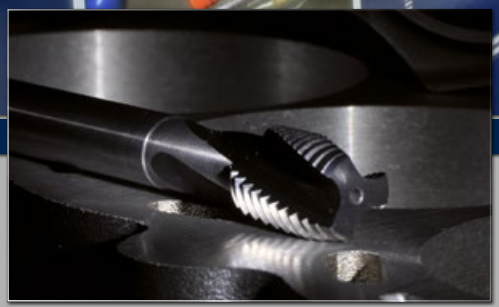
SCHUMACHER

PRECISION TOOLS SINCE 1918

KATALOG NR. 125 G - GEWINDETECHNIK



Edition
Threading Technology

Products | Applications | Digital Services

Catalogue No. 125 G
Threading Technology

Products | Applications | Digital Services

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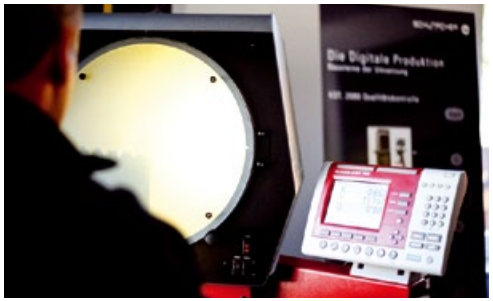


geometry development

fully-automated measurement process for new developments

Research & Development

Research and Development focuses on two crucial areas: tool know-how and machining technology by Schumacher Precision Tools (SPT) and systems for digital process control in small and medium-sized enterprises by GAP (Gesellschaft für angewandte Prozesslenkung).

For the development of new machining technology, Schumacher utilizes the standardized product technology database of the module ToolDesign, which contains more than 20,000 tool variants. This technology can be used for both new designs and ongoing developments, drawing upon algorithms. CAD-variant construction will be deployed for the respective tool models.

Schumacher can rely on an established network of renowned institutions in research disciplines such as high-speed steel and carbide substrates, heat and surface treatment, or hard material coating.

The management and technology modules developed by GAP in cooperation with technical universities ensure a consistent digital networking within the company. Data base-oriented product design with the module ToolDesign combined with the digital control system of the module ToolProduction fulfill the objectives of the government's initiative 'Industry 4.0'. ToolProduction represents digital process structures in production, a know-how advantage that is applied for the internal process optimization of Schumacher Precision Tools. Moreover, the cross-departmental nature of ToolProduction allows partial or complete synchronization with partner companies in designated sections.

SCHUMACHER
PRECISION TOOLS SINCE 1918

GAP
Gesellschaft für angewandte Prozesslenkung

RWTH AACHEN UNIVERSITY

research cooperation with
various technical universities


R&D
by Schumacher
ToolProduction
by Schumacher
DigitalProcessPlanning
by Schumacher

Revolution in der Prozesslenkung

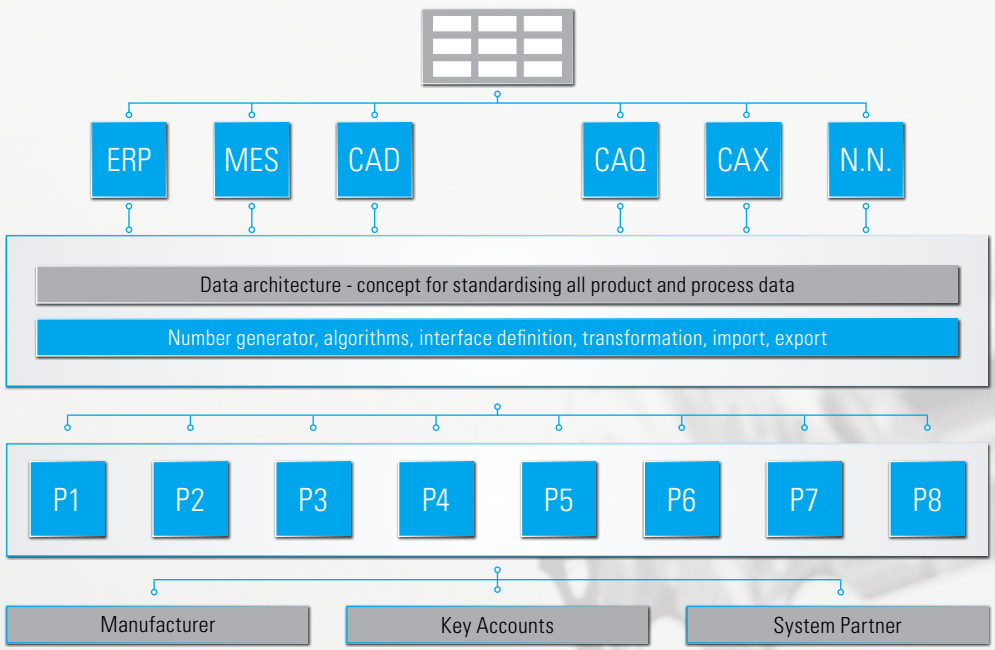
Supporting Digital Production

ToolProduction by Schumacher

DigitalProcessPlanning by Schumacher

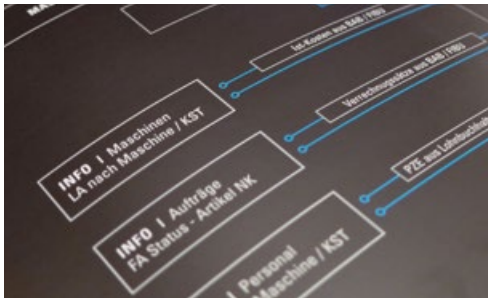
GAP - ToolProduction

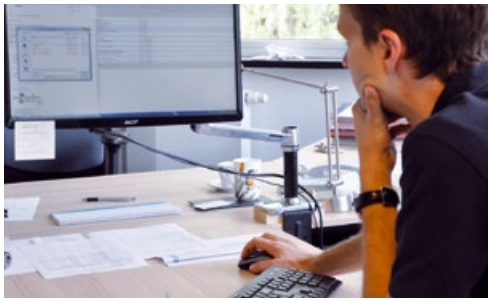
1. integrated user interface GAP / SPT
2. IT modules
3. Standardised data platform
4. 8-platform strategy



ToolSimulation by Schumacher

ToolProduction





Practical solution approach for industrial SMEs

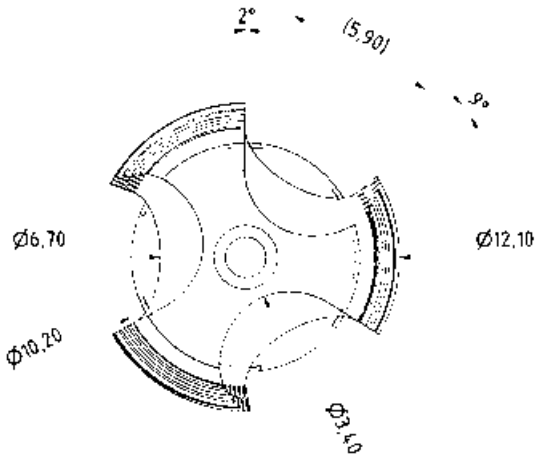
Data Integration & Resource Efficiency

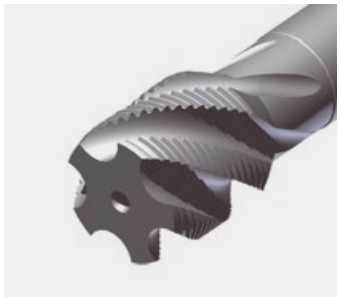
Due to the political and economic framework conditions, resource conservation in all its facets is becoming increasingly important.

› The introduction of cross-divisional digital process control is an obvious choice due to its high efficiency and holistic nature for conserving all resources in industrial processes.

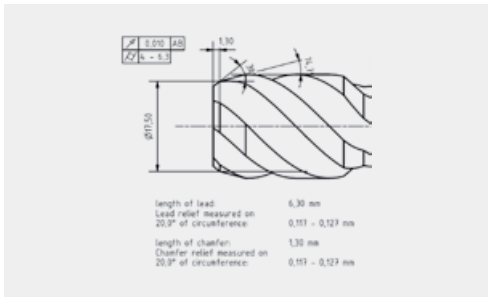
› To increase this efficiency, the use of artificial intelligence can achieve additional positive effects. For such a development in the SME class of companies considered here, however, the prerequisites for the realisation of digital process control must be planned with targeted solution approaches.

› he integration of different IT modules for a control system is a major challenge in this class of company. Data integration is also a key success factor in order to ensure comprehensive process flows between the necessary standard IT modules - not least for AI applications. If this integration is not successful across all areas, redundancies arise which, in the view of the experts, would thwart all the prerequisites for successful digitalisation.





3D model precision tool



Drawing detail

CAD-construction using algorithms and methods of variant construction

Design & Simulation

The ToolDesign Principle

The objective:

The GAP-module ToolDesign supports and automatizes the development, construction, production, and administration of rotation-symmetric precision tools.

ToolDesign serves as the core of Schumacher's process control in the ToolProduction module – as overall technology hub for products and production parameters. The system is founded on the parameter-based item structure with the construction features of all available tool variants. This standardized technology structure allows the automatic generation of constructive, production-technical, and calculative framework conditions for manufacturing rotation-symmetric precision tools.

ToolDesign
by Schumacher

ToolSimulation
by Schumacher

ToolDesign – FEATURES:

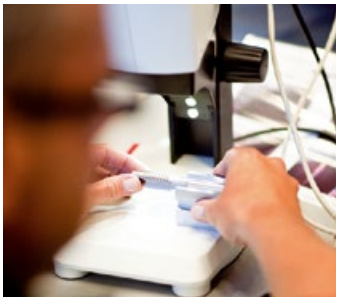
› Pricing for Quotation Management
› Parameterized 3D-volume models
› Production drawings
› Data generation and transfer for CNC-production machine tools
› Providing know-how data for B2B and B2C-Partners

ToolDesign
by Schumacher

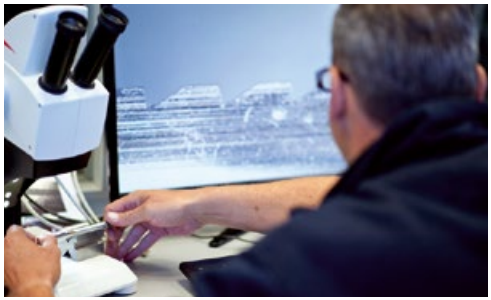
ToolSimulation
by Schumacher

ToolSimulation – FEATURES:

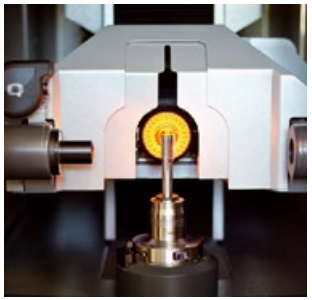
› Digital preparation of 3D volume models for simulation process
› Data transfer of 3D volume tool models from ToolDesign
› Development of 3D volume work piece models
› Material classification of the work piece and tool models
› Simulation – testing new tool variants
› Interpretation of results



measurement process

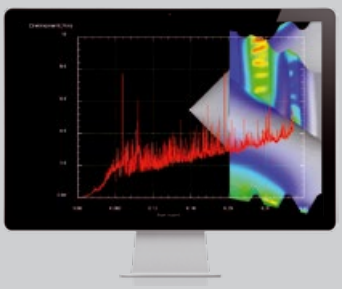


profile inspection



digital measurement process

Simulation-based test runs before start of production increase the quality of new tool variants development



torque curve through FEM simulation

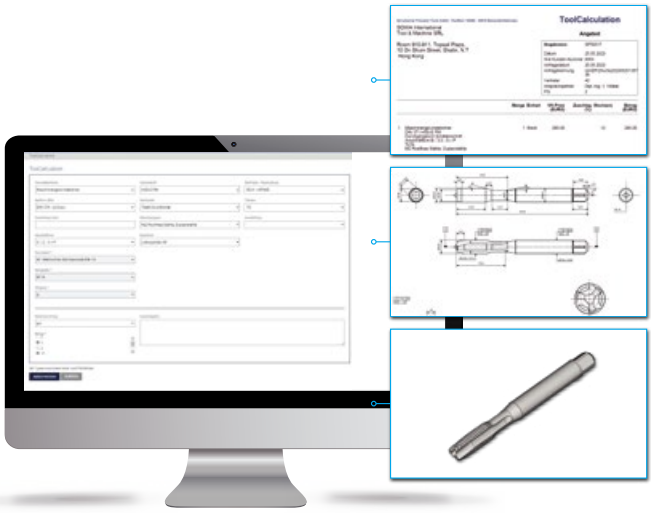
Design & Simulation

The ToolSimulation Principle

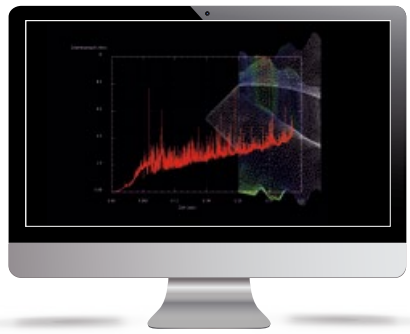
The Objective:

The GAP-module Tool-Simulation uses the FEM method to simulate the cutting performance of precision tools. In this context, 3D tool models from ToolDesign can be tested virtually in defined work pieces with their material properties before tool production begins.

The simulation process was realized with high computer processing power through extensive modification of a standard simulation software. At the start, an interactive work piece description for the process is provided to the user of ToolSimulation. This digital work piece receives information about all material properties that are necessary for the simulation process from an edited system data base. The geometry variations and material properties of the precision tools are available through the 3D volume models from ToolDesign.



WEB-based quotation system



Solid state simulation FEM

Digital value-added services for the primary product

Data Integration & Digital Transformation

Decentralised 3D printing of precision tools using the ‚Additive Manufacturing AM process' with internal cooling variants has already been successfully tested by ToolProduction (TP) at the customer's premises.

At TP, retrofit solutions ensure the continuity of the control of operating resources that are not 100% digital-capable.

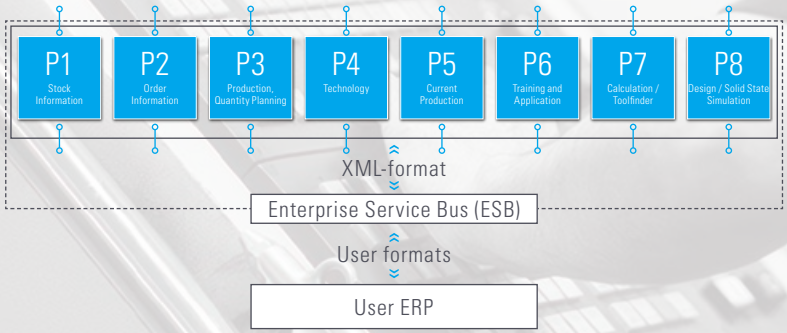
Utilising the data structures of the TP steering system, GAP is developing a WEB-based 8-platform strategy for this application support.

These 8 platforms enable the tool manufacturer to network with its markets and offer product users in all relevant disciplines ‚digital transformation' with value-added services that go beyond the primary product.

ToolProduction
by Schumacher

DigitalProcessPlanning
by Schumacher

Mirosoft Dynamics – Navision



ToolProduction
by Schumacher

DigitalProcessPlanning
by Schumacher

Production & Digital Process Control

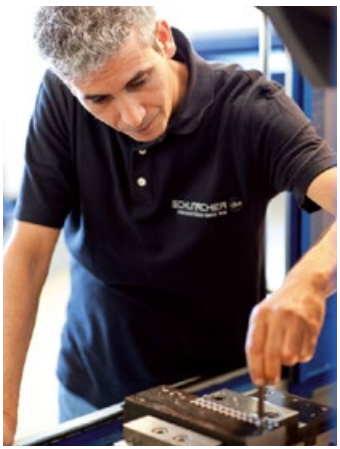
The ToolProduction Principle

The Objective: Introduction of Digital Process Control according to 'Industry 4.0'

The required framework conditions for a successful introduction of digital and decentralized process control at SPT were provided through various modules of computer-aided information processing in all departments. By the early 1990s, SPT had completed connecting all departments related to production with a cross-departmental information system. This was part of the introduction of a CIM strategy (Computer Integrated Manufacturing).

Smart services for customers through data generated during production

Robot-loaded grinding center



Examination of test results

Performance tests

Location-independent digital description of entire processing

GAP
Gesellschaft für angewandte Prozesslenkung

As of Today, use of IT comprises the following technical-organizational sections:

- stock management
- sales
- development and design
- production scheduling
- production planning and control
- manufacturing
- logistics and quality control
- finance

Production & Digital Process Control

The current GAP-initiative ToolProduction with many features from 'Industry 4.0' considers the change in the industry's framework conditions and leads to the digital transformation of all processes. This is related to the introduction of Smart Services, a platform making any relevant process and technology data generated during production available in real-time.

GAP

Gesellschaft für angewandte Prozesslenkung

Digital Process Planning for SMEs | The Modular Principle

Navigator

suitability code	■ well-suited	□ suited	
core hole types	1 blind holes	2 through holes	
	3 blind and through holes	4 blind holes > 2 xd	
coolant	O cutting oil	E emulsion	
	P paraffin	A air	

Reference cutting speeds V_c page 8.5

Type of Thread & Catalogue 125 page
M
MF
G
UNC/UN
UNF
NPT
PG
TR

Material Groups DIN ISO 513		Description		Beispiel	Lubricating Coolant
P	P1	General construction steels	(≤ 800N)	St37-2, 16 MnCr5, C60	E, O
	P2	Cementation, Heat-treatable, Nitriding steels	(≤ 1200N)	42CrMo4, 30CrNiMo8	E, O
	P3	High-alloyed steels, Heat-resistant steels	(≤ 1400N)	X38CrMoV5-3, Toolox44	O
M	M1	Stainless steels austenitic		X 5 Cr Ni 18 10, X 6 Ni Mo Ti 17 12 2, X 10 Cr Ni S 18 9	O
	M1	Stainless steels ferritic, martensitic		X 6 Cr 13, X 4 Cr Mo S 18, X 30 Cr 13, X 12 Cr Mo S 17	O
	M2	Duplex steels		X2CrNiMoN22-5-3	O, P
K	K1	Grey cast iron		EN-GJL-200 (GG 20), EN-GJL-300 (GG 30)	E, O
	K2	Nodular cast iron		EN-GJS-400-15 (GGG 40), EN-GJS-600-3 (GGG 60)	E, O
	K3	Malleable cast iron		EN-GJMB-450-06 (GTS 45), EN-GJMW-350-04 (GTW 35)	E, O
N	N1	Aluminium wrought alloys		Al Mg Si, Al Mn 1	E, O
	N1	Aluminium cast alloys < 10 % Si	(< 10 % Si)	G-Al Mg 3, G-Al Si 9 Cu 3	E, O
	N2	Aluminium cast alloys ≥ 10% Si	(≥ 10 % Si)	G-Al Si 10 Mg, G-AlSi 12	E, O
	N3	Copper alloys		E-Cu, SE-Cu	E, O
	N3	Special copper alloys (AMPCO)		Ampco 18, Ampco 20, Ampco 25	dry
	N4	Brass long chipping		Cu Zn 30	E, O
	N4	Brass short chipping		Cu Zn 39 Pb 2 (MS 58), Cu Zn 40 Al 2	E, O
	N5	Bronze long chipping		G Cu Sn 10 Zn (Rg 10)	E, O
	N5	Bronze short chipping		G Cu Pb 5 Sn (RG 5), Cu Sn 8 (Rg 7)	E, O
	N6	Thermoplastics		Hostalen/Makrolon/PS/PVC	E, O
	N7	Duroplastics/Fibre reinforced		Bakelit/Pertinax/Ferrozell/Resopal	E, O
	N8	Magnesium alloys		Az 91	O, A
	N9	Graphite		C 8000	A
S	S1	Pure titanium/titanium alloys		Ti 99, 5, Ti 99.4, Ti Al 5 Sn 2, Ti Al 6 V 4	E, O, P
	S2	Pure nickel/nickel alloys		Ni 99,6, Inconel 718	O, P
H	H1	Hard materials up to 50 HRC		Hardox 450	O, P
	H2	Hard materials up to 60 HRC		Hardox 550	O, P

2.2	2.5	2.6	2.6	2.6	2.8	2.10	2.12	2.13	2.13	2.15	2.15	2.15	2.18	2.18
3.1		3.5								3.6				3.6
4.1		4.2								4.3				4.3
5.1		5.3								5.5				5.5
5.22		5.24								5.26				5.26
6.4														

ST HSS-E	MS HSS-E	GG HSS-E	GG HSS-E	GG HSS-E	HARD HSS-E/PM	HARD HSS-E/PM	MG HSS-E/PM	AL HSS-E/PM	AL HSS-E/PM	ST HSS-E	ST 6G HSS-E	ST 7G HSS-E	ST LH HSS-E	ST HSS-E
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2.18	2.20	2.22	2.22	2.24	2.26	2.28	2.30	2.32	2.32	2.34	2.36	2.36	2.39	2.41
		3.10	3.10									3.11		3.12
		4.4	4.4									4.5		4.6
		5.7	5.7									5.9		
		5.24	5.24									5.30		

ST 2xL1 HSS-E	ST, CNC HSS-E/PM	VA HSS-E	VA HSS-E	VA HSS-E/PM	VG HSS-E/PM	NI HSS-E/PM	ST, AZ HSS-E	VG HSS-E	VG HSS-E	TI HSS-E/PM	Uni HSS-E	Uni HSS-E	Uni HSS-E/PM	ST HSS-E
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2.41	2.41	2.43	2.43	2.45	2.46	2.48	2.50	2.50	2.50	2.53	2.53	2.53	2.55	2.57
							3.13				3.13			
							4.7				4.7			
				5.11	5.12		5.14				5.14			
					5.32		5.33				5.33			

ST HSS-E	ST HSS-E	VG HSS-E	VG HSS-E	VG HSS-E	NI HSS-E/PM	TI HSS-E/PM	ST HSS-E	ST 6G HSS-E	ST 7G HSS-E	ST LH HSS-E	ST HSS-E	ST 2xL1 HSS-E	ST HSS-E/PM	ST, CNC HSS-E/PM
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2.57	2.59	2.59	2.62	2.64	2.66	2.66	2.68	2.70	2.70	2.72	2.72	2.74	2.76	2.76
	3.14				3.15	3.15								
	4.8				4.9	4.9								
	5.18				5.16	5.16								
	5.38				5.35	5.35								
												Thread former		

ST, CNC HSS-E/PM	Uni HSS-E	Uni HSS-E	Uni HSS/PM	VG HSS-E/PM	VA HSS-E	VA HSS-E	VA HSS-E/PM	AL HSS-E/PM	AL HSS-E/PM	VG HSS-E	VG HSS-E	Uni HSS-E/PM	AL HSS-E/PM	AL HSS-E/PM
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2.78	2.80	2.82	2.82	2.82					2.90	2.91	2.91	2.92	2.93	2.93	
											3.19				
		5.20	5.20												
Thread former					6.1	6.2			VHM tec CARBIDE by Schumacher						
							6.6	6.6							

ST, CNC HSS-E/PM	VG HSS-E/PM	ST HSS-E	ST HSS-E	ST 6GX HSS-E	ST HSS-E	VG HSS-E/PM	ST HSS-E	ST LH HSS-E	Hard VHM	Hard VHM	Hard VHM	Uni VHM	ST VHM	ST VHM
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3	3	3	3	3	3	1	2	2	2	3	3	1	3	3

2.2	ISO Metric Coarse Thread DIN 13	M	
2.90	ISO Metric Coarse Thread DIN 13	M /	VHM
3.1	ISO Metric Fine Thread DIN 13	MF	
3.19	ISO Metric Fine Thread DIN 13	MF /	VHM
4.1	Whitworth Pipe Thread DIN ISO 228	G	
5.1	Unified Coarse Thread ANSI B1.1	UNC	
5.22	Unified Fine Thread ANSI B1.1	UNF	
6.1	American Tapered Pipe Thread ANSI B 1.20.1	NPT	
6.4	Steel Conduit Thread DIN 40430	PG	
6.6	ISO Metric Trapezoidal Thread DIN 103 1977	TR	

7.1	Tap Holder
7.2	ER Collet Tap Holder for machines with synchronous spindle
7.5	Quick Change Tap Holder for machines with synchronous spindle
7.8	Quick Change Tap Holder Conventional

Machine Taps

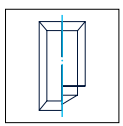
Cutting Data

DIN 371 HSS-E

straight flutes
for general construction steel

Group 3000
for blind and through holes

STEEL



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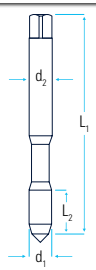


Art.-No.		30000
Technology	i Page 8.1	
Champfer Length	i Page 8.4	C / 2-3 x P
Surface	i Page 8.2	bright
Tolerance	i Page 8.5	ISO2 (6H) | ISO1 (4H)
Cutting Data	i Page 8.6	P1 general construction steel

Ø d_1	P_{mm}	L_1	L_2	d_2	□		
M 1	0.25	40	5.5	2.5	2.1	0.75	■
M 1.2	0.25	40	5.5	2.5	2.1	0.95	■
M 1.4	0.3	40	7	2.5	2.1	1.1	■
M 1.6	0.35	40	8	2.5	2.1	1.25	■
M 1.7	0.35	40	8	2.5	2.1	1.35	■
M 1.8	0.35	40	8	2.5	2.1	1.45	■
M 2	0.4	45	8	2.8	2.1	1.6	■
M 2.2	0.45	45	8	2.8	2.1	1.75	■
M 2.3	0.4	45	8	2.8	2.1	1.9	■
M 2.5	0.45	50	9	2.8	2.1	2.05	■
M 2.6	0.45	50	9	2.8	2.1	2.15	■

Continuation »

■ avialable – intermediate size on request

Machine Taps

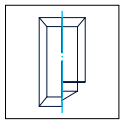
Cutting Data

DIN 371 HSS-E

straight flutes
for general construction steel

Group 3000
for blind and through holes

STEEL



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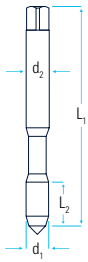


Art.-No.		30000
Technology	Page 8.1	
Champfer Length	Page 8.4	C / 2-3 x P
Surface	Page 8.2	bright
Tolerance	Page 8.5	ISO2 (6H)
Cutting Data	Page 8.6	P1 general construction steel

Ø d_1	P_{mm}	L_1	L_2	d_2	□		
M 3	0.5	56	11	3.5	2.7	2.5	■
M 3.5	0.6	56	12	4	3	2.9	■
M 4	0.7	63	13	4.5	3.4	3.3	■
M 5	0.8	70	15	6	4.9	4.2	■
M 6	1	80	17	6	4.9	5.0	■
M 7	1	80	17	7	5.5	6.0	■
M 8	1.25	90	20	8	6.2	6.8	■
M 9	1.25	90	20	9	7	7.8	■
M 10	1.5	100	22	10	8	8.5	■
M 12	1.75	110	24	12	9	10.2	■

■ avialable – intermediate size on request

Machine Taps

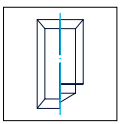
Cutting Data

DIN 376 HSS-E

straight flutes
for general construction steel

Group 4000
for blind and through holes

STEEL



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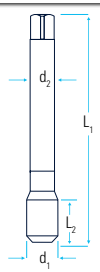


Art.-No.		40000
Technology	Page 8.1	
Champfer Length	Page 8.4	C / 2-3 x P
Surface	Page 8.2	bright
Tolerance	Page 8.5	ISO2 (6H)
Cutting Data	Page 8.6	P1 general construction steel

Ø d_1	P_{mm}	L_1	L_2	d_2	□		
M 6	1	80	17	4.5	3.4	5.0	■
M 7	1	80	17	5.5	4.3	6.0	■
M 8	1.25	90	20	6	4.9	6.8	■
M 9	1.25	90	20	7	5.5	7.8	■
M 10	1.5	100	22	7	5.5	8.5	■
M 12	1.75	110	24	9	7	10.2	■
M 14	2	110	26	11	9	12.0	■
M 16	2	110	27	12	9	14.0	■
M 18	2.5	125	30	14	11	15.5	■
M 20	2.5	140	32	16	12	17.5	■
M 22	2.5	140	32	18	14.5	19.5	■
M 24	3	160	34	18	14.5	21.0	■
M 27	3	160	36	20	16	24.0	■
M 30	3.5	180	40	22	18	26.5	■
M 33	3.5	180	40	25	20	29.5	■
M 36	4	200	50	28	22	32.0	■

■ avialable – intermediate size on request

Machine Taps

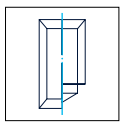
Cutting Data

DIN 371 HSS-E

straight flutes
for copper alloys

Group 3020
for blind and through holes

MS



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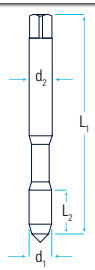


Art.-No.		30200
Technology	Page 8.1	
Champfer Length	Page 8.4	E / 1,5-2 x P
Surface	Page 8.2	bright
Tolerance	Page 8.5	ISO2 (6H)
Cutting Data	Page 8.6	N3 copper alloys

Ø d_1	P_{mm}	L_1	L_2	d_2	□		
M 1.7	0.35	40	8	2.5	2.1	1.35	
M 1.8	0.35	40	8	2.5	2.1	1.45	
M 2	0.4	45	8	2.8	2.1	1.6	
M 2.2	0.45	45	8	2.8	2.1	1.75	
M 2.3	0.4	45	8	2.8	2.1	1.9	
M 2.5	0.45	50	9	2.8	2.1	2.05	
M 2.6	0.45	50	9	2.8	2.1	2.15	
M 3	0.5	56	11	3.5	2.7	2.5	■
M 3.5	0.6	56	12	4	3	2.9	
M 4	0.7	63	13	4.5	3.4	3.3	■
M 5	0.8	70	15	6	4.9	4.2	■
M 6	1	80	17	6	4.9	5.0	■
M 7	1	80	17	7	5.5	6.0	
M 8	1.25	90	20	8	6.2	6.8	■
M 9	1.25	90	20	9	7	7.8	
M 10	1.5	100	22	10	8	8.5	■

■ avialable – intermediate size on request

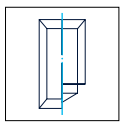
Machine Taps White Ring

Cutting Data

DIN 371 HSS-E
straight flutes
for cast iron

Group 3030
for blind and through holes

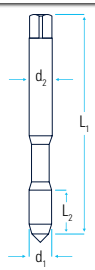
CAST IRON



2xd$_1$

High Speed Cutting by Schumacher

High Speed Cutting by Schumacher



Art.-No.			30300/01	30300/25	30300/2540
Technology	i	Page 8.1	High Volume White Ring	High Volume White Ring	Internal coolant White Ring
Champfer Length	i	Page 8.4		C / 2-3 x P	
Surface	i	Page 8.2	nitrided	TiN	TiN
Tolerance	i	Page 8.5	6HX	6HX	6HX
Cutting Data	i	Page 8.6		K1 grey cast iron N7 duroplastics	

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□				
M 1.7	0.35	40	8	2.5	2.1	1.35			
M 1.8	0.35	40	8	2.5	2.1	1.45			
M 2	0.4	45	8	2.8	2.1	1.6			
M 2.2	0.45	45	8	2.8	2.1	1.75			
M 2.3	0.4	45	8	2.8	2.1	1.9			
M 2.5	0.45	50	9	2.8	2.1	2.05			
M 2.6	0.45	50	9	2.8	2.1	2.15			
M 3	0.5	56	11	3.5	2.7	2.5	■	■	
M 3.5	0.6	56	12	4	3	2.9			
M 4	0.7	63	13	4.5	3.4	3.3	■	■	
M 5	0.8	70	15	6	4.9	4.2	■	■	
M 6	1	80	17	6	4.9	5.0	■	■	■
M 7	1	80	17	7	5.5	6.0			
M 8	1.25	90	20	8	6.2	6.8	■	■	■
M 9	1.25	90	20	9	7	7.8			
M 10	1.5	100	22	10	8	8.5	■	■	■

■ avialable – intermediate size on request

Machine Taps White Ring

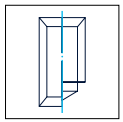
Cutting Data

DIN 376 HSS-E

straight flutes
for cast iron

Group 4030
for blind and through holes

CAST IRON



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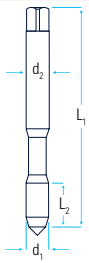


Art.-No.			40300/01	40300/25	40300/2540
Technology	i	Page 8.1	High Volume White Ring	High Volume White Ring	Internal coolant White Ring
Champfer Length	i	Page 8.4		C / 2-3 x P	
Surface	i	Page 8.2	nitrided	TiN	TiN
Tolerance	i	Page 8.5	6HX	6HX	6HX
Cutting Data	i	Page 8.6		K1 grey cast iron N7 duroplastics	

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□				
M 6	1	80	17	4.5	3.4	5.0			
M 7	1	80	17	5.5	4.3	6.0			
M 8	1.25	90	20	6	4.9	6.8			
M 9	1.25	90	20	7	5.5	7.8			
M 10	1.5	100	22	7	5.5	8.5			
M 12	1.75	110	24	9	7	10.2	■	■	■
M 14	2	110	26	11	9	12.0	■		
M 16	2	110	27	12	9	14.0	■	■	■
M 18	2.5	125	30	14	11	15.5	■		
M 20	2.5	140	32	16	12	17.5	■	■	■
M 22	2.5	140	32	18	14.5	19.5	■		
M 24	3	160	34	18	14.5	21.0	■		
M 27	3	160	36	20	16	24.0	■		
M 30	3.5	180	40	22	18	26.5	■		
M 33	3.5	180	40	25	20	29.5			
M 36	4	200	50	28	22	32.0			

■ avialable – intermediate size on request

Machine Taps Red Ring

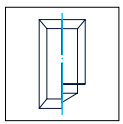
Cutting Data

DIN 371 HSS-E PM

straight flutes
for hard materials

Group 3080
for blind and through holes

HIGH STRENGTH



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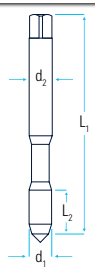


Art.-No.			30800/54
Technology	i	Page 8.1	PM-Line / Hard Steel
Champfer Length	i	Page 8.4	A / 6-8 x P
Surface	i	Page 8.2	TiAlN
Tolerance	i	Page 8.5	ISO2 (6H)
Cutting Data	i	Page 8.6	H1 hard materials

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□		
M 1.7	0.35	40	8	2.5	2.1	1.35	
M 1.8	0.35	40	8	2.5	2.1	1.45	
M 2	0.4	45	8	2.8	2.1	1.6	
M 2.2	0.45	45	8	2.8	2.1	1.75	
M 2.3	0.4	45	8	2.8	2.1	1.9	
M 2.5	0.45	50	9	2.8	2.1	2.05	
M 2.6	0.45	50	9	2.8	2.1	2.15	
M 3	0.5	56	11	3.5	2.7	2.5	
M 3.5	0.6	56	12	4	3	2.9	
M 4	0.7	63	13	4.5	3.4	3.3	
M 5	0.8	70	15	6	4.9	4.2	
M 6	1	80	17	6	4.9	5.0	■
M 7	1	80	17	7	5.5	6.0	
M 8	1.25	90	20	8	6.2	6.8	■
M 9	1.25	90	20	9	7	7.8	
M 10	1.5	100	22	10	8	8.5	■

■ avialable – intermediate size on request

Machine Taps Red Ring

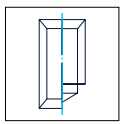
Cutting Data

DIN 376 HSS-E PM

straight flutes
for hard materials

Group 4080
for blind and through holes

HIGH STRENGTH



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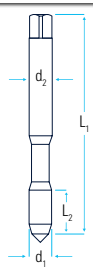


Art.-No.		40800/54
Technology	Page 8.1	PM-Line / Hard Steel
Champfer Length	Page 8.4	A / 6-8 x P
Surface	Page 8.2	TiAlN
Tolerance	Page 8.5	ISO2 (6H)
Cutting Data	Page 8.6	H1 hard materials

Ø d_1	P_{mm}	L_1	L_2	d_2	□		
M 6	1	80	17	4.5	3.4	5.0	
M 7	1	80	17	5.5	4.3	6.0	
M 8	1.25	90	20	6	4.9	6.8	
M 9	1.25	90	20	7	5.5	7.8	
M 10	1.5	100	22	7	5.5	8.5	
M 12	1.75	110	24	9	7	10.2	■
M 14	2	110	26	11	9	12.0	
M 16	2	110	27	12	9	14.0	■
M 18	2.5	125	30	14	11	15.5	
M 20	2.5	140	32	16	12	17.5	■
M 22	2.5	140	32	18	14.5	19.5	
M 24	3	160	34	18	14.5	21.0	
M 27	3	160	36	20	16	24.0	
M 30	3.5	180	40	22	18	26.5	
M 33	3.5	180	40	25	20	29.5	
M 36	4	200	50	28	22	32.0	

■ avialable – intermediate size on request

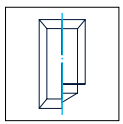
Machine Taps Red Ring - CONDOR

Cutting Data

DIN 371 HSS-E PM
straight flutes
for hard materials

Group 3081
for blind and through holes

HIGH STRENGTH



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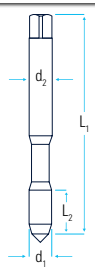


Art.-No.			30810/4064	30810/64
Technology	i	Page 8.1	PM-Line	PM-Line
			Red Ring	Red Ring
Champfer Length	i	Page 8.4	C / 2-3 x P	C / 2-3 x P
Surface	i	Page 8.2	SG 8	SG 8
Tolerance	i	Page 8.5	6HX	6HX
Cutting Data	i	Page 8.6	H1 hard materials	

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□			
M 1.7	0.35	40	8	2.5	2.1	1.35		
M 1.8	0.35	40	8	2.5	2.1	1.45		
M 2	0.4	45	8	2.8	2.1	1.6		
M 2.2	0.45	45	8	2.8	2.1	1.75		
M 2.3	0.4	45	8	2.8	2.1	1.9		
M 2.5	0.45	50	9	2.8	2.1	2.05		
M 2.6	0.45	50	9	2.8	2.1	2.15		
M 3	0.5	56	11	3.5	2.7	2.5		■
M 3.5	0.6	56	12	4	3	2.9		
M 4	0.7	63	13	4.5	3.4	3.3		■
M 5	0.8	70	15	6	4.9	4.2		■
M 6	1	80	17	6	4.9	5.0	■	■
M 7	1	80	17	7	5.5	6.0		
M 8	1.25	90	20	8	6.2	6.8	■	■
M 9	1.25	90	20	9	7	7.8		
M 10	1.5	100	22	10	8	8.5	■	■

■ avialable – intermediate size on request

Machine Taps Red Ring - CONDOR

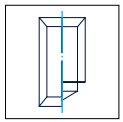
Cutting Data

DIN 376 HSS-E PM

straight flutes
for hard materials

Group 4081
for blind and through holes

HIGH STRENGTH



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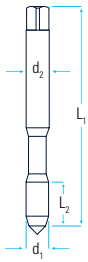


Art.-No.			40810/4064	40810/64
Technology	i	Page 8.1	PM-Line	PM-Line
			Red Ring	Red Ring
Champfer Length	i	Page 8.4	C / 2-3 x P	C / 2-3 x P
Surface	i	Page 8.2	SG 8	SG 8
Tolerance	i	Page 8.5	6HX	6HX
Cutting Data	i	Page 8.6	H1 hard materials	

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□			
M 6	1	80	17	4.5	3.4	5.0		
M 7	1	80	17	5.5	4.3	6.0		
M 8	1.25	90	20	6	4.9	6.8		
M 9	1.25	90	20	7	5.5	7.8		
M 10	1.5	100	22	7	5.5	8.5		
M 12	1.75	110	24	9	7	10.2	■	■
M 14	2	110	26	11	9	12.0		
M 16	2	110	27	12	9	14.0		■
M 18	2.5	125	30	14	11	15.5		
M 20	2.5	140	32	16	12	17.5		■
M 22	2.5	140	32	18	14.5	19.5		
M 24	3	160	34	18	14.5	21.0		
M 27	3	160	36	20	16	24.0		
M 30	3.5	180	40	22	18	26.5		
M 33	3.5	180	40	25	20	29.5		
M 36	4	200	50	28	22	32.0		

■ avialable – intermediate size on request

SCHUMACHER

Machine Taps

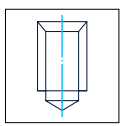
Cutting Data

DIN 371 HSS-E PM

straight flutes
for magnesium alloys

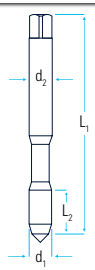
Group 3090
for blind holes

MG



2xd$_1$

Art.-No.			30900/4060
Technology	i	Page 8.1	PM-Line
			Internal coolant
Champfer Length	i	Page 8.4	C / 2-3 x P
Surface	i	Page 8.2	SG 4
Tolerance	i	Page 8.5	ISO2 (6H)
Cutting Data	i	Page 8.6	N8 magnesium alloys



Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□		
M 1.7	0.35	40	8	2.5	2.1	1.35	
M 1.8	0.35	40	8	2.5	2.1	1.45	
M 2	0.4	45	8	2.8	2.1	1.6	
M 2.2	0.45	45	8	2.8	2.1	1.75	
M 2.3	0.4	45	8	2.8	2.1	1.9	
M 2.5	0.45	50	9	2.8	2.1	2.05	
M 2.6	0.45	50	9	2.8	2.1	2.15	
M 3	0.5	56	11	3.5	2.7	2.5	
M 3.5	0.6	56	12	4	3	2.9	
M 4	0.7	63	13	4.5	3.4	3.3	
M 5	0.8	70	15	6	4.9	4.2	
M 6	1	80	17	6	4.9	5.0	■
M 7	1	80	17	7	5.5	6.0	
M 8	1.25	90	20	8	6.2	6.8	■
M 9	1.25	90	20	9	7	7.8	
M 10	1.5	100	22	10	8	8.5	■

■ avialable – intermediate size on request

SCHUMACHER

Machine Taps - MISTRAL

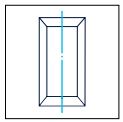
Cutting Data

DIN 371 HSS-E PM

Spiral point
for aluminium and bronze alloys

Group 3100
for through holes

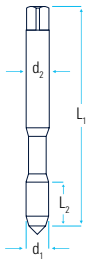
AL



2xd$_1$

DLC
Diamond like Carbon

Innovative surface coating technologies with high hardness and low frictional coeficient



Art.-No.			31000/02	31000/24
Technology	i	Page 8.1	PM-Line	PM-Line
			B / 3,5-5 x P	
Champfer Length	i	Page 8.4		
Surface	i	Page 8.2	CrN	DLC
Tolerance	i	Page 8.5	ISO2 (6H)	ISO2 (6H)
Cutting Data	i	Page 8.6	N1 aluminium alloys	N6 thermoplastics

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□			
M 1.7	0.35	40	8	2.5	2.1	1.35		
M 1.8	0.35	40	8	2.5	2.1	1.45		
M 2	0.4	45	8	2.8	2.1	1.6		
M 2.2	0.45	45	8	2.8	2.1	1.75		
M 2.3	0.4	45	8	2.8	2.1	1.9		
M 2.5	0.45	50	9	2.8	2.1	2.05		
M 2.6	0.45	50	9	2.8	2.1	2.15		
M 3	0.5	56	11	3.5	2.7	2.5	■	■
M 3.5	0.6	56	12	4	3	2.9		
M 4	0.7	63	13	4.5	3.4	3.3	■	■
M 5	0.8	70	15	6	4.9	4.2	■	■
M 6	1	80	17	6	4.9	5.0	■	■
M 7	1	80	17	7	5.5	6.0		
M 8	1.25	90	20	8	6.2	6.8	■	■
M 9	1.25	90	20	9	7	7.8		
M 10	1.5	100	22	10	8	8.5	■	■

■ avialable – intermediate size on request

SCHUMACHER

Machine Taps - MISTRAL

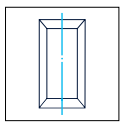
Cutting Data

DIN 376 HSS-E PM

Spiral point
for aluminium and bronze alloys

Group 4100
for through holes

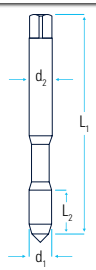
AL



2xd$_1$

DLC
Diamond like Carbon

Innovative surface coating technologies with high hardness and low frictional coeficient



Art.-No.			41000/02	41000/24
Technology	i	Page 8.1	PM-Line	PM-Line
			B / 3,5-5 x P	
Champfer Length	i	Page 8.4		
Surface	i	Page 8.2	CrN	DLC
Tolerance	i	Page 8.5	ISO2 (6H)	ISO2 (6H)
Cutting Data	i	Page 8.6	N1 aluminium alloys	N6 thermoplastics

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□			
M 6	1	80	17	4.5	3.4	5.0		
M 7	1	80	17	5.5	4.3	6.0		
M 8	1.25	90	20	6	4.9	6.8		
M 9	1.25	90	20	7	5.5	7.8		
M 10	1.5	100	22	7	5.5	8.5		
M 12	1.75	110	24	9	7	10.2	■	■
M 14	2	110	26	11	9	12.0		
M 16	2	110	27	12	9	14.0	■	■
M 18	2.5	125	30	14	11	15.5		
M 20	2.5	140	32	16	12	17.5		
M 22	2.5	140	32	18	14.5	19.5		
M 24	3	160	34	18	14.5	21.0		
M 27	3	160	36	20	16	24.0		
M 30	3.5	180	40	22	18	26.5		
M 33	3.5	180	40	25	20	29.5		
M 36	4	200	50	28	22	32.0		

■ avialable – intermediate size on request

Machine Taps

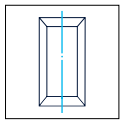
Cutting Data

DIN 371 HSS-E

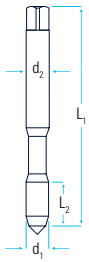
Spiral point
for general construction steel

Group 3110
for through holes

STEEL



2xd$_1$



Art.-No.			31100	31100 B	31100 E
Technology	i	Page 8.1	High Volume		
Champfer Length	i	Page 8.4	B / 3,5-5 x P		
Surface	i	Page 8.2	bright	bright	bright
Tolerance	i	Page 8.5	ISO2 (6H) | ISO1 (4H)	ISO3 (6G)	7G
Cutting Data	i	Page 8.6	P1 general construction steel	K2+K3 spheroidal and malleable cast iron	

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□			
M 1	0.25	40	5.5	2.5	2.1	0.75	■	
M 1.2	0.25	40	5.5	2.5	2.1	0.95	■	
M 1.4	0.3	40	7	2.5	2.1	1.1	■	
M 1.6	0.35	40	8	2.5	2.1	1.25	■	
M 1.7	0.35	40	8	2.5	2.1	1.35	■	
M 1.8	0.35	40	8	2.5	2.1	1.45	■	
M 2	0.4	45	8	2.8	2.1	1.6	■	■
M 2.2	0.45	45	8	2.8	2.1	1.75	■	
M 2.3	0.4	45	8	2.8	2.1	1.9	■	
M 2.5	0.45	50	9	2.8	2.1	2.05	■	■
M 2.6	0.45	50	9	2.8	2.1	2.15	■	

Continuation »

■ avialable – intermediate size on request

Machine Taps

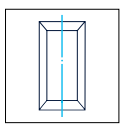
Cutting Data

DIN 371 HSS-E

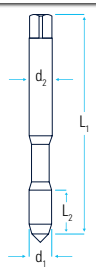
Spiral point
for general construction steel

Group 3110
for through holes

STEEL



2xd$_1$



Art.-No.			31100	31100 B	31100 E
Technology	i	Page 8.1	High Volume		
Champfer Length	i	Page 8.4	B / 3,5-5 x P		
Surface	i	Page 8.2	bright	bright	bright
Tolerance	i	Page 8.5	ISO2 (6H)	ISO3 (6G)	7G
Cutting Data	i	Page 8.6	P1 general construction steel	K2+K3 spheroidal and malleable cast iron	

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□				
M 3	0.5	56	11	3.5	2.7	2.5	■	■	■
M 3.5	0.6	56	12	4	3	2.9	■		
M 4	0.7	63	13	4.5	3.4	3.3	■	■	■
M 5	0.8	70	15	6	4.9	4.2	■	■	■
M 6	1	80	17	6	4.9	5.0	■	■	■
M 7	1	80	17	7	5.5	6.0	■		
M 8	1.25	90	20	8	6.2	6.8	■	■	■
M 9	1.25	90	20	9	7	7.8			
M 10	1.5	100	22	10	8	8.5	■	■	■
M 12	1.75	110	24	12	9	10.2			

■ avialable – intermediate size on request

Machine Taps

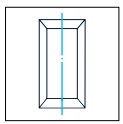
Cutting Data

DIN 376 HSS-E

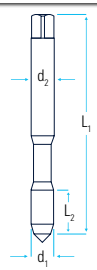
Spiral point
for general construction steel

Group 4110
for through holes

STEEL



2xd$_1$



Art.-No.			41100	41100 B	41105
Technology	i	Page 8.1	High Volume		
					LH
Champfer Length	i	Page 8.4		B / 3,5-5 x P	
Surface	i	Page 8.2	bright	bright	bright
Tolerance	i	Page 8.5	ISO2 (6H)	ISO3 (6G)	ISO2 (6H)
Cutting Data	i	Page 8.6	P1 general construction steel	K2+K3 spheroidal and malleable cast iron	

Ø d_1	P_{mm}	L_1	L_2	d_2	□				
M 6	1	80	17	4.5	3.4	5.0	■		
M 7	1	80	17	5.5	4.3	6.0			
M 8	1.25	90	20	6	4.9	6.8	■		
M 9	1.25	90	20	7	5.5	7.8			
M 10	1.5	100	22	7	5.5	8.5	■		
M 12	1.75	110	24	9	7	10.2	■	■	■
M 14	2	110	26	11	9	12.0	■		
M 16	2	110	27	12	9	14.0	■	■	■
M 18	2.5	125	30	14	11	15.5	■		
M 20	2.5	140	32	16	12	17.5	■	■	■
M 22	2.5	140	32	18	14.5	19.5	■		
M 24	3	160	34	18	14.5	21.0	■	■	
M 27	3	160	36	20	16	24.0	■		
M 30	3.5	180	40	22	18	26.5	■		
M 33	3.5	180	40	25	20	29.5	■		
M 36	4	200	50	28	22	32.0	■		

■ avialable – intermediate size on request

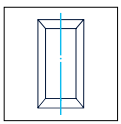
Machine Taps

DIN 371 HSS-E

Spiral point
for general construction steel

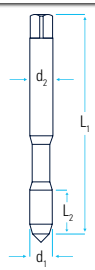
Group 3110
for through holes

STEEL



2xd$_1$

Cutting Data



Art.-No.			31105	31100/25	31100/42
Technology	i	Page 8.1		High Volume	
			LH		2 x L1
Champfer Length	i	Page 8.4		B / 3,5-5 x P	
Surface	i	Page 8.2	bright	TiN	bright
Tolerance	i	Page 8.5	ISO2 (6H)	ISO2 (6H)	ISO2 (6H)
Cutting Data	i	Page 8.6	P1 general construction steel	K2+K3 spheroidal and malleable cast iron	

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□				
M 1.7	0.35	40	8	2.5	2.1	1.35			
M 1.8	0.35	40	8	2.5	2.1	1.45			
M 2	0.4	45	8	2.8	2.1	1.6			
M 2.2	0.45	45	8	2.8	2.1	1.75			
M 2.3	0.4	45	8	2.8	2.1	1.9			
M 2.5	0.45	50	9	2.8	2.1	2.05			
M 2.6	0.45	50	9	2.8	2.1	2.15			
M 3	0.5	56	11	3.5	2.7	2.5	■	■	■
M 3.5	0.6	56	12	4	3	2.9			
M 4	0.7	63	13	4.5	3.4	3.3	■	■	■
M 5	0.8	70	15	6	4.9	4.2	■	■	■
M 6	1	80	17	6	4.9	5.0	■	■	■
M 7	1	80	17	7	5.5	6.0			
M 8	1.25	90	20	8	6.2	6.8	■	■	■
M 9	1.25	90	20	9	7	7.8			
M 10	1.5	100	22	10	8	8.5	■	■	■

■ avialable – intermediate size on request

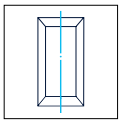
Machine Taps

DIN 376 HSS-E

Spiral point
for general construction steel

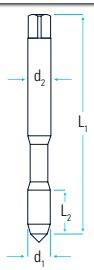
Group 4110
for through holes

STEEL



2xd$_1$

Cutting Data



Art.-No.		41100/25	41100/42
Technology	Page 8.1	High Volume	
Champfer Length	Page 8.4	2 x L1	
Surface	Page 8.2	B / 3,5-5 x P	
Tolerance	Page 8.5	TiN	bright
Cutting Data	Page 8.6	ISO2 (6H)	ISO2 (6H)
		P1 general construction steel	K2+K3 spheroidal and malleable cast iron

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□	ø		
M 6	1	80	17	4.5	3.4	5.0		
M 7	1	80	17	5.5	4.3	6.0		
M 8	1.25	90	20	6	4.9	6.8		
M 9	1.25	90	20	7	5.5	7.8		
M 10	1.5	100	22	7	5.5	8.5		
M 12	1.75	110	24	9	7	10.2	■	■
M 14	2	110	26	11	9	12.0	■	■
M 16	2	110	27	12	9	14.0	■	■
M 18	2.5	125	30	14	11	15.5		
M 20	2.5	140	32	16	12	17.5	■	■
M 22	2.5	140	32	18	14.5	19.5		
M 24	3	160	34	18	14.5	21.0	■	
M 27	3	160	36	20	16	24.0		
M 30	3.5	180	40	22	18	26.5	■	
M 33	3.5	180	40	25	20	29.5		
M 36	4	200	50	28	22	32.0		

■ avialable – intermediate size on request

SCHUMACHER

Machine Taps - NUMERIC

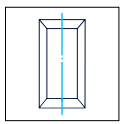
Cutting Data

DIN 371 HSS-E PM

Spiral point
for steel

Group 3113
for through holes

STEEL

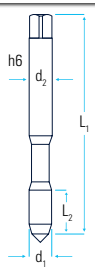


2xd$_1$

High Speed Cutting by Schumacher

NUMERIC
Supporting Digital Production

For use on CNC machines
with synchronized machining



Art.-No.		31130/48
Technology	Page 8.1	**PM-Line**
Champfer Length	Page 8.4	B / 3,5-5 x P
Surface	Page 8.2	TiCN
Tolerance	Page 8.5	6HX
Cutting Data	Page 8.6	P1 general construction steel P2 high strength steel M1 chemical resistant steel

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□		
M 3	0.5	56	5	3.5	2.7	2.5	■
M 4	0.7	63	6	4.5	3.4	3.3	■
M 5	0.8	70	7	6	4.9	4.2	■
M 6	1	80	8	6	4.9	5.0	■
M 7	1	80	8	7	5.5	6.0	
M 8	1.25	90	10	8	6.2	6.8	■
M 9	1.25	90	10	9	7	7.8	
M 10	1.5	100	12	10	8	8.5	■
M 12	1.75	110	14	12	9	10.2	

■ avialable – intermediate size on request

SCHUMACHER

Machine Taps - NUMERIC

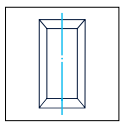
Cutting Data

DIN 376 HSS-E PM

Spiral point
for steel

Group 4113
for through holes

STEEL

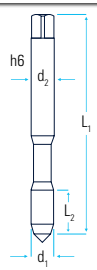


2xd$_1$

High Speed Cutting by Schumacher

NUMERIC
Supporting Digital Production

For use on CNC machines
with synchronized machining



Art.-No.		41130/48
Technology	Page 8.1	**PM-Line**
Champfer Length	Page 8.4	B / 3,5-5 x P
Surface	Page 8.2	TiCN
Tolerance	Page 8.5	6HX
Cutting Data	Page 8.6	P1 general construction steel P2 high strength steel M1 chemical resistant steel

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□		
M 6	1	80	10	4.5	3.4	5.0	
M 7	1	80	10	5.5	4.3	6.0	
M 8	1.25	90	14	6	4.9	6.8	
M 9	1.25	90	14	7	5.5	7.8	
M 10	1.5	100	16	7	5.5	8.5	
M 12	1.75	110	18	9	7	10.2	■
M 14	2	110	20	11	9	12.0	
M 16	2	110	20	12	9	14.0	■
M 18	2.5	125	25	14	11	15.5	
M 20	2.5	140	25	16	12	17.5	■
M 22	2.5	140	25	18	14.5	19.5	
M 24	3	160	30	18	14.5	21.0	
M 27	3	160	30	20	16	24.0	
M 30	3.5	180	35	22	18	26.5	
M 33	3.5	180	35	25	20	29.5	
M 36	4	200	40	28	22	32.0	

■ avialable – intermediate size on request

Machine Taps Blue Ring

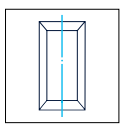
Cutting Data

DIN 371 HSS-E

Spiral point
for chemical resistant steel

Group 3120
for through holes

INOX
Stainless



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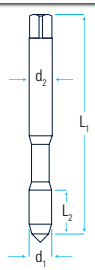


Art.-No.			31200/26	31200/25
Technology	i	Page 8.1	**High Volume** Blue Ring	**High Volume** Blue Ring
Champfer Length	i	Page 8.4	B / 3,5-5 x P	
Surface	i	Page 8.2	VAP	TiN
Tolerance	i	Page 8.5	ISO2 (6H)	ISO2 (6H)
Cutting Data	i	Page 8.6	P2 high strength steel	M1 chemical resistant steel

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□			
M 1.7	0.35	40	8	2.5	2.1	1.35		
M 1.8	0.35	40	8	2.5	2.1	1.45		
M 2	0.4	45	8	2.8	2.1	1.6	■	
M 2.2	0.45	45	8	2.8	2.1	1.75		
M 2.3	0.4	45	8	2.8	2.1	1.9		
M 2.5	0.45	50	9	2.8	2.1	2.05	■	
M 2.6	0.45	50	9	2.8	2.1	2.15		
M 3	0.5	56	11	3.5	2.7	2.5	■	■
M 3.5	0.6	56	12	4	3	2.9		
M 4	0.7	63	13	4.5	3.4	3.3	■	■
M 5	0.8	70	15	6	4.9	4.2	■	■
M 6	1	80	17	6	4.9	5.0	■	■
M 7	1	80	17	7	5.5	6.0		
M 8	1.25	90	20	8	6.2	6.8	■	■
M 9	1.25	90	20	9	7	7.8		
M 10	1.5	100	22	10	8	8.5	■	■

■ avialable – intermediate size on request

Machine Taps Blue Ring

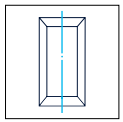
Cutting Data

DIN 376 HSS-E

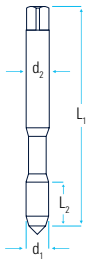
Spiral point
for chemical resistant steel

Group 4120
for through holes

INOX
Stainless



2xd$_1$



Art.-No.		41200/26	41200/25
Technology	Page 8.1	Blue Ring	Blue Ring
Champfer Length	Page 8.4	B / 3,5-5 x P	
Surface	Page 8.2	VAP	TiN
Tolerance	Page 8.5	ISO2 (6H)	ISO2 (6H)
Cutting Data	Page 8.6	P2 high strength steel	M1 chemical resistant steel

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□			
M 6	1	80	17	4.5	3.4	5.0		
M 7	1	80	17	5.5	4.3	6.0		
M 8	1.25	90	20	6	4.9	6.8		
M 9	1.25	90	20	7	5.5	7.8		
M 10	1.5	100	22	7	5.5	8.5		
M 12	1.75	110	24	9	7	10.2	■	■
M 14	2	110	26	11	9	12.0	■	■
M 16	2	110	27	12	9	14.0	■	■
M 18	2.5	125	30	14	11	15.5	■	
M 20	2.5	140	32	16	12	17.5	■	■
M 22	2.5	140	32	18	14.5	19.5	■	
M 24	3	160	34	18	14.5	21.0	■	■
M 27	3	160	36	20	16	24.0	■	
M 30	3.5	180	40	22	18	26.5	■	■
M 33	3.5	180	40	25	20	29.5		
M 36	4	200	50	28	22	32.0		

■ avialable – intermediate size on request

SCHUMACHER

Machine Taps Blue Ring - POLAR

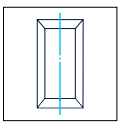
Cutting Data

DIN 371 HSS-E PM

Spiral point
for chemical resistant steel

Group 3121
for through holes

INOX
Stainless



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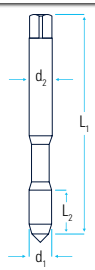


Art.-No.		31210/48
Technology	Page 8.1	PM-Line
		Blue Ring
Champfer Length	Page 8.4	B / 3,5-5 x P
Surface	Page 8.2	TiCN
Tolerance	Page 8.5	6HX
Cutting Data	Page 8.6	P2 high strength steel M1+M2 chemical resistant steel

Ø d_1	P_{mm}	L_1	L_2	d_2	□		
M 1.7	0.35	40	8	2.5	2.1	1.35	
M 1.8	0.35	40	8	2.5	2.1	1.45	
M 2	0.4	45	8	2.8	2.1	1.6	
M 2.2	0.45	45	8	2.8	2.1	1.75	
M 2.3	0.4	45	8	2.8	2.1	1.9	
M 2.5	0.45	50	9	2.8	2.1	2.05	
M 2.6	0.45	50	9	2.8	2.1	2.15	
M 3	0.5	56	11	3.5	2.7	2.5	■
M 3.5	0.6	56	12	4	3	2.9	
M 4	0.7	63	13	4.5	3.4	3.3	■
M 5	0.8	70	15	6	4.9	4.2	■
M 6	1	80	17	6	4.9	5.0	■
M 7	1	80	17	7	5.5	6.0	
M 8	1.25	90	20	8	6.2	6.8	■
M 9	1.25	90	20	9	7	7.8	
M 10	1.5	100	22	10	8	8.5	■

■ avialable – intermediate size on request

Machine Taps Blue Ring - POLAR

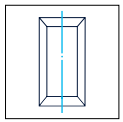
Cutting Data

DIN 376 HSS-E PM

Spiral point
for chemical resistant steel

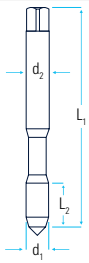
Group 4121
for through holes

INOX
Stainless



2xd$_1$

Art.-No.		41210/48
Technology	Page 8.1	PM-Line
		Blue Ring
Champfer Length	Page 8.4	B / 3,5-5 x P
Surface	Page 8.2	TiCN
Tolerance	Page 8.5	6HX
Cutting Data	Page 8.6	P2 high strength steel M1+M2 chemical resistant steel



Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□		
M 6	1	80	17	4.5	3.4	5.0	
M 7	1	80	17	5.5	4.3	6.0	
M 8	1.25	90	20	6	4.9	6.8	
M 9	1.25	90	20	7	5.5	7.8	
M 10	1.5	100	22	7	5.5	8.5	
M 12	1.75	110	24	9	7	10.2	■
M 14	2	110	26	11	9	12.0	
M 16	2	110	27	12	9	14.0	■
M 18	2.5	125	30	14	11	15.5	
M 20	2.5	140	32	16	12	17.5	■
M 22	2.5	140	32	18	14.5	19.5	
M 24	3	160	34	18	14.5	21.0	
M 27	3	160	36	20	16	24.0	
M 30	3.5	180	40	22	18	26.5	
M 33	3.5	180	40	25	20	29.5	
M 36	4	200	50	28	22	32.0	

■ avialable – intermediate size on request

Machine Taps Red Ring - TYPHOON B

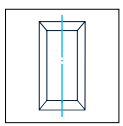
Cutting Data

DIN 371 HSS-E PM

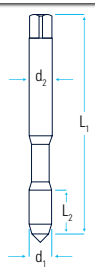
Spiral point
for high strength steel

Group 3130
for through holes

HIGH STRENGTH



2xd$_1$



Art.-No.		31300/48
Technology	Page 8.1	PM-Line
		Red Ring
Champfer Length	Page 8.4	B / 3,5-5 x P
Surface	Page 8.2	TiCN
Tolerance	Page 8.5	ISO2 (6H)
Cutting Data	Page 8.6	P2 high strength steel M1 chemical resistant steel

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□		
M 1.7	0.35	40	8	2.5	2.1	1.35	
M 1.8	0.35	40	8	2.5	2.1	1.45	
M 2	0.4	45	8	2.8	2.1	1.6	
M 2.2	0.45	45	8	2.8	2.1	1.75	
M 2.3	0.4	45	8	2.8	2.1	1.9	
M 2.5	0.45	50	9	2.8	2.1	2.05	
M 2.6	0.45	50	9	2.8	2.1	2.15	
M 3	0.5	56	11	3.5	2.7	2.5	■
M 3.5	0.6	56	12	4	3	2.9	
M 4	0.7	63	13	4.5	3.4	3.3	■
M 5	0.8	70	15	6	4.9	4.2	■
M 6	1	80	17	6	4.9	5.0	■
M 7	1	80	17	7	5.5	6.0	
M 8	1.25	90	20	8	6.2	6.8	■
M 9	1.25	90	20	9	7	7.8	
M 10	1.5	100	22	10	8	8.5	■

■ avialable – intermediate size on request

Machine Taps Red Ring - TYPHOON B

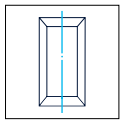
Cutting Data

DIN 376 HSS-E PM

Spiral point
for high strength steel

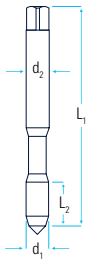
Group 4130
for through holes

HIGH STRENGTH



2xd$_1$

Art.-No.		41300/48
Technology	Page 8.1	PM-Line
		Red Ring
Champfer Length	Page 8.4	B / 3,5-5 x P
Surface	Page 8.2	TiCN
Tolerance	Page 8.5	ISO2 (6H)
Cutting Data	Page 8.6	P2 high strength steel M1 chemical resistant steel



Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□		
M 6	1	80	17	4.5	3.4	5.0	
M 7	1	80	17	5.5	4.3	6.0	
M 8	1.25	90	20	6	4.9	6.8	
M 9	1.25	90	20	7	5.5	7.8	
M 10	1.5	100	22	7	5.5	8.5	
M 12	1.75	110	24	9	7	10.2	■
M 14	2	110	26	11	9	12.0	
M 16	2	110	27	12	9	14.0	■
M 18	2.5	125	30	14	11	15.5	
M 20	2.5	140	32	16	12	17.5	■
M 22	2.5	140	32	18	14.5	19.5	
M 24	3	160	34	18	14.5	21.0	
M 27	3	160	36	20	16	24.0	
M 30	3.5	180	40	22	18	26.5	
M 33	3.5	180	40	25	20	29.5	
M 36	4	200	50	28	22	32.0	

■ avialable – intermediate size on request

Machine Taps Red Ring

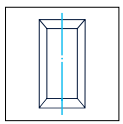
Cutting Data

DIN 371 HSS-E PM

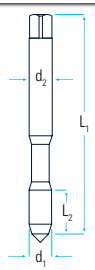
Spiral point
for nickel alloys

Group 3140
for through holes

HIGH STRENGTH



2xd$_1$



Art.-No.		31400
Technology	i Page 8.1	PM-Line
		Red Ring
Champfer Length	i Page 8.4	B / 3,5-5 x P
Surface	i Page 8.2	bright
Tolerance	i Page 8.5	ISO2 (6H)
Cutting Data	i Page 8.6	P2 high strength steel S1 titanium alloys S2 nickel alloys

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□		
M 1.7	0.35	40	8	2.5	2.1	1.35	
M 1.8	0.35	40	8	2.5	2.1	1.45	
M 2	0.4	45	8	2.8	2.1	1.6	
M 2.2	0.45	45	8	2.8	2.1	1.75	
M 2.3	0.4	45	8	2.8	2.1	1.9	
M 2.5	0.45	50	9	2.8	2.1	2.05	
M 2.6	0.45	50	9	2.8	2.1	2.15	
M 3	0.5	56	11	3.5	2.7	2.5	■
M 3.5	0.6	56	12	4	3	2.9	
M 4	0.7	63	13	4.5	3.4	3.3	■
M 5	0.8	70	15	6	4.9	4.2	■
M 6	1	80	17	6	4.9	5.0	■
M 7	1	80	17	7	5.5	6.0	
M 8	1.25	90	20	8	6.2	6.8	■
M 9	1.25	90	20	9	7	7.8	
M 10	1.5	100	22	10	8	8.5	■

■ avialable – intermediate size on request

SCHUMACHER

Machine Taps Red Ring

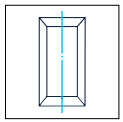
Cutting Data

DIN 376 HSS-E PM

Spiral point
for nickel alloys

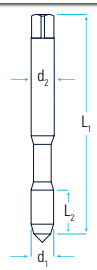
Group 4140
for through holes

HIGH STRENGTH



2xd$_1$

Art.-No.		41400
Technology	i Page 8.1	PM-Line
		Red Ring
Champfer Length	i Page 8.4	B / 3,5-5 x P
Surface	i Page 8.2	bright
Tolerance	i Page 8.5	ISO2 (6H)
Cutting Data	i Page 8.6	P2 high strength steel S1 titanium alloys S2 nickel alloys



Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□		
M 6	1	80	17	4.5	3.4	5.0	
M 7	1	80	17	5.5	4.3	6.0	
M 8	1.25	90	20	6	4.9	6.8	
M 9	1.25	90	20	7	5.5	7.8	
M 10	1.5	100	22	7	5.5	8.5	
M 12	1.75	110	24	9	7	10.2	■
M 14	2	110	26	11	9	12.0	
M 16	2	110	27	12	9	14.0	■
M 18	2.5	125	30	14	11	15.5	
M 20	2.5	140	32	16	12	17.5	■
M 22	2.5	140	32	18	14.5	19.5	
M 24	3	160	34	18	14.5	21.0	
M 27	3	160	36	20	16	24.0	
M 30	3.5	180	40	22	18	26.5	
M 33	3.5	180	40	25	20	29.5	
M 36	4	200	50	28	22	32.0	

■ avialable – intermediate size on request

Machine Taps

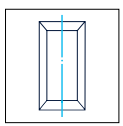
Cutting Data

DIN 371 HSS-E

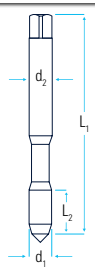
Spiral point and interrupted thread
for general construction steel

Group 3160
for through holes

STEEL



2xd$_1$



Art.-No.			31600
Technology	i	Page 8.1	**High Volume**
			AZ
Champfer Length	i	Page 8.4	B / 3,5-5 x P
Surface	i	Page 8.2	bright
Tolerance	i	Page 8.5	ISO2 (6H)
Cutting Data	i	Page 8.6	P1 general construction steel

Ø d_1	P_{mm}	L_1	L_2	d_2	□		
M 1.7	0.35	40	8	2.5	2.1	1.35	
M 1.8	0.35	40	8	2.5	2.1	1.45	
M 2	0.4	45	8	2.8	2.1	1.6	
M 2.2	0.45	45	8	2.8	2.1	1.75	
M 2.3	0.4	45	8	2.8	2.1	1.9	
M 2.5	0.45	50	9	2.8	2.1	2.05	
M 2.6	0.45	50	9	2.8	2.1	2.15	
M 3	0.5	56	11	3.5	2.7	2.5	■
M 3.5	0.6	56	12	4	3	2.9	■
M 4	0.7	63	13	4.5	3.4	3.3	■
M 5	0.8	70	15	6	4.9	4.2	■
M 6	1	80	17	6	4.9	5.0	■
M 7	1	80	17	7	5.5	6.0	
M 8	1.25	90	20	8	6.2	6.8	■
M 9	1.25	90	20	9	7	7.8	
M 10	1.5	100	22	10	8	8.5	■

■ avialable – intermediate size on request

Machine Taps

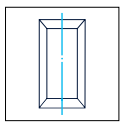
Cutting Data

DIN 376 HSS-E

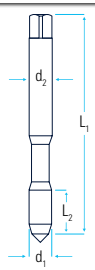
Spiral point and interrupted thread
for general construction steel

Group 4160
for through holes

STEEL



2xd$_1$



Art.-No.	41600
Technology i Page 8.1	High Volume
	AZ
Champfer Length i Page 8.4	B / 3,5-5 x P
Surface i Page 8.2	bright
Tolerance i Page 8.5	ISO2 (6H)
Cutting Data i Page 8.6	P1 general construction steel

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□		
M 6	1	80	17	4.5	3.4	5.0	
M 7	1	80	17	5.5	4.3	6.0	
M 8	1.25	90	20	6	4.9	6.8	
M 9	1.25	90	20	7	5.5	7.8	
M 10	1.5	100	22	7	5.5	8.5	
M 12	1.75	110	24	9	7	10.2	■
M 14	2	110	26	11	9	12.0	■
M 16	2	110	27	12	9	14.0	■
M 18	2.5	125	30	14	11	15.5	
M 20	2.5	140	32	16	12	17.5	■
M 22	2.5	140	32	18	14.5	19.5	
M 24	3	160	34	18	14.5	21.0	■
M 27	3	160	36	20	16	24.0	
M 30	3.5	180	40	22	18	26.5	
M 33	3.5	180	40	25	20	29.5	
M 36	4	200	50	28	22	32.0	

■ avialable – intermediate size on request

Machine Taps Red Ring

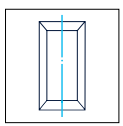
Cutting Data

DIN 371 HSS-E

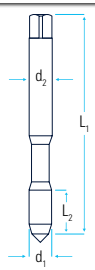
Spiral point
for high strength steel

Group 3170
for through holes

HIGH STRENGTH



2xd$_1$



Art.-No.			31700	31700/48
Technology	i	Page 8.1	**High Volume**	**High Volume**
			Red Ring	Red Ring
Champfer Length	i	Page 8.4	B / 3,5-5 x P	
Surface	i	Page 8.2	bright	TiCN
Tolerance	i	Page 8.5	ISO2 (6H)	ISO2 (6H)
Cutting Data	i	Page 8.6	P2 high strength steel	

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□			
M 1.7	0.35	40	8	2.5	2.1	1.35		
M 1.8	0.35	40	8	2.5	2.1	1.45		
M 2	0.4	45	8	2.8	2.1	1.6		
M 2.2	0.45	45	8	2.8	2.1	1.75		
M 2.3	0.4	45	8	2.8	2.1	1.9		
M 2.5	0.45	50	9	2.8	2.1	2.05		
M 2.6	0.45	50	9	2.8	2.1	2.15		
M 3	0.5	56	11	3.5	2.7	2.5	■	■
M 3.5	0.6	56	12	4	3	2.9		
M 4	0.7	63	13	4.5	3.4	3.3	■	■
M 5	0.8	70	15	6	4.9	4.2	■	■
M 6	1	80	17	6	4.9	5.0	■	■
M 7	1	80	17	7	5.5	6.0		
M 8	1.25	90	20	8	6.2	6.8	■	■
M 9	1.25	90	20	9	7	7.8		
M 10	1.5	100	22	10	8	8.5	■	■

■ avialable – intermediate size on request

Machine Taps Red Ring

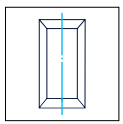
Cutting Data

DIN 376 HSS-E

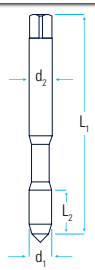
Spiral point
for high strength steel

Group 4170
for through holes

HIGH STRENGTH



2xd$_1$



Art.-No.			41700	41700/48
Technology	i	Page 8.1	High Volume	High Volume
			Red Ring	Red Ring
Champfer Length	i	Page 8.4	B / 3,5-5 x P	
Surface	i	Page 8.2	bright	TiCN
Tolerance	i	Page 8.5	ISO2 (6H)	ISO2 (6H)
Cutting Data	i	Page 8.6	P2 high strength steel	

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□			
M 6	1	80	17	4.5	3.4	5.0		
M 7	1	80	17	5.5	4.3	6.0		
M 8	1.25	90	20	6	4.9	6.8		
M 9	1.25	90	20	7	5.5	7.8		
M 10	1.5	100	22	7	5.5	8.5		
M 12	1.75	110	24	9	7	10.2	■	■
M 14	2	110	26	11	9	12.0	■	■
M 16	2	110	27	12	9	14.0	■	■
M 18	2.5	125	30	14	11	15.5		
M 20	2.5	140	32	16	12	17.5	■	■
M 22	2.5	140	32	18	14.5	19.5		
M 24	3	160	34	18	14.5	21.0	■	■
M 27	3	160	36	20	16	24.0		
M 30	3.5	180	40	22	18	26.5	■	■
M 33	3.5	180	40	25	20	29.5		
M 36	4	200	50	28	22	32.0		

■ avialable – intermediate size on request

SCHUMACHER

Machine Taps Yellow Ring

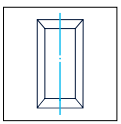
Cutting Data

DIN 371 HSS-E PM

Spiral point
for titanium alloys

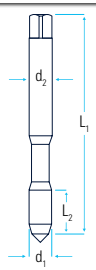
Group 3180
for through holes

TI



2xd$_1$

Art.-No.			31800
Technology	i	Page 8.1	PM-Line
			Yellow Ring
Champfer Length	i	Page 8.4	B / 3,5-5 x P
Surface	i	Page 8.2	bright
Tolerance	i	Page 8.5	ISO2 (6H)
Cutting Data	i	Page 8.6	P2 high strength steel S1 titanium alloys



Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□		
M 1.7	0.35	40	8	2.5	2.1	1.35	
M 1.8	0.35	40	8	2.5	2.1	1.45	
M 2	0.4	45	8	2.8	2.1	1.6	
M 2.2	0.45	45	8	2.8	2.1	1.75	
M 2.3	0.4	45	8	2.8	2.1	1.9	
M 2.5	0.45	50	9	2.8	2.1	2.05	
M 2.6	0.45	50	9	2.8	2.1	2.15	
M 3	0.5	56	11	3.5	2.7	2.5	
M 3.5	0.6	56	12	4	3	2.9	
M 4	0.7	63	13	4.5	3.4	3.3	■
M 5	0.8	70	15	6	4.9	4.2	■
M 6	1	80	17	6	4.9	5.0	■
M 7	1	80	17	7	5.5	6.0	
M 8	1.25	90	20	8	6.2	6.8	■
M 9	1.25	90	20	9	7	7.8	
M 10	1.5	100	22	10	8	8.5	■

■ avialable – intermediate size on request

Machine Taps Yellow Ring

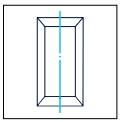
Cutting Data

DIN 376 HSS-E PM

Spiral point
for titanium alloys

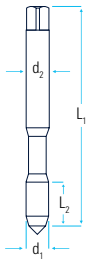
Group 4180
for through holes

TI



2xd$_1$

Art.-No.			41800
Technology	i	Page 8.1	**PM-Line**
			Yellow Ring
Champfer Length	i	Page 8.4	B / 3,5-5 x P
Surface	i	Page 8.2	bright
Tolerance	i	Page 8.5	ISO2 (6H)
Cutting Data	i	Page 8.6	P2 high strength steel S1 titanium alloys



Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□		
M 6	1	80	17	4.5	3.4	5.0	
M 7	1	80	17	5.5	4.3	6.0	
M 8	1.25	90	20	6	4.9	6.8	
M 9	1.25	90	20	7	5.5	7.8	
M 10	1.5	100	22	7	5.5	8.5	
M 12	1.75	110	24	9	7	10.2	■
M 14	2	110	26	11	9	12.0	
M 16	2	110	27	12	9	14.0	■
M 18	2.5	125	30	14	11	15.5	
M 20	2.5	140	32	16	12	17.5	■
M 22	2.5	140	32	18	14.5	19.5	
M 24	3	160	34	18	14.5	21.0	
M 27	3	160	36	20	16	24.0	
M 30	3.5	180	40	22	18	26.5	
M 33	3.5	180	40	25	20	29.5	
M 36	4	200	50	28	22	32.0	

■ avialable – intermediate size on request

Machine Taps Black Ring

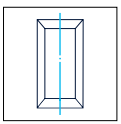
Cutting Data

DIN 371 HSS-E

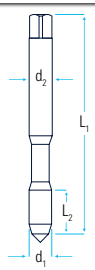
Spiral point
for universal use

Group 3190
for through holes

UNI



2xd$_1$



Art.-No.			31900/26	41900/25
Technology	i	Page 8.1	**High Volume**	**High Volume**
			Black Ring	Black Ring
Champfer Length	i	Page 8.4	B / 3,5-5 x P	B / 3,5-5 x P
Surface	i	Page 8.2	VAP	TiN
Tolerance	i	Page 8.5	ISO2 (6H) | ISO1 (4H)	ISO2 (6H)
Cutting Data	i	Page 8.6	P1 general construction steel	M1 chemical resistant steel N1 aluminium alloys N3 copper alloys

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□		
M 1	0.25	40	5.5	2.5	2.1	0.75	■
M 1.2	0.25	40	5.5	2.5	2.1	0.95	■
M 1.4	0.3	40	7	2.5	2.1	1.1	■
M 1.6	0.35	40	8	2.5	2.1	1.25	■
M 1.7	0.35	40	8	2.5	2.1	1.35	■
M 1.8	0.35	40	8	2.5	2.1	1.45	■
M 2	0.4	45	8	2.8	2.1	1.6	■
M 2.2	0.45	45	8	2.8	2.1	1.75	■
M 2.3	0.4	45	8	2.8	2.1	1.9	■
M 2.5	0.45	50	9	2.8	2.1	2.05	■
M 2.6	0.45	50	9	2.8	2.1	2.15	■

Continuation »

■ avialable – intermediate size on request

Machine Taps Black Ring

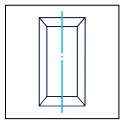
Cutting Data

DIN 371 HSS-E

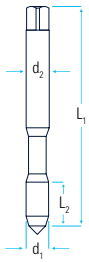
Spiral point
for universal use

Group 3190
for through holes

UNI



2xd$_1$



Art.-No.			31900/26	41900/25		
Technology	i	Page 8.1	**High Volume**	**High Volume**		
			Black Ring	Black Ring		
Champfer Length	i	Page 8.4	B / 3,5-5 x P	B / 3,5-5 x P		
Surface	i	Page 8.2	VAP	TiN		
Tolerance	i	Page 8.5	ISO2 (6H)	ISO2 (6H)		
Cutting Data	i	Page 8.6	P1 general construction steel	M1 chemical resistant steel	N1 aluminium alloys	N3 copper alloys

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□			
M 3	0.5	56	11	3.5	2.7	2.5	■	■
M 3.5	0.6	56	12	4	3	2.9		
M 4	0.7	63	13	4.5	3.4	3.3	■	■
M 5	0.8	70	15	6	4.9	4.2	■	■
M 6	1	80	17	6	4.9	5.0	■	■
M 7	1	80	17	7	5.5	6.0		
M 8	1.25	90	20	8	6.2	6.8	■	■
M 9	1.25	90	20	9	7	7.8		
M 10	1.5	100	22	10	8	8.5	■	■
M 12	1.75	110	24	12	9	10.2		

■ avialable – intermediate size on request

Machine Taps Black Ring

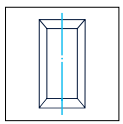
Cutting Data

DIN 376 HSS-E

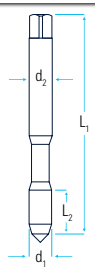
Spiral point
for universal use

Group 4190
for through holes

UNI



2xd$_1$



Art.-No.			41900/26	41900/25		
Technology	i	Page 8.1	**High Volume**	**High Volume**		
			Black Ring	Black Ring		
Champfer Length	i	Page 8.4	B / 3,5-5 x P	B / 3,5-5 x P		
Surface	i	Page 8.2	VAP	TiN		
Tolerance	i	Page 8.5	ISO2 (6H)	ISO2 (6H)		
Cutting Data	i	Page 8.6	P1 general construction steel	M1 chemical resistant steel	N1 aluminium alloys	N3 copper alloys

Ø d_1	P_{mm}	L_1	L_2	d_2	□			
M 6	1	80	17	4.5	3.4	5.0		
M 7	1	80	17	5.5	4.3	6.0		
M 8	1.25	90	20	6	4.9	6.8		
M 9	1.25	90	20	7	5.5	7.8		
M 10	1.5	100	22	7	5.5	8.5		
M 12	1.75	110	24	9	7	10.2	■	■
M 14	2	110	26	11	9	12.0		
M 16	2	110	27	12	9	14.0	■	■
M 18	2.5	125	30	14	11	15.5		
M 20	2.5	140	32	16	12	17.5	■	■
M 22	2.5	140	32	18	14.5	19.5	■	
M 24	3	160	34	18	14.5	21.0	■	
M 27	3	160	36	20	16	24.0	■	
M 30	3.5	180	40	22	18	26.5	■	
M 33	3.5	180	40	25	20	29.5		
M 36	4	200	50	28	22	32.0		

■ avialable – intermediate size on request

Machine Taps Black Ring

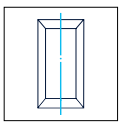
Cutting Data

DIN 371 HSS-E-PM

Spiral point
for universal use

Group 3190
for through holes

UNI



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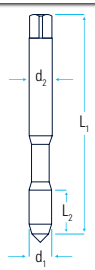


Art.-No.		31900/5760
Technology	i Page 8.1	PM-Line
		Black Ring
Champfer Length	i Page 8.4	B / 3,5-5 x P
Surface	i Page 8.2	SG 4
Tolerance	i Page 8.5	ISO2 (6H)
Cutting Data	i Page 8.6	P1 general construction steel M1 chemical resistant steel N1 Aluminium N3 copper alloys

Ø d_1	P_{mm}	L_1	L_2	d_2	□		
M 1.7	0.35	40	8	2.5	2.1	1.35	
M 1.8	0.35	40	8	2.5	2.1	1.45	
M 2	0.4	45	8	2.8	2.1	1.6	
M 2.2	0.45	45	8	2.8	2.1	1.75	
M 2.3	0.4	45	8	2.8	2.1	1.9	
M 2.5	0.45	50	9	2.8	2.1	2.05	
M 2.6	0.45	50	9	2.8	2.1	2.15	
M 3	0.5	56	11	3.5	2.7	2.5	■
M 3.5	0.6	56	12	4	3	2.9	
M 4	0.7	63	13	4.5	3.4	3.3	■
M 5	0.8	70	15	6	4.9	4.2	■
M 6	1	80	17	6	4.9	5.0	■
M 7	1	80	17	7	5.5	6.0	
M 8	1.25	90	20	8	6.2	6.8	■
M 9	1.25	90	20	9	7	7.8	
M 10	1.5	100	22	10	8	8.5	■

■ avialable – intermediate size on request

Machine Taps Black Ring

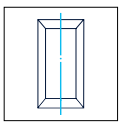
Cutting Data

DIN 376 HSS-E-PM

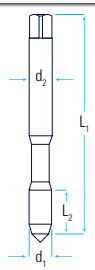
Spiral point
for universal use

Group 4190
for through holes

UNI



2xd$_1$



Art.-No.		41900/5760
Technology	i Page 8.1	PM-Line
		Black Ring
Champfer Length	i Page 8.4	B / 3,5-5 x P
Surface	i Page 8.2	SG 4
Tolerance	i Page 8.5	ISO2 (6H)
Cutting Data	i Page 8.6	P1 general construction steel M1 chemical resistant steel N1 Aluminium N3 copper alloys

Ø d_1	P_{mm}	L_1	L_2	d_2	□		
M 6	1	80	17	4.5	3.4	5.0	
M 7	1	80	17	5.5	4.3	6.0	
M 8	1.25	90	20	6	4.9	6.8	
M 9	1.25	90	20	7	5.5	7.8	
M 10	1.5	100	22	7	5.5	8.5	
M 12	1.75	110	24	9	7	10.2	■
M 14	2	110	26	11	9	12.0	
M 16	2	110	27	12	9	14.0	■
M 18	2.5	125	30	14	11	15.5	
M 20	2.5	140	32	16	12	17.5	■
M 22	2.5	140	32	18	14.5	19.5	
M 24	3	160	34	18	14.5	21.0	
M 27	3	160	36	20	16	24.0	
M 30	3.5	180	40	22	18	26.5	
M 33	3.5	180	40	25	20	29.5	
M 36	4	200	50	28	22	32.0	

■ avialable – intermediate size on request

Machine Taps

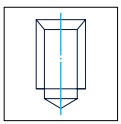
Cutting Data

DIN 371 HSS-E

RH spiral flutes 15°
for general construction steel

Group 3200
for blind holes

STEEL



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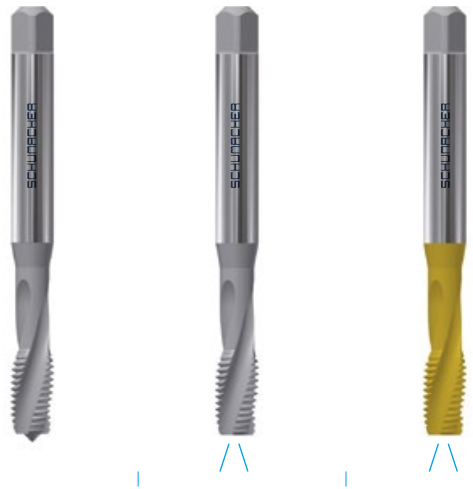
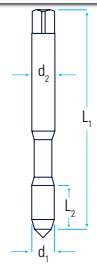




Art.-No.			32000	32000/40	32000/2540
Technology	i	Page 8.1	High Volume		
				Internal coolant	Internal coolant
Champfer Length	i	Page 8.4		C / 2-3 x P	
Surface	i	Page 8.2	bright	bright	TiN
Tolerance	i	Page 8.5	ISO2 (6H)	ISO2 (6H)	ISO2 (6H)
Cutting Data	i	Page 8.6	P1 general construction steel	K2+K3 spheroidal and malleable cast iron	

Ø d_1	P_{mm}	L_1	L_2	d_2	□				
M 1.7	0.35	40	8	2.5	2.1	1.35			
M 1.8	0.35	40	8	2.5	2.1	1.45			
M 2	0.4	45	8	2.8	2.1	1.6			
M 2.2	0.45	45	8	2.8	2.1	1.75			
M 2.3	0.4	45	8	2.8	2.1	1.9			
M 2.5	0.45	50	9	2.8	2.1	2.05			
M 2.6	0.45	50	9	2.8	2.1	2.15			
M 3	0.5	56	6	3.5	2.7	2.5	■		
M 3.5	0.6	56	7	4	3	2.9			
M 4	0.7	63	7	4.5	3.4	3.3	■		
M 5	0.8	70	8	6	4.9	4.2	■		
M 6	1	80	10	6	4.9	5.0	■	■	■
M 7	1	80	10	7	5.5	6.0			
M 8	1.25	90	13	8	6.2	6.8	■	■	■
M 9	1.25	90	13	9	7	7.8			
M 10	1.5	100	15	10	8	8.5	■	■	■

■ avialable – intermediate size on request

Machine Taps

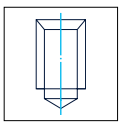
Cutting Data

DIN 376 HSS-E

RH spiral flutes 15°
for general construction steel

Group 4200
for blind holes

STEEL



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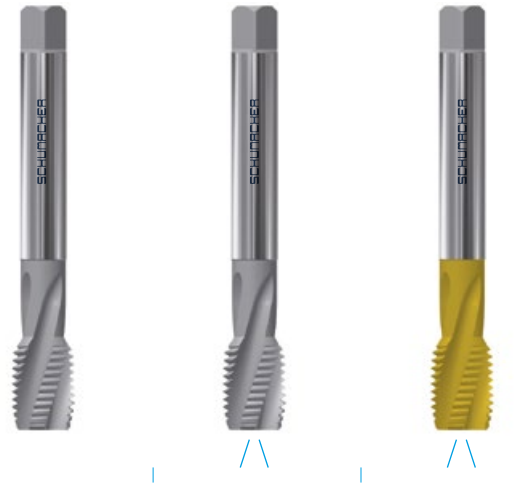
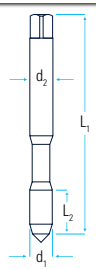




Art.-No.			42000	42000/40	42000/2540
Technology	i	Page 8.1	High Volume		
				Internal coolant	Internal coolant
Champfer Length	i	Page 8.4		C / 2-3 x P	
Surface	i	Page 8.2	bright	bright	TiN
Tolerance	i	Page 8.5	ISO2 (6H)	ISO2 (6H)	ISO2 (6H)
Cutting Data	i	Page 8.6	P1 general construction steel	K2+K3 spheroidal and malleable cast iron	

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□				
M 6	1	80	10	4.5	3.4	5.0			
M 7	1	80	10	5.5	4.3	6.0			
M 8	1.25	90	14	6	4.9	6.8			
M 9	1.25	90	14	7	5.5	7.8			
M 10	1.5	100	16	7	5.5	8.5			
M 12	1.75	110	18	9	7	10.2	■	■	■
M 14	2	110	20	11	9	12.0	■	■	■
M 16	2	110	20	12	9	14.0	■	■	■
M 18	2.5	125	25	14	11	15.5			
M 20	2.5	140	25	16	12	17.5	■	■	■
M 22	2.5	140	25	18	14.5	19.5			
M 24	3	160	30	18	14.5	21.0	■		
M 27	3	160	30	20	16	24.0			
M 30	3.5	180	35	22	18	26.5	■		
M 33	3.5	180	35	25	20	29.5			
M 36	4	200	40	28	22	32.0	■		

■ avialable – intermediate size on request

Machine Taps Red Ring

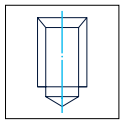
Cutting Data

DIN 371 HSS-E

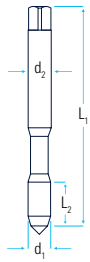
RH spiral flutes 20°
for high strength steel

Group 3240
for blind holes

HIGH STRENGTH



2xd$_1$



Art.-No.			32400	32400/48
Technology	i	Page 8.1	Red Ring	Red Ring
Champfer Length	i	Page 8.4	3-4 x P	
Surface	i	Page 8.2	bright	TiCN
Tolerance	i	Page 8.5	ISO2 (6H)	ISO2 (6H)
Cutting Data	i	Page 8.6	P2 high strength steel	

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□			
M 1.7	0.35	40	8	2.5	2.1	1.35		
M 1.8	0.35	40	8	2.5	2.1	1.45		
M 2	0.4	45	8	2.8	2.1	1.6		
M 2.2	0.45	45	8	2.8	2.1	1.75		
M 2.3	0.4	45	8	2.8	2.1	1.9		
M 2.5	0.45	50	9	2.8	2.1	2.05		
M 2.6	0.45	50	9	2.8	2.1	2.15		
M 3	0.5	56	6	3.5	2.7	2.5	■	■
M 3.5	0.6	56	7	4	3	2.9		
M 4	0.7	63	7	4.5	3.4	3.3	■	■
M 5	0.8	70	8	6	4.9	4.2	■	■
M 6	1	80	10	6	4.9	5.0	■	■
M 7	1	80	10	7	5.5	6.0		
M 8	1.25	90	13	8	6.2	6.8	■	■
M 9	1.25	90	13	9	7	7.8		
M 10	1.5	100	15	10	8	8.5	■	■

■ avialable – intermediate size on request

Machine Taps Red Ring

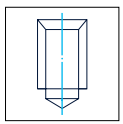
Cutting Data

DIN 376 HSS-E

RH spiral flutes 20°
for high strength steel

Group 4240
for blind holes

HIGH STRENGTH



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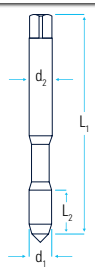


Art.-No.			42400	42400/48
Technology	i	Page 8.1	Red Ring	Red Ring
Champfer Length	i	Page 8.4	3-4 x P	
Surface	i	Page 8.2	bright	TiCN
Tolerance	i	Page 8.5	ISO2 (6H)	ISO2 (6H)
Cutting Data	i	Page 8.6	P2 high strength steel	

Ø d_1	P_{mm}	L_1	L_2	d_2	□			
M 6	1	80	10	4.5	3.4	5.0		
M 7	1	80	10	5.5	4.3	6.0		
M 8	1.25	90	14	6	4.9	6.8		
M 9	1.25	90	14	7	5.5	7.8		
M 10	1.5	100	16	7	5.5	8.5		
M 12	1.75	110	18	9	7	10.2	■	■
M 14	2	110	20	11	9	12.0	■	■
M 16	2	110	20	12	9	14.0	■	■
M 18	2.5	125	25	14	11	15.5		
M 20	2.5	140	25	16	12	17.5	■	■
M 22	2.5	140	25	18	14.5	19.5		
M 24	3	160	30	18	14.5	21.0	■	■
M 27	3	160	30	20	16	24.0		
M 30	3.5	180	35	22	18	26.5	■	■
M 33	3.5	180	35	25	20	29.5		
M 36	4	200	40	28	22	32.0		

■ avialable – intermediate size on request

Machine Taps Red Ring

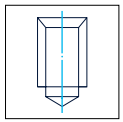
Cutting Data

internal standard HSS-E

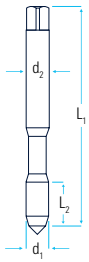
RH spiral flutes 20°
for high strength steel

Group 4241
for deep blind holes ≤ 3xd1

HIGH STRENGTH



3xd$_1$



Art.-No.			42410/4048
Technology	i	Page 8.1	Red Ring, Internal coolant
Champfer Length	i	Page 8.4	C / 2-3 x P
Surface	i	Page 8.2	TiCN
Tolerance	i	Page 8.5	6HX
Cutting Data	i	Page 8.6	P2+P3 high strength steel

Ø d_1	P_{mm}	L_1	L_2	d_2	□		
M 20	2.5	140	25	16	12	17.5	■
M 22	2.5	140	25	18	14.5	19.5	■
M 24	3	160	30	18	14.5	21.0	■
M 27	3	160	30	20	16	24.0	■
M 30	3.5	180	35	22	18	26.5	■
M 33	3.5	180	35	25	20	29.5	■
M 36	4	220	40	28	22	32.0	■
M 39	4	240	40	32	24	35	■
M42	4.5	240	45	32	24	37.5	■
M45	4.5	270	45	36	29	40.5	■
M48	5	270	50	36	29	43	■

■ avialable – intermediate size on request

Machine Taps Red Ring

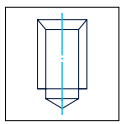
Cutting Data

DIN 371 HSS-E PM

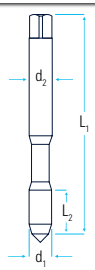
RH spiral flutes 20°
for nickel alloys

Group 3260
for blind holes

HIGH STRENGTH



2xd$_1$



Art.-No.		32600
Technology	Page 8.1	PM-Line
		Red Ring
Champfer Length	Page 8.4	3-4 x P
Surface	Page 8.2	bright
Tolerance	Page 8.5	ISO2 (6H)
Cutting Data	Page 8.6	P2 high strength steel S1 titanium alloys S2 nickel alloys

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□		
M 1.7	0.35	40	8	2.5	2.1	1.35	
M 1.8	0.35	40	8	2.5	2.1	1.45	
M 2	0.4	45	8	2.8	2.1	1.6	
M 2.2	0.45	45	8	2.8	2.1	1.75	
M 2.3	0.4	45	8	2.8	2.1	1.9	
M 2.5	0.45	50	9	2.8	2.1	2.05	
M 2.6	0.45	50	9	2.8	2.1	2.15	
M 3	0.5	56	11	3.5	2.7	2.5	
M 3.5	0.6	56	12	4	3	2.9	
M 4	0.7	63	13	4.5	3.4	3.3	■
M 5	0.8	70	15	6	4.9	4.2	■
M 6	1	80	17	6	4.9	5.0	■
M 7	1	80	17	7	5.5	6.0	
M 8	1.25	90	20	8	6.2	6.8	■
M 9	1.25	90	20	9	7	7.8	
M 10	1.5	100	22	10	8	8.5	■

■ avialable – intermediate size on request

SCHUMACHER

Machine Taps Red Ring

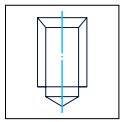
Cutting Data

DIN 376 HSS-E PM

RH spiral flutes 20°
for nickel alloys

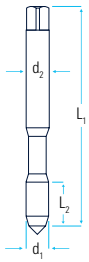
Group 4260
for blind holes

HIGH STRENGTH



2xd$_1$

Art.-No.		42600
Technology	Page 8.1	PM-Line
		Red Ring
Champfer Length	Page 8.4	3-4 x P
Surface	Page 8.2	bright
Tolerance	Page 8.5	ISO2 (6H)
Cutting Data	Page 8.6	P2 high strength steel S1 titanium alloys S2 nickel alloys



Ø d_1	P_{mm}	L_1	L_2	d_2	□		
M 6	1	80	17	4.5	3.4	5.0	
M 7	1	80	17	5.5	4.3	6.0	
M 8	1.25	90	20	6	4.9	6.8	
M 9	1.25	90	20	7	5.5	7.8	
M 10	1.5	100	22	7	5.5	8.5	
M 12	1.75	110	24	9	7	10.2	■
M 14	2	110	26	11	9	12.0	
M 16	2	110	27	12	9	14.0	■
M 18	2.5	125	30	14	11	15.5	
M 20	2.5	140	32	16	12	17.5	■
M 22	2.5	140	32	18	14.5	19.5	
M 24	3	160	34	18	14.5	21.0	
M 27	3	160	36	20	16	24.0	
M 30	3.5	180	40	22	18	26.5	
M 33	3.5	180	40	25	20	29.5	
M 36	4	200	50	28	22	32.0	

■ avialable – intermediate size on request

Machine Taps Yellow Ring

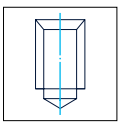
Cutting Data

DIN 371 HSS-E PM

RH spiral flutes 20°
for titanium alloys

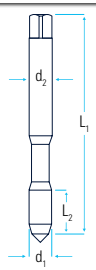
Group 3280
for blind holes

TI



2xd$_1$

Art.-No.			32800
Technology	i	Page 8.1	PM-Line
			Yellow Ring
Champfer Length	i	Page 8.4	3-4 x P
Surface	i	Page 8.2	bright
Tolerance	i	Page 8.5	ISO2 (6H)
Cutting Data	i	Page 8.6	P2 high strength steel S1 titanium alloys



Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□	⌀	
M 1.7	0.35	40	8	2.5	2.1	1.35	
M 1.8	0.35	40	8	2.5	2.1	1.45	
M 2	0.4	45	8	2.8	2.1	1.6	
M 2.2	0.45	45	8	2.8	2.1	1.75	
M 2.3	0.4	45	8	2.8	2.1	1.9	
M 2.5	0.45	50	9	2.8	2.1	2.05	
M 2.6	0.45	50	9	2.8	2.1	2.15	
M 3	0.5	56	11	3.5	2.7	2.5	
M 3.5	0.6	56	12	4	3	2.9	
M 4	0.7	63	13	4.5	3.4	3.3	■
M 5	0.8	70	15	6	4.9	4.2	■
M 6	1	80	17	6	4.9	5.0	■
M 7	1	80	17	7	5.5	6.0	
M 8	1.25	90	20	8	6.2	6.8	■
M 9	1.25	90	20	9	7	7.8	
M 10	1.5	100	22	10	8	8.5	■

■ avialable – intermediate size on request

Machine Taps Yellow Ring

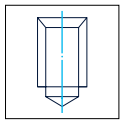
Cutting Data

DIN 376 HSS-E PM

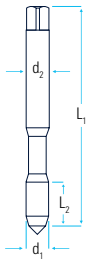
RH spiral flutes 20°
for titanium alloys

Group 4280
for blind holes

TI



2xd$_1$



Art.-No.		42800
Technology	Page 8.1	PM-Line Yellow Ring
Champfer Length	Page 8.4	3-4 x P
Surface	Page 8.2	bright
Tolerance	Page 8.5	ISO2 (6H)
Cutting Data	Page 8.6	P2 high strength steel S1 titanium alloys

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□		
M 6	1	80	17	4.5	3.4	5.0	
M 7	1	80	17	5.5	4.3	6.0	
M 8	1.25	90	20	6	4.9	6.8	
M 9	1.25	90	20	7	5.5	7.8	
M 10	1.5	100	22	7	5.5	8.5	
M 12	1.75	110	24	9	7	10.2	■
M 14	2	110	26	11	9	12.0	
M 16	2	110	27	12	9	14.0	■
M 18	2.5	125	30	14	11	15.5	
M 20	2.5	140	32	16	12	17.5	■
M 22	2.5	140	32	18	14.5	19.5	
M 24	3	160	34	18	14.5	21.0	
M 27	3	160	36	20	16	24.0	
M 30	3.5	180	40	22	18	26.5	
M 33	3.5	180	40	25	20	29.5	
M 36	4	200	50	28	22	32.0	

■ avialable – intermediate size on request

Machine Taps

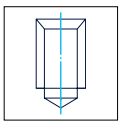
Cutting Data

DIN 371 HSS-E

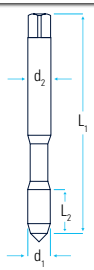
RH spiral flutes 40°
for general construction steel

Group 3300
for blind holes

STEEL



2xd$_1$



Art.-No.			33000	33000 B	33000 E
Technology	i	Page 8.1	High Volume		
Champfer Length	i	Page 8.4	C / 2-3 x P		
Surface	i	Page 8.2	bright	bright	bright
Tolerance	i	Page 8.5	ISO2 (6H) | ISO1 (4H)	ISO3 (6G)	7G
Cutting Data	i	Page 8.6	P1 general construction steel	K2+K3 spheroidal and malleable cast iron	

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□				
M 1	0.25	40	5.5	2.5	2.1	0.75	■		
M 1.2	0.25	40	5.5	2.5	2.1	0.95	■		
M 1.4	0.3	40	7	2.5	2.1	1.1	■		
M 1.6	0.35	40	8	2.5	2.1	1.25	■		
M 1.7	0.35	40	8	2.5	2.1	1.35	■		
M 1.8	0.35	40	8	2.5	2.1	1.45	■		
M 2	0.4	45	8	2.8	2.1	1.6	■	■	
M 2.2	0.45	45	8	2.8	2.1	1.75	■		
M 2.3	0.4	45	8	2.8	2.1	1.9	■		
M 2.5	0.45	50	9	2.8	2.1	2.05	■	■	
M 2.6	0.45	50	9	2.8	2.1	2.15	■		

Continuation »

■ avialable – intermediate size on request

Machine Taps

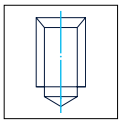
Cutting Data

DIN 371 HSS-E

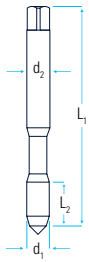
RH spiral flutes 40°
for general construction steel

Group 3300
for blind holes

STEEL



2xd$_1$



Art.-No.			33000	33000 B	33000 E
Technology	i	Page 8.1	High Volume		
Champfer Length	i	Page 8.4	C / 2-3 x P		
Surface	i	Page 8.2	bright	bright	bright
Tolerance	i	Page 8.5	ISO2 (6H)	ISO3 (6G)	7G
Cutting Data	i	Page 8.6	P1 general construction steel	K2+K3 spheroidal and malleable cast iron	

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□				
M 3	0.5	56	6	3.5	2.7	2.5	■	■	■
M 3.5	0.6	56	7	4	3	2.9	■		
M 4	0.7	63	7	4.5	3.4	3.3	■	■	■
M 5	0.8	70	8	6	4.9	4.2	■	■	■
M 6	1	80	10	6	4.9	5.0	■	■	■
M 7	1	80	10	7	5.5	6.0	■		
M 8	1.25	90	13	8	6.2	6.8	■	■	■
M 9	1.25	90	13	9	7	7.8			
M 10	1.5	100	15	10	8	8.5	■	■	■
M 12	1.75	110	18	12	9	10.2			

■ avialable – intermediate size on request

Machine Taps

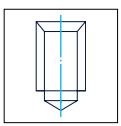
Cutting Data

DIN 376 HSS-E

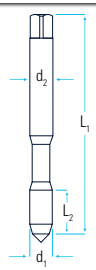
RH spiral flutes 40°
for general construction steel

Group 4300
for blind holes

STEEL



2xd$_1$



Art.-No.			43000	43000 B	43005
Technology	i	Page 8.1	High Volume		
					LH
Champfer Length	i	Page 8.4		C / 2-3 x P	
Surface	i	Page 8.2	bright	bright	bright
Tolerance	i	Page 8.5	ISO2 (6H)	ISO3 (6G)	ISO2 (6H)
Cutting Data	i	Page 8.6	P1 general construction steel	K2+K3 spheroidal and malleable cast iron	

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□				
M 6	1	80	10	4.5	3.4	5.0	■		
M 7	1	80	10	5.5	4.3	6.0			
M 8	1.25	90	14	6	4.9	6.8	■		
M 9	1.25	90	14	7	5.5	7.8			
M 10	1.5	100	16	7	5.5	8.5	■		
M 12	1.75	110	18	9	7	10.2	■	■	■
M 14	2	110	20	11	9	12.0	■	■	
M 16	2	110	20	12	9	14.0	■	■	■
M 18	2.5	125	25	14	11	15.5	■		
M 20	2.5	140	25	16	12	17.5	■	■	■
M 22	2.5	140	25	18	14.5	19.5	■		
M 24	3	160	30	18	14.5	21.0	■	■	
M 27	3	160	30	20	16	24.0	■		
M 30	3.5	180	35	22	18	26.5	■		
M 33	3.5	180	35	25	20	29.5			
M 36	4	200	40	28	22	32.0	■		

■ avialable – intermediate size on request

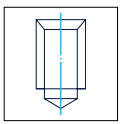
Machine Taps

DIN 371 HSS-E

RH spiral flutes 40°
for general construction steel

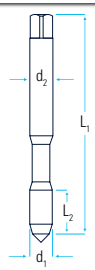
Group 3300
for blind holes

STEEL



2xd$_1$

Cutting Data



Art.-No.			33005	33000/25	33000/42
Technology	i	Page 8.1		High Volume	
			LH		2 x L1
Champfer Length	i	Page 8.4		C / 2-3 x P	
Surface	i	Page 8.2	bright	TiN	bright
Tolerance	i	Page 8.5	ISO2 (6H)	ISO2 (6H)	ISO2 (6H)
Cutting Data	i	Page 8.6	P1 general construction steel	K2+K3 spheroidal and malleable cast iron	

Ø d_1	P_{mm}	L_1	L_2	d_2	□				
M 1.7	0.35	40	8	2.5	2.1	1.35			
M 1.8	0.35	40	8	2.5	2.1	1.45			
M 2	0.4	45	8	2.8	2.1	1.6			
M 2.2	0.45	45	8	2.8	2.1	1.75			
M 2.3	0.4	45	8	2.8	2.1	1.9			
M 2.5	0.45	50	9	2.8	2.1	2.05			
M 2.6	0.45	50	9	2.8	2.1	2.15			
M 3	0.5	56	6	3.5	2.7	2.5	■	■	■
M 3.5	0.6	56	7	4	3	2.9			
M 4	0.7	63	7	4.5	3.4	3.3	■	■	■
M 5	0.8	70	8	6	4.9	4.2	■	■	■
M 6	1	80	10	6	4.9	5.0	■	■	■
M 7	1	80	10	7	5.5	6.0			
M 8	1.25	90	13	8	6.2	6.8	■	■	■
M 9	1.25	90	13	9	7	7.8			
M 10	1.5	100	15	10	8	8.5	■	■	■

■ avialable – intermediate size on request

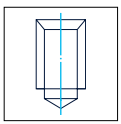
Machine Taps

DIN 376 HSS-E

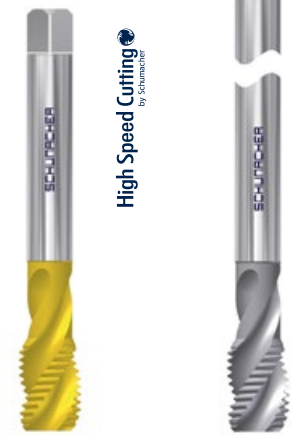
RH spiral flutes 40°
for general construction steel

Group 4300
for blind holes

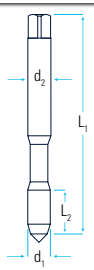
STEEL



2xd$_1$



Cutting Data



Art.-No.			43000/25	43000/42
Technology	i	Page 8.1	High Volume	
Champfer Length	i	Page 8.4		2 x L1
Surface	i	Page 8.2	C / 2-3 x P	
Tolerance	i	Page 8.5	TiN	bright
Cutting Data	i	Page 8.6	ISO2 (6H)	ISO2 (6H)
			P1 general construction steel	K2+K3 spheroidal and malleable cast iron

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□			
M 6	1	80	10	4.5	3.4	5.0		
M 7	1	80	10	5.5	4.3	6.0		
M 8	1.25	90	14	6	4.9	6.8		
M 9	1.25	90	14	7	5.5	7.8		
M 10	1.5	100	16	7	5.5	8.5		
M 12	1.75	110	18	9	7	10.2	■	■
M 14	2	110	20	11	9	12.0	■	■
M 16	2	110	20	12	9	14.0	■	■
M 18	2.5	125	25	14	11	15.5		
M 20	2.5	140	25	16	12	17.5	■	■
M 22	2.5	140	25	18	14.5	19.5		
M 24	3	160	30	18	14.5	21.0	■	
M 27	3	160	30	20	16	24.0		
M 30	3.5	180	35	22	18	26.5	■	
M 33	3.5	180	35	25	20	29.5		
M 36	4	200	40	28	22	32.0		

■ avialable – intermediate size on request

Machine Taps - BLIZZARD

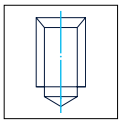
Cutting Data

DIN 371 HSS-E-PM

RH spiral flutes 45°
for general construction steel

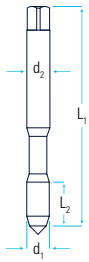
Group 3301
for blind holes

STEEL



3xd$_1$

High Speed Cutting by Schumacher



Art.-No.		33010/6368
Technology	Page 8.1	PM-Line
Champfer Length	Page 8.4	C / 2-3 x P
Surface	Page 8.2	SG 7
Tolerance	Page 8.5	6HX
Cutting Data	Page 8.6	P1 general construction steel N1 aluminium alloys N6 thermoplastics

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□		
M 1.7	0.35	40	8	2.5	2.1	1.35	
M 1.8	0.35	40	8	2.5	2.1	1.45	
M 2	0.4	45	8	2.8	2.1	1.6	
M 2.2	0.45	45	8	2.8	2.1	1.75	
M 2.3	0.4	45	8	2.8	2.1	1.9	
M 2.5	0.45	50	9	2.8	2.1	2.05	
M 2.6	0.45	50	9	2.8	2.1	2.15	
M 3	0.5	56	6	3.5	2.7	2.5	■
M 3.5	0.6	56	7	4	3	2.9	
M 4	0.7	63	7	4.5	3.4	3.3	■
M 5	0.8	70	8	6	4.9	4.2	■
M 6	1	80	10	6	4.9	5.0	■
M 7	1	80	10	7	5.5	6.0	
M 8	1.25	90	13	8	6.2	6.8	■
M 9	1.25	90	13	9	7	7.8	
M 10	1.5	100	15	10	8	8.5	■

■ avialable – intermediate size on request

Machine Taps - BLIZZARD

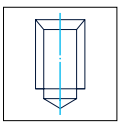
Cutting Data

DIN 376 HSS-E-PM

RH spiral flutes 45°
for general construction steel

Group 4301
for blind holes

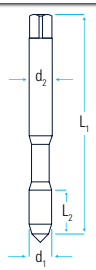
STEEL



3xd$_1$

High Speed Cutting by Schumacher

Art.-No.		43010/63
Technology	Page 8.1	PM-Line
Champfer Length	Page 8.4	C / 2-3 x P
Surface	Page 8.2	SG 7
Tolerance	Page 8.5	6HX
Cutting Data	Page 8.6	P1 general construction steel N1 aluminium alloys N6 thermoplastics



Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□	⌀	
M 6	1	80	10	4.5	3.4	5.0	
M 7	1	80	10	5.5	4.3	6.0	
M 8	1.25	90	14	6	4.9	6.8	
M 9	1.25	90	14	7	5.5	7.8	
M 10	1.5	100	16	7	5.5	8.5	
M 12	1.75	110	18	9	7	10.2	■
M 14	2	110	20	11	9	12.0	
M 16	2	110	20	12	9	14.0	■
M 18	2.5	125	25	14	11	15.5	
M 20	2.5	140	25	16	12	17.5	■
M 22	2.5	140	25	18	14.5	19.5	
M 24	3	160	30	18	14.5	21.0	
M 27	3	160	30	20	16	24.0	
M 30	3.5	180	35	22	18	26.5	
M 33	3.5	180	35	25	20	29.5	
M 36	4	200	40	28	22	32.0	

■ avialable – intermediate size on request

SCHUMACHER

Machine Taps - NUMERIC

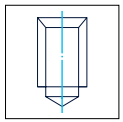
Cutting Data

DIN 371 HSS-E PM

RH spiral flutes 45°
for steel

Group 3303
for blind holes

STEEL

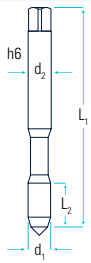


2xd$_1$

DIN 1835-B

NUMERIC
Supporting Digital Production

For use on CNC machines
with synchronized machining



Art.-No.			33030/48	33030/4048	
Technology	i	Page 8.1	PM-Line	PM-Line	
				internal coolant	
Champfer Length	i	Page 8.4		C / 2-3 x P	
Surface	i	Page 8.2	TiCN	TiCN	
Tolerance	i	Page 8.5	6HX	6HX	
Cutting Data	i	Page 8.6	P1 general construction steel	P2 high strength steel	M1 chemical resistant steel

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□	⌀		
M 3	0.5	56	5	3.5	2.7	2.5	■	
M 4	0.7	63	6	4.5	3.4	3.3	■	
M 5	0.8	70	7	6	4.9	4.2	■	
M 6	1	80	8	6	4.9	5.0	■	■
M 7	1	80	8	7	5.5	6.0		
M 8	1.25	90	10	8	6.2	6.8	■	■
M 9	1.25	90	10	9	7	7.8		
M 10	1.5	100	12	10	8	8.5	■	■
M 12	1.75	110	14	12	9	10.2		

■ avialable – intermediate size on request

Machine Taps - NUMERIC

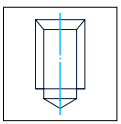
Cutting Data

DIN 376 HSS-E PM

RH spiral flutes 45°
for steel

Group 4303
for blind holes

STEEL



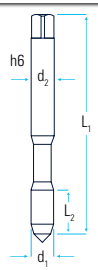
2xd$_1$

High Speed Cutting by Schumacher

NUMERIC
Supporting Digital Production

For use on CNC machines
with synchronized machining

Art.-No.		43030/48
Technology	Page 8.1	PM-Line
Champfer Length	Page 8.4	C / 2-3 x P
Surface	Page 8.2	TiCN
Tolerance	Page 8.5	6HX
Cutting Data	Page 8.6	P1 general construction steel P2 high strength steel M1 chemical resistant steeltant steel



Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□	⌀	
M 6	1	80	10	4.5	3.4	5.0	
M 7	1	80	10	5.5	4.3	6.0	
M 8	1.25	90	14	6	4.9	6.8	
M 9	1.25	90	14	7	5.5	7.8	
M 10	1.5	100	16	7	5.5	8.5	
M 12	1.75	110	18	9	7	10.2	■
M 14	2	110	20	11	9	12.0	
M 16	2	110	20	12	9	14.0	■
M 18	2.5	125	25	14	11	15.5	
M 20	2.5	140	25	16	12	17.5	■
M 22	2.5	140	25	18	14.5	19.5	
M 24	3	160	30	18	14.5	21.0	
M 27	3	160	30	20	16	24.0	
M 30	3.5	180	35	22	18	26.5	
M 33	3.5	180	35	25	20	29.5	
M 36	4	200	40	28	22	32.0	

■ avialable – intermediate size on request

Machine Taps Black Ring

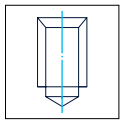
Cutting Data

DIN 371 HSS-E

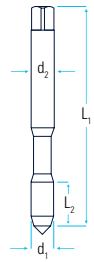
RH spiral flutes 40°
for universal use

Group 3330
for blind holes

UNI



2xd$_1$



Art.-No.			33300/26	33300/25		
Technology	i	Page 8.1	**High Volume**	**High Volume**		
			Black Ring	Black Ring		
Champfer Length	i	Page 8.4	C / 2-3 x P	C / 2-3 x P		
Surface	i	Page 8.2	VAP	TiN		
Tolerance	i	Page 8.5	ISO1 (4H) | ISO2 (6H)	ISO2 (6H)		
Cutting Data	i	Page 8.6	P1 general construction steel	M1 chemical resistant steel	N1 aluminium alloys	N3 copper alloys

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□		
M 1	0.25	40	5.5	2.5	2.1	0.75	■
M 1.2	0.25	40	5.5	2.5	2.1	0.95	■
M 1.4	0.3	40	7	2.5	2.1	1.1	■
M 1.6	0.35	40	8	2.5	2.1	1.25	■
M 1.7	0.35	40	8	2.5	2.1	1.35	■
M 1.8	0.35	40	8	2.5	2.1	1.45	■
M 2	0.4	45	8	2.8	2.1	1.6	■
M 2.2	0.45	45	8	2.8	2.1	1.75	■
M 2.3	0.4	45	8	2.8	2.1	1.9	■
M 2.5	0.45	50	9	2.8	2.1	2.05	■
M 2.6	0.45	50	9	2.8	2.1	2.15	■

Continuation »

■ avialable – intermediate size on request

Machine Taps Black Ring

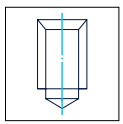
Cutting Data

DIN 371 HSS-E

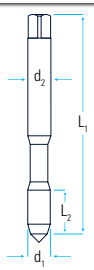
RH spiral flutes 40°
for universal use

Group 3330
for blind holes

UNI



2xd$_1$



Art.-No.			33300/26	33300/25		
Technology	i	Page 8.1	**High Volume**	**High Volume**		
			Black Ring	Black Ring		
Champfer Length	i	Page 8.4	C / 2-3 x P	C / 2-3 x P		
Surface	i	Page 8.2	VAP	TiN		
Tolerance	i	Page 8.5	ISO2 (6H)	ISO2 (6H)		
Cutting Data	i	Page 8.6	P1 general construction steel	M1 chemical resistant steel	N1 aluminium alloys	N3 copper alloys

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□			
M 1.7	0.35	40	8	2.5	2.1	1.35		
M 1.8	0.35	40	8	2.5	2.1	1.45		
M 2	0.4	45	8	2.8	2.1	1.6		
M 2.2	0.45	45	8	2.8	2.1	1.75		
M 2.3	0.4	45	8	2.8	2.1	1.9		
M 2.5	0.45	50	9	2.8	2.1	2.05		
M 2.6	0.45	50	9	2.8	2.1	2.15		
M 3	0.5	56	6	3.5	2.7	2.5	■	■
M 3.5	0.6	56	7	4	3	2.9		
M 4	0.7	63	7	4.5	3.4	3.3	■	■
M 5	0.8	70	8	6	4.9	4.2	■	■
M 6	1	80	10	6	4.9	5.0	■	■
M 7	1	80	10	7	5.5	6.0		
M 8	1.25	90	13	8	6.2	6.8	■	■
M 9	1.25	90	13	9	7	7.8		
M 10	1.5	100	15	10	8	8.5	■	■

■ avialable – intermediate size on request

Machine Taps Black Ring

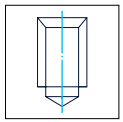
Cutting Data

DIN 376 HSS-E

RH spiral flutes 40°
for universal use

Group 4330
for blind holes

UNI



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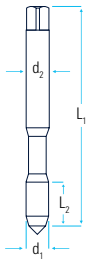


Art.-No.			43300/26	43300/25		
Technology	i	Page 8.1	High Volume	High Volume		
			Black Ring	Black Ring		
Champfer Length	i	Page 8.4	C / 2-3 x P			
Surface	i	Page 8.2	VAP	TiN		
Tolerance	i	Page 8.5	ISO2 (6H)	ISO2 (6H)		
Cutting Data	i	Page 8.6	P1 general construction steel	M1 chemical resistant steel	N1 aluminium alloys	N3 copper alloys

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□			
M 6	1	80	10	4.5	3.4	5.0		
M 7	1	80	10	5.5	4.3	6.0		
M 8	1.25	90	14	6	4.9	6.8		
M 9	1.25	90	14	7	5.5	7.8		
M 10	1.5	100	16	7	5.5	8.5		
M 12	1.75	110	18	9	7	10.2	■	■
M 14	2	110	20	11	9	12.0		
M 16	2	110	20	12	9	14.0	■	■
M 18	2.5	125	25	14	11	15.5		
M 20	2.5	140	25	16	12	17.5	■	■
M 22	2.5	140	25	18	14.5	19.5	■	
M 24	3	160	30	18	14.5	21.0	■	
M 27	3	160	30	20	16	24.0	■	
M 30	3.5	180	35	22	18	26.5	■	
M 33	3.5	180	35	25	20	29.5		
M 36	4	200	40	28	22	32.0		

■ avialable – intermediate size on request

Machine Taps Black Ring

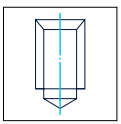
Cutting Data

DIN 371 HSS-E-PM

RH spiral flutes 40°
for universal use

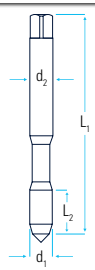
Group 3330
for blind holes

UNI



2xd$_1$

Art.-No.	33300/5760
Technology i Page 8.1	**PM-Line**
	Black Ring
Champfer Length i Page 8.4	C / 2-3 x P
Surface i Page 8.2	SG 4
Tolerance i Page 8.5	ISO2 (6H)
Cutting Data i Page 8.6	P1 general construction steel M1 chemical resistant steel N1 Aluminium N3 copper alloys



Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□		
M 1.7	0.35	40	8	2.5	2.1	1.35	
M 1.8	0.35	40	8	2.5	2.1	1.45	
M 2	0.4	45	8	2.8	2.1	1.6	
M 2.2	0.45	45	8	2.8	2.1	1.75	
M 2.3	0.4	45	8	2.8	2.1	1.9	
M 2.5	0.45	50	9	2.8	2.1	2.05	
M 2.6	0.45	50	9	2.8	2.1	2.15	
M 3	0.5	56	6	3.5	2.7	2.5	■
M 3.5	0.6	56	7	4	3	2.9	
M 4	0.7	63	7	4.5	3.4	3.3	■
M 5	0.8	70	8	6	4.9	4.2	■
M 6	1	80	10	6	4.9	5.0	■
M 7	1	80	10	7	5.5	6.0	
M 8	1.25	90	13	8	6.2	6.8	■
M 9	1.25	90	13	9	7	7.8	
M 10	1.5	100	15	10	8	8.5	■

■ avialable – intermediate size on request

Machine Taps Black Ring

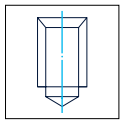
Cutting Data

DIN 376 HSS-E PM

RH spiral flutes 45°
for high strength steel

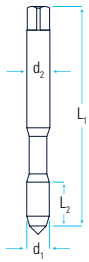
Group 43300
for blind holes

UNI



2xd1

Art.-No.		43300/5760
Technology	Page 8.1	**PM-Line**
		Black Ring
Champfer Length	Page 8.4	C / 2-3 x P
Surface	Page 8.2	SG 4
Tolerance	Page 8.5	ISO2 (6H)
Cutting Data	Page 8.6	P1 general construction steel M1 chemical resistant steel N1 Aluminium N3 copper alloys



Ø d_1	P_{mm}	L_1	L_2	d_2	□		
M 6	1	80	10	4.5	3.4	5.0	
M 7	1	80	10	5.5	4.3	6.0	
M 8	1.25	90	14	6	4.9	6.8	
M 9	1.25	90	14	7	5.5	7.8	
M 10	1.5	100	16	7	5.5	8.5	
M 12	1.75	110	18	9	7	10.2	■
M 14	2	110	20	11	9	12.0	
M 16	2	110	20	12	9	14.0	■
M 18	2.5	125	25	14	11	15.5	
M 20	2.5	140	25	16	12	17.5	■
M 22	2.5	140	25	18	14.5	19.5	
M 24	3	160	30	18	14.5	21.0	
M 27	3	160	30	20	16	24.0	
M 30	3.5	180	35	22	18	26.5	
M 33	3.5	180	35	25	20	29.5	
M 36	4	200	40	28	22	32.0	

■ avialable – intermediate size on request

Machine Taps Red Ring - TYPHOON

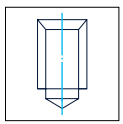
Cutting Data

DIN 371 HSS-E PM

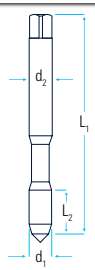
RH spiral flutes 45°
for high strength steel

Group 3340
for deep blind holes ≤ 2.5 x D

HIGH STRENGTH



2,5xd$_1$



Art.-No.		33400/48
Technology	Page 8.1	PM-Line
		Red Ring
Champfer Length	Page 8.4	C / 2-3 x P
Surface	Page 8.2	TiCN
Tolerance	Page 8.5	ISO2 (6H)
Cutting Data	Page 8.6	P2 high strength steel M1 chemical resistant steel

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□		
M 1.7	0.35	40	8	2.5	2.1	1.35	
M 1.8	0.35	40	8	2.5	2.1	1.45	
M 2	0.4	45	8	2.8	2.1	1.6	
M 2.2	0.45	45	8	2.8	2.1	1.75	
M 2.3	0.4	45	8	2.8	2.1	1.9	
M 2.5	0.45	50	9	2.8	2.1	2.05	
M 2.6	0.45	50	9	2.8	2.1	2.15	
M 3	0.5	56	6	3.5	2.7	2.5	■
M 3.5	0.6	56	7	4	3	2.9	
M 4	0.7	63	7	4.5	3.4	3.3	■
M 5	0.8	70	8	6	4.9	4.2	■
M 6	1	80	10	6	4.9	5.0	■
M 7	1	80	10	7	5.5	6.0	
M 8	1.25	90	13	8	6.2	6.8	■
M 9	1.25	90	13	9	7	7.8	
M 10	1.5	100	15	10	8	8.5	■

■ avialable – intermediate size on request

Machine Taps Red Ring - TYPHOON

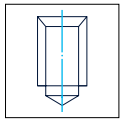
Cutting Data

DIN 376 HSS-E PM

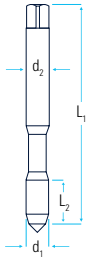
RH spiral flutes 45°
for high strength steel

Group 4340
for deep blind holes ≤ 2.5 x D

HIGH STRENGTH



2,5xd$_1$



Art.-No.			43400/48
Technology	i	Page 8.1	**PM-Line**
			Red Ring
Champfer Length	i	Page 8.4	C / 2-3 x P
Surface	i	Page 8.2	TiCN
Tolerance	i	Page 8.5	ISO2 (6H)
Cutting Data	i	Page 8.6	P2 high strength steel M1 chemical resistant steel

Ø d_1	P_{mm}	L_1	L_2	d_2	□		
M 6	1	80	10	4.5	3.4	5.0	
M 7	1	80	10	5.5	4.3	6.0	
M 8	1.25	90	14	6	4.9	6.8	
M 9	1.25	90	14	7	5.5	7.8	
M 10	1.5	100	16	7	5.5	8.5	
M 12	1.75	110	18	9	7	10.2	■
M 14	2	110	20	11	9	12.0	
M 16	2	110	20	12	9	14.0	■
M 18	2.5	125	25	14	11	15.5	
M 20	2.5	140	25	16	12	17.5	■
M 22	2.5	140	25	18	14.5	19.5	
M 24	3	160	30	18	14.5	21.0	
M 27	3	160	30	20	16	24.0	
M 30	3.5	180	35	22	18	26.5	
M 33	3.5	180	35	25	20	29.5	
M 36	4	200	40	28	22	32.0	

■ avialable – intermediate size on request

Machine Taps Blue Ring

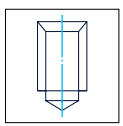
Cutting Data

DIN 371 HSS-E

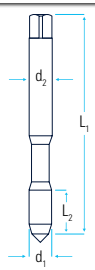
RH spiral flutes 40°
for chemical resistant steel

Group 3350
for blind holes

INOX
Stainless



2xd$_1$



Art.-No.			33500/26	33500/25
Technology	i	Page 8.1	**High Volume** Blue Ring	**High Volume** Blue Ring
Champfer Length	i	Page 8.4	C / 2-3 x P	
Surface	i	Page 8.2	VAP	TiN
Tolerance	i	Page 8.5	ISO2 (6H)	ISO2 (6H)
Cutting Data	i	Page 8.6	P2 high strength steel	M1 chemical resistant steel

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□			
M 1.7	0.35	40	8	2.5	2.1	1.35		
M 1.8	0.35	40	8	2.5	2.1	1.45		
M 2	0.4	45	8	2.8	2.1	1.6	■	
M 2.2	0.45	45	8	2.8	2.1	1.75		
M 2.3	0.4	45	8	2.8	2.1	1.9		
M 2.5	0.45	50	9	2.8	2.1	2.05	■	
M 2.6	0.45	50	9	2.8	2.1	2.15		
M 3	0.5	56	6	3.5	2.7	2.5	■	■
M 3.5	0.6	56	7	4	3	2.9		
M 4	0.7	63	7	4.5	3.4	3.3	■	■
M 5	0.8	70	8	6	4.9	4.2	■	■
M 6	1	80	10	6	4.9	5.0	■	■
M 7	1	80	10	7	5.5	6.0		
M 8	1.25	90	13	8	6.2	6.8	■	■
M 9	1.25	90	13	9	7	7.8		
M 10	1.5	100	15	10	8	8.5	■	■

■ avialable – intermediate size on request

Machine Taps Blue Ring

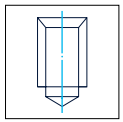
Cutting Data

DIN 376 HSS-E

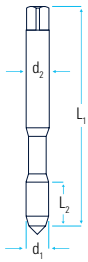
RH spiral flutes 40°
for chemical resistant steel

Group 4350
for blind holes

INOX
Stainless



2xd$_1$



Art.-No.			43500/26	43500/25
Technology	i	Page 8.1	**High Volume** Blue Ring	**High Volume** Blue Ring
Champfer Length	i	Page 8.4	C / 2-3 x P	
Surface	i	Page 8.2	VAP	TiN
Tolerance	i	Page 8.5	ISO2 (6H)	ISO2 (6H)
Cutting Data	i	Page 8.6	P2 high strength steel	M1 chemical resistant steel

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□			
M 6	1	80	10	4.5	3.4	5.0		
M 7	1	80	10	5.5	4.3	6.0		
M 8	1.25	90	14	6	4.9	6.8		
M 9	1.25	90	14	7	5.5	7.8		
M 10	1.5	100	16	7	5.5	8.5		
M 12	1.75	110	18	9	7	10.2	■	■
M 14	2	110	20	11	9	12.0	■	■
M 16	2	110	20	12	9	14.0	■	■
M 18	2.5	125	25	14	11	15.5	■	
M 20	2.5	140	25	16	12	17.5	■	■
M 22	2.5	140	25	18	14.5	19.5	■	
M 24	3	160	30	18	14.5	21.0	■	■
M 27	3	160	30	20	16	24.0	■	
M 30	3.5	180	35	22	18	26.5	■	■
M 33	3.5	180	35	25	20	29.5		
M 36	4	200	40	28	22	32.0		

■ avialable – intermediate size on request

Machine Taps Blue Ring - POLAR

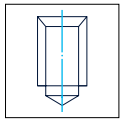
Cutting Data

DIN 371 HSS-E PM

RH spiral flutes 45°
for chemical resistant steel

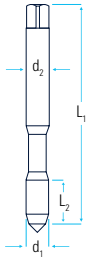
Group 3351
for deep blind holes ≤ 2.5xd1

INOX
Stainless



2,5xd$_1$

Art.-No.		33510/48
Technology	Page 8.1	PM-Line
		Blue Ring
Champfer Length	Page 8.4	C / 2-3 x P
Surface	Page 8.2	TiCN
Tolerance	Page 8.5	6HX
Cutting Data	Page 8.6	P2 high strength steel M1+M2 chemical resistant steel



Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□		
M 1.7	0.35	40	8	2.5	2.1	1.35	
M 1.8	0.35	40	8	2.5	2.1	1.45	
M 2	0.4	45	8	2.8	2.1	1.6	
M 2.2	0.45	45	8	2.8	2.1	1.75	
M 2.3	0.4	45	8	2.8	2.1	1.9	
M 2.5	0.45	50	9	2.8	2.1	2.05	
M 2.6	0.45	50	9	2.8	2.1	2.15	
M 3	0.5	56	6	3.5	2.7	2.5	■
M 3.5	0.6	56	7	4	3	2.9	
M 4	0.7	63	7	4.5	3.4	3.3	■
M 5	0.8	70	8	6	4.9	4.2	■
M 6	1	80	10	6	4.9	5.0	■
M 7	1	80	10	7	5.5	6.0	
M 8	1.25	90	13	8	6.2	6.8	■
M 9	1.25	90	13	9	7	7.8	
M 10	1.5	100	15	10	8	8.5	■

■ avialable – intermediate size on request

Machine Taps Blue Ring - POLAR

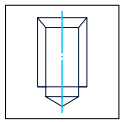
Cutting Data

DIN 376 HSS-E PM

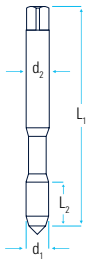
RH spiral flutes 45°
for chemical resistant steel

Group 4351
for deep blind holes ≤ 2.5xd1

INOX
Stainless



2,5xd$_1$



Art.-No.		43510/48
Technology	Page 8.1	PM-Line
		Blue Ring
Champfer Length	Page 8.4	C / 2-3 x P
Surface	Page 8.2	TiCN
Tolerance	Page 8.5	6HX
Cutting Data	Page 8.6	P2 high strength steel M1+M2 chemical resistant steel

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□		
M 6	1	80	10	4.5	3.4	5.0	
M 7	1	80	10	5.5	4.3	6.0	
M 8	1.25	90	14	6	4.9	6.8	
M 9	1.25	90	14	7	5.5	7.8	
M 10	1.5	100	16	7	5.5	8.5	
M 12	1.75	110	18	9	7	10.2	■
M 14	2	110	20	11	9	12.0	
M 16	2	110	20	12	9	14.0	■
M 18	2.5	125	25	14	11	15.5	
M 20	2.5	140	25	16	12	17.5	■
M 22	2.5	140	25	18	14.5	19.5	
M 24	3	160	30	18	14.5	21.0	
M 27	3	160	30	20	16	24.0	
M 30	3.5	180	35	22	18	26.5	
M 33	3.5	180	35	25	20	29.5	
M 36	4	200	40	28	22	32.0	

■ avialable – intermediate size on request

SCHUMACHER

Machine Taps - MISTRAL

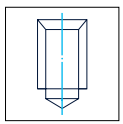
Cutting Data

DIN 371 HSS-E PM

RH spiral flutes 45°
for aluminium and bronze alloys

Group 3360
for blind holes

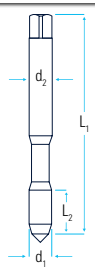
AL



2xd$_1$

DLC
Diamond like Carbon

Innovative surface coating technologies with high hardness and low frictional coeficient



Art.-No.			33600/02	33600/24
Technology	i	Page 8.1	PM-Line	PM-Line
Champfer Length	i	Page 8.4	C / 2-3 x P	
Surface	i	Page 8.2	CrN	DLC
Tolerance	i	Page 8.5	ISO2 (6H)	ISO2 (6H)
Cutting Data	i	Page 8.6	N1 aluminium alloys	N6 thermoplastics

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□			
M 1.7	0.35	40	8	2.5	2.1	1.35		
M 1.8	0.35	40	8	2.5	2.1	1.45		
M 2	0.4	45	8	2.8	2.1	1.6		
M 2.2	0.45	45	8	2.8	2.1	1.75		
M 2.3	0.4	45	8	2.8	2.1	1.9		
M 2.5	0.45	50	9	2.8	2.1	2.05		
M 2.6	0.45	50	9	2.8	2.1	2.15		
M 3	0.5	56	6	3.5	2.7	2.5	■	■
M 3.5	0.6	56	7	4	3	2.9		
M 4	0.7	63	7	4.5	3.4	3.3	■	■
M 5	0.8	70	8	6	4.9	4.2	■	■
M 6	1	80	10	6	4.9	5.0	■	■
M 7	1	80	10	7	5.5	6.0		
M 8	1.25	90	13	8	6.2	6.8	■	■
M 9	1.25	90	13	9	7	7.8		
M 10	1.5	100	15	10	8	8.5	■	■

■ avialable – intermediate size on request

SCHUMACHER

Machine Taps - MISTRAL

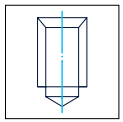
Cutting Data

DIN 376 HSS-E PM

RH spiral flutes 45°
for aluminium and bronze alloys

Group 4360
for blind holes

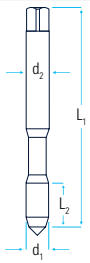
AL



2xd$_1$

DLC
Diamond like Carbon

Innovative surface coating technologies with high hardness and low frictional coeficient



Art.-No.			43600/02	43600/24
Technology	i	Page 8.1	PM-Line	PM-Line
Champfer Length	i	Page 8.4	C / 2-3 x P	
Surface	i	Page 8.2	CrN	DLC
Tolerance	i	Page 8.5	ISO2 (6H)	ISO2 (6H)
Cutting Data	i	Page 8.6	N1 aluminium alloys	N6 thermoplastics

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□			
M 6	1	80	10	4.5	3.4	5.0		
M 7	1	80	10	5.5	4.3	6.0		
M 8	1.25	90	14	6	4.9	6.8		
M 9	1.25	90	14	7	5.5	7.8		
M 10	1.5	100	16	7	5.5	8.5		
M 12	1.75	110	18	9	7	10.2	■	■
M 14	2	110	20	11	9	12.0		
M 16	2	110	20	12	9	14.0	■	■
M 18	2.5	125	25	14	11	15.5		
M 20	2.5	140	25	16	12	17.5		
M 22	2.5	140	25	18	14.5	19.5		
M 24	3	160	30	18	14.5	21.0		
M 27	3	160	30	20	16	24.0		
M 30	3.5	180	35	22	18	26.5		
M 33	3.5	180	35	25	20	29.5		
M 36	4	200	40	28	22	32.0		

■ avialable – intermediate size on request

Machine Taps Red Ring

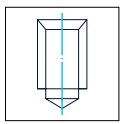
Cutting Data

DIN 371 HSS-E

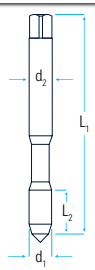
RH spiral flutes 40°
for high strength steel

Group 3380
for blind holes

HIGH STRENGTH



2xd$_1$



Art.-No.		33800	33800/48
Technology	Page 8.1	High Volume	High Volume
		Red Ring	Red Ring
Champfer Length	Page 8.4	C / 2-3 x P	
Surface	Page 8.2	bright	TiCN
Tolerance	Page 8.5	ISO2 (6H)	ISO2 (6H)
Cutting Data	Page 8.6	P2 high strength steel	

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□			
M 1.7	0.35	40	8	2.5	2.1	1.35		
M 1.8	0.35	40	8	2.5	2.1	1.45		
M 2	0.4	45	8	2.8	2.1	1.6		
M 2.2	0.45	45	8	2.8	2.1	1.75		
M 2.3	0.4	45	8	2.8	2.1	1.9		
M 2.5	0.45	50	9	2.8	2.1	2.05		
M 2.6	0.45	50	9	2.8	2.1	2.15		
M 3	0.5	56	6	3.5	2.7	2.5	■	■
M 3.5	0.6	56	7	4	3	2.9		
M 4	0.7	63	7	4.5	3.4	3.3	■	■
M 5	0.8	70	8	6	4.9	4.2	■	■
M 6	1	80	10	6	4.9	5.0	■	■
M 7	1	80	10	7	5.5	6.0		
M 8	1.25	90	13	8	6.2	6.8	■	■
M 9	1.25	90	13	9	7	7.8		
M 10	1.5	100	15	10	8	8.5	■	■

■ avialable – intermediate size on request

Machine Taps Red Ring

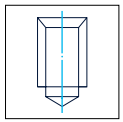
Cutting Data

DIN 376 HSS-E

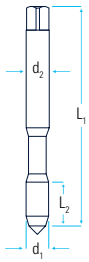
RH spiral flutes 40°
for high strength steel

Group 4380
for blind holes

HIGH STRENGTH



2xd$_1$



Art.-No.			43800	43800/48
Technology	i	Page 8.1	**High Volume** Red Ring	**High Volume** Red Ring
Champfer Length	i	Page 8.4	C / 2-3 x P	
Surface	i	Page 8.2	bright	TiCN
Tolerance	i	Page 8.5	ISO2 (6H)	ISO2 (6H)
Cutting Data	i	Page 8.6	P2 high strength steel	

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□			
M 6	1	80	10	4.5	3.4	5.0		
M 7	1	80	10	5.5	4.3	6.0		
M 8	1.25	90	14	6	4.9	6.8		
M 9	1.25	90	14	7	5.5	7.8		
M 10	1.5	100	16	7	5.5	8.5		
M 12	1.75	110	18	9	7	10.2	■	■
M 14	2	110	20	11	9	12.0	■	■
M 16	2	110	20	12	9	14.0	■	■
M 18	2.5	125	25	14	11	15.5		
M 20	2.5	140	25	16	12	17.5	■	■
M 22	2.5	140	25	18	14.5	19.5		
M 24	3	160	30	18	14.5	21.0	■	■
M 27	3	160	30	20	16	24.0		
M 30	3.5	180	35	22	18	26.5	■	■
M 33	3.5	180	35	25	20	29.5		
M 36	4	200	40	28	22	32.0		

■ avialable – intermediate size on request

Forming Taps Black Ring - TORNADO

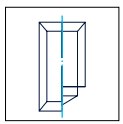
Cutting Data

DIN 371 HSS-E PM

straight oil grooves for steel, heat treatable steel
and chemical resistant steel

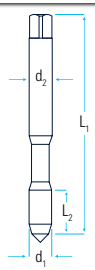
Group 3050
for blind and through holes

UNI



2xd$_1$

Art.-No.		
Technology	i	Page 8.1
Champfer Length	i	Page 8.4
Surface	i	Page 8.2
Tolerance	i	Page 8.5
Cutting Data	i	Page 8.6



30500/4853	
PM-Line	
Black Ring	
C / 2-3 x P	
TiCN	
6HX	
P1 general construction steel	P2 high strength steel M1 chemical resistant steel

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□		
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	1.85	
M 2.2	0.45	45	8	2.8	2.1	2.0	
M 2.3	0.4	45	8	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	11	3.5	2.7	2.8	■
M 3.5	0.6	56	12	4	3	3.25	
M 4	0.7	63	13	4.5	3.4	3.7	■
M 5	0.8	70	15	6	4.9	4.65	■
M 6	1	80	17	6	4.9	5.55	■
M 7	1	80	17	7	5.5	6.55	
M 8	1.25	90	20	8	6.2	7.4	■
M 9	1.25	90	20	9	7	8.4	
M 10	1.5	100	22	10	8	9.3	■

■ avialable – intermediate size on request

Forming Taps Black Ring - TORNADO

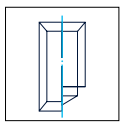
Cutting Data

DIN 376 HSS-E PM

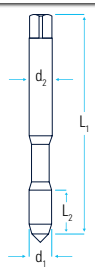
straight oil grooves for steel, heat treatable steel
and chemical resistant steel

Group 4050
for blind and through holes

UNI



2xd$_1$



Art.-No.			40500/4853
Technology	i	Page 8.1	**PM-Line**
			Black Ring
Champfer Length	i	Page 8.4	C / 2-3 x P
Surface	i	Page 8.2	TiCN
Tolerance	i	Page 8.5	6HX
Cutting Data	i	Page 8.6	P1 general construction steel P2 high strength steel M1 chemical resistant steel

Ø d_1	P_{mm}	L_1	L_2	d_2	□		
M 6	1	80	17	4.5	3.4	5.55	
M 7	1	80	17	5.5	4.3	6.55	
M 8	1.25	90	20	6	4.9	7.4	
M 9	1.25	90	20	7	5.5	8.4	
M 10	1.5	100	22	7	5.5	9.3	
M 12	1.75	110	24	9	7	11.2	■
M 14	2	110	26	11	9	13.1	
M 16	2	110	27	12	9	15.1	■
M 18	2.5	125	30	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	34	18	14.5	22.65	
M 27	3	160	36	20	16	25.65	

■ avialable – intermediate size on request

SCHUMACHER

Forming Taps - MISTRAL

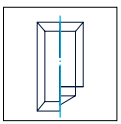
Cutting Data

DIN 371 HSS-E PM

straight oil grooves for aluminium and bronze alloys

Group 3051
for blind and through holes

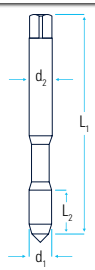
AL



2xd$_1$

DLC
Diamond like Carbon

Innovative surface coating technologies with high hardness and low frictional coeficient



Art.-No.			30510/0253	30510/2453
Technology	i	Page 8.1	PM-Line	PM-Line
Champfer Length	i	Page 8.4	C / 2-3 x P	
Surface	i	Page 8.2	CrN	DLC
Tolerance	i	Page 8.5	6HX	6HX
Cutting Data	i	Page 8.6	N1 aluminium alloys	N5 Bronze alloys N6 thermoplastics

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□			
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	1.85		
M 2.2	0.45	45	8	2.8	2.1	2.0		
M 2.3	0.4	45	8	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	11	3.5	2.7	2.8	■	■
M 3.5	0.6	56	12	4	3	3.25		
M 4	0.7	63	13	4.5	3.4	3.7	■	■
M 5	0.8	70	15	6	4.9	4.65	■	■
M 6	1	80	17	6	4.9	5.55	■	■
M 7	1	80	17	7	5.5	6.55		
M 8	1.25	90	20	8	6.2	7.4	■	■
M 9	1.25	90	20	9	7	8.4		
M 10	1.5	100	22	10	8	9.3	■	■

■ avialable – intermediate size on request

SCHUMACHER

Forming Taps - MISTRAL

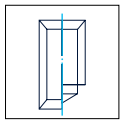
Cutting Data

DIN 376 HSS-E PM

straight oil grooves for aluminium and bronze alloys

Group 4051
for blind and through holes

AL

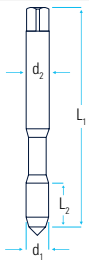


2xd$_1$

DLC
Diamond like Carbon

Innovative surface coating technologies with high hardness and low frictional coeficient

Art.-No.			40510/0253	40510/2453
Technology	i	Page 8.1	PM-Line	PM-Line
Champfer Length	i	Page 8.4	C / 2-3 x P	
Surface	i	Page 8.2	CrN	DLC
Tolerance	i	Page 8.5	6HX	6HX
Cutting Data	i	Page 8.6	N1 aluminium alloys	N5 Bronze alloys N6 thermoplastics



Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□			
M 6	1	80	17	4.5	3.4	5.55		
M 7	1	80	17	5.5	4.3	6.55		
M 8	1.25	90	20	6	4.9	7.4		
M 9	1.25	90	20	7	5.5	8.4		
M 10	1.5	100	22	7	5.5	9.3		
M 12	1.75	110	24	9	7	11.2	■	■
M 14	2	110	26	11	9	13.1		
M 16	2	110	27	12	9	15.1	■	■
M 18	2.5	125	30	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	34	18	14.5	22.65		
M 27	3	160	36	20	16	25.65		

■ avialable – intermediate size on request

SCHUMACHER

Forming Taps - NUMERIC

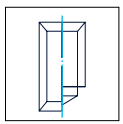
Cutting Data

DIN 371 HSS-E PM

straight oil grooves for steel, heat treatable steel
and chemical resistant steel

Group 3053
for blind and through holes

STEEL



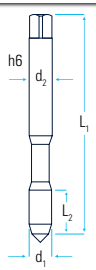
2xd$_1$

High Speed Cutting by Schumacher

NUMERIC
Supporting Digital Production

For use on CNC machines
with synchronized machining

Art.-No.		30530/4853
Technology	Page 8.1	PM-Line
Champfer Length	Page 8.4	C / 2-3 x P
Surface	Page 8.2	TiCN
Tolerance	Page 8.5	6HX
Cutting Data	Page 8.6	P1 general construction steel P2 high strength steel M1 chemical resistant steel



Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□		
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	1.85	
M 2.2	0.45	45	8	2.8	2.1	2.0	
M 2.3	0.4	45	8	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	6	3.5	2.7	2.8	■
M 3.5	0.6	56	7	4	3	3.25	
M 4	0.7	63	7	4.5	3.4	3.7	■
M 5	0.8	70	8	6	4.9	4.65	■
M 6	1	80	10	6	4.9	5.55	■
M 7	1	80	10	7	5.5	6.55	
M 8	1.25	90	13	8	6.2	7.4	■
M 9	1.25	90	13	9	7	8.4	
M 10	1.5	100	15	10	8	9.3	■

■ avialable – intermediate size on request

SCHUMACHER

Forming Taps - NUMERIC

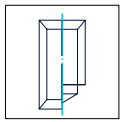
Cutting Data

DIN 376 HSS-E PM

straight oil grooves for steel, heat treatable steel and chemical resistant steel

Group 4053
for blind and through holes

STEEL



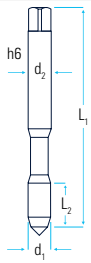
2xd$_1$

High Speed Cutting by Schumacher

NUMERIC
Supporting Digital Production

For use on CNC machines with synchronized machining

Art.-No.		40530/4853
Technology	Page 8.1	PM-Line
Champfer Length	Page 8.4	C / 2-3 x P
Surface	Page 8.2	TiCN
Tolerance	Page 8.5	6HX
Cutting Data	Page 8.6	P1 general construction steel P2 high strength steel M1 chemical resistant steel



Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□		
M 6	1	80	10	4.5	3.4	5.55	
M 7	1	80	10	5.5	4.3	6.55	
M 8	1.25	90	14	6	4.9	7.4	
M 9	1.25	90	14	7	5.5	8.4	
M 10	1.5	100	16	7	5.5	9.3	
M 12	1.75	110	18	9	7	11.2	■
M 14	2	110	20	11	9	13.1	
M 16	2	110	20	12	9	15.1	■
M 18	2.5	125	25	14	11	16.9	
M 20	2.5	140	25	16	12	18.9	
M 22	2.5	140	25	18	14.5	20.9	
M 24	3	160	30	18	14.5	22.65	
M 27	3	160	30	20	16	25.65	

■ avialable – intermediate size on request

Forming Taps - CONDOR

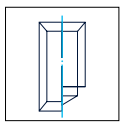
Cutting Data

DIN 371 HSS-E PM

straight oil grooves for high strength steel, heat treatable steel and chemical resistant steel

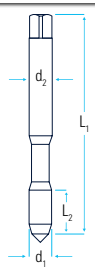
Group 3055
for blind and through holes

HIGH STRENGTH



2xd$_1$

Art.-No.		30550/5367
Technology	Page 8.1	PM-Line
		Red Ring
Champfer Length	Page 8.4	C / 2-3 x P
Surface	Page 8.2	SG 6
Tolerance	Page 8.5	6HX
Cutting Data	Page 8.6	P3 high strength steel M1 chemical resistant steel S1 titanium alloys



Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□	⌀	
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	1.85	
M 2.2	0.45	45	8	2.8	2.1	2.0	
M 2.3	0.4	45	8	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	6	3.5	2.7	2.8	■
M 3.5	0.6	56	7	4	3	3.25	
M 4	0.7	63	7	4.5	3.4	3.7	■
M 5	0.8	70	8	6	4.9	4.65	■
M 6	1	80	10	6	4.9	5.55	■
M 7	1	80	10	7	5.5	6.55	
M 8	1.25	90	13	8	6.2	7.4	■
M 9	1.25	90	13	9	7	8.4	
M 10	1.5	100	15	10	8	9.3	■

■ avialable – intermediate size on request

Forming Taps - CONDOR

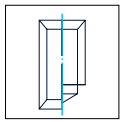
Cutting Data

DIN 376 HSS-E PM

straight oil grooves for high strength steel, heat treatable steel and chemical resistant steel

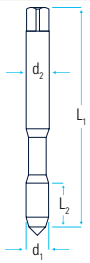
Group 4055
for blind and through holes

HIGH STRENGTH



2xd$_1$

Art.-No.		40550/5367
Technology	Page 8.1	PM-Line
		Red Ring
Champfer Length	Page 8.4	C / 2-3 x P
Surface	Page 8.2	SG 6
Tolerance	Page 8.5	6HX
Cutting Data	Page 8.6	P3 high strength steel M1 chemical resistant steel S1 titanium alloys



Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□	
M 6	1	80	17	4.5	3.4	5.55
M 7	1	80	17	5.5	4.3	6.55
M 8	1.25	90	20	6	4.9	7.4
M 9	1.25	90	20	7	5.5	8.4
M 10	1.5	100	22	7	5.5	9.3
M 12	1.75	110	24	9	7	11.2 ■
M 14	2	110	26	11	9	13.1
M 16	2	110	27	12	9	15.1
M 18	2.5	125	30	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	34	18	14.5	22.65
M 27	3	160	36	20	16	25.65

■ avialable – intermediate size on request

Forming Taps

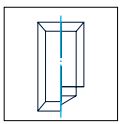
Cutting Data

DIN 371 HSS-E

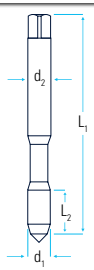
straight oil grooves for steel, non-ferrous steel and heat treatable steel

Group 3060
for blind and through holes

STEEL



2xd$_1$



Art.-No.			30600/53	30600/2553	30600 B/2553
Technology	i	Page 8.1	High Volume	High Volume	
Champfer Length	i	Page 8.4	C / 2-3 x P		
Surface	i	Page 8.2	bright	TiN	TiN
Tolerance	i	Page 8.5	4HX | 6HX	6HX	6GX
Cutting Data	i	Page 8.6	P1 general construction steel	P2 high stregth steel	N3 copper alloys

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□			
M 1	0.25	40	5.5	2.5	2.1	0.9	■	
M 1.2	0.25	40	5.5	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	1.85	■	■
M 2.2	0.45	45	8	2.8	2.1	2.0		
M 2.3	0.4	45	8	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		

Continuation »

■ without oil grooves ■ avialable – intermediate size on request

Forming Taps

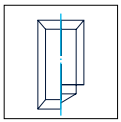
Cutting Data

DIN 371 HSS-E

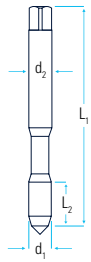
straight oil grooves for steel, non-ferrous steel and heat treatable steel

Group 3060
for blind and through holes

STEEL



2xd$_1$



Art.-No.			30600/53	30600/2553	30600 B/2553
Technology	i	Page 8.1	High Volume	High Volume	
Champfer Length	i	Page 8.4		C / 2-3 x P	
Surface	i	Page 8.2	bright	TiN	TiN
Tolerance	i	Page 8.5	6HX	6HX	6GX
Cutting Data	i	Page 8.6	P1 general construction steel	P2 high strength steel	N3 copper alloys

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□				
M 3	0.5	56	11	3.5	2.7	2.8	■	■	■
M 3.5	0.6	56	12	4	3	3.25			
M 4	0.7	63	13	4.5	3.4	3.7	■	■	■
M 5	0.8	70	15	6	4.9	4.65	■	■	■
M 6	1	80	17	6	4.9	5.55	■	■	■
M 7	1	80	17	7	5.5	6.55			
M 8	1.25	90	20	8	6.2	7.4	■	■	■
M 9	1.25	90	20	9	7	8.4			
M 10	1.5	100	22	10	8	9.3	■	■	■
M 12	1.75	110	24	12	9	11.2			

■ avialable – intermediate size on request

Forming Taps

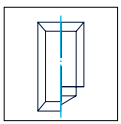
Cutting Data

DIN 376 HSS-E

straight oil grooves for steel, non-ferrous steel and heat treatable steel

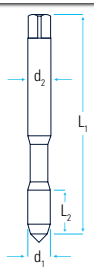
Group 4060
for blind and through holes

STEEL



2xd$_1$

High Speed Cutting by Schumacher



Art.-No.			40600/53	40600/2553	
Technology	i	Page 8.1	High Volume	High Volume	
Champfer Length	i	Page 8.4	C / 2-3 x P		
Surface	i	Page 8.2	bright	TiN	
Tolerance	i	Page 8.5	6HX	6HX	
Cutting Data	i	Page 8.6	P1 general construction steel	P2 high strength steel	N3 copper alloys

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□			
M 6	1	80	17	4.5	3.4	5.55		
M 7	1	80	17	5.5	4.3	6.55		
M 8	1.25	90	20	6	4.9	7.4		
M 9	1.25	90	20	7	5.5	8.4		
M 10	1.5	100	22	7	5.5	9.3		
M 12	1.75	110	24	9	7	11.2	■	■
M 14	2	110	26	11	9	13.1		
M 16	2	110	27	12	9	15.1	■	■
M 18	2.5	125	30	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	34	18	14.5	22.65		
M 27	3	160	36	20	16	25.65		

■ avialable – intermediate size on request

Set of Taps

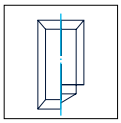
Cutting Data

DIN 352 HSS

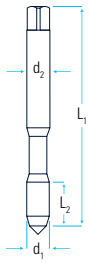
set of 3 pieces, straight flutes
for general construction steel

Group 1000
for blind and through holes

STEEL



2xd$_1$



Art.-No.			10100	10200	10300
Technology	i	Page 8.1	High Volume	High Volume	High Volume
Champfer Length	i	Page 8.4	D / 3,5-5 x P	3-4 x P	C / 2-3 x P
Surface	i	Page 8.2	bright	bright	bright
Tolerance	i	Page 8.5	Nr. 1	Nr. 2	Nr. 3 = ISO2 (6H)
Cutting Data	i	Page 8.6	P1 general construction steel	K2+K3 spheroidal and malleable cast iron	

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□				
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	11	3.5	2.7	2.5	■	■	■
M 4	0.7	45.5	13	4.5	3.4	3.3	■	■	■
M 5	0.8	52	16	6	4.9	4.2	■	■	■
M 6	1	56	18	6	4.9	5.0	■	■	■

Continuation »

■ avialable – intermediate size on request

Set of Taps

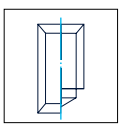
Cutting Data

DIN 352 HSS

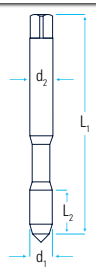
set of 3 pieces, straight flutes
for general construction steel

Group 1000
for blind and through holes

STEEL



2xd$_1$



Art.-No.			10100	10200	10300
Technology	i	Page 8.1	**High Volume**	**High Volume**	**High Volume**
Champfer Length	i	Page 8.4	D / 3,5-5 x P	3-4 x P	C / 2-3 x P
Surface	i	Page 8.2	bright	bright	bright
Tolerance	i	Page 8.5	Nr. 1	Nr. 2	Nr. 3 = ISO2 (6H)
Cutting Data	i	Page 8.6	P1 general construction steel	K2+K3 spheroidal and malleable cast iron	

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□				
M 7	1	56	18	6	4.9	6.0	■	■	■
M 8	1.25	63	20	6	4.9	6.75	■	■	■
M 9	1.25	63	20	7	5.5	7.75	■	■	■
M 10	1.5	70	22	7	5.5	8.5	■	■	■
M 12	1.75	80	24	9	7	10.25	■	■	■
M 14	2	80	26	11	9	12.0	■	■	■
M 16	2	80	27	12	9	14.0	■	■	■
M 18	2.5	95	30	14	11	15.5	■	■	■
M 20	2.5	95	32	16	12	17.5	■	■	■

■ avialable – intermediate size on request

Set of Taps

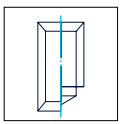
Cutting Data

DIN 352 HSS

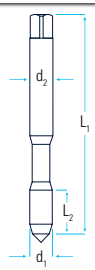
set of 3 pieces, straight flutes
for general construction steel

Group 1000 LH
for blind and through holes

STEEL



2xd$_1$



Art.-No.			10105	10205	10305
Technology	i	Page 8.1	LH	LH	LH
Champfer Length	i	Page 8.4	D / 3,5-5 x P	3-4 x P	C / 2-3 x P
Surface	i	Page 8.2	bright	bright	bright
Tolerance	i	Page 8.5	Nr. 1	Nr. 2	Nr. 3 = ISO2 (6H)
Cutting Data	i	Page 8.6	P1 general construction steel	K2+K3 spheroidal and malleable cast iron	

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□				
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	11	3.5	2.7	2.5	■	■	■
M 4	0.7	45.5	13	4.5	3.4	3.3	■	■	■
M 5	0.8	52	16	6	4.9	4.2	■	■	■
M 6	1	56	18	6	4.9	5.0	■	■	■

Continuation »

■ avialable – intermediate size on request

Set of Taps

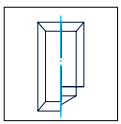
Cutting Data

DIN 352 HSS

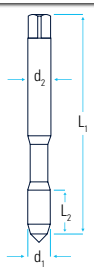
set of 3 pieces, straight flutes
for general construction steel

Group 1000 LH
for blind and through holes

STEEL



2xd$_1$



Art.-No.		10105	10205	10305
Technology	Page 8.1	LH	LH	LH
Champfer Length	Page 8.4	D / 3,5-5 x P	3-4 x P	C / 2-3 x P
Surface	Page 8.2	bright	bright	bright
Tolerance	Page 8.5	Nr. 1	Nr. 2	Nr. 3 = ISO2 (6H)
Cutting Data	Page 8.6	P1 general construction steel	K2+K3 spheroidal and malleable cast iron	

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□				
M 7	1	56	18	6	4.9	6.0			
M 8	1.25	63	20	6	4.9	6.75	■	■	■
M 9	1.25	63	20	7	5.5	7.75			
M 10	1.5	70	22	7	5.5	8.5	■	■	■
M 12	1.75	80	24	9	7	10.25	■	■	■
M 14	2	80	26	11	9	12.0	■	■	■
M 16	2	80	27	12	9	14.0	■	■	■
M 18	2.5	95	30	14	11	15.5	■	■	■
M 20	2.5	95	32	16	12	17.5	■	■	■

■ avialable – intermediate size on request

Set of Taps

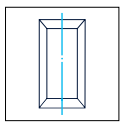
Cutting Data

DIN 352 HSS-E

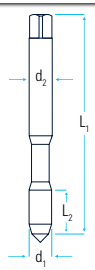
set of 3 pieces, straight flutes
for high strength steel

Group 2000
for through holes

HIGH STRENGTH



2xd$_1$



Art.-No.			20100	20200	20300
Technology	i	Page 8.1			
Champfer Length	i	Page 8.4	D / 3,5-5 x P	3-4 x P	C / 2-3 x P
Surface	i	Page 8.2	bright	bright	bright
Tolerance	i	Page 8.5	Nr. 1	Nr. 2	Nr. 3 = ISO2 (6H)
Cutting Data	i	Page 8.6	P2 high strength steel		

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□				
M 3	0.5	40	11	3.5	2.7	2.5	■	■	■
M 4	0.7	45	13	4.5	3.4	3.3	■	■	■
M 5	0.8	52	16	6	4.9	4.2	■	■	■
M 6	1	56	18	6	4.9	5.0	■	■	■
M 7	1	56	18	6	4.9	6.0			
M 8	1.25	63	20	6	4.9	6.75	■	■	■
M 9	1.25	63	20	7	5.5	7.75			
M 10	1.5	70	22	7	5.5	8.5	■	■	■
M 12	1.75	80	24	9	7	10.25	■	■	■
M 14	2	80	26	11	9	12.0			
M 16	2	80	27	12	9	14.0	■	■	■
M 18	2.5	95	30	14	11	15.5			
M 20	2.5	95	32	16	12	17.5	■	■	■

■ avialable – intermediate size on request

Carbide Machine Taps

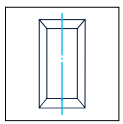
Cutting Data

DIN 371/376 VHM

straight flutes
for hard materials

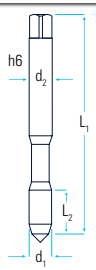
Group G010
for through holes

HARD



2xd$_1$

VHM tec CARBIDE by Schumacher



Art.-No.		G0100/41
Technology	i Page 8.1	VHM tec
		Internal coolant radial
Champfer Length	i Page 8.4	5-6 x P
Surface	i Page 8.2	bright
Tolerance	i Page 8.5	6HX
Cutting Data	i Page 8.6	K1 grey cast iron N3 copper alloys H1 hard materials

Ø d_1	P_{mm}	L_1	L_2	d_2	□		
M 3	0.5	56	11	3.5	2.7	2.5	
M 3.5	0.6	56	12	4	3	2.9	
M 4	0.7	63	13	4.5	3.4	3.3	
M 5	0.8	70	15	6	4.9	4.2	
M 6	1	80	17	6	4.9	5.0	■
M 7	1	80	17	7	5.5	6.0	
M 8	1.25	90	20	8	6.2	6.8	■
M 9	1.25	90	20	9	7	7.8	
M 10	1.5	100	22	10	8	8.5	■
M 12	1.75	110	24	9	7	10.2	■
M 16	2	110	27	12	9	14.0	■

■ avialable – intermediate size on request

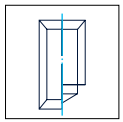
Carbide Machine Taps

Cutting Data

DIN 371/376 VHM
straight flutes
for hard materials

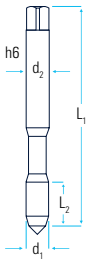
Group G080
for blind and through holes

HARD



2xd$_1$

VHM tec CARBIDE by Schumacher



Art.-No.			G0800	G0800/40
Technology	i	Page 8.1	VHM tec	VHM tec
			Internal coolant	
Champfer Length	i	Page 8.4	3-4 x P	
Surface	i	Page 8.2	bright	bright
Tolerance	i	Page 8.5	6HX	6HX
Cutting Data	i	Page 8.6	K1 grey cast iron N3 copper alloys	H1 hard materials

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□			
M 3	0.5	56	11	3.5	2.7	2.5	■	
M 3.5	0.6	56	12	4	3	2.9		
M 4	0.7	63	13	4.5	3.4	3.3	■	
M 5	0.8	70	15	6	4.9	4.2	■	
M 6	1	80	17	6	4.9	5.0		■
M 7	1	80	17	7	5.5	6.0		
M 8	1.25	90	20	8	6.2	6.8		■
M 9	1.25	90	20	9	7	7.8		
M 10	1.5	100	22	10	8	8.5		■
M 12	1.75	110	24	9	7	10.2		■
M 16	2	110	27	12	9	14.0		■

■ avialable – intermediate size on request

Carbide Machine Taps

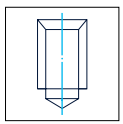
Cutting Data

DIN 371/376 VHM

RH spiral flutes 20°
for universal use

Group G260
for blind holes

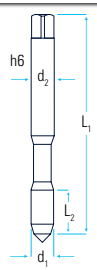
UNI



2xd$_1$

VHM tec CARBIDE by Schumacher

Art.-No.			G2600/40
Technology	i	Page 8.1	VHM tec
			Internal coolant
Champfer Length	i	Page 8.4	3-4 x P
Surface	i	Page 8.2	bright
Tolerance	i	Page 8.5	6HX
Cutting Data	i	Page 8.6	P1 general construction steel M1 chemical resistant steel N1 aluminium alloys N3 copper alloys



Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□		
M 3	0.5	56	11	3.5	2.7	2.5	
M 3.5	0.6	56	12	4	3	2.9	
M 4	0.7	63	13	4.5	3.4	3.3	
M 5	0.8	70	15	6	4.9	4.2	
M 6	1	80	17	6	4.9	5.0	■
M 7	1	80	17	7	5.5	6.0	
M 8	1.25	90	20	8	6.2	6.8	■
M 9	1.25	90	20	9	7	7.8	
M 10	1.5	100	22	10	8	8.5	■
M 12	1.75	110	24	9	7	10.2	■
M 16	2	110	27	12	9	14.0	■

■ avialable – intermediate size on request

Carbide Forming Taps

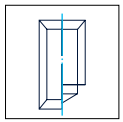
Cutting Data

DIN 371/376 VHM

straight oil grooves
for high strength steel

Group G060/G070
for blind and through holes

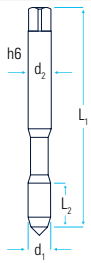
HIGH STRENGTH



2xd$_1$

VHM tec CARBIDE by Schumacher

Art.-No.			G0600/5360	G0700/5360
Technology	i	Page 8.1	VHM tec	VHM tec
			Internal coolant	
Champfer Length	i	Page 8.4	C / 2-3 x P	
Surface	i	Page 8.2	SG4	SG4
Tolerance	i	Page 8.5	6HX	6HX
Cutting Data	i	Page 8.6	P1 general construction steel	P2 high strength steel N1 aluminium alloys



Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□			
M 3	0.5	56	11	6	4.9	2.8	■	
M 3.5	0.6	56	12	6	4.9	3.25		
M 4	0.7	63	13	6	4.9	3.7	■	
M 5	0.8	70	15	6	4.9	4.65	■	
M 6	1	80	17	6	4.9	5.55		■
M 7	1	80	17	8	6.2	6.55		
M 8	1.25	90	20	8	6.2	7.4		■
M 9	1.25	90	20	10	8	8.4		
M 10	1.5	100	22	10	8	9.3		■
M 12	1.75	110	24	12	9	11.2		■
M 16	2	110	27	12	9	15.1		

■ avialable – intermediate size on request

Machine Taps

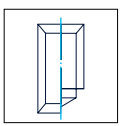
Cutting Data

DIN 374 HSS-E

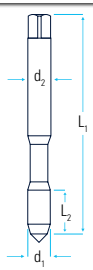
straight flutes
for general construction steel

Group 5000
for blind and through holes

STEEL



2xd$_1$



Art.-No.		50000
Technology	Page 8.1	
Champfer Length	Page 8.4	C / 2-3 x P
Surface	Page 8.2	bright
Tolerance	Page 8.5	ISO2 (6H)
Cutting Data	Page 8.6	P1 general construction steel

Ø d_1	P_{mm}	L_1	L_2	d_2	□	⌀	
M 4	0.5	63	10	2.8	2.1	3.5	■
M 5	0.5	70	11	3.5	2.7	4.5	■
M 6	0.5	80	13	4.5	3.4	5.5	■
M 6	0.75	80	13	4.5	3.4	5.3	■
M 8	0.75	80	14	6	4.9	7.3	■
M 10	0.75	90	18	7	5.5	9.3	■
M 8	1	90	17	6	4.9	7.0	■
M 10	1	90	18	7	5.5	9.0	■
M 12	1	100	18	9	7	11.0	■
M 14	1	100	18	11	9	13.0	■
M 16	1	100	18	12	9	15.0	■
M 18	1	110	20	14	11	17.0	■
M 20	1	125	20	16	12	19.0	■

Continuation »

■ avialable – intermediate size on request

Machine Taps

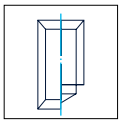
Cutting Data

DIN 374 HSS-E

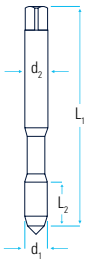
straight flutes
for general construction steel

Group 5000
for blind and through holes

STEEL



2xd$_1$



Art.-No.		50000
Technology	Page 8.1	
Champfer Length	Page 8.4	C / 2-3 x P
Surface	Page 8.2	bright
Tolerance	Page 8.5	ISO2 (6H)
Cutting Data	Page 8.6	P1 general construction steel

Ø d_1	P_{mm}	L_1	L_2	d_2	□		
M 22	1	125	20	18	14.5	21.0	■
M 24	1	140	20	18	14.5	23.0	■
M 10	1.25	100	22	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	9	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	27	18	14.5	22.5	■
M 26	1.5	140	28	18	14.5	24.5	■

Continuation »

■ avialable – intermediate size on request

Machine Taps

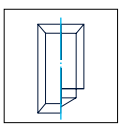
Cutting Data

DIN 374 HSS-E

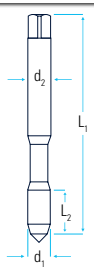
straight flutes
for general construction steel

Group 5000
for blind and through holes

STEEL



2xd$_1$



Art.-No.		50000
Technology	Page 8.1	
Champfer Length	Page 8.4	C / 2-3 x P
Surface	Page 8.2	bright
Tolerance	Page 8.5	ISO2 (6H)
Cutting Data	Page 8.6	P1 general construction steel

Ø d_1	P_{mm}	L_1	L_2	d_2	□		
M 28	1.5	140	28	20	16	26.5	■
M 30	1.5	150	30	22	18	28.5	■
M 32	1.5	150	30	22	18	30.5	■
M 34	1.5	170	33	28	22	32.5	■
M 36	1.5	170	33	28	22	34.5	■
M 38	1.5	170	33	28	22	36.5	■
M 40	1.5	170	33	32	24	38.5	■
M 42	1.5	170	33	32	24	40.5	■
M 45	1.5	180	33	36	29	43.5	■
M 48	1.5	190	36	36	29	46.5	■
M 18	2	125	26	14	11	16.0	■
M 20	2	140	27	16	12	18.0	■
M 22	2	140	27	18	14.5	20.0	■

Continuation »

■ avialable – intermediate size on request

Machine Taps

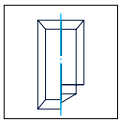
Cutting Data

DIN 374 HSS-E

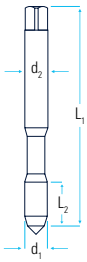
straight flutes
for general construction steel

Group 5000
for blind and through holes

STEEL



2xd$_1$



Art.-No.		50000
Technology	Page 8.1	
Champfer Length	Page 8.4	C / 2-3 x P
Surface	Page 8.2	bright
Tolerance	Page 8.5	ISO2 (6H)
Cutting Data	Page 8.6	P1 general construction steel

Ø d_1	P_{mm}	L_1	L_2	d_2	□		
M 24	2	140	27	18	14.5	22.0	■
M 27	2	140	28	20	16	25.0	■
M 30	2	150	30	22	18	28.0	■
M 33	2	160	32	25	20	31.0	■
M 36	2	170	33	28	22	34.0	■
M 39	2	170	33	32	24	37.0	■
M 40	2	170	33	32	24	38.0	■
M 42	2	180	33	32	24	40.0	■
M 45	2	180	33	36	29	43.0	■
M 36	3	200	45	28	22	33.0	■
M 39	3	200	45	32	24	36.0	■
M 42	3	200	45	32	24	39.0	■
M 45	3	200	45	36	29	42.0	■
M 48	3	225	50	36	29	45.0	■

■ avialable – intermediate size on request

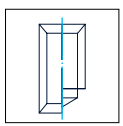
Machine Taps White Ring

Cutting Data

DIN 374 HSS-E
straight flutes
for cast iron

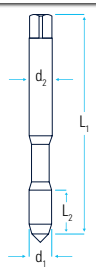
Group 5030
for blind and through holes

CAST IRON



2xd$_1$

Art.-No.			50300/01
Technology	i	Page 8.1	White Ring
Champfer Length	i	Page 8.4	C / 2-3 x P
Surface	i	Page 8.2	nitrided
Tolerance	i	Page 8.5	6HX
Cutting Data	i	Page 8.6	K1 grey cast iron N7 duroplastics



Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□		
M 5	0.5	70	11	3.5	2.7	4.5	
M 6	0.5	80	13	4.5	3.4	5.5	
M 6	0.75	80	13	4.5	3.4	5.3	
M 8	1	90	17	6	4.9	7.0	■
M 10	1	90	18	7	5.5	9.0	■
M 12	1	100	18	9	7	11.0	■
M 14	1	100	18	11	9	13.0	■
M 10	1.25	100	22	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	9	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	27	18	14.5	22.5	■

■ avialable – intermediate size on request

Machine Taps

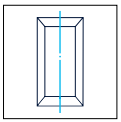
Cutting Data

DIN 374 HSS-E

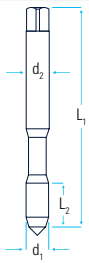
Spiral point
for general construction steel

Group 5100
for through holes

STEEL



2xd$_1$



Art.-No.			51000	51000/25
Technology	i	Page 8.1	High Volume	High Volume
Champfer Length	i	Page 8.4	B / 3,5-5 x P	
Surface	i	Page 8.2	bright	TiN
Tolerance	i	Page 8.5	ISO2 (6H)	ISO2 (6H)
Cutting Data	i	Page 8.6	P1 general construction steel	K2+K3 spheroidal and malleable cast iron

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□			
M 4	0.5	63	10	2.8	2.1	3.5	■	
M 5	0.5	70	11	3.5	2.7	4.5	■	
M 6	0.5	80	13	4.5	3.4	5.5	■	
M 6	0.75	80	13	4.5	3.4	5.2	■	
M 8	0.75	80	14	6	4.9	7.3	■	
M 10	0.75	90	18	7	5.5	9.3	■	
M 8	1	90	17	6	4.9	7.0	■	■
M 10	1	90	18	7	5.5	9.0	■	■
M 12	1	100	18	9	7	11.0	■	■
M 14	1	100	18	11	9	13.0	■	■
M 16	1	100	18	12	9	15.0	■	
M 18	1	110	20	14	11	17.0	■	

Continuation »

■ avialable – intermediate size on request

Machine Taps

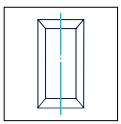
Cutting Data

DIN 374 HSS-E

Spiral point
for general construction steel

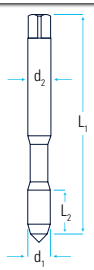
Group 5100
for through holes

STEEL



2xd$_1$

High Speed Cutting by Schumacher



Art.-No.			51000	51000/25
Technology	i	Page 8.1	High Volume	High Volume
Champfer Length	i	Page 8.4	B / 3,5-5 x P	
Surface	i	Page 8.2	bright	TiN
Tolerance	i	Page 8.5	ISO2 (6H)	ISO2 (6H)
Cutting Data	i	Page 8.6	P1 general construction steel	K2+K3 spheroidal and malleable cast iron

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□			
M 20	1	125	20	16	12	19.0	■	
M 22	1	125	20	18	14.5	21.0	■	
M 24	1	140	20	18	14.5	23.0	■	
M 10	1.25	100	22	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	9	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	■	■

Continuation »

■ avialable – intermediate size on request

Machine Taps

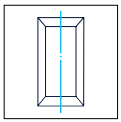
Cutting Data

DIN 374 HSS-E

Spiral point
for general construction steel

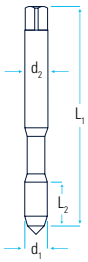
Group 5100
for through holes

STEEL



2xd$_1$

High Speed Cutting by Schumacher



Art.-No.			51000	51000/25
Technology	i	Page 8.1	High Volume	High Volume
Champfer Length	i	Page 8.4	B / 3,5-5 x P	
Surface	i	Page 8.2	bright	TiN
Tolerance	i	Page 8.5	ISO2 (6H)	ISO2 (6H)
Cutting Data	i	Page 8.6	P1 general construction steel	K2+K3 spheroidal and malleable cast iron

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□		
M 26	1.5	140	28	18	14.5	24.5	■
M 28	1.5	140	28	20	16	26.5	■
M 30	1.5	150	30	22	18	28.5	■
M 32	1.5	150	30	22	18	30.5	■
M 34	1.5	170	33	28	22	32.5	■
M 36	1.5	170	33	28	22	34.5	■
M 38	1.5	170	33	28	22	36.5	■
M 40	1.5	170	33	32	24	38.5	■
M 42	1.5	170	33	32	24	40.5	■
M 45	1.5	180	33	36	29	43.5	■
M 48	1.5	190	36	36	29	46.5	■
M 18	2	125	26	14	11	16.0	■
M 20	2	140	27	16	12	18.0	■
M 22	2	140	27	18	14.5	20.0	■

Continuation »

■ avialable – intermediate size on request

Machine Taps

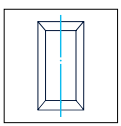
Cutting Data

DIN 374 HSS-E

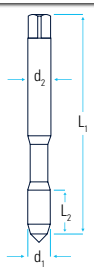
Spiral point
for general construction steel

Group 5100
for through holes

STEEL



2xd$_1$



Art.-No.		51000
Technology	Page 8.1	High Volume
Champfer Length	Page 8.4	B / 3,5-5 x P
Surface	Page 8.2	bright
Tolerance	Page 8.5	ISO2 (6H)
Cutting Data	Page 8.6	P1 general construction steel K2+K3 spheroidal and malleable cast iron

Ø d_1	P_{mm}	L_1	L_2	d_2	□		
M 24	2	140	27	18	14.5	22.0	■
M 27	2	140	28	20	16	25.0	■
M 30	2	150	30	22	18	28.0	■
M 33	2	160	32	25	20	31.0	■
M 36	2	170	33	28	22	34.0	■
M 39	2	170	33	32	24	37.0	■
M 40	2	170	33	32	24	38.0	■
M 42	2	180	33	32	24	40.0	■
M 45	2	180	33	36	29	43.0	■
M 36	3	200	45	28	22	33.0	■
M 39	3	200	45	32	24	36.0	■
M 42	3	200	45	32	24	39.0	■
M 45	3	200	45	36	29	42.0	■
M 48	3	225	50	36	29	45.0	■

■ avialable – intermediate size on request

SCHUMACHER

Machine Taps Blue Ring

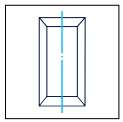
Cutting Data

DIN 374 HSS-E

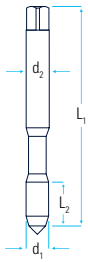
Spiral point
for chemical resistant steel

Group 5120
for through holes

INOX
Stainless



2xd$_1$



Art.-No.			51200	51200/25
Technology	i	Page 8.1	Blue Ring	Blue Ring
Champfer Length	i	Page 8.4	B / 3,5-5 x P	
Surface	i	Page 8.2	bright	TiN
Tolerance	i	Page 8.5	ISO2 (6H)	ISO2 (6H)
Cutting Data	i	Page 8.6	P2 high strength steel	M1 chemical resistant steel

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□			
M 5	0.5	70	11	3.5	2.7	4.5	■	
M 6	0.5	80	13	4.5	3.4	5.5	■	
M 6	0.75	80	13	4.5	3.4	5.3	■	
M 8	1	90	17	6	4.9	7.0	■	■
M 10	1	90	18	7	5.5	9.0	■	■
M 12	1	100	18	9	7	11.0	■	■
M 14	1	100	18	11	9	13.0	■	■
M 10	1.25	100	22	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	9	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	27	18	14.5	22.5	■	■

■ avialable – intermediate size on request

Machine Taps Black Ring

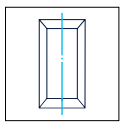
Cutting Data

DIN 374 HSS-E

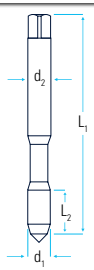
Spiral point
for universal use

Group 5190
for through holes

UNI



2xd$_1$



Art.-No.		51900/26
Technology	Page 8.1	
		Black Ring
Champfer Length	Page 8.4	B / 3,5-5 x P
Surface	Page 8.2	VAP
Tolerance	Page 8.5	ISO2 (6H)
Cutting Data	Page 8.6	P1 general construction steel M1 chemical resistant steel N1 Aluminium N3 copper alloys

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□	⌀	
M 6	0.75	80	13	4.5	3.4	5.3	
M 8	1	90	17	6	4.9	7.0	■
M 10	1	90	18	7	5.5	9.0	■
M 12	1	100	18	9	7	11.0	■
M 14	1	100	18	11	9	13.0	■
M 10	1.25	100	22	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	9	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	27	18	14.5	22.5	
M 26	1.5	140	28	18	14.5	24.5	
M 30	1.5	150	30	22	18	28.5	

■ avialable – intermediate size on request

SCHUMACHER

Cutting Data

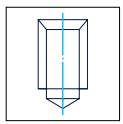
Machine Taps

DIN 374 HSS-E

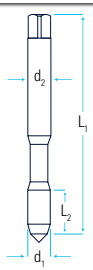
RH spiral flutes 15°
for general construction steel

Group 5200
for blind holes

STEEL



2xd$_1$



Art.-No.		52000
Technology	Page 8.1	
Champfer Length	Page 8.4	C / 2-3 x P
Surface	Page 8.2	bright
Tolerance	Page 8.5	ISO2 (6H)
Cutting Data	Page 8.6	P1 general construction steel K2+K3 spheroidal and malleable cast iron

Ø d_1	P_{mm}	L_1	L_2	d_2	□		
M 6	0.75	80	13	4.5	3.4	5.3	
M 8	1	90	17	6	4.9	7.0	■
M 10	1	90	18	7	5.5	9.0	■
M 12	1	100	18	9	7	11.0	■
M 14	1	100	18	11	9	13.0	■
M 10	1.25	100	22	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	9	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	27	18	14.5	22.5	■
M 26	1.5	140	28	18	14.5	24.5	■
M 30	1.5	150	30	22	18	28.5	■

■ avialable – intermediate size on request

Machine Taps

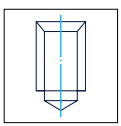
Cutting Data

DIN 374 HSS-E

RH spiral flutes 40°
for general construction steel

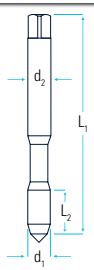
Group 5300
for blind holes

STEEL



2xd$_1$

High Speed Cutting by Schumacher



Art.-No.			53000	53000/25
Technology	i	Page 8.1	High Volume	High Volume
Champfer Length	i	Page 8.4	C / 2-3 x P	
Surface	i	Page 8.2	bright	TiN
Tolerance	i	Page 8.5	ISO2 (6H)	ISO2 (6H)
Cutting Data	i	Page 8.6	P1 general construction steel	K2+K3 spheroidal and malleable cast iron

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□			
M 6	0.75	80	8	4.5	3.4	5.3		
M 8	1	90	10	6	4.9	7.0	■	■
M 10	1	90	10	7	5.5	9.0	■	■
M 12	1	100	11	9	7	11.0	■	■
M 14	1	100	11	11	9	13.0	■	■
M 10	1.25	100	16	7	5.5	8.8	■	■
M 12	1.25	100	15	9	7	10.8	■	■
M 12	1.5	100	15	9	7	10.5	■	■
M 14	1.5	100	15	11	9	12.5	■	■
M 16	1.5	100	15	12	9	14.5	■	■
M 18	1.5	110	17	14	11	16.5	■	■
M 20	1.5	125	17	16	12	18.5	■	■
M 22	1.5	125	17	18	14.5	20.5	■	■
M 24	1.5	140	20	18	14.5	22.5	■	■
M 26	1.5	140	20	18	14.5	24.5	■	
M 30	1.5	150	22	22	18	28.5	■	

■ avialable – intermediate size on request

SCHUMACHER

Machine Taps Black Ring

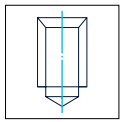
Cutting Data

DIN 374 HSS-E

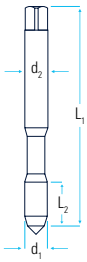
RH spiral flutes 40°
for universal use

Group 5330
for blind holes

UNI



2xd$_1$



Art.-No.		53300/26
Technology	Page 8.1	Black Ring
Champfer Length	Page 8.4	C / 2-3 x P
Surface	Page 8.2	VAP
Tolerance	Page 8.5	ISO2 (6H)
Cutting Data	Page 8.6	P1 general construction steel M1 chemical resistant steel N1 Aluminium N3 copper alloys

Ø d_1	P_{mm}	L_1	L_2	d_2	□		
M 6	0.75	80	8	4.5	3.4	5.3	
M 8	1	90	10	6	4.9	7.0	■
M 10	1	90	10	7	5.5	9.0	■
M 12	1	100	11	9	7	11.0	■
M 14	1	100	11	11	9	13.0	■
M 10	1.25	100	16	7	5.5	8.8	■
M 12	1.25	100	15	9	7	10.8	■
M 12	1.5	100	15	9	7	10.5	■
M 14	1.5	100	15	11	9	12.5	■
M 16	1.5	100	15	12	9	14.5	■
M 18	1.5	110	17	14	11	16.5	■
M 20	1.5	125	17	16	12	18.5	■
M 22	1.5	125	17	18	14.5	20.5	
M 24	1.5	140	20	18	14.5	22.5	
M 26	1.5	140	20	18	14.5	24.5	
M 30	1.5	150	22	22	18	28.5	

■ avialable – intermediate size on request

Machine Taps Blue Ring

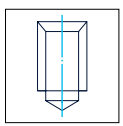
Cutting Data

DIN 374 HSS-E

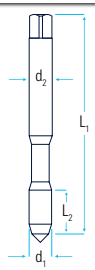
RH spiral flutes 40°
for chemical resistant steel

Group 5350
for blind holes

INOX
Stainless



2xd$_1$



Art.-No.			53500	53500/25
Technology	i	Page 8.1	Blue Ring	Blue Ring
Champfer Length	i	Page 8.4	C / 2-3 x P	
Surface	i	Page 8.2	bright	TiN
Tolerance	i	Page 8.5	ISO2 (6H)	ISO2 (6H)
Cutting Data	i	Page 8.6	P2 high strength steel	M1 chemical resistant steel

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□			
M 5	0.5	70	5	3.5	2.7	4.5		
M 6	0.5	80	5	4.5	3.4	5.5		
M 6	0.75	80	8	4.5	3.4	5.2		
M 8	1	90	10	6	4.9	7.0	■	■
M 10	1	90	10	7	5.5	9.0	■	■
M 12	1	100	11	9	7	11.0	■	■
M 14	1	100	11	11	9	13.0	■	■
M 10	1.25	100	16	7	5.5	8.8	■	■
M 12	1.25	100	15	9	7	10.8	■	■
M 12	1.5	100	15	9	7	10.5	■	■
M 14	1.5	100	15	11	9	12.5	■	■
M 16	1.5	100	15	12	9	14.5	■	■
M 18	1.5	110	17	14	11	16.5	■	■
M 20	1.5	125	17	16	12	18.5	■	■
M 22	1.5	125	17	18	14.5	20.5	■	■
M 24	1.5	140	20	18	14.5	22.5	■	■

■ avialable – intermediate size on request

Set of Taps

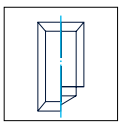
Cutting Data

DIN 2181 HSS-E

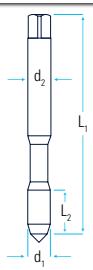
set of 2 pieces, straight flutes
for general construction steel

Group 1200
for blind and through holes

STEEL



2xd$_1$



Art.-No.			12100	12200
Technology	i	Page 8.1		
Champfer Length	i	Page 8.4	D / 3,5-5 x P	C / 2-3 x P
Surface	i	Page 8.2	bright	bright
Tolerance	i	Page 8.5	Nr. 1	Nr. 2 = ISO2 (6H)
Cutting Data	i	Page 8.6	P1 general construction steel	K2+K3 spheroidal and malleable cast iron

Ø d_1	P_{mm}	L_1	L_2	d_2	□			
M 6	0.5	56	13	6	4.9	5.5	■	■
M 6	0.75	56	14	6	4.9	5.3	■	■
M 8	0.75	63	14	6	4.9	7.3	■	■
M 10	0.75	63	18	7	5.5	9.3	■	■
M 8	1	63	17	6	4.9	7.0	■	■
M 10	1	63	18	7	5.5	9.0	■	■
M 12	1	70	18	9	7	11.0	■	■
M 14	1	70	18	11	9	13.0	■	■
M 16	1	70	20	12	9	15.0	■	■
M 18	1	80	18	14	11	17.0	■	■
M 20	1	80	18	16	12	19.0	■	■
M 10	1.25	70	22	7	5.5	8.8	■	■
M 12	1.25	70	20	9	7	10.8	■	■
M 14	1.25	70	20	11	9	12.8	■	■

Continuation »

■ avialable – intermediate size on request

Set of Taps

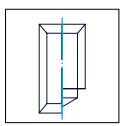
Cutting Data

DIN 2181 HSS-E

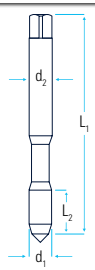
set of 2 pieces, straight flutes
for general construction steel

Group 1200
for blind and through holes

STEEL



2xd$_1$



Art.-No.			12100	12200
Technology	i	Page 8.1		
Champfer Length	i	Page 8.4	D / 3,5-5 x P	C / 2-3 x P
Surface	i	Page 8.2	bright	bright
Tolerance	i	Page 8.5	Nr. 1	Nr. 2 = ISO2 (6H)
Cutting Data	i	Page 8.6	P1 general construction steel	K2+K3 spheroidal and malleable cast iron

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□			
M 12	1.5	70	20	9	7	10.5	■	■
M 14	1.5	70	20	11	9	12.5	■	■
M 16	1.5	70	20	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	■	■
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	25	22	18	30.5	■	■
M 33	1.5	100	25	25	20	31.5	■	■
M 34	1.5	100	25	28	22	32.5	■	■

Continuation »

■ avialable – intermediate size on request

Set of Taps

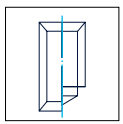
Cutting Data

DIN 2181 HSS-E

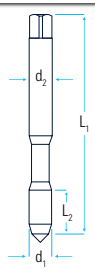
set of 2 pieces, straight flutes
for general construction steel

Group 1200
for blind and through holes

STEEL



2xd$_1$



Art.-No.			12100	12200
Technology	i	Page 8.1		
Champfer Length	i	Page 8.4	D / 3,5-5 x P	C / 2-3 x P
Surface	i	Page 8.2	bright	bright
Tolerance	i	Page 8.5	Nr. 1	Nr. 2 = ISO2 (6H)
Cutting Data	i	Page 8.6	P1 general construction steel	K2+K3 spheroidal and malleable cast iron

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□			
M 35	1.5	100	25	28	22	33.5	■	■
M 36	1.5	100	25	28	22	34.5	■	■
M18	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	36	32	24	39.0	■	■
M 45	3	125	36	36	29	42.0	■	■
M 48	3	140	36	36	29	45.0	■	■

■ avialable – intermediate size on request

Carbide Machine Taps

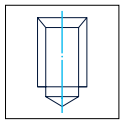
Cutting Data

DIN 374 Solid Carbide

straight flutes
for hard materials

Group G580
for blind holes

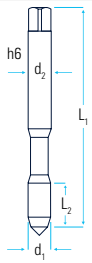
HARD



2xd$_1$

VHM tec CARBIDE by Schumacher

Art.-No.		G5800/40
Technology	Page 8.1	VHM tec
		Internal coolant
Champfer Length	Page 8.4	C / 2-3 x P
Surface	Page 8.2	bright
Tolerance	Page 8.5	6HX
Cutting Data	Page 8.6	K1 grey cast iron N3 copper alloys H1 hard materials



Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□		
M 8	1	90	17	6	4.9	7.0	■
M 10	1	90	18	7	5.5	9.0	■
M 12	1.5	100	22	9	7	10.5	■

■ avialable – intermediate size on request

Cutting Data

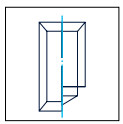
Machine Taps

DIN 5156 HSS-E

straight flutes
for general construction steel

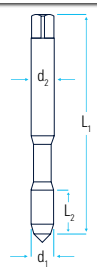
Group 5500
for blind and through holes

STEEL



2xd$_1$

Art.-No.			55000
Technology	i	Page 8.1	
Champfer Length	i	Page 8.4	C / 2-3 x P
Surface	i	Page 8.2	bright
Tolerance	i	Page 8.5	
Cutting Data	i	Page 8.6	P1 general construction steel



Ø d_1	P	L_1	L_2	d_2	□		
G 1/8"	28	90	20	7	5.5	8.8	■
G 1/4"	19	100	22	11	9	11.8	■
G 3/8"	19	100	22	12	9	15.3	■
G 1/2"	14	125	25	16	12	19.0	■
G 5/8"	14	125	25	18	14.5	21.0	■
G 3/4"	14	140	28	20	16	24.5	■
G 7/8"	14	150	28	22	18	28.3	■
G 1"	11	160	30	25	20	30.8	■
G 1 1/4"	11	170	30	32	24	39.5	■
G 1 1/2"	11	190	32	36	29	45.3	■

■ avialable – intermediate size on request

Machine Taps White Ring

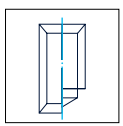
Cutting Data

DIN 5156 HSS-E

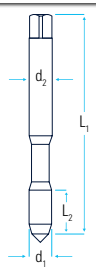
straight flutes
for cast iron

Group 5530
for blind and through holes

CAST IRON



2xd$_1$



Art.-No.		55300/01
Technology	Page 8.1	White Ring
Champfer Length	Page 8.4	C / 2-3 x P
Surface	Page 8.2	nitrided
Tolerance	Page 8.5	
Cutting Data	Page 8.6	K1 grey cast iron N7 duroplastics

Ø d_1	P	L_1	L_2	d_2	□		
G 1/8"	28	90	20	7	5.5	8.8	■
G 1/4"	19	100	22	11	9	11.8	■
G 3/8"	19	100	22	12	9	15.3	■
G 1/2"	14	125	25	16	12	19.0	■
G 5/8"	14	125	25	18	14.5	21.0	
G 3/4"	14	140	28	20	16	24.5	■
G 7/8"	14	150	28	22	18	28.3	■
G 1"	11	160	30	25	20	30.8	■
G 1 1/4"	11	170	30	32	24	39.5	■
G 1 1/2"	11	190	32	36	29	45.3	■

■ avialable – intermediate size on request

Machine Taps

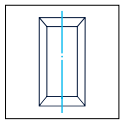
Cutting Data

DIN 5156 HSS-E

Spiral point
for general construction steel

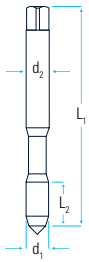
Group 5600
for through holes

STEEL



2xd$_1$

High Speed Cutting by Schumacher



Art.-No.			56000	56000/25
Technology	i	Page 8.1	High Volume	High Volume
Champfer Length	i	Page 8.4	B / 3,5-5 x P	
Surface	i	Page 8.2	bright	TiN
Tolerance	i	Page 8.5		
Cutting Data	i	Page 8.6	P1 general construction steel	K2+K3 spheroidal and malleable cast iron

Ø d$_1$	P	L$_1$	L$_2$	d$_2$	□			
G 1/8"	28	90	20	7	5.5	8.8	■	■
G 1/4"	19	100	22	11	9	11.8	■	■
G 3/8"	19	100	22	12	9	15.3	■	■
G 1/2"	14	125	25	16	12	19.0	■	■
G 5/8"	14	125	25	18	14.5	21.0	■	■
G 3/4"	14	140	28	20	16	24.5	■	■
G 7/8"	14	150	28	22	18	28.3	■	■
G 1"	11	160	30	25	20	30.8	■	■
G 1 1/4"	11	170	30	32	24	39.5	■	■
G 1 1/2"	11	190	32	36	29	45.3	■	■

■ avialable – intermediate size on request

Machine Taps Blue Ring

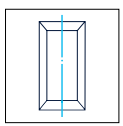
Cutting Data

DIN 5156 HSS-E

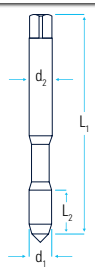
Spiral point
for chemical resistant steel

Group 5620
for through holes

INOX
Stainless



2xd$_1$



Art.-No.			56200	56200/25
Technology	i	Page 8.1	Blue Ring	Blue Ring
Champfer Length	i	Page 8.4	B / 3,5-5 x P	
Surface	i	Page 8.2	bright	TiN
Tolerance	i	Page 8.5		
Cutting Data	i	Page 8.6	P2 high strength steel	M1 chemical resistant steel

Ø d$_1$	P	L$_1$	L$_2$	d$_2$	□			
G 1/8"	28	90	20	7	5.5	8.8	■	■
G 1/4"	19	100	22	11	9	11.8	■	■
G 3/8"	19	100	22	12	9	15.3	■	■
G 1/2"	14	125	25	16	12	19.0	■	■
G 5/8"	14	125	25	18	14.5	21.0		
G 3/4"	14	140	28	20	16	24.5	■	■
G 7/8"	14	150	28	22	18	28.3		
G 1"	11	160	30	25	20	30.8	■	■
G 1 1/4"	11	170	30	32	24	39.5		
G 1 1/2"	11	190	32	36	29	45.3		

■ avialable – intermediate size on request

Machine Taps Black Ring

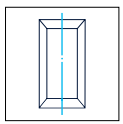
Cutting Data

DIN 5156 HSS-E

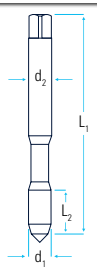
Spiral point
for universal use

Group 5690
for through holes

UNI



2xd$_1$



Art.-No.		56900/26
Technology	Page 8.1	
		Black Ring
Champfer Length	Page 8.4	B / 3,5-5 x P
Surface	Page 8.2	VAP
Tolerance	Page 8.5	
Cutting Data	Page 8.6	P1 general construction steel M1 chemical resistant steel N1 Aluminium N3 copper alloys

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□		
G 1/8"	28	90	20	7	5.5	8.8	■
G 1/4"	19	100	22	11	9	11.8	■
G 3/8"	19	100	22	12	9	15.3	■
G 1/2"	14	125	25	16	12	19.0	■
G 5/8"	14	125	25	18	14.5	21.0	
G 3/4"	14	140	28	20	16	24.5	■
G 7/8"	14	150	28	22	18	28.3	
G 1"	11	160	30	25	20	30.8	■
G 1 1/4"	11	170	30	32	24	39.5	
G 1 1/2"	11	190	32	36	29	45.3	

■ avialable – intermediate size on request

Machine Taps

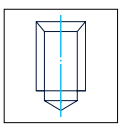
Cutting Data

DIN 5156 HSS-E

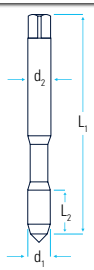
RH spiral flutes 15°
for general construction steel

Group 5700
for blind holes

STEEL



2xd$_1$



Art.-No.		57000
Technology	Page 8.1	
Champfer Length	Page 8.4	C / 2-3 x P
Surface	Page 8.2	bright
Tolerance	Page 8.5	
Cutting Data	Page 8.6	P1 general construction steel K2+K3 spheroidal and malleable cast iron

Ø d_1	P	L_1	L_2	d_2	□		
G 1/8"	28	90	20	7	5.5	8.8	■
G 1/4"	19	100	22	11	9	11.8	■
G 3/8"	19	100	22	12	9	15.3	■
G 1/2"	14	125	25	16	12	19.0	■
G 5/8"	14	125	25	18	14.5	21.0	
G 3/4"	14	140	28	20	16	24.5	■
G 7/8"	14	150	28	22	18	28.3	
G 1"	11	160	30	25	20	30.8	■
G 1 1/4"	11	170	30	32	24	39.5	■
G 1 1/2"	11	190	32	36	29	45.3	■

■ avialable – intermediate size on request

Machine Taps

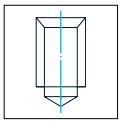
Cutting Data

DIN 5156 HSS-E

RH spiral flutes 40°
for general construction steel

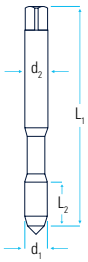
Group 5800
for blind holes

STEEL



2xd$_1$

High Speed Cutting by Schumacher



Art.-No.			58000	58000/25
Technology	i	Page 8.1	High Volume	High Volume
Champfer Length	i	Page 8.4	C / 2-3 x P	
Surface	i	Page 8.2	bright	TiN
Tolerance	i	Page 8.5		
Cutting Data	i	Page 8.6	P1 general construction steel	K2+K3 spheroidal and malleable cast iron

Ø d$_1$	P	L$_1$	L$_2$	d$_2$	□			
G 1/8"	28	90	20	7	5.5	8.8	■	■
G 1/4"	19	100	22	11	9	11.8	■	■
G 3/8"	19	100	22	12	9	15.3	■	■
G 1/2"	14	125	25	16	12	19.0	■	■
G 5/8"	14	125	25	18	14.5	21.0	■	■
G 3/4"	14	140	28	20	16	24.5	■	■
G 7/8"	14	150	28	22	18	28.3	■	■
G 1"	11	160	30	25	20	30.8	■	■
G 1 1/4"	11	170	30	32	24	39.5	■	■
G 1 1/2"	11	190	32	36	29	45.3	■	■

■ avialable – intermediate size on request

Machine Taps Black Ring

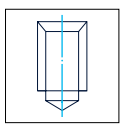
Cutting Data

DIN 5156 HSS-E

RH spiral flutes 40°
for universal use

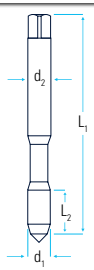
Group 5830
for blind holes

UNI



2xd$_1$

Art.-No.			58300/26
Technology	i	Page 8.1	
			Black Ring
Champfer Length	i	Page 8.4	C / 2-3 x P
Surface	i	Page 8.2	VAP
Tolerance	i	Page 8.5	
Cutting Data	i	Page 8.6	P1 general construction steel M1 chemical resistant steel N1 Aluminium N3 copper alloys



Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□		
G 1/8"	28	90	20	7	5.5	8.8	■
G 1/4"	19	100	22	11	9	11.8	■
G 3/8"	19	100	22	12	9	15.3	■
G 1/2"	14	125	25	16	12	19.0	■
G 5/8"	14	125	25	18	14.5	21.0	
G 3/4"	14	140	28	20	16	24.5	■
G 7/8"	14	150	28	22	18	28.3	
G 1"	11	160	30	25	20	30.8	■
G 1 1/4"	11	170	30	32	24	39.5	
G 1 1/2"	11	190	32	36	29	45.3	

■ avialable – intermediate size on request

Machine Taps Blue Ring

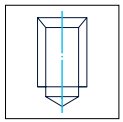
Cutting Data

DIN 5156 HSS-E

RH spiral flutes 40°
for chemical resistant steel

Group 5850
for blind holes

INOX
Stainless



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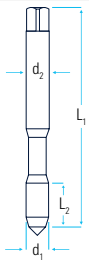


Art.-No.			58500	58500/25
Technology	i	Page 8.1	Blue Ring	Blue Ring
Champfer Length	i	Page 8.4	C / 2-3 x P	
Surface	i	Page 8.2	bright	TiN
Tolerance	i	Page 8.5		
Cutting Data	i	Page 8.6	P2 high strength steel	M1 chemical resistant steel

Ø d$_1$	P	L$_1$	L$_2$	d$_2$	□			
G 1/8"	28	90	20	7	5.5	8.8	■	■
G 1/4"	19	100	22	11	9	11.8	■	■
G 3/8"	19	100	22	12	9	15.3	■	■
G 1/2"	14	125	25	16	12	19.0	■	■
G 5/8"	14	125	25	18	14.5	21.0		
G 3/4"	14	140	28	20	16	24.5	■	■
G 7/8"	14	150	28	22	18	28.3		
G 1"	11	160	30	25	20	30.8	■	■
G 1 1/4"	11	170	30	32	24	39.5		
G 1 1/2"	11	190	32	36	29	45.3		

■ avialable – intermediate size on request

SCHUMACHER

Short Machine Taps

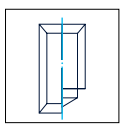
Cutting Data

DIN 5157 HSS-E

straight flutes
for copper alloys

Group 1350
for blind and through holes

MS



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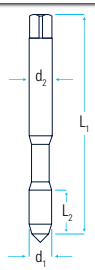


Art.-No.		13500
Technology	Page 8.1	
Champfer Length	Page 8.4	E / 1,5-2 x P
Surface	Page 8.2	bright
Tolerance	Page 8.5	
Cutting Data	Page 8.6	N3 copper alloys

Ø d$_1$	P	L$_1$	L$_2$	d$_2$	□		
G 1/8"	28	63	22	7	5.5	8.8	■
G 1/4"	19	70	22	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	40	28	22	35.5	
G 1 1/4"	11	125	40	32	24	39.5	■
G 1 3/8"	11	125	40	36	29	41.75	■
G 1 1/2"	11	140	40	36	29	45.3	■
G 1 3/4"	11	140	40	40	32	51.0	
G 2"	11	160	40	45	35	57.0	

■ avialable – intermediate size on request

Short Machine Taps

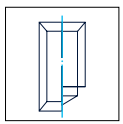
Cutting Data

DIN 5157 HSS-E

straight flutes
for cast iron

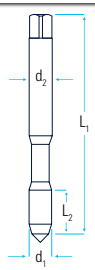
Group 1360
for blind and through holes

CAST IRON



2xd$_1$

Art.-No.		13600/01
Technology	i Page 8.1	
Champfer Length	i Page 8.4	C / 2-3 x P
Surface	i Page 8.2	nitrided
Tolerance	i Page 8.5	
Cutting Data	i Page 8.6	K1 grey cast iron N7 duroplastics



Ø d$_1$	P	L$_1$	L$_2$	d$_2$	□		
G 1/8"	28	63	22	7	5.5	8.8	■
G 1/4"	19	70	22	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	40	28	22	35.5	■
G 1 1/4"	11	125	40	32	24	39.5	■
G 1 3/8"	11	125	40	36	29	41.75	■
G 1 1/2"	11	140	40	36	29	45.3	■
G 1 3/4"	11	140	40	40	32	51.0	
G 2"	11	160	40	45	35	57.0	

■ avialable – intermediate size on request

SCHUMACHER

Set of Taps

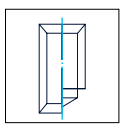
Cutting Data

DIN 5157 HSS-E

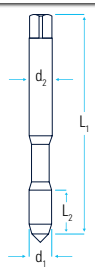
set of 2 pieces, straight flutes
for general construction steel

Group 1300
for blind and through holes

STEEL



2xd$_1$



Art.-No.			13100	13200
Technology	i	Page 8.1		
Champfer Length	i	Page 8.4	D / 3,5-5 x P	C / 2-3 x P
Surface	i	Page 8.2	bright	bright
Tolerance	i	Page 8.5	Nr. 1	Nr. 2
Cutting Data	i	Page 8.6	P1 general construction steel	K2+K3 spheroidal and malleable cast iron

Ø d$_1$	P	L$_1$	L$_2$	d$_2$	□			
G 1/8"	28	63	22	7	5.5	8.8	■	■
G 1/4"	19	70	22	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	40	28	22	35.5	■	■
G 1 1/4"	11	125	40	32	24	39.5	■	■
G 1 3/8"	11	125	40	36	29	41.75	■	■
G 1 1/2"	11	140	40	36	29	45.3	■	■
G 1 3/4"	11	140	40	40	32	51.0	■	■
G 2"	11	160	40	45	35	57.0	■	■

■ avialable – intermediate size on request

Machine Taps

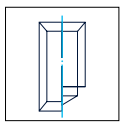
Cutting Data

DIN 371 HSS-E

straight flutes
for general construction steel

Group 3400
for blind and through holes

STEEL



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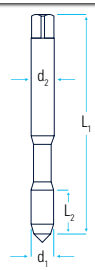


Art.-No.		34000
Technology	Page 8.1	
Champfer Length	Page 8.4	C / 2-3 x P
Surface	Page 8.2	bright
Tolerance	Page 8.5	2 B
Cutting Data	Page 8.6	P1 general construction steel

Ø d$_1$	P	L$_1$	L$_2$	d$_2$	□		
Nr. 4	40	56	11	3.5	2.7	2.35	■
Nr. 5	40	56	11	3.5	2.7	2.65	■
Nr. 6	32	56	12	4	3	2.85	■
Nr. 8	32	63	13	4.5	3.4	3.5	■
Nr. 10	24	70	15	6	4.9	3.9	■
Nr. 12	24	80	17	6	4.9	4.5	■
1/4"	20	80	17	7	5.5	5.2	■
5/16"	18	90	20	8	6.2	6.6	■
3/8"	16	100	22	9	7	8.0	■

■ avialable – intermediate size on request

Machine Taps

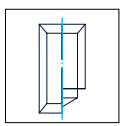
Cutting Data

DIN 376 HSS-E

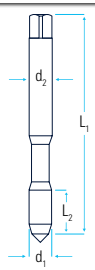
straight flutes
for general construction steel

Group 4400
for blind and through holes

STEEL



2xd$_1$



Art.-No.		44000
Technology	Page 8.1	
Champfer Length	Page 8.4	C / 2-3 x P
Surface	Page 8.2	bright
Tolerance	Page 8.5	2 B
Cutting Data	Page 8.6	P1 general construction steel

Ø d_1	P	L_1	L_2	d_2	□		
7/16"	14	100	22	8	6.2	9.4	■
1/2"	13	110	25	9	7	10.8	■
9/16"	12	110	26	11	9	12.2	■
5/8"	11	110	27	12	9	13.6	■
3/4"	10	125	30	14	11	16.5	■
7/8"	9	140	32	18	14.5	19.5	■
1"	8	160	36	20	16	22.3	■

■ avialable – intermediate size on request

Machine Taps White Ring

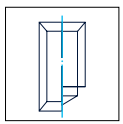
Cutting Data

DIN 371 HSS-E

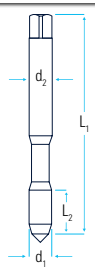
straight flutes
for cast iron

Group 3430
for blind and through holes

CAST IRON



2xd$_1$



Art.-No.			34300/01
Technology	i	Page 8.1	White Ring
Champfer Length	i	Page 8.4	C / 2-3 x P
Surface	i	Page 8.2	nitrided
Tolerance	i	Page 8.5	2 B
Cutting Data	i	Page 8.6	K1 grey cast iron N7 duroplastics

Ø d$_1$	P	L$_1$	L$_2$	d$_2$	□		
Nr. 4	40	56	11	3.5	2.7	2.35	
Nr. 5	40	56	11	3.5	2.7	2.65	■
Nr. 6	32	56	12	4	3	2.85	■
Nr. 8	32	63	13	4.5	3.4	3.5	■
Nr. 10	24	70	15	6	4.9	3.9	■
Nr. 12	24	80	17	6	4.9	4.5	
1/4"	20	80	17	7	5.5	5.2	■
5/16"	18	90	20	8	6.2	6.6	■
3/8"	16	100	22	9	7	8.0	■

■ avialable – intermediate size on request

Machine Taps White Ring

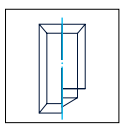
Cutting Data

DIN 376 HSS-E

straight flutes
for cast iron

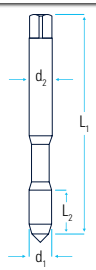
Group 4430
for blind and through holes

CAST IRON



2xd$_1$

Art.-No.			44300/01
Technology	i	Page 8.1	White Ring
Champfer Length	i	Page 8.4	C / 2-3 x P
Surface	i	Page 8.2	nitrided
Tolerance	i	Page 8.5	2 B
Cutting Data	i	Page 8.6	K1 grey cast iron N7 duroplastics



Ø d$_1$	P	L$_1$	L$_2$	d$_2$	□		
7/16"	14	100	22	8	6.2	9.4	
1/2"	13	110	25	9	7	10.8	■
9/16"	12	110	26	11	9	12.2	
5/8"	11	110	27	12	9	13.6	■
3/4"	10	125	30	14	11	16.5	■
7/8"	9	140	32	18	14.5	19.5	■
1"	8	160	36	18	14.5	22.3	■

■ avialable – intermediate size on request

Machine Taps

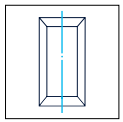
Cutting Data

DIN 371 HSS-E

Spiral point
for general construction steel

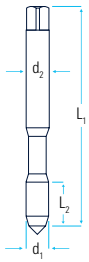
Group 3450
for through holes

STEEL



2xd$_1$

High Speed Cutting by Schumacher



Art.-No.			34500	34500/25
Technology	i	Page 8.1	High Volume	High Volume
Champfer Length	i	Page 8.4	B / 3,5-5 x P	
Surface	i	Page 8.2	bright	TiN
Tolerance	i	Page 8.5	2 B	2 B
Cutting Data	i	Page 8.6	P1 general construction steel	K2+K3 spheroidal and malleable cast iron

Ø d$_1$	P	L$_1$	L$_2$	d$_2$	□			
Nr. 4	40	56	11	3.5	2.7	2.35	■	
Nr. 5	40	56	11	3.5	2.7	2.65	■	■
Nr. 6	32	56	12	4	3	2.85	■	■
Nr. 8	32	63	13	4.5	3.4	3.5	■	■
Nr. 10	24	70	15	6	4.9	3.9	■	■
Nr. 12	24	80	17	6	4.9	4.5	■	
1/4"	20	80	17	7	5.5	5.2	■	■
5/16"	18	90	20	8	6.2	6.6	■	■
3/8"	16	100	22	9	7	8.0	■	■

■ avialable – intermediate size on request

Machine Taps

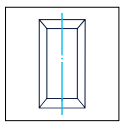
Cutting Data

DIN 376 HSS-E

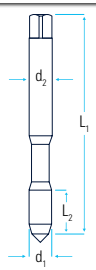
Spiral point
for general construction steel

Group 4450
for through holes

STEEL



2xd$_1$



Art.-No.			44500	44500/25
Technology	i	Page 8.1	High Volume	High Volume
Champfer Length	i	Page 8.4	B / 3,5-5 x P	
Surface	i	Page 8.2	bright	TiN
Tolerance	i	Page 8.5	2 B	2 B
Cutting Data	i	Page 8.6	P1 general construction steel	K2+K3 spheroidal and malleable cast iron

Ø d$_1$	P	L$_1$	L$_2$	d$_2$	□			
7/16"	14	100	22	8	6.2	9.4	■	
1/2"	13	110	25	9	7	10.8	■	■
9/16"	12	110	26	11	9	12.2	■	
5/8"	11	110	27	12	9	13.6	■	■
3/4"	10	125	30	14	11	16.5	■	■
7/8"	9	140	32	18	14.5	19.5	■	■
1"	8	160	36	18	14.5	22.3	■	■

■ avialable – intermediate size on request

Machine Taps Blue Ring

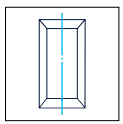
Cutting Data

DIN 371 HSS-E

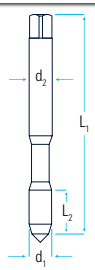
Spiral point
for chemical resistant steel

Group 3460
for through holes

INOX
Stainless



2xd$_1$



Art.-No.			34600/26	34600/25
Technology	i	Page 8.1	Blue Ring	Blue Ring
Champfer Length	i	Page 8.4	B / 3,5-5 x P	
Surface	i	Page 8.2	VAP	TiN
Tolerance	i	Page 8.5	2 B	2 B
Cutting Data	i	Page 8.6	P2 high strength steel	M1 chemical resistant steel

Ø d$_1$	P	L$_1$	L$_2$	d$_2$	□			
Nr. 4	40	56	11	3.5	2.7	2.35		
Nr. 5	40	56	11	3.5	2.7	2.65	■	■
Nr. 6	32	56	12	4	3	2.85	■	■
Nr. 8	32	63	13	4.5	3.4	3.5	■	■
Nr. 10	24	70	15	6	4.9	3.9	■	■
Nr. 12	24	80	17	6	4.9	4.5		
1/4"	20	80	17	7	5.5	5.2	■	■
5/16"	18	90	20	8	6.2	6.6	■	■
3/8"	16	100	22	9	7	8.0	■	■

■ avialable – intermediate size on request

Machine Taps Blue Ring

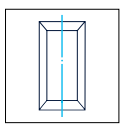
Cutting Data

DIN 376 HSS-E

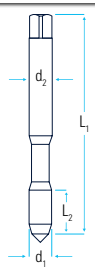
Spiral point
for chemical resistant steel

Group 4460
for through holes

INOX
Stainless



2xd$_1$



Art.-No.			44600/26	44600/25
Technology	i	Page 8.1	Blue Ring	Blue Ring
Champfer Length	i	Page 8.4	B / 3,5-5 x P	
Surface	i	Page 8.2	VAP	TiN
Tolerance	i	Page 8.5	2 B	2 B
Cutting Data	i	Page 8.6	P2 high strength steel	M1 chemical resistant steel

Ø d$_1$	P	L$_1$	L$_2$	d$_2$	□			
7/16"	14	100	22	8	6.2	9.4	■	
1/2"	13	110	25	9	7	10.8	■	■
9/16"	12	110	26	11	9	12.2	■	
5/8"	11	110	27	12	9	13.6	■	■
3/4"	10	125	30	14	11	16.5	■	■
7/8"	9	140	32	18	14.5	19.5	■	■
1"	8	160	36	18	14.5	22.3	■	■

■ avialable – intermediate size on request

Machine Taps Black Ring

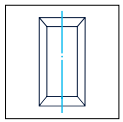
Cutting Data

DIN 376 HSS-E

Spiral point
for universal use

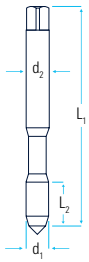
Group 3490
for through holes

UNI



2xd$_1$

Art.-No.		34900/26
Technology	Page 8.1	
		Black Ring
Champfer Length	Page 8.4	B / 3,5-5 x P
Surface	Page 8.2	VAP
Tolerance	Page 8.5	2 B
Cutting Data	Page 8.6	P1 general construction steel M1 chemical resistant steel N1 Aluminium N3 copper alloys



Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□		
Nr. 4	40	56	11	3.5	2.7	2.35	
Nr. 5	40	56	11	3.5	2.7	2.65	
Nr. 6	32	56	12	4	3	2.85	
Nr. 8	32	63	13	4.5	3.4	3.5	
Nr. 10	24	70	15	6	4.9	3.9	
Nr. 12	24	80	17	6	4.9	4.5	
1/4"	20	80	17	7	5.5	5.2	■
5/16"	18	90	20	8	6.2	6.6	■
3/8"	16	100	22	9	7	8.0	■

■ avialable – intermediate size on request

Machine Taps Black Ring

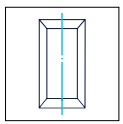
Cutting Data

DIN 376 HSS-E

Spiral point
for universal use

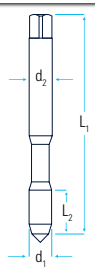
Group 4490
for through holes

UNI



2xd$_1$

Art.-No.		44900/26
Technology	Page 8.1	
		Black Ring
Champfer Length	Page 8.4	B / 3,5-5 x P
Surface	Page 8.2	VAP
Tolerance	Page 8.5	2 B
Cutting Data	Page 8.6	P1 general construction steel M1 chemical resistant steel N1 Aluminium N3 copper alloys



Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□		
7/16"	14	100	22	8	6.2	9.4	■
1/2"	13	110	25	9	7	10.8	■
9/16"	12	110	26	11	9	12.2	
5/8"	11	110	27	12	9	13.6	■
3/4"	10	125	30	14	11	16.5	■
7/8"	9	140	32	18	14.5	19.5	■
1"	8	160	36	18	14.5	22.3	■

■ avialable – intermediate size on request

Machine Taps Red Ring

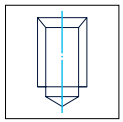
Cutting Data

internal standard HSS-E

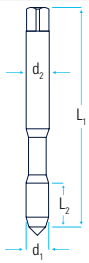
RH spiral flutes 20°
for high strength steel

Group 4471
for deep blind holes ≤ 3xd1

HIGH STRENGTH



3xd$_1$



Art.-No.		44710/4048
Technology	Page 8.1	Red Ring, Internal coolant
Champfer Length	Page 8.4	C/2-3 x P
Surface	Page 8.2	TiCN
Tolerance	Page 8.5	2 BX
Cutting Data	Page 8.6	P2 high strength steel

Ø d_1	P	L_1	L_2	d_2	□		
1"	8	160	30	18	14.5	22.3	■
1 1/8"	8	200	35	22	18	25.5	■
1 1/4"	8	200	35	22	18	28.5	■
1 3/8"	8	220	40	28	22	31.75	■
1 1/2"	8	220	40	32	24	35	■
1 5/8"	8	240	45	32	24	38	■

■ avialable – intermediate size on request

Machine Taps Red Ring

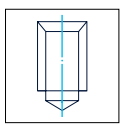
Cutting Data

DIN 371 HSS-E PM

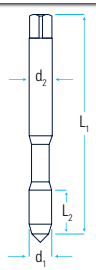
RH spiral flutes 20°
for nickel alloys

Group 3480
for blind holes

HIGH STRENGTH



2xd$_1$



Art.-No.		34800
Technology	Page 8.1	PM-Line
		Red Ring
Champfer Length	Page 8.4	3-4 x P
Surface	Page 8.2	bright
Tolerance	Page 8.5	2 B
Cutting Data	Page 8.6	P2 high strength steel S1 titanium alloys S2 nickel alloys

Ø d$_1$	P	L$_1$	L$_2$	d$_2$	□		
Nr. 4	40	56	11	3.5	2.7	2.35	
Nr. 5	40	56	11	3.5	2.7	2.65	
Nr. 6	32	56	12	4	3	2.85	
Nr. 8	32	63	13	4.5	3.4	3.5	■
Nr. 10	24	70	15	6	4.9	3.9	■
Nr. 12	24	80	17	6	4.9	4.5	
1/4"	20	80	17	7	5.5	5.2	■
5/16"	18	90	20	8	6.2	6.6	■
3/8"	16	100	22	9	7	8.0	■

■ avialable – intermediate size on request

Machine Taps Red Ring

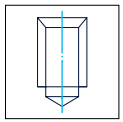
Cutting Data

DIN 371 HSS-E PM

RH spiral flutes 20°
for nickel alloys

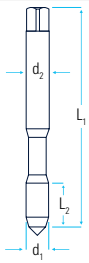
Group 4480
for blind holes

HIGH STRENGTH



2xd_1

Art.-No.		44800
Technology	Page 8.1	PM-Line
		Red Ring
Champfer Length	Page 8.4	3-4 x P
Surface	Page 8.2	bright
Tolerance	Page 8.5	2 B
Cutting Data	Page 8.6	P2 high strength steel S1 titanium alloys S2 nickel alloys



Ø d_1	P	L_1	L_2	d_2	□		
7/16"	14	100	22	8	6.2	9.4	
1/2"	13	110	25	9	7	10.8	■
9/16"	12	110	26	11	9	12.2	
5/8"	11	110	27	12	9	13.6	■
3/4"	10	125	30	14	11	16.5	■
7/8"	9	140	32	18	14.5	19.5	
1"	8	160	36	18	14.5	22.3	

■ avialable – intermediate size on request

Machine Taps

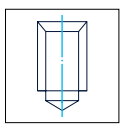
Cutting Data

DIN 371 HSS-E

RH spiral flutes 40°
for general construction steel

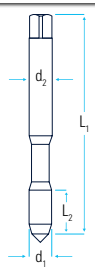
Group 3520
for blind holes

STEEL



2xd$_1$

High Speed Cutting by Schumacher



Art.-No.			35200	35200/25
Technology	i	Page 8.1	High Volume	High Volume
Champfer Length	i	Page 8.4	C / 2-3 x P	
Surface	i	Page 8.2	bright	TiN
Tolerance	i	Page 8.5	2 B	2 B
Cutting Data	i	Page 8.6	P1 general construction steel	K2+K3 spheroidal and malleable cast iron

Ø d$_1$	P	L$_1$	L$_2$	d$_2$	□			
Nr. 4	40	56	6	3.5	2.7	2.35	■	
Nr. 5	40	56	7	3.5	2.7	2.65	■	■
Nr. 6	32	56	7	4	3	2.85	■	■
Nr. 8	32	63	8	4.5	3.4	3.5	■	■
Nr. 10	24	70	10	6	4.9	3.9	■	■
Nr. 12	24	80	10	6	4.9	4.5	■	
1/4"	20	80	13	7	5.5	5.2	■	■
5/16"	18	90	14	8	6.2	6.6	■	■
3/8"	16	100	16	9	7	8.0	■	■

■ avialable – intermediate size on request

Machine Taps

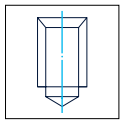
Cutting Data

DIN 376 HSS-E

RH spiral flutes 40°
for general construction steel

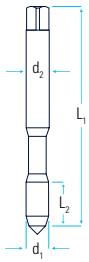
Group 4520
for blind holes

STEEL



2xd$_1$

High Speed Cutting by Schumacher



Art.-No.			45200	45200/25
Technology	i	Page 8.1	High Volume	High Volume
Champfer Length	i	Page 8.4	C / 2-3 x P	
Surface	i	Page 8.2	bright	TiN
Tolerance	i	Page 8.5	2 B	2 B
Cutting Data	i	Page 8.6	P1 general construction steel	K2+K3 spheroidal and malleable cast iron

Ø d$_1$	P	L$_1$	L$_2$	d$_2$	□			
7/16"	14	100	17	8	6.2	9.4	■	
1/2"	13	110	20	9	7	10.8	■	■
9/16"	12	110	20	11	9	12.2	■	
5/8"	11	110	22	12	9	13.6	■	■
3/4"	10	125	25	14	11	16.5	■	■
7/8"	9	140	27	18	14.5	19.5	■	■
1"	8	160	30	18	14.5	22.3	■	■

■ avialable – intermediate size on request

Machine Taps Blue Ring

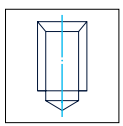
Cutting Data

DIN 371 HSS-E

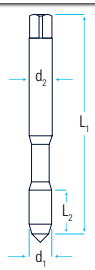
RH spiral flutes 40°
for chemical resistant steel

Group 3530
for blind holes

INOX
Stainless



2xd$_1$



Art.-No.			35300/26	35300/25
Technology	i	Page 8.1	Blue Ring	Blue Ring
Champfer Length	i	Page 8.4	C / 2-3 x P	
Surface	i	Page 8.2	VAP	TiN
Tolerance	i	Page 8.5	2 B	2 B
Cutting Data	i	Page 8.6	P2 high strength steel	M1 chemical resistant steel

Ø d$_1$	P	L$_1$	L$_2$	d$_2$	□			
Nr. 4	40	56	6	3.5	2.7	2.35		
Nr. 5	40	56	7	3.5	2.7	2.65	■	■
Nr. 6	32	56	7	4	3	2.85	■	■
Nr. 8	32	63	8	4.5	3.4	3.5	■	■
Nr. 10	24	70	10	6	4.9	3.9	■	■
Nr. 12	24	80	10	6	4.9	4.5		
1/4"	20	80	13	7	5.5	5.2	■	■
5/16"	18	90	14	8	6.2	6.6	■	■
3/8"	16	100	16	9	7	8.0	■	■

■ avialable – intermediate size on request

Machine Taps Blue Ring

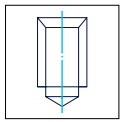
Cutting Data

DIN 376 HSS-E

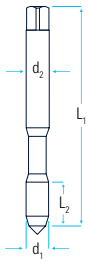
RH spiral flutes 40°
for chemical resistant steel

Group 4530
for blind holes

INOX
Stainless



2xd$_1$



Art.-No.			45300/26	45300/25
Technology	i	Page 8.1	Blue Ring	Blue Ring
Champfer Length	i	Page 8.4	C / 2-3 x P	
Surface	i	Page 8.2	VAP	TiN
Tolerance	i	Page 8.5	2 B	2 B
Cutting Data	i	Page 8.6	P2 high strength steel	M1 chemical resistant steel

Ø d_1	P	L_1	L_2	d_2	□			
7/16"	14	100	17	8	6.2	9.4		
1/2"	13	110	20	9	7	10.8	■	■
9/16"	12	110	20	11	9	12.2		
5/8"	11	110	22	12	9	13.6	■	■
3/4"	10	125	25	14	11	16.5	■	■
7/8"	9	140	27	18	14.5	19.5	■	■
1"	8	160	30	18	14.5	22.3	■	■

■ avialable – intermediate size on request

Machine Taps Black Ring

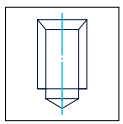
Cutting Data

DIN 371 HSS-E

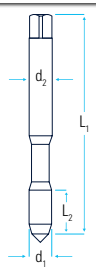
RH spiral flutes 40°
for universal use

Group 3590
for blind holes

UNI



2xd$_1$



Art.-No.		35900/26
Technology	Page 8.1	
		Black Ring
Champfer Length	Page 8.4	C / 2-3 x P
Surface	Page 8.2	VAP
Tolerance	Page 8.5	2 B
Cutting Data	Page 8.6	P1 general construction steel M1 chemical resistant steel N1 Aluminium N3 copper alloys

Ø d_1	P_{mm}	L_1	L_2	d_2	□		
Nr. 4	40	56	6	3.5	2.7	2.35	
Nr. 5	40	56	7	3.5	2.7	2.65	
Nr. 6	32	56	7	4	3	2.85	
Nr. 8	32	63	8	4.5	3.4	3.5	
Nr. 10	24	70	10	6	4.9	3.9	
Nr. 12	24	80	10	6	4.9	4.5	
1/4"	20	80	13	7	5.5	5.2	■
5/16"	18	90	14	8	6.2	6.6	■
3/8"	16	100	16	9	7	8.0	■

■ avialable – intermediate size on request

Machine Taps Black Ring

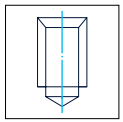
Cutting Data

DIN 371 HSS-E

RH spiral flutes 40°
for universal use

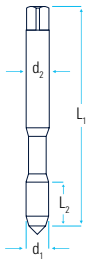
Group 4590
for blind holes

UNI



3xd$_1$

Art.-No.		45900/26
Technology	i Page 8.1	Black Ring
Champfer Length	i Page 8.4	C / 2-3 x P
Surface	i Page 8.2	VAP
Tolerance	i Page 8.5	2 B
Cutting Data	i Page 8.6	P1 general construction steel M1 chemical resistant steel N1 Aluminium N3 copper alloys



Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□		
7/16"	14	100	17	8	6.2	9.4	■
1/2"	13	110	20	9	7	10.8	■
9/16"	12	110	20	11	9	12.2	
5/8"	11	110	22	12	9	13.6	■
3/4"	10	125	25	14	11	16.5	■
7/8"	9	140	27	18	14.5	19.5	■
1"	8	160	30	18	14.5	22.3	■

■ avialable – intermediate size on request

Forming Taps

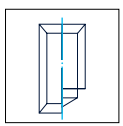
Cutting Data

DIN 371 HSS-E

straight oil grooves for steel, non-ferrous steel
and heat treatable steel

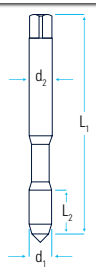
Group 3560
for blind and through holes

STEEL



2xd$_1$

High Speed Cutting by Schumacher



Art.-No.			35600/53	35600/2553	
Technology	i	Page 8.1	High Volume	High Volume	
Champfer Length	i	Page 8.4	C / 2-3 x P		
Surface	i	Page 8.2	bright	TiN	
Tolerance	i	Page 8.5	2 BX	2 BX	
Cutting Data	i	Page 8.6	P1 general construction steel	P2 high strength steel	N3 copper alloys

Ø d$_1$	P	L$_1$	L$_2$	d$_2$	□			
Nr. 4	40	56	11	3.5	2.7	2.55	■	■
Nr. 5	40	56	11	3.5	2.7	2.9	■	■
Nr. 6	32	56	12	4	3	3.15	■	■
Nr. 8	32	63	13	4.5	3.4	3.8	■	■
Nr. 10	24	70	15	6	4.9	4.35	■	■
Nr. 12	24	80	17	6	4.9	4.95		
1/4"	20	80	17	7	5.5	5.8	■	■
5/16"	18	90	20	8	6.2	7.3	■	■
3/8"	16	100	22	9	7	8.8	■	■

■ avialable – intermediate size on request

Set of Taps

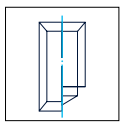
Cutting Data

DIN 351 HSS-E

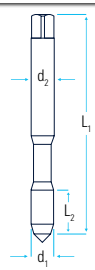
set of 3 pieces, straight flutes
for general construction steel

Group 1500
for blind and through holes

STEEL



2xd$_1$



Art.-No.			15100	15200	15300
Technology	i	Page 8.1			
Champfer Length	i	Page 8.4	D / 3,5-5 x P	3-4 x P	C / 2-3 x P
Surface	i	Page 8.2	bright	bright	bright
Tolerance	i	Page 8.5	Nr. 1	Nr. 2	Nr. 3 = 2 B
Cutting Data	i	Page 8.6	P1 general construction steel		K2+K3 spheroidal and malleable cast iron

Ø d$_1$	P	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	■	■	■

■ avialable – intermediate size on request

Machine Taps

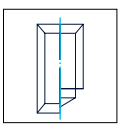
Cutting Data

DIN 371 HSS-E

straight flutes
for general construction steel

Group 3600
for blind and through holes

STEEL



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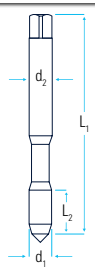


Art.-No.		36000
Technology	Page 8.1	
Champfer Length	Page 8.4	C / 2-3 x P
Surface	Page 8.2	bright
Tolerance	Page 8.5	2 B
Cutting Data	Page 8.6	P1 general construction steel

Ø d_1	P	L_1	L_2	d_2	□		
Nr. 5	44	56	11	3.5	2.7	2.7	■
Nr. 6	40	56	12	4	3	3.0	■
Nr. 8	36	63	13	4.5	3.4	3.5	■
Nr. 10	32	70	15	6	4.9	4.1	■
Nr. 12	28	80	17	6	4.9	4.7	■
1/4"	28	80	17	7	5.5	5.5	■
5/16"	24	90	18	8	6.2	6.9	■
3/8"	24	100	18	9	7	8.5	■

■ avialable – intermediate size on request

Machine Taps

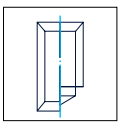
Cutting Data

DIN 374 HSS-E

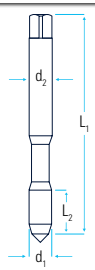
straight flutes
for general construction steel

Group 4600
for blind and through holes

STEEL



2xd$_1$



Art.-No.		46000
Technology	Page 8.1	
Champfer Length	Page 8.4	C / 2-3 x P
Surface	Page 8.2	bright
Tolerance	Page 8.5	2 B
Cutting Data	Page 8.6	P1 general construction steel

Ø d$_1$	P	L$_1$	L$_2$	d$_2$	□		
7/16"	20	100	22	8	6.2	9.9	■
1/2"	20	100	22	9	7	11.5	■
9/16"	18	100	22	11	9	12.9	■
5/8"	18	100	22	12	9	14.5	■
3/4"	16	110	25	14	11	17.5	■
7/8"	14	125	26	18	14.5	20.4	■
1"	12	140	28	18	14.5	23.3	■

■ avialable – intermediate size on request

Machine Taps White Ring

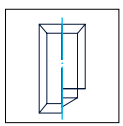
Cutting Data

DIN 371 HSS-E

straight flutes
for cast iron

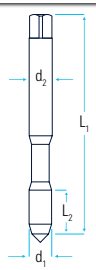
Group 3630
for blind and through holes

CAST IRON



2xd$_1$

Art.-No.			36300/01
Technology	i	Page 8.1	White Ring
Champfer Length	i	Page 8.4	C / 2-3 x P
Surface	i	Page 8.2	nitrided
Tolerance	i	Page 8.5	2 B
Cutting Data	i	Page 8.6	K1 grey cast iron N7 duroplastics



Ø d$_1$	P	L$_1$	L$_2$	d$_2$	□		
Nr. 5	44	56	11	3.5	2.7	2.7	
Nr. 6	40	56	12	4	3	3.0	
Nr. 8	36	63	13	4.5	3.4	3.5	
Nr. 10	32	70	15	6	4.9	4.1	■
Nr. 12	28	80	17	6	4.9	4.7	
1/4"	28	80	17	7	5.5	5.5	■
5/16"	24	90	18	8	6.2	6.9	■
3/8"	24	100	18	9	7	8.5	■

■ avialable – intermediate size on request

Machine Taps White Ring

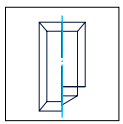
Cutting Data

DIN 374 HSS-E

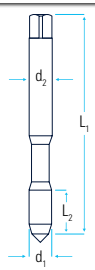
straight flutes
for cast iron

Group 4630
for blind and through holes

CAST IRON



2xd$_1$



Art.-No.			46300/01
Technology	i	Page 8.1	
			White Ring
Champfer Length	i	Page 8.4	C / 2-3 x P
Surface	i	Page 8.2	nitrided
Tolerance	i	Page 8.5	2 B
Cutting Data	i	Page 8.6	K1 grey cast iron N7 duroplastics

Ø d_1	P	L_1	L_2	d_2	□		
7/16"	20	100	22	8	6.2	9.9	
1/2"	20	100	22	9	7	11.5	■
9/16"	18	100	22	11	9	12.9	
5/8"	18	100	22	12	9	14.5	■
3/4"	16	110	25	14	11	17.5	■
7/8"	14	125	26	18	14.5	20.4	■
1"	12	140	28	18	14.5	23.3	■

■ avialable – intermediate size on request

Machine Taps

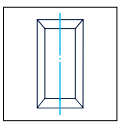
Cutting Data

DIN 371 HSS-E

Spiral point
for general construction steel

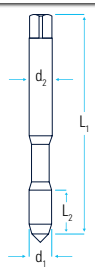
Group 3650
for through holes

STEEL



2xd$_1$

High Speed Cutting by Schumacher



Art.-No.			36500	36500/25
Technology	i	Page 8.1		
Champfer Length	i	Page 8.4	B / 3,5-5 x P	
Surface	i	Page 8.2	bright	TiN
Tolerance	i	Page 8.5	2 B	2 B
Cutting Data	i	Page 8.6	P1 general construction steel	K2+K3 spheroidal and malleable cast iron

Ø d$_1$	P	L$_1$	L$_2$	d$_2$	□			
Nr. 5	44	56	11	3.5	2.7	2.7	■	■
Nr. 6	40	56	12	4	3	3.0	■	■
Nr. 8	36	63	13	4.5	3.4	3.5	■	■
Nr. 10	32	70	15	6	4.9	4.1	■	■
Nr. 12	28	80	17	6	4.9	4.7	■	
1/4"	28	80	17	7	5.5	5.5	■	■
5/16"	24	90	18	8	6.2	6.9	■	■
3/8"	24	100	18	9	7	8.5	■	■

■ avialable – intermediate size on request

Machine Taps

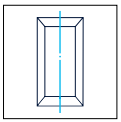
Cutting Data

DIN 374 HSS-E

Spiral point
for general construction steel

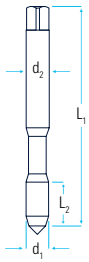
Group 4650
for through holes

STEEL



2xd$_1$

High Speed Cutting by Schumacher



Art.-No.			46500	46500/25
Technology	i	Page 8.1		
Champfer Length	i	Page 8.4	B / 3,5-5 x P	
Surface	i	Page 8.2	bright	TiN
Tolerance	i	Page 8.5	2 B	2 B
Cutting Data	i	Page 8.6	P1 general construction steel	K2+K3 spheroidal and malleable cast iron

Ø d$_1$	P	L$_1$	L$_2$	d$_2$	□			
7/16"	20	100	22	8	6.2	9.9	■	
1/2"	20	100	22	9	7	11.5	■	■
9/16"	18	100	22	11	9	12.9	■	
5/8"	18	100	22	12	9	14.5	■	■
3/4"	16	110	25	14	11	17.5	■	■
7/8"	14	125	26	18	14.5	20.4	■	■
1"	12	140	28	18	14.5	23.3	■	■

■ avialable – intermediate size on request

Machine Taps Blue Ring

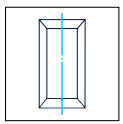
Cutting Data

DIN 371 HSS-E

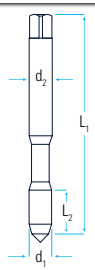
Spiral point
for chemical resistant steel

Group 3660
for through holes

INOX
Stainless



2xd$_1$



Art.-No.			36600	36600/25
Technology	i	Page 8.1	Blue Ring	Blue Ring
Champfer Length	i	Page 8.4	B / 3,5-5 x P	
Surface	i	Page 8.2	bright	TiN
Tolerance	i	Page 8.5	2 B	2 B
Cutting Data	i	Page 8.6	P2 high strength steel	M1 chemical resistant steel

Ø d$_1$	P	L$_1$	L$_2$	d$_2$	□			
Nr. 5	44	56	11	3.5	2.7	2.7	■	■
Nr. 6	40	56	12	4	3	3.0	■	■
Nr. 8	36	63	13	4.5	3.4	3.5	■	■
Nr. 10	32	70	15	6	4.9	4.1	■	■
Nr. 12	28	80	17	6	4.9	4.7	■	
1/4"	28	80	17	7	5.5	5.5	■	■
5/16"	24	90	18	8	6.2	6.9	■	■
3/8"	24	100	18	9	7	8.5	■	■

■ avialable – intermediate size on request

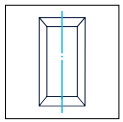
Machine Taps Blue Ring

Cutting Data

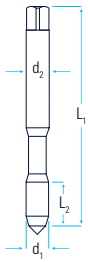
DIN 374 HSS-E
Spiral point
for chemical resistant steel

Group 4660
for through holes

INOX
Stainless



2xd$_1$



Art.-No.			46600	46600/25
Technology	i	Page 8.1	Blue Ring	Blue Ring
Champfer Length	i	Page 8.4	B / 3,5-5 x P	
Surface	i	Page 8.2	bright	TiN
Tolerance	i	Page 8.5	2 B	2 B
Cutting Data	i	Page 8.6	P2 high strength steel	M1 chemical resistant steel

Ø d$_1$	P	L$_1$	L$_2$	d$_2$	□			
7/16"	20	100	22	8	6.2	9.9		
1/2"	20	100	22	9	7	11.5	■	■
9/16"	18	100	22	11	9	12.9		
5/8"	18	100	22	12	9	14.5	■	■
3/4"	16	110	25	14	11	17.5	■	■
7/8"	14	125	26	18	14.5	20.4	■	■
1"	12	140	28	18	14.5	23.3	■	■

■ avialable – intermediate size on request

Machine Taps Black Ring

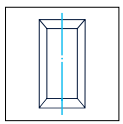
Cutting Data

DIN 371 HSS-E

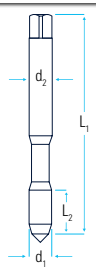
Spiral point
for universal use

Group 3690
for through holes

UNI



2xd$_1$



Art.-No.		36900/26
Technology	Page 8.1	
		Black Ring
Champfer Length	Page 8.4	B / 3,5-5 x P
Surface	Page 8.2	VAP
Tolerance	Page 8.5	2 B
Cutting Data	Page 8.6	P1 general construction steel M1 chemical resistant steel N1 Aluminium N3 copper alloys

Ø d_1	P_{mm}	L_1	L_2	d_2	□		
Nr. 5	44	56	11	3.5	2.7	2.7	
Nr. 6	40	56	12	4	3	3.0	
Nr. 8	36	63	13	4.5	3.4	3.5	
Nr. 10	32	70	15	6	4.9	4.1	
Nr. 12	28	80	17	6	4.9	4.7	
1/4"	28	80	17	7	5.5	5.5	■
5/16"	24	90	18	8	6.2	6.9	■
3/8"	24	100	18	9	7	8.5	■

■ avialable – intermediate size on request

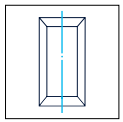
Machine Taps Black Ring

Cutting Data

DIN 374 HSS-E
Spiral point
for universal use

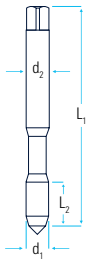
Group 4690
for through holes

UNI



2xd$_1$

Art.-No.		46900/26
Technology	Page 8.1	
		Black Ring
Champfer Length	Page 8.4	B / 3,5-5 x P
Surface	Page 8.2	VAP
Tolerance	Page 8.5	2 B
Cutting Data	Page 8.6	P1 general construction steel M1 chemical resistant steel N1 Aluminium N3 copper alloys



Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□		
7/16"	20	100	22	8	6.2	9.9	■
1/2"	20	100	22	9	7	11.5	■
9/16"	18	100	22	11	9	12.9	
5/8"	18	100	22	12	9	14.5	■
3/4"	16	110	25	14	11	17.5	■
7/8"	14	125	26	18	14.5	20.4	■
1"	12	140	28	18	14.5	23.3	■

■ avialable – intermediate size on request

Machine Taps Red Ring

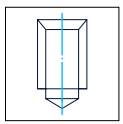
Cutting Data

DIN 371 HSS-E PM

RH spiral flutes 20°
for nickel alloys

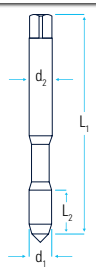
Group 3680
for blind holes

HIGH STRENGTH



2xd$_1$

Art.-No.		36800
Technology	i Page 8.1	PM-Line
		Red Ring
Champfer Length	i Page 8.4	3-4 x P
Surface	i Page 8.2	bright
Tolerance	i Page 8.5	2 B
Cutting Data	i Page 8.6	P2 high strength steel S1 titanium alloys S2 nickel alloys



Ø d$_1$	P	L$_1$	L$_2$	d$_2$	□		
Nr. 5	44	56	11	3.5	2.7	2.7	
Nr. 6	40	56	12	4	3	3.0	
Nr. 8	36	63	13	4.5	3.4	3.5	■
Nr. 10	32	70	15	6	4.9	4.1	■
Nr. 12	28	80	17	6	4.9	4.7	
1/4"	28	80	17	7	5.5	5.5	■
5/16"	24	90	18	8	6.2	6.9	■
3/8"	24	100	18	9	7	8.5	■

■ avialable – intermediate size on request

Machine Taps

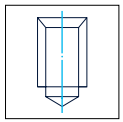
Cutting Data

DIN 371 HSS-E

RH spiral flutes 40°
for general construction steel

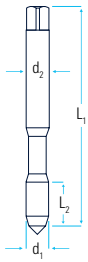
Group 3720
for blind holes

STEEL



2xd$_1$

High Speed Cutting by Schumacher



Art.-No.			37200	37200/25
Technology	i	Page 8.1		
Champfer Length	i	Page 8.4	C / 2-3 x P	
Surface	i	Page 8.2	bright	TiN
Tolerance	i	Page 8.5	2 B	2 B
Cutting Data	i	Page 8.6	P1 general construction steel	K2+K3 spheroidal and malleable cast iron

Ø d$_1$	P	L$_1$	L$_2$	d$_2$	□			
Nr. 5	44	56	7	3.5	2.7	2.7	■	■
Nr. 6	40	56	7	4	3	3.0	■	■
Nr. 8	36	63	8	4.5	3.4	3.5	■	■
Nr. 10	32	70	10	6	4.9	4.1	■	■
Nr. 12	28	80	10	6	4.9	4.7	■	
1/4"	28	80	10	7	5.5	5.5	■	■
5/16"	24	90	10	8	6.2	6.9	■	■
3/8"	24	100	10	9	7	8.5	■	■

■ avialable – intermediate size on request

Machine Taps

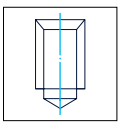
Cutting Data

DIN 374 HSS-E

RH spiral flutes 40°
for general construction steel

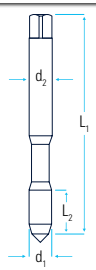
Group 4720
for blind holes

STEEL



2xd$_1$

High Speed Cutting by Schumacher



Art.-No.			47200	47200/25
Technology	i	Page 8.1		
Champfer Length	i	Page 8.4	C / 2-3 x P	
Surface	i	Page 8.2	bright	TiN
Tolerance	i	Page 8.5	2 B	2 B
Cutting Data	i	Page 8.6	P1 general construction steel	K2+K3 spheroidal and malleable cast iron

Ø d$_1$	P	L$_1$	L$_2$	d$_2$	□			
7/16"	20	100	13	8	6.2	9.9	■	
1/2"	20	100	13	9	7	11.5	■	■
9/16"	18	100	15	11	9	12.9	■	
5/8"	18	100	15	12	9	14.5	■	■
3/4"	16	110	17	14	11	17.5	■	■
7/8"	14	125	17	18	14.5	20.4	■	■
1"	12	140	20	18	14.5	23.3	■	■

■ avialable – intermediate size on request

Machine Taps Blue Ring

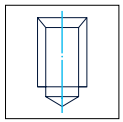
Cutting Data

DIN 371 HSS-E

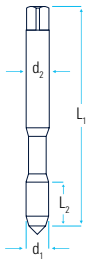
RH spiral flutes 40°
for chemical resistant steel

Group 3730
for blind holes

INOX
Stainless



2xd$_1$



Art.-No.			37300	37300/25
Technology	i	Page 8.1	Blue Ring	Blue Ring
Champfer Length	i	Page 8.4	C / 2-3 x P	
Surface	i	Page 8.2	bright	TiN
Tolerance	i	Page 8.5	2 B	2 B
Cutting Data	i	Page 8.6	P2 high strength steel	M1 chemical resistant steel

Ø d$_1$	P	L$_1$	L$_2$	d$_2$	□			
Nr. 5	44	56	7	3.5	2.7	2.7	■	■
Nr. 6	40	56	7	4	3	3.0	■	■
Nr. 8	36	63	8	4.5	3.4	3.5	■	■
Nr. 10	32	70	10	6	4.9	4.1	■	■
Nr. 12	28	80	10	6	4.9	4.7		
1/4"	28	80	10	7	5.5	5.5	■	■
5/16"	24	90	10	8	6.2	6.9	■	■
3/8"	24	100	10	9	7	8.5	■	■

■ avialable – intermediate size on request

Machine Taps Blue Ring

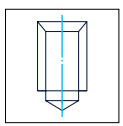
Cutting Data

DIN 374 HSS-E

RH spiral flutes 40°
for chemical resistant steel

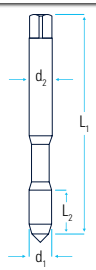
Group 4730
for blind holes

INOX
Stainless



2xd$_1$

Art.-No.			47300	47300/25
Technology	i	Page 8.1	Blue.Ring	Blue Ring
Champfer Length	i	Page 8.4	C / 2-3 x P	
Surface	i	Page 8.2	bright	TiN
Tolerance	i	Page 8.5	2 B	2 B
Cutting Data	i	Page 8.6	P2 high strength steel	M1 chemical resistant steel



Ø d$_1$	P	L$_1$	L$_2$	d$_2$	□			
7/16"	20	100	13	8	6.2	9.9		
1/2"	20	100	13	9	7	11.5	■	■
9/16"	18	100	15	11	9	12.9		
5/8"	18	100	15	12	9	14.5	■	■
3/4"	16	110	17	14	11	17.5	■	■
7/8"	14	125	17	18	14.5	20.4	■	■
1"	12	140	20	18	14.5	23.3	■	■

■ avialable – intermediate size on request

Machine Taps Black Ring

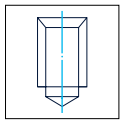
Cutting Data

DIN 371 HSS-E

RH spiral flutes 40°
for universal use

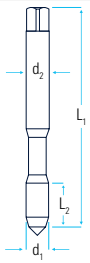
Group 3790
for blind holes

UNI



2xd$_1$

Art.-No.		37900/26
Technology	Page 8.1	Black Ring
Champfer Length	Page 8.4	C / 2-3 x P
Surface	Page 8.2	VAP
Tolerance	Page 8.5	2 B
Cutting Data	Page 8.6	P2 high strength steel M1 chemical resistant steel



Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□		
Nr. 5	44	56	7	3.5	2.7	2.7	
Nr. 6	40	56	7	4	3	3.0	
Nr. 8	36	63	8	4.5	3.4	3.5	
Nr. 10	32	70	10	6	4.9	4.1	
Nr. 12	28	80	10	6	4.9	4.7	
1/4"	28	80	10	7	5.5	5.5	■
5/16"	24	90	10	8	6.2	6.9	■
3/8"	24	100	10	9	7	8.5	■

■ avialable – intermediate size on request

Machine Taps Black Ring

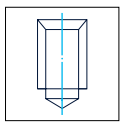
Cutting Data

DIN 374 HSS-E

RH spiral flutes 40°
for universal use

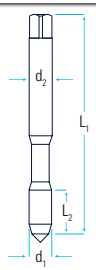
Group 4790
for blind holes

UNI



2xd$_1$

Art.-No.		47900/26
Technology	Page 8.1	
		Black Ring
Champfer Length	Page 8.4	C / 2-3 x P
Surface	Page 8.2	VAP
Tolerance	Page 8.5	2 B
Cutting Data	Page 8.6	P1 general construction steel M1 chemical resistant steel N1 Aluminium N3 copper alloys



Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□	⌀	
7/16"	20	100	13	8	6.2	9.9	■
1/2"	20	100	13	9	7	11.5	■
9/16"	18	100	15	11	9	12.9	
5/8"	18	100	15	12	9	14.5	■
3/4"	16	110	17	14	11	17.5	■
7/8"	14	125	17	18	14.5	20.4	■
1"	12	140	20	18	14.5	23.3	■

■ avialable – intermediate size on request

Cutting Data

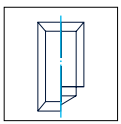
Set of Taps

DIN 2181 HSS-E

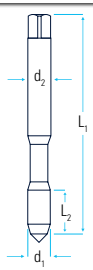
set of 2 pieces, straight flutes
for general construction steel

Group 1600
for blind and through holes

STEEL



2xd$_1$



Art.-No.			16100	16200
Technology	i	Page 8.1		
Champfer Length	i	Page 8.4	D / 3,5-5 x P	C / 2-3 x P
Surface	i	Page 8.2	bright	bright
Tolerance	i	Page 8.5	Nr.1	Nr. 2 = 2 B
Cutting Data	i	Page 8.6	P1 general construction steel	K2+K3 spheroidal and malleable cast iron

Ø d_1	P	L_1	L_2	d_2	□			
Nr. 8	36	45	10	4.5	3.4	3.5	■	■
Nr. 10	32	56	14	6	4.9	4.1	■	■
Nr. 12	28	56	14	6	4.9	4.7	■	■
1/4"	28	56	17	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	18	14.5	23.3	■	■

■ avialable – intermediate size on request

Machine Taps

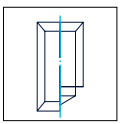
Cutting Data

internal standard HSS-E

straight flutes
for general construction steel

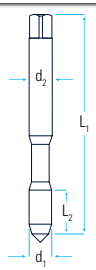
Group 1730
for blind and through holes

STEEL



2xd$_1$

Art.-No.		17300
Technology	i Page 8.1	
Champfer Length	i Page 8.4	C / 2-3 x P
Surface	i Page 8.2	bright
Tolerance	i Page 8.5	
Cutting Data	i Page 8.6	P1 general construction steel



Ø d$_1$	P	L$_1$	L$_2$	d$_2$	□		
1/8"	27	90	12	7	5.5	8.5	■
1/4"	18	100	20	11	9	11	■
3/8"	18	100	22	12	9	14.5	■
1/2"	14	125	26	16	12	17.85	■
3/4"	14	140	26	20	16	23.2	■
1"	11.5	160	36	25	20	29.0	■
1 1/4"	11.5	170	30	32	24	37.8	■
1 1/2"	11.5	190	36	36	29	44.0	■
2"	11.5	220	36	45	35	56.0	■

■ avialable – intermediate size on request

Machine Taps Red Ring

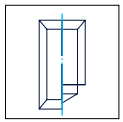
Cutting Data

internal standard HSS-E PM

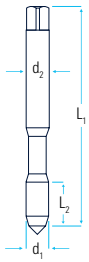
RH spiral flutes 15°
for high strength steel

Group 1750
for blind and through holes

HIGH STRENGTH



2xd$_1$



Art.-No.		17500
Technology	Page 8.1	PM-Line
		Red Ring
Champfer Length	Page 8.4	C / 2-3 x P
Surface	Page 8.2	bright
Tolerance	Page 8.5	
Cutting Data	Page 8.6	P2 high strength steel M1 chemical resistant steel

Ø d$_1$	P	L$_1$	L$_2$	d$_2$	□		
1/8"	27	90	12	7	5.5	8.5	■
1/4"	18	100	20	11	9	11	■
3/8"	18	100	22	12	9	14.5	■
1/2"	14	125	26	16	12	17.85	■
3/4"	14	140	26	20	16	23.2	■
1"	11.5	160	36	25	20	29.0	■
1 1/4"	11.5	170	30	32	24	37.8	
1 1/2"	11.5	190	36	36	29	44.0	
2"	11.5	220	36	45	35	56.0	

■ avialable – intermediate size on request

Set of Taps

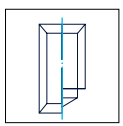
Cutting Data

DIN 2181 HSS-E

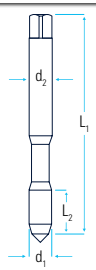
set of 2 pieces, straight flutes
for general construction steel

Group 1700
for blind and through holes

STEEL



2xd$_1$



Art.-No.			17100	17200
Technology	i	Page 8.1		
Champfer Length	i	Page 8.4	D / 3,5-5 x P	C / 2-3 x P
Surface	i	Page 8.2	bright	bright
Tolerance	i	Page 8.5	Nr.1	Nr. 2
Cutting Data	i	Page 8.6	P1 general construction steel	K2+K3 spheroidal and malleable cast iron

Ø d_1	P	L_1	L_2	d_2	□			
1/8"	27	63	12	7	5.5	8.5	■	■
1/4"	18	70	20	11	9	11	■	■
3/8"	18	80	22	12	9	14.5	■	■
1/2"	14	80	22	16	12	17.85	■	■
3/4"	14	90	22	20	16	23.2	■	■
1"	11.5	125	30	25	20	29.0	■	■

■ avialable – intermediate size on request

Machine Taps

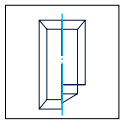
Cutting Data

DIN 40433 HSS-E

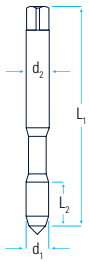
straight flutes
for general construction steel

Group 1830
for blind and through holes

STEEL



2xd$_1$



Art.-No.		18300
Technology	i Page 8.1	
Champfer Length	i Page 8.4	C / 2-3 x P
Surface	i Page 8.2	bright
Tolerance	i Page 8.5	
Cutting Data	i Page 8.6	P1 general construction steel K2+K3 spheroidal and malleable cast iron

Ø d$_1$	P	L$_1$	L$_2$	d$_2$	□		
Pg 7	20	100	22	9	7	11.4	■
Pg 9	18	100	22	12	9	14	■
Pg 11	18	110	25	14	11	17.4	■
Pg 13.5	18	125	25	16	12	19.2	■
Pg 16	18	125	25	18	14.5	21.3	■
Pg 21	16	150	28	22	18	27.0	■
Pg 29	16	170	30	28	22	35.6	■
Pg 36	16	190	32	36	29	45.6	■
Pg 42	16	190	32	40	32	52.6	■
Pg 48	16	220	40	45	35	57.9	■

■ avialable – intermediate size on request

Set of Taps

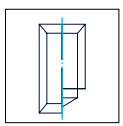
Cutting Data

DIN 40432 HSS-E

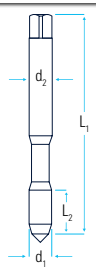
set of 2 pieces, straight flutes
for general construction steel

Group 1800
for blind and through holes

STEEL



2xd$_1$



Art.-No.			18100	18200
Technology	i	Page 8.1		
Champfer Length	i	Page 8.4	D / 3,5-5 x P	C / 2-3 x P
Surface	i	Page 8.2	bright	bright
Tolerance	i	Page 8.5	Nr.1	Nr.2
Cutting Data	i	Page 8.6	P1 general construction steel	K2+K3 spheroidal and malleable cast iron

Ø d$_1$	P	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	■	■

■ avialable – intermediate size on request

Single Finishing Machine Taps

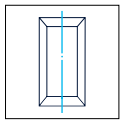
Cutting Data

internal standard HSS-E

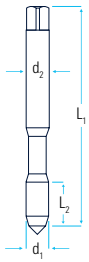
2-step design, RH thread - LH spiral flutes 6°
LH thread - RH spiral flutes 6°, for general construction steel

Group 6850
for through holes

STEEL



2xd$_1$



Art.-No.			68500	68505
Technology	i	Page 8.1		LH
Champfer Length	i	Page 8.4		
Surface	i	Page 8.2	bright	bright
Tolerance	i	Page 8.5	7H	7H
Cutting Data	i	Page 8.6	P1 general construction steel	K2+K3 spheroidal and malleable cast iron

Ø d_1	P_{mm}	L_1	L_2	d_2	□			
Tr 10	2	110	65	7	5.5	8.2	■	■
Tr 12	3	160	110	8	6.2	9.25	■	■
Tr 14	3	160	110	10	8	11.25	■	■
Tr 16	4	200	130	11	9	12.3	■	■
Tr 18	4	200	130	12	9	14.3	■	■
Tr 20	4	200	130	15	12	16.3	■	■
Tr 22	5	240	155	16	12	17.3	■	■
Tr 24	5	240	155	18	14.5	19.3	■	■
Tr 26	5	260	165	20	16	21.3	■	■
Tr 28	5	270	170	22	18	23.3	■	■
Tr 30	6	290	190	22	18	24.3	■	■
Tr 32	6	300	190	25	20	26.3	■	■
Tr 36	6	320	200	28	22	30.3	■	■
Tr 40	7	390	250	32	24	33.5	■	■

■ avialable – intermediate size on request

Set of Taps

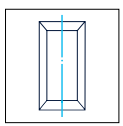
Cutting Data

internal standard HSS-E

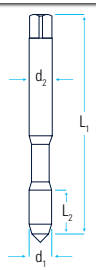
set of 3 pieces, LH spiral flutes 6°
for general construction steel

Group 6800
for through holes

STEEL



2xd$_1$



Art.-No.			68100	68200	68300
Technology	i	Page 8.1			
Champfer Length	i	Page 8.4			
Surface	i	Page 8.2	bright	bright	bright
Tolerance	i	Page 8.5	Nr. 1	Nr. 2	Nr. 3 = 7H
Cutting Data	i	Page 8.6	P1 general construction steel	K2+K3 spheroidal and malleable cast iron	

Ø d$_1$	P$_{mm}$	L$_1$	L$_2$	d$_2$	□				
Tr 10	2	90	35	7	5.5	8.2	■	■	■
Tr 12	3	110	45	8	6.2	9.25	■	■	■
Tr 14	3	130	45	10	8	11.25	■	■	■
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	100	32	24	33.5	■	■	■

■ avialable – intermediate size on request

Set of Taps

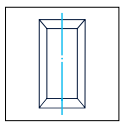
Cutting Data

internal standard HSS-E

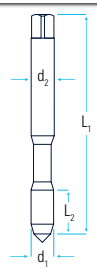
set of 3 pieces, RH spiral flutes 6°
for general construction steel

Group 6800 LH
for through holes

STEEL



2xd$_1$



Art.-No.			68105	68205	68305
Technology	i	Page 8.1	LH	LH	LH
Champfer Length	i	Page 8.4			
Surface	i	Page 8.2	bright	bright	bright
Tolerance	i	Page 8.5	Nr. 1	Nr. 2	Nr. 3 = 7H
Cutting Data	i	Page 8.6	P1 general construction steel	K2+K3 spheroidal and malleable cast iron	

Ø d_1	P_{mm}	L_1	L_2	d_2	□				
Tr 10	2	90	35	7	5.5	8.2	■	■	■
Tr 12	3	110	45	8	6.2	9.25	■	■	■
Tr 14	3	130	45	10	8	11.25	■	■	■
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	100	32	24	33.5	■	■	■

■ avialable – intermediate size on request

SCHUMACHER

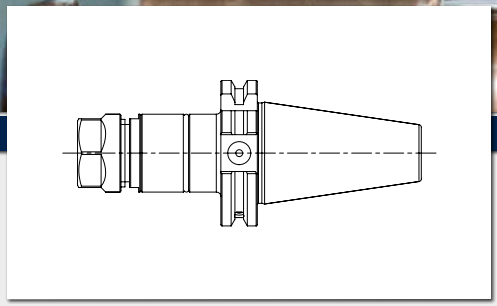
PRECISION TOOLS SINCE 1918

Developed by:

ToolDesign

by Schumacher

CATALOGUE NO. 125 S - THREADING TECHNOLOGY



Edition
Tap Holder

New product development

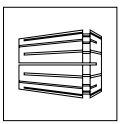
Tap Holder - NUMERIC

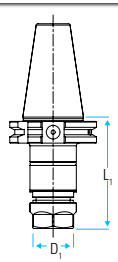
DIN 69871 AD/B
with coolant feed

Group S2000
for machines with synchronous spindle

minimum length compensation

NUMERIC
Supporting Digital Production





Art.-No.	S2000
Technology	NUMERIC
Tool Adaptation	ER (GB) collet
Shank Types	ISO taper shanks
Cooling & Lubrication	internal coolant - lubricant supply

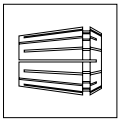
SK-Size	Taps	Ø Range	Ø D_1	L_1	C	T	Size	Dimension	Availability
40	M 3 - M 12	3.5 - 10	28	79	0.4	0.2	ER16	79/28	■
	M 3 - M 12	3.5 - 10	34	85	0.4	0.2	ER20	85/34	■
	M 3 - M 20	3.5 - 16	42	90	0.4	0.2	ER25	90/42	■
	M 4 - M 27	3.5 - 16	50	100	0.4	0.2	ER32	100/50	■
	M 4 - M 33	7 - 16	63	105	0.4	0.2	ER40	105/63	■
50	M 3 - M 12	3.5 - 10	28	79	0.4	0.2	ER16	79/28	■
	M 3 - M12	3.5 - 10	34	85	0.4	0.2	ER20	85/34	■
	M 3 - M20	3.5 - 16	42	90	0.4	0.2	ER25	90/42	■
	M 4 - M 27	3.5 - 16	50	100	0.4	0.2	ER32	100/50	■
	M 4 - M 33	7 - 16	63	105	0.4	0.2	ER40	105/63	■

Tap Holder - NUMERIC

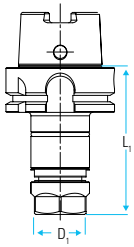
DIN 69893 HSK-A
with coolant feed

Group S2200
for machines with synchronous spindle

minimum length compensation



NUMERIC
Supporting Digital Production



Art.-No.	S2200
Technology	NUMERIC
Tool Adaptation	ER (GB) collet
Shank Types	Hollow taper shanks
Cooling & Lubrication	internal coolant - lubricant supply

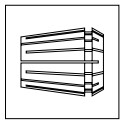
HSK-Size	Taps	Ø Range	Ø D_1	L_1	C	T	Size	Dimension	Availability
63	M 3 - M 12	3.5 - 10	34	90	0.4	0.2	ER20	90/34	■
	M 3 - M 20	3.5 - 16	42	94	0.4	0.2	ER25	94/42	■
	M 4 - M 27	3.5 - 16	50	105	0.4	0.2	ER32	105/50	■

Tap Holder - NUMERIC

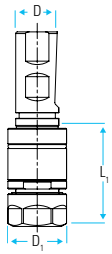
DIN 1835 B + E
with coolant feed

Group S2400
for machines with synchronous spindle

minimum length compensation



NUMERIC
Supporting Digital Production



Art.-No.	S2400
Technology	NUMERIC
Tool Adaptation	ER (GB) collet
Shank Types	straight shank
Cooling & Lubrication	internal coolant - lubricant supply

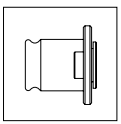
Zyl.-Size-D	Taps	Ø Range	Ø D_1	L_1	C	T	Size	Dimension	Availability
20	M 3 - M 12	3.5 - 10	34	58	0.4	0.2	ER20	58/34	■
25	M 3 - M 12	3.5 - 10	34	61	0.4	0.2	ER20	61/31	■
	M 4 - M 27	3.5 - 16	50	69	0.4	0.2	ER32	69/50	■

Tap Holder - NUMERIC

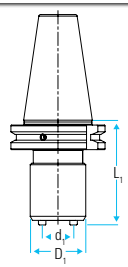
DIN 69871 AD/B

Group S4000
for machines with synchronous spindle

minimum length compensation



NUMERIC
Supporting Digital Production



Art.-No.	S4000
Technology	NUMERIC
Tool Adaptation	Quick Change Adapter
Shank Types	ISO taper shanks
Cooling & Lubrication	–

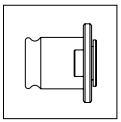
SK-Size	Taps	Ø d_1	Ø D_1	L_1	C	T	Size	Dimension	Availability
30	M 3 - M 12	19	36	65	0.4	0.2	1	65/36	■
	M 8 - M 20	31	53	89	0.4	0.2	2	89/53	■
40	M 3 - M12	19	36	65	0.4	0.2	1	65/36	■
	M 8 - M 20	31	53	79	0.4	0.2	2	79/53	■
	M 14 - M 33	48	78	115	0.4	0.2	3	115/78	■
50	M 3 - M 12	19	36	65	0.4	0.2	1	65/36	■
	M 8 - M 20	31	53	79	0.4	0.2	2	79/53	■
	M 14 - M 33	48	78	115	0.4	0.2	3	115/78	■

Tap Holder - NUMERIC

DIN 69893 HSK-A

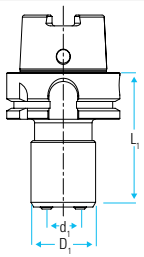
Group S4200
for machines with synchronous spindle

minimum length compensation



NUMERIC
Supporting Digital Production

Art.-No.	S4200
Technology	NUMERIC
Tool Adaptation	Quick Change Adapter
Shank Types	Hollow taper shanks
Cooling & Lubrication	–



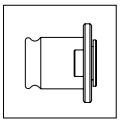
HSK-Size	Taps	Ø d_1	Ø D_1	L_1	C	T	Size	Dimension	Availability
32	M 3 - M 12	19	36	75	0.4	0.2	1	75/36	■
50	M 3 - M 12	19	36	72	0.4	0.2	1	72/36	■
	M 8 - M 20	31	53	91	0.4	0.2	2	91/53	■
63	M 3 - M 12	19	36	75	0.4	0.2	1	75/36	■
	M 3 - M 12	19	36	80	0.4	0.2	1	80/36	■
	M 3 - M 12	19	36	120	0.4	0.2	1	120/36	■
	M 3 - M 12	19	36	152	0.4	0.2	1	152/36	■
	M 3 - M 12	19	36	180	0.4	0.2	1	180/36	■
	M 8 - M 20	31	53	89	0.4	0.2	2	89/53	■
	M 14 - M 33	48	78	121	0.4	0.2	3	121/78	■
100	M 3 - M 12	19	36	75	0.4	0.2	1	75/36	■
	M 3 - M 12	19	36	160	0.4	0.2	1	160/36	■
	M 8 - M 20	31	53	94	0.4	0.2	2	94/53	■
	M 8 - M 20	31	53	160	0.4	0.2	2	160/53	■
	M 14 - M 33	48	78	127	0.4	0.2	3	127/78	■
	M 14 - M 33	48	78	160	0.4	0.2	3	160/78	■

Tap Holder - NUMERIC

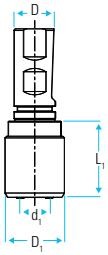
DIN 1835 B

Group S4400
for machines with synchronous spindle

minimum length compensation



NUMERIC
Supporting Digital Production



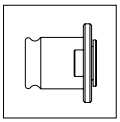
Art.-No.	S4400
Technology	NUMERIC
Tool Adaptation	Quick Change Adapter
Shank Types	straight shank
Cooling & Lubrication	–

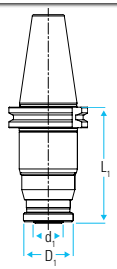
Zyl.-Size-D	Taps	Ø d_1	Ø D_1	L_1	C	T	Size	Dimension	Availability
20	M 3 - M 12	19	36	46	0.4	0.2	1	46/36	■
	M 3 - M 12	19	36	107.5	0.4	0.2	1	107,5/36	■
25	M 3 - M 12	19	36	46	0.4	0.2	1	46/36	■
	M 8 - M 20	31	53	74	0.4	0.2	2	74/53	■
	M 14 - M 33	48	78	107.5	0.4	0.2	3	107,5/78	■
32	M 3 - M 12	19	36	74	0.4	0.2	1	74/36	■

Tap Holder

DIN 69871 AD/B

Group S1000
for CNC machining centers and
conventional machine tools





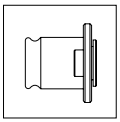
Art.-No.	S1000
Technology	
Tool Adaptation	Quick Change Adapter
Shank Types	ISO taper shanks
Cooling & Lubrication	–

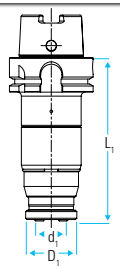
SK-Size	Taps	Ø d_1	Ø D_1	L_1	C	T	Size	Dimension	Availability
40	M 3 - M 12	19	45	90	5	15	1	90/45	■
	M 6 - M 24	31	63	120	5	20	2	120/63	■
50	M 3 - M 12	19	45	130	5	15	1	130/45	■
	M 6 - M 24	31	63	142	5	20	2	142/63	■
	M 6 - M 24	31	63	187	5	20	2	187/63	■
	M 18 - M 38	48	98	175	10	25	3	175/98	■

Tap Holder

DIN 69893 HSK-A

Group S1200
for CNC machining centers and
conventional machine tools





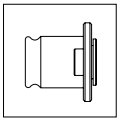
Art.-No.	S1200
Technology	
Tool Adaptation	Quick Change Adapter
Shank Types	Hollow taper shanks
Cooling & Lubrication	–

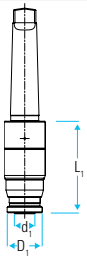
HSK-Size	Taps	Ø d_1	Ø D_1	L_1	C	T	Size	Dimension	Availability
63	M 3 - M 12	19	45	120	5	15	1	120/45	■
	M 6 - M 24	31	63	142	5	20	2	142/63	■
100	M 3 - M 12	19	45	130	5	15	1	130/45	■
	M 6 - M 24	31	63	142	5	20	2	142/63	■

Tap Holder

DIN 228 B

Group S1400
for CNC machining centers and
conventional machine tools





Art.-No.	S1400
Technology	
Tool Adaptation	Quick Change Adapter
Shank Types	Morse taper shanks
Cooling & Lubrication	–

MK-Size	Taps	Ø d_1	Ø D_1	L_1	C	T	Size	Dimension	Availability
5	M 3 - M 12	19	45	145	5	15	1	145/45	■
5	M 6 - M 24	31	63	175	5	20	2	175/63	■

Color Ring Series

The color ring line comprises machine taps from five different product groups which meet the requirements of highly sophisticated industries such as automotive, aerospace or chemicals. By their color marking, the appropriate use of these taps is facilitated. Selected hard material coatings increase the range of employment.

White Ring
Product line for grey cast iron

Red Ring
Product line for high strength heat treatable steel and nickel alloys

Blue Ring
Product line for use in INOX/stainless steel

Black Ring
Product line for general purpose »Black Power«

Yellow Ring
Product line for use in titanium alloys

Coatings

Technologies for hard material coatings of HSS and solid carbide tools are increasingly important since they bring about advantages such as:

› an increase in tool life
› a reduction of set-up times

and a substantial
› increase of working speeds
These factors justify the extra expenditures compared to tools without hard material coatings.

TiN Coating

Allround coating designed to improve tool life and optimize cutting speed. With a surface hardness of 2600 HV 0.05 and a frictional coefficient of 0.40 this coating can be applied in working temperatures of up to 450°C. The thickness of the layer ranges between 2 - 4 µm. TiN coatings have a internal compressive stress of approx. 3.1 GPa.

TiCN Coating

Improved tribological characteristics compared to TiN. Micro hardness at 3000 HV 0.05; frictional coefficient reduced to 0.35 compared to steel. Temperature stability of TiCN layers (thickness of 2 - 4 µm) extends up to 350°C. Internal compressive stress is at 3.5 GPa.

TiAlN Coating

Optimized PVD layer system, for hard materials of up to 50 HRC. Enhanced range of employment due to temperature stability up to 800°C and micro hardness of 3000 HV 0,05. This layer system features an oxidizing protection layer which provides the tool with a 'renewal effect.' Internal compressive stress of 1.9 GPa. The coating system is applied with a layer thickness of 2-4 µm.

SG4 Coating

Special coating made of super hard coating layer and solid state lubrication layer. Sectors of use comprise dry cutting and minimum lubrification. Wide range of applications due to optimum friction results and reduced tendency of adhesion.

CrN Coating

PVD layer system for non-ferrous materials and thermoplastics. It can be applied in working temperatures up to 600°C and has a low frictional coefficient of 0.3 compared to steel. The layer system has a thickness of 6 µm and a micro hardness of 1750 HV 0.05.

DLC Coating

The diamond like carbon layer ist the best solution for non-ferrous materials. The high surface hardness of 5000 HV 0,05 is combined with a very low friction coefficient of 0.1 compared to steel. The characteristics are completed by the reduced layer thickness of 0.8-1.2 µm and a high temperature stability up to 500°C. Because of this the material adhesion is significantly reduced.

The SG6 coating

HiPIMS of the latest generation with outstanding layer smoothness and density. It can withstand a high thermal load of more than 1000°C and is therefore ideal for difficult thread forming processes.

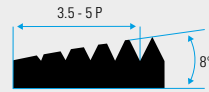
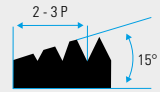
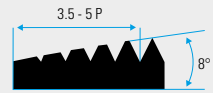
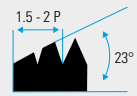
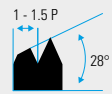
The SG7 coating

Droplet-free HiPIMS process of the latest technology for reliable blind hole machining in steel. Improved chip removal and reduced friction between workpiece and tool ensure longer tool life.

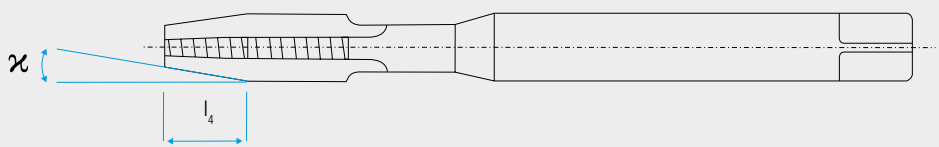
The SG8 coating

Innovative PVD coating system characterised by good oxidation resistance and high hardness. The coating is ideal for machining hard materials and for dry machining at very high application temperatures.

Chamfer Types

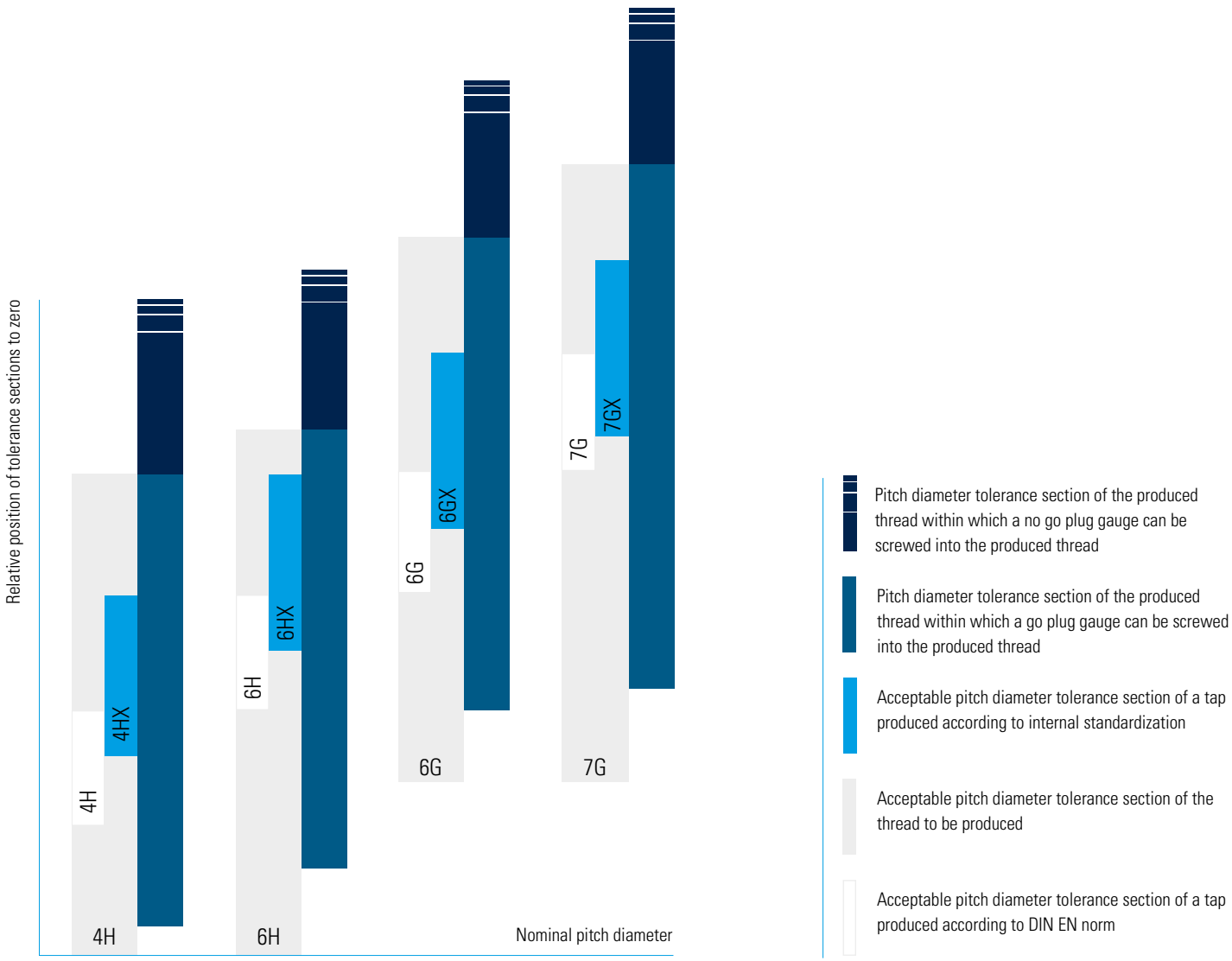
Form	Chamfer length l_4 [1] [x pitch]	Chamfer angle $\varkappa$ [°]	Main field of application:	
A	6 to 8	5°	short through holes	
B	3.5 to 5	8°	through holes in mid and long chipping materials	
C	2 to 3	15°	blind holes and through holes in short chipping materials	
D	3.5 to 5	8°	blind holes with long thread run-out and through holes	
E	1.5 to 2	23°	blind holes with very short thread run-out	
F	1 to 1.5	> 28°	blind holes with very short thread run-out	

[1] The number of pitches is a simple, practice-oriented criterion for defining the chamfer length of taps



Tolerance Levels

Schematic description of production tolerances applicable for metric internal thread – in addition please also find below the specific tolerance fields for tap production.



Cutting Data

Definition of rotation and cutting speeds for threading tools.

The table below contains the calculated values of rotation and cutting speeds for threading tools between M 3 and M 42. In most cases these calculations will serve for workshop use in practice. If interim values should be required, these can be calculated by drawing upon the formulas listed below.

nominal/diameter	round per minute [1/min]												
M3	425	530	635	850	1060	1270	1590	2120	2330	2650	2965	3180	3390
M4	319	398	480	635	795	955	1190	1590	1750	1990	2230	2390	2550
M5	255	318	382	510	635	765	955	1270	1400	1590	1785	1910	2040
M6	212	265	318	425	530	635	795	1060	1170	1325	1485	1590	1700
M8	159	198	238	318	398	478	598	795	875	995	1115	1195	1275
M10	127	159	191	255	318	382	478	636	700	795	892	955	1020
M12	106	133	159	212	265	318	398	531	584	664	744	795	850
M14	91	114	136	182	228	273	342	455	500	568	636	682	728
M16	80	100	119	159	199	239	299	398	438	497	557	597	637
M18	71	88	106	142	177	212	265	354	388	442	495	530	565
M20	64	80	95	127	159	192	239	318	350	398	446	478	510
M22	58	72	87	116	145	174	217	290	318	362	405	435	463
M24	53	66	80	106	133	159	200	266	292	332	372	398	425
M27	47	59	71	95	118	142	177	236	260	295	330	355	378
M30	42	53	64	85	106	127	159	212	234	265	297	318	340
M33	39	48	58	77	96	116	145	193	212	242	270	290	309
M36	35	44	53	71	88	106	133	177	195	221	248	265	283
M39	33	41	49	65	82	98	122	163	180	205	228	245	262
M42	30	38	45	61	76	91	114	152	167	190	212	228	243
	4	5	6	8	10	12	15	20	22	25	28	30	32
	Cutting speed v [m/min]												

legend:

v = Cutting speed [m/min]
d = Nominal tap diameter [m]
n = Tool spindle rotation [1/min]
π = 3.14

$$v = d \times \pi \times n$$

$$n = \frac{v}{d \times \pi}$$

Work Piece Material Groups/Cutting Data

Material Groups DIN ISO 513	Schumacher	Description	DIN Description	DIN 17 007 Material-No.	Strength [N/mm²]	Cutting Speed v_c [m/min] v_c forming taps = v_c + 30-50% HSS-E / VHM bright	coated
P	P1	Carbon steels	St 33	1.0035	290	10 - 15	15 - 25
	P1	Carbon steels	St 37	1.0120	340 - 370	10 - 15	15 - 25
	P1	Carbon steels	St 50	1.0531	470 - 610	10 - 15	15 - 25
	P1	Carbon steels	St 60 - 2	1.0060	570 - 710	10 - 15	15 - 25
	P1	Carbon steels	St 70 - 2	1.0070	670 - 830	10 - 15	15 - 25
	P1	Heat-treatable steels	C 45	1.0503	650 - 800	10 - 15	15 - 25
	P1	Tool steels	21 MnCr 5	1.2162	720	8 - 10	10 - 15
	P1	Free-cutting steels	9 S 20 K	1.0711	360	10 - 15	15 - 25
	P1	Free-cutting steels	9 SMnPb 28	1.0718	380	10 - 15	15 - 25
	P1	Free-cutting steels	35 SMn 20	1.0726	490 - 610	10 - 15	15 - 25
	P1	Hot-Work steels	X 10 CrSi 13	1.4722	690	3 - 5	5 - 8
	P1	Cast Steels	GS 45	1.0443	440	10 - 15	15 - 25
	P1	Cast Steels	GS 60	1.0553	590	10 - 15	15 - 25
	P1	Cast Steels	GS 70	1.0554	685	10 - 15	15 - 25
	P1	Case-hardened steels	C 15	1.0401	600 - 800	10 - 15	15 - 25
	P1	Case-hardened steels	Ck 15	1.1141	500 - 800	10 - 15	15 - 25
	P2	Case-hardened steels	20 MnCr 5	1.7147	1000 - 1300	10 - 15	15 - 25
	P2	Case-hardened steels	17 CrNiMo 6	1.6587	1050 - 1350	2 - 5	5 - 10
	P2	Heat-treatable steels	C 60	1.0601	800 - 850	10 - 15	15 - 25
	P2	Heat-treatable steels	46 Cr 2	1.7003	700 - 850	2 - 5	5 - 10
	P2	Heat-treatable steels	25 CrMo 4	1.7218	800 - 950	2 - 5	5 - 10
	P2	Tool steels	105 WCr 6	1.2419		8 - 10	10 - 15
	P2	Tool steels	X 45 NiCrMo 4	1.2767	850	8 - 10	10 - 15
	P2	Tool steels	55 Ni Cr Mo V 6	1.2713	810	8 - 10	10 - 15
	P2	Nitriding Steels	31 CrMo 12	1.8515	1000 - 1200	3 - 5	5 - 8
	P2	Nitriding Steels	34 CrAlMo 5	1.8505	800 - 950	3 - 5	5 - 8
	P2	Nitriding Steels	34 CrAlNi 7	1.8550	850 - 1050	3 - 5	5 - 8

Work Piece Material Groups/Cutting Data

Material Groups DIN ISO 513	Schumacher	Description	DIN Description	DIN 17 007 Material-No.	Strength [N/mm2]	Cutting Speed v_c [m/min] v_c forming taps = v_c + 30-50% HSS-E / VHM bright	coated
M	M1	Stainless steels ferritic	X 6 Cr 13	1.4000	400 - 600	3 - 5	5 - 8
	M1	Stainless steels ferritic	X 4 CrMoS 18	1.4105	450 - 650	3 - 5	5 - 8
	M1	Stainless steels martensitic	X 30Cr 13	1.4028	800 - 1000	3 - 5	5 - 8
	M1	Stainless steels martensitic	X 12 CrMoS 17	1.4104	600 - 840	3 - 5	5 - 8
	M1	Stainless steels austenitic	X 5 CrNi 18 10	1.4301	500 - 700	3 - 5	5 - 8
	M1	Stainless steels austenitic	X 6 CrNiMoTi 17 12 2	1.4571	500 - 730	3 - 5	5 - 8
	M1	Stainless steels austenitic	X 2 CrNiMo 18 14 3	1.4435	490 - 690	3 - 5	5 - 8
	M1	Cast Steels	G X 6 CrNiMo 18 10	1.4408	440 - 640	3 - 5	5 - 8
	M1	Cast Steels	G X 2 CrNiMoN 17 13 5	1.4439	490 - 690	3 - 5	5 - 8
	M2	Duplex steels	X 2 CrNiMoN22-5-3	1.4462	880	3 - 5	5 - 8
K	K1	Grey cast iron	EN-GJL-100 (GG 10)	0.6010	88	8 - 12 | 25 - 30	12 - 20
	K1	Grey cast iron	EN-GJL-200 (GG 20)	0.6020	195	8 - 12 | 25 - 30	12 - 20
	K1	Grey cast iron	EN-GJL-300 (GG 30)	0.6030	295	8 - 12 | 25 - 30	12 - 20
	K1	Grey cast iron	EN-GJL-400 (GG 40)	0.6040	390	8 - 12 | 25 - 30	12 - 20
	K2	Nodular cast iron	EN-GJS-400-15 (GGG 40)	0.7040	400	5 - 8	10 - 20
	K2	Nodular cast iron	EN-GJS-500-7 (GGG 50)	0.7045	500	5 - 8	10 - 20
	K2	Nodular cast iron	EN-GJS-600-3 (GGG 60)	0.7060	600	5 - 8	10 - 20
	K3	Malleable cast iron	EN-GJMW-400-5 (GTW-40)	0.8040	400	10 - 15	15 - 20
	K3	Malleable cast iron	EN-GJMW-450-7 (GTW-45)	0.8045	450	10 - 15	15 - 20
	K3	Malleable cast iron	EN-GJMW-550-4 (GTW-55)	0.8055	550	10 - 15	15 - 20
	K3	Malleable cast iron	EN-GJMB-350-10 (GTS-35)	0.8135	350	10 - 15	15 - 20
	K3	Malleable cast iron	EN-GJMB-450-6 (GTS-45)	0.8145	450	10 - 15	15 - 20
	K3	Malleable cast iron	EN-GJMB-550-4 (GTS-55)	0.8155	550	10 - 15	15 - 20
N	N1	Aluminium wrought alloys	AlMn 1	3.0515	150 - 200	20 - 25	25 - 35
	N1	Aluminium wrought alloys	AlMg 3	3.3535	200 - 300	20 - 25	25 - 35
	N1	Aluminium wrought alloys	AlMgSiPb	3.0615	200 - 270	20 - 25	25 - 35
	N1	Aluminium wrought alloys	AlZn 4.5 Mg 1	3.4335		20 - 25	25 - 35
	N2	Aluminium cast alloys	G-Al Mg 3	3.3541	140 - 200	20 - 30	30 - 40
	N2	Aluminium cast alloys	G-Al Cu 4	3.1841	280 - 400	20 - 30	30 - 40
	N2	Aluminium cast alloys	G-Al Si 10 Mg	3.2381	250 - 320	20 - 30	30 - 40
	N3	Copper alloys	E-Cu	2.0060	250	10 - 15	15 - 20
	N3	Copper alloys	SE-Cu	2.0070	300	10 - 15	15 - 20
	N3	Special copper alloys	Ampco 18		159 - 183	2 - 4	4 - 6
	N3	Special copper alloys	Ampco 21		285 - 311	2 - 4	4 - 6
	N3	Special copper alloys	Ampco 25		356 - 394	2 - 4	4 - 6

Work Piece Material Groups/Cutting Data

Material Groups DIN ISO 513	Schumacher	Description	DIN Description	DIN 17 007 Material-No.	Strength [N/mm2]	Cutting Speed v_c [m/min] v_c forming taps = v_c + 30-50% HSS-E / VHM bright	coated
N	N4	Brass long chipping	Cu Zn 30 (Ms 70)	2.0265		20 - 25 | 30 - 50	25 - 35
	N4	Brass short chipping	CuZn 39 Pb 2 (Ms 58)	2.0380		20 - 25 | 30 - 50	25 - 35
	N4	Brass short chipping	Cu Zn 40 Al 2	2.0550		20 - 25 | 30 - 50	25 - 35
	N5	Bronze short chipping	CuPb 5 Sn 5	2.1170	250	10 - 15	15 - 20
	N5	Bronze long chipping	Cu Sn 6	2.1030	400 - 550	10 - 15	15 - 20
	N5	Bronze	G-CuPb 10 Sn	2.1176	230	10 - 15	15 - 20
	N6	Thermoplastics long chipping	Hostalen			20 - 30	30 - 40
	N6	Thermoplastics long chipping	Makrolon			20 - 30	30 - 40
	N6	Thermoplastics long chipping	PS Polystyrol			20 - 30	30 - 40
	N6	Thermoplastics long chipping	POM Polymethylen			20 - 30	30 - 40
	N6	Thermoplastics long chipping	PVC Ployvinylchlorid			20 - 30	30 - 40
	N6	Thermoplastics long chipping	PA Polyamid			20 - 30	30 - 40
	N7	Duroplastics short chipping	Bakelit			3 - 5	5 - 8
	N7	Duroplastics short chipping	Pertinax			3 - 5	5 - 8
	N7	Duroplastics short chipping	Ferrozell			3 - 5	5 - 8
	N7	Duroplastics short chipping	Resopal			3 - 5	5 - 8
	N8	Magnesium alloys	AZ 91			-	15 - 20
S	S1	Pure titanium	Ti 99.5	3.7024.1	290 - 410	2 - 4	4 - 6
	S1	Pure titanium	Ti 99.4	3.7055	450 - 550	2 - 4	4 - 6
	S1	Titanium alloys	TiAl 5 Sn 2	3.7114	840 - 990	2 - 4	4 - 6
	S1	Titanium alloys	Ti Al 6V4	3.7165	910 - 1100	2 - 4	4 - 6
	S2	Pure nickel	Ni 99.6	2.4060	370 - 590	2 - 4	4 - 6
	S2	Pure nickel	Ni 99.2	2.4068	340 - 540	2 - 4	4 - 6
	S2	Nickel alloys	Monel 400	2.4360	800	2 - 4	4 - 6
	S2	Nickel alloys	Hastelloy C	2.4812	900	2 - 4	4 - 6
	S2	Nickel alloys	Inconel 600	2.4816	700	2 - 4	4 - 6
	S2	Nickel alloys	Nimonic 90	2.4632	1200	2 - 4	4 - 6
H	H1	Hardened steels	up to 50 HRC			6 - 8	2 - 4
	H2	Hardened steels	up to 55 HRC			1 - 3	1 - 3
	H2	Hardened steels	up to 60 HRC			1 - 3	-

item code	catalog page	item code	catalog page	item code	catalog page
10100	2.85	30300/25	2.6	31700/48	2.32
10105	2.85	30300/2540	2.6	31800	2.34
10200	2.85	30500/4853	2.74	31900/25	2.36
10205	2.87	30510/0253	2.76	31900/26	2.36
10300	2.87	30510/2453	2.76	31900/5760	2.39
10305	2.87	30530/4853	2.78	32000	2.41
12100	3.16	30550/5367	2.80	32000/25	2.41
12200	3.16	30600/2553	2.82	32000/2540	2.41
13100	4.12	30600/53	2.82	32400	2.43
13200	4.12	30600 B/2553	2.82	32400/48	2.43
13500	4.10	30800/54	2.8	32600	2.46
13600	4.11	30810/4064	2.10	32800	2.48
15100	5.21	30810/64	2.10	33000	2.50
15200	5.21	30900/4060	2.12	33000/25	2.53
15300	5.21	31000/02	2.13	33000/42	2.53
16100	5.39	31000/24	2.13	33000 B	2.50
16200	5.39	31100	2.15	33000 E	2.50
17100	6.3	31100/25	2.18	33005	2.53
17200	6.3	31100/42	2.18	33010/6368	2.55
17300	6.1	31100 B	2.15	33030/4048	2.57
17500	6.2	31100 E	2.15	33030/48	2.57
18100	6.5	31105	2.18	33300/25	2.59
18200	6.5	31130/48	2.20	33300/26	2.59
18300	6.4	31200/25	2.22	33300/5760	2.62
20100	2.89	31200/26	2.22	33400/48	2.64
20200	2.89	31210/48	2.24	33500/25	2.66
20300	2.89	31300/48	2.26	33500/26	2.66
30000	2.2	31400	2.28	33510/48	2.68
30200	2.5	31600	2.30	33600/02	2.70
30300/01	2.6	31700	2.32	33600/24	2.70

item code	catalog page	item code	catalog page	item code	catalog page
33800	2.72	40000	2.4	41800	2.35
33800/48	2.72	40300/01	2.7	41900/25	2.38
34000	5.1	40300/25	2.7	41900/26	2.38
34300/01	5.3	40300/2540	2.7	41900/5760	2.40
34500	5.5	40500/4853	2.75	42000	2.42
34500/25	5.5	40510/0253	2.77	42000/25	2.42
34600/25	5.7	40510/2453	2.77	42000/2540	2.42
34600/26	5.7	40530/4853	2.79	42400	2.44
34800	5.12	40550/5367	2.81	42400/48	2.44
34900/26	5.9	40600/2553	2.84	42410/4048	2.45
35200	5.14	40600/53	2.84	42600	2.47
35200/25	5.14	40800/54	2.9	42800	2.49
35300/25	5.16	40810/4064	2.11	43000	2.52
35300/26	5.16	40810/64	2.11	43000/25	2.54
35600/2553	5.20	41000/02	2.14	43000/42	2.54
35600/53	5.20	41000/24	2.14	43000 B	2.52
35900/26	5.18	41100	2.17	43005	2.52
36000	5.22	41100/25	2.19	43010/63	2.56
36300/01	5.24	41100/42	2.19	43030/48	2.58
36500	5.26	41100 B	2.17	43300/25	2.61
36500/25	5.26	41105	2.17	43300/26	2.61
36600	5.28	41130/48	2.21	43300/5760	2.63
36600/25	5.28	41200/25	2.23	43400/48	2.65
36800	5.32	41200/26	2.23	43500/25	2.67
36900/26	5.30	41210/48	2.25	43500/26	2.67
37200	5.33	41300/48	2.27	43510/48	2.69
37200/25	5.33	41400	2.29	43600/02	2.71
37300	5.35	41600	2.31	43600/24	2.71
37300/25	5.35	41700	2.33	43800	2.73
37900/26	5.37	41700/48	2.33	43800/48	2.73

item code	catalog page
44000	5.2
44300/01	5.4
44500	5.6
44500/25	5.6
44600/25	5.8
44600/26	5.8
44710/4048	5.11
44800	5.13
44900/26	5.10
45200	5.15
45200/25	5.15
45300/25	5.17
45300/26	5.17
45900/26	5.19
46000	5.23
46300/01	5.25
46500	5.27
46500/25	5.27
46600	5.29
46600/26	5.29
46900/26	5.31
47200	5.34
47200/25	5.34
47300	5.36
47300/25	5.36
47900/26	5.38
50000	3.1
50300/01	3.5
51000	3.6
51000/25	3.6

item code	catalog page
51200	3.10
51200/25	3.10
51900/26	3.11
52000	3.12
53000	3.13
53000/25	3.13
53300/26	3.14
53500	3.15
53500/25	3.15
55000	4.1
55300/01	4.2
56000	4.3
56000/25	4.3
56200	4.4
56200/25	4.4
56900/26	4.5
57000	4.6
58000	4.7
58000/25	4.7
58300/26	4.8
58500	4.9
58500/25	4.9
68100	6.7
68105	6.8
68200	6.7
68205	6.8
68300	6.7
68305	6.8
68500	6.6
68505	6.6

item code	catalog page
G0100/41	2.90
G0600/5360	2.93
G0700/5360	2.93
G0800/40	2.91
G0800	2.91
G2600/40	2.92
G5800/40	3.19
S1000	7.8
S1200	7.9
S1400	7.10
S2000	7.2
S2200	7.3
S2400	7.4
S4000	7.5
S4200	7.6
S4400	7.7

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