

Durativ N-X 系列無屑絲攻

Application recommendations



孔型			
刀具材質	HSS-E-PM	HSS-E-PM	HSS-E-PM
類型	Durativ N-X	Durativ N-X	Durativ N-X
銼型	C 帶潤滑油槽	C 帶潤滑油槽	E
表面塗層	TiCN	TiCN	TiCN
冷卻方式	外冷	徑向內冷	軸向內冷*

牙型	尺寸根據工業標準 DIN 2184-1	公差範圍	貨號 / Ø-範圍 / 頁數		
M	~ DIN 371	4/6HX	53630 M1-M10 Page 123	53610 M5-M20 Page 124	53618 M2*-M10 Page 124
		6GX	53631 M2-M10 Page 125		
	~ DIN 376	6HX	53630 M12-M20 Page 123		53618 M12-M20 Page 124
		6GX	53631 M12-M20 Page 125		
MF	~ DIN 374	6HX	53632 M8x1-M20x1.5 Page 127	53612 M8x1-M20x1.5 Page 128	53619 M8x1-M20x1.5 Page 128
UNC	~ DIN 371 ~ DIN 376	2BX	53633 No.4-40 - 3/4-10 Page 129		
UNF	~ DIN 374	2BX	53634 No.4-48 - 3/4-16 Page 130		
G	DIN 5156	X	53635 G1/8 - G1/2 Page 126		

M2 以上的所有刀具規格都帶潤滑油槽
* M5 以上的規格都帶
冷卻孔 IC

Durativ N-X 系列無屑絲攻參數推薦表

材料組		抗拉強度	材料示列	材料號	v _c m/min			
P	P1	Structural and free cutting steels, heat-treatable steels unalloyed	≤800 N/mm ²	S235JR C15 11SMnPb30	1.0037 1.0401 1.0718	25	25	25
			800 - 1000 N/mm ²	S355J2 C60 31CrMo12	1.0577 1.0601 1.8515	25	25	25
				800 - 1200 N/mm ²	42CrMo4 36CrNiMo4 X36CrMo17 HS 6-5-2	1.7225 1.6511 1.2316 1.3343	15	15
M	M1	Stainless steels, sulphured, austenitic	≤1000 N/mm ²		X5CrNi18-10 X6CrNiTi18-10 X8CrNiS18-9	1.4301 1.4571 1.4305	15	15
			≤1000 N/mm ²	X17CrNi16-2 X90CrMoV18 X2CrTi12	1.4057 1.4112 1.4512	10	10	10
				≤1300 N/mm ²	X2CrNiMoN22-5-3 X2CrNiMoN25-7-4 X2CrNiMoCuWN25-7-4	1.4462 1.4410 1.4501	6	6
K	K1	Cast iron	300 HB		EN-GJL-150 EN-GJL-250 EN-GJL-300	0.6015 0.6025 0.6030		
			350 HB	EN-GJS-400-15 EN-GJS-600-3 EN-GJS-700-2	0.7040 0.7060 0.7070	30	30	30
				1000 N/mm ² 350 HB	EN-GJS1000-5 EN-GJV250 EN-GJV400		25	25
N	N1	Aluminium, Aluminium wrought alloys	≤450 N/mm ²		Al99,5H AlMgSi1 AlZn4,5Mg	3.0250 3.2315 3.4335	15	15
			≤600 N/mm ²	GD-ALSi5Cu1Mg GD-ALSi8Cu3 G-ALSi9Mg G-ALSi12	3.2134 3.2162 3.2373 3.2581	30	30	30
				≤500 N/mm ²	GDMgAl8Zn1	3.5812.08		
N	N4	Copper and copper alloys	long-chipping		CuZn20 CuZn37Pb0.5	2.0250 2.0332	30	30
			short-chipping	CuZn39Pb2 CuZn43Pb2	2.0380 2.0410			
			≤1400 N/mm ²	Ampco				
N	N6	Plastics [Thermoplastics, duroplastics]	long-chipping	PMMA, POM, PVC				
			short-chipping	Pertinax				
S	S1	Titanium and Titanium alloys	≤1200 N/mm ²	Titanium TiAl5Sn2 TiAl6V4	3.7025 3.7115 3.7165	8	8	8
			≤1400 N/mm ²	Hastelloy C4 Inconel 718 Nimonic 105	2.4610 2.4668 2.4634	8	8	8
H	H1	High tensile steels, hardened steels		45 - 55 HRC				
			55 - 62 HRC					

ISO M 公制螺紋用機械絲攻 DIN 371/376

Durativ N-X: 高性能無屑絲攻系列

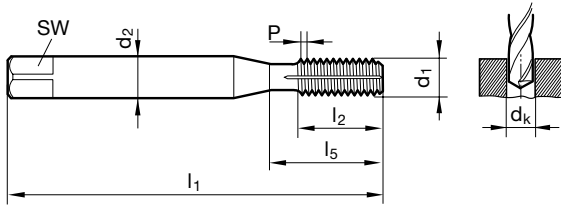


貨號 53630



P	M	K	N	S	H
●	●	●	○	●	

- 通孔和盲孔用
- 高性能擠壓成型螺紋加工刀具, 柄徑公差為h6
- 可攻較深的螺紋 (~3.5xD)
- 特別適用於所有可成型材質
- 加工材質硬度需 $\leq 1200 \text{ N/mm}^2$
- 新粉末冶金的基材、創新性幾何形狀和摩擦系數低的硬質鍍層帶來最高的刀具壽命
- 減少下孔阻力30%, 最高的加工可靠性和利潤率
- 可實現更快的攻牙加工
- 大批量生產時每個螺紋的加工成本最低
- **注意事項**
 絲攻公差: $\varnothing \leq M1.4 = 4HX \mid \varnothing \geq M1.6 = 6HX$
 絲攻帶潤滑槽的規格: $\varnothing \geq M2$



d1	P	d2	SW	dk	l1	l2	l5
	mm	mm	mm	mm	mm	mm	mm
M1	0.250	2.500	2.100	0.90	40.000	4.000	7.600
M1,2	0.250	2.500	2.100	1.10	40.000	4.800	7.600
M1,4	0.300	2.500	2.100	1.25	40.000	5.600	10.600
M1,6	0.350	2.500	2.100	1.45	40.000	6.400	11.600
M1,7	0.350	2.500	2.100	1.55	40.000	6.800	11.600
M1,8	0.350	2.500	2.100	1.65	40.000	7.300	11.600
M2	0.400	2.800	2.100	1.85	45.000	8.000	13.500
M2,5	0.450	2.800	2.100	2.30	50.000	9.000	14.500
M3	0.500	3.500	2.700	2.80	56.000	10.000	18.000
M4	0.700	4.500	3.400	3.70	63.000	12.000	21.000
M5	0.800	6.000	4.900	4.65	70.000	14.000	25.000
M6	1.000	6.000	4.900	5.55	80.000	16.000	30.000
M8	1.250	8.000	6.200	7.40	90.000	17.000	35.000
M10	1.500	10.000	8.000	9.30	100.000	20.000	39.000
M12	1.750	9.000	7.000	11.20	110.000	24.000	49.000
M14	2.000	11.000	9.000	13.10	110.000	26.000	53.000
M16	2.000	12.000	9.000	15.10	110.000	26.000	54.000
M20	2.500	16.000	12.000	18.90	140.000	32.000	62.000

ISO M 公制螺紋用機械絲攻 DIN 371/376

Durativ N-X: 高性能無屑絲攻系列



貨號 53610



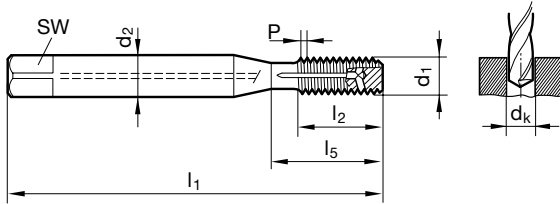
P	M	K	N	S	H
●	●	●	○	●	

- 通孔和盲孔用
- 高性能擠壓成型螺紋加工刀具, 柄徑公差為h6
- 可攻較深的螺紋 (~3.5xD)
- 特別適用於所有可成型材質
- 加工材質硬度需 $\leq 1200 \text{ N/mm}^2$
- 新粉末冶金的基材、創新性幾何形狀和摩擦系數低的硬質鍍層帶來最高的刀具壽命
- 減少下孔阻力30%, 最高的加工可靠性和利潤率
- 可實現更快的攻牙加工
- 大批量生產時每個螺紋的加工成本最低

注意項目

冷卻方式: 徑向內冷

絲攻帶潤滑油槽的規格: $\varnothing \geq M2$



d1	P	d2	SW	dk	l1	l2	l5
	mm	mm	mm	mm	mm	mm	mm
M5	0.800	6.000	4.900	4.65	70.000	8.500	25.000
M6	1.000	6.000	4.900	5.55	80.000	11.000	30.000
M8	1.250	8.000	6.200	7.40	90.000	14.000	35.000
M10	1.500	10.000	8.000	9.30	100.000	16.000	39.000
M12	1.750	9.000	7.000	11.20	110.000	18.500	49.000
M14	2.000	11.000	9.000	13.10	110.000	20.000	53.000
M16	2.000	12.000	9.000	15.10	110.000	20.000	54.000
M20	2.500	16.000	12.000	18.90	140.000	25.000	62.000

ISO M 公制螺紋用機械絲攻 DIN 371/376

Durativ N-X: 高性能無屑絲攻系列



貨號 53618



P	M	K	N	S	H
●	●	●	○	●	

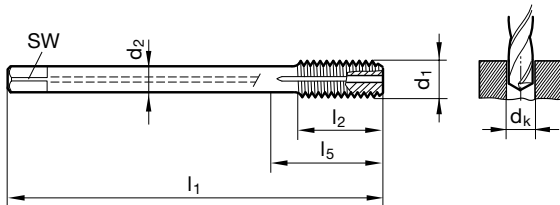
- 通孔和盲孔用
- 高性能擠壓成型螺紋加工刀具, 柄徑公差為h6
- 可攻較深的螺紋 (~3.5xD)
- 特別適用於所有可成型材質
- 加工材質硬度需 $\leq 1200 \text{ N/mm}^2$
- 新粉末冶金的基材、創新性幾何形狀和摩擦系數低的硬質鍍層帶來最高的刀具壽命
- 減少下孔阻力30%, 最高的加工可靠性和利潤率
- 可實現更高切削速度
- 大批量生產時每個螺紋的加工成本最低

注意項目

絲攻帶軸向內冷和潤滑油槽

無效牙較少 (Form E = 1.5~2牙)

螺紋深度容易可加工到孔底接近



d1	P	d2	SW	dk	l1	l2	l5
	mm	mm	mm	mm	mm	mm	mm
M2	0.400	2.800	2.100	1.85	45.000	8.000	13.500
M2,5	0.450	2.800	2.100	2.30	50.000	9.000	14.500
M3	0.500	3.500	2.700	2.80	56.000	10.000	18.000
M4	0.700	4.500	3.400	3.70	63.000	12.000	21.000
M5	0.800	6.000	4.900	4.65	70.000	8.500	25.000
M6	1.000	6.000	4.900	5.55	80.000	11.000	30.000
M8	1.250	8.000	6.200	7.40	90.000	14.000	35.000
M10	1.500	10.000	8.000	9.30	100.000	16.000	39.000
M12	1.750	9.000	7.000	11.20	110.000	18.500	49.000
M14	2.000	11.000	9.000	13.10	110.000	20.000	53.000
M16	2.000	12.000	9.000	15.10	110.000	20.000	54.000
M20	2.500	16.000	12.000	18.90	140.000	25.000	62.000

ISO M 公制螺紋用機械絲攻 DIN 371/376

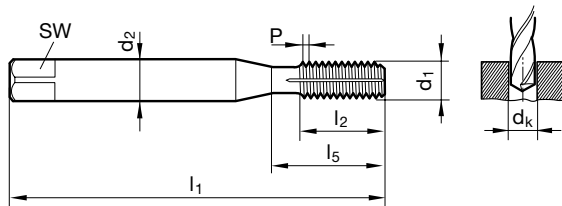
Durativ N-X: 高性能無屑絲攻系列



貨號 53631

Durativ N-X	~DIN 371/376	C	HSS-E- PM	TiCN	R	6GX
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P	M	K	N	S	H
●	●	●	○	●	



- 通孔和盲孔用
- 高性能擠壓成型螺紋加工刀具，柄徑公差為h6
- 可攻較深的螺紋 (~3.5xD)
- 特別適用於所有可成型材質
- 加工材質硬度需 ≤ 1200 N/mm²
- 新粉末冶金的基材、創新性幾何形狀和摩擦系數低的硬質鍍層帶來最高的刀具壽命
- 減少下孔阻力30%，最高的加工可靠性和利潤率
- 可實現更快的攻牙加工
- 大批量生產時每個螺紋的加工成本最低
- **注意項目**
絲攻公差：6GX
絲攻帶潤滑槽的規格：Ø ≥ M2

d1	P	d2	SW	dk	l1	l2	l5
	mm	mm	mm	mm	mm	mm	mm
M2	0.400	2.800	2.100	1.85	45.000	8.000	13.500
M2,5	0.450	2.800	2.100	2.30	50.000	9.000	14.500
M3	0.500	3.500	2.700	2.80	56.000	10.000	18.000
M4	0.700	4.500	3.400	3.70	63.000	12.000	21.000
M5	0.800	6.000	4.900	4.65	70.000	14.000	25.000
M6	1.000	6.000	4.900	5.55	80.000	16.000	30.000
M8	1.250	8.000	6.200	7.40	90.000	17.000	35.000
M10	1.500	10.000	8.000	9.30	100.000	20.000	39.000
M12	1.750	9.000	7.000	11.20	110.000	24.000	49.000
M14	2.000	11.000	9.000	13.10	110.000	26.000	53.000
M16	2.000	12.000	9.000	15.10	110.000	26.000	54.000
M20	2.500	16.000	12.000	18.90	140.000	32.000	62.000

BSP (G) 英制管螺紋用機械絲攻 DIN 5156

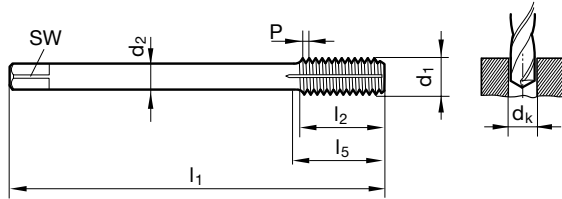
Durativ N-X: 高性能無屑絲攻系列



貨號 53635



P	M	K	N	S	H
●	●	●	○	●	



- 通孔和盲孔用
- 高性能擠壓成型螺紋加工刀具，柄徑公差為h6
- 可攻較深的螺紋 (~3.5xD)
- 特別適用於所有可成型材質
- 加工材質硬度需 $\leq 1200 \text{ N/mm}^2$
- 新粉末冶金的基材、創新性幾何形狀和摩擦系數低的硬質鍍層帶來最高的刀具壽命
- 減少下孔阻力30%，最高的加工可靠性和利潤率
- 可實現更快的攻牙加工
- 大批量生產時每個螺紋的加工成本最低

訂購代碼	d1	P inch	d2 mm	SW mm	dk mm	l1 mm	l2 mm	l5 mm
9.728	G1/8	28.000	7.000	5.500	9.30	90.000	18.000	35.000
13.157	G1/4	19.000	11.000	9.000	12.50	100.000	20.000	40.000
16.662	G3/8	19.000	12.000	9.000	16.00	100.000	22.000	44.000
20.955	G1/2	14.000	16.000	12.000	20.00	125.000	25.000	44.000

ISO MF 公制螺紋用機械絲攻 DIN 374

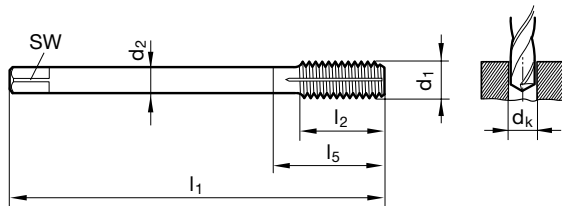
Durativ N-X: 高性能無屑絲攻系列



貨號 53632

Durativ N-X	~DIN 374	C	HSS-E- PM	TiCN		6HX
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P	M	K	N	S	H
●	●	●	○	●	



- 通孔和盲孔用
- 高性能擠壓成型螺紋加工刀具, 柄徑公差為h6
- 可攻較深的螺紋 (~3.5xD)
- 特別適用於所有可成型材質
- 加工材質硬度需 $\leq 1200 \text{ N/mm}^2$
- 新粉末冶金的基材、創新性幾何形狀和摩擦系數低的硬質鍍層帶來最高的刀具壽命
- 減少下孔阻力30%, 最高的加工可靠性和利潤率
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- 大批量生產時每個螺紋的加工成本最低

訂購代碼	d1	d2	SW	dk	l1	l2	l5
		mm	mm	mm	mm	mm	mm
8.005	M8 x 1	6.000	4.900	7.55	90.000	17.000	35.000
10.005	M10 x 1	7.000	5.500	9.55	90.000	16.000	35.000
10.006	M10 x 1,25	7.000	5.500	9.40	100.000	20.000	39.000
12.006	M12 x 1,25	9.000	7.000	11.40	100.000	20.000	40.000
12.007	M12 x 1,5	9.000	7.000	11.30	100.000	20.000	40.000
14.006	M14 x 1,25	11.000	9.000	13.40	100.000	20.000	40.000
14.007	M14 x 1,5	11.000	9.000	13.30	100.000	20.000	40.000
16.007	M16 x 1,5	12.000	9.000	15.30	100.000	22.000	44.000
20.007	M20 x 1,5	16.000	12.000	19.30	125.000	25.000	44.000

ISO MF 公制螺紋用機械絲攻 DIN 374

Durativ N-X: 高性能無屑絲攻系列



貨號 53612

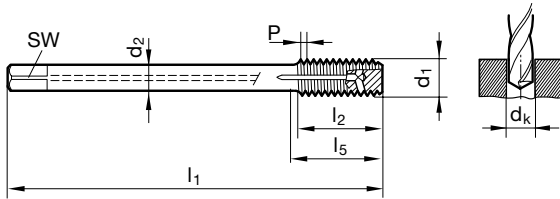
Durativ N-X	~DIN 374	C	HSS-E- PM	TiCN	(R)	6HX
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P	M	K	N	S	H
●	●	●	○	●	

- 通孔和盲孔用
- 高性能擠壓成型螺紋加工刀具, 柄徑公差為h6
- 可攻較深的螺紋 (~3.5xD)
- 特別適用於所有可成型材質
- 加工材質硬度需 $\leq 1200 \text{ N/mm}^2$
- 新粉末冶金的基材、創新性幾何形狀和摩擦系數低的硬質鍍層帶來最高的刀具壽命
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- 大批量生產時每個螺紋的加工成本最低

注意項目

冷卻方式: 軸向內冷
絲攻帶潤滑油槽的規格



訂購代碼	d1	d2	SW	dk	l1	l2	l5
		mm	mm	mm	mm	mm	mm
8.005	M8 x 1	6.000	4.900	7.55	90.000	11.000	35.000
10.005	M10 x 1	7.000	5.500	9.55	90.000	11.000	35.000
10.006	M10 x 1,25	7.000	5.500	9.40	100.000	14.000	39.000
12.006	M12 x 1,25	9.000	7.000	11.40	100.000	16.000	40.000
12.007	M12 x 1,5	9.000	7.000	11.30	100.000	16.000	40.000
14.006	M14 x 1,25	11.000	9.000	13.40	100.000	15.000	40.000
14.007	M14 x 1,5	11.000	9.000	13.30	100.000	15.000	40.000
16.007	M16 x 1,5	12.000	9.000	15.30	100.000	15.000	44.000
20.007	M20 x 1,5	16.000	12.000	19.30	125.000	16.000	44.000

ISO MF 公制螺紋用機械絲攻 DIN 374

Durativ N-X: 高性能無屑絲攻系列



貨號 53619

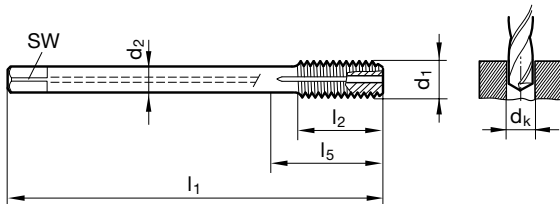
Durativ N-X	~DIN 374	E	HSS-E- PM	TiCN	(R)	6HX
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P	M	K	N	S	H
●	●	●	○	●	

- 通孔和盲孔用
- 高性能擠壓成型螺紋加工刀具, 柄徑公差為h6
- 可攻較深的螺紋 (~3.5xD)
- 特別適用於所有可成型材質
- 加工材質硬度需 $\leq 1200 \text{ N/mm}^2$
- 新粉末冶金的基材、創新性幾何形狀和摩擦系數低的硬質鍍層帶來最高的刀具壽命
- 減少下孔阻力30%, 最高的加工可靠性和利潤率
- 可實現更高切削速度
- 大批量生產時每個螺紋的加工成本最低

注意項目

絲攻帶軸向內冷和潤滑油槽
無效牙較少 (Form E = 1.5~2牙)
螺紋深度容易可加工到孔底接近



訂購代碼	d1	d2	SW	dk	l1	l2	l5
		mm	mm	mm	mm	mm	mm
8.005	M8 x 1	6.000	4.900	7.55	90.000	11.000	35.000
10.005	M10 x 1	7.000	5.500	9.55	90.000	11.000	35.000
10.006	M10 x 1,25	7.000	5.500	9.40	100.000	14.000	39.000
12.006	M12 x 1,25	9.000	7.000	11.40	100.000	16.000	40.000
12.007	M12 x 1,5	9.000	7.000	11.30	100.000	16.000	40.000
14.006	M14 x 1,25	11.000	9.000	13.40	100.000	15.000	40.000
14.007	M14 x 1,5	11.000	9.000	13.30	100.000	15.000	40.000
16.007	M16 x 1,5	12.000	9.000	15.30	100.000	15.000	44.000
20.007	M20 x 1,5	16.000	12.000	19.30	125.000	16.000	44.000

UNC 美制螺紋用機械絲攻 DIN 371/376

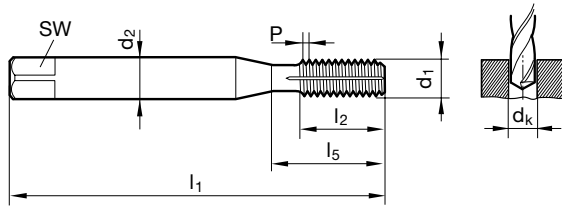
Durativ N-X: 高性能無屑絲攻系列



貨號 53633



P	M	K	N	S	H
●	●	●	○	●	



- 通孔和盲孔用
- 高性能擠壓成型螺紋加工刀具, 柄徑公差為h6
- 可攻較深的螺紋 (~3.5xD)
- 特別適用於所有可成型材質
- 加工材質硬度需 $\leq 1200 \text{ N/mm}^2$
- 新粉末冶金的基材、創新性幾何形狀和摩擦系數低的硬質鍍層帶來最高的刀具壽命
- 減少下孔阻力30%, 最高的加工可靠性和利潤率
- 可實現更快的攻牙加工
- 大批量生產時每個螺紋的加工成本最低

訂購代碼	d1	d2	SW	dk	l1	l2	l5
	mm	mm	mm	mm	mm	mm	mm
2.845	4 - 40	3.500	2.700	2.55	56.000	11.000	18.000
3.505	6 - 32	4.000	3.000	3.15	56.000	12.000	20.000
4.166	8 - 32	4.500	3.400	3.80	63.000	12.000	21.000
4.826	10 - 24	6.000	4.900	4.35	70.000	14.000	25.000
5.486	12 - 24	6.000	4.900	5.00	80.000	16.000	30.000
6.350	1/4 - 20	7.000	5.500	5.75	80.000	16.000	30.000
7.938	5/16 - 18	8.000	6.200	7.30	90.000	18.000	35.000
9.525	3/8 - 16	10.000	8.000	8.80	90.000	20.000	35.000
11.113	7/16 - 14	8.000	6.200	10.30	100.000	22.000	42.000
12.700	1/2 - 13	9.000	7.000	11.80	100.000	25.000	40.000
14.288	9/16 - 12	11.000	9.000	13.30	100.000	28.000	40.000
15.875	5/8 - 11	12.000	9.000	14.80	100.000	30.000	44.000
19.050	3/4 - 10	14.000	11.000	17.90	110.000	33.000	44.000

Application recommendations for N form taps



Hole type	HSS-E	HSS-E	HSS-E	HSS-E-PM	Solid carbide
Type	Durativ	Durativ	Durativ	Durativ	Durativ
Form	C w/o oil grooves	C with oil grooves	C with oil grooves	C with oil grooves	C with oil grooves
Surface finish	TiN	blank	TiN	AlCrN	TiCN
Cooling	without	without	without	without	radial*

Thread type	Dimensions to DIN 2184-1	Tolerance zone	Catalogue no./Ø-range/Page				
			63121 M2 - M10 Page 132	73120 M3 - M10 Page 133	63120 M3 - M10 Page 134	53620 M3 - M10 Page 135	63013 M3 - M10 Page 136
M	~ DIN 371	4/6HX			63119 M3 - M10 Page 137	53621 M3 - M10 Page 137	
		6GX					
	~ DIN 376	6HX	63123 M12 - M20 Page 132		63122 M12 - M16 Page 134	53622 M12 - M20 Page 135	
		6GX					
MF	~ DIN 374	6HX			63703 M8x1 - M16x1.5 Page 138		

Materialgruppe	Tensile strength	Recommended cutting speed v _c m/min					
		10	11	12	12	25	
P	Alloyed heat-treatable steels, tool steels, high speed steels	800 - 1200 N/mm ²	10	11	12	12	25
M	Stainless steels, sulphured, austenitic	≤1000 N/mm ²	4	5	6		15
	Stainless- and acidresistant steels, martensitic	≤1000 N/mm ²	4	3	4		12
	Duplex and Super Duplex	≤1300 N/mm ²					15
K	Spheroidal and malleable cast iron	from GGG40	15	14	15		40
N	Aluminum, non-ferrous metals and plastics		20	18	20		45
S	Special-, Super- and Titanium alloys						10

All tools from M2 with oil grooves.
* from M5 with IC

Fluteless taps M

Fluteless taps w/o oil grooves for ISO metric threads



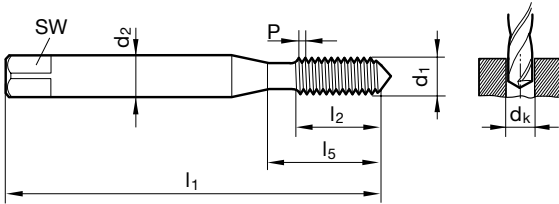
Catalogue no. 63121

Durativ	DIN 371	C	HSS-E	TiN	R	6HX
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P	M	K	N	S	H
•	•		•		

Application recommendations page 131

- for through and blind holes
- for large thread depths
- for universal application
- steel materials up to 1000 N/mm²
- acid resist./stainless steels
- tough, long-chipping materials



d1	P	d2	SW	dk	l1	l2	l5
	mm	mm	mm	mm	mm	mm	mm
M2	0.400	2.800	2.100	1.85	45.000	8.000	13.500
M3	0.500	3.500	2.700	2.80	56.000	10.000	18.000
M4	0.700	4.500	3.400	3.70	63.000	12.000	21.000
M5	0.800	6.000	4.900	4.65	70.000	14.000	25.000
M6	1.000	6.000	4.900	5.55	80.000	16.000	30.000
M8	1.250	8.000	6.200	7.40	90.000	17.000	35.000
M10	1.500	10.000	8.000	9.30	100.000	20.000	39.000

Fluteless taps M

Fluteless taps w/o oil grooves for ISO metric threads



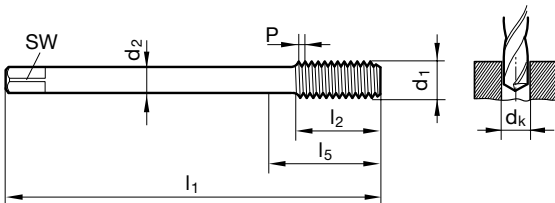
Catalogue no. 63123

Durativ	~DIN 376	C	HSS-E	TiN	R	6HX
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P	M	K	N	S	H
•	•		•		

Application recommendations page 24

- for through and blind holes
- for large thread depths
- for universal application
- steel materials up to 1000 N/mm²
- acid resist./stainless steels
- tough, long-chipping materials



d1	P	d2	SW	dk	l1	l2	l5
	mm	mm	mm	mm	mm	mm	mm
M12	1.750	9.000	7.000	11.20	110.000	24.000	49.000
M16	2.000	12.000	9.000	15.10	110.000	26.000	54.000
M20	2.500	16.000	12.000	18.90	140.000	32.000	62.000

Fluteless taps M

Fluteless taps with oil grooves for ISO metric threads



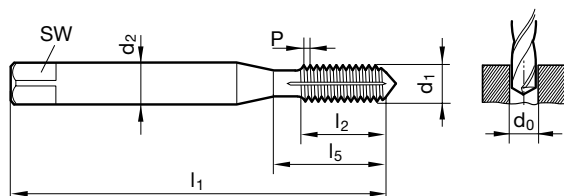
Catalogue no. 73120

Durativ	~DIN 371	C	HSS-E	bright	R	6HX
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P	M	K	N	S	H
•	•		•		

Application
recommendations
page 131

- for through and blind holes
- for large thread depths
- for universal application
- steel materials up to 1000 N/mm²
- acid resist./stainless steels
- tough, long-chipping materials



d1	P	d2	SW	dk	l1	l2	l5
	mm	mm	mm	mm	mm	mm	mm
M3	0.500	3.500	2.700	2.80	56.000	10.000	18.000
M4	0.700	4.500	3.400	3.70	63.000	12.000	21.000
M5	0.800	6.000	4.900	4.65	70.000	14.000	25.000
M6	1.000	6.000	4.900	5.55	80.000	16.000	30.000
M8	1.250	8.000	6.200	7.40	90.000	17.000	35.000
M10	1.500	10.000	8.000	9.30	100.000	20.000	39.000

Fluteless taps M

Fluteless taps with oil grooves for ISO metric threads



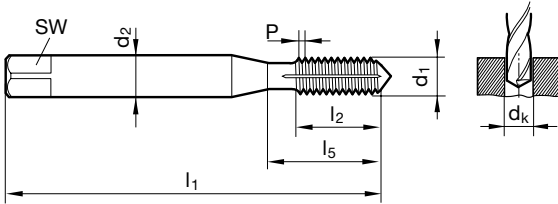
Catalogue no. 63120

Durativ	~DIN 371	C	HSS-E	TiN		6HX
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P	M	K	N	S	H
•	•		•		

Application recommendations page 131

- for through and blind holes
- for large thread depths
- for universal application
- steel materials up to 1000 N/mm²
- acid resist./stainless steels
- tough, long-chipping materials



d1	P	d2	SW	dk	l1	l2	l5
mm	mm	mm	mm	mm	mm	mm	mm
M3	0.500	3.500	2.700	2.80	56.000	10.000	18.000
M4	0.700	4.500	3.400	3.70	63.000	12.000	21.000
M5	0.800	6.000	4.900	4.65	70.000	14.000	25.000
M6	1.000	6.000	4.900	5.55	80.000	16.000	30.000
M8	1.250	8.000	6.200	7.40	90.000	17.000	35.000
M10	1.500	10.000	8.000	9.30	100.000	20.000	39.000

Fluteless taps M

Fluteless taps with oil grooves for ISO metric threads



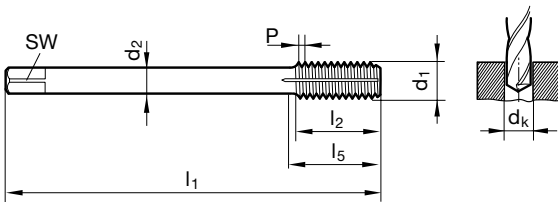
Catalogue no. 63122

Durativ	~DIN 376	C	HSS-E	TiN		6HX
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P	M	K	N	S	H
•	•		•		

Application recommendations page 131

- for through and blind holes
- for large thread depths
- for universal application
- steel materials up to 1000 N/mm²
- acid resist./stainless steels
- tough, long-chipping materials



d1	P	d2	SW	dk	l1	l2	l5
mm	mm	mm	mm	mm	mm	mm	mm
M12	1.750	9.000	7.000	11.20	110.000	24.000	49.000
M14	2.000	11.000	9.000	13.10	110.000	26.000	53.000
M16	2.000	12.000	9.000	15.10	110.000	26.000	54.000

Fluteless taps M

Fluteless taps with oil grooves for ISO metric threads



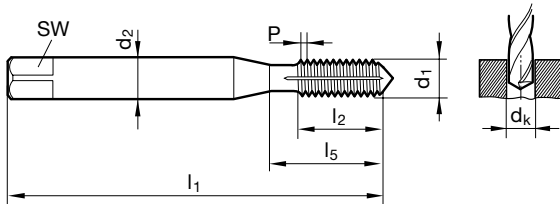
Catalogue no. 53620

Durativ	~DIN 371	C	HSS-E- PM	Al- CrN		6HX
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P	M	K	N	S	H
•	•		•		

Application recommendations page 131

- for through and blind holes
- for large thread depths
- for universal application
- steel materials up to 1000 N/mm²
- acid resist./stainless steels
- tough, long-chipping materials



d1	P	d2	SW	dk	l1	l2	l5
mm	mm	mm	mm	mm	mm	mm	mm
M3	0.500	3.500	2.700	2.80	56.000	10.000	18.000
M4	0.700	4.500	3.400	3.70	63.000	12.000	21.000
M5	0.800	6.000	4.900	4.65	70.000	14.000	25.000
M6	1.000	6.000	4.900	5.55	80.000	16.000	30.000
M8	1.250	8.000	6.200	7.40	90.000	17.000	35.000
M10	1.500	10.000	8.000	9.30	100.000	20.000	39.000

Fluteless taps M

Fluteless taps with oil grooves for ISO metric threads



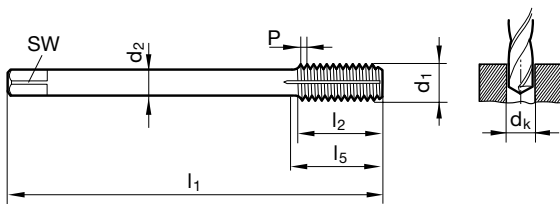
Catalogue no. 53622

Durativ	~DIN 376	C	HSS-E- PM	Al- CrN		6HX
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P	M	K	N	S	H
•	•		•		

Application recommendations page 131

- for through and blind holes
- for large thread depths
- for universal application
- steel materials up to 1000 N/mm²
- acid resist./stainless steels
- tough, long-chipping materials



d1	P	d2	SW	dk	l1	l2	l5
mm	mm	mm	mm	mm	mm	mm	mm
M12	1.750	9.000	7.000	11.20	110.000	24.000	49.000
M14	2.000	11.000	9.000	13.10	110.000	26.000	53.000
M16	2.000	12.000	9.000	15.10	110.000	26.000	54.000
M20	2.500	16.000	12.000	18.90	140.000	32.000	62.000

Fluteless taps M

Fluteless taps with coolant ducts for metric ISO threads



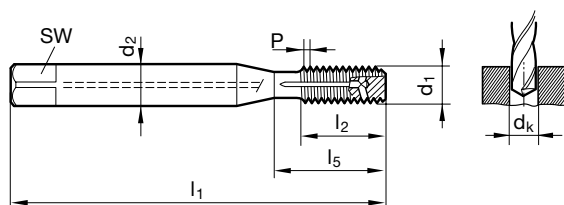
Catalogue no. 63013

Durativ	~DIN 371	C	VHM	TiCN	R	6HX
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P	M	K	N	S	H
•	•		•		

Application
recommendations
page 131

- for through and blind holes
- for large thread depths
- for universal application
- radial coolant exit
- steel materials up to 1000 N/mm²
- acid resist./stainless steels
- tough, long-chipping materials



d1	P	d2	SW	dk	l1	l2	l5
	mm	mm	mm	mm	mm	mm	mm
M3	0.500	3.500	2.700	2.80	56.000	6.000	18.000
M4	0.700	4.500	3.400	3.70	63.000	7.500	21.000
M5	0.800	6.000	4.900	4.65	70.000	8.500	25.000
M6	1.000	6.000	4.900	5.55	80.000	11.000	30.000
M8	1.250	8.000	6.200	7.40	90.000	14.000	35.000
M10	1.500	10.000	8.000	9.30	100.000	16.000	39.000

Fluteless taps M

Fluteless taps with oil grooves for ISO metric threads



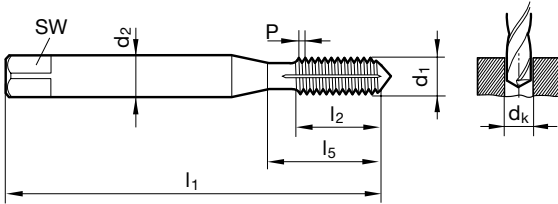
Catalogue no. 63119

Durativ	~DIN 371	C	HSS-E	TiN	R	6GX
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P	M	K	N	S	H
•	•		•		

Application recommendations page 131

- for through and blind holes
- for large thread depths
- for universal application
- steel materials up to 1000 N/mm²
- acid resist./stainless steels
- tough, long-chipping materials



d1	P	d2	SW	dk	l1	l2	l5
	mm	mm	mm	mm	mm	mm	mm
M3	0.500	3.500	2.700	2.80	56.000	10.000	18.000
M4	0.700	4.500	3.400	3.70	63.000	12.000	21.000
M5	0.800	6.000	4.900	4.65	70.000	14.000	25.000
M6	1.000	6.000	4.900	5.55	80.000	16.000	30.000
M8	1.250	8.000	6.200	7.40	90.000	17.000	35.000
M10	1.500	10.000	8.000	9.30	100.000	20.000	39.000

Fluteless taps M

Fluteless taps with oil grooves for ISO metric threads



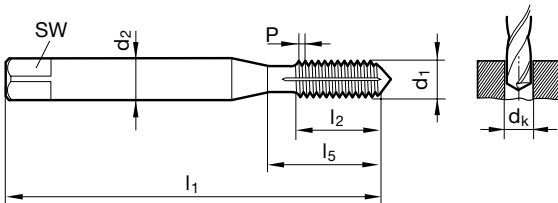
Catalogue no. 53621

Durativ	~DIN 371	C	HSS-E-PM	Al-CrN	R	6GX
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P	M	K	N	S	H
•	•		•		

Application recommendations page 131

- for through and blind holes
- for large thread depths
- for universal application
- steel materials up to 1000 N/mm²
- acid resist./stainless steels
- tough, long-chipping materials



d1	P	d2	SW	dk	l1	l2	l5
	mm	mm	mm	mm	mm	mm	mm
M3	0.500	3.500	2.700	2.80	56.000	10.000	18.000
M4	0.700	4.500	3.400	3.70	63.000	12.000	21.000
M5	0.800	6.000	4.900	4.65	70.000	14.000	25.000
M6	1.000	6.000	4.900	5.55	80.000	16.000	30.000
M8	1.250	8.000	6.200	7.40	90.000	17.000	35.000
M10	1.500	10.000	8.000	9.30	100.000	20.000	39.000

Fluteless taps with oil grooves MF

Fluteless taps for ISO metric fine threads



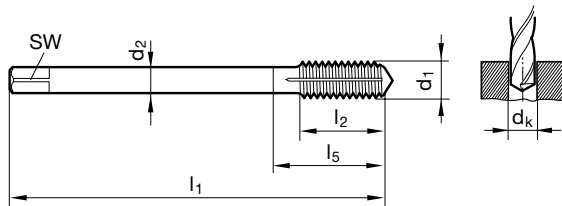
Catalogue no. 63703



P	M	K	N	S	H
•	•	•	○	•	

Application recommendations page 131

- for through and blind holes
- steel materials of up to 1200 N/mm²
- acid resist./stainless steels
- malleable cast materials
- malleable non-ferrous metals
- special alloys



Code no.	d1	d2 mm	SW mm	dk mm	l1 mm	l2 mm	l5 mm
8.005	M8 x 1	6.000	4.900	7.55	90.000	17.000	35.000
10.005	M10 x 1	7.000	5.500	9.55	90.000	16.000	35.000
10.006	M10 x 1,25	7.000	5.500	9.40	100.000	20.000	39.000
12.005	M12 x 1	9.000	7.000	11.55	100.000	20.000	40.000
12.007	M12 x 1,5	9.000	7.000	11.30	100.000	20.000	40.000
14.007	M14 x 1,5	11.000	9.000	13.30	100.000	20.000	40.000
16.007	M16 x 1,5	12.000	9.000	15.30	100.000	22.000	44.000