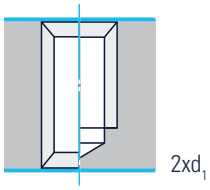
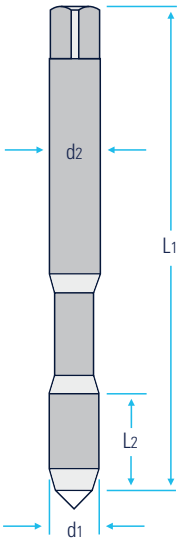
M - ISO Metric Coarse Thread DIN 13

Forming Taps
Black Ring - TORNADO

DIN 371 HSS-E PM
straight oil grooves
for steel, heat treatable steel
and chemical resistant steel

Group 305
for blind and through holes





Art.-No.							305/4853			
Technology	Page 7.1						PM-Line by Schumacher Black Ring			
Chamfer Length	Page 7.4						C / 2-3 x P			
Surface	Page 7.5						TiCN			
Tolerance	Page 7.6						ISO2X (6HX)			
Material Groups	Page 7.7						1a. general construction steel	1b. high strength steel	2. chemical resistant steel	
Ød1	Pmm	L1	L2	d2	□					
M 1	0,25	40	5	2,5	2,1	0,9				
M 1,2	0,25	40	5	2,5	2,1	1,1				
M 1,4	0,3	40	7	2,5	2,1	1,25				
M 1,6	0,35	40	8	2,5	2,1	1,45				
M 1,7	0,35	40	8	2,5	2,1	1,55				
M 1,8	0,35	40	8	2,5	2,1	1,65				
M 2	0,4	45	8	2,8	2,1	1,8				
M 2,2	0,45	45	9	2,8	2,1	2,0				
M 2,3	0,4	45	9	2,8	2,1	2,1				
M 2,5	0,45	50	9	2,8	2,1	2,3				
M 2,6	0,45	50	9	2,8	2,1	2,4				
M 3	0,5	56	10	3,5	2,7	2,75	●			
M 3,5	0,6	56	11	4	3	3,2				
M 4	0,7	63	12	4,5	3,4	3,65	●			
M 5	0,8	70	14	6	4,9	4,6	●			
M 6	1	80	16	6	4,9	5,55	●			
M 7	1	80	16	7	4,9	6,55				
M 8	1,25	90	18	8	6,2	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				

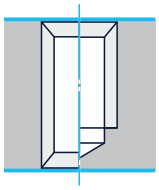
○ available – intermediate size on request

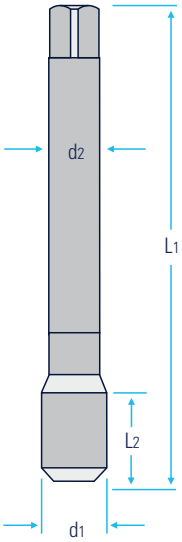
M - ISO Metric Coarse Thread DIN 13

Forming Taps
Black Ring - TORNADO

DIN 376 HSS-E PM
straight oil grooves
for steel, heat treatable steel
and chemical resistant steel

Group 405
for blind and through holes





Art.-No.							405/4853			
Technology	Page 7.1						PM-Line by Schumacher Black Ring			
Chamfer Length	Page 7.4						C / 2-3 x P			
Surface	Page 7.5						TiCN			
Tolerance	Page 7.6						ISO2X (6HX)			
Material Groups	Page 7.7						1a. general construction steel	1b. high strength steel	2. chemical resistant steel	

Ød1	Pmm	L1	L2	d2	□					
M 6	1	80	16	4,5	3,4	5,55				
M 7	1	80	16	5,5	4,3	6,55				
M 8	1,25	90	18	6	4,9	7,4				
M 9	1,25	100	20	7	5,5	8,4				
M 10	1,5	100	20	7	5,5	9,3				
M 12	1,75	110	22	9	7	11,1	●			
M 14	2	110	25	11	9	13,1				
M 16	2	110	28	12	9	15,1	●			
M 18	2,5	125	32	14	11	16,9				
M 20	2,5	140	32	16	12	18,9				
M 22	2,5	140	32	18	14,5	20,9				
M 24	3	160	36	18	14,5	22,65				
M 27	3	160	36	20	16	25,65				

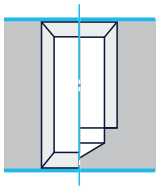
○ available – intermediate size on request

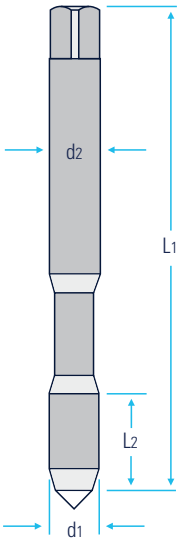
M - ISO Metric Coarse Thread DIN 13

Forming Taps

DIN 371 HSS-E
straight oil grooves
for steel, non-ferrous steel
and heat treatable steel

Group 306
for blind and through holes





Art.-No.			306/53	306/2553	306 B/2553
Technology	Page 7.1		High Volume by Schumacher	High Volume by Schumacher	
Chamfer Length	Page 7.4		C / 2-3 x P		
Surface	Page 7.5		bright	TiN	TiN
Tolerance	Page 7.6		ISO2X (6HX)	ISO2X (6HX)	ISO3X (6GX)
Material Groups	Page 7.7		1a. general construction steel 1b. high strength steel 6. copper alloys		

Ød1	Pmm	L1	L2	d2	□				
M 1	0,25	40	5	2,5	2,1	0,9			
M 1,2	0,25	40	5	2,5	2,1	1,1			
M 1,4	0,3	40	7	2,5	2,1	1,25			
M 1,6	0,35	40	8	2,5	2,1	1,45			
M 1,7	0,35	40	8	2,5	2,1	1,55			
M 1,8	0,35	40	8	2,5	2,1	1,65			
M 2	0,4	45	8	2,8	2,1	1,8	●	●	
M 2,2	0,45	45	9	2,8	2,1	2,0			
M 2,3	0,4	45	9	2,8	2,1	2,1			
M 2,5	0,45	50	9	2,8	2,1	2,3	●	●	
M 2,6	0,45	50	9	2,8	2,1	2,4			
M 3	0,5	56	10	3,5	2,7	2,75	●	●	●
M 3,5	0,6	56	11	4	3	3,2			
M 4	0,7	63	12	4,5	3,4	3,65	●	●	●
M 5	0,8	70	14	6	4,9	4,6	●	●	●
M 6	1	80	16	6	4,9	5,55	●	●	●
M 7	1	80	16	7	4,9	6,55			
M 8	1,25	90	18	8	6,2	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			

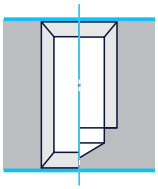
○ available – intermediate size on request

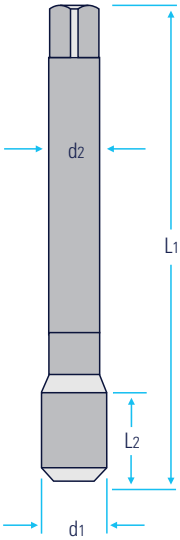
M - ISO Metric Coarse Thread DIN 13

Forming Taps

DIN 376 HSS-E
straight oil grooves
for steel, non-ferrous steel
and heat treatable steel

Group 406
for blind and through holes





Art.-No.							406/53	406/2553		
Technology	Page 7.1									
Chamfer Length	Page 7.4						C / 2-3 x P			
Surface	Page 7.5						bright	TiN		
Tolerance	Page 7.6						ISO2X (6HX)	ISO2X (6HX)		
Material Groups	Page 7.7						1a. general construction steel	1b. high strength steel	6. copper alloys	
Ød1	Pmm	L1	L2	d2	□					
M 6	1	80	16	4,5	3,4	5,55				
M 7	1	80	16	5,5	4,3	6,55				
M 8	1,25	90	18	6	4,9	7,4				
M 9	1,25	100	20	7	5,5	8,4				
M 10	1,5	100	20	7	5,5	9,3				
M 12	1,75	110	22	9	7	11,1	●	●		
M 14	2	110	25	11	9	13,1				
M 16	2	110	28	12	9	15,1	●	●		
M 18	2,5	125	32	14	11	16,9				
M 20	2,5	140	32	16	12	18,9				
M 22	2,5	140	32	18	14,5	20,9				
M 24	3	160	36	18	14,5	22,65				
M 27	3	160	36	20	16	25,65				

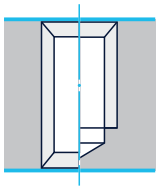
○ available – intermediate size on request

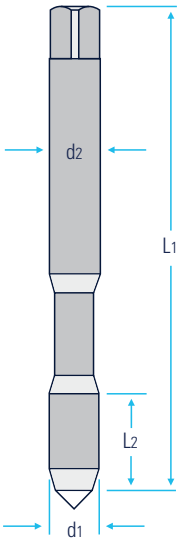
UNC - Unified Coarse Thread ANSI B1.1

Forming Taps

DIN 371 HSS-E
straight oil grooves
for steel, non-ferrous steel
and heat treatable steel

Group 356
for blind and through holes





Art.-No.							356/53	356/2553	
Technology	Page 7.1						High Volume by Schumacher	High Volume by Schumacher	
Chamfer Length	Page 7.4						C / 2-3 x P		
Surface	Page 7.5						bright	TiN	
Tolerance	Page 7.6						2 BX	2 BX	
Material Groups	Page 7.7						1a. general construction steel	1b. high strength steel	6. copper alloys
Ød1	P tpi	L1	L2	d2	□				
Nr. 4	40	56	10	3,5	2,7	2,55	●	●	
Nr. 5	40	56	10	3,5	2,7	2,9	●	●	
Nr. 6	32	56	10	4	3	3,15	●	●	
Nr. 8	32	63	12	4,5	3,4	3,8	●	●	
Nr. 10	24	70	14	6	4,9	4,35	●	●	
Nr. 12	24	80	16	6	4,9	4,95			
1/4"	20	80	16	7	5,5	5,8	●	●	
5/16"	18	90	18	8	6,2	7,3	●	●	
3/8"	16	100	20	10	8	8,8	●	●	

○ available – intermediate size on request