No 12 x 24	5,49	3,5	70	16	2,7	4,50	140601015	11,92		
UNC 1/4 x 20	6,35	4,5	80	17	3,4	5,20	140601016	11,92		
UNC 5/16 x 18	7,94	6,0	90	20	4,9	6,60	140601017	14,93	140605010	40,03
UNC 3/8 x 16	9,53	7,0	100	22	5,5	8,00	140601018	16,37	140605011	46,59
UNC 7/16 x 14	11,11	8,0	100	22	6,2	9,40	140601019	20,16	140605012	60,11
UNC 1/2 x 13	12,70	9,0	110	25	7,0	10,80	140601020	20,16	140605013	60,11
UNC 9/16 x 12	14,29	11,0	110	26	9,0	12,20	140601021	29,73	140605014	77,98
UNC 5/8 x 11	15,88	12,0	110	27	9,0	13,50	140601022	29,73	140605015	87,31
UNC 3/4 x 10	19,05	14,0	125	30	11,0	16,50	140601023	59,26	140605016	147,82
UNC 7/8 x 9	22,23	18,0	140	32	14,5	19,50	140601024	72,39	140605017	181,48
UNC 1" x 8	25,40	20,0	160	36	16,0	22,25	140601025	81,31	140605018	238,20
UNC 1.1/4 x 7	31,75	22,0	180	40	18,0	28,25	140601026	103,58		
UNC 1.1/2 x 6	38,10	32,0	200	50	24,0	34,00	140601027	226,09		
UNC 1.3/4 x 5	44,45	36,0	220	65	29,0	39,50	140601028	356,40		
UNC 2" x 4,5	50,80	40,0	250	70	32,0	45,00	140601029	505,64		

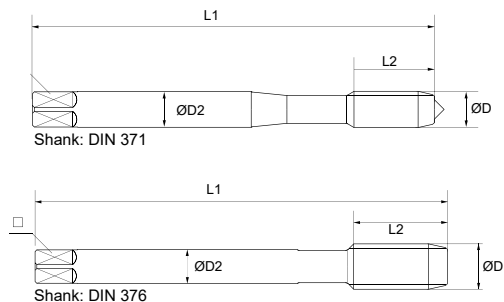
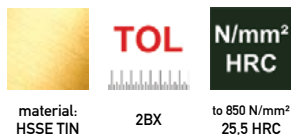
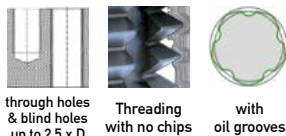
UNiForm Machine Forming Taps

UNC Unified coarse thread ANSI B1.1

Machine Forming Taps have following advantages:

- No chips
- Up to 20 times longer lifetime (compared to taps)
- Same forming tap for through and blind hole
- Wide range of materials can be processed
- Intersection of the thread is impossible
- Very high trueness
- Increased strength of the thread
- Higher surface quality
- Much higher cutting speed

Machine Forming Taps for universal use



UNC

UNC	D1	D2	L1	L2	□		No.	€
UNC No 4 x 40	2,85	3,5	56	11	2,7	2,55	141101001	*
UNC No 5 x 40	3,18	3,5	56	10	2,7	2,65	141101002	*
UNC No 6 x 32	3,51	4,0	56	12	3,0	3,15	141101003	*
UNC No 8 x 32	4,17	4,5	63	13	3,4	3,80	141101004	*
UNC No 10 x 24	4,83	6,0	70	15	4,9	4,35	141101005	*
UNC No 12 x 24	5,49	6,0	80	16	4,9	5,00	141101006	*
UNC 1/4 x 20	6,35	7,0	80	17	5,5	5,75	141101007	*
UNC 5/16 x 18	7,94	8,0	90	20	6,2	7,30	141101008	*
UNC 3/8 x 16	9,53	10,0	100	22	8,0	8,80	141101009	*
UNC 7/16 x 14	11,11	8,0	100	22	6,2	10,25	141101010	*
UNC 1/2 x 13	12,70	9,0	110	25	7,0	11,80	141101011	*
UNC 9/16 x 12	14,29	11,0	110	26	9,0	13,30	141101012	*
UNC 5/8 x 11	15,88	12,0	110	27	9,0	14,80	141101013	*
UNC 3/4 x 10	19,05	14,0	125	30	11,0	17,85	141101014	*

* on request

1/4" Combined-Bit-Taps

UNC

Unified coarse thread
ANSI B1.1

Efficient internal thread cutting with battery-powered screwdriver (min. 7,5 Volt). Core hole drilling and thread tapping in one fluent process.

Application:
non abrasive material up to 600 N/mm²
unalloyed and low alloyed steel

Kombi-Bit-Taps for through holes



through holes
up to 1 x D



Chip removal
(like picture)



Combined
form



material:
HSSG



2B



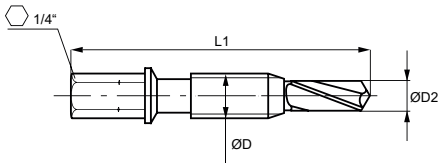
to 600 N/mm²



4-5 threads



outside cooling
and lubrication



UNC

UNC	D1	D2	L1	Hex	No.	€
UNC No 4 x 40	2,85	2,3	36	1/4"	141301001	*
UNC No 5 x 40	3,18	2,6	36	1/4"	141301002	*
UNC No 6 x 32	3,51	2,9	39	1/4"	141301003	*
UNC No 8 x 32	4,17	3,5	39	1/4"	141301004	*
UNC No 10 x 24	4,83	3,9	41	1/4"	141301005	*
UNC No 12 x 24	5,49	4,5	41	1/4"	141301006	*
UNC 1/4 x 20	6,35	5,2	44	1/4"	141301007	*
UNC 5/16 x 18	7,94	6,6	50	1/4"	141301008	*
UNC 3/8 x 16	9,53	8,0	59	1/4"	141301009	*

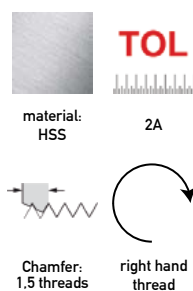
* on request

Round Dies

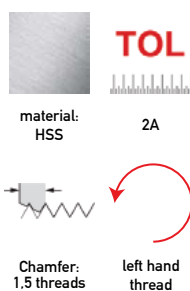
UNC

Unified coarse thread
ANSI B1.1

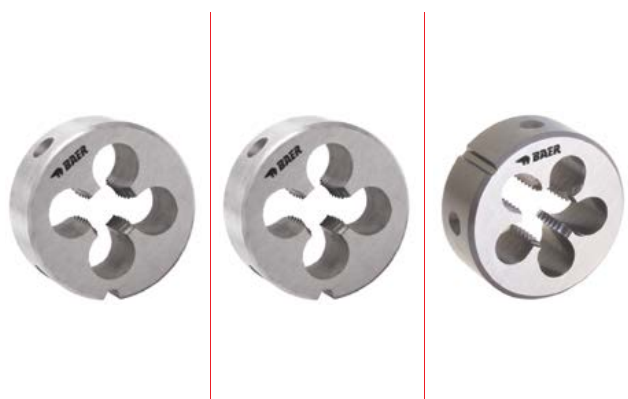
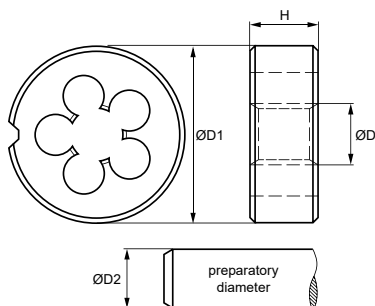
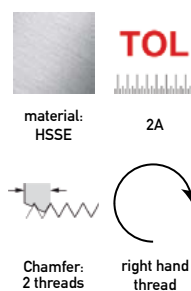
Round Dies
for general use



Round Dies
for general use
Left Hand



Round Dies
for stainless steels



UNC

	D	D1	H	D2	No.	€	No.	€	No.	€
UNC No 1 x 64	1,85	16	5	1,79	141401001	15,95				
UNC No 2 x 56	2,18	16	5	2,12	141401002	15,95				
UNC No 3 x 48	2,52	16	5	2,44	141401003	15,95				
UNC No 4 x 40	2,85	20	5	2,76	141401004	13,10			141405001	106,22
UNC No 5 x 40	3,18	20	5	3,09	141401005	12,30				
UNC No 6 x 32	3,51	20	7	3,41	141401006	12,30	141402001	22,27	141405002	90,45
UNC No 8 x 32	4,17	20	7	4,07	141401007	12,30	141402002	22,27	141405003	81,75
UNC No 10 x 24	4,83	20	7	4,71	141401008	12,30	141402003	22,27		
UNC No 12 x 24	5,49	20	7	5,37	141401009	12,30				
UNC 1/4 x 20	6,35	20	7	6,22	141401010	11,70	141402004	18,04	141405004	75,32
UNC 5/16 x 18	7,94	25	9	7,80	141401011	13,36	141402005	21,05	141405005	107,18
UNC 3/8 x 16	9,53	30	11	9,37	141401012	14,82	141402006	25,62	141405006	112,98
UNC 7/16 x 14	11,11	30	11	10,95	141401013	17,15	141402007	25,62		
UNC 1/2 x 13	12,70	38	14	12,52	141401014	19,27	141402008	40,09		
UNC 9/16 x 12	14,29	38	14	14,10	141401015	23,84	141402009	40,09		
UNC 5/8 x 11	15,88	45	18	15,68	141401016	26,06	141402010	51,24		
UNC 3/4 x 10	19,05	45	18	18,84	141401017	26,06	141402011	51,24		
UNC 7/8 x 9	22,23	55	22	22,00	141401018	44,54	141402012	74,62		
UNC 1" x 8	25,40	55	22	25,16	141401019	44,54	141402013	74,62		
UNC 1.1/8 x 7	28,58	65	25	28,31	141401020	67,39				
UNC 1.1/4 x 7	31,75	65	25	31,49	141401021	67,39				
UNC 1.3/8 x 6	34,93	65	25	34,63	141401022	67,39				
UNC 1.1/2 x 6	38,10	65	25	37,80	141401023	67,39				
UNC 1.1/2 x 6	38,10	75	30	37,80	141401024	120,29				
UNC 1.5/8 x 5	41,28	75	30	40,95	141401025	120,29				
UNC 1.3/4 x 5	44,45	90	36	44,12	141401026	183,77				
UNC 1.7/8 x 4,5	47,63	90	36	47,30	141401027	183,77				
UNC 2" x 4,5	50,80	90	36	50,45	141401028	183,77				

Hexagon Die Nuts

UNC

Unified coarse thread
ANSI B1.1

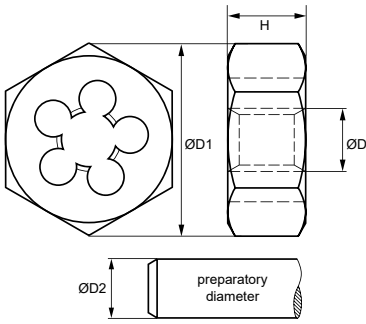
Hexagon Die Nuts
for general use



material: HSS 2A



Chamfer: 1.5 threads right hand thread



UNC

	D	D1	H	D2	No.	€
UNC 1/4 x 20	6,35	19	7	6,22	141501001	14,48
UNC 5/16 x 18	7,94	22	9	7,80	141501002	15,03
UNC 3/8 x 16	9,53	27	11	9,37	141501003	18,16
UNC 7/16 x 14	11,11	27	11	10,95	141501004	18,16
UNC 1/2 x 13	12,70	36	14	12,52	141501005	22,27
UNC 9/16 x 12	14,29	36	14	14,10	141501006	22,27
UNC 5/8 x 11	15,88	41	18	15,68	141501007	30,41
UNC 3/4 x 10	19,05	41	18	18,84	141501008	30,41
UNC 7/8 x 9	22,23	50	22	22,00	141501009	63,16
UNC 1" x 8	25,40	50	22	25,16	141501010	63,16
UNC 1.1/8 x 7	28,58	60	25	28,31	141501011	95,79
UNC 1.1/4 x 7	31,75	60	25	31,49	141501012	95,79
UNC 1.3/8 x 6	34,93	60	25	34,63	141501013	95,79
UNC 1.1/2 x 6	38,10	70	30	37,80	141501014	101,83

M	MF	G (BSP)	UNC	UNF	UNS	UNEF	8 UN	12 UN	BSW	BSF	TR	NPT NPTF	NPS NPSM	RC RP	BA	W	PG	FG BSC	RD RMS	MINI	Camera (Tripod)	VG	Tools	Techn. Information
---	----	------------	------------	-----	-----	------	---------	----------	-----	-----	----	-------------	-------------	----------	----	---	----	-----------	-----------	------	--------------------	----	-------	-----------------------

Thread Cutting Kits with Taps, Dies and Tools

UNF

Unified fine thread
ANSI B1.1

BAER Hand-Tap Sets, Round Dies and Tools Sets

(example picture)



BAER Set UNF 1/4" - 1/2" HSSG Hand Tap Sets & HSS Round Dies & Tools		€/Set
BAER HSSG Hand Tap Sets (2 parts)	UNF 1/4 x 28 UNF 5/16 x 24 UNF 3/8 x 24 UNF 7/16 x 20 UNF 1/2 x 20	255,00 € Item No.: 264806004
BAER HSS Round Dies	UNF 1/4 x 28 UNF 5/16 x 24 UNF 3/8 x 24 UNF 7/16 x 20 UNF 1/2 x 20	
BAER adjustable Tap Wrenches - zinc die cast	M 1-10 1/16-3/8 G 1/8 & M 4-12 5/32-1/2 G 1/8	
BAER Die Stocks - zinc die cast	20 x 7 25 x 9 30 x 11 38 x 10	
Screw extractor		

BAER Set UNF 1/4" - 3/4" HSSG Hand Tap Sets & HSS Round Dies & Tools		€/Set
BAER HSSG Hand Tap Sets (2 parts)	UNF 1/4 x 28 UNF 5/16 x 24 UNF 3/8 x 24 UNF 7/16 x 20 UNF 1/2 x 20 UNF 5/8 x 18 UNF 3/4 x 16	427,00 € Item No.: 264806104
BAER HSS Round Dies	UNF 1/4 x 28 UNF 5/16 x 24 UNF 3/8 x 24 UNF 7/16 x 20 UNF 1/2 x 20 UNF 5/8 x 18 UNF 3/4 x 16	
BAER adjustable Tap Wrenches - zinc die cast	M 1-10 1/16-3/8 G 1/8 & M 5-20 7/32-3/4" G 1/8-1/2	
BAER Die Stocks - zinc die cast	20 x 7 25 x 9 30 x 11 38 x 10 45 x 14	
Screw extractor		

BAER Set UNF 1/4" - 1" HSSG Hand Tap Sets & HSS Round Dies & Tools		€/Set
BAER HSSG Hand Tap Sets (2 parts)	UNF 1/4 x 28 UNF 5/16 x 24 UNF 3/8 x 24 UNF 7/16 x 20 UNF 1/2 x 20 UNF 5/8 x 18 UNF 3/4 x 16 UNF 7/8 x 14	644,00 € Item No.: 264806304
BAER HSS Round Dies	UNF 1/4 x 28 UNF 5/16 x 24 UNF 3/8 x 24 UNF 7/16 x 20 UNF 1/2 x 20 UNF 5/8 x 18 UNF 3/4 x 16 UNF 7/8 x 14	
BAER adjustable Tap Wrenches - zinc die cast	M 1-10 1/16-3/8 G 1/8 & M 11-27 7/16-1" G 1/4-3/4	
BAER Die Stocks - zinc die cast	20 x 7 25 x 9 30 x 11 38 x 10 45 x 14 55 x 16	
Screw extractor		

BAER Set UNC & UNF 1/4" - 3/4" HSSG Hand Tap Sets & HSS Round Dies & Tools		€/Set
BAER HSSG Hand Tap Sets (3 parts) UNC	UNC 1/4 UNC 5/16 UNC 3/8 UNC 7/16 UNC 1/2 UNC 5/8 UNC 3/4	777,00 € Item No.: 264806203
BAER HSSG Hand Tap Sets (2 parts) UNF	UNF 1/4 UNF 5/16 UNF 3/8 UNF 7/16 UNF 1/2 UNF 5/8 UNF 3/4	
BAER HSS Round Dies UNC	UNC 1/4 UNC 5/16 UNC 3/8 UNC 7/16 UNC 1/2 UNC 5/8 UNC 3/4	
BAER HSS Round Dies UNF	UNF 1/4 UNF 5/16 UNF 3/8 UNF 7/16 UNF 1/2 UNF 5/8 UNF 3/4	
BAER adjustable Tap Wrenches - zinc die cast	M 1-10 1/16-3/8 G 1/8 & M 5-20 7/32-3/4" G 1/8-1/2	
BAER Die Stocks - zinc die cast	20 x 7 25 x 9 30 x 11 38 x 14 45 x 18	
Screw extractor		

Thread Cutting Kits with Taps and Dies

UNF

Unified fine thread
ANSI B1.1

BAER Short Machine Taps und Round Dies Sets UNF 1/4" - 1/2" (example picture)



BAER Set UNF 1/4" - 1/2"

HSSG Short Machine Taps & Drill bits for core holes

HSS Round Dies

BAER HSSG Short Machine Tap Form D for through hole & blind hole (up to 4 x D)

BAER HSSG Drill bits for core holes

BAER HSS Round Dies

UNF 1/4 x 28 | UNF 5/16 x 24 | UNF 3/8 x 24 | UNF 7/16 x 20 | UNF 1/2 x 20
5,5 mm | 6,9 mm | 8,5 mm | 9,9 mm | 11,5 mm
UNF 1/4 x 28 | UNF 5/16 x 24 | UNF 3/8 x 24 | UNF 7/16 x 20 | UNF 1/2 x 20

€/Set

172,73 €

Item No.:
BES3

Short Machine Taps and Hand Tap Sets

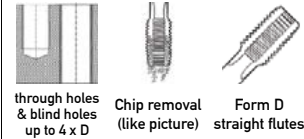
UNF Unified fine thread ANSI B1.1

Efficient internal thread cutting.
The short structural type makes that tap usable by hand. The Short-Machine-Tap is also usable by machine.

A Hand-Tap-Set includes 2 taps:
Taper Tap
Finish Tap

Short Machine Taps

Form D for through holes and blind holes



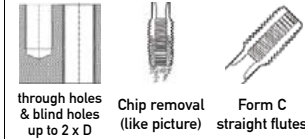
material: HSSG 2B to 900 N/mm² 27.1 HRC

TOL **N/mm² HRC**



Hand Tap Sets

for general use



material: HSSG 2B to 900 N/mm² 27.1 HRC

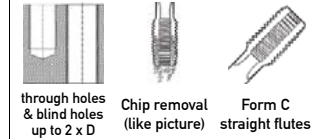
TOL **N/mm² HRC**



Hand Tap Sets

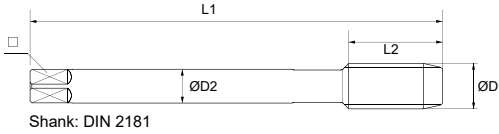
for general use

Left Hand



material: HSSG 2B to 900 N/mm² 27.1 HRC

TOL **N/mm² HRC**



UNF	D1	D2	L1	L2	□		No.	€	No.	€	No.	€
UNF No 0 x 80	1,52	2,5	28	8	2,1	1,30			150301001	13,36		
UNF No 1 x 72	1,85	2,8	32	9	2,1	1,60			150301002	13,36		
UNF No 2 x 64	2,18	2,8	32	10	2,1	1,90			150301003	13,36		
UNF No 3 x 56	2,52	2,8	32	10	2,1	2,10			150301004	13,36		
UNF No 4 x 48	2,85	3,5	36	11	2,7	2,40			150301005	11,14		
UNF No 5 x 44	3,18	3,5	36	11	2,7	2,70			150301006	9,35		
UNF No 6 x 40	3,51	4,5	40	12	3,4	3,00			150301007	9,35		
UNF No 8 x 36	4,17	4,5	40	12	3,4	3,50			150301008	9,35		
UNF No 10 x 32	4,83	6,0	45	14	4,9	4,10			150301009	9,35	150302001	24,28
UNF No 12 x 28	5,49	6,0	50	14	4,9	4,70			150301010	9,35		
UNF 1/4 x 28	6,35	6,0	50	18	4,9	5,50	150101001	4,67	150301011	9,36	150302002	15,37
UNF 5/16 x 24	7,94	6,0	56	22	4,9	6,90	150101002	5,24	150301012	10,47	150302003	16,04
UNF 3/8 x 24	9,53	7,0	63	22	5,5	8,50	150101003	5,79	150301013	11,58	150302004	18,71
UNF 7/16 x 20	11,11	8,0	63	22	6,2	9,90	150101004	7,35	150301014	14,70	150302005	22,94
UNF 1/2 x 20	12,70	9,0	75	24	7,0	11,50	150101005	8,91	150301015	17,82	150302006	27,40
UNF 9/16 x 18	14,29	11,0	80	28	9,0	12,90	150101006	11,69	150301016	23,39	150302007	35,64
UNF 5/8 x 18	15,88	12,0	80	28	9,0	14,50	150101007	13,14	150301017	26,29	150302008	40,54
UNF 3/4 x 16	19,05	14,0	95	32	11,0	17,50	150101008	17,60	150301018	35,19	150302009	54,13
UNF 7/8 x 14	22,23	18,0	100	36	14,5	20,25	150101009	23,39	150301019	46,78	150302010	67,50
UNF 1" x 12	25,40	18,0	110	40	14,5	23,25	150101010	26,95	150301020	53,91	150302011	81,08
UNF 1" x 14	25,40	18,0	110	40	14,5	23,30			150301021	58,37		
UNF 1.1/8 x 12	28,58	22,0	110	50	18,0	26,50			150301022	83,09		
UNF 1.1/4 x 12	31,75	22,0	132	56	18,0	29,50			150301023	93,56		
UNF 1.3/8 x 12	34,93	28,0	132	56	22,0	32,50			150301024	121,62		
UNF 1.1/2 x 12	38,10	32,0	150	63	24,0	36,00			150301025	140,33		

Machine Taps - Form B for through holes

UNF Unified fine thread ANSI B1.1

Machine Tap for general use



through holes up to 4 x D
Chip removal (like picture)
Form B with spiral point



material: HSSE 2B to 900 N/mm² 27,1 HRC



4-5 threads outside cooling and lubrication

Machine Tap for stainless steels



through holes up to 2.5 x D
Chip removal (like picture)
Form B with spiral point

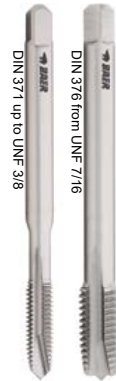
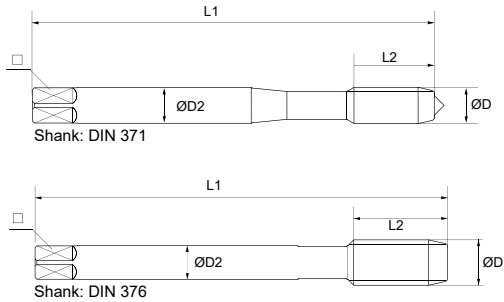


material: HSSE-TIAIN 2B to 1300 N/mm² 41 HRC



4-5 threads outside cooling and lubrication

Tap for machine use in through hole.
The spiral point pushes the chips ahead.



UNF

	D1	D2	L1	L2	□		No.	€	No.	€
UNF No 3 x 56	2,52	2,8	50	9	2,1	2,10			150405001	47,78
UNF No 4 x 48	2,85	3,5	50	10	2,7	2,40	150401001	9,58	150405002	46,75
UNF No 5 x 44	3,18	3,5	56	11	2,7	2,70	150401002	9,58	150405003	49,22
UNF No 6 x 40	3,51	4,0	56	12	3,0	3,00	150401003	9,58	150405004	49,22
UNF No 8 x 36	4,17	4,5	63	13	3,4	3,50	150401004	9,58	150405005	50,26
UNF No 10 x 32	4,83	6,0	70	15	4,9	4,10	150401005	9,58	150405006	56,88
UNF No 12 x 28	5,49	6,0	70	16	4,9	4,70	150401006	9,58	150405007	50,07
UNF 1/4 x 28	6,35	7,0	80	17	5,5	5,50	150401007	9,58	150405008	50,07
UNF 5/16 x 24	7,94	8,0	90	17	6,2	6,90	150401008	12,14	150405009	54,30
UNF 3/8 x 24	9,53	9,0	100	18	7,0	8,50	150401009	13,58	150405010	62,57
UNF 7/16 x 20	11,11	8,0	100	22	6,2	9,90	150401010	16,15	150405011	75,00
UNF 1/2 x 20	12,70	9,0	100	22	7,0	11,50	150401011	16,15	150405012	75,00
UNF 9/16 x 18	14,29	11,0	100	22	9,0	12,90	150401012	24,62	150405013	83,63
UNF 5/8 x 18	15,88	12,0	100	22	9,0	14,50	150401013	24,62	150405014	104,94
UNF 3/4 x 16	19,05	14,0	110	25	11,0	17,50	150401014	47,89	150405015	148,64
UNF 7/8 x 14	22,23	18,0	140	26	14,5	20,25	150401015	57,92	150405016	170,80
UNF 1" x 12	25,40	20,0	150	28	16,0	23,25	150401016	65,71	150405017	217,79
UNF 1" x 14	25,40	20,0	150	28	16,0	23,30	150401017	65,71		
UNF 1.1/4 x 12	31,75	22,0	150	30	18,0	29,50	150401018	91,88		
UNF 1.1/2 x 12	38,10	32,0	170	33	24,0	36,00	150401019	191,56		

Machine Taps - Form C (with spiral flutes) for blind holes

UNF Unified fine thread ANSI B1.1

Machine Tap for general use



blind holes up to 3 x D
Chip removal (like picture)
Form C 35° spiral flute



material: HSSE 2B to 900 N/mm² 27.1 HRC



2-3 threads outside cooling and lubrication

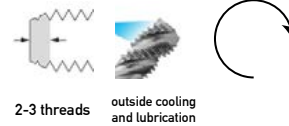
Machine Tap for stainless steels



blind holes up to 2.5 x D
Chip removal (like picture)
Form C 40° spiral flute

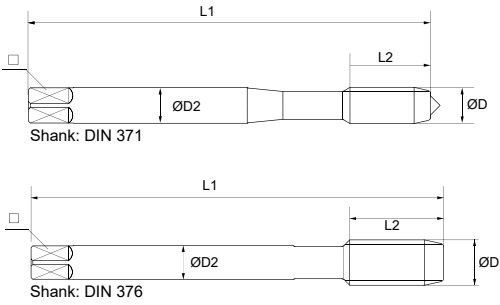


material: HSSE-TiAIN 2B to 1300 N/mm² 41 HRC



2-3 threads outside cooling and lubrication

Tap for machine use in blind holes. The fast spiral flutes provide good chip removal from the blind hole.



UNF

	D1	D2	L1	L2	□		No.	€	No.	€
UNF No 3 x 56	2,52	2,8	50	6	2,1	2,10			150605001	50,05
UNF No 4 x 48	2,85	3,5	50	6	2,7	2,40	150601001	11,92	150605002	47,78
UNF No 5 x 44	3,18	3,5	56	7	2,7	2,70	150601002	11,92	150605003	46,75
UNF No 6 x 40	3,51	4,0	56	7	3,0	3,00	150601003	11,92	150605004	49,22
UNF No 8 x 36	4,17	4,5	63	8	3,4	3,50	150601004	11,92	150605005	49,22
UNF No 10 x 32	4,83	6,0	70	10	4,9	4,10	150601005	11,92	150605006	50,26
UNF No 12 x 28	5,49	6,0	70	10	4,9	4,70	150601006	11,92	150605007	54,36
UNF 1/4 x 28	6,35	7,0	80	10	5,5	5,50	150601007	11,92	150605008	53,64
UNF 5/16 x 24	7,94	8,0	90	10	6,2	6,90	150601008	14,93	150605009	58,01
UNF 3/8 x 24	9,53	9,0	100	10	7,0	8,50	150601009	16,37	150605010	66,73
UNF 7/16 x 20	11,11	8,0	100	13	6,2	9,90	150601010	20,16	150605011	79,81
UNF 1/2 x 20	12,70	9,0	100	13	7,0	11,50	150601011	20,16	150605012	79,81
UNF 9/16 x 18	14,29	11,0	100	15	9,0	12,90	150601012	29,73	150605013	88,86
UNF 5/8 x 18	15,88	12,0	100	15	9,0	14,50	150601013	29,73	150605014	111,24
UNF 3/4 x 16	19,05	14,0	110	17	11,0	17,50	150601014	59,26	150605015	157,13
UNF 7/8 x 14	22,23	18,0	140	17	14,5	20,25	150601015	72,39	150605016	180,45
UNF 1" x 12	25,40	20,0	150	20	16,0	23,25	150601016	81,31	150605017	229,76
UNF 1" x 14	25,40	20,0	150	20	16,0	23,30	150601017	90,02		
UNF 1.1/4 x 12	31,75	22,0	150	22	18,0	29,50	150601018	103,58		
UNF 1.1/2 x 12	38,10	32,0	170	25	24,0	36,00	150601019	226,09		

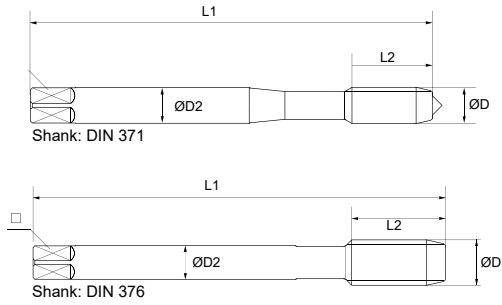
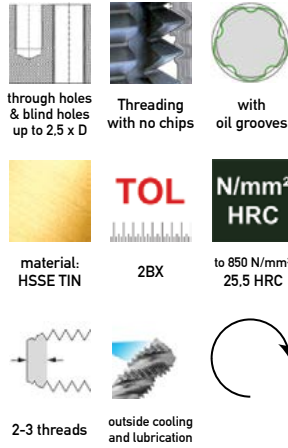
UNiForm Machine Forming Taps

UNF Unified fine thread ANSI B1.1

Machine Forming Taps have following advantages:

- No chips
- Up to 20 times longer lifetime (compared to taps)
- Same forming tap for through and blind hole
- Wide range of materials can be processed
- Intersection of the thread is impossible
- Very high trueness
- Increased strength of the thread
- Higher surface quality
- Much higher cutting speed

Machine Forming Taps for universal use



UNF	D1	D2	L1	L2	□		No.	€
UNF No 2 x 64	2,18	2,8	45	7	2,1	2,02	151101001	*
UNF No 4 x 48	2,85	3,5	56	11	2,7	2,62	151101002	*
UNF No 6 x 40	3,51	4,0	56	12	3,0	3,22	151101003	*
UNF No 8 x 36	4,17	4,5	63	13	3,4	3,85	151101004	*
UNF No 10 x 32	4,83	6,0	70	15	4,9	4,45	151101005	*
UNF 1/4 x 28	6,35	7,0	80	17	5,5	5,95	151101006	*
UNF 5/16 x 24	7,94	8,0	90	17	6,2	7,45	151101007	*
UNF 3/8 x 24	9,53	10,0	90	18	8,0	9,05	151101008	*
UNF 7/16 x 20	11,11	8,0	100	22	6,2	10,55	151101009	*
UNF 1/2 x 20	12,70	9,0	100	22	7,0	12,15	151101010	*
UNF 5/8 x 18	15,88	12,0	100	22	9,0	15,25	151101011	*
UNF 3/4 x 16	19,05	14,0	110	25	11,0	18,35	151101012	*

* on request

1/4" Combined-Bit-Taps

UNF

Unified fine thread
ANSI B1.1

Efficient internal thread cutting with battery-powered screwdriver (min. 7,5 Volt). Core hole drilling and thread tapping in one fluent process.

Application:
non abrasive material up to 600 N/mm²
unalloyed and low alloyed steel

Kombi-Bit-Taps for through holes



through holes
up to 1 x D



Chip removal
(like picture)



Combined
form



material:
HSSG



2B



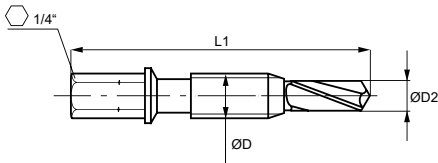
to 600 N/mm²



4-5 threads



outside cooling
and lubrication



UNF





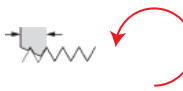
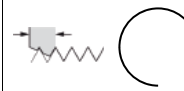
	D1	D2	L1	Hexagon	No.	€
UNF No 4 x 48	2,85	2,4	36	1/4"	151301001	*
UNF No 5 x 44	3,18	2,7	36	1/4"	151301002	*
UNF No 6 x 40	3,51	3,0	39	1/4"	151301003	*
UNF No 8 x 36	4,17	3,5	39	1/4"	151301004	*
UNF No 10 x 32	4,83	4,1	41	1/4"	151301005	*
UNF No 12 x 28	5,49	4,7	41	1/4"	151301006	*
UNF 1/4 x 28	6,35	5,5	44	1/4"	151301007	*
UNF 5/16 x 24	7,94	6,9	50	1/4"	151301008	*
UNF 3/8 x 24	9,53	8,5	59	1/4"	151301009	*

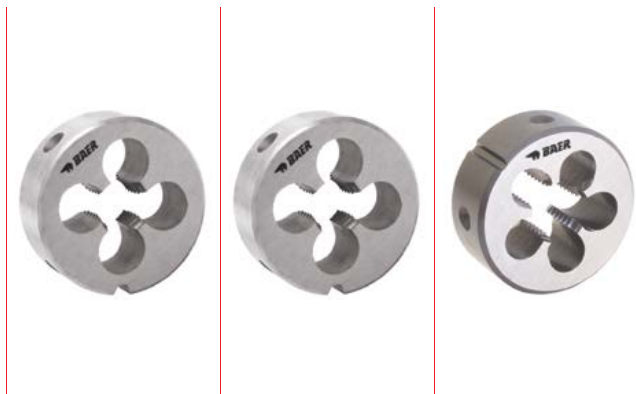
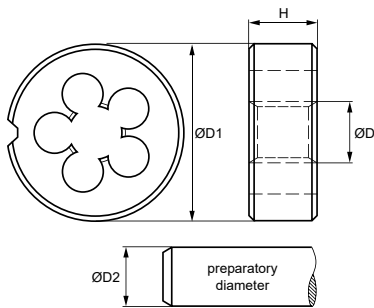
* on request

Round Dies

UNF

Unified fine thread
ANSI B1.1

Round Dies for general use	Round Dies for general use Left Hand	Round Dies for stainless steels
		
material: HSS	material: HSS	material: HSSE
2A	2A	2A
		
Chamfer: 1.5 threads	Chamfer: 1.5 threads	Chamfer: 2 threads
right hand thread	left hand thread	right hand thread



UNF	D	D1	H	D2	No.	€	No.	€	No.	€
UNF NR. 0 x 80	1,52	16	5	1,47	151401001	20,00				
UNF NR. 1 x 72	1,85	16	5	1,79	151401002	20,00				
UNF NR. 2 x 64	2,18	16	5	2,12	151401003	15,95				
UNF NR. 3 x 56	2,52	16	5	2,44	151401004	15,95				
UNF NR. 4 x 48	2,85	20	5	2,77	151401005	13,20				
UNF NR. 5 x 44	3,18	20	5	3,10	151401006	13,20				
UNF NR. 6 x 40	3,51	20	5	3,42	151401007	12,30				
UNF NR. 8 x 36	4,17	20	7	4,08	151401008	12,30				
UNF NR. 10 x 32	4,83	20	7	4,73	151401009	12,30	151402001	22,27	151405001	75,39
UNF NR. 12 x 28	5,49	20	7	5,38	151401010	12,30				
UNF 1/4 x 28	6,35	20	7	6,24	151401011	11,69	151402002	18,04	151405002	90,81
UNF 5/16 x 24	7,94	25	9	7,82	151401012	13,36	151402003	21,05	151405003	94,15
UNF 3/8 x 24	9,53	30	11	9,41	151401013	14,82	151402004	25,62	151405004	116,11
UNF 7/16 x 20	11,11	30	11	10,98	151401014	17,15	151402005	25,62	151405005	111,97
UNF 1/2 x 20	12,70	38	10	12,56	151401015	19,27	151402006	40,09		
UNF 9/16 x 18	14,29	38	10	14,14	151401016	23,84	151402007	40,09		
UNF 5/8 x 18	15,88	45	14	15,73	151401017	26,06	151402008	51,24		
UNF 3/4 x 16	19,05	45	14	18,89	151401018	26,06	151402009	51,24		
UNF 7/8 x 14	22,23	55	16	22,05	151401019	44,54	151402010	74,62		
UNF 1" x 12	25,40	55	16	25,21	151401020	44,54	151402011	74,62		
UNF 1" x 14	25,40	55	16	25,23	151401021	44,54				
UNF 1.1/8 x 12	28,58	65	18	28,38	151401022	67,39				
UNF 1.1/4 x 12	31,75	65	18	31,55	151401023	67,39				
UNF 1.3/8 x 12	34,93	65	18	34,73	151401024	67,39				
UNF 1.1/2 x 12	38,10	65	18	37,90	151401025	67,39				
UNF 1.1/2 x 12	38,10	75	20	37,90	151401026	120,29				

Hexagon Die Nuts

UNF

Unified fine thread
ANSI B1.1

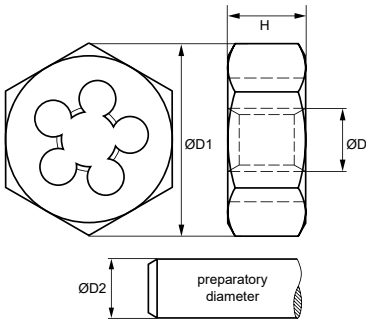
Hexagon Die Nuts for general use



material: HSS 2A



Chamfer: 1.5 threads
right hand thread



UNF

	D	D1	H	D2	No.	€
UNF 1/4 x 28	6,35	19	7	6,24	151501001	14,48
UNF 5/16 x 24	7,94	22	9	7,82	151501002	15,03
UNF 3/8 x 24	9,53	27	11	9,41	151501003	18,16
UNF 7/16 x 20	11,11	27	11	10,98	151501004	18,16
UNF 1/2 x 20	12,70	36	10	12,56	151501005	22,27
UNF 9/16 x 18	14,29	36	10	14,14	151501006	22,27
UNF 5/8 x 18	15,88	41	14	15,73	151501007	30,41
UNF 3/4 x 16	19,05	41	14	18,89	151501008	30,41
UNF 7/8 x 14	22,23	50	16	22,05	151501009	63,16
UNF 1" x 12	25,40	50	16	25,21	151501010	63,16
UNF 1.1/8 x 12	28,58	60	18	28,38	151501011	95,79
UNF 1.1/4 x 12	31,75	60	18	31,55	151501012	95,79
UNF 1.3/8 x 12	34,93	60	18	34,73	151501013	95,79
UNF 1.1/2 x 12	38,10	70	20	37,90	151501014	114,72

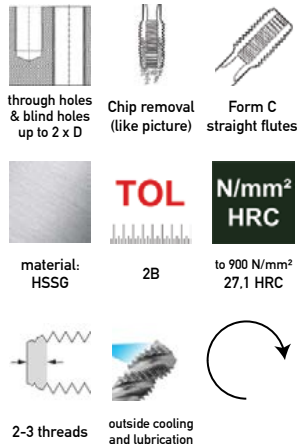
Machine Taps and Round Dies

UNS

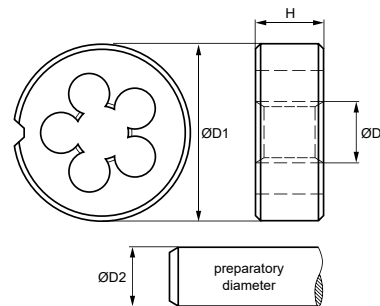
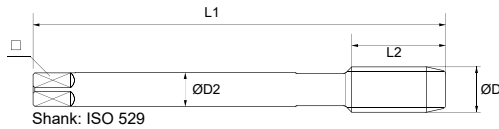
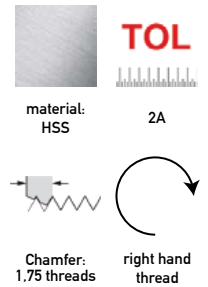
Unified thread with special threads per inch (TPI)

Tap for machine use in through hole and blind hole. The short lead-in chamfer makes that tap universal in application. The flutes can hold the most part of the chips.

Machine Taps
Form C for through holes and blind holes



Round Dies
for general use



UNS	D1	D2	L1	L2	□	🔧	No.	€
UNS 1/4 x 24	6,35	6,3	66	19	5,0	5,40	160501001	8,80
UNS 1/4 x 36	6,35	6,3	66	19	5,0	5,70	160501002	8,80
UNS 1/4 x 40	6,35	6,3	66	19	5,0	5,75	160501003	8,80
UNS 3/8 x 27	9,53	10,0	80	24	8,0	8,35	160501004	12,59
UNS 7/16 x 24	11,11	8,0	85	25	6,3	10,10	160501005	14,82
UNS 1/2 x 24	12,70	9,0	89	29	7,1	11,75	160501006	14,82
UNS 5/8 x 27	15,88	12,5	102	32	10,0	14,70	160501007	22,71
UNS 3/4 x 24	19,05	14,0	112	37	11,2	18,00	160501008	42,10
UNS 7/8 x 18	22,23	16,0	118	38	12,5	21,00	160501009	51,46
UNS 1" x 14	25,40	18,0	130	45	14,0	23,75	160501010	59,03

UNS	D	D1	H	D2	No.	€
UNS 1/4 x 24	6,35	20	7	6,24	161401001	37,80
UNS 1/4 x 36	6,35	20	5	6,26	161401002	37,80
UNS 1/4 x 40	6,35	20	5	6,27	161401003	37,80
UNS 3/8 x 27	9,53	30	11	9,41	161401004	*
UNS 7/16 x 24	11,11	30	11	11,00	161401005	62,48
UNS 1/2 x 24	12,70	38	10	12,59	161401006	63,53
UNS 5/8 x 27	15,88	45	14	15,76	161401007	104,79
UNS 7/8 x 18	22,23	55	16	22,08	161401008	194,25
UNS 1" x 14	25,40	55	16	25,23	161401009	194,25

* on request

Hand Tap Sets and Machine Taps

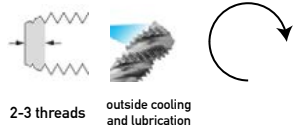
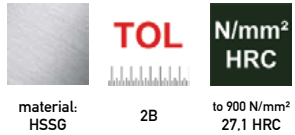
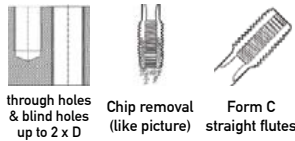
UNEF

Unified extra fine thread
ANSI B1.1

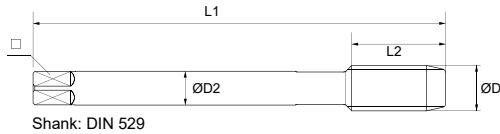
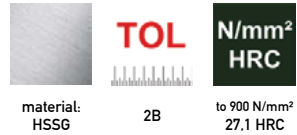
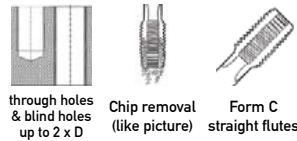
Efficient internal thread cutting.
The short structural type of the Hand Tap Sets makes that tap usable by hand. The Short-Machine-Tap is also usable by machine.

A Hand-Tap-Set includes 2 taps:
Taper Tap
Finish Tap

Hand Tap Sets for general use



Machine Taps Form C for through holes and blind holes



UNEF

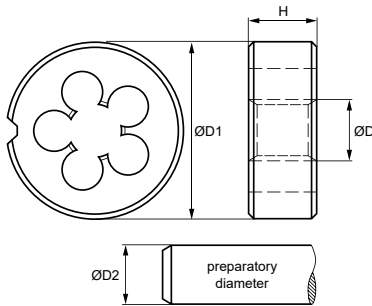
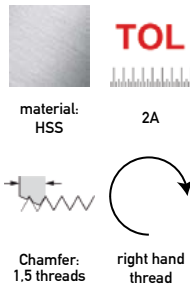
	D1	D2	L1	L2	□		No.	€	No.	€
UNEF No 12 x 32	5,49	5,6	62	17	4,5	4,75			170501001	9,82
UNEF 1/4 x 32	6,35	6,3	66	19	5,0	5,60	170313001	16,04	170501002	8,77
UNEF 5/16 x 32	7,94	8,0	72	22	6,3	7,20	170313002	18,04	170501003	10,99
UNEF 3/8 x 32	9,53	10,0	80	24	8,0	8,80	170313003	18,06	170501004	12,51
UNEF 7/16 x 28	11,11	8,0	85	25	6,3	10,25	170313004	25,39	170501005	14,74
UNEF 1/2 x 28	12,70	9,0	89	29	7,1	11,80	170313005	30,07	170501006	14,74
UNEF 9/16 x 24	14,29	11,2	95	30	9,0	13,30	170313006	42,10	170501007	22,22
UNEF 5/8 x 24	15,88	12,5	102	32	10,0	14,90	170313007	47,45	170501008	22,68
UNEF 11/16 x 24	17,46	14,0	112	37	11,2	16,50			170501009	42,10
UNEF 3/4 x 20	19,05	14,0	112	37	11,2	17,75	170313008	63,49	170501010	42,10
UNEF 13/16 x 20	20,64	16,0	118	38	12,5	19,50			170501011	51,46
UNEF 7/8 x 20	22,23	16,0	118	38	12,5	21,00	170313009	85,21	170501012	51,46
UNEF 15/16 x 20	23,81	18,0	130	45	14,0	22,50			170501013	58,94
UNEF 1" x 20	25,40	16,0	130	45	14,0	24,25	170313010	97,56	170501014	58,94
UNEF 1.1/16 x 18	26,99	20,0	138	48	16,0	25,70			170501015	67,83
UNEF 1.1/8 x 18	28,58	20,0	138	48	16,0	27,25			170501016	67,83
UNEF 1.3/16 x 18	30,16	22,4	151	51	18,0	28,75			170501017	79,52
UNEF 1.1/4 x 18	31,75	22,4	151	51	18,0	30,50			170501018	79,52
UNEF 1.5/16 x 18	33,34	25,0	162	57	20,0	32,00			170501019	99,40
UNEF 1.3/8 x 18	34,93	25,0	162	57	20,0	33,50			170501020	99,40
UNEF 1.7/16 x 18	36,51	28,0	170	60	22,4	35,20			170501021	128,64
UNEF 1.1/2 x 18	38,10	28,0	170	60	22,4	36,80			170501022	128,64
UNEF 1.9/16 x 18	39,69	28,0	170	60	22,4	38,40			170501023	152,03
UNEF 1.5/8 x 18	41,28	28,0	170	60	22,4	40,00			170501024	152,03
UNEF 1.11/16 x 18	42,86	31,5	187	67	25,0	41,50			170501025	175,42
UNEF 1.3/4 x 18	44,45	31,5	187	67	25,0	43,00			170501026	175,42
UNEF 2" x 18	50,80	35,5	200	70	28,0	49,50			170501027	268,97

Round Dies

UNEF

Unified extra fine thread
ANSI B1.1

Round Dies
for general use



UNEF

	D	D1	H	D2	No.	€
UNEF No 12 x 32	5,49	20	7	5,39	171401001	14,48
UNEF 1/4 x 32	6,35	20	7	6,25	171401002	14,48
UNEF 5/16 x 32	7,94	25	9	7,84	171401003	18,38
UNEF 3/8 x 32	9,53	30	11	9,42	171401004	21,05
UNEF 7/16 x 28	11,11	30	11	11,00	171401005	21,05
UNEF 1/2 x 28	12,70	38	10	12,59	171401006	32,18
UNEF 9/16 x 24	14,29	38	10	14,17	171401007	32,18
UNEF 5/8 x 24	15,88	45	14	15,75	171401008	51,46
UNEF 11/16 x 24	17,46	45	14	17,33	171401009	51,46
UNEF 3/4 x 20	19,05	45	14	18,91	171401010	51,46
UNEF 13/16 x 20	20,64	55	16	20,50	171401011	60,70
UNEF 7/8 x 20	22,23	55	16	22,09	171401012	60,70
UNEF 15/16 x 20	23,81	55	16	23,67	171401013	60,70
UNEF 1" x 20	25,40	55	16	25,26	171401014	60,70
UNEF 1.1/16 x 18	26,99	65	18	26,84	171401015	96,90
UNEF 1.1/8 x 18	28,58	65	18	28,58	171401016	96,90
UNEF 1.3/16 x 18	30,23	65	18	30,16	171401017	96,90
UNEF 1.1/4 x 18	31,75	65	18	31,75	171401018	96,90
UNEF 1.5/16 x 18	33,34	65	18	33,34	171401019	96,90
UNEF 1.3/8 x 18	34,93	65	18	34,93	171401020	96,90
UNEF 1.7/16 x 18	36,51	75	20	36,51	171401021	122,51
UNEF 1.1/2 x 18	38,10	75	20	38,10	171401022	122,51

Hand Tap Sets and Machine Taps

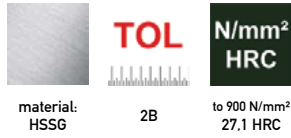
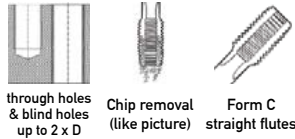
8-UN

Unified thread series with 8-threads per inch (TPI)

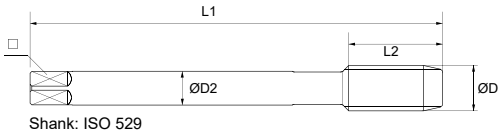
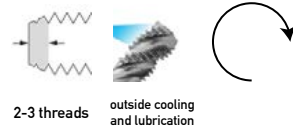
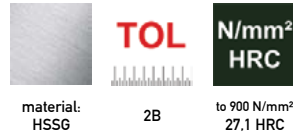
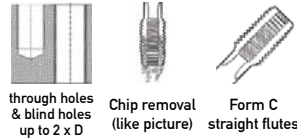
Efficient internal thread cutting. The short structural type makes that tap usable by hand. The Short-Machine-Tap is also usable by machine.

A Hand-Tap-Set includes 2 taps:
Taper Tap
Finish Tap

Hand Tap Sets for general use



Machine Taps Form C for through holes and blind holes



8-UN	D1	D2	L1	L2	□		No.	€	No.	€
UN 1.1/16 x 8	26,99	20,0	138	48	16,0		180301001	336,00	180501001	67,83
UN 1.1/8 x 8	28,58	20,0	138	48	16,0		180301002	322,00	180501002	67,83
UN 1.3/16 x 8	30,16	22,4	151	51	18,0		180301003	371,28	180501003	79,52
UN 1.1/4 x 8	31,75	22,4	151	51	18,0		180301004	371,28	180501004	79,52
UN 1.5/16 x 8	33,34	25,0	162	57	20,0		180301005	393,75	180501005	100,23
UN 1.3/8 x 8	34,93	25,0	162	57	20,0		180301006	375,00	180501006	100,23
UN 1.1/2 x 8	38,10	28,0	170	60	22,4		180301007	472,00	180501007	129,19
UN 1.5/8 x 8	41,28	28,0	170	60	22,4		180301008	698,00	180501008	152,58
UN 1.3/4 x 8	44,45	31,5	187	67	25,0		180301009	698,00	180501009	178,21
UN 1.7/8 x 8	47,63	31,5	187	67	25,0		180301010	794,00	180501010	269,54
UN 2" x 8	50,80	35,5	200	70	28,0		180301011	962,00	180501011	269,54
UN 2.1/8 x 8	53,98	35,5	200	70	28,0		180301012	1063,65	180501012	534,59
UN 2.1/4 x 8	57,15	40,0	221	76	31,5		180301013	1099,63	180501013	534,59
UN 2.1/2 x 8	63,50	40,0	224	79	31,5		180301014	1634,33	180501014	779,60
UN 2.3/4 x 8	69,85	45,0	234	79	35,5		180301015	2529,45	180501015	857,59
UN 3" x 8	76,20	50,0	258	83	40,0		180301016	2752,67	180501016	963,41
UN 3.1/4 x 8	82,55	50,0	261	86	40,0		180301017	4364,85	180501017	963,41
UN 3.1/2 x 8	88,90	50,0	261	86	40,0		180301018	5257,24	180501018	1136,03
UN 3.3/4 x 8	95,25	56,0	279	89	45,0		180301019	7515,90	180501019	1391,63
UN 4" x 8	101,60	56,0	279	89	45,0		180301020	8499,75	180501020	1391,63

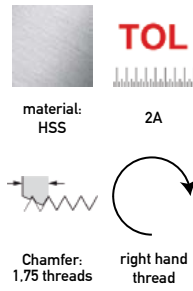
* on request

Round Dies and Hexagon Die Nuts

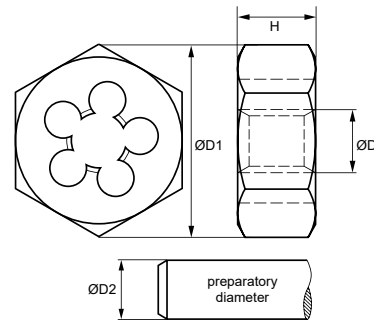
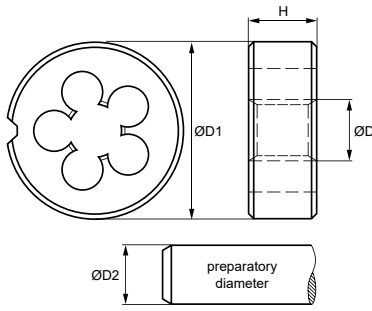
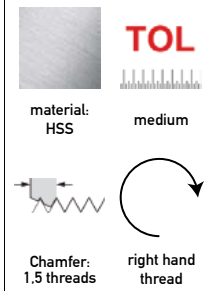
8-UN

Unified thread series with 8-threads per inch (TPI)

Round Dies for general use



Hexagon Die Nuts for general use



8-UN

	D	D1	H	D2	No.	€
UN 1.1/8 x 8	28,58	65	25	28,33	181401001	242,03
UN 1.1/4 x 8	31,75	65	25	31,51	181401002	296,10
UN 1.3/8 x 8	34,93	65	25	34,68	181401003	273,00
UN 1.1/2 x 8	38,10	75	20	37,85	181401004	381,15
UN 1.3/4 x 8	44,45	90	22	44,20	181401005	567,00
UN 2" x 8	50,80	90	22	50,55	181401006	593,25

8-UN

	D	D1	H	D2	No.	€
UN 1.1/8 x 8	28,58	60	25	28,33	181501001	95,90
UN 1.1/4 x 8	31,75	60	25	31,51	181501002	95,90
UN 1.3/8 x 8	34,93	60	25	34,68	181501003	95,90
UN 1.1/2 x 8	38,10	60	25	37,85	181501004	174,25
UN 1.5/8 x 8	41,28	70	30	41,03	181501005	174,25
UN 1.3/4 x 8	44,45	85	36	44,20	181501006	174,25
UN 1.7/8 x 8	47,63	85	22	47,38	181501007	174,25
UN 2" x 8	50,80	85	22	50,55	181501008	174,25
UN 2.1/8 x 8	53,98	85	22		181501009	297,04
UN 2.1/4 x 8	57,15	100	22		181501010	297,04
UN 2.1/2 x 8	63,50	115	22		181501011	444,38

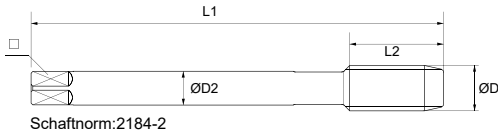
Hand Tap Sets and Machine Taps

12-UN

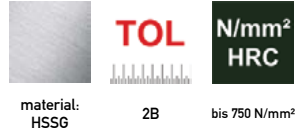
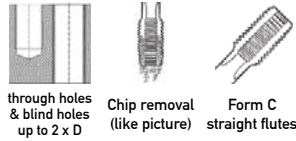
Unified thread series with 12-threads per inch (TPI)

Efficient internal thread cutting. The short structural type makes that tap usable by hand. The Short-Machine-Tap is also usable by machine.

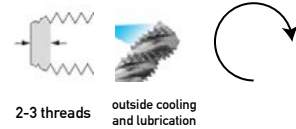
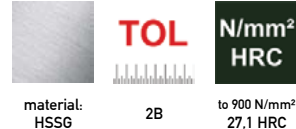
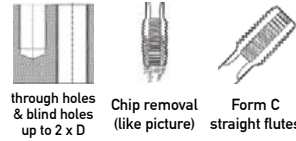
A Hand-Tap-Set includes 2-3 taps:
Taper Tap
(Intermediate Tap)
Finish Tap



Hand Tap Sets for general use



Machine Taps Form C for through holes and blind holes



12-UN

	D1	D2	L1	L2	□		No.	€	No.	€
UN 1/2 x 12	12,70	9,0	75	25	7,0	10,65	190301001	299,25		
UN 5/8 x 12	15,88	12,0	80	25	9,0	13,80	190301002	357,00		
UN 11/16 x 12	17,46	14,0	80	25	11,0	15,40	190301003	399,00		
UN 3/4 x 12	19,05	14,0	80	25	11,0	17,00	190301004	441,00		
UN 13/16 x 12	20,64	16,0	80	25	12,0	18,60	190301005	451,50		
UN 7/8 x 12	22,23	18,0	80	25	14,5	20,20	190301006	452,55		
UN 15/16 x 12	23,81	18,0	90	25	14,5	21,80	190301007	452,55		
UN 1.1/16 x 12	26,99	20,0	90	28	16,0	24,90	190301008	473,55		
UN 1.3/16 x 12	30,16	22,0	90	28	18,0	28,10	190301009	550,20		
UN 1.5/16 x 12	33,34	28,0	125	32	22,0	31,30	190301010	584,85		
UN 1.7/16 x 12	36,51	28,0	125	32	22,0	34,50	190301011	762,30		
UN 1.5/8 x 12	41,28	32,0	125	32	24,0	39,20	190301012	976,50	190501001	148,52
UN 1.3/4 x 12	44,45	36,0	125	32	29,0	42,40	190301013	976,50	190501002	170,74
UN 1.7/8 x 12	47,63	36,0	140	32	29,0	45,60	190301014	1113,00	190501003	264,30
UN 2 x 12	50,80	40,0	140	32	32,0	48,75	190301015	1354,50	190501004	264,30
UN 2.1/8 x 12	53,98	35,5	200	70	28,0	51,90			190501005	522,74
UN 2.1/4 x 12	57,15	40,0	221	76	31,5	55,10			190501006	522,74
UN 2.1/2 x 12	63,50	40,0	224	79	31,5	61,50			190501007	760,14
UN 2.3/4 x 12	69,85	45,0	234	79	35,5	67,80			190501008	836,15
UN 3" x 12	76,20	50,0	258	83	40,0	74,20			190501009	929,70
UN 3.1/4 x 12	82,55	50,0	261	86	40,0	80,50			190501010	929,70
UN 3.1/2 x 12	88,90	50,0	261	86	40,0	86,90			190501011	1093,43
UN 3.3/4 x 12	95,25	56,0	279	89	45,0	93,20			190501012	1344,85
UN 4" x 12	101,60	56,0	279	89	45,0	99,60			190501013	1344,85

* on request

Round Dies

12-UN

Unified thread series with 12-threads per inch (TPI)

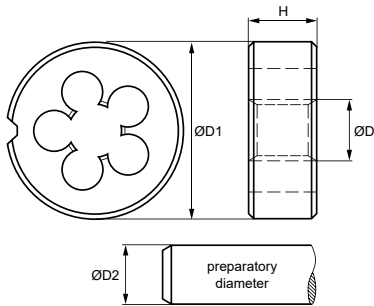
Round Dies for general use



material: HSS medium



Chamfer: 1.75 threads right hand thread



12-UN

	D	D1	H	D2	No.	€
UN 1.1/16 x 12	26,99	65	18	26,80	191401001	215,43
UN 1.5/16 x 12	33,34	65	18	33,15	191401002	*
UN 1.5/8 x 12	41,28	75	20	41,09	191401003	409,73
UN 1.3/4 x 12	44,45	90	22	44,26	191401004	478,48
UN 2" x 12	50,80	90	22	50,61	191401005	*

* on request

Thread Cutting Kits with Taps, Dies and Tools

BSW

British standard BS 84
whitworth coarse thread

BAER Hand-Tap Sets, Round Dies and Tools Sets

(example picture)



BAER Set BSW 1/8" - 1/2"		€/Set
HSSG Hand Tap Sets & HSS Round Dies & Tools		
BAER HSSG Hand Tap Sets (3 parts)	BSW 1/8 x 40 BSW 3/16 x 24 BSW 1/4 x 20 BSW 5/16 x 18 BSW 3/8 x 16 BSW 7/16 x 14 BSW 1/2 x 12	322,00 € Item No.: 264803010
BAER HSS Round Dies	BSW 1/8 x 40 BSW 3/16 x 24 BSW 1/4 x 20 BSW 5/16 x 18 BSW 3/8 x 16 BSW 7/16 x 14 BSW 1/2 x 12	
BAER adjustable Tap Wrenches - zinc die cast	M 1-10 1/16-3/8 G 1/8 & M 4-12 5/32-1/2 G 1/8	
BAER Die Stocks - zinc die cast	20 x 5 20 x 7 25 x 9 30 x 11 38 x 14	
Screw extractor		
BAER Set BSW 1/4" - 1/2"		€/Set
HSSG Hand Tap Sets & HSS Round Dies & Tools		
BAER HSSG Hand Tap Sets (3 parts)	BSW 1/4 x 20 BSW 5/16 x 18 BSW 3/8 x 16 BSW 7/16 x 14 BSW 1/2 x 12	275,00 € Item No.: 264803110
BAER HSS Round Dies	BSW 1/4 x 20 BSW 5/16 x 18 BSW 3/8 x 16 BSW 7/16 x 14 BSW 1/2 x 12	
BAER adjustable Tap Wrenches - zinc die cast	M 1-10 1/16-3/8 G 1/8 & M 4-12 5/32-1/2 G 1/8	
BAER Die Stocks - zinc die cast	20 x 7 25 x 9 30 x 11 38 x 14	
Screw extractor		
BAER Set BSW 1/4" - 3/4"		€/Set
HSSG Hand Tap Sets & HSS Round Dies & Tools		
BAER HSSG Hand Tap Sets (3 parts)	BSW 1/4 x 20 BSW 5/16 x 18 BSW 3/8 x 16 BSW 7/16 x 14 BSW 1/2 x 12 BSW 5/8 x 11 BSW 3/4 x 10	485,00 € Item No.: 264803210
BAER HSS Round Dies	BSW 1/4 x 20 BSW 5/16 x 18 BSW 3/8 x 16 BSW 7/16 x 14 BSW 1/2 x 12 BSW 5/8 x 11 BSW 3/4 x 10	
BAER adjustable Tap Wrenches - zinc die cast	M 1-10 1/16-3/8 G 1/8 & M 5-20 7/32-3/4" G 1/8-1/2	
BAER Die Stocks - zinc die cast	20 x 7 25 x 9 30 x 11 38 x 14 45 x 18	
Screw extractor		
BAER Set BSW 1/4" - 1"		€/Set
HSSG Hand Tap Sets & HSS Round Dies & Tools		
BAER HSSG Hand Tap Sets (3 parts)	BSW 1/4 x 20 BSW 5/16 x 18 BSW 3/8 x 16 BSW 7/16 x 14 BSW 1/2 x 12 BSW 5/8 x 11 BSW 3/4 x 10 BSW 7/8 x 9	725,00 € Item No.: 264803410
BAER HSS Round Dies	BSW 1/4 x 20 BSW 5/16 x 18 BSW 3/8 x 16 BSW 7/16 x 14 BSW 1/2 x 12 BSW 5/8 x 11 BSW 3/4 x 10 BSW 7/8 x 9	
BAER adjustable Tap Wrenches - zinc die cast	M 1-10 1/16-3/8 G 1/8 & M 11-27 7/16-1" G 1/4-3/4	
BAER Die Stocks - zinc die cast	20 x 7 25 x 9 30 x 11 38 x 14 45 x 18 55 x 22	
Screw extractor		
BAER Set BSW 1/4" - 1.1/2"		€/Set
HSSG Hand Tap Sets & HSS Round Dies & Tools		
BAER HSSG Hand Tap Sets (3 parts)	BSW 1/4 x 20 BSW 5/16 x 18 BSW 3/8 x 16 BSW 7/16 x 14 BSW 1/2 x 12 BSW 5/8 x 11 BSW 3/4 x 10 BSW 7/8 x 9	1733,00 € Item No.: 264803510
BAER HSS Round Dies	BSW 1/4 x 20 BSW 5/16 x 18 BSW 3/8 x 16 BSW 7/16 x 14 BSW 1/2 x 12 BSW 5/8 x 11 BSW 3/4 x 10 BSW 7/8 x 9	
BAER adjustable Tap Wrenches - zinc die cast	M 1-10 1/16-3/8 G 1/8 & M 5-20 7/32-3/4 G 1/8-1/2 & M 13-32 1/2-1.1/4" G 1/4-1"	
BAER Die Stocks - zinc die cast	20 x 7 25 x 9 30 x 11 38 x 14 45 x 18 55 x 22 65 x 25	
Screw extractor		

Thread Cutting Kits with Taps and Dies

BSW

British standard BS 84
whitworth coarse thread

BAER Short Machine Taps und Round Dies Sets BSW 1/4" - 1/2"

(example picture)



BAER Set BSW 1/4" - 1/2"

HSSG Short Machine Taps & Drill bits for core holes

HSS Round Dies

BAER HSSG Short Machine Tap Form D for through hole & blind hole (up to 4 x D)

BAER HSSG Drill bits for core holes

BAER HSS Round Dies

BSW 1/4 x 20 | BSW 5/16 x 18 | BSW 3/8 x 16 | BSW 7/16 x 14 | BSW 1/2 x 12

5,1 mm | 6,5 mm | 7,9 mm | 9,3 mm | 10,5 mm

BSW 1/4 x 20 | BSW 5/16 x 18 | BSW 3/8 x 16 | BSW 7/16 x 14 | BSW 1/2 x 12

€/Set

168,21

€ Item No.:

BES4

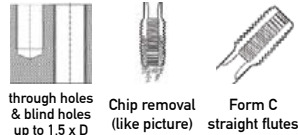
Hand Tap Sets

BSW

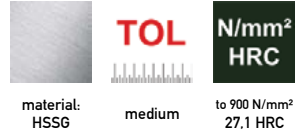
British standard BS 84
whitworth coarse thread

Short Machine Taps

Form D for through holes
and blind holes

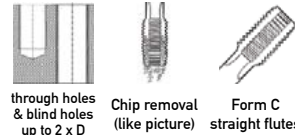


through holes & blind holes up to 1.5 x D
Chip removal (like picture)
Form C straight flutes

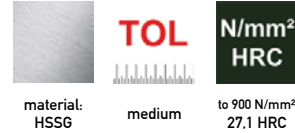


Hand Tap Sets

for general use



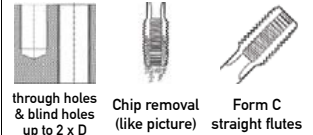
through holes & blind holes up to 2 x D
Chip removal (like picture)
Form C straight flutes



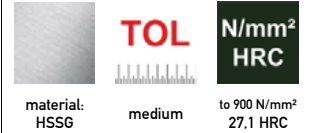
Hand Tap Sets

for general use

Left Hand

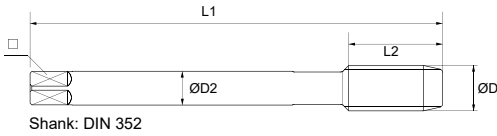


through holes & blind holes up to 2 x D
Chip removal (like picture)
Form C straight flutes



Efficient internal thread cutting.
The short structural type makes that tap usable by hand.

A Hand-Tap-Set includes 3 taps:
Taper Tap
Intermediate Tap
Finish Tap

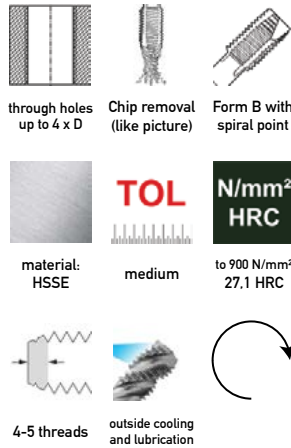


BSW	D1	D2	L1	L2	□		No.	€	No.	€	No.	€
BSW 1/16 x 60	1,59	2,5	36	10	2,1	1,20	210101001	10,26	210301001	20,05		
BSW 3/32 x 48	2,38	2,8	36	10	2,1	1,90	210101002	8,28	210301002	16,04		
BSW 1/8 x 40	3,18	3,5	40	12	2,7	2,60	210101003	7,38	210301003	14,37	210302001	23,06
BSW 5/32 x 32	3,97	4,5	45	14	3,4	3,20	210101004	7,38	210301004	14,37	210302002	23,06
BSW 3/16 x 24	4,76	6,0	50	18	4,9	3,80	210101005	7,20	210301005	14,03	210302003	23,06
BSW 7/32 x 24	5,56	6,0	50	18	4,9	4,60	210101006	7,20	210301006	14,03		
BSW 1/4 x 20	6,35	6,0	50	19	4,9	5,10	210101007	7,20	210301007	14,03	210302004	23,06
BSW 5/16 x 18	7,94	6,0	56	22	4,9	6,50	210101008	8,10	210301008	15,71	210302005	24,06
BSW 3/8 x 16	9,53	7,0	70	24	5,5	7,90	210101009	8,99	210301009	17,37	210302006	28,07
BSW 7/16 x 14	11,11	8,0	70	24	6,2	9,30	210101010	11,33	210301010	22,05	210302007	34,42
BSW 1/2 x 12	12,70	9,0	75	29	7,0	10,50	210101011	13,67	210301011	26,73	210302008	41,10
BSW 9/16 x 12	14,29	11,0	80	30	9,0	12,00	210101012	17,99	210301012	35,08	210302009	53,46
BSW 5/8 x 11	15,88	12,0	80	32	9,0	13,50	210101013	20,15	210301013	39,43	210302010	60,81
BSW 3/4 x 10	19,05	14,0	95	40	11,0	16,50	210101014	26,99	210301014	52,79	210302011	81,19
BSW 7/8 x 9	22,23	18,0	100	40	14,5	19,50	210101015	35,98	210301015	70,17	210302012	101,24
BSW 1" x 8	25,40	18,0	110	50	14,5	22,00	210101016	41,38	210301016	80,86	210302013	121,62
BSW 1.1/8 x 7	28,58	22,0	132	56	18,0	25,00	210101017	63,87	210301017	124,63		
BSW 1.1/4 x 7	31,75	22,0	132	56	18,0	28,00	210101018	71,97	210301018	140,34		
BSW 1.3/8 x 6	34,93	28,0	150	63	22,0	30,50	210101019	93,55	210301019	182,43		
BSW 1.1/2 x 6	38,10	32,0	150	63	24,0	33,50	210101020	107,95	210301020	210,50		
BSW 1.5/8 x 5	41,28	32,0	160	70	24,0	35,50	210101021	215,90	210301021	421,00		
BSW 1.3/4 x 5	44,45	36,0	160	70	29,0	39,00	210101022	215,90	210301022	421,00		
BSW 1.7/8 x 4,5	47,63	36,0	190	80	29,0	41,50	210101023	280,67	210301023	547,98		
BSW 2" x 4,5	50,80	40,0	190	80	32,0	44,50	210101024	280,67	210301024	547,98		
BSW 2.1/4 x 4	57,15	45,0	220	80	35,0	50,00	210101025	611,71	210301025	1303,14		
BSW 2.1/2 x 4	63,50	50,0	220	80	39,0	56,50	210101026	782,62	210301026	1737,44		
BSW 2.3/4 x 3,5	69,85	50,0	240	80	39,0	62,00	210101027	2015,03	210301027	4343,57		
BSW 3" x 3,5	76,20	50,0	260	80	39,0	68,00	210101028	2590,75	210301028	5345,95		

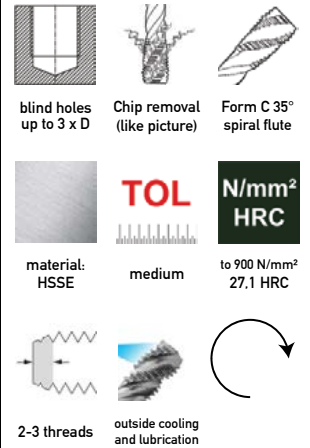
Machine Taps for through holes und blind holes

BSW British standard BS 84 whitworth coarse thread

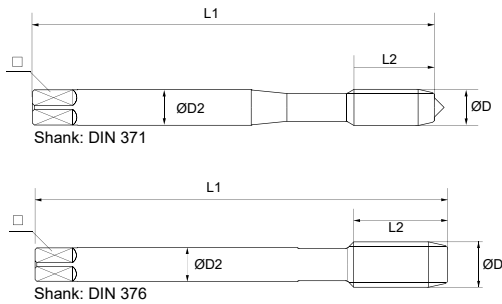
Machine Tap for general use in through hole



Machine Tap for general use in blind hole



Tap for machine use in through hole and blind hole.



BSW

D1 D2 L1 L2 □

No. €

D1 D2 L1 L2 □

No. €

DIN 371	D1	D2	L1	L2	□	No.	€
BSW 1/8 x 40	3,18	3,5	56	11	2,7	2,60	210401001 9,58
BSW 5/32 x 32	3,97	4,5	63	13	3,4	3,20	210401002 9,58
BSW 3/16 x 24	4,76	6,0	70	15	4,9	3,80	210401003 9,58
BSW 1/4 x 20	6,35	7,0	80	17	5,5	5,10	210401004 9,58
BSW 5/16 x 18	7,94	8,0	90	20	6,2	6,50	210401005 12,14
BSW 3/8 x 16	9,53	9,0	100	22	7,0	7,90	210401006 13,58
BSW 7/16 x 14	11,11	11,0	100	22	9,0	9,30	210401007 16,15
BSW 1/2 x 12	12,70	12,0	110	25	9,0	10,50	210401008 16,15

DIN 376	D1	D2	L1	L2	□	No.	€
BSW 1/4 x 20	6,35	4,5	80	17	3,4	5,10	210401009 9,58
BSW 5/16 x 18	7,94	6,0	90	20	4,9	6,50	210401010 12,14
BSW 3/8 x 16	9,53	7,0	100	22	5,5	7,90	210401011 13,58
BSW 7/16 x 14	11,11	8,0	100	22	6,2	9,30	210401012 16,15
BSW 1/2 x 12	12,70	9,0	110	25	7,0	10,50	210401013 16,15
BSW 9/16 x 12	14,29	11,0	110	26	9,0	12,00	210401014 24,62
BSW 5/8 x 11	15,88	12,0	110	27	9,0	13,50	210401015 24,62
BSW 3/4 x 10	19,05	14,0	125	30	11,0	16,50	210401016 47,89
BSW 7/8 x 9	22,23	18,0	140	32	14,5	19,50	210401017 57,92
BSW 1" x 8	25,40	20,0	160	36	16,0	22,00	210401018 65,71
BSW 1.1/4 x 7	31,75	22,0	180	40	18,0	28,00	210401019 91,88
BSW 1.3/8 x 6	34,93	28,0	200	50	22,0	30,50	210401020 191,56
BSW 1.1/2 x 6	38,10	32,0	200	50	24,0	33,50	210401021 191,56

DIN 371	D1	D2	L1	L2	□	No.	€
BSW 1/8 x 40	3,18	3,5	56	7	2,7	2,60	210601001 11,92
BSW 5/32 x 32	3,97	4,5	63	7	3,4	3,20	210601002 11,92
BSW 3/16 x 24	4,76	6,0	70	10	4,9	3,80	210601003 11,92
BSW 1/4 x 20	6,35	7,0	80	13	5,5	5,10	210601004 11,92
BSW 5/16 x 18	7,94	8,0	90	14	6,2	6,50	210601005 14,93
BSW 3/8 x 16	9,53	9,0	100	16	7,0	7,90	210601006 16,37
BSW 7/16 x 14	11,11	11,0	100	17	9,0	9,30	210601007 20,16
BSW 1/2 x 12	12,70	12,0	110	20	9,0	10,50	210601008 20,16

DIN 376	D1	D2	L1	L2	□	No.	€
BSW 1/4 x 20	6,35	4,5	80	13	3,4	5,10	210601009 11,92
BSW 5/16 x 18	7,94	6,0	90	14	4,9	6,50	210601010 14,93
BSW 3/8 x 16	9,53	7,0	100	16	5,5	7,90	210601011 16,37
BSW 7/16 x 14	11,11	8,0	100	17	6,2	9,30	210601012 20,16
BSW 1/2 x 12	12,70	9,0	110	20	7,0	10,50	210601013 20,16
BSW 9/16 x 12	14,29	11,0	110	20	9,0	12,00	210601014 29,73
BSW 5/8 x 11	15,88	12,0	110	22	9,0	13,50	210601015 29,73
BSW 3/4 x 10	19,05	14,0	125	25	11,0	16,50	210601016 59,26
BSW 7/8 x 9	22,23	18,0	140	27	14,5	19,50	210601017 72,39
BSW 1" x 8	25,40	20,0	160	30	16,0	22,00	210601018 81,31
BSW 1.1/4 x 7	31,75	22,0	180	35	18,0	28,00	210601019 103,58
BSW 1.3/8 x 6	34,93	28,0	200	40	22,0	30,50	210601020 226,09
BSW 1.1/2 x 6	38,10	32,0	200	40	24,0	33,50	210601021 226,09

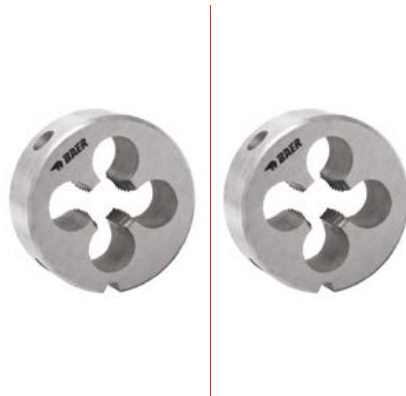
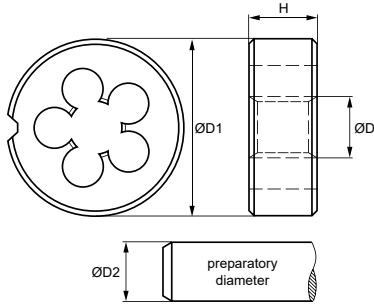
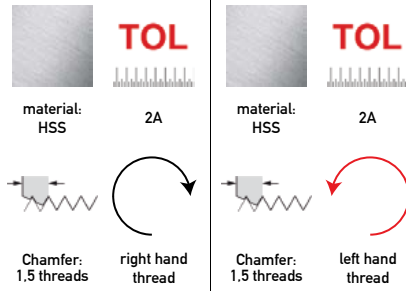
Round Dies

BSW

British standard BS 84
whitworth coarse thread

Round Dies
for general use

Round Dies
for general use
Left Hand



BSW

	D	D1	H	D2	No.	€	No.	€
BSW 3/32 x 48	2,38	16	5	2,30	211401002	11,69		
BSW 1/8 x 40	3,18	20	5	3,09	211401003	11,69	211402001	18,04
BSW 5/32 x 32	3,97	20	5	3,88	211401004	11,69	211402002	18,04
BSW 3/16 x 24	4,76	20	7	4,66	211401005	11,69	211402003	18,04
BSW 7/32 x 24	5,56	20	7	5,46	211401006	11,69		
BSW 1/4 x 20	6,35	20	7	6,24	211401007	11,69	211402004	18,04
BSW 5/16 x 18	7,94	25	9	7,82	211401008	13,36	211402005	21,05
BSW 3/8 x 16	9,53	30	11	9,40	211401009	14,82	211402006	25,62
BSW 7/16 x 14	11,11	30	11	10,98	211401010	17,15	211402007	25,62
BSW 1/2 x 12	12,70	38	14	12,56	211401011	19,27	211402008	40,09
BSW 9/16 x 12	14,29	38	14	14,14	211401012	23,84	211402009	40,09
BSW 5/8 x 11	15,88	45	18	15,72	211401013	26,06	211402010	51,24
BSW 3/4 x 10	19,05	45	18	18,89	211401014	26,06	211402011	51,24
BSW 7/8 x 9	22,23	55	22	22,10	211401015	44,54	211402012	74,62
BSW 1" x 8	25,40	55	22	25,27	211401016	44,54	211402013	74,62
BSW 1.1/8 x 7	28,58	65	25	28,44	211401017	67,39		
BSW 1.1/4 x 7	31,75	65	25	31,61	211401018	67,39		
BSW 1.3/8 x 6	34,93	65	25	34,77	211401019	67,39		
BSW 1.1/2 x 6	38,10	65	25	37,95	211401020	67,39		
BSW 1.1/2 x 6	38,10	75	30	37,95	211401021	120,29		
BSW 1.5/8 x 5	41,28	75	30	41,11	211401022	120,29		
BSW 1.3/4 x 5	44,45	90	36	44,28	211401023	183,77		
BSW 1.7/8 x 4,5	47,63	90	36	47,46	211401024	183,77		
BSW 2" x 4,5	50,80	90	36	50,63	211401025	183,77		
BSW 2.1/4 x 4	57,15	105	36	56,98	211401026	473,35		
BSW 2.1/2 x 4	63,50	105	36	63,34	211401027	473,35		
BSW 2.3/4 x 3,5	69,85	120	36	69,68	211401028	580,26		
BSW 3" x 3,5	76,20	120	36	76,03	211401029	580,26		

Hexagon Die Nuts

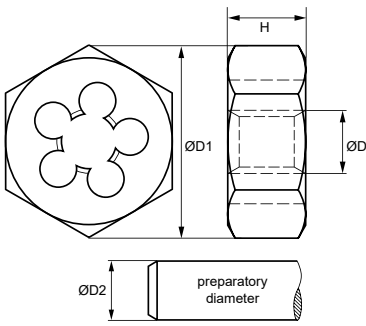
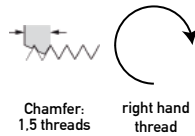
BSW

British standard BS 84
whitworth coarse thread

Hexagon Die Nuts for general use



material: HSS 2A



BSW

	D	D1	H	D2	No.	€
BSW 1/8 x 40	3,18	20	5	3,09	211501001	14,48
BSW 3/16 x 24	4,76	20	7	4,66	211501002	14,48
BSW 1/4 x 20	6,35	20	7	6,24	211501003	14,48
BSW 5/16 x 18	7,94	25	9	7,82	211501004	15,03
BSW 3/8 x 16	9,53	30	11	9,40	211501005	18,16
BSW 7/16 x 14	11,11	30	11	10,98	211501006	18,16
BSW 1/2 x 12	12,70	38	14	12,56	211501007	22,27
BSW 9/16 x 12	14,29	38	14	14,14	211501008	22,27
BSW 5/8 x 11	15,88	45	18	15,72	211501009	30,41
BSW 3/4 x 10	19,05	45	18	18,89	211501010	30,41
BSW 7/8 x 9	22,23	55	22	22,10	211501011	63,16
BSW 1" x 8	25,40	55	22	25,27	211501012	63,16
BSW 1.1/8 x 7	28,58	65	25	28,44	211501013	95,79
BSW 1.1/4 x 7	31,75	65	25	31,61	211501014	95,79
BSW 1.3/8 x 6	34,93	65	25	34,77	211501015	95,79
BSW 1.1/2 x 6	38,10	65	25	37,95	211501016	114,72
BSW 2" x 4,5	50,80	90	36	50,63	211501017	150,35
BSW 2.1/4 x 4	57,15	105	36	56,98	211501018	529,05
BSW 2.1/2 x 4	63,50	105	36	63,34	211501019	529,05
BSW 2.3/4 x 3,5	69,85	120	36	69,68	211501020	654,88
BSW 3" x 3,5	76,20	120	36	76,03	211501021	654,88

Thread Cutting Kits with Taps, Dies and Tools

BSF

British standard BS 84
whitworth fine thread

BAER Hand-Tap Sets, Round Dies and Tools Sets

(example picture)



BAER Set BSF 1/4" - 1/2"		€/Set
HSSG Hand Tap Sets & HSS Round Dies & Tools		
BAER HSSG Hand Tap Sets (2 parts)	BSF 1/4 x 26 BSF 5/16 x 22 BSF 3/8 x 20 BSF 7/16 x 18 BSF 1/2 x 16	267,00 € Item No.: 264804111
BAER HSS Round Dies	BSF 1/4 x 26 BSF 5/16 x 22 BSF 3/8 x 20 BSF 7/16 x 18 BSF 1/2 x 16	
BAER adjustable Tap Wrenches - zinc die cast	M 1-10 1/16-3/8 G 1/8 & M 4-12 5/32-1/2 G 1/8	
BAER Die Stocks - zinc die cast	20 x 7 25 x 9 30 x 11 38 x 10	
Screw extractor		

BAER Set BSF 1/4" - 3/4"		€/Set
HSSG Hand Tap Sets & HSS Round Dies & Tools		
BAER HSSG Hand Tap Sets (2 parts)	BSF 1/4 x 26 BSF 5/16 x 22 BSF 3/8 x 20 BSF 7/16 x 18 BSF 1/2 x 16 BSF 5/8 x 14 BSF 3/4 x 12	456,00 € Item No.: 264804211
BAER HSS Round Dies	BSF 1/4 x 26 BSF 5/16 x 22 BSF 3/8 x 20 BSF 7/16 x 18 BSF 1/2 x 16 BSF 5/8 x 14 BSF 3/4 x 12	
BAER adjustable Tap Wrenches - zinc die cast	M 1-10 1/16-3/8 G 1/8 & M 5-20 7/32-3/4 G 1/8-1/2	
BAER Die Stocks - zinc die cast	20 x 7 25 x 9 30 x 11 38 x 10 45 x 14	
Screw extractor		

BAER Set BSF 1/4" - 1"		€/Set
HSSG Hand Tap Sets & HSS Round Dies & Tools		
BAER HSSG Hand Tap Sets (2 parts)	BSF 1/4 x 26 BSF 5/16 x 22 BSF 3/8 x 20 BSF 7/16 x 18 BSF 1/2 x 16 BSF 5/8 x 14 BSF 3/4 x 12 BSF 7/8 x 11	701,00 € Item No.: 264804411
BAER HSS Round Dies	BSF 1/4 x 26 BSF 5/16 x 22 BSF 3/8 x 20 BSF 7/16 x 18 BSF 1/2 x 16 BSF 5/8 x 14 BSF 3/4 x 12 BSF 7/8 x 11	
BAER adjustable Tap Wrenches - zinc die cast	M 1-10 1/16-3/8 G 1/8 & M 11-27 7/16-1" G 1/4-3/4	
BAER Die Stocks - zinc die cast	20 x 7 25 x 9 30 x 11 38 x 10 45 x 14 55 x 16	
Screw extractor		

BAER Set BSW & BSF 1/4" - 3/4"		€/Set
HSSG Hand Tap Sets & HSS Round Dies & Tools		
BAER HSSG Hand Tap Sets (3 parts) UNC	BSW 1/4 BSW 5/16 BSW 3/8 BSW 7/16 BSW 1/2 BSW 5/8 BSW 3/4	777,00 € Item No.: 2648046210
BAER HSSG Hand Tap Sets (2 parts) UNF	BSF 1/4 BSF 5/16 BSF 3/8 BSF 7/16 BSF 1/2 BSF 5/8 BSF 3/4	
BAER HSS Round Dies UNC	BSW 1/4 BSW 5/16 BSW 3/8 BSW 7/16 BSW 1/2 BSW 5/8 BSW 3/4	
BAER HSS Round Dies UNF	BSF 1/4 BSF 5/16 BSF 3/8 BSF 7/16 BSF 1/2 BSF 5/8 BSF 3/4	
BAER adjustable Tap Wrenches - zinc die cast	M 1-10 1/16-3/8 G 1/8 & M 5-20 7/32-3/4" G 1/8-1/2	
BAER Die Stocks - zinc die cast	20 x 7 25 x 9 30 x 11 38 x 14 45 x 18	
Screw extractor		

Thread Cutting Kits with Taps and Dies

BSF

British standard BS 84
whitworth fine thread

BAER Short Machine Taps und Round Dies Sets BSF 1/4" - 1/2"

(example picture)



BAER Set BSF 1/4" - 1/2"

HSSG Short Machine Taps & Drill bits for core holes
HSS Round Dies

BAER HSSG Short Machine Tap Form D for through hole & blind hole (up to 4 x D)

BAER HSSG Drill bits for core holes

BAER HSS Round Dies

BSF 1/4 x 26 | BSF 5/16 x 22 | BSF 3/8 x 20 | BSF 7/16 x 18 | BSF 1/2 x 16

5,2 mm | 6,6 mm | 8,1 mm | 9,5 mm | 11 mm

BSF 1/4 x 26 | BSF 5/16 x 22 | BSF 3/8 x 20 | BSF 7/16 x 18 | BSF 1/2 x 16

€/Set

168,21 €

Item No.:

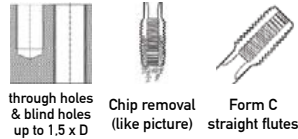
BE5

Short Machine Taps and Hand Tap Sets

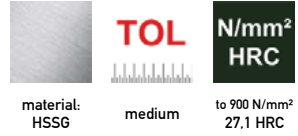
BSF British standard BS 84 whitworth fine thread

Short Machine Taps

Form D for through holes and blind holes



through holes & blind holes up to 1.5 x D
Chip removal (like picture)
Form C straight flutes



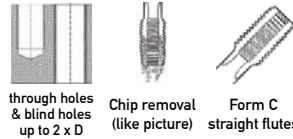
material: HSSG medium to 900 N/mm² 27.1 HRC



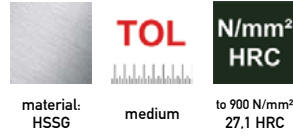
3-4 threads outside cooling and lubrication

Hand Tap Sets

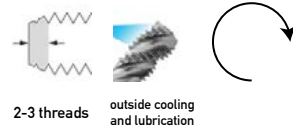
for general use



through holes & blind holes up to 2 x D
Chip removal (like picture)
Form C straight flutes



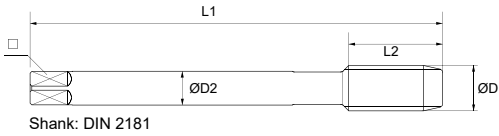
material: HSSG medium to 900 N/mm² 27.1 HRC



2-3 threads outside cooling and lubrication

Efficient internal thread cutting. The short structural type makes that tap usable by hand. The Short-Machine-Tap is also usable by machine.

A Hand-Tap-Set includes 2 taps:
Taper Tap
Finish Tap



BSF	D1	D2	L1	L2	□		No.	€	No.	€
BSF 3/16 x 32	4,76	6,0	50	14	4,9	3,90	220101001	6,30	220301001	9,36
BSF 1/4 x 26	6,35	6,0	50	18	4,9	5,30	220101002	6,30	220301002	9,36
BSF 5/16 x 22	7,94	6,0	56	22	4,9	6,80	220101003	7,09	220301003	10,47
BSF 3/8 x 20*	9,53	7,0	63	22	5,5	8,30	220101004	7,88	220301004	11,58
BSF 7/16 x 18	11,11	8,0	63	22	6,2	9,70	220101005	9,92	220301005	14,70
BSF 1/2 x 16	12,70	9,0	75	24	7,0	11,10	220101006	11,97	220301006	17,82
BSF 9/16 x 16	14,29	11,0	80	28	9,0	12,70	220101007	15,75	220301007	23,39
BSF 5/8 x 14	15,88	12,0	80	28	9,0	14,00	220101008	17,64	220301008	26,29
BSF 3/4 x 12	19,05	14,0	95	32	11,0	16,80	220101009	23,63	220301009	35,19
BSF 7/8 x 11	22,23	18,0	100	36	14,5	19,70	220101010	31,50	220301010	46,78
BSF 1" x 10	25,40	18,0	110	40	14,5	22,70	220101011	36,23	220301011	53,91

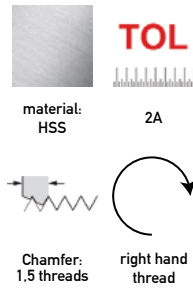
* BSF 3/8 = Fisher thread

Round Dies and Hexagon Die Nuts

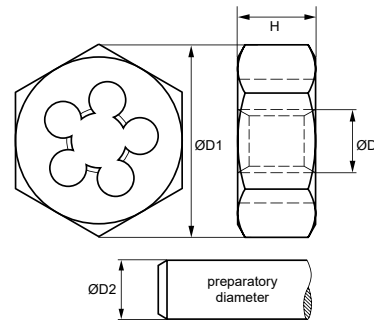
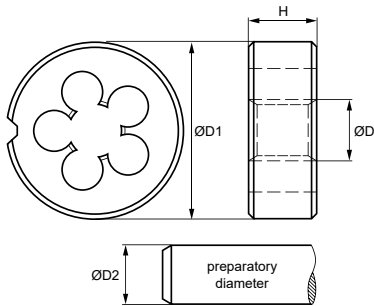
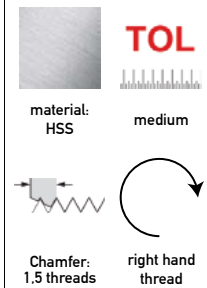
BSF

British standard BS 84
whitworth fine thread

Round Dies
for general use



Hexagon Die Nuts
for general use



BSF

	D	D1	H	D2	No.	€
BSF 3/16 x 32	4,76	20	7	4,67	221401001	11,69
BSF 1/4 x 26	6,35	20	7	6,25	221401002	11,69
BSF 5/16 x 22	7,94	25	9	7,83	221401003	13,36
BSF 3/8 x 20	9,53	30	11	9,41	221401004	14,81
BSF 7/16 x 18	11,11	30	11	10,99	221401005	17,15
BSF 1/2 x 16	12,70	38	10	12,57	221401006	22,05
BSF 9/16 x 16	14,29	38	10	14,12	221401007	24,50
BSF 5/8 x 14	15,88	45	14	15,73	221401008	33,41
BSF 3/4 x 12	19,05	45	14	18,89	221401009	33,41
BSF 7/8 x 11	22,23	55	22	22,11	221401010	45,67
BSF 1" x 10	25,40	55	22	25,28	221401011	45,67

BSF

	D	D1	H	D2	No.	€
BSF 3/16 x 32	4,76	19	7	4,67	221501001	16,38
BSF 1/4 x 26	6,35	19	7	6,25	221501002	16,38
BSF 5/16 x 22	7,94	22	9	7,83	221501003	18,16
BSF 3/8 x 20	9,53	27	11	9,41	221501004	22,27
BSF 7/16 x 18	11,11	27	11	10,99	221501005	22,27
BSF 1/2 x 16	12,70	36	10	12,57	221501006	35,09
BSF 9/16 x 16	14,29	36	10	14,12	221501007	35,09
BSF 5/8 x 14	15,88	41	14	15,73	221501008	53,80
BSF 3/4 x 12	19,05	41	14	18,89	221501009	53,80
BSF 7/8 x 11	22,23	50	16	22,11	221501010	63,49
BSF 1" x 10	25,40	50	16	25,28	221501011	63,49

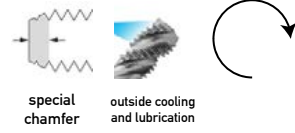
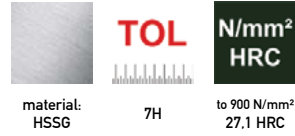
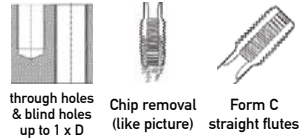
Short Machine Taps and Hand-Tap-Set

TR Trapezoidal thread
DIN 103

Efficient internal thread cutting.
The short structural type makes that tap usable by hand. The Short-Machine-Tap is also usable by machine.

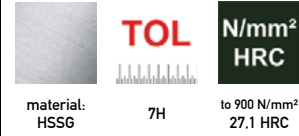
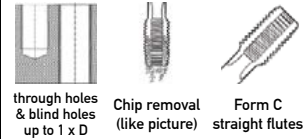
A Hand-Tap-Set includes 3 taps:
Taper Tap
Intermediate Tap
Finish Tap

Hand Tap Sets for general use



Hand Tap Sets for general use

Left Hand



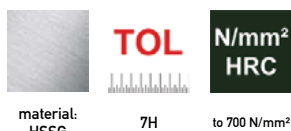
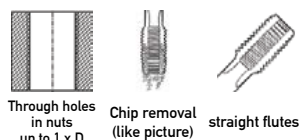
TR	D2	L1	L2	□		No.	€	No.	€
TR 9 x 1,5	7,0	100,0	22	5,5	7,60	230301001	*	230302001	*
TR 10 x 1,5	7,0	100,0	22	5,5	8,60	230301002	436,71	230302002	681,39
TR 10 x 2	7,0	90,0	34	5,5	8,20	230301003	330,79	230302003	749,42
TR 10 x 3	7,0	100,0	40	5,5	7,60	230301004	330,79	230302004	749,42
TR 11 x 2	8,0	100,0	22	6,2	9,20	230301005	553,01	230302005	862,44
TR 12 x 2	9,0	110,0	25	7,0	10,20	230301006	480,27	230302006	749,42
TR 12 x 3	8,0	110,0	40	6,2	9,25	230301007	344,25	230302007	749,42
TR 14 x 2	11,0	110,0	26	9,0	12,20	230301008	652,86	230302008	989,72
TR 14 x 3	10,0	130,0	45	8,0	11,25	230301009	438,77	230302009	899,75
TR 14 x 4	10,0	130,0	55	8,0	10,70	230301010	438,77	230302010	899,75
TR 16 x 2	12,0	110,0	27	9,0	14,20	230301011	652,86	230302011	989,72
TR 16 x 4	11,0	140,0	55	9,0	12,25	230301012	438,80	230302012	899,75
TR 18 x 2	14,0	125,0	27	11,0	16,20	230301013	921,69	230302013	1437,40
TR 18 x 4	12,0	150,0	55	9,0	14,25	230301014	624,42	230302014	1330,96
TR 20 x 2	16,0	140,0	27	12,0	18,20	230301015	987,53	230302015	1538,34
TR 20 x 4	14,0	160,0	55	11,0	16,25	230301016	658,18	230302016	1424,23
TR 22 x 3	18,0	160,0	34	14,5	19,25	230301017	1245,38	230302017	1943,23
TR 22 x 5	16,0	175,0	65	12,0	17,30	230301018	833,65	230302018	1799,49
TR 24 x 3	18,0	160,0	36	14,5	21,25	230301019	1382,54	230302019	2145,12
TR 24 x 5	18,0	190,0	65	14,5	19,30	230301020	914,72	230302020	1986,02
TR 26 x 3	20,0	160,0	36	16,0	23,25	230301021	1525,18	230302021	2368,96
TR 26 x 5	20,0	210,0	70	16,0	21,30	230301022	1015,86	230302022	2164,87
TR 28 x 3	22,0	180,0	40	18,0	25,25	230301023	1662,33	230302023	2588,41
TR 28 x 5	22,0	220,0	70	18,0	23,30	230301024	1107,07	230302024	2398,59
TR 30 x 3	22,0	180,0	40	18,0	27,25	230301025	1811,45	230302025	2827,61
TR 30 x 6	22,0	240,0	80	18,0	24,30	230301026	1181,26	230302026	2547,81
TR 32 x 6	25,0	255,0	80	20,0	26,30	230301027	1437,90	230302027	2946,12

* on request

Machine Nut Taps

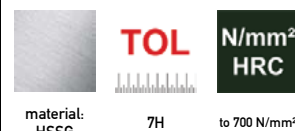
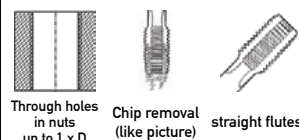
TR Trapezoidal thread
DIN 103

Machine Nut Taps for general use

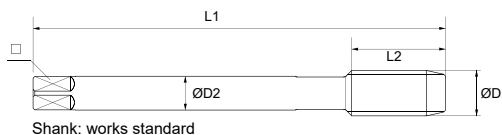


Machine Nut Taps for general use

Left Hand



Machine Nut Tap with long shank for cutting Nuts.
For all through holes up to a max. thread depth of 1,0 x diameter.
Please note that this tap can only take cutting forces up to 1,0 times diameter.



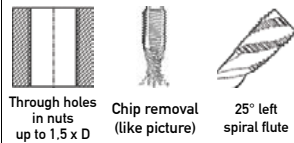
TR	D2	L1	L2	□		No.	€	No.	€
TR 8 x 1,5	6,0	90,0	55	4,9	6,70				
TR 9 x 2	7,0	110,0	63	5,5	7,20				
TR 10 x 2	7,0	110,0	63	5,5	8,20	230901001	231,74	230902001	325,31
TR 10 x 3	7,0	125,0	75	5,5	7,60	230901002	231,74	230902002	325,31
TR 12 x 2	9,0	135,0	75	7,0	10,20				
TR 12 x 3	8,0	165,0	111	6,2	9,25	230901003	200,52	230902003	280,67
TR 14 x 2	10,0	150	90	8,0	12,20				
TR 14 x 3	10,0	140	85	8,0	11,25	230901004	213,83	230902004	300,81
TR 14 x 4	10,0	170	112	8,0	10,70	230901005	213,83	230902005	300,81
TR 16 x 2	12,0	160	90	9,0	14,20				
TR 16 x 4	11,0	180	116	9,0	12,25	230901006	233,96	230902006	325,31
TR 18 x 2	14,0	175	90	11,0	16,20				
TR 18 x 4	12,0	190	120	9,0	14,25	230901007	239,55	230902007	325,26
TR 20 x 2	16,0	185	105	12,0	18,20				
TR 20 x 4	14,0	200	124	11,0	16,25	230901008	248,46	230902008	348,59
TR 22 x 3	16,0	220	125	12,0	19,25				
TR 22 x 4	16,0	210	130	12,0	18,25	230901009	322,99		
TR 22 x 5	16,0	235	155	12,0	17,30	230901010	322,99	230902009	451,05
TR 24 x 3	18,0	220	130	14,5	21,25				
TR 24 x 5	18,0	245	160	14,5	19,30	230901011	369,81	230902010	517,90
TR 26 x 3	20,0	235	130	16,0	23,25				
TR 26 x 5	20,0	255	165	16,0	21,30	230901012	389,88	230902011	541,31
TR 28 x 3	22,0	245	140	18,0	25,25				
TR 28 x 5	22,0	265	170	18,0	23,30	230901013	434,41	230902012	602,57
TR 30 x 3	22,0	250	140	18,0	27,25				
TR 30 x 6	22,0	290	185	18,0	24,30	230901014	506,80	230902013	707,33
TR 32 x 6	25,0	300	191	20,0	26,30	230901015	623,74	230902014	857,58
TR 36 x 6	28,0	310	200	22,0	30,50	230901016	634,94	230902015	879,92

Machine Nut Taps

TR Trapezoidal thread DIN 103

Machine Nut Tap with long shank for cutting Nuts.
For all through holes up to a max. thread depth of 1,5 x diameter.
Please note that this tap can only take cutting forces up to 1,5 times diameter.

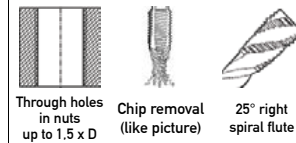
Machine Nut Taps for stainless steels



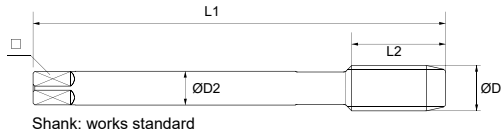
Through holes in nuts up to 1.5 x D
Chip removal (like picture)
25° left spiral flute
material: HSSE-nitrated
7H
to 900 N/mm²
27.1 HRC



Machine Nut Taps for stainless steels Left Hand



Through holes in nuts up to 1.5 x D
Chip removal (like picture)
25° right spiral flute
material: HSSE-nitrated
7H
to 900 N/mm²
27.1 HRC



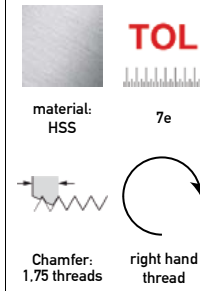
TR	D2	L1	L2	□		No.	€	No.	€
TR 8 x 1,5	6,0	90,0	55	4,9	6,70	230905001	*	230905001L	*
TR 9 x 2	7,0	110,0	63	5,5	7,20	230905002	*	230905002L	*
TR 10 x 2	7,0	110,0	63	5,5	8,20	230905003	*	230905003L	*
TR 10 x 3	7,0	125,0	75	5,5	7,60	230905004	*	230905004L	*
TR 12 x 2	9,0	135,0	75	7,0	10,20	230905005	*	230905005L	*
TR 12 x 3	8,0	165,0	111	6,2	9,25	230905006	*	230905006L	*
TR 14 x 2	10,0	150,0	90	8,0	12,20	230905007	*	230905007L	*
TR 14 x 3	10,0	140,0	85	8,0	11,25	230905008	*	230905008L	*
TR 14 x 4	10,0	170,0	112	8,0	10,70	230905009	*	230905009L	*
TR 16 x 2	12,0	160,0	90	9,0	14,20	230905010	*	230905010L	*
TR 16 x 4	11,0	180,0	116	9,0	12,25	230905011	*	230905011L	*
TR 18 x 2	14,0	175,0	90	11,0	16,20	230905012	*	230905012L	*
TR 18 x 4	12,0	190,0	120	9,0	14,25	230905013	*	230905013L	*
TR 20 x 2	16,0	185,0	105	12,0	18,20	230905014	*	230905014L	*
TR 20 x 4	14,0	200,0	124	11,0	16,25	230905015	*	230905015L	*
TR 22 x 3	16,0	220,0	125	12,0	19,25	230905016	*	230905016L	*
TR 22 x 4	16,0	210,0	130	12,0	18,25	230905017	*	230905017L	*
TR 22 x 5	16,0	235,0	155	12,0	17,30	230905018	*	230905018L	*
TR 24 x 3	18,0	220,0	130	14,5	21,25	230905019	*	230905019L	*
TR 24 x 5	18,0	245,0	160	14,5	19,30	230905020	*	230905020L	*
TR 26 x 3	20,0	235,0	130	16,0	23,25	230905021	*	230905021L	*
TR 26 x 5	20,0	255,0	165	16,0	21,30	230905022	*	230905022L	*
TR 28 x 3	22,0	245,0	140	18,0	25,25	230905023	*	230905023L	*
TR 28 x 5	22,0	265,0	170	18,0	23,30	230905024	*	230905024L	*
TR 30 x 3	22,0	250,0	140	18,0	27,25	230905025	*	230905025L	*
TR 30 x 6	22,0	290,0	185	18,0	24,30	230905026	*	230905026L	*
TR 32 x 6	25,0	300,0	191	20,0	26,30	230905027	*	230905027L	*

* on request

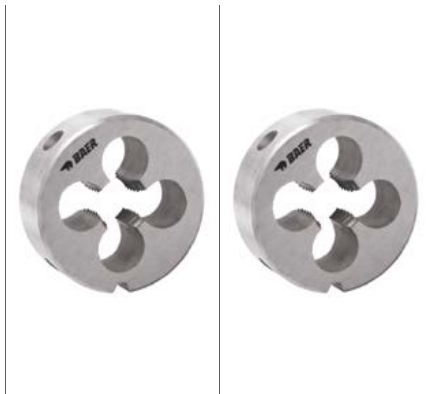
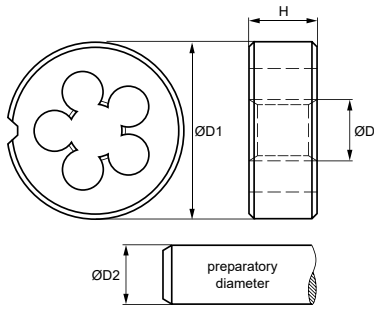
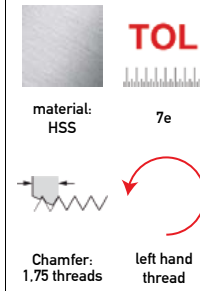
Round Dies

TR Trapezoidal thread DIN 103

Round Dies for general use



Round Dies for general use Left Hand



TR	D1	H	D2	No.	€	No.	€
TR 10 x 2	38,0	14	9,91	231401001	110,85	231402001	253,05
TR 10 x 3	38,0	14	9,88	231401002	158,05	231402002	*
TR 12 x 2	38,0	14	11,91	231401003	158,05	231402003	*
TR 12 x 3	38,0	14	11,88	231401004	120,20	231402004	352,28
TR 14 x 2	38,0	14	13,91	231401005	158,05	231402005	*
TR 14 x 3	45,0	18	13,88	231401006	169,18	231402006	399,00
TR 14 x 4	45,0	18	13,85	231401007	187,27	231402007	319,20
TR 16 x 2	45,0	18	15,91	231401008	220,37	231402008	*
TR 16 x 4	45,0	18	15,85	231401009	154,15	231402009	361,73
TR 18 x 2	45,0	18	17,91	231401010	247,09	231402010	*
TR 18 x 4	45,0	18	17,85	231401011	155,82	231402011	361,73
TR 20 x 2	45,0	18	19,91	231401012	251,54	231402012	*
TR 20 x 4	55,0	22	19,85	231401013	202,57	231402013	399,53
TR 22 x 5	55,0	22	21,84	231401014	268,23	231402014	822,15
TR 24 x 5	65,0	25	23,84	231401015	268,23	231402015	573,30
TR 26 x 5	65,0	25	25,84	231401016	268,23	231402016	822,15
TR 28 x 5	65,0	25	27,84	231401017	287,15	231402017	939,75
TR 30 x 6	65,0	25	29,82	231401018	323,88	231402018	930,30

* on request

Short Machine Taps

NPT

National standard taper 1:16
pipe thread ANSI B 1.20.1

NPTF

National standard sealing
pipe thread ANSI B 1.20.3

Short Machine Taps

Form D for through holes
and blind holes



through holes
& blind holes
up to 2 x D



Chip removal
(like picture)



Form C
straight flutes



material:
HSSG



medium



to 900 N/mm²
27,1 HRC



2-3 threads

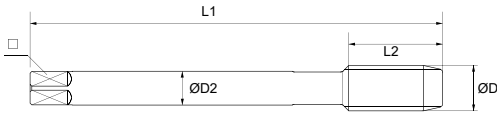


outside cooling
and lubrication



Efficient internal thread cutting.
The short structural type makes that tap usable by
machine and hand.

Application:
non abrasive material up to 900 N/mm²
unalloyed and low alloyed steel



NPT	D1	D2	L1	L2	□		No.	€
NPT 1/16 x 27	7,90	19,0	65	19	5,5	6,00	240101001	17,18
NPT 1/8 x 27	10,24	19,0	65	19	5,5	8,25	240101002	14,41
NPT 1/4 x 18	13,62	25,0	70	25	9,0	10,70	240101003	16,07
NPT 3/8 x 18	17,06	26,0	75	26	9,0	14,10	240101004	22,16
NPT 1/2 x 14	21,22	31,0	80	31	12,0	17,40	240101005	27,71
NPT 3/4 x 14	26,57	33,0	100	33	16,0	22,60	240101006	37,13
NPT 1" x 11,5	33,23	38,0	110	38	20,0	28,50	240101007	58,17
NPT 1.1/4 x 11,5	41,99	41,0	125	41	24,0	37,00	240101008	89,09
NPT 1.1/2 x 11,5	48,05	42,0	140	42	29,0	43,50	240101009	167,07
NPT 2" x 11,5	60,09	44,0	160	44	29,0	55,00	240101010	206,04

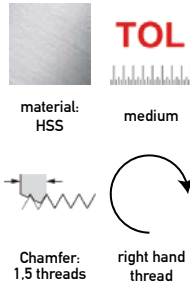
NPTF	D1	D2	L1	L2	□		No.	€
NPTF 1/16 x 27	7,87	19,0	65	19	5,5	6,00	250101001	21,16
NPTF 1/8 x 27	10,22	19,0	65	19	5,5	8,25	250101002	17,04
NPTF 1/4 x 18	13,58	25,0	70	25	9,0	10,70	250101003	20,05
NPTF 3/8 x 18	17,02	26,0	75	26	9,0	14,10	250101004	25,61
NPTF 1/2 x 14	21,21	31,0	80	31	12,0	17,40	250101005	32,19
NPTF 3/4 x 14	26,57	33,0	100	33	16,0	22,60	250101006	42,87
NPTF 1" x 11,5	33,20	38,0	110	38	20,0	28,50	250101007	69,05
NPTF 1.1/4 x 11,5	41,95	41,0	125	41	24,0	37,00	250101008	102,91
NPTF 1.1/2 x 11,5	48,02	42,0	140	42	29,0	43,50	250101009	171,52
NPTF 2" x 11,5	60,06	44,0	160	44	29,0	55,00	250101010	228,32

Round Dies and Hexagon Die Nuts

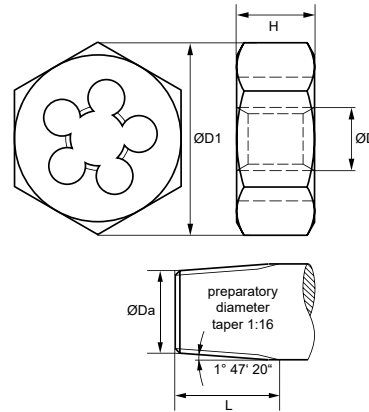
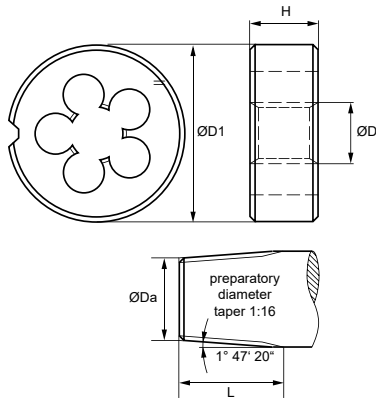
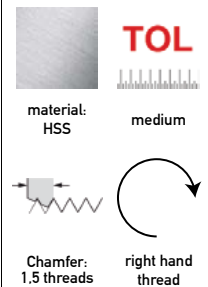
NPT

National standard taper 1:16 pipe thread ANSI B 1.20.1

Round Dies for general use



Hexagon Die Nuts for general use



NPT

	D	D1	H	Da x L	No.	€
NPT 1/16 x 27	7,90	25	9	7,58 x 8,4	241401001	35,08
NPT 1/8 x 27	10,24	30	11	9,93 x 8,5	241401002	37,31
NPT 1/4 x 18	13,62	38	14	13,18 x 12,7	241401003	45,67
NPT 3/8 x 18	17,06	45	14	16,60 x 12,9	241401004	57,91
NPT 1/2 x 14	21,22	45	18	20,63 x 16,8	241401005	57,91
NPT 5/8 x 14	23,90	55	22		241401006	92,44
NPT 3/4 x 14	26,57	55	22	25,95 x 17,1	241401007	92,44
NPT 7/8 x 14	29,90	65	25		241401008	136,99
NPT 1" x 11,5	33,23	65	25	32,51 x 21,3	241401009	136,99
NPT 1.1/4 x 11,5	41,99	75	26	41,23 x 21,9	241401010	161,50
NPT 1.1/2 x 11,5	48,05	90	27	47,30 x 22,3	241401011	263,95
NPT 2" x 11,5	60,09	105	28	59,31 x 23,1	241401012	348,59

NPT

	D	D1	H	Da x L	No.	€
NPT 1/16 x 27	7,90	22	9	7,58 x 8,4	241501001	46,90
NPT 1/8 x 27	10,24	27	11	9,93 x 8,5	241501002	50,80
NPT 1/4 x 18	13,62	36	14	13,18 x 12,7	241501003	62,52
NPT 3/8 x 18	17,06	41	14	16,60 x 12,9	241501004	78,15
NPT 1/2 x 14	21,22	41	14	20,63 x 16,8	241501005	78,15
NPT 3/4 x 14	26,57	50	22	25,95 x 17,1	241501006	123,76
NPT 1" x 11,5	33,23	60	25	32,51 x 21,3	241501007	182,37
NPT 1.1/4 x 11,5	41,99	70	25	41,23 x 21,9	241501008	217,54
NPT 1.1/2 x 11,5	48,05	85	28	47,30 x 22,3	241501009	351,70
NPT 2" x 11,5	60,09	100	28	59,31 x 23,1	241501010	475,45

Short Machine Taps and Round Dies

NPS

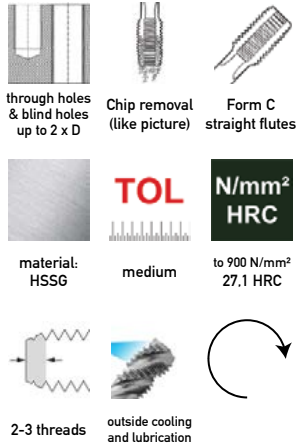
National standard straight pipe thread

Efficient internal thread cutting.
The short structural type makes that tap usable by machine and hand.

Application:
non abrasive material up to 900 N/mm²
unalloyed and low alloyed steel

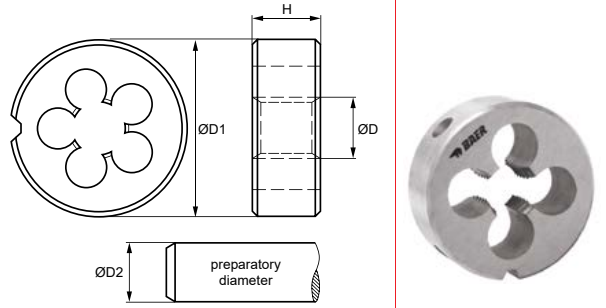
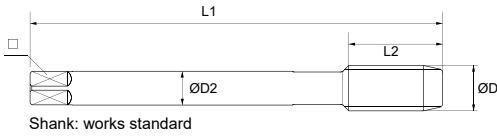
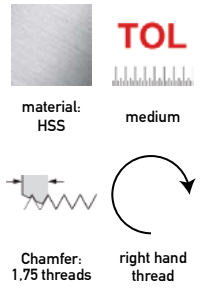
Short Machine Taps

Form C for through holes and blind holes



Round Dies

for general use



NPS

NPS	D1	D2	L1	L2	□	✎	No.	€
NPS 1/16 x 27	7,90	8,0	54	18	6,0	6,40	260101001	19,20
NPS 1/8 x 27	10,24	8,0	55	19	6,0	8,90	260101002	16,56
NPS 1/4 x 18	13,62	11,0	62	28	9,0	11,50	260101003	19,44
NPS 3/8 x 18	17,06	14,0	65	28	11,0	15,00	260101004	23,52
NPS 1/2 x 14	21,22	18,0	80	35	14,0	18,50	260101005	29,16
NPS 3/4 x 14	26,57	23,0	85	35	17,0	23,80	260101006	38,40
NPS 1" x 11,5	33,23	26,0	95	45	21,0	29,90	260101007	61,20
NPS 1,1/4 x 11,5	41,99	32,0	105	45	26,0	38,60	260101008	92,40
NPS 1,1/2 x 11,5	48,05	38,0	110	45	29,0	44,70	260101009	206,40
NPS 2" x 11,5	60,09	46,0	120	50	35,0	56,70	260101010	331,20

NPSM

NPSM	D	D1	H	D2	No.	€
NPSM 1/8 x 27	10,24	30	11	9,99	261401001	176,82
NPSM 1/4 x 18	13,62	38	10	13,25	261401002	184,80
NPSM 3/8 x 18	17,06	45	14	16,70	261401003	208,85
NPSM 1/2 x 14	21,22	45	14	20,78	261401004	199,50
NPSM 3/4 x 14	26,57	55	16	26,14	261401005	301,35
NPSM 1" x 11,5	33,23	65	18	32,69	261401006	*
NPSM 1.1/4 x 11,5	41,99	75	20	41,45	261401007	*

* on request

Short Machine Taps and Hexagon Die Nuts

RC (BSPT)

Whitworth tapered pipe thread
DIN 2999

RP (BSPP)

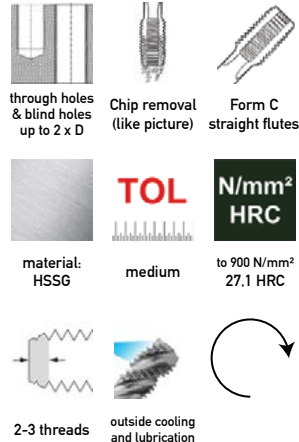
British standard whitworth pipe thread
ISO 7-1

Efficient internal thread cutting.
The short structural type makes that tap usable by machine and hand.

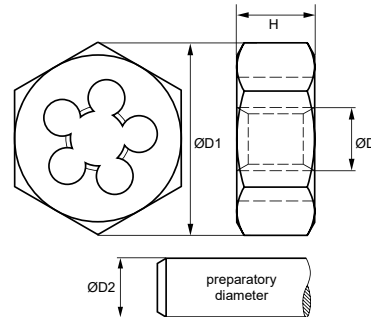
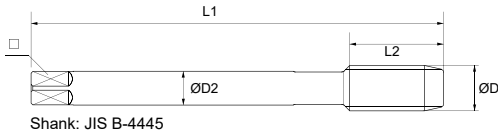
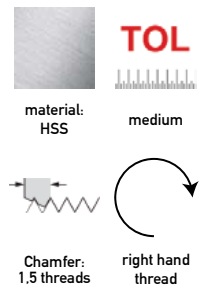
Application:
non abrasive material up to 900 N/mm²
unalloyed and low alloyed steel

Short Machine Taps

Form C for through holes and blind holes



Hexagon Die Nuts for general use



RC (BSPT)	D1	D2	L1	L2	□	✎	No.	€
RC 1/16 x 28	7,72	8,0	55	17,5	6,0	6,30	*	
RC 1/8 x 28	9,73	8,0	55	19	6,0	8,30	270101001	8,80
RC 1/4 x 19	13,16	11,0	62	28	9,0	11,10	270101002	10,24
RC 3/8 x 19	16,66	14,0	65	28	11,0	14,50	270101003	16,15
RC 1/2 x 14	20,95	18,0	80	35	14,0	18,10	270101004	20,27
RC 3/4 x 14	26,44	23,0	85	35	17,0	23,50	270101005	29,73
RC 1" x 11	33,25	26,0	95	45	21,0	29,50	270101006	44,88
RC 1.1/4 x 11	41,91	32,0	105	45	26,0	38,25		*
RC 1.1/2 x 11	47,80	38,0	110	45	29,0	44,25		*
RC 2" x 11	59,61	46,0	120	50	35,0	56,00		*

R (BSPT)	D	D1	H	No.	€
R 1/8 x 28	9,73	27	11	271501001	43,44
R 1/4 x 19	13,16	36	14	271501002	53,46
R 3/8 x 19	16,66	41	15	271501003	66,83
R 1/2 x 14	20,95	50	19	271501004	66,83
R 3/4 x 14	26,44	60	20	271501005	105,81
R 1" x 11	33,25	60	25	271501006	155,93
R 1.1/4 x 11	41,91	85	26	271501007	185,99
R 1.1/2 x 11	47,80	85	26	271501008	300,71
R 2" x 11	59,61	100	31	271501009	406,52

RP (BSPP)

RP 1/16 x 28	7,72	8,0	55	18	6,0	6,55	280101001	8,25
RP 1/8 x 28	9,73	8,0	55	19	6,0	8,60	280101002	8,25
RP 1/4 x 19	13,16	11,0	62	28	9,0	11,50	280101003	10,13
RP 3/8 x 19	16,66	14,0	65	28	11,0	15,00	280101004	16,26
RP 1/2 x 14	20,95	18,0	80	35	14,0	18,50	280101005	25,00
RP 3/4 x 14	26,44	23,0	85	35	17,0	24,00	280101006	43,13
RP 1" x 11	33,25	26,0	95	45	21,0	30,25	280101007	56,25
RP 1.1/4 x 11	41,91	32,0	105	45	26,0	38,75	280101008	85,01
RP 1.1/2 x 11	47,80	38,0	110	45	29,0	44,75	280101009	117,49
RP 2" x 11	59,61	46,0	120	50	35,0	56,50	280101010	178,76

* on request

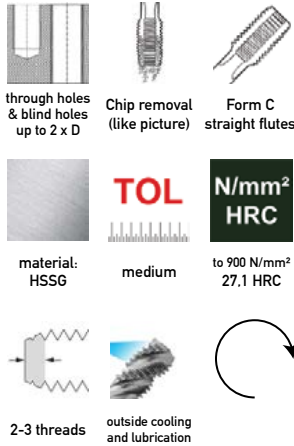
Hand Tap Sets (conical) and Round Dies

BA British Association thread
BS 93

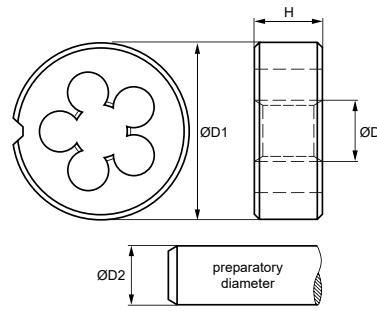
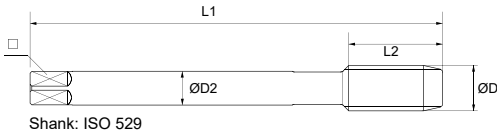
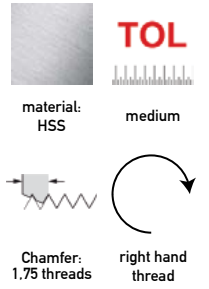
Efficient internal thread cutting.
The short structural type makes that tap usable by hand. The Short-Machine-Tap is also usable by machine.

A Hand-Tap-Set includes 3 taps:
Taper Tap
Intermediate Tap
Finish Tap

Hand Tap Sets for general use



Round Dies for general use



BA	D1	D2	L1	L2	□	✎	No.	€
BA 0	6,00	6,3	66	19,0	5,0	5,10	290313001	19,38
BA 1	5,30	5,6	62	17,0	4,5	4,50	290313002	19,38
BA 2	4,70	5,0	58	16,0	4,0	4,00	290313003	19,38
BA 3	4,10	4,5	53	13,0	3,6	3,40	290313004	19,38
BA 4	3,60	3,6	50	13,0	2,8	3,00	290313005	19,38
BA 5	3,20	3,2	48	11,0	2,5	2,65	290313006	19,38
BA 6	2,80	2,8	45	9,5	2,2	2,30	290313007	19,38

BA	D	D1	H	D2	No.	€
BA 0	6,00	20,6	6,35	5,90	291401001	13,30
BA 1	5,30	20,6	6,35	5,21	291401002	13,30
BA 2	4,70	20,6	6,35	4,61	291401003	13,30
BA 3	4,10	20,6	6,35	4,02	291401004	13,30
BA 4	3,60	20,6	6,35	3,52	291401005	13,30
BA 5	3,20	20,6	6,35	3,14	291401006	13,30
BA 6	2,80	20,6	6,35	2,74	291401007	13,30
BA 7	2,50	20,6	6,35	2,44	291401008	*
BA 8	2,20	20,6	6,35	2,15	291401009	*
BA 10	1,70	20,6	6,35	1,66	291401010	*

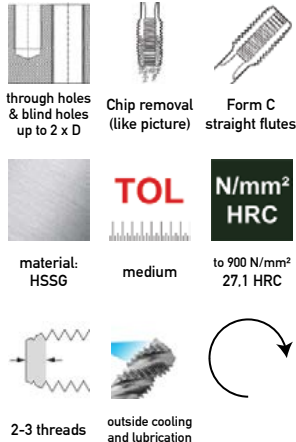
* on request

Short Machine Taps and Round Dies

W Tapered whitworth DIN 477
for screw sockets taper 3:25

Short Machine Taps

Form C for through holes
and blind holes

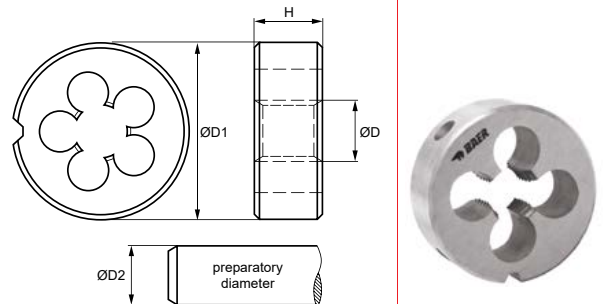
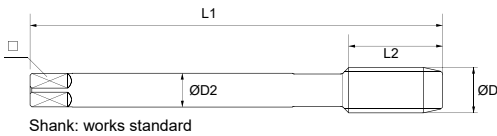
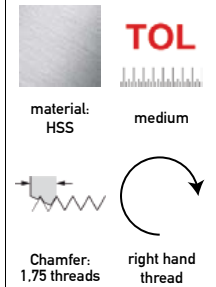


Efficient internal thread cutting.
The short structural type makes that tap usable by machine and hand.

Application:
non abrasive material up to 900 N/mm²
unalloyed and low alloyed steel

Round Dies

for general use



W	D1	D2	L1	L2	□	🔧	No.	€
W 19,8 x 14 conical	19,80	16,0	90	32	12,0	14,70	300101001	158,13
W 28,8 x 14 conical	28,80	22,0	100	40	18,0	22,70	300101002	178,20
W 31,3 x 14 conical	31,30	22,0	110	40	18,0	25,20	300101003	204,93
W 21,8 x 14 cyl. - right	21,80	18,0	80	22	14,5	19,75	310101004	*
W 21,8 x 14 cyl. - left	21,80	18,0	80	22	14,5	19,75	310101005	*
W 24,32 x 14 cylindrical	24,32	18,0	90	22	14,5	22,25	310101006	*

* on request

W	D	D1	H	D2	No.	€
W 19,8 x 14 conical	19,80	45	25	17,34	301401001	405,83
W 28,8 x 14 conical	28,80	65	30	25,74	301401002	580,65
W 21,8 x 14 cyl. - right	21,80	55	16	21,58	311401003	274,58
W 21,8 x 14 cyl. - left	21,80	55	16	21,58	311401004	302,40
W 24,32 x 14 cylindrical	24,32	55	16	24,10	311401005	369,60

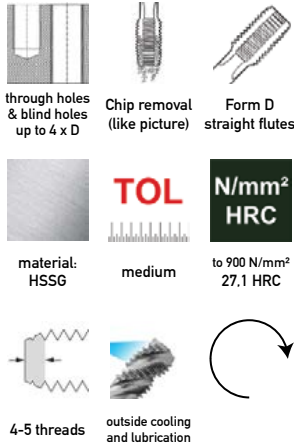
Short Machine Taps and Round Dies

PG Steel Conduit Thread DIN 40430

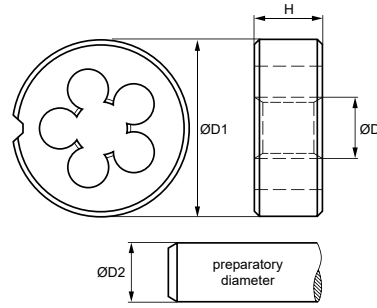
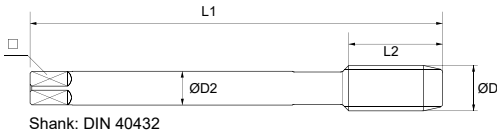
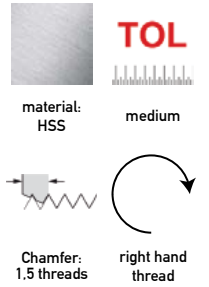
Efficient internal thread cutting.
The short structural type makes that tap usable by machine and hand.

Application:
non abrasive material up to 900 N/mm²
unalloyed and low alloyed steel

Short Machine Taps Form D for through holes and blind holes



Round Dies for general use



PG	D1	D2	L1	L2	□	✂	No.	€
PG 7 x 20	12,50	9,0	70	22	7,0	11,35	320101001	11,69
PG 9 x 18	15,20	12,0	70	22	9,0	13,95	320101002	15,60
PG 11 x 18	18,60	14,0	80	22	11,0	17,35	320101003	25,73
PG 13,5 x 18	20,40	16,0	80	22	12,0	19,15	320101004	30,40
PG 16 x 18	22,50	18,0	80	22	14,5	21,25	320101005	36,86
PG 21 x 16	28,30	22,0	90	22	18,0	26,90	320101006	50,34
PG 29 x 16	37,00	28,0	100	25	22,0	35,60	320101007	83,53
PG 36 x 16	47,00	36,0	140	40	29,0	45,60	320101008	133,65
PG 42 x 16	54,00	40,0	140	40	32,0	52,60	320101009	211,60
PG 48 x 16	59,30	45,0	160	40	35,0	57,90	320101010	250,59

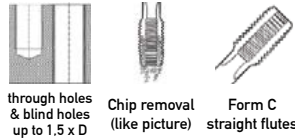
PG	D	D1	H	D2	No.	€
PG 7 x 20	12,50	38	10	12,50	321401001	43,22
PG 9 x 18	15,20	45	14	15,20	321401002	52,63
PG 11 x 18	18,60	45	14	18,60	321401003	52,63
PG 13,5 x 18	20,40	45	14	20,40	321401004	52,63
PG 16 x 18	22,50	55	16	22,50	321401005	62,05
PG 21 x 16	28,30	65	18	28,30	321401006	95,30
PG 29 x 16	37,00	65	18	37,00	321401007	95,30
PG 36 x 16	47,00	90	22	47,00	321401008	188,39
PG 42 x 16	54,00	105	22	54,00	321401009	239,34
PG 48 x 16	59,30	105	22	59,30	321401010	239,34

Machine Taps and Round Dies

FG Bicycle thread
DIN 79012
BSC British bicycle thread
RS 811

Short Machine Taps

Form C for through holes and blind holes



through holes & blind holes up to 1,5 x D
Chip removal (like picture)
Form C straight flutes



material: HSSE
medium
to 800 N/mm²



2-3 threads
outside cooling and lubrication

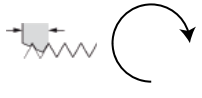
Tap for machine use in through hole and blind hole. The short lead-in chamfer makes that tap universal in application. The flutes can hold the most part of the chips.

Round Dies

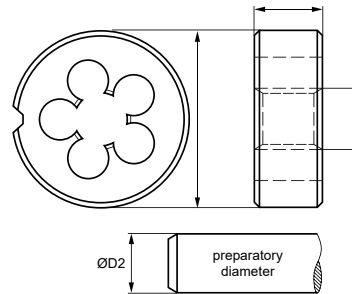
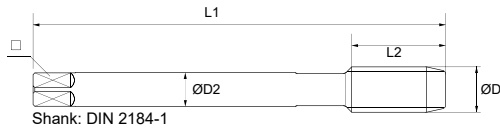
for general use



material: HSS
medium



Chamfer: 1.5 threads
right hand thread



FG	D1	D2	L1	L2	□	◻	No.	€
FG 6,35 x 26	6,35	7,0	80	14	5,5	5,50	330501001	73,70
FG 7,9 x 26	7,90	8,0	90	16	6,2	7,00	330501002	78,95
FG 9,5 x 26	9,50	7,0	90	16	5,5	8,60	330501003	78,95
FG 14,3 x 20 right	14,30	11,0	100	22	9,0	13,10	330501004	84,21
FG 14,3 x 20 left	14,30	11,0	100	22	9,0	13,10	330501005	94,75
FG 25,4 x 24	25,40	14,0	110	22	11,0	24,50	330501006	*

FG	D	D1	H	D2	No.	€
FG 6,35 x 26	6,35	20	7	6,24	331401001	37,90
FG 7,9 x 26	7,90	25	9	7,82	331401002	53,70
FG 9,5 x 26	9,50	30	11	9,40	331401003	74,75
FG 14,3 x 20 right	14,30	38	10	14,40	331401004	114,75
FG 14,3 x 20 left	14,30	38	10	14,40	331401005	137,90
FG 25,4 x 24	25,40	55	16	25,25	331401006	312,63

BSC	D1	D2	L1	L2	□	◻	No.	€
BSC 1/4 x 26	6,35	6,0	56	14	4,9	5,55	340101001	73,70
BSC 5/16 x 26	7,94	6,0	63	16	4,9	7,10	340101002	78,95
BSC 3/8 x 26	9,53	7,0	63	16	5,5	8,65	340101003	78,95
BSC 9/16 x 20 right	14,29	11,0	70	22	9,0	13,15	340101004	84,21
BSC 9/16 x 20 left	14,29	11,0	70	22	9,0	13,15	340101005	94,74
BSC 1" x 24	25,40	14,0	70	22	11,0	24,50	340101006	*

BSC	D	D1	H	D2	No.	€
BSC 1/4 x 26	6,35	20,6	6,35	6,24	341401001	37,90
BSC 5/16 x 26	7,94	25,4	9,5	7,82	341401002	53,70
BSC 3/8 x 26	9,53	25,4	9,5	9,40	341401003	74,75
BSC 7/16 x 26	11,11	25,4	9,5	10,98	341401004	*
BSC 9/16 x 20 right	14,29	38,1	12,7	14,14	341401005	114,75
BSC 9/16 x 20 left	14,29	38,1	12,7	14,14	341401006	137,90
BSC 1" x 24	25,40	55	16	25,25	341401007	312,63

* on request

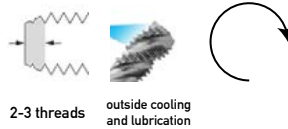
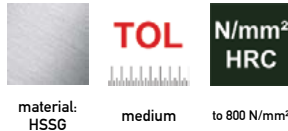
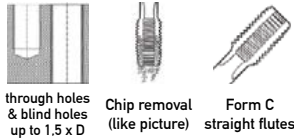
* on request

Machine Taps and Round Dies

RD knuckle thread
DIN 405

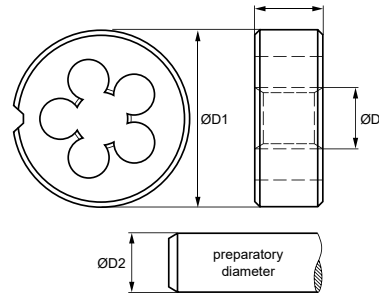
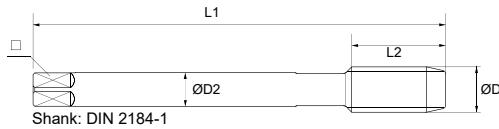
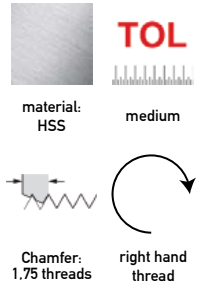
RMS Royal Microscopical
Society DIN 58888

Short Machine Taps
Form C for through holes
and blind holes



Tap for machine use in through hole and blind hole. The short lead-in chamfer makes that tap universal in application. The flutes can hold the most part of the chips.

Round Dies
for general use



RD	D1	D2	L1	L2	□		No.	€
Rd 8 x 1/10	8,25	6,0	90	26	4,9	5,71	350501001	77,40
Rd 9 x 1/10	9,25	7,0	90	26	5,5	6,71	350501002	77,40
Rd 10 x 1/10	10,25	7,0	100	28	5,5	7,71	350501003	77,40
Rd 11 x 1/10	11,25	8,0	100	28	6,2	8,71	350501004	94,75
Rd 12 x 1/10	12,25	9,0	110	28	7,0	9,71	350501005	105,25
Rd 14 x 1/8	14,32	11,0	110	32	9,0	11,14	350501006	132,65
Rd 16 x 1/8	16,32	12,0	110	32	9,0	13,14	350501007	138,95
Rd 18 x 1/8	18,32	14,0	125	32	11,0	15,14	350501008	133,30
Rd 20 x 1/8	20,32	16,0	140	32	12,0	17,14	350501009	166,30
Rd 22 x 1/8	22,32	18,0	140	32	14,5	19,14	350501010	215,80
Rd 24 x 1/8	24,32	18,0	160	34	14,5	21,14	350501011	260,00
Rd 26 x 1/8	26,32	20,0	160	36	16,0	23,14	350501012	304,20
Rd 28 x 1/8	28,32	20,0	160	36	16,0	25,14	350501013	326,32
Rd 30 x 1/8	30,32	22,0	180	36	18,0	27,14	350501014	343,16
Rd 32 x 1/8	32,82	25,0	180	36	20,0	29,14	350501015	458,95
Rd 34 x 1/8	34,32	28,0	200	36	22,0	31,14	350501016	521,05
Rd 36 x 1/8	36,32	28,0	200	36	22,0	33,14	350501017	525,26
Rd 38 x 1/8	38,32	28,0	200	38	22,0	35,14	350501018	608,42
Rd 40 x 1/6	40,42	32,0	200	50	24,0	36,19	350501019	718,95

RD	D	D1	H	D2	No.	€
Rd 10 x 1/10	10,25	38	14	9,84	351401001	325,50
Rd 11 x 1/10	11,25	38	14	10,84	351401002	325,50
Rd 12 x 1/10	12,25	38	14	11,84	351401003	325,50
Rd 14 x 1/8	14,32	45	18	13,82	351401004	367,50
Rd 16 x 1/8	16,32	45	18	15,82	351401005	367,50
Rd 18 x 1/8	18,32	45	18	17,82	351401006	367,50
Rd 20 x 1/8	20,32	55	22	19,82	351401007	504,00
Rd 22 x 1/8	22,32	55	22	21,82	351401008	504,00
Rd 24 x 1/8	24,32	55	22	23,82	351401009	504,00
Rd 26 x 1/8	26,32	65	25	25,82	351401010	632,10
Rd 28 x 1/8	28,32	65	25	27,82	351401011	632,10
Rd 30 x 1/8	30,32	65	25	29,82	351401012	632,10
Rd 32 x 1/8	32,82	65	25	31,82	351401013	632,10

RMS	D1	D2	L1	L2	□		No.	€
W 0,8 x 36	20,35	16,0	80	18	12,0	19,45	360501001	*

* on request

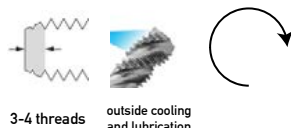
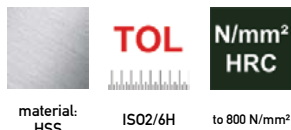
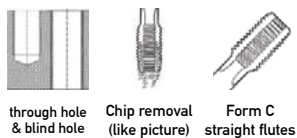
RMS	D	D1	H	D2	No.	€
W 0,8 x 36	20,35	45	14	20,00	361401002	*

* on request

Mini Gewindebohrer - Form C (straight flutes) for through holes and blind holes

MINI Metric Mini-thread and Nano-thread

Machine Tap
for general use



Efficient internal thread cutting in clock and watch industry as well as apparatus construction and fine mechanics.

For through and blind holes. Very break-proof. Suitable for automatic lathe and tapping machine.



MINI

	D1	D2	L1	L2			No.	packing unit [PU]	€ per PU
M 0,3 x 0,08	0,3	1,0	22	2	0,2	0,24	370501001	10 pieces	*
M 0,35 x 0,09	0,4	1,0	22	2	0,3	0,28	370501002	10 pieces	*
M 0,4 x 0,1	0,4	1,0	22	2,5	0,3	0,32	370501003	10 pieces	*
M 0,5 x 0,125	0,5	1,0	22	3	0,4	0,40	370501004	10 pieces	*
M 0,6 x 0,15	0,6	1,0	22	3,5	0,5	0,49	370501005	10 pieces	*
M 0,7 x 0,175	0,7	1,5	25	4,5	0,6	0,57	370501006	10 pieces	*
M 0,8 x 0,2	0,8	1,5	25	5	0,7	0,65	370501007	10 pieces	*
M 0,9 x 0,225	0,9	1,5	25	5,5	0,8	0,73	370501008	10 pieces	*
M 1 x 0,15	1,0	1,5	25	6	0,9	0,89	370501009	10 pieces	*
M 1 x 0,2	1,0	1,5	25	6	0,9	0,85	370501010	10 pieces	*
M 1 x 0,25	1,0	1,5	25	6	0,8	0,81	370501011	10 pieces	*
M 1,1 x 0,25	1,1	1,5	25	7	0,9	0,91	370501012	10 pieces	*
M 1,2 x 0,15	1,2	1,5	25	7	1,1	1,09	370501013	10 pieces	*
M 1,2 x 0,2	1,2	1,5	25	7	1,1	1,05	370501014	10 pieces	*
M 1,2 x 0,25	1,2	1,5	25	7	1,0	1,01	370501015	10 pieces	*
M 1,3 x 0,3	1,3	1,5	25	8	1,1	1,07	370501016	10 pieces	*
M 1,4 x 0,2	1,4	2,0	30	9	1,3	1,25	370501017	10 pieces	*
M 1,4 x 0,25	1,4	2,0	30	9	1,2	1,21	370501018	10 pieces	*
M 1,4 x 0,3	1,4	2,0	30	8,5	1,2	1,17	370501019	10 pieces	*
M 1,5 x 0,3	1,5	2,0	30	10	1,3	1,27	370501020	10 pieces	*
M 1,6 x 0,2	1,6	2,0	30	10	1,5	1,45	370501021	10 pieces	*
M 1,6 x 0,25	1,6	2,0	30	10	1,4	1,41	370501022	10 pieces	*
M 1,6 x 0,35	1,6	2,0	30	10	1,3	1,30	370501023	10 pieces	*
M 1,7 x 0,35	1,7	2,0	30	10	1,4	1,40	370501024	10 pieces	*
M 1,8 x 0,2	1,8	2,0	30	10	1,7	1,65	370501025	10 pieces	*
M 1,8 x 0,25	1,8	2,0	30	10	1,6	1,61	370501026	10 pieces	*
M 1,8 x 0,35	1,8	2,0	30	10	1,5	1,50	370501027	10 pieces	*
M 2 x 0,2	2,0	3,0	35	13	1,9	1,85	370501028	10 pieces	*
M 2 x 0,25	2,0	3,0	35	13	1,8	1,81	370501029	10 pieces	*
M 2 x 0,4	2,0	3,0	35	13	1,7	1,65	370501030	10 pieces	*
M 2,2 x 0,45	2,2	3,0	35	13	1,8	1,80	370501031	10 pieces	*
M 2,3 x 0,4	2,3	3,0	35	13	2,0	1,95	370501032	10 pieces	*
M 2,4 x 0,45	2,4	3,0	40	15	2,0	2,00	370501033	10 pieces	*
M 2,5 x 0,45	2,5	3,0	40	15	2,1	2,10	370501034	10 pieces	*
M 2,6 x 0,45	2,6	3,0	40	15	2,2	2,20	370501035	10 pieces	*

* on request

Short Machine Taps and Hand Tap Sets

Camera-Tripod

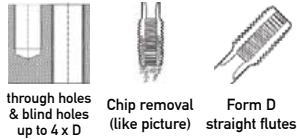
Camera tripod & C-Mount thread
DIN 4503

Efficient internal thread cutting.
The short structural type makes that tap usable by hand.
The Short-Machine-Tap is also usable by machine.

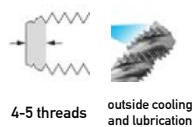
A Hand-Tap-Set includes 2 taps:
Taper Tap
Finish Tap

Short Machine Taps

Form D for through holes and blind holes

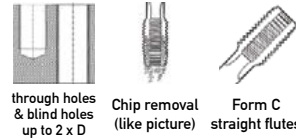


through holes & blind holes up to 4 x D
Chip removal (like picture)
Form D straight flutes

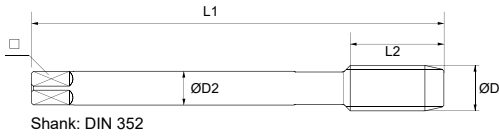
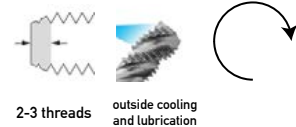


Hand Tap Sets

for general use



through holes & blind holes up to 2 x D
Chip removal (like picture)
Form C straight flutes



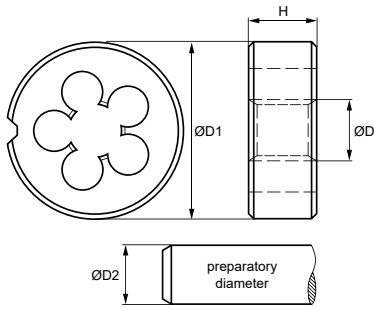
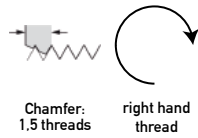
Camera	D1	D2	L1	L2	□		No.	€	No.	€
Cam.-Tripod 1/4"	6,35	6,0	50	19	4,9	5,20	380101001	29,09		
Cam.-Tripod 3/8"	9,53	7,0	70	24	5,5	8,00	380101002	40,53		
C-Mount 1" x 32	25,40	18,0	130	45	14,0	23,75	380101003	387,45		
S-Mount 12 x 0,5	12,00	9,0	70	22	7,0	11,50			380301004	99,73

Round Dies

Camera-Tripod

Camera tripod & C-Mount thread
DIN 4503

Round Dies
for general use

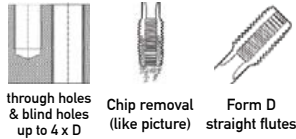


Camera	D	D1	H	D2	No.	€
Camera-Tripod 1/4"	6,35	20	7	6,22	381401001	37,59
Camera-Tripod 3/8"	9,53	20	7	9,37	381401002	50,40
C-Mount 1" x 32	25,40	55	16	25,25	381401003	271,43
S-Mount 12 x 0,5	12,00	38	10	11,92	381401004	100,11

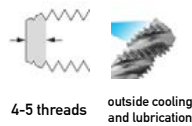
Taps

VG Valve thread DIN 7756

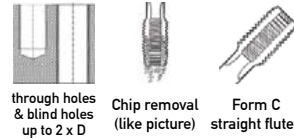
Short Machine Taps Form D for through holes and blind holes



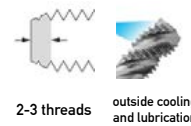
material: HSSG
medium
to 900 N/mm²
27,1 HRC



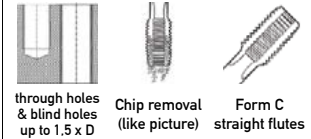
Hand Tap Sets for general use



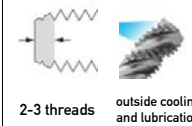
material: HSSG
medium
to 900 N/mm²
27,1 HRC



Short Machine Taps Form C for through holes and blind holes

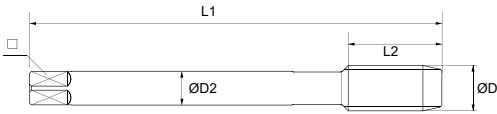


material: HSSG
medium
to 800 N/mm²



Efficient internal thread cutting.
The short structural type makes that tap usable by hand.
The Short-Machine-Tap is also usable by machine.

A Hand-Tap-Set includes 2 taps:
Taper Tap
Finish Tap



VG	D1	D2	L1	L2	□		No.	€	No.	€	No.	€
DIN 2181												
VG 5 x 36	5,15	6,0	50	12	4,9	4,65	390101001	68,40	390301001	265,26		
VG 5,2 x 24	5,23	6,0	56	17	4,9	4,25	390101002	68,40	390301002	243,16		
VG 6 x 32	5,98	6,0	56	14	4,9	5,35	390101003	76,30	390301003	276,32		
VG 8 x 32	7,68	7,0	56	16	5,5	6,90	390101004	77,90	390301004	309,48		
VG 10 x 28	10,27	8,0	63	18	6,2	9,35	390101005	84,20	390301005	331,58		
VG 12 x 26	12,17	9,0	70	22	7,0	11,15	390101006	94,75	390301006	223,97		
DIN 374												
VG 5 x 36	5,15	6,0	70	12	4,9	4,65					390501001	75,40
VG 5,2 x 24	5,23	6,0	80	17	4,9	4,25					390501002	126,30
VG 6 x 32	5,98	7,0	80	14	5,5	5,35					390501003	144,70
VG 8 x 32	7,68	8,0	80	16	6,2	6,90					390501004	85,84
VG 10 x 28	10,27	8,0	90	18	6,2	9,35					390501005	170,00
VG 12 x 26	12,17	9,0	100	22	7,0	11,15					390501006	200,00

Round Dies

VG Valve thread DIN 7756

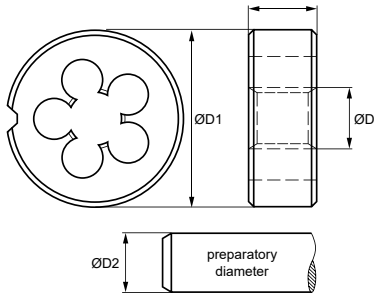
Round Dies for general use



material: HSS medium



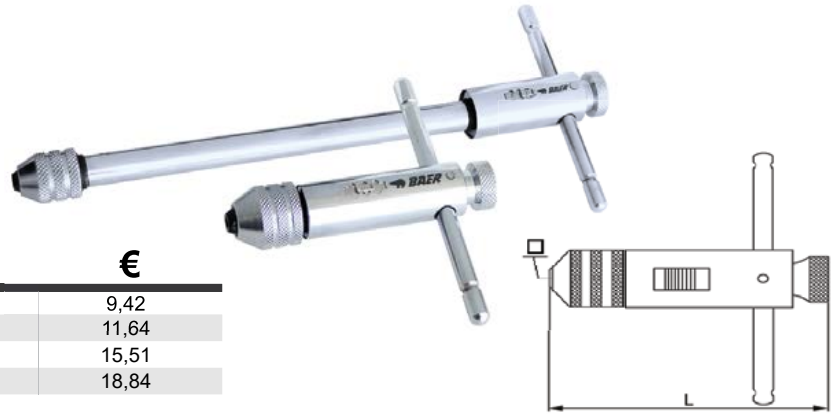
Chamfer: 1.5 threads right hand thread



VG	D	D1	H	D2	No.	€
VG 5 x 36	5,15	20	7	5,15	391401001	38,00
VG 5,2 x 24	5,23	20	7	5,23	391401002	38,00
VG 6 x 32	5,98	20	7	5,98	391401003	38,00
VG 8 x 32	7,68	25	9	9,60	391401004	54,00
VG 10 x 28	10,27	30	11	10,27	391401005	75,75
VG 12 x 26	12,17	30	11	12,17	391401006	75,75

Holding Tools

BAER Tap holders with ratchet

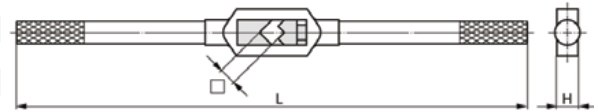


for taps			<input type="checkbox"/>	L1	No.	€
size	metric	inch-sizes				
1	M 3 - M 10	1/8 - 3/8	2,4 - 5,5	85	491625001	9,42
2	M 5 - M 12	7/32 - 1/2	4,5 - 8,0	100	491625002	11,64
10	M 3 - M 10	1/8 - 3/8	2,4 - 5,5	250	491625010	15,51
20	M 5 - M 12	7/32 - 1/2	4,5 - 8,0	300	491625020	18,84

Adjustable Tap Wrenches - zinc die cast



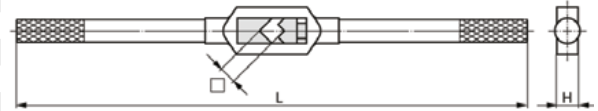
for taps				<input type="checkbox"/>	L1	No.	€
size	metric	inch-sizes	pipe-threads				
0	M 1 - M 8	1/16 - 1/4		2,0 - 5,0	130	491723000	4,24
1	M 1 - M 10	1/16 - 3/8	G 1/8	2,0 - 6,3	176	491723010	4,46
1.1/2	M 1 - M 12	1/16 - 1/2	G 1/8	2,1 - 8,0	176	491723015	4,46
2	M 4 - M 12	5/32 - 1/2	G 1/8	3,0 - 9,0	280	491723020	7,35
3	M 5 - M 20	7/32 - 3/4	G 1/8 - G 1/2	4,9 - 12	380	491723030	14,47
4	M 11 - M 27	7/16 - 1"	G 1/4 - G 3/4	5,5 - 16	505	491723040	27,28
5	M 13 - M 32	1/2 - 1.1/4	G 1/4 - G 1"	7,0 - 20	700	491723050	37,86



Adjustable Tap Wrenches - steel



for taps				<input type="checkbox"/>	L1	No.	€
	metric	inch-sizes	pipe-threads				
0	M 1 - M 8	1/16 - 1/4		2,0 - 5,0	130	491724000	7,19
1	M 1 - M 10	1/16 - 3/8		2,0 - 6,3	180	491724010	7,64
1.1/2	M 1 - M 12	1/16 - 1/2	G 1/8	2,1 - 8,0	205	491724015	7,64
2	M 4 - M 12	5/32 - 1/2	G 1/8	3,0 - 9,0	280	491724020	14,84
3	M 5 - M 20	7/32 - 3/4	G 1/8 - G 1/2	4,9 - 12	380	491724030	26,76
4	M 11 - M 27	7/16 - 1"	G 1/4 - G 3/4	5,5 - 16	500	491724040	46,34
5	M 13 - M 32	1/2 - 1.1/4	G 1/4 - G 1"	7,0 - 20	700	491724050	57,93
6	M 18 - M 42	3/4 - 1.1/2	G 1/2 - G 1.1/4	11 - 24	1000	491724060	98,50
7	M 27 - M 52	1.1/8 - 2"	G 3/4 - G 1.3/4	16 - 32	1250	491724070	110,09
8	M 27 - M 64	1.1/8 - 3"	G 3/4 - G 3"	16 - 40	1250	491724080	266,52

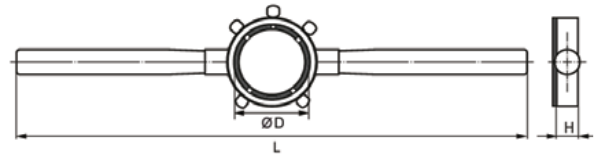


Holding Tools

Die Stocks - zinc die cast



Ø D x H	For Round Dies		L1	No.	€
	metric	inch-sizes			
16 x 5	M 1 - M 2,6	BSW 1/16 - BSW 3/32	160	491823001	3,34
20 x 5	M 3 - M 4	BSW 1/8 - BSW 5/32	200	491823002	3,34
20 x 7	M 4.5 - M 6	BSW 3/16 - BSW 1/4	200	491823003	3,34
25 x 9	M 7 - M 9	BSW 5/16	224	491823004	4,12
30 x 11	M 10 - M 11	BSW 3/8 - BSW 7/16	280	491823005	6,57
38 x 10	MF 12 - MF 15	G 1/4	315	491823006	10,80
38 x 14	M 12 - M 14	BSW 1/2 - BSW 9/16	315	491823007	10,80
45 x 14	MF 16 - MF 20	G 3/8-1/2	450	491823008	13,25
45 x 18	M 16 - M 20	BSW 5/8 - BSW 13/16	450	491823009	13,25
55 x 16	MF 22 - MF 26	G 5/8 - G 3/4	560	491823010	17,49
55 x 22	M 22 - M 24	BSW 7/8 - BSW 1"	560	491823011	17,49
65 x 18	MF 27 - MF 36	G 7/8 - G 1"	630	491823012	24,50
65 x 25	M 27 - M 36	BSW 1.1/8 - BSW 1.3/8	630	491823013	24,50

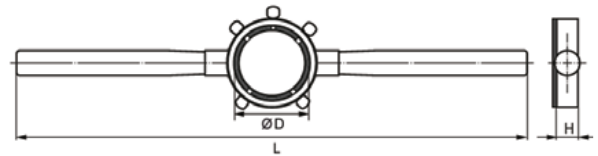


Ø D in inch	For Round Dies		L1	No.	€
	Ø D (mm) x H (mm)	Ø D (inch) x H (inch)			
13/16"	20,6 x 6,35	13/16 x 1/4	200	491823014	3,34
1"	25,4 x 9,5	1" x 3/8	224	491823015	4,12
1.5/16"	33,4 x 11,1	1.5/16 x 7/16	270	491823016	7,02
1.1/2"	38,1 x 12,7	1.1/2 x 1/2	315	491823017	10,58
2"	50,8 x 15,9	2" x 5/8	560	491823018	17,26
2.1/4"	57,1 x 17,5	2.1/4 x 11/16	560	491823019	17,48
2.1/2"	63,5 x 19,0	2.1/2 x 3/4	630	491823020	24,50
3"	76,2 x 22,2	3" x 7/8	900	491823021	67,94
3.1/2"	88,9 x 25,4	3.1/2" x 1"	900	491823022	70,16
4"	101,6 x 25,4	4" x 1"	1000	491823023	212,72

Die Stocks - steel



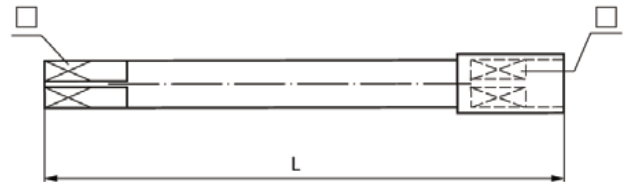
Ø D x H	For Round Dies		L1	No.	€
	metric	inch-sizes			
45 x 18	M 16 - M 20	BSW 5/8 - BSW 13/16	450	491824001	25,49
55 x 22	M 22 - M 24	BSW 7/8 - BSW 1"	560	491824002	35,92
65 x 25	M 27 - M 36	BSW 1.1/8 - BSW 1.3/8	630	491824003	45,20
75 x 20	MF 38 - MF 42	G 1.1/8 - G 1.1/4	800	491824004	74,15
75 x 30	M 38 - M 42	BSW 1.1/2 - BSW 1.5/8	800	491824005	74,15
90 x 22	MF 45 - MF 52	G 1.3/8 - G 1.5/8	900	491824006	95,02
90 x 36	M 45 - M 52	BSW 1.3/4 - BSW 2"	900	491824007	95,02
105 x 22	MF 54 - MF 63	G 1.3/4 - G 2"	975	491824008	113,55
105 x 36	M 54 - M 63	BSW 2.1/4	975	491824009	113,55
120 x 22	MF 64 - MF 71	G 2.1/4 - G 2.3/4	956	491824010	324,44
120 x 36	M 64 - M 71	BSW 2.1/2 - BSW 2.3/4	956	491824011	324,44
130 x 25		G 3"	966	491824012	405,55
130 x 36			966	491824013	405,55
140 x 22			976	491824014	521,44
150 x 25		G 3.1/2"	986	491824015	551,31
160 x 25		G 4"	996	491824016	757,38



Holding Tools

Extension sleeves for taps

□	L1	for taps metric acc. to DIN 352	No.	€	
	2,1	60	M 1 - M 2,6	491925021	3,37
	2,4	70		491925024	3,37
	2,7	80	M 3	491925027	3,37
	3,0	90	M 3,5	491925030	3,37
	3,4	95	M 4	491925034	3,37
	3,8	100		491925038	4,05
	4,3	105		491925043	4,73
	4,9	110	M 4,5 - M 8	491925049	3,83
	5,5	115	M 9 - M 10	491925055	4,28
	6,2	120	M 11	491925062	4,61
	7,0	125	M 12	491925070	5,73
	8,0	125		491925080	7,08
	9,0	130	M 14 - M 16	491925090	7,87
	10,0	140		491925100	10,36
	11,0	150	M 18	491925110	12,38
	12,0	155	M 20	491925120	16,20
	13,0	165		491925130	18,34
	14,5	175	M 22 - M 24	491925145	22,50
	16,0	180	M 27	491925160	23,63
	18,0	200	M 30	491925180	27,79
	20,0	220	M 33	491925200	36,00
	22,0	220	M 36	491925220	49,62
	24,0	235	M 39 - M 42	491925240	65,25
	26,0	250		491925260	84,37
	29,0	265	M 45 - M 48	491925290	99,01
	32,0	285	M 52	491925320	140,63



Die Guides M 3 - M 12

for Round Dies DIN 223 = EN 22568 and
Die Stocks DIN 225 = EN 22568



Application:

The guide helps cutting an external thread with cutting dies. The guides will be laid together with the cutting dies into the die holder.

Advantages:

- accurate aligned threads
- clear thread flanks
- less deficient products
- better evacuation of the chip, because of the leading with clearance holes
- able to cut right- or left-hand threads as well as all possible pitches

18,50 €

Item No.: 492025312

Net prices without VAT or tax

Cutting Paste

BAER High Performance cutting paste

Cutting paste with high pressure additives achieves extremely high lubricity. The paste adhering to the cutting edges only gets liquid when used (use cutting paste undiluted).

Lubrication is important for chip removal processes.

Advantages:

- Contains no petroleum, chlorine or sulfur
- Significantly improved tool life time
- Does not leave a greasy film of oil on the workpiece

Applications:

Drilling, tapping, thread milling, reaming, milling, core drilling, sawing, as well as for heavy chipping and for all machining operations.

For all steels such as: iron, steel, tool steel, high alloy steels, chromium-nickel alloys, Aluminum, titanium, manganese, cast steel, cast iron, brass, bronze and all stainless steels AISI 304, AISI 316, INOX etc.



100 ml
12,39 €

Item No.: SP100

Net prices without VAT or tax

BAER Countersink

**HSSG 90°
Countersink**
for general use



**HSSE-VAP 90°
Countersink**
for stainless steels



**HSSG-Bit 90°
Countersink**
for electric screw drivers



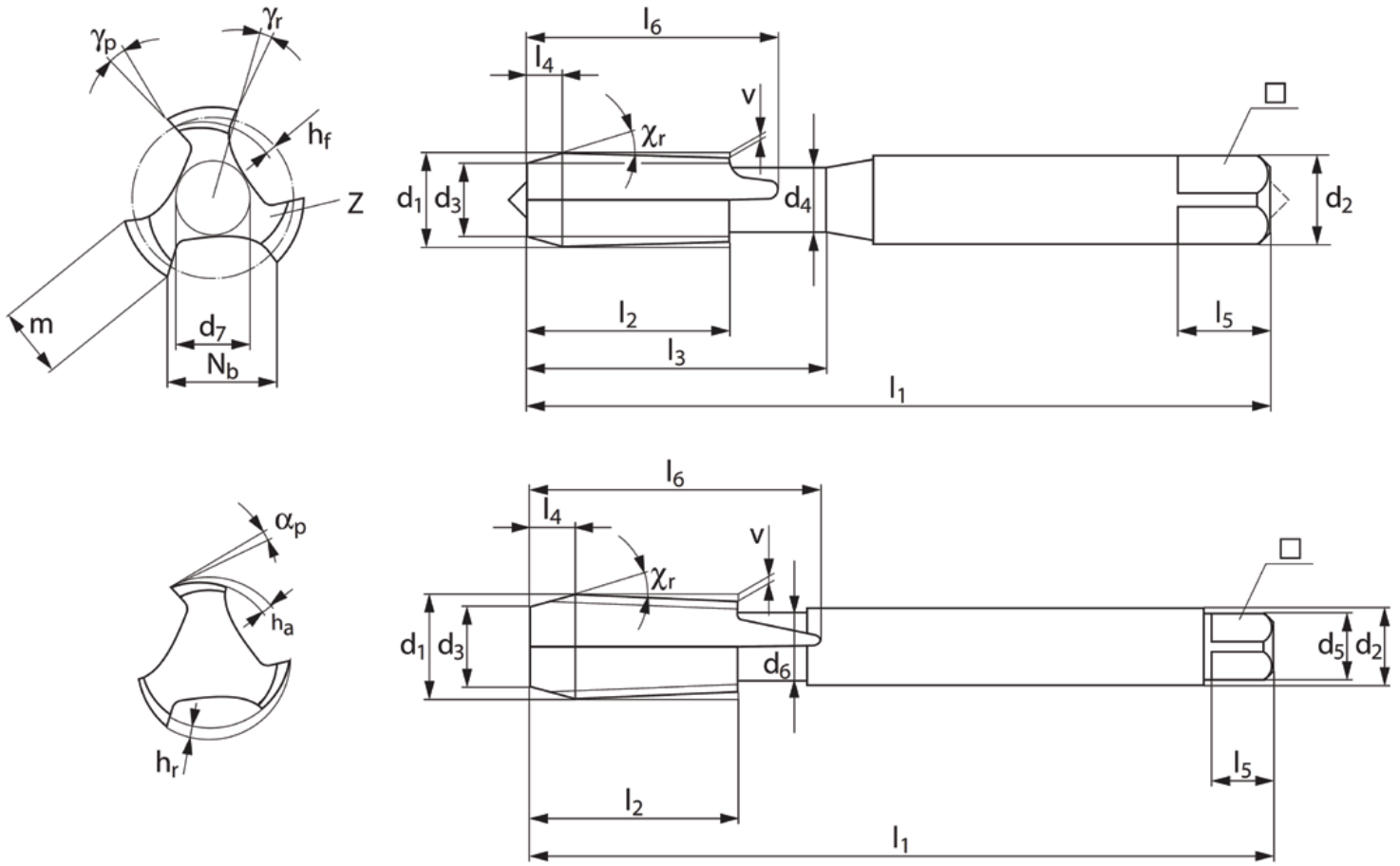
dimension	No.	€	No.	€	No.	€
6,3 mm (M 3)	74563	6,30	74663	12,50	744063	5,70
8,3 mm (M 4)	74583	7,56	74683	14,60	744083	6,00
10,4 mm (M 5)	745104	8,40	746104	16,80	744104	7,65
12,4 mm (M 6)	745124	10,50	746124	19,95	744124	8,88
16,5 mm (M 8)	745165	14,65	746165	32,76	744165	12,20
20,5 mm (M 10)	745205	20,37	746205	41,69	744205	15,70
25,0 mm (M 12)	745250	28,14	746250	52,50		
31,0 mm (M 16)	745310	52,08	746310	97,65		
Set 6,3 8,3 10,4 12,4 16,5 20,5 mm*	1571	85,58	1573	153,30	1576	63,00
Set 6,3 10,4 16,5 20,5 25,0 mm*	1572	97,44	1574	173,25		



* picture of sets

Technical Information

Tap Geometries



d1	Thread diameter
d2	Shank diameter
d3	Chamfer diameter
d4	Neck diameter
d5	Recessed square diameter
d6	Neck diameter
d7	Web diameter
l1	Total length
l2	Thread length
l3	Useful length
l4	Chamfer lead length
l5	Square length
l6	Flute length
<input type="checkbox"/>	Sqaure dimension

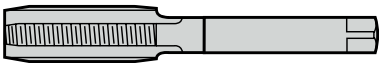
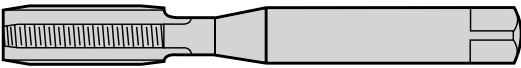

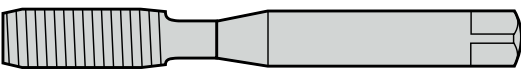
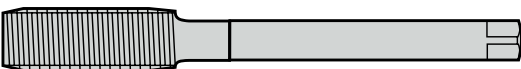
Z	Number of flutes
v	Back taper (axial relief)
xr	Chamfer angle
Nb	Width of flute
m	Width of land
ha	Chamfer relief
hf	Relief on flanks
hr	Chamfer relief
ap	Relief angle
yp	Rake angle

Tap Centering

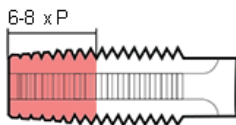
	Ø 0,8 mm - 6,0 mm	
	Ø 6,0 mm - 12,8 mm	
	> Ø 12,8 mm	

Technical Information

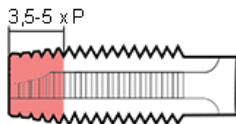
Tap Construction dimensions

 Gewindebohrer / Tap	DIN 352	DIN 2181	DIN 5157	DIN 40432	
 Gewindebohrer / Tap	DIN 371	DIN 40435			
 Gewindebohrer / Tap	DIN 376	DIN 374	DIN 5156	DIN 40433	DIN 40435
 Gewindeformer / Forming Tap	DIN 2174	DIN 371			
 Gewindeformer / Forming Tap	DIN2174	DIN 376	DIN 2189		

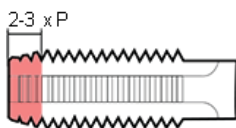
Tap Chamfer Forms



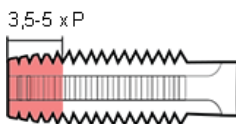
Form A
long, 6 - 8 thread
straight flutes
for short through holes



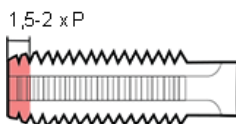
Form B
medium, 3,5 - 5,5 threads
straight flutes with spiral point
for through holes in medium- and long chipping materials



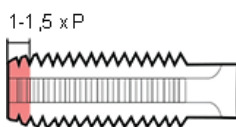
Form C
short, 2 - 3 threads
straight and spiral flutes
for blind holes in medium- and long chipping materials
for through holes in short chipping materials



Form D
medium, 3,5 - 5 threads
straight and spiral flutes 15°
for blind holes with long thread runout
for short through holes



Form E
very short, 1,5 - 2 threads
straight and spiral flutes 15°
for blind holes with short thread runout



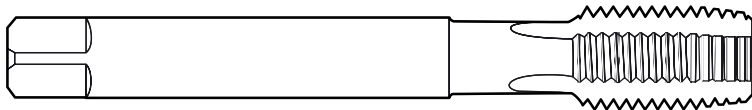
Form F
very short, 1 - 1,5 threads
straight and spiral flutes
for blind holes with short thread runout
Avoid if possible.

Please note:

Short chamfers cut threads close to the bottom of the borehole.
Long chamfers reduce the forced on the cutting edges (recommended for materials with higher material strength)
Long chamfers increase the required torque.

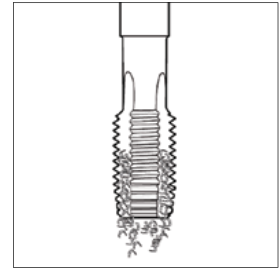
Technical Information

Tap flutes



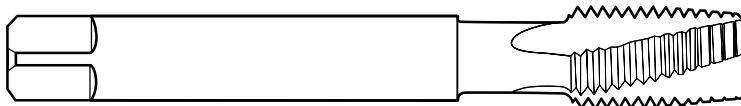
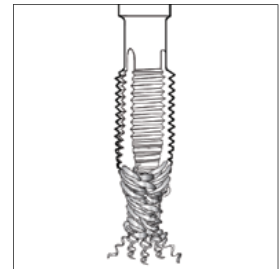
Form A, C, E
straight-fluted
for through and blind holes

The flutes can hold a part of the chips. Chips get only partially removed in cutting direction. For this reason it is not recommended to use the tap for deep holes.



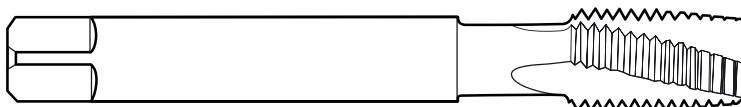
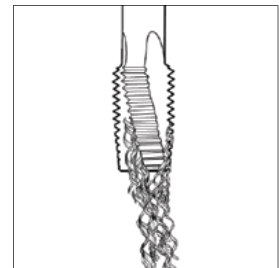
Form B
straight-fluted with spiral point
for through holes

Due to the spiral point the chips are getting removed tightly rolled in cutting direction and prevents chip-packing. Coolant-lubricant can flow freely.



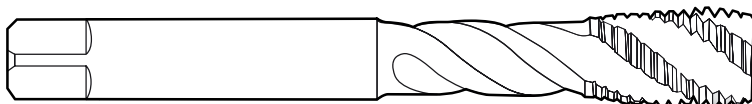
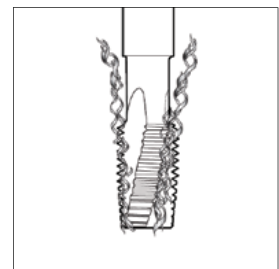
Form C, D
8 - 15° left-hand spiral flutes
for through holes

Due to the left-hand spiral flutes the rake angle remains constant and ensure stable chamfer teeth to produce threads in high-strength materials. The left-hand spiral flutes forces the chips to remove ahead of the tap.



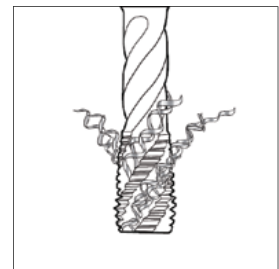
Form C, E
10 - 15° right-hand spiral flutes
for blind holes

Especially suitable for automatic lathes and multi-spindle machines. Due to the chip removal against the cutting direction a secured tapping process is assured in hard conditions, even for threads with cross holes.



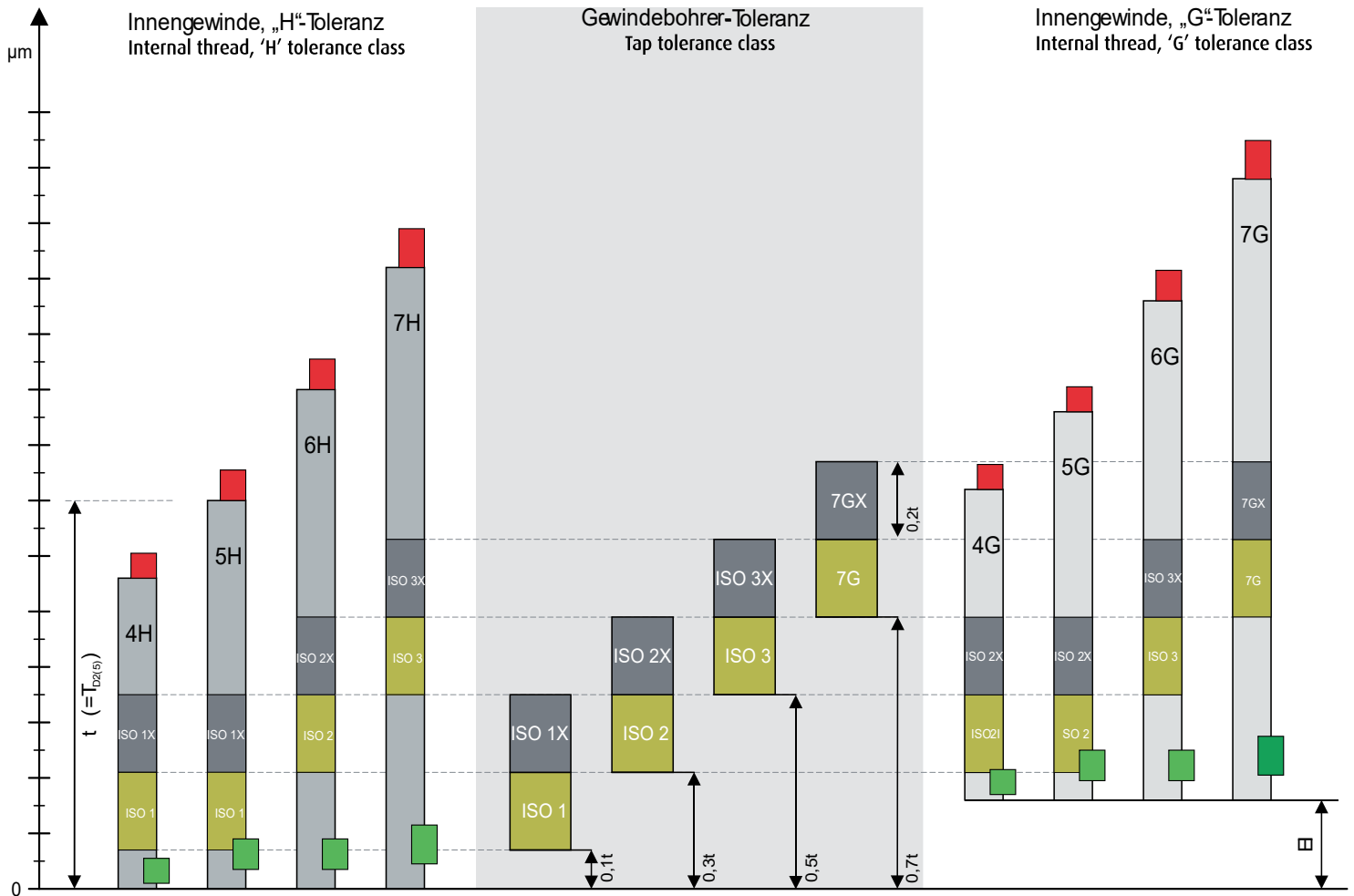
Form C, E
35 - 50° right-hand spiral flutes
for blind holes

Due to the high spiral flutes, the chips can be removed securely also in long-chipping and deep blind holes.



Technical Information

Tolerances



- Flankendurchmesser-Toleranz des Innengewindes nach DIN ISO 965-1
Pitch diameter tolerance of internal thread acc. DIN ISO 965-1
- Gewindebohrer mit spezieller Flankendurchmesser-Toleranz
Taps with specific pitch diameter tolerance
- Flankendurchmesser-Toleranz des Gewindebohrers nach DIN EN 22857
Pitch diameter tolerance of the tap acc. DIN EN 22857
- Flankendurchmesser-Toleranz des Ausschusslehrdorns nach DIN ISO 1502
Pitch diameter tolerance of the no-go thread plug gauge acc. DIN ISO 1502
- Flankendurchmesser-Toleranz des Gutlehdorns nach DIN ISO 1502
Pitch diameter tolerance of the go thread plug gauge acc. DIN ISO 1502

- EI = Grundmaß
Basis
- t = Toleranzklasse 5 des Innengewindes (Toleranzeinheit)
Tolerance class of the internal thread (tolerance unit)
- TD2 = Toleranz des Flankendurchmessers
Pitch diameter tolerance

tolerance class of tap		tolerance field internal thread				remarks	Applications
4H (DIN 802/1)	ISO 1	4H	5H			undersize	Threads with small clearance
6H (DIN 802/1)	ISO 2	4G	5G	6H		normal	Thread with normal clearance
6G (DIN 802/1)	ISO 3			6G	7H	8H	Threads with large clearance
7G (DIN 802/4)					7G	8G	before heat treatment, causing distortion
6H +0,1						oversize	Electroplating allowance ≈ 25µm thickness
6H +0,2						oversize	Electroplating allowance ≈ 50µm thickness

Technical Information

Tap Surface Treatments



TIN (titanium nitride) coating

The TIN surface treatment (titanium-nitride gold-yellow) increases the surface hardness (approx. 2300 HV) and the sliding properties. It provides a better cutting performance and increased tool life time.



VAP (vaporized - steam tempered)

The oxide surface (vaporized) improves the adhesion of the cutting oil and provides a stabil lubricant film. Cold welding in the tap flanks is reduced.



TiAlN (titanium aluminium nitride) coating

The TiAlN surface treatment increases the surface hardness (approx. 3300 HV), the sliding properties (friction coefficient: 0,25) and with high temperature resistance up to 800°C. It provides a better cutting performance and increased tool life time.



TiCN (titanium carbonitride) coating

The TiCN surface treatment (titanium carbon nitride - grey violet) increases the surface hardness (approx. 3000 HV) and the sliding properties (coefficient of friction: 0,3). It provides a better cutting performance and increased tool life time.

Coating services

Every threading tool of our product range - whether or not cataloged - can be delivered with any coating or surface treatment in short time.

Troubleshooting guide for tapping

Tapping undersized threads	<ul style="list-style-type: none"> Pitch error Too small tolerance Geometry of the tap is not suitable for the material
Tapping oversized threads	<ul style="list-style-type: none"> Cutting speed is too high Bad running accuracy Chip jammings in flutes Incorrect positioning of workpiece or tap Inconsistent feed of tap Too high tolerance
Poor thread surface	<ul style="list-style-type: none"> Cutting speed not suitable Cooling is not suitable or not existing Geometry of the tap is not suitable for the material Core hole too small
Thread break of the thread to be cut	<ul style="list-style-type: none"> Geometry of the tap is not suitable for the material Core hole too small Core hole not deep enough Chip jammings in flutes Bad running accuracy Incorrect positioning of workpiece or tap Inconsistent feed of tap
Low tap lifetime	<ul style="list-style-type: none"> Cutting speed not suitable Cooling is not suitable or not existing Geometry of the tap is not suitable for the material Surface treatment/ coating for tap needed Core hole too small
Tool outbreaks	<ul style="list-style-type: none"> Geometry of the tap is not suitable for the material Core hole too small Core hole not deep enough Chip jammings in flutes Bad running accuracy Incorrect positioning of workpiece or tap Inconsistent feed of tap Worn tap
Cold welding on the tap	<ul style="list-style-type: none"> Cutting speed not suitable Increase coolant supply

Technical Information

Tap Cutting speeds

The cutting speeds for taps depend on following parameters:

- material of the workpiece
- tap geometries
- lubrication
- and more.

You can find the cutting speed in the product descriptions of the taps in our online-shop. Just enter the item number into the Search-field and find the cutting speeds in the bottom part of the product description.

Lubrication and cooling

It is recommended to use one of the following coolings or lubrications to improve the thread results and tool life time.

Dry machining and pressurized air

- cast iron
- (Cooled) pressurized air is used for chip removal

Emulsion

- Most common coolant-lubricant for thread cutting

Thread cutting oil

- Achieving excellent thread surfaces and tool life time

Thread cutting paste

- suitable for forming taps
- good results with horizontal cutting direction
- for bigger diameters and through holes

MQL - Minimum-quantity lubrication

- cooling by aerosol

Technical Information

Formula

Description	Symbol	Unit	Formula	Example
Rotation speed	n	min ⁻¹		
Angular speed	ω	s ⁻¹	$\omega = \frac{2 \cdot \pi \cdot n}{60}$	n = 400 min ⁻¹ $\omega = \frac{2 \cdot \pi \cdot 400}{60}$ ω = 41,89 s ⁻¹
Cutting speed	v _c	m/min	$v_c = \frac{d \cdot \omega}{33,3}$ $v_c = \frac{d \cdot \pi \cdot n}{1000}$	n = 400 min ⁻¹ , d = 20 mm $v_c = \frac{20 \cdot \pi \cdot 400}{1000}$ v _c = 25,133 m/min
Feed per revolution	f	mm		
Feed speed	v _f	mm/min	v _f = f · n	n = 400 min ⁻¹ f = 0,800 mm v _f = 0,800 · 400 v _f = 320 mm/min
Force	F	N	F = k _c · A	
Torque	M	Nm	$M = \frac{F \cdot d}{2000}$	F = 200 N, d = 20 mm $M = \frac{200 \cdot 20}{2000}$ M = 2 Nm
Mechanical work	W	J	W = F · U	F = 200 N, d = 20 mm $U = \frac{d \cdot \pi}{1000} = 0,063 \text{ m}$ W = 200 · 0,063 = 12,6 J
Performance	P	W	$P = \frac{F \cdot v_c}{60}$ P = M · ω	F = 200 N, v _c = 25,133 m/min P = 83,78 W M = 2 Nm, ω = 41,89 s ⁻¹ P = 83,78 W
Efficiency	η	-	$\eta = \frac{P_{ab}}{P_{an}}$ η < 1	P _{ab} = 58,65, P _{an} = 83,78 W $\eta = \frac{58,65}{83,78} = 0,7$

π = 3,141592654

d = Diameter in mm

U = circumference in m

1 kW = 1,36 PS

1 PS = 0,736 kW

$1 \frac{\text{m}}{\text{s}} = 60 \frac{\text{m}}{\text{min}}$

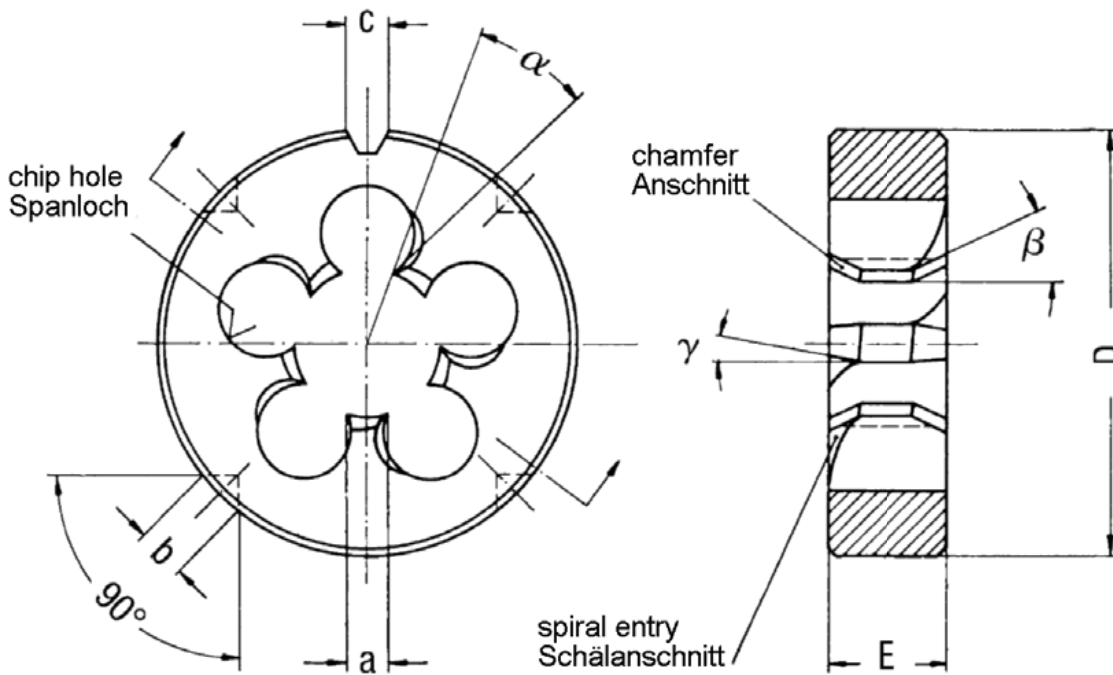
1/s = 60/min = 1 Hz

$1 \text{ J} = 1 \text{ Nm} = 1 \frac{\text{kg} \cdot \text{m}^2}{\text{s}^2}$

$1 \text{ W} = 1 \frac{\text{J}}{\text{s}} = 1 \frac{\text{Nm}}{\text{s}} = 1 \frac{\text{kg} \cdot \text{m}^2}{\text{s}^3}$

Technical Information

Round Dies Geometries



D	outside diameter	b	diameter of hole for fixing screw
E	thickness	α	rake angle
a	width of tooth	β	chamfer angle
c	width of notch	γ	spiral angle

Preparation of workpiece:

- concentric chamfer - ease entry of cutting
- workpiece diameter must be less than the nominal diameter

Chamfer

- Standard chamfer (length, see at the item)
- Spiral entry: free flow of chips ahead of the die and a reducing of cutting torque. This result in an improved surface finish on the cut threads and longer die life
- 70° (short chamfer) - chamfer length: 1,25 pitch = 70°

Tolerances for Round Dies

Metric ISO thread acc. DIN 13 - coarse and fine thread

- 4h = tolerance class „fine“
- 6h = tolerance class „middle“, for small diameters (up to M 1,4)
- 6g = tolerance class „middle“ - Standard
- 6e = undersize tolerance; for bolts that receive a surface treatment or a galvanizing (layer thickness up to 8 μm).
Cutting dies with 6e tolerance are cutting about 0,03 mm smaller than normal cutting dies with 6g tolerance.
- 8e = undersize tolerance; for bolts that receive a strong surface coating (layer thickness about 16 - 18 μm)

Unified thread UNC, UNF, UNEF, UNS, UN, UNJC, UNJF etc.

- 3A = tolerance „fine“
- 2A = standard tolerance „middle“
- 1A = tolerance „coarse“

Whitworth pipe thread G (BSP) acc. DIN-ISO 228

- A = standard tolerance „middle“
- B = tolerance „coarse“

Technical Information

Cutting speeds for Machine Forming Taps

materials	tensile strength	forming speed in m/min	recommended lubrication
construction steels, free-machining steels, cold-extrusion steels etc.	< 600 N/mm ²	20 - 80	Cutting oil/ Emulsion
construction steels, heat-treatable steels, cast steels etc.	< 800 N/mm ²	20 - 60	Cutting oil/ Emulsion
heat-treatable steels, cold-extrusion steels, nitriding steels etc.	< 1000 N/mm ²	10 - 40	Cutting oil
corrosion and acid proof steels ferritic, martensitic	< 950 N/mm ²	10 - 25 (with emulsion just limitedly applicable)	Cutting oil
corrosion and acid proof steels austenitic	< 950 N/mm ²	10 - 25 (with emulsion just limitedly applicable)	Cutting oil
aluminium wrought alloys	< 550 N/mm ²	15 - 40	Cutting oil/ Emulsion
aluminium cast alloys	Si < 12%	15 - 40	Cutting oil/ Emulsion
pure copper	< 400 N/mm ²	20 - 40	Cutting oil/ Emulsion
copper-zinc alloys (brass long-chipping)	< 550 N/mm ²	40 - 80	Emulsion

forming (cutting) speed [m/min] = (diameter * π * number of rotation) / 1000
 number of rotation n [1/min] = (cutting speed in m/min * 1000) / (diameter * π)
 feed programming [mm/min] = number of rotation * pitch
 Please notice that the mentioned cutting speeds are only for orientation.
 The right cutting speed is depend on lubrication and application.



BAER Vertriebs GmbH

Robert-Bosch-Str. 5

68542 Heddesheim

Germany

Tel: +49 (0) 6203 4048 790

Fax: +49 (0) 6203 4048 791

E-Mail: info@gewindebohrer.de

www.threading-tools.com



BAER Vertriebs GmbH
Robert-Bosch-Str. 5
68542 Heddesheim
Germany

T: +49 (0) 6203 4048 790
F: +49 (0) 6203 4048 791
info@gewindebohrer.de
www.threading-tools.com

