

CARBIDE TAPS STRAIGHT FLUTES DIN STANDARD

- ✓ This cutting edge geometry produces short chips even in long chipping materials
- ✓ High speed & higher productivity results in less CPC
- ✓ Also internal through coolant taps available which enables optimum transportation of swarf
- ✓ Grey Cast Iron & SG Iron

Standard	Size	Pitch	OAL (L) mm	Thread Length (L1) mm	Recess Length mm	Shank Dia (D3) mm	Square (a) mm	Square Length (L3) mm	No. of Flutes	Tapping Drill Dia mm
DIN 371	M 3	0.5	56.0	8.0	18.0	3.5	2.7	6.0	3	2.5
	M 4	0.7	63.0	10.0	21.0	4.5	3.4	6.0	3	3.3
	M 5	0.8	70.0	10.0	25.0	6.0	4.9	8.0	3	4.2
	M 6	1	80.0	12.0	30.0	6.0	4.9	8.0	4	5
	M 8	1.25	90.0	16.0	35.0	8.0	6.2	9.0	4	6.8
	M 10	1.5	100.0	18.0	39.0	10.0	8.0	11.0	4	8.5
DIN 376	M 12	1.75	110.0	18.0	---	9.0	7.0	12.0	4	10.2
	M 14	2	110.0	20.0	---	11.0	9.0	12.0	4	12
	M 16	2	110.0	20.0	---	12.0	9.0	12.0	4	14

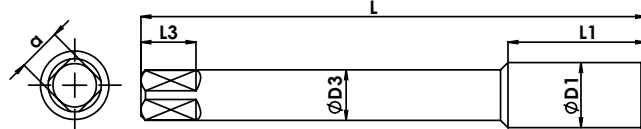
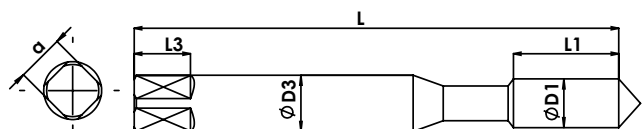


CARBIDE TAPS 15° SPIRAL FLUTES DIN STANDARD

- ✓ Low helix (15°) and new geometry suitable for short and long chipping materials
- ✓ Special flute geometry for excellent chip evacuation
- ✓ Edge polishing done on cutting edges which avoids chipping off
- ✓ Steel - 700 N/mm² to 1100N/mm²

Standard	Size	Pitch	OAL (L) mm	Thread Length (L1) mm	Recess Length mm	Shank Dia (D3) mm	Square (a) mm	Square Length (L3) mm	No. of Flutes	Tapping Drill Dia mm
DIN 371	M 3	0.5	56.0	8.0	18.0	3.5	2.7	6.0	3	2.5
	M 4	0.7	63.0	10.0	21.0	4.5	3.4	6.0	3	3.3
	M 5	0.8	70.0	10.0	25.0	6.0	4.9	8.0	3	4.2
	M 6	1	80.0	12.0	30.0	6.0	4.9	8.0	3	5
	M 8	1.25	90.0	16.0	35.0	8.0	6.2	9.0	3	6.8
	M 10	1.5	100.0	18.0	39.0	10.0	8.0	11.0	3	8.5
DIN 376	M 12	1.75	110.0	18.0	---	9.0	7.0	12.0	4	10.2
	M 14	2	110.0	20.0	---	11.0	9.0	12.0	4	12
	M 16	2	110.0	20.0	---	12.0	9.0	12.0	4	14





CARBIDE TAPS FORMING DIN STANDARD

- ✓ New chamfer geometry for uniform load distribution
- ✓ Optimised lobe form reduces friction and increases tool life
- ✓ High parameters and higher productivity for optimum output
- ✓ Aluminium & Aluminium Alloys

Standard	Size	Pitch	OAL (L) mm	Thread Length (L1) mm	Recess Length mm	Shank Dia (D3) mm	Square (a) mm	Square Length (L3) mm	Tapping Drill Dia mm
DIN 371	M 3	0.5	56.0	6.0	18.0	3.5	2.7	6.0	2.8
	M 4	0.7	63.0	7.5	21.0	4.5	3.4	6.0	3.7
	M 5	0.8	70.0	8.5	25.0	6.0	4.9	8.0	4.7
	M 6	1	80.0	11.0	30.0	6.0	4.9	8.0	5.5
	M 8	1.25	90.0	14.0	35.0	8.0	6.2	9.0	7.4
	M 10	1.5	100.0	16.0	39.0	10.0	8.0	11.0	9.3



6HX



CARBIDE TAPS FORMING DIN STD - WITH INTERNAL COOLANT

- ✓ Forming taps available in Axial and Radial internal coolant

Standard	Size	Pitch	OAL (L) mm	Thread Length (L1) mm	Recess Length mm	Shank Dia (D3) mm	Square (a) mm	Square Length (L3) mm	Tapping Drill Dia mm
DIN 371	M 3	0.5	56.0	6.0	18.0	3.5	2.7	6.0	2.8
	M 4	0.7	63.0	7.5	21.0	4.5	3.4	6.0	3.7
	M 5	0.8	70.0	8.5	25.0	6.0	4.9	8.0	4.7
	M 6	1	80.0	11.0	30.0	6.0	4.9	8.0	5.5
	M 8	1.25	90.0	14.0	35.0	8.0	6.2	9.0	7.4
	M 10	1.5	100.0	16.0	39.0	10.0	8.0	11.0	9.3



CASE STUDY FOR FORMING TAP

Industry Segment	Automotive
Tap series	SDK1 (Carbide Roll Tap)
Size	M6 X 1 SDK1 DIN 371
Component	Crank Case (Motorbike)
Work material	ADC12 (upto 12% Silicon)
Type of hole	Blind hole / Through hole
Hole dia	5.50 mm
Drill depth	18.0 mm
Tapping depth	14.0 mm
Machine	Vertical Machining Centre
Tapping direction	Vertical
Speed (Vc)	50 m/min
Coolant	Water Soluble Oil (external flood coolant)
Tool Life	8.1 km
Competitor tool life	4.0 km



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