

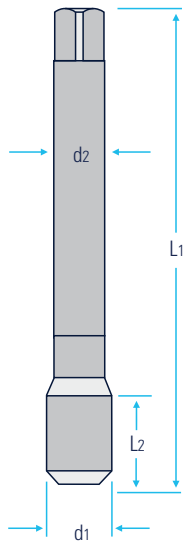
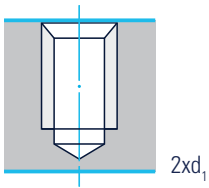


# MF - ISO Metric Fine Thread DIN 13

## Machine Taps

DIN 374 HSS-E  
straight flutes  
for general construction steel

Group 500  
for blind holes



MF

Art.-No.		500		
Technology	<a href="#">Page 7.1</a>			
Chamfer Length	<a href="#">Page 7.4</a>	C / 2-3 x P		
Surface	<a href="#">Page 7.5</a>	bright		
Tolerance	<a href="#">Page 7.6</a>	ISO2 (6H)		
Material Groups	<a href="#">Page 7.7</a>	1a. general construction steel		

Ød <sub>1</sub>	P <sub>mm</sub>	L <sub>1</sub>	L <sub>2</sub>	d <sub>2</sub>	□	⌀			
M 4	0,5	63	8	4,5	3,4	3,5	●		
M 5	0,5	70	9	6	4,9	4,5	●		
M 6	0,5	80	10	6	4,9	5,5	●		
M 6	0,75	80	12	6	4,9	5,3	●		
M 8	0,75	80	14	6	4,9	7,3	●		
M 10	0,75	90	16	7	5,5	9,3	●		
M 8	1	90	16	6	4,9	7,0	●		
M 10	1	90	16	7	5,5	9,0	●		
M 12	1	100	16	9	7	11,0	●		
M 14	1	100	16	11	9	13,0	●		
M 16	1	100	16	12	9	15,0	●		
M 18	1	110	18	14	11	17,0	●		
M 20	1	125	18	16	12	19,0	●		
M 22	1	125	18	18	18	21,0	●		
M 24	1	140	18	18	18	23,0	●		
M 10	1,25	100	20	7	5,5	8,8	●		
M 12	1,25	100	22	9	7	10,8	●		
M 14	1,25	100	22	11	9	12,8	●		
M 12	1,5	100	22	9	7	10,5	●		
M 14	1,5	100	22	11	9	12,5	●		
M 16	1,5	100	22	12	12	14,5	●		
M 18	1,5	110	25	14	11	16,5	●		
M 20	1,5	125	25	16	12	18,5	●		

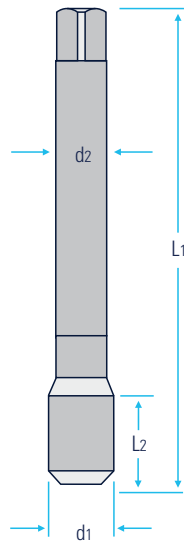
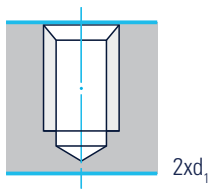


# MF - ISO Metric Fine Thread DIN 13

## Machine Taps

DIN 374 HSS-E  
straight flutes  
for general construction steel

Group 500  
for blind holes



Art.-No.		500		
Technology	<a href="#">Page 7.1</a>			
Chamfer Length	<a href="#">Page 7.4</a>	C / 2-3 x P		
Surface	<a href="#">Page 7.5</a>	bright		
Tolerance	<a href="#">Page 7.6</a>	ISO2 (6H)		
Material Groups	<a href="#">Page 7.7</a>	1a. general construction steel		

Ød <sub>1</sub>	P <sub>mm</sub>	L <sub>1</sub>	L <sub>2</sub>	d <sub>2</sub>	□	⌀			
M 22	1,5	125	25	18	14,5	20,5	●		
M 24	1,5	140	25	18	14,5	22,5	●		
M 26	1,5	140	25	18	14,5	24,5	●		
M 28	1,5	140	28	20	16	26,5	●		
M 30	1,5	150	28	22	18	28,5	●		
M 32	1,5	150	28	22	18	30,5	●		
M 34	1,5	170	28	22	22	32,5	●		
M 36	1,5	170	28	22	22	34,5	●		
M 38	1,5	170	28	22	22	36,5	●		
M 40	1,5	170	28	32	24	38,5	●		
M 42	1,5	170	30	32	24	40,5	●		
M 45	1,5	180	25	36	29	43,5	●		
M 48	1,5	190	32	36	29	46,5	●		
M 18	2	125	32	14	11	16,0	●		
M 20	2	140	32	16	12	18,0	●		
M 22	2	140	32	18	14,5	20,0	●		
M 24	2	140	28	18	14,5	22,0	●		
M 27	2	140	28	20	16	25,0	●		
M 30	2	150	28	22	18	28,0	●		
M 33	2	160	28	25	20	31,0	●		
M 36	2	170	28	28	22	34,0	●		
M 39	2	170	28	32	24	37,0	●		
M 40	2	170	28	32	24	38,0	●		

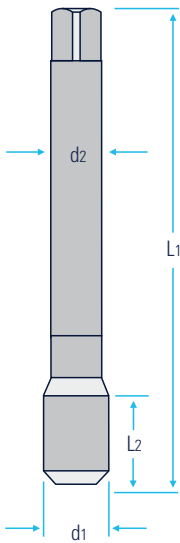
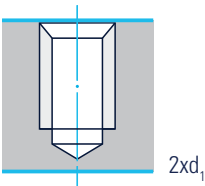


## MF - ISO Metric Fine Thread DIN 13

### Machine Taps

DIN 374 HSS-E  
straight flutes  
for general construction steel

Group 500  
for blind holes



Art.-No.		500					
Technology	Page 7.1						
Chamfer Length	Page 7.4	C / 2-3 x P					
Surface	Page 7.5	bright					
Tolerance	Page 7.6	ISO2 (6H)					
Material Groups	Page 7.7	1a. general construction steel					
Ød <sub>1</sub>	P <sub>mm</sub>	L <sub>1</sub>	L <sub>2</sub>	d <sub>2</sub>	□		
M 42	2	170	30	32	24	40,0	●
M 45	2	180	32	36	29	43,0	●
M 36	3	200	36	28	22	33,0	●
M 39	3	200	36	32	24	36,0	●
M 42	3	200	40	32	24	39,0	●
M 45	3	200	40	36	29	42,0	●
M 48	3	225	40	36	29	45,0	●

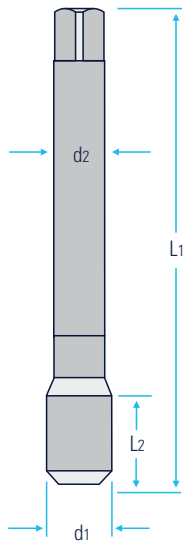
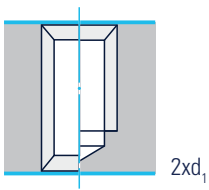


# MF - ISO Metric Fine Thread DIN 13

Machine Taps  
White Ring

DIN 374 HSS-E  
straight flutes  
for cast iron

Group 503  
for blind and through holes



Art.-No.		503		
Technology	<a href="#">Page 7.1</a>	White Ring		
Chamfer Length	<a href="#">Page 7.4</a>	C / 2-3 x P		
Surface	<a href="#">Page 7.5</a>	nitrided		
Tolerance	<a href="#">Page 7.6</a>	ISO2 (6H)		
Material Groups	<a href="#">Page 7.7</a>	3a. grey cast iron 8b. duroplastics		

Ød <sub>1</sub>	P <sub>mm</sub>	L <sub>1</sub>	L <sub>2</sub>	d <sub>2</sub>	□	⌘			
M 4	0,5	63	8	4,5	3,4	3,5			
M 5	0,5	70	9	6	4,9	4,5			
M 6	0,5	80	10	6	4,9	5,5			
M 6	0,75	80	12	6	4,9	5,3			
M 8	1	90	16	6	4,9	7,0	●		
M 10	1	90	16	7	5,5	9,0	●		
M 12	1	100	16	9	7	11,0	●		
M 14	1	100	16	11	9	13,0	●		
M 10	1,25	100	20	7	5,5	8,8	●		
M 12	1,25	100	22	9	7	10,8	●		
M 12	1,5	100	22	9	7	10,5	●		
M 14	1,5	100	22	11	9	12,5	●		
M 16	1,5	100	22	12	12	14,5	●		
M 18	1,5	110	25	14	11	16,5	●		
M 20	1,5	125	25	16	12	18,5	●		
M 22	1,5	125	25	18	14,5	20,5	●		
M 24	1,5	140	25	18	14,5	22,5	●		

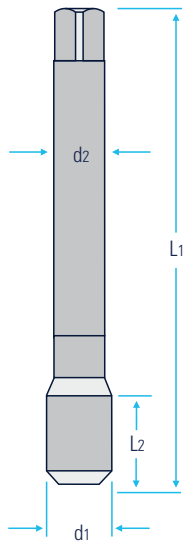
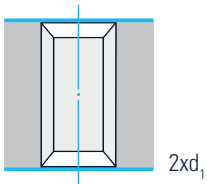


# MF - ISO Metric Fine Thread DIN 13

## Machine Taps

DIN 374 HSS-E  
spiral point  
for general construction steel

Group 510  
for through holes



Art.-No.		510	510/25	
Technology	<a href="#">Page 7.1</a>	<b>High Volume</b> by Schumacher	<b>High Volume</b> by Schumacher	
Chamfer Length	<a href="#">Page 7.4</a>	B / 3,5-5 x P		
Surface	<a href="#">Page 7.5</a>	bright	TiN	
Tolerance	<a href="#">Page 7.6</a>	ISO2 (6H)	ISO2 (6H)	
Material Groups	<a href="#">Page 7.7</a>	1a. general construction steel 3b. spheroidal and malleable cast iron		

Ød <sub>1</sub>	P <sub>mm</sub>	L <sub>1</sub>	L <sub>2</sub>	d <sub>2</sub>	□	⌀			
M 4	0,5	63	8	4,5	3,4	3,5	●		
M 5	0,5	70	9	6	4,9	4,5	●		
M 6	0,5	80	10	6	4,9	5,5	●		
M 6	0,75	80	12	6	4,9	5,3	●		
M 8	0,75	80	14	6	4,9	7,3	●		
M 10	0,75	90	16	7	5,5	9,3	●		
M 8	1	90	16	6	4,9	7,0	●	●	
M 10	1	90	16	7	5,5	9,0	●	●	
M 12	1	100	16	9	7	11,0	●	●	
M 14	1	100	16	11	9	13,0	●	●	
M 16	1	100	16	12	9	15,0	●		
M 18	1	110	18	14	11	17,0	●		
M 20	1	125	18	16	12	19,0	●		
M 22	1	125	18	18	18	21,0	●		
M 24	1	140	18	18	18	23,0	●		
M 10	1,25	100	20	7	5,5	8,8	●	●	
M 12	1,25	100	22	9	7	10,8	●	●	
M 14	1,25	100	22	11	9	12,8	●		
M 12	1,5	100	22	9	7	10,5	●	●	
M 14	1,5	100	22	11	9	12,5	●	●	
M 16	1,5	100	22	12	12	14,5	●	●	
M 18	1,5	110	25	14	11	16,5	●	●	
M 20	1,5	125	25	16	12	18,5	●	●	

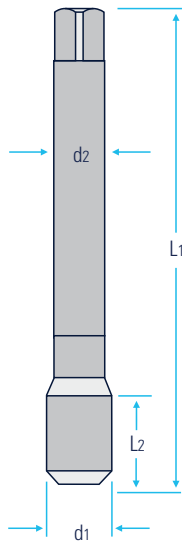
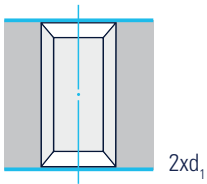


# MF - ISO Metric Fine Thread DIN 13

## Machine Taps

DIN 374 HSS-E  
spiral point  
for general construction steel

Group 510  
for through holes



Art.-No.		510	510/25	
Technology	<a href="#">Page 7.1</a>	<b>High Volume</b> by Schumacher	<b>High Volume</b> by Schumacher	
Chamfer Length	<a href="#">Page 7.4</a>	B / 3,5-5 x P		
Surface	<a href="#">Page 7.5</a>	bright	TiN	
Tolerance	<a href="#">Page 7.6</a>	ISO2 (6H)	ISO2 (6H)	
Material Groups	<a href="#">Page 7.7</a>	1a. general construction steel 3b. spheroidal and malleable cast iron		

Ød <sub>1</sub>	P <sub>mm</sub>	L <sub>1</sub>	L <sub>2</sub>	d <sub>2</sub>	□	🌀			
M 22	1,5	125	25	18	14,5	20,5	●	●	
M 24	1,5	140	25	18	14,5	22,5	●	●	
M 26	1,5	140	25	18	14,5	24,5	●		
M 28	1,5	140	28	20	16	26,5	●		
M 30	1,5	150	28	22	18	28,5	●		
M 32	1,5	150	28	22	18	30,5	●		
M 34	1,5	170	28	28	22	32,5	●		
M 36	1,5	170	28	28	22	34,5	●		
M 38	1,5	170	28	28	22	36,5	●		
M 40	1,5	170	28	32	24	38,5	●		
M 42	1,5	170	30	32	24	40,5	●		
M 45	1,5	180	25	36	29	43,5	●		
M 48	1,5	190	32	36	29	46,5	●		
M 18	2	125	32	14	11	16,0	●		
M 20	2	140	32	16	12	18,0	●		
M 22	2	140	32	18	14,5	20,0	●		
M 24	2	140	28	18	14,5	22,0	●		
M 27	2	140	28	20	16	25,0	●		
M 30	2	150	28	22	18	28,0	●		
M 33	2	160	28	25	20	31,0	●		
M 36	2	170	28	28	22	34,0	●		
M 39	2	170	28	32	24	37,0	●		
M 40	2	170	28	32	24	38,0	●		

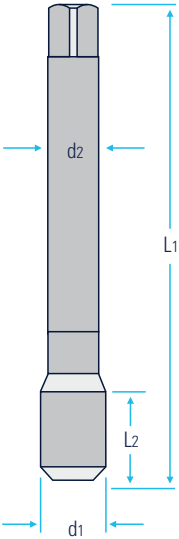
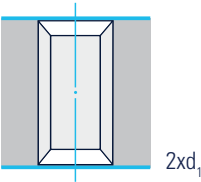


# MF - ISO Metric Fine Thread DIN 13

### Machine Taps

DIN 374 HSS-E  
spiral point  
for general construction steel

Group 510  
for through holes



Art.-No.		510			
Technology	<a href="#">i Page 7.1</a>	High Volume			
Chamfer Length	<a href="#">i Page 7.4</a>	B / 3,5-5 x P			
Surface	<a href="#">i Page 7.5</a>	bright			
Tolerance	<a href="#">i Page 7.6</a>	ISO2 (6H)			
Material Groups	<a href="#">i Page 7.7</a>	1a. general construction steel 3b. spheroidal and malleable cast iron			

$\varnothing d_1$	$P_{mm}$	$L_1$	$L_2$	$d_2$	$\square$				
M 42	2	170	30	32	24	40,0	<input checked="" type="radio"/>		
M 45	2	180	32	36	29	43,0	<input checked="" type="radio"/>		
M 36	3	200	36	28	22	33,0	<input checked="" type="radio"/>		
M 39	3	200	36	32	24	36,0	<input checked="" type="radio"/>		
M 42	3	200	40	32	24	39,0	<input checked="" type="radio"/>		
M 45	3	200	40	36	29	42,0	<input checked="" type="radio"/>		
M 48	3	225	40	36	29	45,0	<input checked="" type="radio"/>		

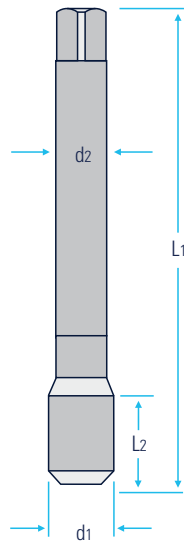
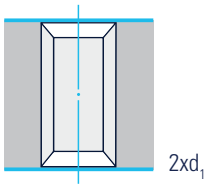


## MF - ISO Metric Fine Thread DIN 13

Machine Taps  
Blue Ring

DIN 374 HSS-E  
spiral point  
for chemical resistant steel

Group 512  
for through holes



Art.-No.		512	512/25	
Technology	Page 7.1	Blue Ring	Blue Ring	
Chamfer Length	Page 7.4	B / 3,5-5 x P		
Surface	Page 7.5	bright	TiN	
Tolerance	Page 7.6	ISO2 (6H)	ISO2 (6H)	
Material Groups	Page 7.7	1b. high strength steel 2. chemical resistant steel 4. titanium alloys		

Ød <sub>1</sub>	P <sub>mm</sub>	L <sub>1</sub>	L <sub>2</sub>	d <sub>2</sub>	□				
M 4	0,5	63	8	4,5	3,4	3,5	●		
M 5	0,5	70	9	6	4,9	4,5	●		
M 6	0,5	80	10	6	4,9	5,5	●		
M 6	0,75	80	12	6	4,9	5,3	●		
M 8	1	90	16	6	4,9	7,0	●	●	
M 10	1	90	16	7	5,5	9,0	●	●	
M 12	1	100	16	9	7	11,0	●	●	
M 14	1	100	16	11	9	13,0	●	●	
M 10	1,25	100	20	7	5,5	8,8	●	●	
M 12	1,25	100	22	9	7	10,8	●	●	
M 12	1,5	100	22	9	7	10,5	●	●	
M 14	1,5	100	22	11	9	12,5	●	●	
M 16	1,5	100	22	12	12	14,5	●	●	
M 18	1,5	110	25	14	11	16,5	●	●	
M 20	1,5	125	25	16	12	18,5	●	●	
M 22	1,5	125	25	18	14,5	20,5	●	●	
M 24	1,5	140	25	18	14,5	22,5	●	●	



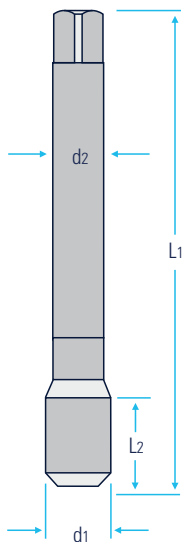
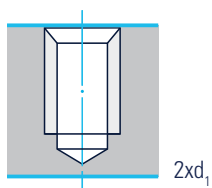


# MF - ISO Metric Fine Thread DIN 13

## Machine Taps

DIN 374 HSS-E  
RH spiral flutes 15°  
for general construction steel

Group 520  
for blind holes



Art.-No.		520		
Technology	<a href="#">i Page 7.1</a>			
Chamfer Length	<a href="#">i Page 7.4</a>	C / 2-3 x P		
Surface	<a href="#">i Page 7.5</a>	bright		
Tolerance	<a href="#">i Page 7.6</a>	ISO2 (6H)		
Material Groups	<a href="#">i Page 7.7</a>	1a. general construction steel 3b. spheroidal and malleable cast iron		

Ød <sub>1</sub>	P <sub>mm</sub>	L <sub>1</sub>	L <sub>2</sub>	d <sub>2</sub>	□	⌀			
M 4	0,5	63	8	4,5	3,4	3,5			
M 5	0,5	70	9	6	4,9	4,5			
M 6	0,5	80	10	6	4,9	5,5			
M 6	0,75	80	12	6	4,9	5,3			
M 8	1	90	16	6	4,9	7,0	●		
M 10	1	90	16	7	5,5	9,0	●		
M 12	1	100	16	9	7	11,0	●		
M 14	1	100	16	11	9	13,0	●		
M 10	1,25	100	20	7	5,5	8,8	●		
M 12	1,25	100	22	9	7	10,8	●		
M 12	1,5	100	22	9	7	10,5	●		
M 14	1,5	100	22	11	9	12,5	●		
M 16	1,5	100	22	12	12	14,5	●		
M 18	1,5	110	25	14	11	16,5	●		
M 20	1,5	125	25	16	12	18,5	●		
M 22	1,5	125	25	18	14,5	20,5	●		
M 24	1,5	140	25	18	14,5	22,5	●		
M 26	1,5	140	25	18	14,5	24,5	●		
M 30	1,5	150	28	22	18	28,5	●		

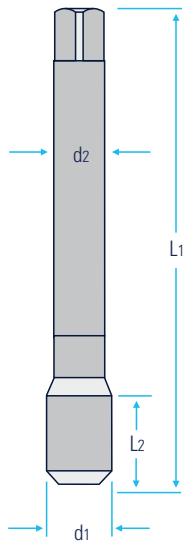
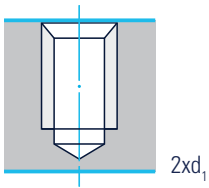


# MF - ISO Metric Fine Thread DIN 13

## Machine Taps

DIN 374 HSS-E  
RH spiral flutes 40°  
for general construction steel

Group 530  
for blind holes



Art.-No.		530	530/25	
Technology	<a href="#">Page 7.1</a>	<b>High Volume</b> by Schumacher	<b>High Volume</b> by Schumacher	
Chamfer Length	<a href="#">Page 7.4</a>	C / 2-3 x P		
Surface	<a href="#">Page 7.5</a>	bright	TiN	
Tolerance	<a href="#">Page 7.6</a>	ISO2 (6H)	ISO2 (6H)	
Material Groups	<a href="#">Page 7.7</a>	1a. general construction steel 3b. spheroidal and malleable cast iron		

Ød1	P <sub>mm</sub>	L1	L2	d2	□	⌀			
M 4	0,5	63	8	4,5	3,4	3,5			
M 5	0,5	70	9	6	4,9	4,5			
M 6	0,5	80	10	6	4,9	5,5			
M 6	0,75	80	12	6	4,9	5,3			
M 8	1	90	16	6	4,9	7,0	●	●	
M 10	1	90	16	7	5,5	9,0	●	●	
M 12	1	100	16	9	7	11,0	●	●	
M 14	1	100	16	11	9	13,0	●	●	
M 10	1,25	100	20	7	5,5	8,8	●	●	
M 12	1,25	100	22	9	7	10,8	●	●	
M 12	1,5	100	22	9	7	10,5	●	●	
M 14	1,5	100	22	11	9	12,5	●	●	
M 16	1,5	100	22	12	12	14,5	●	●	
M 18	1,5	110	25	14	11	16,5	●	●	
M 20	1,5	125	25	16	12	18,5	●	●	
M 22	1,5	125	25	18	14,5	20,5	●	●	
M 24	1,5	140	25	18	14,5	22,5	●	●	
M 26	1,5	140	25	18	14,5	24,5	●		
M 30	1,5	150	28	22	18	28,5	●		

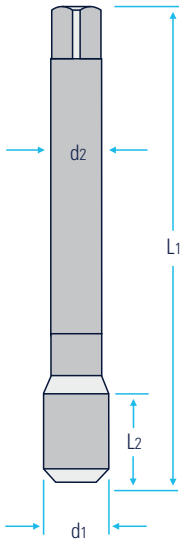
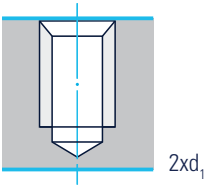


**MF - ISO Metric Fine Thread DIN 13**

Machine Taps  
Blue Ring

DIN 374 HSS-E  
RH spiral flutes 40°  
for chemical resistant steel

Group 535  
for blind holes



Art.-No.		535	535/25		
Technology	<a href="#">Page 7.1</a>	Blue Ring	Blue Ring		
Chamfer Length	<a href="#">Page 7.4</a>	C / 2-3 x P			
Surface	<a href="#">Page 7.5</a>	bright	TiN		
Tolerance	<a href="#">Page 7.6</a>	ISO2 (6H)	ISO2 (6H)		
Material Groups	<a href="#">Page 7.7</a>	1b. high strength steel 2. chemical resistant steel 4. titanium alloys			

Ød1	P <sub>mm</sub>	L1	L2	d2	□	🌀			
M 4	0,5	63	8	4,5	3,4	3,5			
M 5	0,5	70	9	6	4,9	4,5			
M 6	0,5	80	10	6	4,9	5,5			
M 6	0,75	80	12	6	4,9	5,3			
M 8	1	90	16	6	4,9	7,0	●	●	
M 10	1	90	16	7	5,5	9,0	●	●	
M 12	1	100	16	9	7	11,0	●	●	
M 14	1	100	16	11	9	13,0	●	●	
M 10	1,25	100	20	7	5,5	8,8	●	●	
M 12	1,25	100	22	9	7	10,8	●	●	
M 12	1,5	100	22	9	7	10,5	●	●	
M 14	1,5	100	22	11	9	12,5	●	●	
M 16	1,5	100	22	12	12	14,5	●	●	
M 18	1,5	110	25	14	11	16,5	●	●	
M 20	1,5	125	25	16	12	18,5	●	●	
M 22	1,5	125	25	18	14,5	20,5	●	●	
M 24	1,5	140	25	18	14,5	22,5	●	●	
M 26	1,5	140	25	18	14,5	24,5			
M 30	1,5	150	28	22	18	28,5			