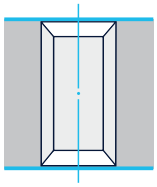
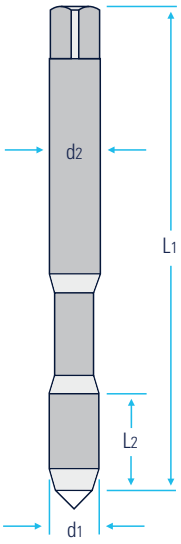
M - ISO Metric Coarse Thread DIN 13

Carbide
Machine Taps

DIN 371/376 Solid Carbide
straight flutes
for hard materials

Group G01
for through holes





VHM tec
CARBIDE by Schumacher

Art.-No.		G01/41
Technology	Page 7.1	VHM tec radial internal coolant
Chamfer Length	Page 7.4	D / 3,5-5 x P
Surface	Page 7.5	bright
Tolerance	Page 7.6	ISO2X (6HX)
Material Groups	Page 7.7	3a. grey cast iron 6. copper alloys 9. hard materials

Ød1	Pmm	L1	L2	d2	□	ø	
M 3	0,5	56	10	6	2,7	2,5	
M 3,5	0,6	56	11	6	3	2,9	
M 4	0,7	63	12	6	3,4	3,3	
M 5	0,8	70	14	6	4,9	4,2	
M 6	1	80	16	6	6	5,0	●
M 7	1	80	16	7	6	6,0	
M 8	1,25	90	18	8	6	6,8	●
M 9	1,25	90	18	9	7	7,8	
M 10	1,5	100	20	10	8	8,5	●
M 12	1,75	110	22	12	9	10,2	●
M 16	2	110	28	12	9	14,0	●

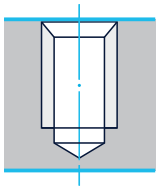
○ available – intermediate size on request

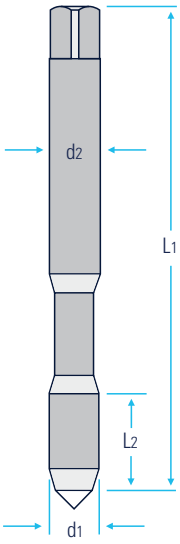
M - ISO Metric Coarse Thread DIN 13

Carbide
Machine Taps

DIN 371/376 Solid Carbide
straight flutes
for hard materials

Group G08
for blind holes





VHM tec
CARBIDE by Schumacher

Art.-No.			G08	G08/40		
Technology	Page 7.1		VHM tec CARBIDE by Schumacher	VHM tec internal coolant		
Chamfer Length	Page 7.4		C / 2-3 x P	C / 2-3 x P		
Surface	Page 7.5		bright	bright		
Tolerance	Page 7.6		ISO2X (6HX)	ISO2X (6HX)		
Material Groups	Page 7.7		3a. grey cast iron 6. copper alloys 9. hard materials			

ød1	P mm	L1	L2	d2	□				
M 3	0,5	56	10	6	2,7	2,5	●		
M 3,5	0,6	56	11	6	3	2,9			
M 4	0,7	63	12	6	3,4	3,3	●		
M 5	0,8	70	14	6	4,9	4,2	●		
M 6	1	80	16	6	6	5,0		●	
M 7	1	80	16	7	6	6,0			
M 8	1,25	90	18	8	6	6,8		●	
M 9	1,25	90	18	9	7	7,8			
M 10	1,5	100	20	10	8	8,5		●	
M 12	1,75	110	22	12	9	10,2		●	
M 16	2	110	28	12	9	14,0		●	

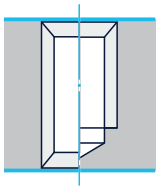
○ available – intermediate size on request

M - ISO Metric Coarse Thread DIN 13

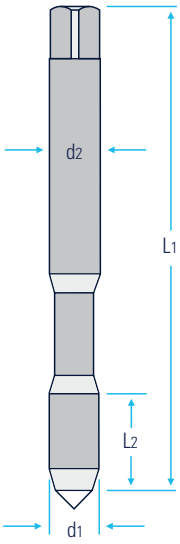
Carbide
Machine Taps

DIN 371/376 Solid Carbide
RH spiral flutes 20°
for universal use

Group G26
for blind and through holes



2xd1



VHM tec
CARBIDE by Schumacher

Art.-No.							G26/40			
Technology	Page 7.1						VHM tec internal coolant			
Chamfer Length	Page 7.4						C / 2-3 x P			
Surface	Page 7.5						bright			
Tolerance	Page 7.6						ISO2X (6HX)			
Material Groups	Page 7.7						universal			
Ød1	Pmm	L1	L2	d2	□	ø				
M 3	0,5	56	10	6	2,7	2,5				
M 3,5	0,6	56	11	6	3	2,9				
M 4	0,7	63	12	6	3,4	3,3				
M 5	0,8	70	14	6	4,9	4,2				
M 6	1	80	16	6	6	5,0	●			
M 7	1	80	16	7	6	6,0				
M 8	1,25	90	18	8	6	6,8	●			
M 9	1,25	90	18	9	7	7,8				
M 10	1,5	100	20	10	8	8,5	●			
M 12	1,75	110	22	12	9	10,2	●			
M 16	2	110	28	12	9	14,0	●			

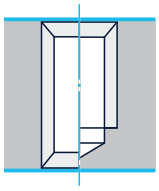
○ available – intermediate size on request

M - ISO Metric Coarse Thread DIN 13

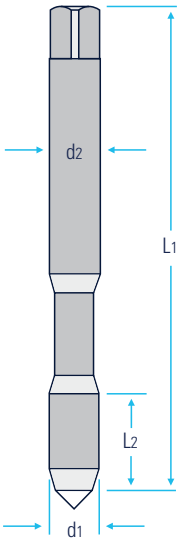
Carbide
Forming Taps

DIN 371/376 Solid Carbide
straight oil grooves
for high strength steel

Group G06/G07
for blind and through holes



2xd1



VHM tec
CARBIDE by Schumacher

Art.-No.							G06/5360	G07/5360		
Technology	Page 7.1						VHM tec CARBIDE by Schumacher	VHM tec internal coolant		
Chamfer Length	Page 7.4						C / 2-3 x P	C / 2-3 x P		
Surface	Page 7.5						SG4	SG4		
Tolerance	Page 7.6						ISO2X (6HX)	ISO2X (6HX)		
Material Groups	Page 7.7						1a. general construction steel 1b. high strength steel 7. aluminium alloys			
Ød1	Pmm	L1	L2	d2	□					
M 3	0,5	56	10	6	2,7	2,75	●			
M 3,5	0,6	56	11	6	3	3,2				
M 4	0,7	63	12	6	3,4	3,65	●			
M 5	0,8	70	14	6	4,9	4,6	●			
M 6	1	80	16	6	6	5,55		●		
M 7	1	80	16	7	6	6,55				
M 8	1,25	90	18	8	6	7,4		●		
M 9	1,25	90	18	9	7	8,4				
M 10	1,5	100	20	10	8	9,3		●		
M 12	1,75	110	22	12	9	11,1		●		
M 16	2	110	28	12	9	15,1				

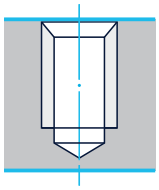
○ available – intermediate size on request

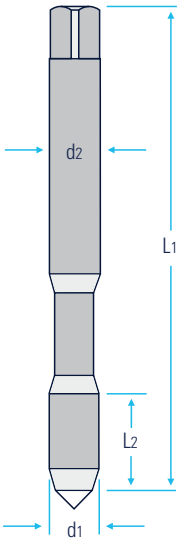
MF - ISO Metric Fine Thread DIN 13

Carbide
Machine Taps

DIN 374 Solid Carbide
straight flutes
for hard materials

Group G58
for blind holes





VHM tec
CARBIDE by Schumacher

Art.-No.							G58/40			
Technology	Page 7.1						VHM tec internal coolant			
Chamfer Length	Page 7.4						C / 2-3 x P			
Surface	Page 7.5						bright			
Tolerance	Page 7.6						ISO2X (6HX)			
Material Groups	Page 7.7						3a. grey cast iron 6. copper alloys 9. hard materials			
Ød1	Pmm	L1	L2	d2	□					
M 8	1	90	16	6	4,9	7,0	●			
M 10	1	90	16	7	5,5	9,0	●			
M 12	1,5	100	22	9	7	10,5	●			

○ available – intermediate size on request