

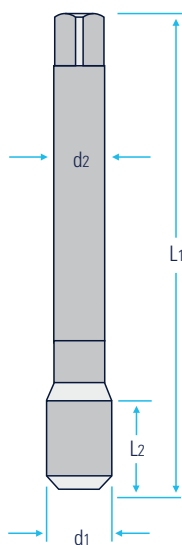
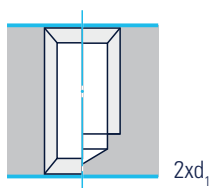


M - ISO Metric Coarse Thread DIN 13

Set of Taps

DIN 352 HSS
set of 3 pieces
straight flutes
for general construction steel

Group 100
for blind and through holes



Art.-No.	Technology	101	102	103						
	Page 7.1	High Volume <small>by Schumacher</small>	High Volume <small>by Schumacher</small>	High Volume <small>by Schumacher</small>						
Chamfer Length	Page 7.4	C / 2-3 x P								
Surface	Page 7.5	bright	bright	bright						
Tolerance	Page 7.6	No. 1	No. 2	No. 3 = ISO2 (6H)						
Material Groups	Page 7.7	1a. general construction steel		3b. spheroidal and malleable cast iron						
$\varnothing d_1$	P _{mm}	L ₁	L ₂	d ₂	\square					
M 2	0,4	36	8	2,8	2,1	1,6	●	●	●	
M 2,2	0,45	36	9	2,8	2,1	1,75	●	●	●	
M 2,3	0,4	36	9	2,8	2,1	1,9	●	●	●	
M 2,5	0,45	40	9	2,8	2,1	2,05	●	●	●	
M 2,6	0,45	40	9	2,8	2,1	2,15	●	●	●	
M 3	0,5	40	9	3,5	2,7	2,5	●	●	●	
M 4	0,7	45	13	4,5	3,4	3,3	●	●	●	
M 5	0,8	50	14	6	4,9	4,2	●	●	●	
M 6	1	50	16	6	4,9	5,0	●	●	●	
M 7	1	50	16	6	4,9	6,0	●	●	●	
M 8	1,25	56	18	6	4,9	6,8	●	●	●	
M 9	1,25	70	20	7	5,5	7,8	●	●	●	
M 10	1,5	70	20	7	5,5	8,5	●	●	●	
M 12	1,75	75	22	9	7	10,2	●	●	●	
M 14	2	80	25	11	9	12,0	●	●	●	
M 16	2	80	28	12	9	14,0	●	●	●	
M 18	2,5	95	32	14	11	15,5	●	●	●	
M 20	2,5	95	32	16	12	17,5	●	●	●	

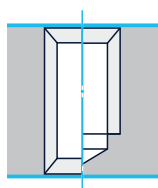


M - ISO Metric Coarse Thread DIN 13

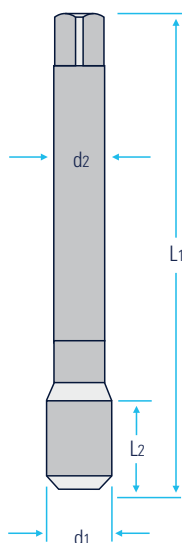
Set of Taps

DIN 352 HSS
set of 3 pieces
straight flutes
for general construction steel

Group 100 LH
for blind and through holes



2x d₁



Art.-No.		101/50	102/50	103/50	
Technology	Page 7.1	LH	LH	LH	
Chamfer Length	Page 7.4	C / 2-3 x P			
Surface	Page 7.5	bright	bright	bright	
Tolerance	Page 7.6	No. 1	No. 2	No. 3 = ISO2 (6H)	
Material Groups	Page 7.7	1a. general construction steel		3b. spheroidal and malleable cast iron	

Ød ₁	P _{mm}	L ₁	L ₂	d ₂	\square				
M 2	0,4	36	8	2,8	2,1	1,6	●	●	●
M 2,2	0,45	36	9	2,8	2,1	1,75			
M 2,3	0,4	36	9	2,8	2,1	1,9			
M 2,5	0,45	40	9	2,8	2,1	2,05	●	●	●
M 2,6	0,45	40	9	2,8	2,1	2,15			
M 3	0,5	40	9	3,5	2,7	2,5	●	●	●
M 4	0,7	45	13	4,5	3,4	3,3	●	●	●
M 5	0,8	50	14	6	4,9	4,2	●	●	●
M 6	1	50	16	6	4,9	5,0	●	●	●
M 7	1	50	16	6	4,9	6,0			
M 8	1,25	56	18	6	4,9	6,8	●	●	●
M 9	1,25	70	20	7	5,5	7,8			
M 10	1,5	70	20	7	5,5	8,5	●	●	●
M 12	1,75	75	22	9	7	10,2	●	●	●
M 14	2	80	25	11	9	12,0	●	●	●
M 16	2	80	28	12	9	14,0	●	●	●
M 18	2,5	95	32	14	11	15,5	●	●	●
M 20	2,5	95	32	16	12	17,5	●	●	●

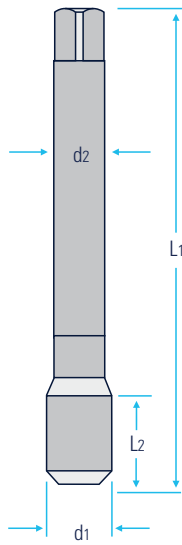
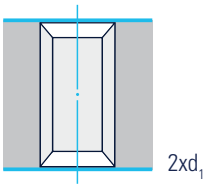


M - ISO Metric Coarse Thread DIN 13

Set of Taps

DIN 352 HSS
set of 3 pieces
straight flutes
for high strength steel

Group 200
for through holes



Art.-No.		201	202	203	
Technology	i Page 7.1				
Chamfer Length	i Page 7.4	C / 2-3 x P			
Surface	i Page 7.5	bright	bright	bright	
Tolerance	i Page 7.6	No. 1	No. 2	No. 3 = ISO2 (6H)	
Material Groups	i Page 7.7	1b. high strength steel			

Ød1	P _{mm}	L1	L2	d2	□	🌀			
M 2	0,4	36	8	2,8	2,1	1,6			
M 2,2	0,45	36	9	2,8	2,1	1,75			
M 2,3	0,4	36	9	2,8	2,1	1,9			
M 2,5	0,45	40	9	2,8	2,1	2,05			
M 2,6	0,45	40	9	2,8	2,1	2,15			
M 3	0,5	40	9	3,5	2,7	2,5	●	●	●
M 4	0,7	45	13	4,5	3,4	3,3	●	●	●
M 5	0,8	50	14	6	4,9	4,2	●	●	●
M 6	1	50	16	6	4,9	5,0	●	●	●
M 7	1	50	16	6	4,9	6,0			
M 8	1,25	56	18	6	4,9	6,8	●	●	●
M 9	1,25	70	20	7	5,5	7,8			
M 10	1,5	70	20	7	5,5	8,5	●	●	●
M 12	1,75	75	22	9	7	10,2	●	●	●
M 14	2	80	25	11	9	12,0			
M 16	2	80	28	12	9	14,0	●	●	●
M 18	2,5	95	32	14	11	15,5			
M 20	2,5	95	32	16	12	17,5	●	●	●

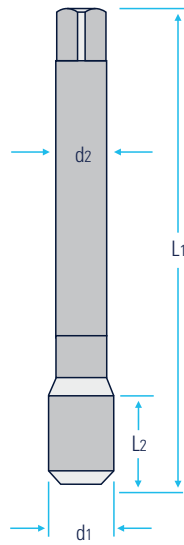
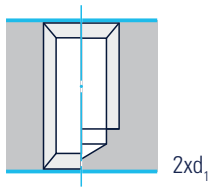


MF - ISO Metric Fine Thread DIN 13

Set of Taps

DIN 2181 HSS-E
set of 2 pieces
straight flutes
for general construction steel

Group 120
for blind and through holes



Art.-No.		121	122		
Technology	Page 7.1				
Chamfer Length	Page 7.4	C / 2-3 x P			
Surface	Page 7.5	bright	bright		
Tolerance	Page 7.6	No. 1	No. 2 = ISO2 (6H)		
Material Groups	Page 7.7	1a. general construction steel		3b. spheroidal and malleable cast iron	

Ød ₁	P _{mm}	L ₁	L ₂	d ₂	□	⊖			
M 6	0,5	50	10	6	4,9	5,5	●	●	
M 6	0,75	50	12	6	4,9	5,3	●	●	
M 8	0,75	50	14	6	4,9	7,3	●	●	
M 10	0,75	63	16	7	5,5	9,3	●	●	
M 8	1	56	16	6	4,9	7,0	●	●	
M 10	1	63	16	7	5,5	9,0	●	●	
M 12	1	70	16	9	7	11,0	●	●	
M 14	1	70	20	11	9	13,0	●	●	
M 16	1	70	22	12	9	15,0	●	●	
M 18	1	80	22	14	11	17,0	●	●	
M 20	1	80	22	16	12	19,0	●	●	
M 10	1,25	70	16	7	5,5	8,8	●	●	
M 12	1,25	70	18	9	7	10,8	●	●	
M 14	1,25	70	22	11	9	12,8	●	●	
M 12	1,5	70	22	9	7	10,5	●	●	
M 14	1,5	70	22	11	9	12,5	●	●	
M 16	1,5	70	22	12	9	14,5	●	●	
M 18	1,5	80	22	14	11	16,5	●	●	
M 20	1,5	80	22	16	12	18,5	●	●	
M 22	1,5	80	22	18	14,5	20,5	●	●	
M 24	1,5	90	22	18	14,5	22,5	●	●	
M 25	1,5	90	22	18	14,5	23,5	●	●	
M 26	1,5	90	22	18	14,5	24,5	●	●	

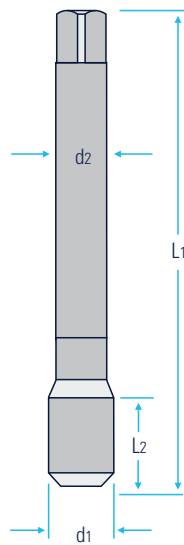
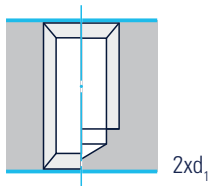


MF - ISO Metric Fine Thread DIN 13

Set of Taps

DIN 2181 HSS-E
set of 2 pieces
straight flutes
for general construction steel

Group 120
for blind and through holes



Art.-No.		121	122	
Technology	Page 7.1			
Chamfer Length	Page 7.4	C / 2-3 x P		
Surface	Page 7.5	bright	bright	
Tolerance	Page 7.6	No. 1	No. 2 = ISO2 (6H)	
Material Groups	Page 7.7	1a. general construction steel 3b. spheroidal and malleable cast iron		

Ød ₁	P _{mm}	L ₁	L ₂	d ₂	□	🌀			
M 27	1,5	90	22	20	16	25,5	●	●	
M 28	1,5	90	22	20	16	26,5	●	●	
M 30	1,5	90	22	22	18	28,5	●	●	
M 32	1,5	90	22	22	18	30,5	●	●	
M 33	1,5	100	25	25	20	31,5	●	●	
M 34	1,5	100	25	28	22	32,5	●	●	
M 35	1,5	100	25	28	22	33,5	●	●	
M 36	1,5	100	25	28	22	34,5	●	●	
M 18	2	80	22	14	11	16,0	●	●	
M 20	2	80	22	16	12	18,0	●	●	
M 22	2	80	22	18	14,5	20,0	●	●	
M 24	2	90	22	18	14,5	22,0	●	●	
M 27	2	90	22	20	16	25,0	●	●	
M 30	2	90	22	22	18	28,0	●	●	
M 36	3	125	36	28	22	33,0	●	●	
M 39	3	125	36	32	24	36,0	●	●	
M 42	3	125	40	32	24	39,0	●	●	
M 45	3	125	40	36	29	42,0	●	●	
M 48	3	140	40	36	29	45,0	●	●	

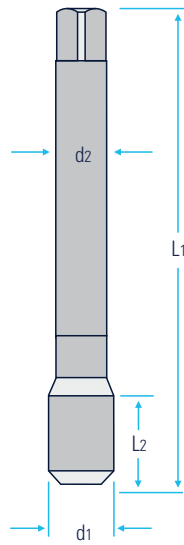
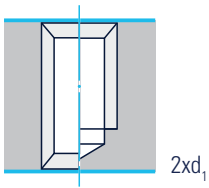


G - Whitworth Pipe Thread DIN ISO 228

Set of Taps

DIN 5157 HSS-E
set of 2 pieces
straight flutes
for general construction steel

Group 130
for blind and through holes



Art.-No.		131	132		
Technology	Page 7.1				
Chamfer Length	Page 7.4	C / 2-3 x P			
Surface	Page 7.5				
Tolerance	Page 7.6	Nr. 1	Nr. 2		
Material Groups	Page 7.7	1a. general construction steel		3b. spheroidal and malleable cast iron	

$\varnothing d_1$	P tpi	L ₁	L ₂	d ₂	\square	H_2S			
G 1/8"	28	63	18	7	5,5	8,7	●	●	
G 1/4"	19	70	20	11	9	11,8	●	●	
G 3/8"	19	70	22	12	9	15,3	●	●	
G 1/2"	14	80	22	16	12	19,0	●	●	
G 5/8"	14	80	22	18	14,5	21,0	●	●	
G 3/4"	14	90	22	20	16	24,5	●	●	
G 7/8"	14	90	22	22	18	28,3	●	●	
G 1"	11	100	25	25	20	30,8	●	●	
G 1 1/8"	11	125	30	28	22	35,5	●	●	
G 1 1/4"	11	125	30	32	24	39,5	●	●	
G 1 3/8"	11	125	30	36	29	41,7	●	●	
G 1 1/2"	11	140	30	36	29	45,3	●	●	
G 1 3/4"	11	140	36	40	32	51,0	●	●	
G 2"	11	160	36	45	35	57,0	●	●	

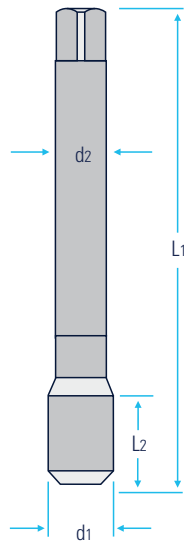
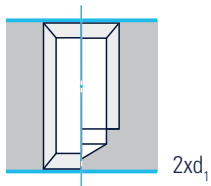


UNC - Unified Coarse Thread ANSI B1.1

Set of Taps

DIN 351 HSS-E
set of 3 pieces
straight flutes
for general construction steel

Group 150
for blind and through holes



Art.-No.		151	152	153	
Technology	Page 7.1				
Chamfer Length	Page 7.4	C / 2-3 x P			
Surface	Page 7.5	bright	bright	bright	
Tolerance	Page 7.6	No. 1	No. 2	No. 3 = 2 B	
Material Groups	Page 7.7	1a. general construction steel		3b. spheroidal and malleable cast iron	

Ød ₁	P t _{pi}	L ₁	L ₂	d ₂	□	♁			
Nr. 4	40	40	12	3,5	2,7	2,3	●	●	●
Nr. 5	40	40	12	3,5	2,7	2,6	●	●	●
Nr. 6	32	45	14	4	3	2,8	●	●	●
Nr. 8	32	45	14	4,5	3,4	3,5	●	●	●
Nr. 10	24	50	16	6	4,9	3,9	●	●	●
Nr. 12	24	50	16	6	4,9	4,5	●	●	●
1/4"	20	50	18	6	4,9	5,2	●	●	●
5/16"	18	56	18	6	4,9	6,6	●	●	●
3/8"	16	70	23	7	5,5	8,0	●	●	●
7/16"	14	70	25	8	6,2	9,4	●	●	●
1/2"	13	75	28	9	7	10,8	●	●	●
9/16"	12	80	30	11	9	12,2	●	●	●
5/8"	11	80	30	12	9	13,6	●	●	●
3/4"	10	95	35	14	11	16,5	●	●	●
7/8"	9	110	38	18	14,5	19,5	●	●	●
1"	8	110	38	20	16	22,3	●	●	●

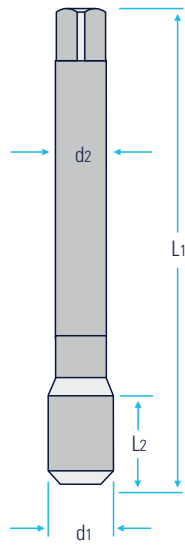
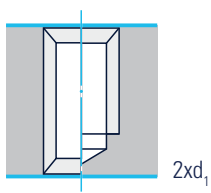


UNF - Unified Fine Thread ANSI B1.1

Set of Taps

DIN 2181 HSS-E
set of 2 pieces
straight flutes
for general construction steel

Group 160
for blind and through holes



Art.-No.		161	162		
Technology	Page 7.1				
Chamfer Length	Page 7.4	C / 2-3 x P			
Surface	Page 7.5	bright	bright		
Tolerance	Page 7.6	No. 1	No. 2 = 2 B		
Material Groups	Page 7.7	1a. general construction steel		3b. spheroidal and malleable cast iron	

Ød ₁	P _{t_{pi}}	L ₁	L ₂	d ₂	□	⌀				
Nr. 8	36	45	10	4,5	3,4	3,5	●	●		
Nr. 10	32	50	12	6	4,9	4,1	●	●		
Nr. 12	28	50	12	6	4,9	4,7	●	●		
1/4"	28	50	18	6	4,9	5,5	●	●		
3/8"	24	63	18	7	5,5	8,5	●	●		
7/16"	20	63	18	8	6,2	9,9	●	●		
1/2"	20	70	20	9	7	11,5	●	●		
3/4"	16	80	22	14	11	17,5	●	●		
1"	12	90	22	20	16	23,3	●	●		

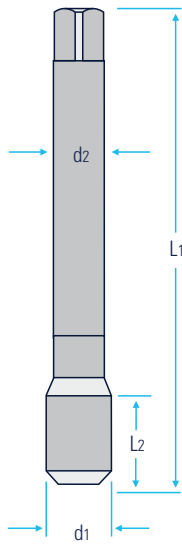
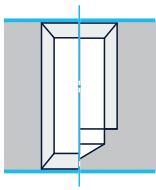


NPT - American Tapered Pipe Thread ANSI B 1.20.1

Set of Taps

DIN 2181 HSS-E
set of 2 pieces
straight flutes
for general construction steel

Group 170
for blind and through holes



Art.-No.		171	172		
Technology	Page 7.1				
Chamfer Length	Page 7.4		C / 2-3 x P		
Surface	Page 7.5	bright	bright		
Tolerance	Page 7.6	No. 1	No. 2		
Material Groups	Page 7.7	1a. general construction steel			3b. spheroidal and malleable cast iron

$\varnothing d_1$	P _{tpi}	L ₁	L ₂	d ₂	□					
1/8"	27	63	12	7	5,5	8,4	●		●	
1/4"	18	70	20	11	9	11,1	●		●	
3/8"	18	80	22	12	9	14,3	●		●	
1/2"	14	80	22	16	12	17,9	●		●	
3/4"	14	90	22	20	16	23,0	●		●	
1"	11,5	125	30	25	20	29,0	●		●	

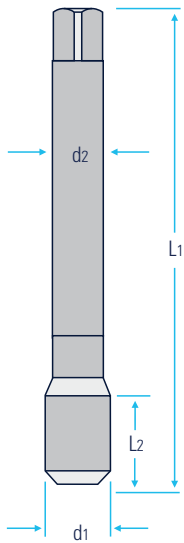
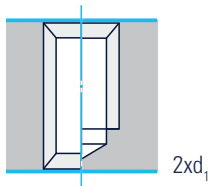


PG - Steel Conduit Thread DIN 40430

Set of Taps

internal standard HSS-E
set of 2 pieces
straight flutes
for general construction steel

Group 180
for blind and through holes



Art.-No.		181	182		
Technology	Page 7.1				
Chamfer Length	Page 7.4			C / 2-3 x P	
Surface	Page 7.5	bright	bright		
Tolerance	Page 7.6	No. 1	No. 2		
Material Groups	Page 7.7	1a. general construction steel		3b. spheroidal and malleable cast iron	

Ød ₁	P _{t_{pi}}	L ₁	L ₂	d ₂	□	▨			
Pg 7	20	70	20	9	7	11,4	●	●	
Pg 9	18	70	20	12	9	14,0	●	●	
Pg 11	18	80	22	14	11	17,4	●	●	
Pg 13,5	18	80	22	16	12	19,2	●	●	
Pg 16	18	80	22	18	14,5	21,3	●	●	
Pg 21	16	90	22	22	18	27,0	●	●	
Pg 29	16	100	25	28	22	35,6	●	●	
Pg 36	16	140	25	36	29	45,6	●	●	

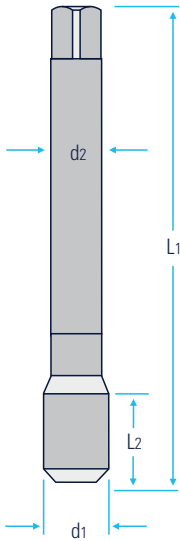
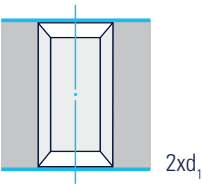


TR - ISO Metric Trapezoidal Thread DIN 103 1977

Set of Taps

internal standard HSS-E
set of 3 pieces
LH spiral flutes 6°
for general construction steel

Group 680
for through holes



Art.-No.		681	682	683
Technology	Page 7.1			
Chamfer Length	Page 7.4			
Surface	Page 7.5	bright	bright	bright
Tolerance	Page 7.6	No. 1	No. 2	No. 3 = 7H
Material Groups	Page 7.7	1a. general construction steel		3b. spheroidal and malleable cast iron

Ød ₁	P _{mm}	L ₁	L ₂	d ₂	□	ℓ			
Tr 10	2	90	35	7	5,5	8,1	●	●	●
Tr 12	3	110	45	8	6,2	9,2	●	●	●
Tr 14	3	130	45	10	8	11,2	●	●	●
Tr 16	4	140	55	11	9	12,3	●	●	●
Tr 18	4	150	55	12	9	14,3	●	●	●
Tr 20	4	160	55	15	12	16,3	●	●	●
Tr 22	5	180	70	16	12	17,3	●	●	●
Tr 24	5	190	70	18	14,5	19,3	●	●	●
Tr 26	5	210	70	20	16	21,3	●	●	●
Tr 28	5	220	70	22	18	23,3	●	●	●
Tr 30	6	240	85	22	18	24,3	●	●	●
Tr 32	6	255	85	25	20	26,3	●	●	●
Tr 36	6	280	85	28	22	30,3	●	●	●
Tr 40	7	310	90	32	24	33,3	●	●	●

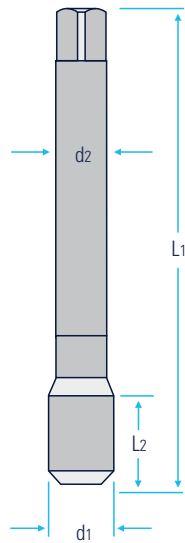
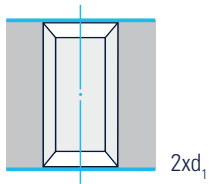


TR - ISO Metric Trapezoidal Thread DIN 103 1977

Set of Taps

internal standard HSS-E
set of 3 pieces
RH spiral flutes 6°
for general construction steel

Group 680 LH
for through holes



Art.-No.		681/50	682/50	683/50	
Technology	Page 7.1	LH	LH	LH	
Chamfer Length	Page 7.4				
Surface	Page 7.5	bright	bright	bright	
Tolerance	Page 7.6	No. 1	No. 2	No. 3 = 7H	
Material Groups	Page 7.7	1a. general construction steel		3b. spheroidal and malleable cast iron	

Ød ₁	P _{mm}	L ₁	L ₂	d ₂	<input type="checkbox"/>				
Tr 10	2	90	35	7	5,5	8,1	•	•	•
Tr 12	3	110	45	8	6,2	9,2	•	•	•
Tr 14	3	130	45	10	8	11,2	•	•	•
Tr 16	4	140	55	11	9	12,3	•	•	•
Tr 18	4	150	55	12	9	14,3	•	•	•
Tr 20	4	160	55	15	12	16,3	•	•	•
Tr 22	5	180	70	16	12	17,3	•	•	•
Tr 24	5	190	70	18	14,5	19,3	•	•	•
Tr 26	5	210	70	20	16	21,3	•	•	•
Tr 28	5	220	70	22	18	23,3	•	•	•
Tr 30	6	240	85	22	18	24,3	•	•	•
Tr 32	6	255	85	25	20	26,3	•	•	•
Tr 36	6	280	85	28	22	30,3	•	•	•
Tr 40	7	310	90	32	24	33,3	•	•	•