

Hand taps M DIN 352 HSS, ground

Set: 3 piece Thread: metric, DIN ISO 13
 Taper tap: 5-6 thread chamfer Flanks: relief-ground
 Second tap: 4-5 thread chamfer Tolerance: ISO 2/6H
 Final tap: 2-3 thread chamfer Surface: bright
 Right hand cutting

For through threads and bottoming threads in alloyed or low-alloyed steels up to 800N/mm² strength, malleable cast iron and non-ferrous metals. The thread is cut in three operations.

Packing unit: set in plastic pack

Nominal thread size	Pitch mm	Thread core hole	Total length mm	Thread length mm	Part no.
M1	0.25	0.75	32	5.5	R230010
M1.2	0.25	0.95	32	5.5	R230012
M1.4	0.30	1.10	32	7.0	R230014
M1.56	0.35	1.25	32	7.0	R230016
M1.7	0.35	1.35	32	8.0	R230017
M1.8	0.35	1.45	32	8.0	R230018
M2	0.40	1.60	36	8.0	R230020
M2.2	0.45	1.75	36	9.0	R230022
M2.3	0.40	1.90	36	9.0	R230023
M2.5	0.45	2.10	40	8.0	R230025
M2.6	0.45	2.10	40	8.0	R230026
M3	0.50	2.50	40	10.0	R230030
M3.5	0.60	2.90	45	12.0	R230035
M4	0.70	3.30	45	12.0	R230040
M4.5	0.75	3.70	50	16.0	R230045
M5	0.80	4.20	50	13.0	R230050
M6	1.00	5.00	50	15.0	R230060
M7	1.00	6.00	50	16.0	R230070
M8	1.25	6.80	56	18.0	R230080
M9	1.25	7.80	63	22.0	R230090
M10	1.50	8.50	70	24.0	R230100
M11	1.50	9.50	70	24.0	R230110
M12	1.75	10.20	75	29.0	R230120
M14	2.00	12.00	80	30.0	R230140
M15	2.00	13.00	80	32.0	R230150
M16	2.00	14.00	80	32.0	R230160
M18	2.50	15.50	95	40.0	R230180
M20	2.50	17.50	95	40.0	R230200
M22	2.50	19.50	100	40.0	R230220
M24	3.00	21.00	110	45.0	R230240
M27	3.00	24.00	110	50.0	R230270
M30	3.50	26.50	125	56.0	R230300
M33	3.50	29.50	125	56.0	R230330
M36	4.00	32.00	150	63.0	R230360
M39	4.00	35.00	150	63.0	R230390
M42	4.50	37.50	150	63.0	R230420
M45	4.50	40.50	160	70.0	R230450
M48	5.00	43.00	180	75.0	R230480
M52	5.00	47.00	180	75.0	R230520



Loose Taps available
 i.e. to order 6mm taps, part no. is R230060-1

Hand taps G DIN 5157 HSS, ground

Set: 2-piece Flanks: relief-ground
 Taper tap: 5-6 thread chamfer Tolerance: ISO 2 / 6H
 Final tap: 2-3 thread chamfer Surface: bright
 Thread: DIN ISO 228 'G' (cylindrical pipe thread)
 DIN 2999 'Rp' (whitworth pipe thread)
 Right hand cutting

For through threads and bottoming threads in alloyed or low-alloyed steels up to 800N/mm² strength, malleable cast iron and non-ferrous metals. The thread is cut in three operations.

Nominal Thread size	Threads per inch	Thread core hole	Total length mm	Thread length mm	Part no.	
G 1/8	Rp 1/8	28	8.8	63	18	R236018
G 1/4	Rp 1/4	19	11.8	70	20	R236014
G 3/8	Rp 3/8	19	15.25	70	20	R236038
G 1/2	Rp 1/2	14	19	80	22	R236012



Hand taps MF DIN 2181 HSS, ground

Set: 2-piece
 Taper tap: 5-6 thread chamfer
 Final tap: 2-3 thread chamfer
 Thread: metric, fine, DIN ISO 13
 Flanks: relief-ground
 Tolerance: ISO2 / 6H
 Surface: bright

For through threads and bottoming threads in unalloyed or low-alloyed steels up to 800N/mm² strength, malleable cast iron and non-ferrous metals. The thread is cut in two operations.

Right hand cutting

Also available individually

Taper tap: Product code -1

Final tap: Product code -2



Nominal thread size	Pitch mm	Thread core hole mm	Total length mm	Thread length mm	Part no.
MF 3	0.35	2.60	40	10	R235030
MF 4	0.35	3.10	45	10	R235040
MF 4	0.50	3.50	45	12	R235041
MF 5	0.50	4.50	50	13	R235050
MF 6	0.50	5.50	50	14	R235061
MF 6	0.75	5.20	50	15	R235060
MF 7	0.75	6.20	50	14	R235070
MF 8	0.50	7.50	50	19	R235082
MF 8	0.75	7.20	56	18	R235080
MF 8	1.00	7.00	56	18	R235081
MF 9	0.75	8.20	56	19	R235092
MF 9	1.00	8.00	63	20	R235090
MF 10	0.75	9.20	63	20	R235102
MF 10	1.00	9.00	63	18	R235100
MF 10	1.25	8.70	70	24	R235101
MF 11	1.00	9.20	63	20	R235110
MF 11	1.25	9.80	63	22	R235111
MF 12	1.00	11.00	70	20	R235122
MF 12	1.25	10.70	70	20	R235121
MF 12	1.50	10.50	70	20	R235120
MF 13	1.00	12.00	70	22	R235130
MF 13	1.50	11.50	70	22	R235131
MF 14	1.00	13.00	70	20	R235142
MF 14	1.25	12.70	70	20	R235140
MF 14	1.50	12.50	70	20	R235141
MF 15	1.50	13.50	70	22	R235150
MF 16	1.00	15.00	70	20	R235161
MF 16	1.50	14.50	70	20	R235160
MF 18	1.00	17.00	80	22	R235181
MF 18	1.25	16.80	80	22	R235183
MF 18	1.50	16.50	80	22	R235180
MF 18	2.00	16.00	80	22	R235182
MF 20	1.00	19.00	80	22	R235201
MF 20	1.25	18.80	80	22	R235203
MF 20	1.50	18.50	80	22	R235200
MF 35	1.50	33.50	100	25	R235350
MF 38	1.50	36.50	110	25	R235380
MF 40	1.50	38.50	110	25	R235400
MF 42	1.50	40.50	110	25	R235420
MF 45	1.50	43.50	110	25	R235450
MF 48	1.50	46.50	125	40	R235480
MF 50	1.50	48.50	125	40	R235500
MF 52	1.50	50.50	125	40	R235520

Hand taps M DIN 352 HSS, ground

Set: 3 piece
 Taper tap: 5-6 thread chamfer
 Second tap: 4-5 thread chamfer
 Final tap: 2-3 thread chamfer
 Thread: american UNC coarse thread
 Flanks: relief-ground
 Tolerance: 2B
 Surface: bright
 Right hand cutting

For through threads and bottoming threads in alloyed or low-alloyed steels up to 800N/mm² strength, malleable cast iron and non-ferrous metals. The thread is cut in three operations.

Packing unit: set in plastic pack

Nominal thread size	Threads per inch	Thread core hole mm	Total length mm	Thread length mm	Part no.
No. 2	56	1.85	36	11.0	R246020 UNC
No. 3	48	2.10	36	11.0	R246030 UNC
No. 4	40	2.35	40	12.0	R246040 UNC
No. 5	40	2.65	40	12.0	R246050 UNC
No. 6	32	2.85	45	14.0	R246060 UNC
No. 8	32	3.50	45	14.0	R246080 UNC
No. 10	24	3.90	50	16.0	R246100 UNC
No. 12	24	4.50	50	18.0	R246120 UNC
1/4	20	5.10	50	19.0	R246014 UNC
5/16	18	6.60	56	22.0	R246516 UNC
3/8	16	8.00	70	24.0	R246038 UNC
7/16	14	9.40	70	24.0	R246716 UNC
1/2	13	10.80	75	29.0	R246012 UNC
9/16	12	12.20	80	30.0	R246916 UNC
5/8	11	13.50	80	32.0	R246058 UNC
3/4	10	16.50	95	40.0	R246034 UNC
7/8	9	19.50	100	40.0	R246078 UNC
1	8	22.25	110	50.0	R246010 UNC



Loose Taps available
 i.e. to order 6mm taps, part no. is R246020 UNC-1

Combined machine taps HSS, ground

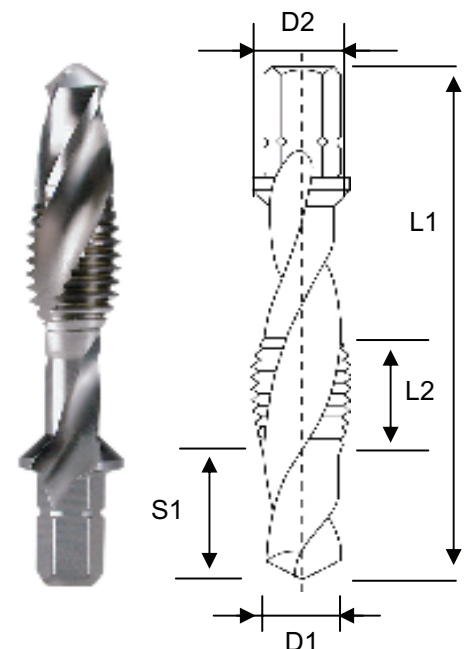
Thread: metric DIN ISO 13
 Flanks: relief-ground
 Tolerance: ISO 2/6H
 Surface: bright
 Shank: 1/4" hexagon
 Right hand cutting

The combined machine tap is suitable for sheet metal working with right/left handed rotation cordless drilling machines. For tapping drill hole and through thread in unalloyed or low-alloyed steels up to 600 N/mm² strength, malleable cast iron and non-ferrous metals. The thread is cut in one operation, without any tool changing. The tool incorporates a twist drill before the thread-tapping part. The machine tap consists of heavy-duty high speed steel.

In one working stroke:

- ✓ Hole drilling
- ✓ Thlead cutting (tapping)
- ✓ Thread deburring
- ✓ Thread cleaning

Nominal thread size	Pitch mm	L1m m	S1m m	L2 mm	D1 mm	D2 mm	Part no.
M5	0.8	41	7	9	4.2	7.2	R270016
M6	1	44	8	11	5	7.2	R270017
M8	1.25	51	11	14	6.8	8.8	R270018
M10	1.5	59	15	15	8.5	11	R270019



Round dies M DIN EN 22568 HSS, ground (formerly DIN 223)

Type: Type B closed, preslotted
 Thread: metric, DIN ISO 13
 Tolerance: ISO - 6g
 Surface: bright

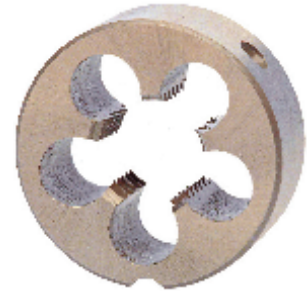
For unalloyed or low-alloyed steels up to 800 N/mm² strength and non-ferrous metals.

The thread is cut in one operation. The round die consists of cobalt alloyed heavy duty high speed steel with higher heat resistance for a longer tool life.

Right hand cutting

Packing unit: individual plastic pack

Nominal thread size	Pitch mm	Outside Ø mm	Thickness mm	Part no.
M1	0.25	16.00	5	R237010
M1.2	0.25	16.00	5	R237012
M1.4	0.30	16.00	5	R237014
M1.6	0.35	16.00	5	R237016
M1.7	0.35	16.00	5	R237017
M1.8	0.35	16.00	5	R237018
M2	0.40	16.00	5	R237020
M2.2	0.45	16.00	5	R237022
M2.3	0.40	16.00	5	R237023
M2.5	0.45	16.00	5	R237025
M2.6	0.45	16.00	5	R237026
M3	0.50	20.00	5	R237030
M3.5	0.60	20.00	5	R237035
M4	0.70	20.00	5	R237040
M4.5	0.75	20.00	7	R237045
M5	0.80	20.00	7	R237050
M6	1.00	20.00	7	R237060
M7	1.00	25.00	9	R237070
M8	1.25	25.00	9	R237080
M9	1.25	25.00	9	R237090
M10	1.50	30.00	11	R237100
M11	1.50	30.00	11	R237110
M12	1.75	38.00	14	R237120
M14	2.00	38.00	14	R237140
M16	2.00	45.00	18	R237160
M18	2.50	45.00	18	R237180
M20	2.50	45.00	18	R237200
M22	2.50	55.00	22	R237220
M24	3.00	55.00	22	R237240
M27	3.00	65.00	25	R237270
M30	3.50	65.00	25	R237300
M33	3.50	65.00	25	R237330
M36	4.00	65.00	25	R237360
M39	4.00	75.00	30	R237390
M42	4.50	75.00	30	R237420
M45	4.50	90.00	36	R237450
M48	5.00	90.00	36	R237480
M52	5.00	90.00	36	R237520



Round dies M ≈ DIN EN 22568 HSS ground (formerly DIN 223)

Type: Type B closed, preslotted
 Thread: metric, DIN ISO 13
 Tolerance: ISO - 6g
 Surface: bright

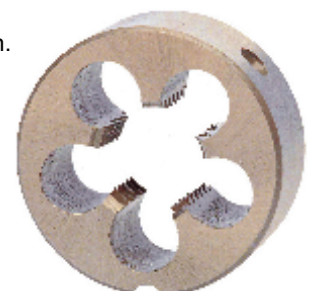
For unalloyed or low-alloyed steels up to 800 N/mm² strength and non-ferrous metals.

The thread is cut in one operation.

Right hand cutting

Packing unit: Individual plastic pack

Nominal thread size	Pitch mm	Outside Ø mm	Thickness mm	Part no.
M4	0.70	25.00	9	R238040
M5	0.80	25.00	9	R238050
M6	1.00	25.00	9	R238060
M8	1.25	25.00	9	R238080
M10	1.50	25.00	9	R238100
M12	1.75	25.00	9	R238120



Tap Wrench with ratchet

Version: adjustable left, right, fixed
 Shank: sliding cross-handle with grooves at both ends
 Surface: chromium plated
 Packing unit: Individual plastic pack

Ideal for thread-cutting in accessible places.
 With two-jaw chuck for tensioning square shanks.



Size	Length mm	for hand tape size			Part no.
		M	Ww	G	
1.0	85.0	M3 - M10	1/8 - 3/8	-	R241001
2.0	100.0	M5 - M12	7/32 - 1/2	6 1/8	R241002
10	250.0	M3 - M10	1/8 - 3/8	-	R241010
20	300.0	M5 - M12	7/32 - 1/2	6 1/8	R241020

Adjustable tap wrenches as per DIN 1814

Version: die-cast zinc housing
 Chuck jaws: hardened

Ideal for thread-cutting in accessible places.
 With two-jaw chuck for tensioning square shanks. With steel handles one of which can be unscrewed.



Packing unit: Individual plastic pack

Size	Length mm	for hand tape size			Part no.
		M	Ww	G	
0	130.0	M1 - M8	1/16 - 5/16	-	R241100
1	180.0	M1 - M10	1/8 - 3/8	-	R241101
2	180.0	M1 - M12	1/8 - 1/2	1/8	R241112
2	280.0	M3.5 - M12	3/16 - 5/8	1/8 - 3/8	R241102
3	380.0	M5 - M20	1/4 - 3/4	1/8 - 1/2	R241103
4	500.0	M11 - M27	1/2 - 1	1/8 - 3/4	R241104
5	700.0	M13 - M32	5/8 - 1 1/4	1/4 - 1	R241105
6	1000.0	M19 - M38	3/4 - 1 1/2	1/4 - 1 1/4	R241106
7	1200.0	M25 - M52	07/08/2002	5/8 - 2 1/4	R241107

Die stocks as per DIN 225

Version: die-cast zinc housing

For closed and slotted taps as per DIN EN 24231. With steel handles one of which can be unscrewed and fixed with screws for clamping the tap.

Packing unit: Individual plastic pack

Size	Thickness mm	Length mm	for tap size			Part no.
			M + MF	Ww	G	
16	5.0	160.0	M1 - M2.6	1/16 - 3/32	-	R242165
20	5.0	200.0	M3 - M4	1/8 - 5/32	-	R242205
20	7.0	200.0	M4.5 - M6	3/16 - 1/4	-	R242207
25	9.0	224.0	M7 - M9	5/16	0.1	R242259
30	11.0	280.0	M10 - M11	3/8 - 7/16	0.1	R2423011
38	10.0	315.0	MF12 - MF14	-	0.3	R2423810
38	14.0	315.0	M12 - M14	1/2 - 9/16	-	R2423814
45	14.0	450.0	MF16 - MF20	-	3/8 - 1/2	R2424514
45	18.0	450.0	M16 - M20	5/8 - 3/4	-	R2424518
55	16.0	560.0	MF22 - MF24	-	5/8 - 3/4	R2425516
55	22.0	560.0	M22 - M24	7/8 - 1	-	R2425522
65	18.0	630.0	MF27 - MF36	-	07/08/2001	R2426518
65	25.0	630.0	M27 - M36	1 1/8 - 1 3/8	-	R2426525
75	30.0	740.0	M38 - M42	1 1/2 - 1 5/8	-	R2427530
75	20.0	740.0	MF38 - MF42	-	1 1/8 - 1 1/4	R2427520
90	36.0	900.0	M45 - M52	1 3/4 - 2	-	R2429036
90	22.0	900.0	MF45 - MF52	-	1 3/8 - 1 5/8	R2429022
105	36.0	975.0	M54 - M63	2 1/4 - 2 3/4	-	R24210536
105	22.0	975.0	MF54 - MF63	-	1 3/4 - 2	R24210522

