



# THREADING TOOLS

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THREADING  
TOOLS



## Fluteless taps with oil grooves

Type	Form	Tolerance on Ø	Tool material	Surface	Standard	Diameter range	Catalog no.	Discount group	Standard range, page
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## Fluteless machine taps for ISO metric threads

	Durativ	C	6HX	HSS-E	bright	~ DIN 371	M 3 - M10	<b>73120</b>	103	521
	Durativ	C	6HX	HSS-E	TiN	~ DIN 371	M 3 - M10	<b>63120</b>	103	521
	Durativ	C	6GX	HSS-E	TiN	~ DIN 371	M 3 - M10	<b>63119</b>	103	522
	Durativ	C	6HX	HSS-E	TiN	~ DIN 376	M12 - M16	<b>63122</b>	103	523
	Durativ	C	6HX	HSS-E-PM	AlCrN	~ DIN 371	M 3 - M10	<b>53620</b>	103	524
	Durativ	C	6GX	HSS-E-PM	AlCrN	~ DIN 371	M 3 - M10	<b>53621</b>	103	525
	Durativ	C	6HX	HSS-E-PM	AlCrN	~ DIN 376	M12 - M20	<b>53622</b>	103	526

## Oil feed fluteless taps f. ISO metric threads

	Durativ	C	6HX	Solid Carbide	AlTiN	~ DIN 371	M 3 - M10	<b>63013</b>	103	527
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## Fluteless taps without oil grooves

Type	Form	Tolerance on Ø	Tool material	Surface	Standard	Diameter range	Catalog no.	Discount group	Standard range, page
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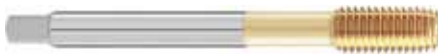
### Fluteless machine taps for ISO metric threads



Durativ	C	6HX	HSS-E	bright	DIN 371	M 2 - M10	<b>73121</b>	103	528
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Durativ	C	6HX	HSS-E	TiN	DIN 371	M 2 - M10	<b>63121</b>	103	528
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Durativ	C	6HX	HSS-E	TiN	~ DIN 376	M12 - M20	<b>63123</b>	103	529
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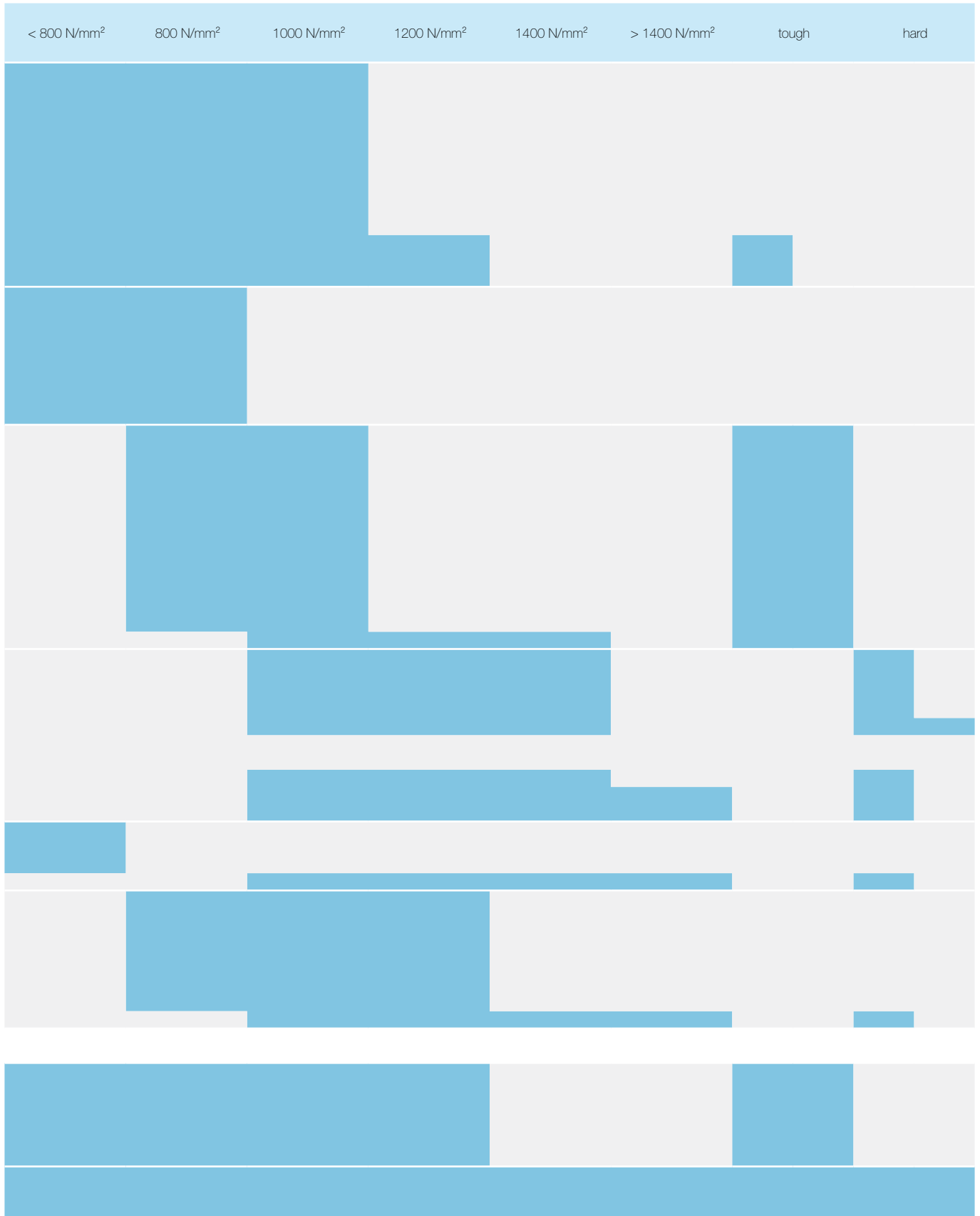
# Application

by materials

Coloured ring	Catalog no.		Nonferrous metals, Aluminium	Steels	GG, GGG	Stainless and acid resistant steels	Nickel, Titanium alloys	Harded steels
	Produktiv	Intensiv						
Green	73033	73046						
	73038	73048						
	73183	73187						
	73308	73322						
	73309	73323						
	73310	73324						
	73321	73325						
	63033	63046						
Green Synchro	53053	53050						
	53054	53051						
	53055	53052						
		63048						
Yellow	73133	73146						
	73132	73145						
	73138	73148						
	73250	73173						
	73293	73286						
	63133	63146						
	63138	63148						
	63250	63173						
Blue	73176	73660						
	73177	73659						
	73178	73180						
	73297	73304						
	73298	73305						
	73299	73306						
	73300	73288						
	63176	73662						
	63177	73665						
	73641	63662						
	73643	53662						
	53641	53665						
53667	53666							
Red	73642	53661						
	73645	73619						
	73646	73661						
	53642	73664						
	73640	73666						
	63641	63010						
	63643							
	53640							
53670	53670							
53669	53668							
Black	73131	73156						
	73189	73136						
	73011	73011						
	53670	53670						
White	73201	73201						
	73211	73211						
	73194	73194						
	73326	73326						
	73327	73327						
	73345	73345						
	63201	63201						
	53670	53670						
for blind and trough holes								
Thread Forming Taps	73121	63122						
	63121	53620						
	63123	53621						
	73120	53622						
	63120	63013						
	63119							
Thread Milling Cutters	73810	53820						
	73820	73830						
	53810	53830						

optimal well suited

by tensile strength



## Fluteless taps with oil grooves

### Fluteless machine taps for ISO metric threads

#### Catalog no. 73120



For through and blind holes of up to 1 x d. suitable for materials with good cold deformation and at least 10% extension characteristics such as unalloyed steels up to 1000 N/mm<sup>2</sup>, stainless-, noncorrosive and heat-resistant steels, al-alloys long chipping, zinc-alloys, zinc die-casting.

~ DIN 371	DIN 2174
Tool material	HSS-E
Surface	bright
Type	Durativ
Form	C
Cutting direction	right-hand
Tolerance on Ø	6HX
Flutes	with oil grooves

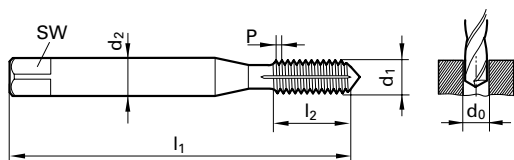
### Fluteless machine taps for ISO metric threads

#### Catalog no. 63120



For through and blind holes of up to 1 x d. suitable for materials with good cold deformation and at least 10% extension characteristics such as unalloyed steels up to 1000 N/mm<sup>2</sup>, stainless-, noncorrosive and heat-resistant steels, al-alloys long chipping, zinc-alloys, zinc die-casting. High wear resistance thanks to TiN coating.

~ DIN 371	DIN 2174
Tool material	HSS-E
Surface	TiN
Type	Durativ
Form	C
Cutting direction	right-hand
Tolerance on Ø	6HX
Flutes	with oil grooves



Catalog no.	73120	63120
Tool material	HSS-E	
Discount group	103	103
Cutting direction	right-hand	right-hand
Surface	bright	TiN

d1	P	d2	SW	d0	l1	l2	price per piece	
mm	mm	mm	mm	mm	mm	mm		
M 3	0.50	3.500	2.70	2.800	56.00	10.00	●	●
M 3,5	0.60	4.000	3.00	3.250	56.00	12.00	○	
M 4	0.70	4.500	3.40	3.700	63.00	12.00	●	●
M 5	0.80	6.000	4.90	4.650	70.00	14.00	●	●
M 6	1.00	6.000	4.90	5.550	80.00	16.00	●	●
M 8	1.25	8.000	6.20	7.400	90.00	18.00	●	●
M10	1.50	10.000	8.00	9.250	100.00	20.00	●	●

## Fluteless taps with oil grooves

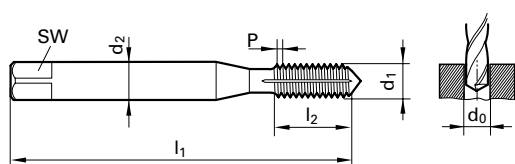
### Fluteless machine taps for ISO metric threads

#### Catalog no. 63119



For through and blind holes of up to 1 x d. suitable for materials with good cold deformation and at least 10% extension characteristics such as unalloyed steels up to 1000 N/mm<sup>2</sup>, stainless-, noncorrosive and heat-resistant steels, al-alloys long chipping, zinc-alloys, zinc die-casting. High wear resistance thanks to TiN coating.

~ DIN 371	DIN 2174
Tool material	HSS-E
Surface	TiN
Type	Durativ
Form	C
Cutting direction	right-hand
Tolerance on Ø	6GX
Flutes	with oil grooves



Catalog no.	63119
Tool material	HSS-E
Discount group	103
Cutting direction	right-hand
Surface	TiN

d1	P	d2	SW	d0	l1	l2	price per piece
mm	mm	mm	mm	mm	mm	mm	
M 3	0.50	3.500	2.70	2.800	56.00	10.00	●
M 4	0.70	4.500	3.40	3.700	63.00	12.00	●
M 5	0.80	6.000	4.90	4.650	70.00	14.00	●
M 6	1.00	6.000	4.90	5.550	80.00	16.00	●
M 8	1.25	8.000	6.20	7.400	90.00	18.00	●
M10	1.50	10.000	8.00	9.250	100.00	20.00	●

## Fluteless taps with oil grooves

### Fluteless machine taps for ISO metric threads

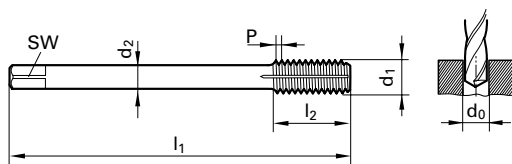
#### Catalog no. 63122



For through and blind holes of up to 1 x d. suitable for materials with good cold deformation and at least 10% extension characteristics such as unalloyed steels up to 1000 N/mm<sup>2</sup>, stainless-, noncorrosive and heat-resistant steels, al-alloys long chipping, zinc-alloys, zinc die-casting. High wear resistance thanks to TiN coating.

~ DIN 376    DIN 2174

Tool material	HSS-E
Surface	TiN
Type	Durativ
Form	C
Cutting direction	right-hand
Tolerance on Ø	6HX
Flutes	with oil grooves



Catalog no.	63122
Tool material	HSS-E
Discount group	103
Cutting direction	right-hand
Surface	TiN

d1	P	d2	SW	d0	l1	l2	price per piece
mm	mm	mm	mm	mm	mm	mm	
M12	1.75	9.000	7.00	11.250	110.00	24.00	●
M14	2.00	11.000	9.00	13.100	110.00	26.00	●
M16	2.00	12.000	9.00	15.100	110.00	26.00	●



## Fluteless taps with oil grooves

### Fluteless machine taps for ISO metric threads

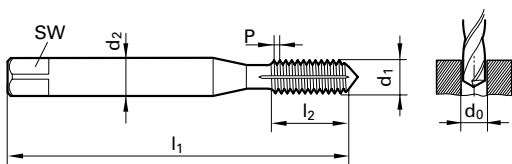
#### Catalog no. 53620



For through and blind holes of up to 1 x d. suitable for materials with good cold deformation and at least 10% extension characteristics such as unalloyed steels up to 1000 N/mm<sup>2</sup>, stainless-, noncorrosive and heat-resistant steels, al-alloys long chipping, zinc-alloys, zinc die-casting. Greatly increased wear resistance thanks to AlCrN coating.

~ DIN 371    **DIN 2174**

Tool material	HSS-E-PM
Surface	AlCrN
Type	Durativ
Form	C
Cutting direction	right-hand
Tolerance on Ø	6HX
Flutes	with oil grooves



Catalog no.	53620
Tool material	HSS-E-PM
Discount group	103
Cutting direction	right-hand
Surface	AlCrN

d1	P	d2	SW	d0	l1	l2	price per piece
mm	mm	mm	mm	mm	mm	mm	
M 3	0.50	3.500	2.70	2.800	56.00	10.00	●
M 4	0.70	4.500	3.40	3.700	63.00	12.00	●
M 5	0.80	6.000	4.90	4.650	70.00	14.00	●
M 6	1.00	6.000	4.90	5.550	80.00	16.00	●
M 8	1.25	8.000	6.20	7.400	90.00	18.00	●
M10	1.50	10.000	8.00	9.250	100.00	20.00	●

## Fluteless taps with oil grooves

### Fluteless machine taps for ISO metric threads

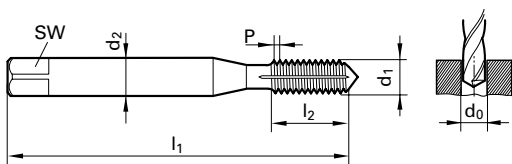
#### Catalog no. 53621



For through and blind holes of up to 1 x d. suitable for materials with good cold deformation and at least 10% extension characteristics such as unalloyed steels up to 1000 N/mm<sup>2</sup>, stainless-, noncorrosive and heat-resistant steels, al-alloys long chipping, zinc-alloys, zinc die-casting. Greatly increased wear resistance thanks to AlCrN coating.

~ DIN 371    **DIN 2174**

Tool material	HSS-E-PM
Surface	AlCrN
Type	Durativ
Form	C
Cutting direction	right-hand
Tolerance on Ø	6GX
Flutes	with oil grooves



Catalog no.	53621
Tool material	HSS-E-PM
Discount group	103
Cutting direction	right-hand
Surface	AlCrN

d1	P	d2	SW	d0	l1	l2	price per piece
mm	mm	mm	mm	mm	mm	mm	
M 3	0.50	3.500	2.70	2.800	56.00	10.00	●
M 4	0.70	4.500	3.40	3.700	63.00	12.00	●
M 5	0.80	6.000	4.90	4.650	70.00	14.00	●
M 6	1.00	6.000	4.90	5.550	80.00	16.00	●
M 8	1.25	8.000	6.20	7.400	90.00	18.00	●
M10	1.50	10.000	8.00	9.250	100.00	20.00	●

## Fluteless taps with oil grooves

### Fluteless machine taps for ISO metric threads

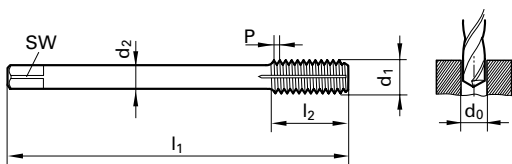
#### Catalog no. 53622



For through and blind holes of up to 1 x d. suitable for materials with good cold deformation and at least 10% extension characteristics such as unalloyed steels up to 1000 N/mm<sup>2</sup>, stainless-, noncorrosive and heat-resistant steels, al-alloys long chipping, zinc-alloys, zinc die-casting. Greatly increased wear resistance thanks to AlCrN coating.

~ DIN 376    DIN 2174

Tool material	HSS-E-PM
Surface	AlCrN
Type	Durativ
Form	C
Cutting direction	right-hand
Tolerance on Ø	6HX
Flutes	with oil grooves



Catalog no.	53622
Tool material	HSS-E-PM
Discount group	103
Cutting direction	right-hand
Surface	AlCrN

d1	P	d2	SW	d0	l1	l2	price per piece
mm	mm	mm	mm	mm	mm	mm	
M12	1.75	9.000	7.00	11.250	110.00	24.00	●
M14	2.00	11.000	9.00	13.100	110.00	26.00	●
M16	2.00	12.000	9.00	15.100	110.00	26.00	●
M20	2.50	16.000	12.00	18.900	140.00	32.00	●

## Fluteless taps with oil grooves

### Oil feed fluteless taps f. ISO metric threads

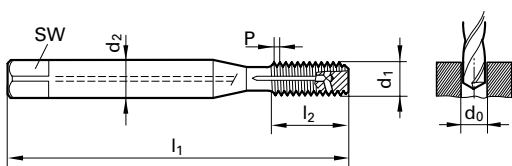
#### Catalog no. 63013

For through and blind holes of up to 1 x d. suitable for materials with good cold deformation and at least 10% extension characteristics such as unalloyed steels up to 1000 N/mm<sup>2</sup>, stainless-, noncorrosive and heat-resistant steels, al-alloys long chipping, zinc-alloys, zinc die-casting. Greatly increased wear resistance thanks to AlTiN coating.



~ DIN 371    DIN 2174

Tool material	Solid Carbide
Surface	AlTiN
Type	Durativ
Form	C
Cutting direction	right-hand
Tolerance on Ø	6HX
Flutes	with oil grooves



Catalog no.	63013
Tool material	Solid Carbide
Discount group	103
Cutting direction	right-hand
Surface	AlTiN

d1	P	d2	SW	d0	l1	l2	price per piece
mm	mm	mm	mm	mm	mm	mm	
M 3	0.50	3.500	2.70	2.800	56.00	6.00	●
M 4	0.70	4.500	3.40	3.700	63.00	7.50	●
M 5	0.80	6.000	4.90	4.650	70.00	8.50	●
M 6	1.00	6.000	4.90	5.550	80.00	11.00	●
M 8	1.25	8.000	6.20	7.400	90.00	14.00	●
M10	1.50	10.000	8.00	9.250	100.00	16.00	●

## Fluteless taps without oil grooves

### Fluteless machine taps for ISO metric threads

#### Catalog no. 73121



For through and blind holes of up to 1 x d. suitable for materials with good cold deformation and at least 10% extension characteristics such as unalloyed steels up to 900 n/mm<sup>2</sup>, stainless-, noncorrosive and heat-resistant steels, al-alloys long chipping, zinc-alloys, zinc die-casting.

DIN 371	DIN 2174
Tool material	HSS-E
Surface	bright
Type	Durativ
Form	C
Cutting direction	right-hand
Tolerance on Ø	6HX
Flutes	without oil grooves

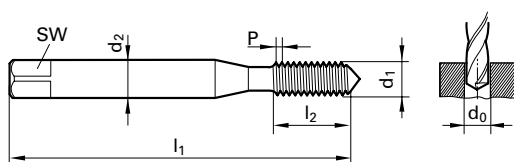
### Fluteless machine taps for ISO metric threads

#### Catalog no. 63121



For through and blind holes of up to 1 x d. suitable for materials with good cold deformation and at least 10% extension characteristics such as unalloyed steels up to 900 n/mm<sup>2</sup>, stainless-, noncorrosive and heat-resistant steels, al-alloys long chipping, zinc-alloys, zinc die-casting. High wear resistance thanks to TiN coating.

DIN 371	DIN 2174
Tool material	HSS-E
Surface	TiN
Type	Durativ
Form	C
Cutting direction	right-hand
Tolerance on Ø	6HX
Flutes	without oil grooves



Catalog no.	73121	63121
Tool material	HSS-E	
Discount group	103	103
Cutting direction	right-hand	right-hand
Surface	bright	TiN

d1	P	d2	SW	d0	l1	l2	price per piece	
mm	mm	mm	mm	mm	mm	mm		
M 2	0.40	2.800	2.10	1.800	45.00	8.00	●	●
M 2,2	0.45	2.800	2.10	2.000	45.00	9.00	○	
M 2,3	0.40	2.800	2.10	2.100	45.00	9.00	○	
M 2,5	0.45	2.800	2.10	2.300	50.00	9.00	○	
M 3	0.50	3.500	2.70	2.800	56.00	10.00	●	●
M 3,5	0.60	4.000	3.00	3.250	56.00	12.00	○	
M 4	0.70	4.500	3.40	3.700	63.00	12.00	●	●
M 5	0.80	6.000	4.90	4.650	70.00	14.00	●	●
M 6	1.00	6.000	4.90	5.550	80.00	16.00	●	●
M 8	1.25	8.000	6.20	7.400	90.00	18.00	●	●
M10	1.50	10.000	8.00	9.250	100.00	20.00	●	●

## Fluteless taps without oil grooves

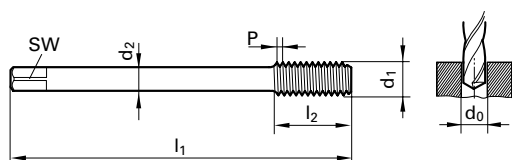
### Fluteless machine taps for ISO metric threads

#### Catalog no. 63123



For through and blind holes of up to 1 x d. suitable for materials with good cold deformation and at least 10% extension characteristics such as unalloyed steels up to 900 N/mm<sup>2</sup>, stainless-, noncorrosive and heat-resistant steels, Al-alloys long chipping, zinc-alloys, zinc die-casting. High wear resistance thanks to TiN coating.

~ DIN 376	DIN 2174
Tool material	HSS-E
Surface	TiN
Type	Durativ
Form	C
Cutting direction	right-hand
Tolerance on Ø	6HX
Flutes	without oil grooves



Catalog no.	63123
Tool material	HSS-E
Discount group	103
Cutting direction	right-hand
Surface	TiN

d1	P	d2	SW	d0	l1	l2	price per piece
mm	mm	mm	mm	mm	mm	mm	
M12	1.75	9.000	7.00	11.250	110.00	24.00	●
M16	2.00	12.000	9.00	15.100	110.00	26.00	●
M20	2.50	16.000	12.00	18.900	140.00	32.00	●