DORMER PRAMET

THREADING 2021 – 2022



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THREADING – GENERAL CONTENT

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DORMER PRAMET

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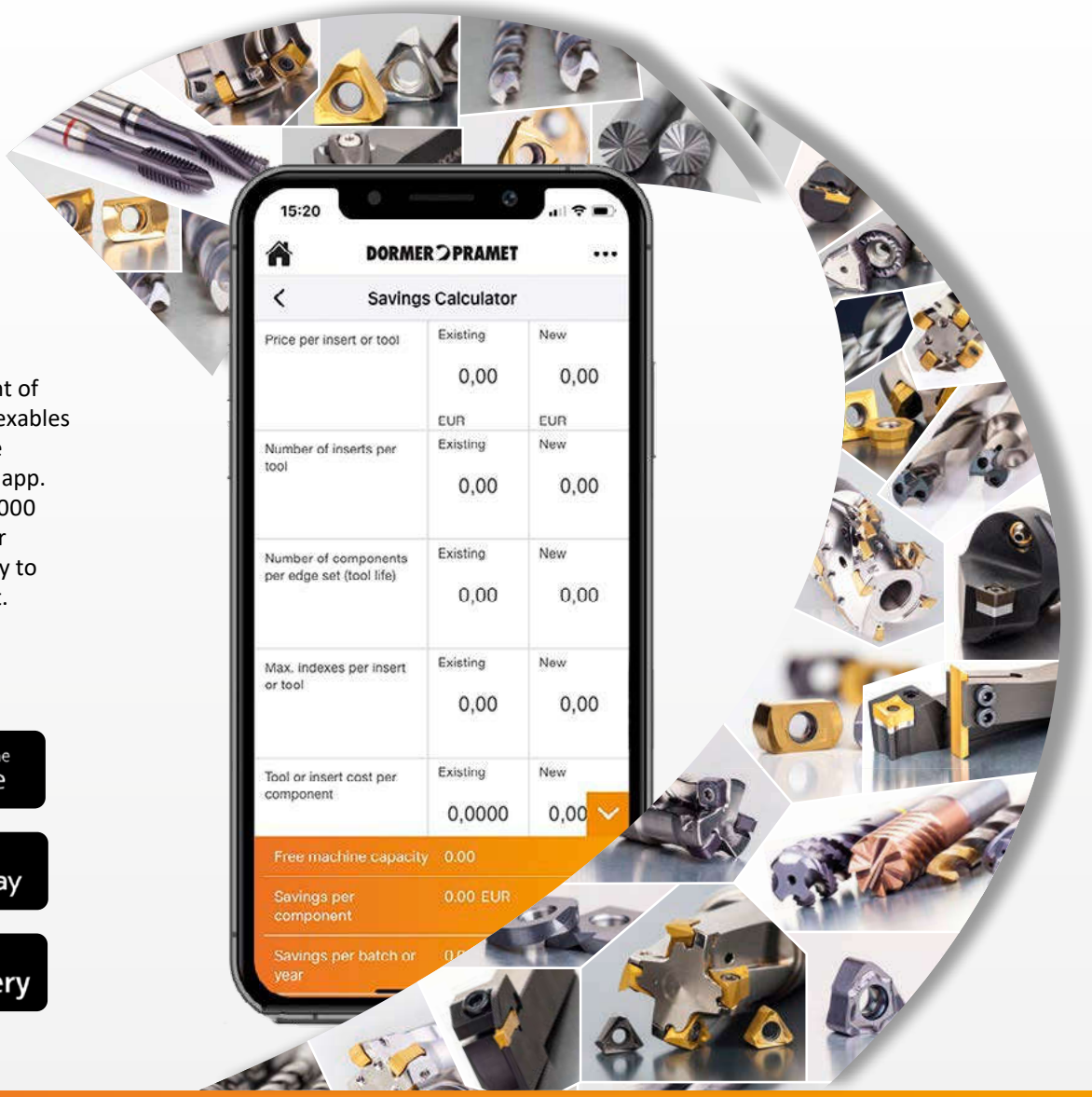
DORMER PRAMET

ALL TOOLS TOGETHER



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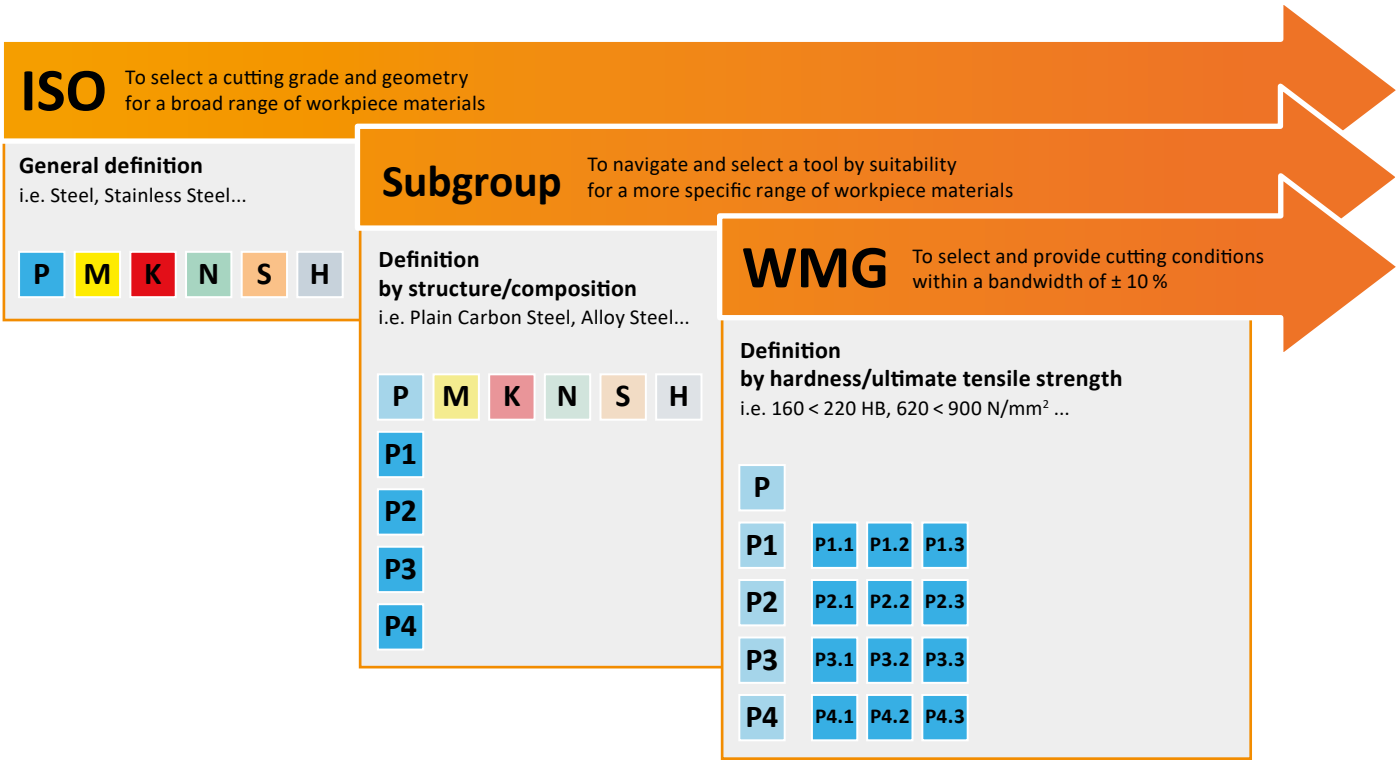
WORKPIECE MATERIAL GROUPS (WMG)



ABOUT DORMER PRAMET'S WORKPIECE MATERIAL CLASSIFICATION

Workpiece **M**aterial **G**roups (**WMG**) are used to support easy and reliable selection of the right cutting tool and starting values for machining conditions in particular applications.

Dormer Pramet classifies workpiece materials into six different coloured groups;

- **Blue**: Steel and cast steel (P-group)
- **Yellow**: Stainless steel (M-group)
- **Red**: Cast iron (K-group)
- **Green**: Non-ferrous metals (N-group)
- **Brown**: High-temperature alloys (S-group)
- **Grey**: Hardened materials (H-group)

Each of these are divided into subgroups on the basis of their structure and/or composition. For example, P-group steel and cast steel is split into four subgroups, namely;

- **P1** – Free machining steel
- **P2** – Plain carbon steel
- **P3** – Alloy steel
- **P4** – Tool steel

A final division includes material properties, such as hardness and ultimate tensile strength. This is to provide our customers with a complete tool recommendation, including starting values for cutting speed and feed.

The table on the next page includes a description of each workpiece material group, as well as examples of commonly used designations.

WMG (WORK MATERIAL GROUP)

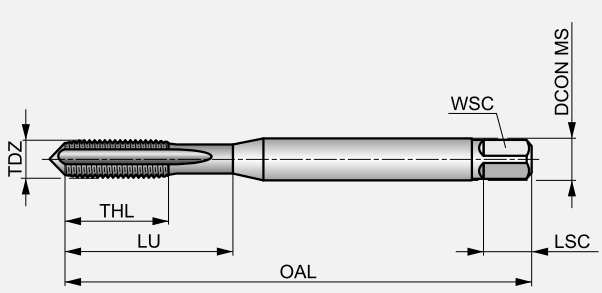
ISO group		WMG (Work Material Group)			Hardness (HB or HRC)	Ultimate Tensile Strength (MPa)
P	P1	P1.1	Free machining steel (carbon steels with increased machinability)	Sulfurized	< 240 HB	≤ 830
		P1.2		Sulfurized and phosphorized	< 180 HB	≤ 620
		P1.3		Sulfurized/phosphorized and leaded	< 180 HB	≤ 620
	P2	P2.1	Plain carbon steel (steels comprised of mainly iron and carbon)	Containing <0.25 % C	< 180 HB	≤ 620
		P2.2		Containing <0.55 % C	< 240 HB	≤ 830
		P2.3		Containing >0.55 % C	< 300 HB	≤ 1030
	P3	P3.1	Alloy steel (carbon steels with an alloying content ≤ 10%)	Annealed	< 180 HB	≤ 620
		P3.2		Hardened and tempered	180 – 260 HB	> 620 ≤ 900
		P3.3			260 – 360 HB	> 900 ≤ 1240
	P4	P4.1	Tool steel (special alloy steel for tools, dies and molds)	Annealed	< 26 HRC	≤ 900
		P4.2		Hardened and tempered	26 – 39 HRC	> 900 ≤ 1240
		P4.3			39 – 45 HRC	> 1240 ≤ 1450
M	M1	M1.1	Ferritic stainless steel (straight chromium non-hardenable alloys)		< 160 HB	≤ 520
		M1.2			160 – 220 HB	> 520 ≤ 700
	M2	M2.1	Martensitic stainless steel (straight chromium hardenable alloys)	Annealed	< 200 HB	≤ 670
		M2.2		Quenched and tempered	200 – 280 HB	> 670 ≤ 950
		M2.3		Precipitation-hardened	280 – 380 HB	> 950 ≤ 1300
	M3	M3.1	Austenitic stainless steel (chromium-nickel and chromium-nickel-manganese alloys)		< 200 HB	≤ 750
		M3.2			200 – 260 HB	> 750 ≤ 870
		M3.3			260 – 300 HB	> 870 ≤ 1040
	M4	M4.1	Austenitic-ferritic (DUPLEX) or super-austenitic stainless steel		< 300 HB	≤ 990
		M4.2	Precipitation hardening austenitic stainless steel		300 – 380 HB	≤ 1320
K	K1	K1.1	Gray iron or Automotive Gray iron (GG) (iron-carbon castings with a lamellar graphite microstructure)	Ferritic or ferritic-pearlitic	< 180 HB	≤ 190
		K1.2		Ferritic-pearlictic or pearlitic	180 – 240 HB	> 190 ≤ 310
		K1.3		Pearlitic	240 – 280 HB	> 310 ≤ 390
	K2	K2.1	Malleable iron (GTS/GTW) (iron-carbon castings with a graphite-free microstructure)	Ferritic	< 160 HB	≤ 400
		K2.2		Ferritic or pearlitic	160 – 200 HB	> 400 ≤ 550
		K2.3		Pearlitic	200 – 240 HB	> 550 ≤ 660
	K3	K3.1	Ductile iron (GGG) (iron-carbon castings with a nodular graphite microstructure)	Ferritic	< 180 HB	≤ 560
		K3.2		Ferritic or pearlitic	180 – 220 HB	> 560 ≤ 680
		K3.3		Pearlitic	220 – 260 HB	> 680 ≤ 800
	K4	K4.1	Austenitic gray iron (ASTM A436) (iron-carbon alloy castings with an austenitic lamellar graphite microstructure)		< 180 HB	≤ 190
		K4.2	Austenitic ductile iron (ASTM A439 or ASTM A571) (iron-carbon alloy castings with an austenitic nodular graphite microstructure)		< 240 HB	≤ 740
		K4.3	Austempered ductile iron (ASTM A897) (iron-carbon alloy castings with an ausferrite microstructure)		< 280 HB	> 840 ≤ 980
		K4.4			280 – 320 HB	> 980 ≤ 1130
		K4.5			320 – 360 HB	> 1130 ≤ 1280
	K5	K5.1	Compacted graphite iron CGI (ASTM A842) (iron-carbon castings with a vermicular graphite structure)	Ferritic	< 180 HB	≤ 400
		K5.2		Ferritic-pearlitic	180 – 220 HB	> 400 ≤ 450
		K5.3		Pearlitic	220 – 260 HB	> 450 ≤ 500
N	N1	N1.1	Commercially pure wrought aluminium		< 60 HB	≤ 240
		N1.2	Wrought aluminium alloys	Half hard tempered	60 – 100 HB	> 240 ≤ 400
		N1.3		Full hard tempered	100 – 150 HB	> 400 ≤ 590
	N2	N2.1	Cast aluminium alloys		< 75 HB	≤ 240
		N2.2			75 – 90 HB	> 240 ≤ 270
		N2.3			90 – 140 HB	> 270 ≤ 440
	N3	N3.1	Free-cutting copper-alloys materials with excellent machining properties		–	–
		N3.2	Short-chip copper-alloys with good to moderate machining properties		–	–
		N3.3	Electrolytic copper and long-chip copper-alloys with moderate to poor machining properties		–	–
	N4	N4.1	Thermoplastic polymers		–	–
		N4.2	Thermosetting polymers		–	–
		N4.3	Reinforced polymers or composites		–	–
	N5	N5.1	Graphite		–	–
S	S1	S1.1	Titanium or titanium alloys		< 200 HB	≤ 660
		S1.2			200 – 280 HB	> 660 ≤ 950
		S1.3			280 – 360 HB	> 950 ≤ 1200
	S2	S2.1	Fe-based high-temperature alloys		< 200 HB	≤ 690
		S2.2			200 – 280 HB	> 690 ≤ 970
	S3	S3.1	Ni-based high-temperature alloys		< 280 HB	≤ 940
		S3.2			280 – 360 HB	> 940 ≤ 1200
	S4	S4.1	Co-based high-temperature alloys		< 240 HB	≤ 800
		S4.2			240 – 320 HB	> 800 ≤ 1070
H	H1	H1.1	Chilled cast iron		< 440 HB	–
	H2	H2.1	Hardened cast iron		< 55 HRC	–
		H2.2			> 55 HRC	–
	H3	H3.1	Hardened steel <55 HRC		< 51 HRC	–
		H3.2			51 – 55 HRC	–
	H4	H4.1	Hardened steel >55 HRC		55 – 59 HRC	–
		H4.2			> 59 HRC	–

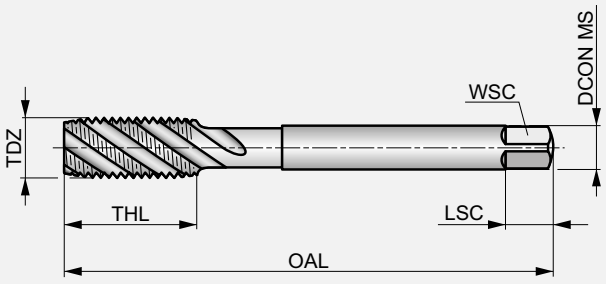
CUTTING TOOL PARAMETERS ACCORDING TO ISO 13399

All cutting tools are defined by a number of parameters according to the standard ISO 13399. This list contains all the parameters used in this catalogue and their definitions.

ISO 13399 is an international cutting tool information standard. It provides dimensions and parameters in a neutral format that is independent of any particular system or company nomenclature. When cutting tools are clearly defined according to a global standard, all types of software can process the electronic data more quickly, improving the quality of communication and helping to make the exchange of information run smoothly. Supporting a common language in our cutting tool descriptions this will assist system to system communication. It will save you a significant amount of time, providing an easier gathering of high-quality data across our 40,000 solid and indexable tools. By using an ISO 13399 compliant system, there will be no need to manually interpret data and key-enter it into your system.

EXAMPLES ONLY!





ISO 13399	Description
BD	Body diameter
DCON MS	Connection diameter
DRVS	Drive size
LDP	Drill part length
LSC	Clamping length
LU	Usable Length
NOF	Flute count
OAL	Overall length
PHD	Premachined hole diameter
PRAT_HEADER	Description

ISO 13399	Description
TCL	Tap chamfer length
TD	Thread diameter
TDZ	Thread diameter size
THL	Threading length
TP	Thread pitch
TPI	Threads per inch
WSC	Clamping width
WSCN	Clamping width minimum
WSCX	Clamping width maximum

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SOLID CARBIDE,
MATERIAL SPECIFIC & HSS TAPS



THREADING – GENERAL CONTENT

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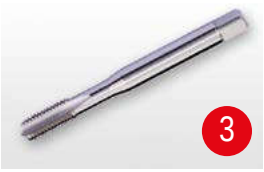
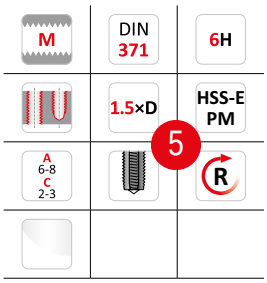
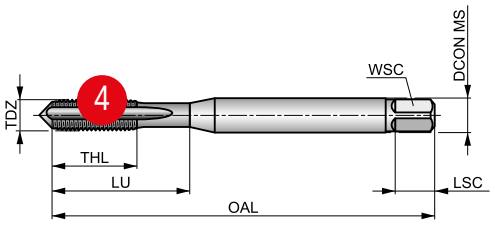


HSS-E-PM Straight Flute Machine Tap, Metric, DIN371 Standard, Bright Finish

The straight flute design makes it suitable for both through and blind holes whilst the bright finish means workpiece material will not stick to the cutting edge, so giving you a more accurate finish on the thread. Suitable for a wide range of materials.





Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	K1.1	K1.2	K1.3	K2.1	K2.2
■11	■12	■12	■9	■8	◩7	■7	◩6	◩4	◩13	◩10	◩8	◩14	◩11

K3.1	K3.2	K4.1	K4.2	K5.1	K5.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N4.2
◩12	◩9	◩12	◩9	◩12	◩10	◩12	◩15	◩14	◩11	◩21	■14	◩8

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E200M2	2	0.40	45.0	6	2.80	2.10	5	3	1.60	9.00
E200M2.5	2.5	0.45	50.0	8	2.80	2.10	5	3	2.05	12.50
E200M3	3	0.50	56.0	9	3.50	2.70	6	3	2.50	18.00
E200M3N01	3	0.50	56.0	9	3.50	2.70	6	3	2.50	18.00
E200	4	0.70	63.0	12	4.50	3.40	6	3	3.30	21.00
E200 01	4	0.70	63.0	12	4.50	3.40	6	3	3.30	21.00
E200M5	5	0.80	70.0	13	6.00	4.90	8	3	4.20	25.00
E200M5N01	5	0.80	70.0	13	6.00	4.90	8	3	4.20	25.00
E200M6	6	1.00	80.0	15	6.00	4.90	8	3	5.00	30.00
E200M6N01	6	1.00	80.0	15	6.00	4.90	8	3	5.00	30.00
E200M8	8	1.25	90.0	18	8.00	6.20	9	3	6.80	35.00
E200M8N01	8	1.25	90.0	18	8.00	6.20	9	3	6.80	35.00
E200M10	10	1.50	100.0	20	10.00	8.00	11	3	8.50	39.00
E200M10N01	10	1.50	100.0	20	10.00	8.00	11	3	8.50	39.00

Pos.	Description
1	Designation of taps
2	Product description
3	Illustrative picture
4	Schematic drawing of tool

Pos.	Description
5	Product features
6	Material group recommendations incl. speed and feed guidance
7	Product code
8	Product dimensions

Typical page with tap holder displayed – specific page details will differ.

SOLID CARBIDE TAPS – HSS TAPS – ICONS OVERVIEW

General icons

■	Primary use
◪	Possible use

Basic standard group (BSG)

ANSI B94.9	ANSI B94.9 – Tap Standard
ANSI	ANSI – Tap Standard
ANSI DORMER	ANSI Dormer Standard
DIN 2174	DIN 2174 – Forming Tap Standard
DIN 2181	DIN 2181 – Hand Tap Standard
DIN 2184-1	DIN 2184-1 – Tap Standard
DIN 351	DIN 351 – Straight Flute Tap Standard
DIN 352	DIN 352 – Thread Form Standard
DIN 357	DIN 357 – Nut Tap Standard
DIN 371	DIN 371 – Thread Form Standard
DIN 374	DIN 374 – MF Thread Standard
DIN 376	DIN 376 – Thread Form Standard
DIN 40432	DIN 40432 – PG Thread Standard
DIN 5156	DIN 5156 – Thread Form Standard
DIN 5157	DIN 5157 – Pipe Thread Standard
DIN DORMER	DIN Dormer Standard
DIN 371/376	DIN Thread Standard (based on size range) DIN 371 if Ø ≤ 10mm / DIN 376 if Ø ≥ 12mm
ISO 2283	ISO 2283 – Long Shank Tap Standard
ISO 2284	ISO 2284 – Pipe Tap Standard
ISO 529	ISO 529 – Tap Standard
ISO DORMER	ISO Dormer Standard

Material code (BMC)

HSS-E PM	High Speed Cobalt Powder Metal Tool Material
HSS-E	High Speed Cobalt Steel Tool Material
HSS	High Speed Steel Tool Material
HM	Hard Material (Solid Carbide)

Coating

Bright	Bright (uncoated)
Bright ST	Combination Bright and Steam Tempered
Cr	Flash Chrome (Hard Chrome) Plating
Super B	Special TiAlN Coating (+ WC/C)
ST	Steam Tempered (Steam Oxide) Surface Treatment
TiAlN Top	Titanium Aluminium Nitride Coating (with smoothing process)
TiAlN	Titanium Aluminium Nitride Coating
TiN	Titanium Nitride Coating
TiCN	Titanium Carbon Nitride Coating

Coolant exit style code (CXSC)

	Through Tool Coolant – Radial Exit
	Through Tool Coolant – Axial Exit

Flute helix angle (FHA)

λ 15°	15° Helix Angle (Flute)
λ 27°	27° Helix Angle (Flute)
λ 30°	30° Helix Angle (Flute)
λ 35°	35° Helix Angle (Flute)
λ 40°	40° Helix Angle (Flute)
λ 45°	45° Helix Angle (Flute)
λ 48°	48° Helix Angle (Flute)

SOLID CARBIDE TAPS – HSS TAPS – ICONS OVERVIEW

Flute Geometry (FDC)

	Fluteless Geometry (Threadforming)
	Oil Grooves Geometry (Threadforming)
	Spiral Flute Geometry
	Spiral Point Geometry
	Straight Flute Geometry

Hand (Cutting direction)

	Left Hand Rotation / Cutting
	Right Hand Rotation / Cutting

Tap chamfer style (TCS)

E 1.5-2	Full Bottoming Tap Chamfer (1.5-2 Pitch Lead)
B 3.5-5	Plug Tap Chamfer (3.5-5 Pitch Lead)
C 2-3	Semi-Bottoming Tap Chamfer (2-3 Pitch Lead)
C 2-3.5	Semi-Bottoming Tap Chamfer (2-3.5 Pitch Lead)
A 6-8 C 2-3	Tap Chamfers; A = Taper (6-8 Pitch Lead) & C = Semi-Bottoming (2-3 Pitch Lead)
C 2-3 D 18-20	Tap Chamfers; C = Semi-Bottoming (2-3 Pitch Lead) & D = Nut Style (18-20 Pitch Lead)

Thread form type (THFT)

NPSF	Thread Form, American National Pipe Straight Fuel (Dryseal)
NPSM	Thread Form, American National Pipe Straight Mechanical
NPT	Thread Form, American National Pipe Taper
NPTF	Thread Form, American National Pipe Taper Fuel (Dryseal)
BA	Thread Form, British Association Screw Threads
BSF	Thread Form, British Standard Fine
G	Thread Form, British Standard Pipe (BSP)
Rc	Thread Form, British Standard Taper Pipe, 1:16 Taper (BSPT)
BSW	Thread Form, British Standard Whitworth
M	Thread Form, Metric Coarse
MF	Thread Form, Metric Fine
EGM	Thread Form, Metric ISO (Screw Thread Insert Type)
PG	Thread Form, Steel Conduit DIN 40430 (electrical)
UNC	Thread Form, Unified Coarse
UNF	Thread Form, Unified Fine
UN	Thread Form, Unified National

Thread Tolerance Zone class (TCTR)

6H	DIN Thread Pitch Diameter Tolerance Zone (high basic pitch diameter)
6G	DIN Thread Pitch Diameter Tolerance Zone (low basic pitch diameter)
6HX	DIN Thread Pitch Diameter Tolerance Zone (with increased pitch diameter)
6GX	DIN Thread Pitch Diameter Tolerance Zone (with increased pitch diameter)
2B	Internal Inch Thread Medium Class of Fit
2BX	Internal Inch Thread Medium Class of Fit (with increased pitch diameter)
Medium	Medium Inch Thread Class of Fit
Normal	Normal Fit Class for Pipe Thread

Threading application

	Blind Hole Application
	Through Hole Application
	Through or Blind Hole Application

Usable length diameter ratio (ULDR)

1.5×D	1.5×D Useable Tool Depth to Diameter Ratio
2.5×D	2.5×D Useable Tool Depth to Diameter Ratio
2×D	2×D Useable Tool Depth to Diameter Ratio
3.5×D	3.5×D Useable Tool Depth to Diameter Ratio
3×D	3×D Useable Tool Depth to Diameter Ratio



SOLID CARBIDE TAPS

Carbide materials

Carbide Materials (or Hard Materials)	HM	A sintered powder metallurgy substrate, consisting of a metallic carbide composite with binder metal. The most central raw material is tungsten carbide (WC). Tungsten carbide contributes to the hardness of the material. Tantalum carbide (TaC), titanium carbide (TiC) and niobium carbide (NbC) complements WC and adjusts the properties to what is desired. These three materials are called cubic carbides. Cobalt (Co) acts as a binder and keeps the material together. Carbide materials are often characterised by high compression strength, high hardness and therefore high wear resistance, but also by limited flexural strength and toughness. Carbide is used in taps, reamers, milling cutters, drills and thread milling cutters.

Surface Treatments

Bright (uncoated)		Bright finish (uncoated surface) improves chip flow in soft or non-ferrous materials and maintains sharp cutting edges in abrasive materials.

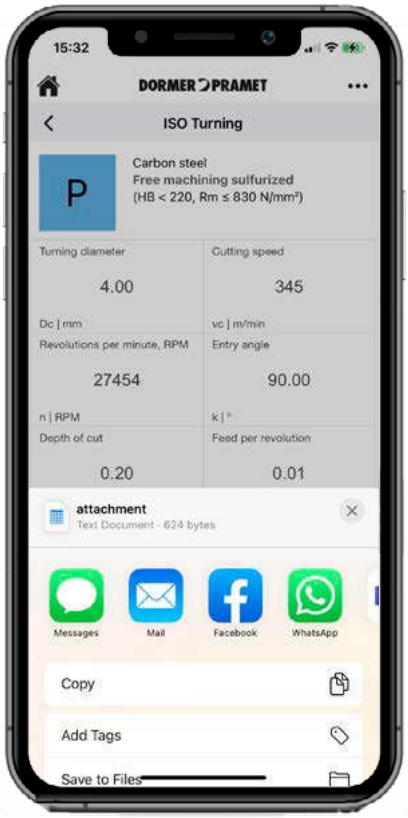
Surface Coatings

Titanium Carbon Nitride Coating (TiCN)		Titanium Carbon Nitride is a ceramic coating applied by PVD coating technology. TiCN is harder than TiN and has a lower coefficient of friction. Its hardness and toughness in combination with good wear resistance ensures that it finds its principal application in the field of milling to enhance the performance of milling cutters.
Super-B Coating (TiAlN/ WC/C)		Super B is a Titanium Aluminium Nitride + Tungsten Carbide + Carbon Coating used for wet and minimal lubrication machining in drilling, milling and tapping applications. Very effective for cast iron, hardened steels and heat resistant super alloys.

DORMER PRAMET

ALWAYS CONNECT

No wifi or internet connection? The machining calculator works perfectly even when you are offline, making sure it's always available when you need it. **Simply Reliable.**



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Thread form (THFT)		M	M	M	M	M	M							
Basic standard group (BSG)		DIN 371/376	DIN 371/376	DIN 371	DIN 371/376	DIN 371/376	DIN 2174							
Thread tolerance class (TCTR)		6H	6HX	6HX	6H	6H	6HX							
Threading application														
Usable length (ULDR)		2×D	2.5×D	2×D	2×D	2.5×D	3×D							
Material code (BMC)		HM	HM	HM	HM	HM	HM							
Tap chamfer style (TCS)		C 2-3	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3.5							
Flute Geometry (FDC)														
Flute helix angle (FHA)					λ 15°	λ 15°								
Hand (Cutting direction)		R	R	R	R	R	R							
Coating		TiCN	Super B	TiCN	Bright	Bright	TiCN							
Coolant exit style (CXSC)														
Product Family Code		T200	T201	T210	T205	T206	T215							
		M3 - M12	M5 - M16	M3 - M12	M3 - M12	M5 - M12	M3 - M10							
		19	20	21	22	23	24							
P	P1						■							
	P2						■							
	P3						■							
	P4						■							
M	M1						■							
	M2						■							
	M3						■							
	M4						◪							
K	K1	◪	■		◪	◪								
	K2		◪		■	■								
	K3		◪		■	■								
	K4		◪		■	■								
	K5		◪		■	■								
N	N1						■							
	N2		◪		■	■	■							
	N3						■							
	N4	◪	◪		◪	◪								
	N5													
S	S1													
	S2													
	S3													
	S4													
H	H1	■		◪										
	H2	◪		◪										
	H3	■		◪										
	H4	◪		■										

■ Primary use ◪ Possible use

T200

DORMER

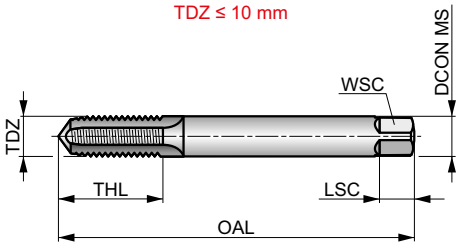


Carbide Straight Flute Machine Tap, Metric, with TiCN Coating, DIN Standard

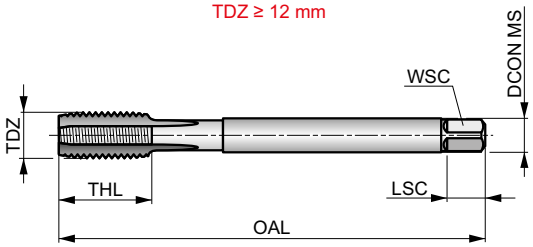
Superior performance and great tool life at high speeds. Suitable for machine tapping in tool steels, high silicon aluminium and other hardened and abrasive materials. The straight flute design makes the taps ideal for threading both through and blind holes. TiCN coated to improve performance and extend tool life.

M	DIN 371/376	6H
2×D		HM
C 2-3		R
TiCN		

TDZ ≤ 10 mm



TDZ ≥ 12 mm



Workpiece material group suitability and starting values for cutting speed (m/min).

K1.1	K1.2	K1.3	N2.3	N3.2	N4.2	N4.3	H1.1	H2.1	H2.2	H3.1	H3.2	H4.1	H4.2
◪60	◪44	◪33	◪60	◪7	◪50	◪30	■11	■7	◪5	■7	■6	◪4	◪3

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
T200M3 [1]	3	0.50	56.0	10	3.50	2.70	6	3	2.60	–
T200M4 [1]	4	0.70	63.0	13	4.50	3.40	6	3	3.40	–
T200M5 [1]	5	0.80	70.0	16	6.00	4.90	8	3	4.30	–
T200M6	6	1.00	80.0	19	6.00	4.90	8	3	5.10	30.00
T200M8	8	1.25	90.0	22	8.00	6.20	9	3	6.90	35.00
T200M10	10	1.50	100.0	24	10.00	8.00	11	3	8.70	39.00
T200M12	12	1.75	110.0	23	9.00	7.00	10	3	10.40	–

[1] Without neck.

T201

DORMER

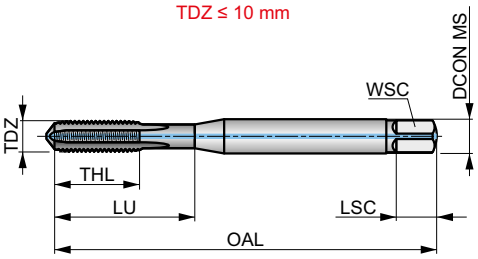


Carbide Straight Flute Machine Tap with Coolant Feed, Metric, DIN Standard

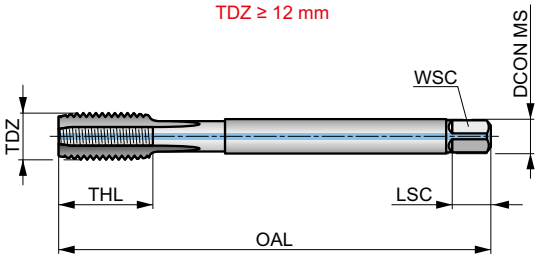
Suitable for machine tapping in abrasive materials, such as cast iron and high silicon aluminium. It has a straight flute design with coolant feed, for efficient threading of blind holes. Super-B coated to improve performance and extend the tool life.

M	DIN 371/376	6HX
	2.5×D	HM
C 2-3		R
Super B		

TDZ ≤ 10 mm



TDZ ≥ 12 mm



Workpiece material group suitability and starting values for cutting speed (m/min).

K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K4.1	K4.2	K4.3	K4.4	K4.5
■ 60	■ 44	■ 33	◪ 47	◪ 38	◪ 30	◪ 41	◪ 32	◪ 26	◪ 38	◪ 29	◪ 21	◪ 18	◪ 15

K5.1	K5.2	K5.3	N2.2	N2.3	N3.2	N4.2	N4.3
◪ 43	◪ 33	◪ 25	◪ 50	■ 40	◪ 10	◪ 25	◪ 15

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
T201M5 [1]	5	0.80	70.0	16	6.00	4.90	8	4	4.30	–
T201M6	6	1.00	80.0	19	6.00	4.90	8	4	5.10	30.00
T201M8	8	1.25	90.0	22	8.00	6.20	9	4	6.90	35.00
T201M10	10	1.50	100.0	24	10.00	8.00	11	4	8.70	39.00
T201M12	12	1.75	110.0	23	9.00	7.00	10	4	10.40	–
T201M16	16	2.00	110.0	25	12.00	9.00	12	4	14.25	–

[1] Without neck.

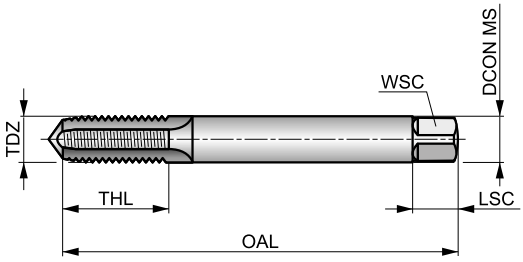
T210

DORMER



Carbide Straight Flute Machine Tap, Metric, DIN Standard

Superior performance and great tool life at high speeds. Suitable for machine tapping of hardened steel. The straight flute design makes the taps ideal for threading both through and blind holes. TiCN coated to improve performance and extend the tool life.



M	DIN 371	6HX
	2×D	HM
C 2-3		R
TiCN		

Workpiece material group suitability and starting values for cutting speed (m/min).

H1.1	H2.1	H2.2	H3.1	H3.2	H4.1	H4.2
◪11	◪7	■5	◪7	◪6	■4	■3

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]
T210M3 [1)]	3	0.50	56.0	8	3.50	2.70	6	4	2.60
T210M4 [1)]	4	0.70	63.0	11	4.50	3.40	6	5	3.40
T210M5 [1)]	5	0.80	70.0	13.5	6.00	4.90	8	5	4.30
T210M6 [1)]	6	1.00	80.0	16.5	6.00	4.90	8	5	5.10
T210M8 [1)]	8	1.25	90.0	21.5	8.00	6.20	9	5	6.90
T210M10 [1)]	10	1.50	100.0	27	10.00	8.00	11	5	8.70
T210M12 [1)]	12	1.75	110.0	32	12.00	9.00	12	6	10.40

[1)] Without neck.

T205

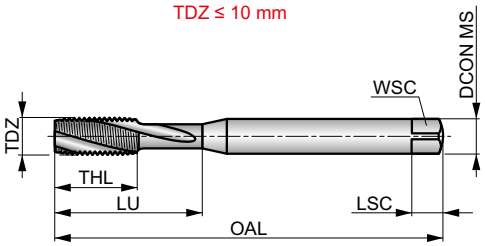


Carbide 15° Spiral Flute Machine Tap, Metric, DIN Standard

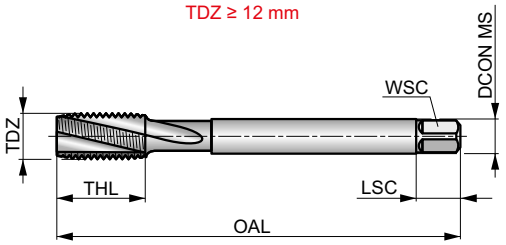
Suitable for machine tapping in abrasive materials, such as cast iron and high silicon aluminium, making them a very versatile choice. The 15° spiral flute makes it great for threading holes which do not go all the way through the workpiece (blind holes). The bright finish ensures a clean and accurate result.

M	DIN 371/376	6H
2×D		HM
C 2-3		λ 15°
R	Bright	

TDZ ≤ 10 mm



TDZ ≥ 12 mm



Workpiece material group suitability and starting values for cutting speed (m/min).

K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K4.1	K4.2	K4.3	K4.4	K4.5
◪ 40	◪ 30	◪ 22	■ 31	■ 25	■ 20	■ 27	■ 21	■ 17	■ 25	■ 19	■ 14	■ 12	■ 10

K5.1	K5.2	K5.3	N2.1	N2.2	N2.3	N4.2	N4.3
■ 29	■ 21	■ 17	■ 54	■ 48	■ 35	◪ 25	◪ 15

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
T205M3 [1]	3	0.50	56.0	10	3.50	2.70	6	3	2.60	–
T205M4 [1]	4	0.70	63.0	13	4.50	3.40	6	3	3.40	–
T205M5 [1]	5	0.80	70.0	16	6.00	4.90	8	3	4.30	–
T205M6	6	1.00	80.0	19	6.00	4.90	8	3	5.10	30.00
T205M8	8	1.25	90.0	22	8.00	6.20	9	3	6.90	35.00
T205M10	10	1.50	100.0	24	10.00	8.00	11	3	8.70	39.00
T205M12	12	1.75	110.0	23	9.00	7.00	10	3	10.40	–

[1] Without neck.

T206

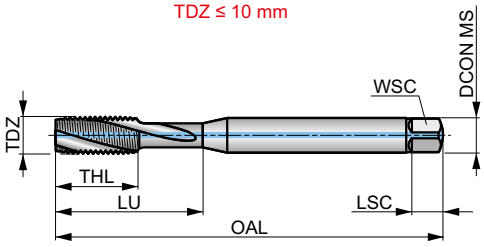


Carbide 15° Spiral Flute Machine Tap, Coolant Feed, Metric, DIN Standard

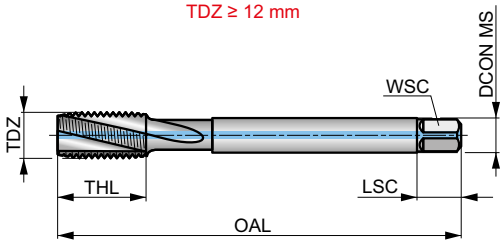
Premium carbide tap which provides superior performance, coupled with longer tool life. It can be used to machine tap in abrasive materials, such as cast iron and high silicon aluminium. The 15° spiral flute, makes it ideal for threading holes which do not go all the way through the workpiece (blind holes). Bright finish.

M	DIN 371/376	6H
	2.5×D	HM
C 2-3		λ 15°
R	Bright	

TDZ ≤ 10 mm



TDZ ≥ 12 mm



Workpiece material group suitability and starting values for cutting speed (m/min).

K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K4.1	K4.2	K4.3	K4.4	K4.5
◪40	◪30	◪22	■31	■25	■20	■27	■21	■17	■25	■19	■14	■12	■10

K5.1	K5.2	K5.3	N2.1	N2.2	N2.3	N4.2	N4.3
■29	■21	■17	■54	■48	■35	◪25	◪15

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
T206M5 [1]	5	0.80	70.0	16	6.00	4.90	8	3	4.30	–
T206M6	6	1.00	80.0	19	6.00	4.90	8	3	5.10	30.00
T206M8	8	1.25	90.0	22	8.00	6.20	9	3	6.90	35.00
T206M10	10	1.50	100.0	24	10.00	8.00	11	3	8.70	39.00
T206M12	12	1.75	110.0	23	9.00	7.00	10	3	10.40	–

[1] Without neck.

T215

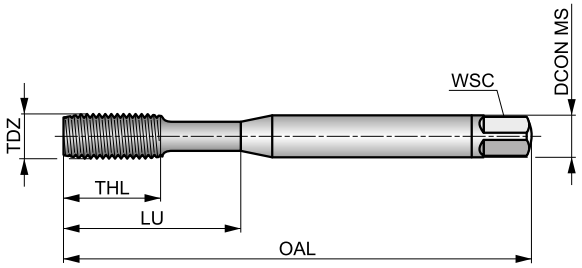
DORMER



Carbide Thread Forming Tap, Metric, DIN Standard

Forming tap for blind and through holes. Provides a strong, clean, chip free and accurate thread with excellent tolerance. The carbide material gives high process security and excellent tool life when forming threads in mild to medium strength steels, medium strength stainless steel and non-ferrous materials. TiCN coated.

M	DIN 2174	6HX
	3×D	HM
C 2-3.5		R
TiCN		



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1
■ 60	■ 68	■ 68	■ 68	■ 60	■ 45	■ 44	■ 36	■ 30	■ 26	■ 22	■ 34	■ 29	■ 31
M2.2	**M2.3**	**M3.1**	**M3.2**	**M3.3**	**M4.1**	**M4.2**	**N1.1**	**N1.2**	**N1.3**	**N2.1**	**N2.2**	**N2.3**	**N3.1**
■ 25	◪ 21	■ 29	■ 25	■ 23	■ 25	◪ 22	■ 70	■ 53	■ 35	■ 98	■ 98	■ 80	■ 50
N3.2	**N3.3**												
◪ 50	■ 38												

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
T215M3 [1]	3	0.50	56.0	10	3.50	2.70	6	4	2.80	–
T215M4 [1]	4	0.70	63.0	13	4.50	3.40	6	5	3.70	–
T215M5 [1]	5	0.80	70.0	16	6.00	4.90	8	5	4.60	–
T215M6	6	1.00	80.0	19	6.00	4.90	8	5	5.50	30.00
T215M8	8	1.25	90.0	22	8.00	6.20	9	5	7.40	35.00
T215M10	10	1.50	100.0	24	10.00	8.00	11	5	9.30	39.00

[1] Without neck.



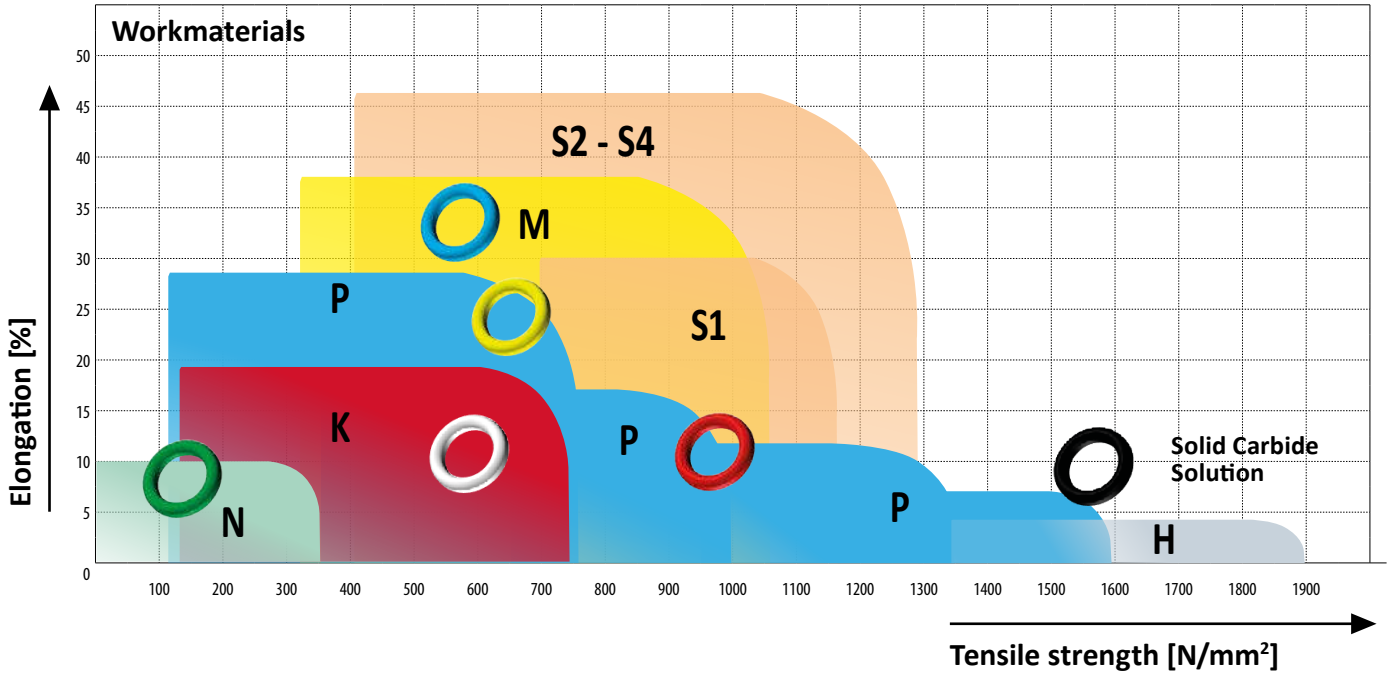
MATERIAL SPECIFIC TAPS

SHARK

MATERIAL SPECIFIC APPLICATION TAPS

Dormer's application-based ranges of DIN taps, branded Shark Line, are renowned for their high performance and are easily recognizable by their colored rings, denoting recommendation for use on specific materials.





FEATURES AND BENEFITS

COLOUR RING CODING

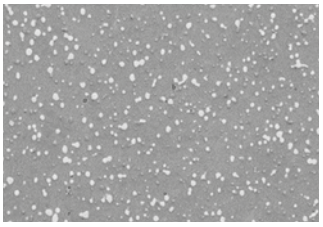
- The colour ring on the tool shank identifies suitability for specific materials and enables **quick and easy tool selection**.

EDGE TREATMENT (Black, Red, Yellow, Blue Shark)

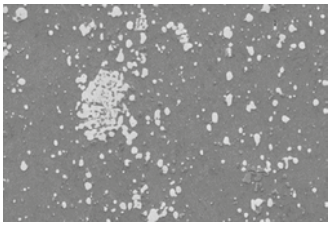
- Spiral flute taps incorporate a special edge treatment to increase strength and reduce the chance of micro-chipping on the cutting edges. This considerably improves **performance and tool life** as well as process security.

MATERIAL

Shark taps are manufactured from a unique powder metallurgy tool steel different from any other HSS-E-PM. This provides an unbeatable combination of toughness and edge strength, allowing the taps to perform at higher cutting temperatures while offering excellent performance and longer tool life.



Unique HSS-E-PM material used for **SHARK TAPS** (note the evenly dispersed grain structure)



Traditional HSS-E (M35) material





STRUCTURAL, PLAIN CARBON & LOW ALLOY STEELS

YELLOW SHARK



- **SURFACE TREATMENT**
  Hard chrome plating (Cr) with an additional edge treatment prevents built up edge when tapping in materials prone to sticking to the cutting edges.
- **FLUTE GEOMETRY**
  Available in spiral point for through holes and spiral flute (40° angle) for blind holes. Special flute geometry on Yellow Shark spiral flute taps prevents nest formation of chips, reducing the risk of re-cutting chips on reversal.
- **THREAD FORMS**
  Metric and Metric Fine
- **PRODUCT CODES**
  E297, E298, E299, E300

YELLOW SHARK 3×D



- **SURFACE TREATMENT**
  TiAlN-Top coating with an additional edge treatment.
- **FLUTE GEOMETRY**
  Spiral flute angle of 48° facilitates smooth and fast chip evacuation, making it suitable for threading deep blind holes (3×D). The increased thread relief also enables higher cutting speeds in high strength steels.
- **CUTTING GEOMETRY**
  The special three radii profile with a constant rake angle along the flute length leads to a better control of cutting properties and prevents nest formation of chips.
- **BACK TAPERED**
  Back taper further facilitates chip evacuation, reducing chipping on the last threads of the taps and also reducing torque when the tap reverses.
- **TAPPING ATTACHMENT (RECOMMENDATION)**
  When using 48° spiral flute Yellow Shark taps, it is recommended to use a tool holder with minimal float or soft start.
- **THREAD FORMS**
  Metric
- **PRODUCT CODE**
  E412



STAINLESS STEELS

BLUE SHARK



- **SURFACE TREATMENT**
  Steam-tempered or Super-B (TiAlN + WC/C) coated with an additional edge treatment.
- **FLUTE GEOMETRY**
  Available in spiral point for through holes and spiral flute (40° angle) for blind holes.
- **BACK TAPERED**
  Back taper on spiral flute taps further facilitates chip evacuation, reducing chipping on the last threads of the taps and also reducing torque when the tap reverses.
- **THREAD FORMS**
  Metric, Metric Fine and G(BSP)
- **PRODUCT CODES**
  E238, E239, E240, E241, E382, E383, E384

BLUE SHARK 3×D



- **SURFACE TREATMENT**
  Super-B (TiAlN + WC/C) coating with an additional edge treatment.
- **FLUTE GEOMETRY**
  Spiral flute angle of 48° facilitates smooth and fast chip evacuation, making it suitable for threading deep blind holes (3×D). The increased thread relief ensures process security when tapping resilient materials such as stainless steel.
- **CUTTING GEOMETRY**
  The special three radii profile with a constant rake angle along the flute length leads to a better control of cutting properties and prevents nest formation of chips.
- **BACK TAPERED**
  Back taper further facilitates chip evacuation, reducing chipping on the last threads of the taps and also reducing torque when the tap reverses.
- **TAPPING ATTACHMENT (RECOMMENDATION)**
  When using 48° spiral flute Blue Shark taps, it is recommended to use a tool holder with minimal float or soft start.
- **THREAD FORMS**
  Metric
- **PRODUCT CODE**
  E414

SHARK

MATERIAL SPECIFIC APPLICATION TAPS



ALLOY STEELS

RED SHARK



- **SURFACE TREATMENT**
  Bright or TiAlN-Top coated with an additional edge treatment.
- **FLUTE GEOMETRY**
  Available in spiral point for through holes and spiral flute (45° angle) for blind holes.
- **BACK TAPERED**
  Back taper on spiral flute taps further facilitates chip evacuation, reducing chipping on the last threads of the taps and also reducing torque when the tap reverses.
- **CUTTING GEOMETRY (SPIRAL FLUTE TAPS)**
  The special three-radii profile with a constant rake angle along the flute length leads to better control of cutting properties and prevents nest formation of chips.
- **TAPPING ATTACHMENT (RECOMMENDATION)**
  When using spiral flute Red Shark taps, it is recommended to use a tool holder with minimal float or soft start.
- **THREAD FORMS**
  Metric
- **PRODUCT CODES**
  E255, E256, E260, E261

HIGH STRENGTH STEELS

BLACK SHARK

NEW



- **SURFACE TREATMENT**
  TiAlN-Top coating with an additional edge treatment.
- **FLUTE GEOMETRY**
  Spiral point or low helix spiral flute geometries with low rake angle for good chip control and edge strength.
- **CUTTING GEOMETRY (SPIRAL FLUTE TAPS)**
  The special three-radii profile with a constant rake angle along the flute length leads to better control of cutting properties and prevents nest formation of chips.
- **TAPPING ATTACHMENT (RECOMMENDATION)**
  When using Black Shark taps, it is recommended to use synchronized (rigid) tapping.
- **THREAD FORMS**
  Metric
- **PRODUCT CODES**
  E334, E335

SHARK

MATERIAL SPECIFIC APPLICATION TAPS



NON-FERROUS MATERIALS

GREEN SHARK



- **SURFACE TREATMENT**
  Bright or Super-B (TiAlN + WC/C) coated.
- **FLUTE GEOMETRY**
  Available in spiral point for through holes and spiral flute (35° angle) for blind holes.
- **CUTTING GEOMETRY (SPIRAL FLUTE TAPS)**
  The special three radii profile with a constant rake angle along the flute length leads to a better control of cutting properties and prevents nest formation of chips.
- **THREAD FORMS**
  Metric
- **PRODUCT CODES**
  E471, E472, E473, E474

CAST IRONS

WHITE SHARK



- **SURFACE TREATMENT**
  Steam-tempered or TiAlN-Top coated.
- **FLUTE GEOMETRY**
  Straight flute design gives excellent performance when threading both through and blind holes in short chipping materials.
- **THREAD FORMS**
  Metric
- **PRODUCT CODES**
  E201, E252, E390

Tool materials

Sintered Cobalt High Speed Steel	HSS-E PM	HSS-E-PM is a Cobalt High Speed Powder Metal substrate which has been produced using powder metal technology. High speed steel produced by this method exhibits superior toughness and grindability due to the uniform and consistent grain structure. High performance taps and end mills have a particular advantage when manufactured from this substrate.

Surface Treatments

Bright (uncoated)		Bright finish (uncoated surface) improves chip flow in soft or non-ferrous materials and maintains sharp cutting edges in abrasive materials.
Steam Tempering		Steam tempering gives a strongly adhering blue oxide surface that acts to retain cutting fluid and prevent chip to tool welding, thereby counteracting the formation of a built-up edge. Steam tempering can be applied to any bright tool but is most effective on drills and taps.

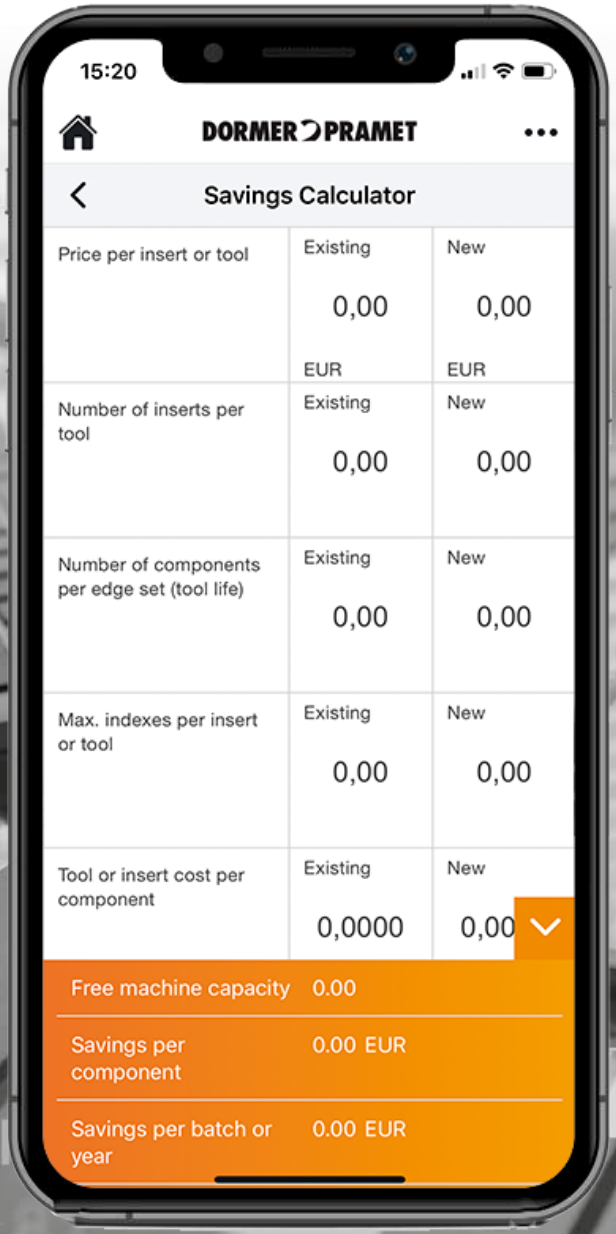
Surface Coatings

Titanium Aluminium Nitride Coatings (TiAlN & TiAlN-Top)	 	Titanium Aluminium Nitride is a multi layer ceramic coating applied by PVD coating technology, which exhibits high toughness and oxidation stability. These properties make it ideal for higher speeds and feeds, while at the same time improving tool life. TiAlN is used in drilling, tapping, and milling applications and can be suitable for use when machining without coolant. TiAlN-Top coating is the same as TiAlN but with a post-coating process designed to smooth out imperfections, enhance chip flow and reduce built up edge.
Super-B Coating (TiAlN/ WC/C)		Super B is a Titanium Aluminium Nitride + Tungsten Carbide + Carbon Coating used for wet and minimal lubrication machining in drilling, milling and tapping applications. Very effective for cast iron, hardened steels and heat resistant super alloys.
Chromium Nitride Coating (CrN)		Hard chromium (Cr) for cutting tool applications provides excellent wear and abrasion resistance due to lowering the coefficient of friction. Only designed for machining soft and gummy materials to promote chip flow and to prevent workpiece materials from sticking to the tool. Hard chromium increases the surface hardness of the tool and is especially effective for tapping soft structural steels, copper and brass materials.

DORMER PRAMET

POCKET SAVER

Our machining calculator allows you to measure the savings based on different products and applications. A useful pocket-sized tool, which will help keep cash in your pockets! **Simply Reliable.**



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Thread form (THFT)		M	M	M	M	M	M	M	M	M	M	M	M	M
Basic standard group (BSG)		DIN 371	DIN 376	DIN 371/376	DIN 371/376	DIN 371/376	DIN 371/376	DIN DORMER	DIN 371/376	DIN 371/376	DIN 371/376	DIN 371/376	DIN 371/376	DIN 371/376
Thread tolerance class (TCTR)		6HX	6HX	6HX	6H	6HX	6HX	6HX	6H	6H	6H	6H	6H	6H
Threading application														
Usable length (ULDR)		2×D	2×D	2×D	2.5×D	2.5×D	2.5×D	2.5×D	2.5×D	2.5×D	2.5×D	2.5×D	2×D	3×D
Material code (BMC)		HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM
Tap chamfer style (TCS)		C 2-3	C 2-3	C 2-3	B 3.5-5	B 3.5-5	B 3.5-5	B 3.5-5	B 3.5-5	B 3.5-5	B 3.5-5	B 3.5-5	C 2-3	C 2-3
Flute Geometry (FDC)														
Flute helix angle (FHA)													λ 40°	λ 48°
Hand (Cutting direction)		R	R	R	R	R	R	R	R	R	R	R	R	R
Coating		ST	ST	TiAlN	Cr	Bright	TiAlN Top	TiAlN Top	ST	Super B	Bright	Super B	Cr	TiAlN Top
		SHARK	SHARK	SHARK	SHARK	SHARK	SHARK	SHARK NEW	SHARK	SHARK	SHARK	SHARK	SHARK	SHARK
Product Family Code		E201	E252	E390	E297	E255	E256	E334	E240	E241	E471	E472	E298	E412
		M3 - M10	M8 - M24	M3 - M20	M3 - M30	M3 - M20	M3 - M20	M3 - M12	M3 - M30	M3 - M20	M3 - M20	M3 - M20	M3 - M30	M3 - M30
		36	37	38	39	40	41	42	43	44	45	46	47	48
P	P1				■						◪	◪	■	■
	P2				■	■	■		◪	◪	◪	◪	■	■
	P3				◪	■	■	◪	◪	◪			◪	■
	P4				◪	■	■	■	◪	◪			◪	■
M	M1								■	■				◪
	M2								■	■				◪
	M3								■	■				◪
	M4								■	◪				◪
K	K1	■	■	■										
	K2	■	■	■										
	K3	■	■	■										
	K4	◪	◪	◪										
	K5	■	■	■										
N	N1										■	◪		◪
	N2										■	■		◪
	N3	◪	◪	◪	■						■	◪	■	◪
	N4	■	■	■							■	◪		
	N5													
S	S1					◪	◪	■						
	S2					◪	◪							
	S3					◪	◪	■						
	S4					◪	◪							
H	H1													
	H2													
	H3							◪						
	H4													

■ Primary use ◪ Possible use

	M	M	M	M	M	M	M	M	MF	MF	MF	MF	G
	DIN 371/376	DIN 371/376	DIN DORMER	DIN 371/376	DIN 371/376	DIN 371/376	DIN 371/376	DIN 371/376	DIN 374	DIN 374	DIN 374	DIN 374	DIN 5156
	6HX	6HX	6HX	6H	6H	6H	6H	6H	6H	6H	6H	6H	Normal
	2.5×D	2.5×D	1.5×D	2.5×D	2.5×D	3×D	2.5×D	2.5×D	2.5×D	2.5×D	2×D	2×D	2×D
	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM
	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3	B 3.5-5	B 3.5-5	C 2-3	C 2-3	C 2-3
	λ 45°	λ 45°	λ 15°	λ 40°	λ 40°	λ 48°	λ 35°	λ 35°			λ 40°	λ 40°	λ 40°
	Bright	TiAlN Top	TiAlN Top	ST	Super B	Super B	Bright	Super B	Cr	ST	Cr	ST	ST
	SHARK	SHARK	SHARK NEW	SHARK	SHARK	SHARK	SHARK	SHARK	SHARK	SHARK	SHARK	SHARK	SHARK
	E260	**E261**	**E335**	**E238**	**E239**	**E414**	**E473**	**E474**	**E299**	**E384**	**E300**	**E383**	**E382**
	M3 - M20	M3 - M20	M3 - M12	M3 - M30	M3 - M20	M3 - M20	M3 - M20	M3 - M20	M4 - M30	M6 - M20	M4 - M30	M6 - M20	1/8 - 1"
	49	50	51	52	53	54	55	56	57	58	59	60	61
P1							◪	◪	■		■		
P2	■	■		◪	◪	◪	◪	◪	■	◪	■	◪	◪
P3	■	■	◪	◪	◪	◪			◪	◪	◪	◪	◪
P4	■	■	■	◪	◪	◪			◪	◪	◪	◪	◪
M1				■	■	■				■		■	■
M2				■	■	■				■		■	■
M3				■	■	■				■		■	■
M4				■	◪					■		■	■
K1													
K2													
K3													
K4													
K5													
N1							■	◪					
N2							■	■					
N3							■	◪	■		■		
N4							■	◪					
N5													
S1	◪	◪	■										
S2	◪	◪											
S3	◪	◪	■										
S4	◪	◪											
H1													
H2													
H3			◪										
H4													

■ Primary use ◪ Possible use

E201

DORMER

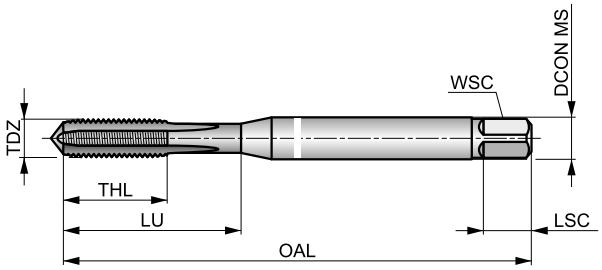


White SHARK Straight Flute Metric Machine Tap, DIN Standard

Straight flute tap with reduced shank for blind and through holes in short chipping cast iron and high strength non-ferrous materials. HSS-E-PM substrate provides superior performance, consistency and extended tool life. Steam tempered surface acts to retain cutting fluid and prevent chip to tool welding.

SHARK

M	DIN 371	6HX
LU	2×D	HSS-E PM
C 2-3		R
ST		



Workpiece material group suitability and starting values for cutting speed (m/min).

K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K4.1	K4.2	K4.3	K4.4	K4.5
■ 15	■ 11	■ 8	■ 18	■ 15	◪ 12	■ 16	■ 12	◪ 10	■ 15	■ 11	◪ 8	◪ 7	◪ 6

K5.1	K5.2	K5.3	N2.3	N3.2	N4.2
■ 17	■ 13	◪ 10	◪ 15	◪ 20	■ 10

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E201M3	3	0.50	56.0	9	3.50	2.70	6	3	2.50	18.00
E201M4	4	0.70	63.0	12	4.50	3.40	6	4	3.30	21.00
E201M5	5	0.80	70.0	13	6.00	4.90	8	4	4.20	25.00
E201M6	6	1.00	80.0	15	6.00	4.90	8	4	5.00	30.00
E201M8	8	1.25	90.0	18	8.00	6.20	9	4	6.80	35.00
E201M10	10	1.50	100.0	20	10.00	8.00	11	4	8.50	39.00

E252

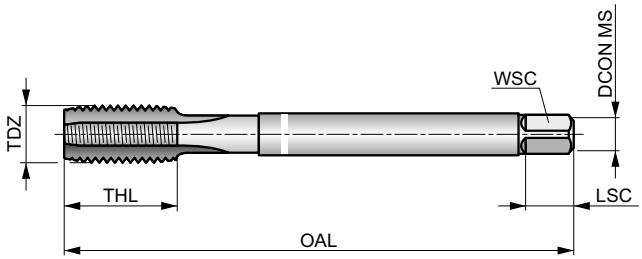


White SHARK Straight Flute Metric Machine Tap, DIN Standard

Straight flute tap with reinforced shank for blind and through holes in short chipping cast iron and high strength non-ferrous materials. HSS-E-PM substrate provides superior performance, consistency and extended tool life. Steam tempered surface acts to retain cutting fluid and prevent chip to tool welding.

SHARK

M	DIN 376	6HX
	2×D	HSS-E PM
C 2-3		R
ST		



Workpiece material group suitability and starting values for cutting speed (m/min).

K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K4.1	K4.2	K4.3	K4.4	K4.5
■ 15	■ 11	■ 8	■ 18	■ 15	◪ 12	■ 16	■ 12	◪ 10	■ 15	■ 11	◪ 8	◪ 7	◪ 6

K5.1	K5.2	K5.3	N2.3	N3.2	N4.2
■ 17	■ 13	◪ 10	◪ 15	◪ 20	■ 10

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]
E252M8	8	1.25	90.0	18	6.00	4.90	8	4	6.80
E252M10	10	1.50	100.0	20	7.00	5.50	8	4	8.50
E252M12	12	1.75	110.0	23	9.00	7.00	10	4	10.30
E252M14	14	2.00	110.0	25	11.00	9.00	12	4	12.00
E252M16	16	2.00	110.0	25	12.00	9.00	12	4	14.00
E252M18	18	2.50	125.0	30	14.00	11.00	14	4	15.50
E252M20	20	2.50	140.0	30	16.00	12.00	15	4	17.50
E252M22	22	2.50	140.0	34	18.00	14.50	17	4	19.50
E252M24	24	3.00	160.0	38	18.00	14.50	17	4	21.00

E390

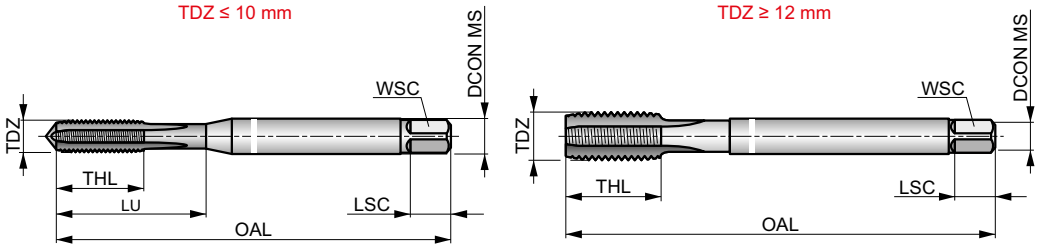


White SHARK Straight Flute Metric Machine Tap, DIN Standard

High performance TiAlN coated tap for blind and through holes in short chipping materials, such as cast iron and non-ferrous metals. Premium HSS-E-PM substrate provides superior performance, consistency and extended tool life. Up to M10 with reinforced and from M12 with reduced shank.

SHARK

M	DIN 371/376	6HX
LU	2×D	HSS-E PM
C 2-3		R
TiAlN		



Workpiece material group suitability and starting values for cutting speed (m/min).

K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K4.1	K4.2	K4.3	K4.4	K4.5
■ 30	■ 22	■ 17	■ 43	■ 35	◪ 28	■ 38	■ 29	◪ 24	■ 35	■ 27	◪ 20	◪ 17	◪ 14

K5.1	K5.2	K5.3	N2.3	N3.2	N4.2
■ 40	■ 30	◪ 23	◪ 20	◪ 30	■ 15

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E390M3	3	0.50	56.0	9	3.50	2.70	6	3	2.50	18.00
E390M4	4	0.70	63.0	12	4.50	3.40	6	4	3.30	21.00
E390M5	5	0.80	70.0	13	6.00	4.90	8	4	4.20	25.00
E390M6	6	1.00	80.0	15	6.00	4.90	8	4	5.00	30.00
E390M8	8	1.25	90.0	18	8.00	6.20	9	4	6.80	35.00
E390M10	10	1.50	100.0	20	10.00	8.00	11	4	8.50	39.00
E390M12	12	1.75	110.0	23	9.00	7.00	10	4	10.30	–
E390M16	16	2.00	110.0	25	12.00	9.00	12	4	14.00	–
E390M20	20	2.50	140.0	30	16.00	12.00	15	4	17.50	–

E297

DORMER

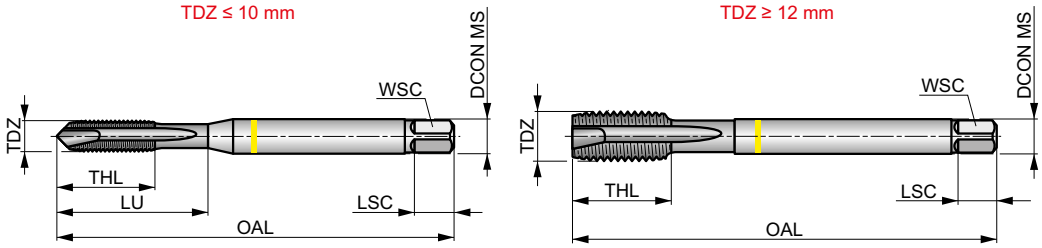


Yellow SHARK Spiral Point Metric Machine Tap, DIN Standard

High performance through hole tap for low carbon and alloyed steel and non-ferrous materials. Unique HSS-E-PM substrate with additional edge treatment provides consistency and process security. Hard chrome coated to increase the surface hardness and reduce built-up edge for increased performance and tool life.

SHARK

M	DIN 371/376	6H
	2.5×D	HSS-E PM
B 3.5-5		R
Cr		



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	N3.1	N3.2	N3.3
■ 24	■ 27	■ 28	■ 20	■ 18	◪ 16	■ 15	◪ 12	◪ 9	■ 51	■ 30	◪ 15

Products from this series are also available in set with drills. Please see L114.

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E297M3	3	0.50	56.0	9	3.50	2.70	6	3	2.50	18.00
E297M4	4	0.70	63.0	12	4.50	3.40	6	3	3.30	21.00
E297M5	5	0.80	70.0	13	6.00	4.90	8	3	4.20	25.00
E297M6	6	1.00	80.0	15	6.00	4.90	8	3	5.00	30.00
E297M8	8	1.25	90.0	18	8.00	6.20	9	3	6.80	35.00
E297M10	10	1.50	100.0	20	10.00	8.00	11	3	8.50	39.00
E297M12	12	1.75	110.0	23	9.00	7.00	10	3	10.30	–
E297M14	14	2.00	110.0	25	11.00	9.00	12	3	12.00	–
E297M16	16	2.00	110.0	25	12.00	9.00	12	3	14.00	–
E297M18	18	2.50	125.0	30	14.00	11.00	14	3	15.50	–
E297M20	20	2.50	140.0	30	16.00	12.00	15	3	17.50	–
E297M22	22	2.50	140.0	34	18.00	14.50	17	4	19.50	–
E297M24	24	3.00	160.0	38	18.00	14.50	17	4	21.00	–
E297M27	27	3.00	160.0	38	20.00	16.00	19	4	24.00	–
E297M30	30	3.50	180.0	45	22.00	18.00	21	4	26.50	–

E255

DORMER

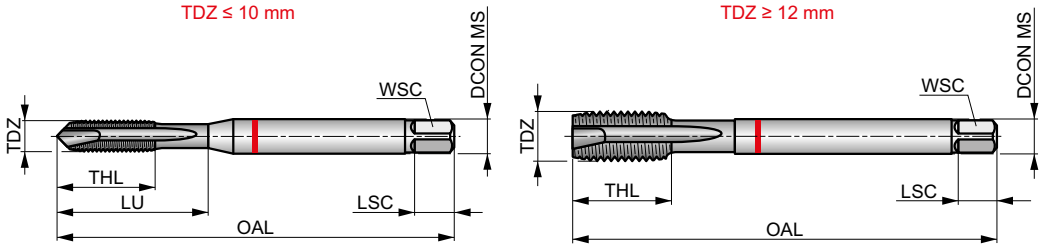


Red SHARK, Spiral Point Metric Machine Tap, DIN Standard

Through hole tap with reinforced or reduced shank for medium to high strength steels. Unique HSS-E-PM steel with bright surface finish provide consistency and process security.

SHARK

M	DIN 371/376	6HX
2.5×D		HSS-E PM
B 3.5-5		R
Bright		



Workpiece material group suitability and starting values for cutting speed (m/min).

P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	S1.2	S2.1	S3.1	S4.1
■11	■10	■8	■7	■6	■5	◪2	◪3	◪2	◪2

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E255M3	3	0.50	56.0	9	3.50	2.70	6	3	2.50	18.00
E255M4	4	0.70	63.0	12	4.50	3.40	6	3	3.30	21.00
E255M5	5	0.80	70.0	13	6.00	4.90	8	3	4.20	25.00
E255M6	6	1.00	80.0	15	6.00	4.90	8	3	5.00	30.00
E255M8	8	1.25	90.0	18	8.00	6.20	9	3	6.80	35.00
E255M10	10	1.50	100.0	20	10.00	8.00	11	3	8.50	39.00
E255M12	12	1.75	110.0	23	9.00	7.00	10	3	10.30	–
E255M14	14	2.00	110.0	25	11.00	9.00	12	3	12.00	–
E255M16	16	2.00	110.0	25	12.00	9.00	12	3	14.00	–
E255M20	20	2.50	140.0	30	16.00	12.00	15	4	17.50	–

E256

DORMER

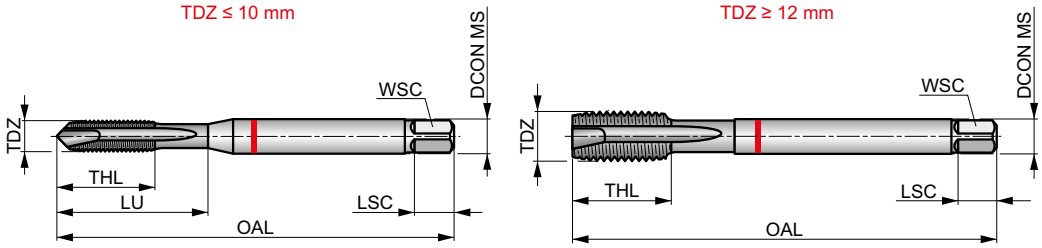


Red SHARK Spiral Point Metric Machine Tap, DIN Standard

High performance through hole tap with reinforced or reduced shank for medium to high strength steel. Unique HSS-E-PM substrate along with TiAlN-Top coating and edge treatment provide superior performance, consistency, extended tool life and higher process security.

SHARK

M	DIN 371/376	6HX
	2.5×D	HSS-E PM
B 3.5-5		R
TiAlN Top		



Workpiece material group suitability and starting values for cutting speed (m/min).

P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	S1.2	S2.1	S3.1	S4.1
■ 27	■ 25	■ 20	■ 17	■ 15	■ 13	◪ 10	◪ 3	◪ 4	◪ 3	◪ 3

Product	TDZ	TP [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	LSC [mm]	NOF	PHD [mm]	LU [mm]
E256M3	3	0.50	56.0	9	3.50	2.70	6	3	2.50	18.00
E256M4	4	0.70	63.0	12	4.50	3.40	6	3	3.30	21.00
E256M5	5	0.80	70.0	13	6.00	4.90	8	3	4.20	25.00
E256M6	6	1.00	80.0	15	6.00	4.90	8	3	5.00	30.00
E256M8	8	1.25	90.0	18	8.00	6.20	9	3	6.80	35.00
E256M10	10	1.50	100.0	20	10.00	8.00	11	3	8.50	39.00
E256M12	12	1.75	110.0	23	9.00	7.00	10	3	10.30	–
E256M16	16	2.00	110.0	25	12.00	9.00	12	3	14.00	–
E256M20	20	2.50	140.0	30	16.00	12.00	15	4	17.50	–

E334

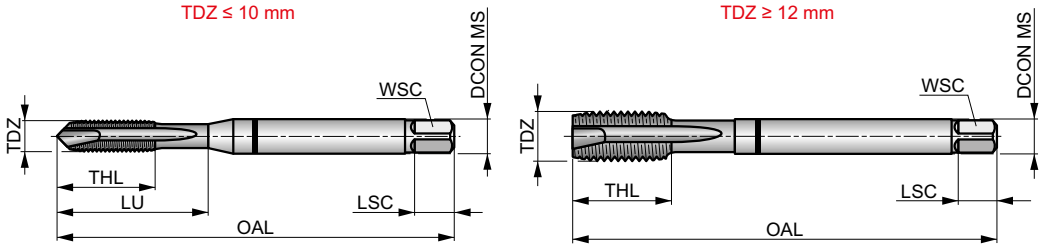


Red SHARK 45° Spiral Flute Metric Machine Tap, DIN Standard

Blind hole tap with reinforced or reduced shank for medium to high strength steels. Unique HSS-E-PM substrate with bright surface finish. Extra back taper to further facilitate chip evacuation, preventing chipping on the last threads of the tap and also reduces torque when the tap reverses.

SHARK

M	DIN DORMER	6HX
	2.5×D	HSS-E PM
B 3.5-5		R
TiAlN Top		



Workpiece material group suitability and starting values for cutting speed (m/min).

P3.3	P4.2	P4.3	S1.2	S1.3	S3.1	S3.2	H3.1
■17	■13	■10	■13	■8	■5	■3	◪7

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E334M3	3	0.50	63.0	12	4.50	3.40	6	3	2.50	12.00
E334M4	4	0.70	70.0	17	6.00	4.90	8	3	3.30	17.00
E334M5	5	0.80	80.0	20	6.00	4.90	8	3	4.20	20.00
E334M6	6	1.00	90.0	24	8.00	6.20	9	3	5.00	24.00
E334M8	8	1.25	100.0	32	10.00	8.00	11	3	6.80	32.00
E334M10	10	1.50	100.0	20	10.00	8.00	11	3	8.50	39.00
E334M12	12	1.75	110.0	23	9.00	7.00	10	4	10.30	–

E240

DORMER

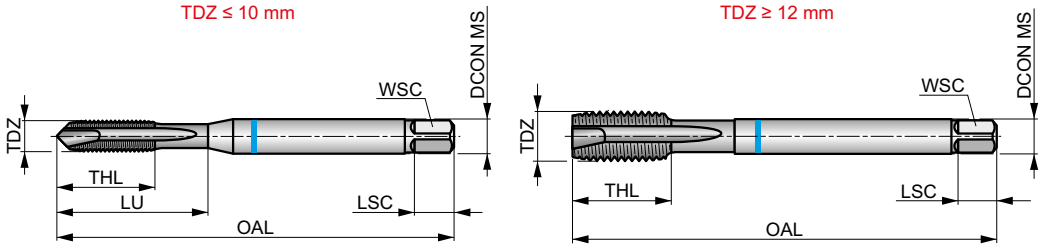


Blue SHARK Spiral Point Metric Machine Tap, DIN Standard

Through hole tap with reinforced or reduced shank for medium strength stainless steel. Unique HSS-E-PM substrate along with additional edge treatment provide consistency and process security. Steam tempered surface acts to retain cutting fluid and prevent chip to tool welding.

SHARK

M	DIN 371/376	6H
	2.5×D	HSS-E PM
B 3.5-5		R
ST		



Workpiece material group suitability and starting values for cutting speed (m/min).

P2.3	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1	M2.2	M3.1	M3.2	M3.3	M4.1
◪8	◪10	◪9	◪7	■11	■9	■10	■8	■8	■7	■6	■5

Products from this series are also available in set with drills. Please see L114.

Product	TDZ	TP [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	LSC [mm]	NOF	PHD [mm]	LU [mm]
E240M3	3	0.50	56.0	9	3.50	2.70	6	3	2.50	18.00
E240M4	4	0.70	63.0	12	4.50	3.40	6	3	3.30	21.00
E240M5	5	0.80	70.0	13	6.00	4.90	8	3	4.20	25.00
E240M6	6	1.00	80.0	15	6.00	4.90	8	3	5.00	30.00
E240M8	8	1.25	90.0	18	8.00	6.20	9	3	6.80	35.00
E240M10	10	1.50	100.0	20	10.00	8.00	11	3	8.50	39.00
E240M12	12	1.75	110.0	23	9.00	7.00	10	4	10.30	–
E240M14	14	2.00	110.0	25	11.00	9.00	12	4	12.00	–
E240M16	16	2.00	110.0	25	12.00	9.00	12	4	14.00	–
E240M18	18	2.50	125.0	30	14.00	11.00	14	4	15.50	–
E240M20	20	2.50	140.0	30	16.00	12.00	15	4	17.50	–
E240M22	22	2.50	140.0	34	18.00	14.50	17	4	19.50	–
E240M24	24	3.00	160.0	38	18.00	14.50	17	4	21.00	–
E240M27	27	3.00	160.0	38	20.00	16.00	19	4	24.00	–
E240M30	30	3.50	180.0	45	22.00	18.00	21	4	26.50	–

E241

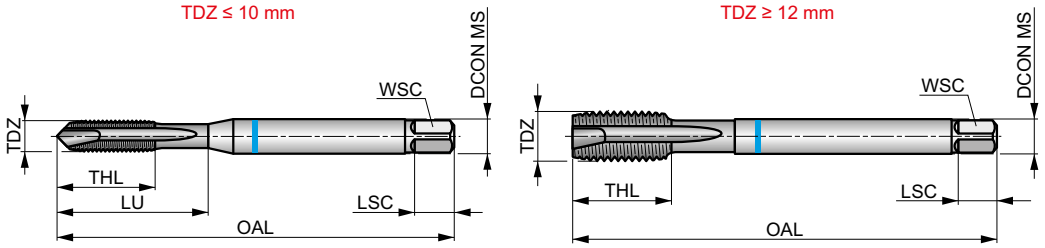


Blue SHARK Spiral Point Metric Machine Tap, DIN Standard

High performance through hole tap with reinforced or reduced shank for medium strength stainless steel. Unique HSS-E-PM substrate with Super-B coating and additional edge treatment providing superior performance, consistency and extended tool life.

SHARK

M	DIN 371/376	6H
2.5×D		HSS-E PM
B 3.5-5		R
Super B		



Workpiece material group suitability and starting values for cutting speed (m/min).

P2.3	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1	M2.2	M2.3	M3.1	M3.2	M3.3	M4.1	M4.2
◪16	◪14	◪11	◪9	■19	■16	■17	■14	◪12	■12	■10	■9	■6	◪5

Product	TDZ	TP [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	LSC [mm]	NOF	PHD [mm]	LU [mm]
E241M3	3	0.50	56.0	9	3.50	2.70	6	3	2.50	18.00
E241M4	4	0.70	63.0	12	4.50	3.40	6	3	3.30	21.00
E241M5	5	0.80	70.0	13	6.00	4.90	8	3	4.20	25.00
E241M6	6	1.00	80.0	15	6.00	4.90	8	3	5.00	30.00
E241M8	8	1.25	90.0	18	8.00	6.20	9	3	6.80	35.00
E241M10	10	1.50	100.0	20	10.00	8.00	11	3	8.50	39.00
E241M12	12	1.75	110.0	23	9.00	7.00	10	4	10.30	–
E241M14	14	2.00	110.0	25	11.00	9.00	12	4	12.00	–
E241M16	16	2.00	110.0	25	12.00	9.00	12	4	14.00	–
E241M18	18	2.50	125.0	30	14.00	11.00	14	4	15.50	–
E241M20	20	2.50	140.0	30	16.00	12.00	15	4	17.50	–

E471

DORMER

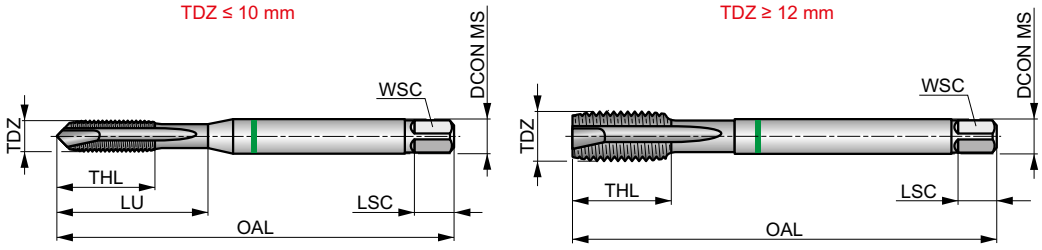


Green SHARK Spiral Point Metric Machine Tap, DIN Standard

Through hole tap with reinforced or reduced shank for non-ferrous materials. Unique HSS-E-PM substrate with polished flutes to avoid chip sticking, provide consistency and process security.

SHARK

M	DIN 371/376	6H
	2.5×D	HSS-E PM
B 3.5-5		R
Bright		



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.2	P1.3	P2.1	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	N4.1
◪23	◪24	◪16	■16	■12	■8	■31	■28	■20	■51	■30	◪15	■25

Product	TDZ	TP [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	LSC [mm]	NOF	PHD [mm]	LU [mm]
E471M3	3	0.50	56.0	9	3.50	2.70	6	2	2.50	18.00
E471M4	4	0.70	63.0	12	4.50	3.40	6	2	3.30	21.00
E471M5	5	0.80	70.0	13	6.00	4.90	8	2	4.20	25.00
E471M6	6	1.00	80.0	15	6.00	4.90	8	3	5.00	30.00
E471M8	8	1.25	90.0	18	8.00	6.20	9	3	6.80	35.00
E471M10	10	1.50	100.0	20	10.00	8.00	11	3	8.50	39.00
E471M12	12	1.75	110.0	23	9.00	7.00	10	3	10.30	–
E471M16	16	2.00	110.0	25	12.00	9.00	12	4	14.00	–
E471M20	20	2.50	140.0	30	16.00	12.00	15	4	17.50	–

E472

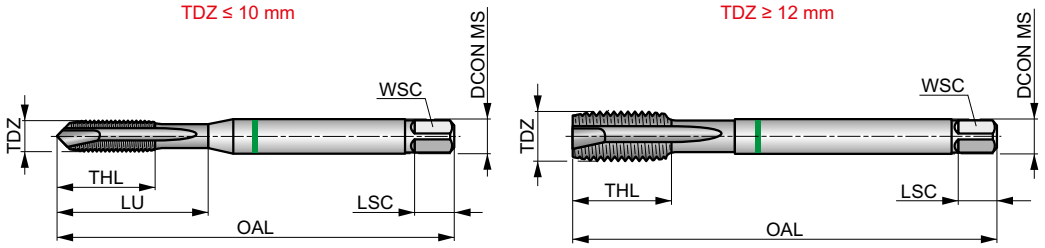


Green SHARK Spiral Point Metric Machine Tap, DIN Standard

High performance through hole tap with reinforced or reduced shank for non-ferrous materials. Unique HSS-E-PM substrate with Super-B coating to avoid chip sticking, providing superior performance, consistency and extended tool life.

SHARK

M	DIN 371/376	6H
2.5×D		HSS-E PM
B 3.5-5		R
Super B		



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N4.1
◪34	◪38	◪40	◪29	◪24	◪35	◪26	■18	■46	■42	■30	◪76	■45	◪30

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E472M3	3	0.50	56.0	9	3.50	2.70	6	2	2.50	18.00
E472M4	4	0.70	63.0	12	4.50	3.40	6	2	3.30	21.00
E472M5	5	0.80	70.0	13	6.00	4.90	8	2	4.20	25.00
E472M6	6	1.00	80.0	15	6.00	4.90	8	3	5.00	30.00
E472M8	8	1.25	90.0	18	8.00	6.20	9	3	6.80	35.00
E472M10	10	1.50	100.0	20	10.00	8.00	11	3	8.50	39.00
E472M12	12	1.75	110.0	23	9.00	7.00	10	3	10.30	–
E472M16	16	2.00	110.0	25	12.00	9.00	12	4	14.00	–
E472M20	20	2.50	140.0	30	16.00	12.00	15	4	17.50	–

E298

DORMER

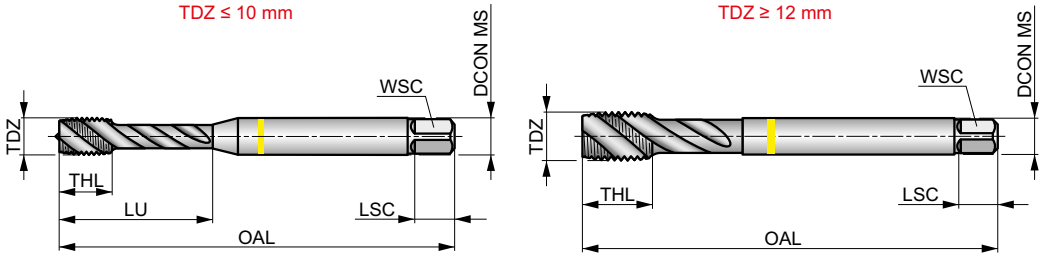


Yellow SHARK 40° Spiral Flute Metric Machine Tap, DIN Standard

High performance blind hole tap for low carbon and alloyed steel and non-ferrous materials. Unique HSS-E-PM substrate with additional edge treatment to provide consistency and process security. Hard chrome coated to increase the surface hardness, reducing built-up edge and extend tool life.

SHARK

M	DIN 371/376	6H
	2×D	HSS-E PM
C 2-3		λ 40°
R	Cr	



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	N3.1	N3.2	N3.3
■ 23	■ 25	■ 26	■ 19	■ 17	◪ 15	■ 14	◪ 11	◪ 8	■ 48	■ 28	◪ 14

Products from this series are also available in set with drills. Please see L114.

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E298M3	3	0.50	56.0	6	3.50	2.70	6	3	2.50	18.00
E298M4	4	0.70	63.0	7	4.50	3.40	6	3	3.30	21.00
E298M5	5	0.80	70.0	8	6.00	4.90	8	3	4.20	25.00
E298M6	6	1.00	80.0	10	6.00	4.90	8	3	5.00	30.00
E298M8	8	1.25	90.0	12	8.00	6.20	9	3	6.80	35.00
E298M10	10	1.50	100.0	15	10.00	8.00	11	3	8.50	39.00
E298M12	12	1.75	110.0	16	9.00	7.00	10	3	10.30	–
E298M14	14	2.00	110.0	20	11.00	9.00	12	3	12.00	–
E298M16	16	2.00	110.0	20	12.00	9.00	12	4	14.00	–
E298M18	18	2.50	125.0	25	14.00	11.00	14	4	15.50	–
E298M20	20	2.50	140.0	25	16.00	12.00	15	4	17.50	–
E298M22	22	2.50	140.0	25	18.00	14.50	17	4	19.50	–
E298M24	24	3.00	160.0	30	18.00	14.50	17	4	21.00	–
E298M27	27	3.00	160.0	30	20.00	16.00	19	4	24.00	–
E298M30	30	3.50	160.0	36	22.00	18.00	21	4	26.50	–

E412



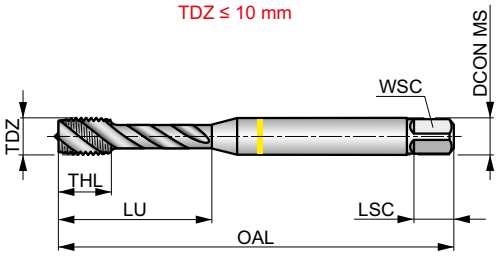
Yellow SHARK 48° Spiral Flute Metric Machine Tap, DIN Standard

High performance quick spiral tap for deep blind holes in medium strength steels. Unique HSS-E-PM substrate with TiAlN-Top coating and additional edge treatment provide superior performance. Extra back taper facilitates chip evacuation and reduces torque on reversal. Recommended for synchronous feed tap holders.

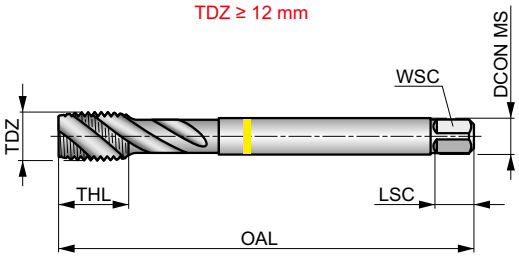
SHARK

M	DIN 371/376	6H
	3×D	HSS-E PM
C 2-3		λ 48°
R	TiAlN Top	

TDZ ≤ 10 mm



TDZ ≥ 12 mm



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1
■46	■52	■54	■40	■35	■31	■24	■19	■16	■14	■12	◪19	◪16	◪17

M2.2	M3.1	M3.2	M3.3	M4.1	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1
◪14	◪12	◪10	◪9	◪6	◪16	◪12	◪8	◪54	◪48	◪35	◪60

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E412M3	3	0.50	56.0	6	3.50	2.70	6	3	2.50	18.00
E412M4	4	0.70	63.0	7	4.50	3.40	6	3	3.30	21.00
E412M5	5	0.80	70.0	8	6.00	4.90	8	3	4.20	25.00
E412M6	6	1.00	80.0	10	6.00	4.90	8	3	5.00	30.00
E412M8	8	1.25	90.0	13	8.00	6.20	9	3	6.80	35.00
E412M10	10	1.50	100.0	15	10.00	8.00	11	3	8.50	39.00
E412M12	12	1.75	110.0	18	9.00	7.00	10	3	10.30	–
E412M14	14	2.00	110.0	20	11.00	9.00	12	3	12.00	–
E412M16	16	2.00	110.0	20	12.00	9.00	12	4	14.00	–
E412M20	20	2.50	140.0	25	16.00	12.00	15	4	17.50	–
E412M22	22	2.50	140.0	25	18.00	14.50	17	4	19.50	–
E412M24	24	3.00	160.0	30	18.00	14.50	17	4	21.00	–
E412M27	27	3.00	160.0	30	20.00	16.00	19	4	24.00	–
E412M30	30	3.50	180.0	36	22.00	18.00	21	4	26.50	–

E260

DORMER

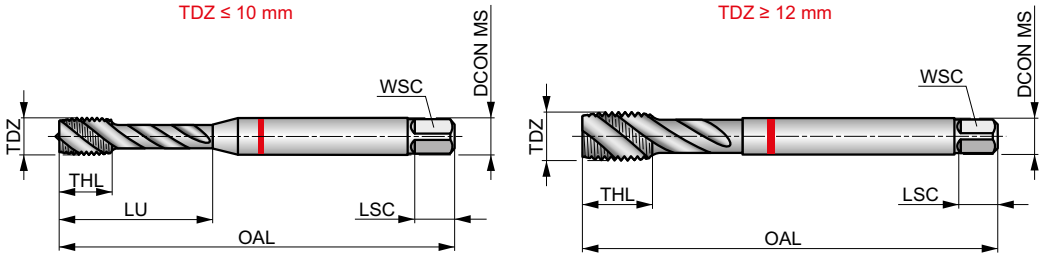


Red SHARK 45° Spiral Flute Metric Machine Tap, DIN Standard

Through hole tap with reinforced or reduced shank for medium to high strength steels. Unique HSS-E-PM substrate with bright surface finish. Extra back taper to further facilitate chip evacuation, preventing chipping on the last threads of the tap and also reduces torque when the tap reverses.

SHARK

M	DIN 371/376	6HX
2.5×D		HSS-E PM
C 2-3		λ 45°
R	Bright	



Workpiece material group suitability and starting values for cutting speed (m/min).

P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	S1.2	S2.1	S3.1	S4.1
■10	■9	■7	■6	■5	■4	◪2	◪3	◪2	◪2

Product	TDZ	TP [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	LSC [mm]	NOF	PHD [mm]	LU [mm]
E260M3	3	0.50	56.0	6	3.50	2.70	6	3	2.50	18.00
E260M4	4	0.70	63.0	7	4.50	3.40	6	3	3.30	21.00
E260M5	5	0.80	70.0	8	6.00	4.90	8	3	4.20	25.00
E260M6	6	1.00	80.0	10	6.00	4.90	8	3	5.00	30.00
E260M8	8	1.25	90.0	12	8.00	6.20	9	3	6.80	35.00
E260M10	10	1.50	100.0	15	10.00	8.00	11	3	8.50	39.00
E260M12	12	1.75	110.0	16	9.00	7.00	10	3	10.30	–
E260M14	14	2.00	110.0	20	11.00	9.00	12	3	12.00	–
E260M16	16	2.00	110.0	20	12.00	9.00	12	4	14.00	–
E260M20	20	2.50	140.0	25	16.00	12.00	15	4	17.50	–

E261

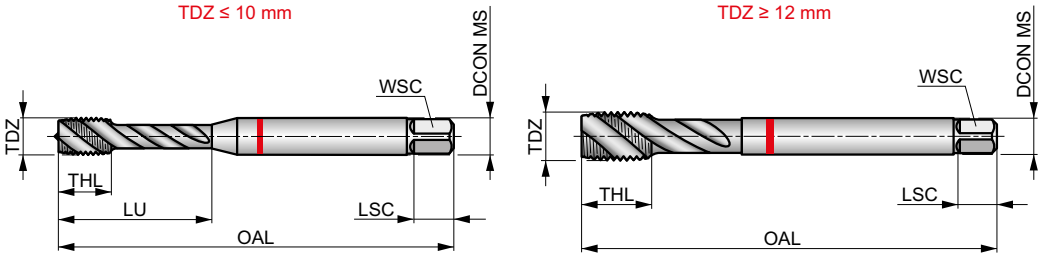


Red SHARK 45° Spiral Flute Metric Machine Tap, DIN Standard

High performance blind hole tap for medium to high strength steels. Unique HSS-E-PM substrate with TiAlN-Top coating and additional edge treatment provide superior performance, consistency and extended tool life. Extra back taper further facilitates chip evacuation and reduces torque on tap reversal.

SHARK

M	DIN 371/376	6HX
2.5×D		HSS-E PM
C 2-3		λ 45°
R	TiAlN Top	



Workpiece material group suitability and starting values for cutting speed (m/min).

P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	S1.2	S2.1	S3.1	S4.1
■26	■24	■19	■16	■14	■12	◪9	◪2	◪3	◪2	◪2

Product	TDZ	TP [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	LSC [mm]	NOF	PHD [mm]	LU [mm]
E261M3	3	0.50	56.0	6	3.50	2.70	6	3	2.50	18.00
E261M4	4	0.70	63.0	7	4.50	3.40	6	3	3.30	21.00
E261M5	5	0.80	70.0	8	6.00	4.90	8	3	4.20	25.00
E261M6	6	1.00	80.0	10	6.00	4.90	8	3	5.00	30.00
E261M8	8	1.25	90.0	12	8.00	6.20	9	3	6.80	35.00
E261M10	10	1.50	100.0	15	10.00	8.00	11	3	8.50	39.00
E261M12	12	1.75	110.0	16	9.00	7.00	10	3	10.30	–
E261M16	16	2.00	110.0	20	12.00	9.00	12	4	14.00	–
E261M20	20	2.50	140.0	25	16.00	12.00	15	4	17.50	–

E335

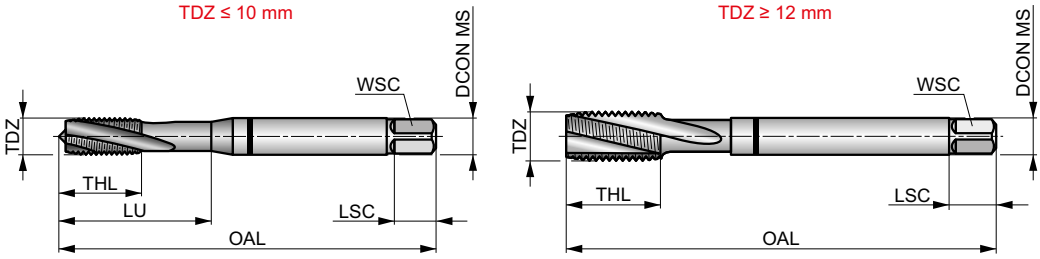


Black SHARK 15° Spiral Flute Metric Machine Tap, DIN Standard

High performance blind hole tap for efficient tapping in high strength steels and titanium alloys. A 15° slow spiral allows the chips to be pulled slightly upwards, yet without weakening the cutting edge, as higher spiral taps would. Unique HSS-E-PM substrate along with TiAlN-Top coating for superior performance.

SHARK

M	DIN DORMER	6HX
	1.5×D	HSS-E PM
C 2-3		λ 15°
R	TiAlN Top	



Workpiece material group suitability and starting values for cutting speed (m/min).

P3.3	P4.2	P4.3	S1.2	S1.3	S3.1	S3.2	H3.1
■16	■12	■9	■12	■7	■4	■2	◪6

Product	TDZ	TP [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	LSC [mm]	NOF	PHD [mm]	LU [mm]
E335M3	3	0.50	63.0	12	4.50	3.40	6	3	2.50	12.00
E335M4	4	0.70	70.0	13	6.00	4.90	8	3	3.30	13.00
E335M5	5	0.80	80.0	15	6.00	4.90	8	3	4.20	15.00
E335M6	6	1.00	90.0	18	8.00	6.20	9	3	5.00	18.00
E335M8	8	1.25	100.0	20	10.00	8.00	11	3	6.80	20.00
E335M10	10	1.50	100.0	20	10.00	8.00	11	3	8.50	39.00
E335M12	12	1.75	110.0	23	9.00	7.00	10	4	10.30	–

E238

DORMER

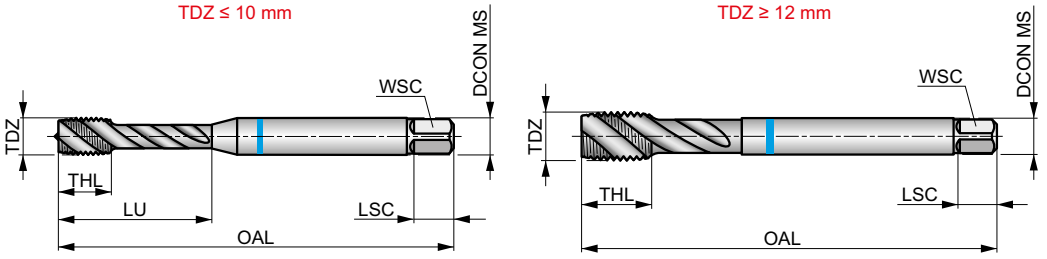


Blue SHARK 40° Spiral Flute Metric Machine Tap, DIN Standard

Blind hole tap with reinforced or reduced shank for medium strength stainless steel. Unique HSS-E-PM substrate, along with additional edge treatment, provide consistency and process security. Steam tempered surface acts to retain cutting fluid and prevent chip to tool welding.

SHARK

M	DIN 371/376	6H
	2.5×D	HSS-E PM
C 2-3		λ 40°
R	ST	



Workpiece material group suitability and starting values for cutting speed (m/min).

P2.3	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1	M2.2	M3.1	M3.2	M3.3	M4.1
◪7	◪9	◪8	◪7	■10	■8	■9	■7	■7	■6	■5	■4

Products from this series are also available in set with drills. Please see L114.

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E238M3	3	0.50	56.0	6	3.50	2.70	6	3	2.50	18.00
E238M4	4	0.70	63.0	7	4.50	3.40	6	3	3.30	21.00
E238M5	5	0.80	70.0	8	6.00	4.90	8	3	4.20	25.00
E238M6	6	1.00	80.0	10	6.00	4.90	8	3	5.00	30.00
E238M8	8	1.25	90.0	12	8.00	6.20	9	3	6.80	33.00
E238M10	10	1.50	100.0	15	10.00	8.00	11	3	8.50	39.00
E238M12	12	1.75	110.0	16	9.00	7.00	10	4	10.30	–
E238M14	14	2.00	110.0	20	11.00	9.00	12	4	12.00	–
E238M16	16	2.00	110.0	20	12.00	9.00	12	4	14.00	–
E238M18	18	2.50	125.0	25	14.00	11.00	14	4	15.50	–
E238M20	20	2.50	140.0	25	16.00	12.00	15	4	17.50	–
E238M22	22	2.50	140.0	25	18.00	14.50	17	4	19.80	–
E238M24	24	3.00	160.0	30	18.00	14.50	17	4	21.00	–
E238M27	27	3.00	160.0	30	20.00	16.00	19	4	24.00	–
E238M30	30	3.50	180.0	36	22.00	18.00	21	4	26.50	–

E239

DORMER

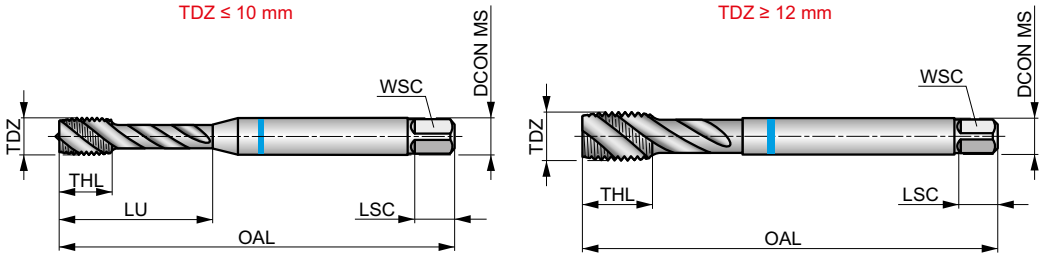


Blue SHARK 40° Spiral Flute Metric Machine Tap, DIN Standard

High performance blind hole tap for medium strength stainless steel. Unique HSS-E-PM substrate with Super-B coating and additional edge treatment providing superior performance, consistency and extended tool life. Back taper on spiral flute taps facilitates chip evacuation and reduces torque when the tap reverses.

SHARK

M	DIN 371/376	6H
2.5×D		HSS-E PM
C 2-3		λ 40°
R	Super B	



Workpiece material group suitability and starting values for cutting speed (m/min).

P2.3	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1	M2.2	M2.3	M3.1	M3.2	M3.3	M4.1	M4.2
◪15	◪13	◪10	◪8	■18	■15	■16	■13	◪11	■11	■9	■8	■5	◪4

Product	TDZ	TP [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	LSC [mm]	NOF	PHD [mm]	LU [mm]
E239M3	3	0.50	56.0	6	3.50	2.70	6	3	2.50	18.00
E239M4	4	0.70	63.0	7	4.50	3.40	6	3	3.30	21.00
E239M5	5	0.80	70.0	8	6.00	4.90	8	3	4.20	25.00
E239M6	6	1.00	80.0	10	6.00	4.90	8	3	5.00	30.00
E239M8	8	1.25	90.0	12	8.00	6.20	9	3	6.80	33.00
E239M10	10	1.50	100.0	15	10.00	8.00	11	3	8.50	39.00
E239M12	12	1.75	110.0	16	9.00	7.00	10	4	10.30	–
E239M14	14	2.00	110.0	20	11.00	9.00	12	4	12.00	–
E239M16	16	2.00	110.0	20	12.00	9.00	12	4	14.00	–
E239M20	20	2.50	140.0	25	16.00	12.00	15	4	17.50	–

E414

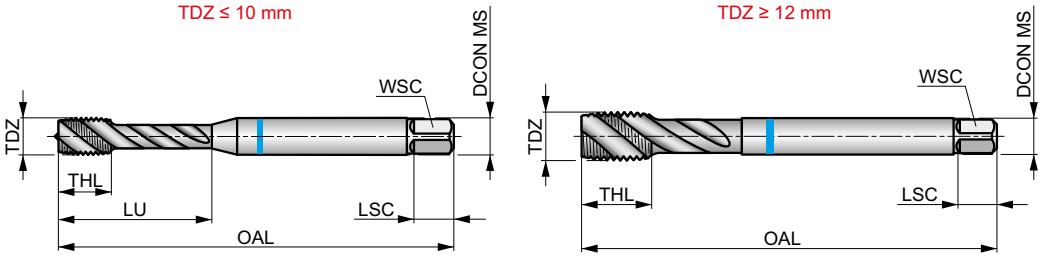


Blue SHARK 48° Spiral Flute Metric Machine Tap, DIN Standard

High performance quick spiral tap for deep blind holes in stainless steels. Unique HSS-E-PM substrate with Super-B coating and additional edge treatment provide superior performance. Extra back taper facilitates chip evacuation and reduces torque on reversal. Recommended to be used with synchronous feed tap holders.

SHARK

M	DIN 371/376	6H
	3×D	HSS-E PM
C 2-3		λ 48°
R	Super B	



Workpiece material group suitability and starting values for cutting speed (m/min).

P2.2	P2.3	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1	M2.2	M2.3	M3.1	M3.2	M3.3
◪32	◪28	◪15	◪13	◪11	◪10	■22	■19	■20	■16	■13	■14	■12	■11

M4.1	M4.2
■8	■7

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E414M3	3	0.50	56.0	6	3.50	2.70	6	3	2.50	18.00
E414M4	4	0.70	63.0	7	4.50	3.40	6	3	3.30	21.00
E414M5	5	0.80	70.0	8	6.00	4.90	8	3	4.20	25.00
E414M6	6	1.00	80.0	10	6.00	4.90	8	3	5.00	30.00
E414M8	8	1.25	90.0	13	8.00	6.20	9	3	6.80	35.00
E414M10	10	1.50	100.0	15	10.00	8.00	11	3	8.50	39.00
E414M12	12	1.75	110.0	18	9.00	7.00	10	3	10.30	–
E414M14	14	2.00	110.0	20	11.00	9.00	12	3	12.00	–
E414M16	16	2.00	110.0	20	12.00	9.00	12	4	14.00	–
E414M20	20	2.50	140.0	25	16.00	12.00	15	4	17.50	–

E473

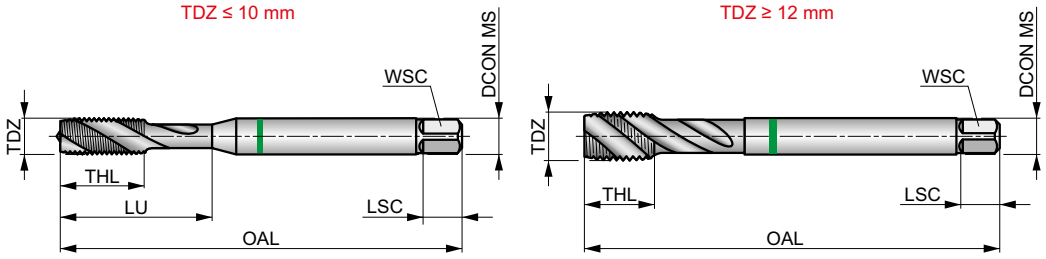


Green SHARK 35° Spiral Flute Metric Machine Tap, DIN Standard

Blind hole tap with reinforced or reduced shank for non-ferrous materials. Unique HSS-E-PM substrate with polished flutes provide consistency and process security.

SHARK

M	DIN 371/376	6H
2.5×D		HSS-E PM
C 2-3		λ 35°
R	Bright	



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.2	P1.3	P2.1	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	N4.1
◪22	◪23	◪15	■15	■11	■7	■29	■27	■19	■48	■28	◪14	■24

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E473M3	3	0.50	56.0	9	3.50	2.70	6	2	2.50	18.00
E473M4	4	0.70	63.0	12	4.50	3.40	6	2	3.30	21.00
E473M5	5	0.80	70.0	13	6.00	4.90	8	2	4.20	25.00
E473M6	6	1.00	80.0	15	6.00	4.90	8	2	5.00	30.00
E473M8	8	1.25	90.0	18	8.00	6.20	9	2	6.80	35.00
E473M10	10	1.50	100.0	20	10.00	8.00	11	2	8.50	39.00
E473M12	12	1.75	110.0	23	9.00	7.00	10	3	10.30	–
E473M16	16	2.00	110.0	25	12.00	9.00	12	3	14.00	–
E473M20	20	2.50	140.0	30	16.00	12.00	15	3	17.50	–

E474

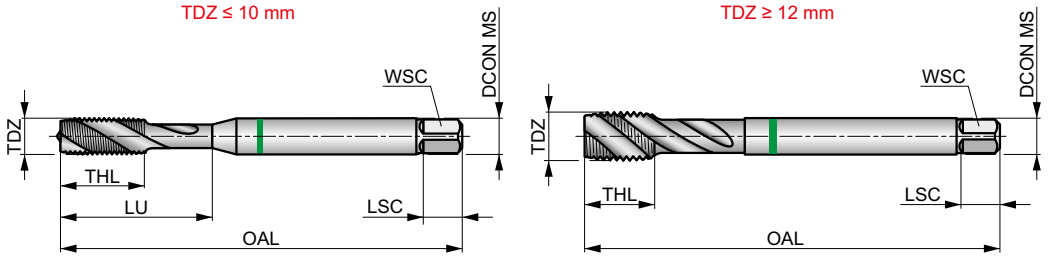


Green SHARK 35° Spiral Flute Metric Machine Tap, DIN Standard

High performance blind hole tap with reinforced or reduced shank for non-ferrous materials. Unique HSS-E-PM substrate with Super-B to avoid chip sticking, providing superior performance, consistency and extended tool life.

SHARK

M	DIN 371/376	6H
	2.5×D	HSS-E PM
C 2-3		λ 35°
R	Super B	



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N4.1
◪32	◪36	◪38	◪27	◪22	◪33	◪24	■17	■44	■40	■28	◪72	■43	◪28

Product	TDZ	TP [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	LSC [mm]	NOF	PHD [mm]	LU [mm]
E474M3	3	0.50	56.0	9	3.50	2.70	6	2	2.50	18.00
E474M4	4	0.70	63.0	12	4.50	3.40	6	2	3.30	21.00
E474M5	5	0.80	70.0	13	6.00	4.90	8	2	4.20	25.00
E474M6	6	1.00	80.0	15	6.00	4.90	8	2	5.00	30.00
E474M8	8	1.25	90.0	18	8.00	6.20	9	2	6.80	35.00
E474M10	10	1.50	100.0	20	10.00	8.00	11	2	8.50	39.00
E474M12	12	1.75	110.0	23	9.00	7.00	10	3	10.30	–
E474M16	16	2.00	110.0	25	12.00	9.00	12	3	14.00	–
E474M20	20	2.50	140.0	30	16.00	12.00	15	3	17.50	–

E299

DORMER

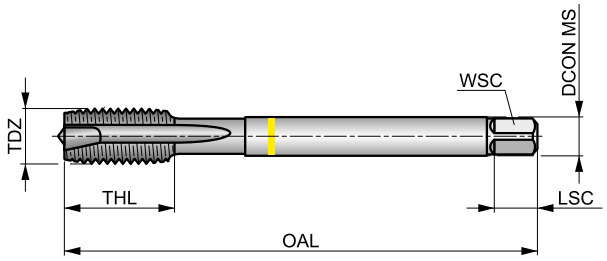


Yellow SHARK Spiral Point Metric-Fine Machine Tap, DIN Standard

High performance through hole tap for low carbon and alloyed steel and non-ferrous materials. Unique HSS-E-PM substrate with additional edge treatment, provide consistency and process security. Hard chrome coated to increase the surface hardness and reduce built-up edge, increasing performance and tool life.

SHARK

MF	DIN 374	6H
	2.5×D	HSS-E PM
B 3.5-5		R
Cr		



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	N3.1	N3.2	N3.3
■24	■27	■28	■20	■18	◪16	■15	◪12	◪9	■51	■30	◪15

Product	TDZ	TP [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	LSC [mm]	NOF	PHD [mm]
E299M4X.5	4	0.50	63.0	12	2.80	2.10	5	3	3.50
E299M5X.5	5	0.50	70.0	13	3.50	2.70	6	3	4.50
E299M6X.75	6	0.75	80.0	15	4.50	3.40	6	3	5.30
E299M8X.75	8	0.75	80.0	15	6.00	4.90	8	3	7.30
E299M8X1.0	8	1.00	90.0	18	6.00	4.90	8	3	7.00
E299M10X.75	10	0.75	90.0	20	7.00	5.50	8	3	9.30
E299M10X1.0	10	1.00	90.0	20	7.00	5.50	8	3	9.00
E299M10X1.25	10	1.25	100.0	20	7.00	5.50	8	3	8.80
E299M12X1.0	12	1.00	100.0	21	9.00	7.00	10	4	11.00
E299M12X1.25	12	1.25	100.0	21	9.00	7.00	10	4	10.80
E299M12X1.5	12	1.50	110.0	21	9.00	7.00	10	4	10.50
E299M14X1.0	14	1.00	100.0	21	11.00	9.00	12	4	13.00
E299M14X1.25	14	1.25	100.0	21	11.00	9.00	12	4	12.80
E299M14X1.5	14	1.50	100.0	21	11.00	9.00	12	4	12.50
E299M16X1.0	16	1.00	100.0	21	12.00	9.00	12	4	15.00
E299M16X1.5	16	1.50	100.0	21	12.00	9.00	12	4	14.50
E299M18X1.0	18	1.00	110.0	24	14.00	11.00	14	4	17.00
E299M18X1.5	18	1.50	110.0	24	14.00	11.00	14	4	16.50
E299M20X1.5	20	1.50	125.0	24	16.00	12.00	15	4	18.50
E299M22X1.5	22	1.50	125.0	25	18.00	14.50	17	4	20.50
E299M24X1.5	24	1.50	140.0	28	18.00	14.50	17	4	22.50
E299M24X2.0	24	2.00	140.0	28	18.00	14.50	17	4	22.00
E299M27X2.0	27	2.00	140.0	28	20.00	16.00	19	4	25.00
E299M30X2.0	30	2.00	150.0	28	22.00	18.00	21	4	28.00

E384

DORMER

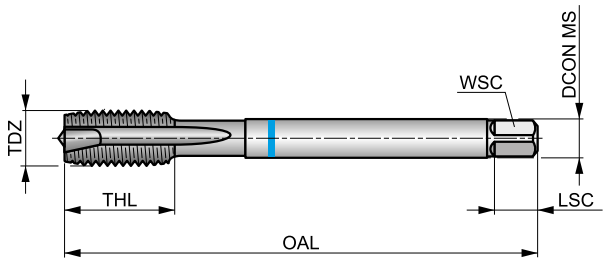


Blue SHARK Spiral Point Metric-Fine Machine Tap, DIN Standard

Through hole tap with reinforced or reduced shank for medium strength stainless steel. Unique HSS-E-PM substrate along with additional edge treatment, provide consistency and process security. Steam tempered surface acts to retain cutting fluid and prevent chip to tool welding.

SHARK

MF	DIN 374	6H
	2.5×D	HSS-E PM
B 3.5-5		R
ST		



Workpiece material group suitability and starting values for cutting speed (m/min).

P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2	M2.1	M2.2	M2.3	M3.1	M3.2
◪8	◪15	◪12	◪10	◪9	◪7	◪6	■11	■9	■10	■8	◪7	■8	■7

M3.3	M4.1	M4.2
■6	■5	◪4

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]
E384M6X.75	6	0.75	80.0	15	4.50	3.40	6	3	5.30
E384M8X1.0	8	1.00	90.0	18	6.00	4.90	8	3	7.00
E384M10X1.0	10	1.00	90.0	20	7.00	5.50	8	3	9.00
E384M10X1.25	10	1.25	100.0	20	7.00	5.50	8	3	8.80
E384M12X1.0	12	1.00	100.0	21	9.00	7.00	10	4	11.00
E384M12X1.25	12	1.25	100.0	21	9.00	7.00	10	4	10.80
E384M12X1.5	12	1.50	100.0	21	9.00	7.00	10	4	10.50
E384M14X1.5	14	1.50	100.0	21	11.00	9.00	12	4	12.50
E384M16X1.5	16	1.50	100.0	21	12.00	9.00	12	5	14.50
E384M18X1.5	18	1.50	110.0	24	14.00	11.00	14	5	16.50
E384M20X1.5	20	1.50	125.0	24	16.00	12.00	15	5	18.50

E300

DORMER

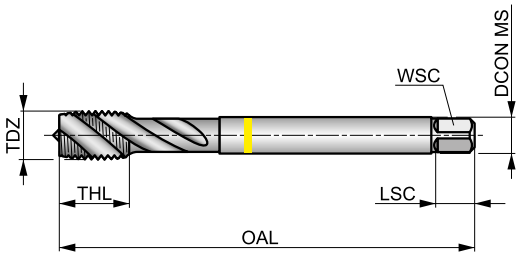


Yellow SHARK 40° Spiral Flute Metric-Fine Machine Tap, DIN Standard

High performance blind hole tap for low carbon and alloyed steel and non-ferrous materials. Unique HSS-E-PM substrate with additional edge treatment, provide consistency and process security. Hard chrome coated to increase the surface hardness, reduces built-up edge, resulting in increased performance and tool life.

SHARK

MF	DIN 374	6H
	2×D	HSS-E PM
C 2-3		λ 40°
R	Cr	



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	N3.1	N3.2	N3.3
■23	■25	■26	■19	■17	◪15	■14	◪11	◪8	■48	■28	◪14

Product	TDZ	TP [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	LSC [mm]	NOF	PHD [mm]
E300M4X.5	4	0.50	63.0	6.5	2.80	2.10	5	3	3.50
E300M5X.5	5	0.50	70.0	7.5	3.50	2.70	6	3	4.50
E300M6X.75	6	0.75	80.0	10	4.50	3.40	6	3	5.30
E300M8X.75	8	0.75	80.0	13	6.00	4.90	8	3	7.30
E300M8X1.0	8	1.00	90.0	13	6.00	4.90	8	3	7.00
E300M10X.75	10	0.75	90.0	13	7.00	5.50	8	3	9.30
E300M10X1.0	10	1.00	90.0	12	7.00	5.50	8	3	9.00
E300M10X1.25	10	1.25	100.0	15	7.00	5.50	8	3	8.80
E300M12X1.0	12	1.00	100.0	15	9.00	7.00	10	4	11.00
E300M12X1.25	12	1.25	100.0	13	9.00	7.00	10	4	10.80
E300M12X1.5	12	1.50	100.0	13	9.00	7.00	10	4	10.50
E300M14X1.0	14	1.00	100.0	15	11.00	9.00	12	4	13.00
E300M14X1.25	14	1.25	100.0	15	11.00	9.00	12	4	12.80
E300M14X1.5	14	1.50	100.0	15	11.00	9.00	12	4	12.50
E300M16X1.0	16	1.00	100.0	15	12.00	9.00	12	5	15.00
E300M16X1.5	16	1.50	100.0	15	12.00	9.00	12	5	14.50
E300M18X1.0	18	1.00	110.0	17	14.00	11.00	14	5	17.00
E300M18X1.5	18	1.50	110.0	17	14.00	11.00	14	5	16.50
E300M20X1.5	20	1.50	125.0	17	16.00	12.00	15	5	18.50
E300M22X1.5	22	1.50	125.0	17	18.00	14.50	17	5	20.50
E300M24X1.5	24	1.50	140.0	20	18.00	14.50	17	5	22.50
E300M24X2.0	24	2.00	140.0	20	18.00	14.50	17	5	22.00
E300M27X2.0	27	2.00	140.0	20	20.00	16.00	19	5	25.00
E300M30X2.0	30	2.00	150.0	20	22.00	18.00	21	5	28.00

E383

DORMER

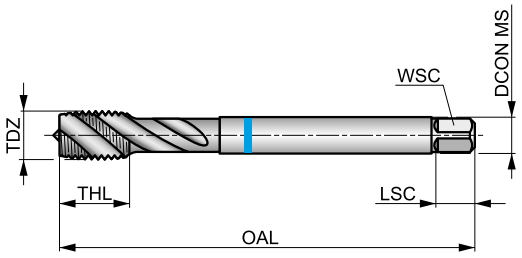


Blue SHARK 40° Spiral Flute Metric-Fine Machine Tap, DIN Standard

Blind hole tap with reduced shank for medium strength stainless steel. Unique HSS-E-PM substrate along with additional edge treatment, provide consistency and process security. Steam tempered surface acts to retain cutting fluid and prevent chip to tool welding.

SHARK

MF	DIN 374	6H
	2×D	HSS-E PM
C 2-3		λ 40°
R	ST	



Workpiece material group suitability and starting values for cutting speed (m/min).

P2.3	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1	M2.2	M3.1	M3.2	M3.3	M4.1
◪7	◪9	◪8	◪7	■10	■8	■9	■7	■7	■6	■5	■4

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]
E383M6X.75	6	0.75	80.0	10	4.50	3.40	6	3	5.30
E383M8X1.0	8	1.00	90.0	13	6.00	4.90	8	3	7.00
E383M10X1.0	10	1.00	90.0	12	7.00	5.50	8	3	9.00
E383M10X1.25	10	1.25	100.0	15	7.00	5.50	8	3	8.80
E383M12X1.0	12	1.00	100.0	13	9.00	7.00	10	4	11.00
E383M12X1.25	12	1.25	100.0	13	9.00	7.00	10	4	10.80
E383M12X1.5	12	1.50	100.0	13	9.00	7.00	10	4	10.50
E383M14X1.5	14	1.50	100.0	21	11.00	9.00	12	4	12.50
E383M16X1.5	16	1.50	100.0	21	12.00	9.00	12	5	14.50
E383M18X1.5	18	1.50	110.0	24	14.00	11.00	14	5	16.50
E383M20X1.5	20	1.50	125.0	24	16.00	12.00	15	5	18.50

E382

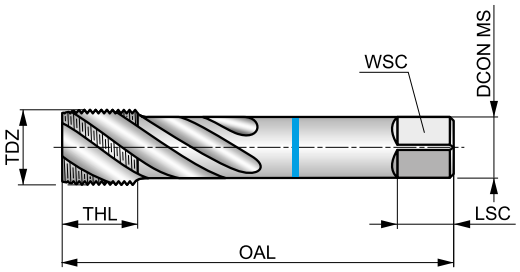
DORMER



Blue SHARK 40° Spiral Flute G(BSP) Machine Tap, DIN Standard

Blind hole tap with reduced shank for medium strength stainless steel. Unique HSS-E-PM substrate along with additional edge treatment, provide consistency and process security. Steam tempered surface acts to retain cutting fluid and prevent chip to tool welding.

SHARK



G	DIN 5156	Normal
	2×D	HSS-E PM
C 2-3		λ 40°
R	ST	

Workpiece material group suitability and starting values for cutting speed (m/min).

P2.3	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1	M2.2	M3.1	M3.2	M3.3	M4.1
◪8	◪10	◪9	◪7	■10	■8	■9	■7	■7	■6	■5	■4

Product	TDZ	TPI	TD [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	LSC [mm]	NOF	PHD [mm]
E3821/8	1/8	28	9.730	90.0	12	7.00	5.50	8	3	8.80
E3821/4	1/4	19	13.160	100.0	15	11.00	9.00	12	4	11.80
E3823/8	3/8	19	16.660	100.0	15	12.00	9.00	12	4	15.25
E3821/2	1/2	14	20.960	125.0	24	16.00	12.00	15	4	19.00
E3823/4	3/4	14	26.440	140.0	20	20.00	16.00	19	4	24.50
E3821	1″	11	33.250	160.0	24	25.00	20.00	23	4	30.75



HSS HAND & MACHINE TAPS

HSS HAND & MACHINE TAPS – TOOL MATERIAL NAVIGATOR

Tool materials

High Speed Steel	HSS	A medium-alloyed high speed steel that has good machinability and good performance. HSS exhibits hardness, toughness and wear resistance characteristics that make it attractive in a wide range of applications, for example in drills and taps.
Sintered Cobalt High Speed Steel	HSS-E PM	HSS-E-PM is a Cobalt High Speed Powder Metal substrate which has been produced using powder metal technology. High speed steel produced by this method exhibits superior toughness and grindability due to the uniform and consistent grain structure. High performance taps and end mills have a particular advantage when manufactured from this substrate.

Surface Treatments

Bright (uncoated)		Bright finish (uncoated surface) improves chip flow in soft or non-ferrous materials and maintains sharp cutting edges in abrasive materials.
Combination Bright and Steam Tempered		Combination of bright and steam tempering can be effective as the blue oxide more porous surface acts to retain and pull cutting fluid into the hole while the bright surface assists in chip evacuation. This combination is achieved by grinding the bright surface after tempering.
Steam Tempering		Steam tempering gives a strongly adhering blue oxide surface that acts to retain cutting fluid and prevent chip to tool welding, thereby counteracting the formation of a built-up edge. Steam tempering can be applied to any bright tool but is most effective on drills and taps.

Surface Coatings

Titanium Nitride (TiN)		Titanium Nitride is a gold coloured ceramic coating applied by physical vapour deposition (PVD). High hardness combined with low friction properties ensures considerably longer tool life, or alternatively, better cutting performance from tools which have not been coated. TiN coatings are used mainly for drills and taps.

Thread form (THFT)		M	M	M	M	M	M	M	M	M	M	M	M
Basic standard group (BSG)		DIN 352	DIN 352	DIN 352	DIN 371	DIN 376	DIN 371	DIN 376	ISO 529	ISO 529	ISO 529	DIN 357	ISO 2283	ISO 2283
Thread tolerance class (TCTR)		6H	6HX	6H	6H	6H	6H	6H	6H	6H	6H	6H	6H	6H
Threading application		IU	IU	IU	IU	IU	IU	IU	IU	IU	IU	IU	IU	IU
Usable length (ULDR)		1.5×D	1.5×D	1.5×D	1.5×D	1.5×D	1.5×D	1.5×D	1.5×D	1.5×D	1.5×D	2×D	1.5×D	1.5×D
Material code (BMC)		HSS	HSS-E	HSS	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS	HSS	HSS	HSS-E	HSS-E PM	HSS-E PM
Tap chamfer style (TCS)		C 2-3	C 2-3	C 2-3	A 6-8 C 2-3	A 6-8 C 2-3	C 2-3	C 2-3				C 2-3 D 18-20	C 2-3	C 2-3
Flute Geometry (FDC)														
Flute helix angle (FHA)														
Hand (Cutting direction)		R	R	L	R	R	L	L	R	L	R	R	R	R
Coating		Bright	ST	Bright	Bright	Bright	Bright	Bright	Bright	Bright	TiN	Bright	Bright	TiN
Coolant exit style (CXSC)														
Product Family Code		E100	E102	E101	E200	E250	E237	E251	E500	E501	E504	E303	E600	E610
		M1.6 - M52	M3 - M30	M4 - M16	M2 - M10	M3 - M52	M3 - M10	M12 - M24	M1 - M56	M3 - M24	M3 - M10	M3 - M20	M3 - M20	M3 - M16
		74	76	77	78	79	80	81	82	86	88	89	90	91
P	P1	■	◪	■	■	■	■	■	■	■	■	■	■	■
	P2	■	◪	■	■	■	■	■	■	■	◪	◪	■	■
	P3	◪	◪	◪	◪	◪	◪	◪	◪	◪	◪	◪	◪	◪
	P4	◪	◪	◪	◪	◪	◪	◪	◪	◪	◪	◪	◪	◪
M	M1		■											
	M2		◪											
	M3		■											
	M4		◪											
K	K1	◪	■	◪	◪	◪	◪	◪	◪	◪	■	◪	◪	■
	K2	◪	■	◪	◪	◪	◪	◪	◪	◪	■	◪	◪	■
	K3	◪	■	◪	◪	◪	◪	◪	◪	◪	■	◪	◪	■
	K4	◪	■	◪	◪	◪	◪	◪	◪	◪	■	◪	◪	◪
	K5		■		◪	◪	◪	◪	◪	◪	■	◪	◪	■
N	N1	■		■	◪	◪	◪	◪	◪	◪	◪	◪	◪	◪
	N2	■		■	◪	◪	◪	◪	◪	◪	◪	◪	◪	◪
	N3	■		■	◪	◪	◪	◪	◪	◪	◪	◪	◪	◪
	N4	■		■	◪	◪	◪	◪	◪	◪	◪	◪	◪	◪
	N5													
S	S1		◪											
	S2		◪											
	S3		◪											
	S4		◪											
H	H1													
	H2													
	H3													
	H4													

■ Primary use ◪ Possible use

	EP006H	EP006G	EP00TIN	EP016H	E000	E000TIN	E001	E606	E216	E266	E422	E423	E207	E258	E212
	M	M	M	M	M	M	M	M	M	M	M	M	M	M	M
	DIN 371/376	DIN 371/376	DIN 371/376	DIN 371/376	ISO 529	ISO 529	ISO 529	ISO 2283	DIN 371	DIN 376	DIN 371	DIN 376	DIN 371	DIN 376	DIN 371
	6H	6G	6H	6H	6H	6H	6H	6H	6H	6H	6H	6H	6H	6H	6H
	2.5×D	2.5×D	2.5×D	2.5×D	2.5×D	2.5×D	2.5×D	2.5×D	3×D	3×D	3×D	3×D	1.5×D	1.5×D	1.5×D
	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM
	B 3.5-5	B 3.5-5	B 3.5-5	B 3.5-5	B 3.5-5	B 3.5-5	B 3.5-5	B 3.5-5	B 3.5-5	B 3.5-5	B 3.5-5	B 3.5-5	C 2-3	C 2-3	C 2-3
													λ 15°	λ 15°	λ 15°
	Bright	Bright	TiN	ST	Bright	TiN	ST	Bright	Bright	Bright	TiN	TiN	Bright	Bright	TiN
	M2 - M30	M3 - M20	M3 - M30	M2 - M30	M1.6 - M24	M3 - M20	M1.6 - M24	M3 - M24	M3 - M10	M12 - M24	M3 - M10	M12 - M24	M2 - M10	M4 - M36	M3 - M10
	92	93	94	95	96	97	98	99	100	101	102	103	104	105	106
P1	■	■	■	◪	■	■	◪	■	■	■	■	■			
P2	■	■	■	■	■	■	■	■	■	■	■	■	◪	◪	◪
P3	◪	◪	■	■	◪	■	■	◪	■	■	■	■	■	■	■
P4	◪	◪	■	■	◪	◪	■	◪	◪	◪	◪	◪	◪	◪	◪
M1			■	◪		■	◪								
M2			■	◪		■	◪								
M3			■	◪		■	◪								
M4			◪	◪		◪	◪								
K1			◪	◪		◪	◪								
K2			◪	◪		◪	◪								
K3			◪	◪		◪	◪								
K4			◪	◪		◪	◪								
K5			◪	◪		◪	◪								
N1	■	■	■		■	■		◪	■	■	■	■	◪	◪	◪
N2	■	■	■		■	■		◪	◪	◪	◪	◪	◪	◪	◪
N3	◪	◪	◪		■	■		◪	◪	◪	■	■			
N4	◪	◪	◪		◪	◪		◪	◪	◪	◪	◪			
N5															
S1															
S2															
S3															
S4															
H1															
H2															
H3															
H4															

■ Primary use ◪ Possible use

Thread form (THFT)		M	M	M	M	M	M	M	M	M	M	M	M	M
Basic standard group (BSG)		DIN 376	DIN 371/376	DIN 371/376	DIN 371/376	DIN 371/376	ISO 529	ISO 529	ISO 529	ISO DORMER	ISO 2283	DIN 2174	DIN 2174	DIN 2174
Thread tolerance class (TCTR)		6H	6H	6G	6H	6H	6H	6H	6H	6H	6H	6HX	6HX	6HX
Threading application		U	U	U	U	U	U	U	U	⫼	U	⫼U	⫼U	⫼U
Usable length (ULDR)		1.5×D	2.5×D	2.5×D	2.5×D	2.5×D	2.5×D	2.5×D	2.5×D	1.5×D	2×D	3×D	3×D	3.5×D
Material code (BMC)		HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS	HSS-E PM	HSS-E	HSS-E	HSS-E
Tap chamfer style (TCS)		C 2-3	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3.5	C 2-3.5	C 2-3.5
Flute Geometry (FDC)														
Flute helix angle (FHA)		λ 15°	λ 45°	λ 45°	λ 45°	λ 45°	λ 45°	λ 45°	λ 45°	λ 30°	λ 40°			
Hand (Cutting direction)		R	R	R	R	R	R	R	R	R	R	R	R	R
Coating		TiN	Bright	Bright	TiN	ST	Bright	TiN	ST	ST	Bright	Bright	TiN	TiN
Coolant exit style (CXSC)														
														
Product Family Code		E263	EX006H	EX006G	EX00TIN	EX016H	E002	E002TIN	E003	E650	E605	E291	E292	E294
		M12 - M36	M2 - M64	M3 - M20	M3 - M30	M2 - M64	M2 - M24	M3 - M20	M2 - M24	M3 - M16	M3 - M20	M1.6 - M16	M1.6 - M16	M3 - M16
		107	108	109	110	111	112	113	114	115	116	117	118	119
P	P1		■	■	■	◪	■	■	◪	■	◪	■	■	■
	P2	◪	■	■	■	■	■	■	■	◪	■	■	■	■
	P3	■	◪	■	■	■	◪	■	■	◪	◪	■	■	■
	P4	◪	◪	◪	■	■	◪	◪	■		◪	■	◪	■
M	M1				■	◪		■	◪				■	■
	M2				■	◪		■	◪				■	■
	M3				■	◪		■	◪				■	■
	M4				◪	◪		◪	◪				◪	■
K	K1													
	K2													
	K3													
	K4													
	K5													
N	N1	◪	■	■			■			◪	◪	■	■	■
	N2	◪	■	■	■		■	■			◪	◪	■	■
	N3									◪			◪	◪
	N4									◪				
	N5													
S	S1													
	S2													
	S3													
	S4													
H	H1													
	H2													
	H3													
	H4													

■ Primary use ◪ Possible use

	E289	E293	E295	E296	E105	E268	E242	E290	E513	EP10	EP10TIN	EP11	E011	EX10	EX10TIN
	M	M	M	M	MF	MF	MF	MF	MF	MF	MF	MF	MF	MF	MF
	DIN 2174	DIN 2174	DIN 2174	DIN 2174	DIN 2181	DIN 374	DIN 371	DIN 374	ISO 529	DIN 374	DIN 374	DIN 374	ISO 529	DIN 374	DIN 374
	6HX	6HX	6GX	6GX	6H	6H	6H	6H	6H	6H	6H	6H	6H	6H	6H
	3.5×D	3×D	3×D	3×D	1.5×D	1.5×D	1.5×D	1.5×D	1.5×D	2.5×D	2.5×D	2.5×D	2.5×D	2.5×D	2.5×D
	HSS-E	HSS-E	HSS-E	HSS-E	HSS	HSS-E PM	HSS-E PM	HSS-E PM	HSS	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM
	C 2-3.5	E 1.5-2	C 2-3.5	E 1.5-2	C 2-3	C 2-3	C 2-3	C 2-3		B 3.5-5	B 3.5-5	B 3.5-5	B 3.5-5	C 2-3	C 2-3
														λ 45°	λ 45°
	R	R	R	R	R	R	L	L	R	R	R	R	R	R	R
	TiN	TiN	TiN	TiN	Bright	Bright	Bright	Bright	Bright	Bright	TiN	ST	ST	Bright	TiN
	M5 - M12	M3 - M16	M3 - M12	M3 - M10	M2.5 - M50	M4 - M50	M8 - M10	M12 - M24	M3 - M50	M4 - M30	M8 - M20	M4 - M30	M4 - M24	M4 - M30	M8 - M20
	120	121	122	123	124	127	129	130	131	135	136	137	138	139	140
P1	■	■	■	■	■	■	■	■	■	■	■	◪	◪	■	■
P2	■	■	■	■	■	■	■	■	■	■	■	◪	■	■	■
P3	■	■	■	■	◪	◪	◪	◪	◪	■	■	■	■	◪	■
P4	■	◪	◪	◪	◪	◪	◪	◪	◪	◪	◪	◪	■	◪	◪
M1	■	■	■	■							■	◪	◪		■
M2	■	■	■	■							■	◪	◪		■
M3	■	■	■	■							■	◪	◪		■
M4	■	◪	◪	◪							◪	◪	◪		◪
K1					◪	◪	◪	◪	◪		◪	◪	◪		
K2					◪	◪	◪	◪	◪		◪	◪	◪		
K3					◪	◪	◪	◪	◪		◪	◪	◪		
K4					◪	◪	◪	◪	◪		◪	◪	◪		
K5						◪	◪	◪	◪		◪	◪	◪		
N1	■	■	■	■	■	◪	◪	◪	◪	■	■			■	
N2	■	■	■	■	■	◪	◪	◪	◪	■	■			■	■
N3	◪	◪	◪	◪	■	◪	◪	◪	■	◪	◪				
N4					■	◪	◪	◪	◪	◪	◪				
N5															
S1															
S2															
S3															
S4															
H1															
H2															
H3															
H4															

■ Primary use ◪ Possible use

Thread form (THFT)	MF	MF	MF	UNC	UNC	UNC	UNC	UNC	UNC	UNC	UNC	UNC	UNC
Basic standard group (BSG)	DIN 374	ISO 529	DIN 2174	DIN 352	DIN 371	DIN 376	ISO 529	DIN 2184-1	DIN 2184-1	ISO 529	DIN 2184-1	DIN 2184-1	ISO 529
Thread tolerance class (TCTR)	6H	6H	6HX	2B	2B	2B	2B	2B	2B	2B	2B	2B	2B
Threading application	U	U	IU	IU	IU	IU	IU	I	I	I	U	U	U
Usable length (ULDR)	2.5×D	2.5×D	3×D	1.5×D	1.5×D	1.5×D	1.5×D	2.5×D	2.5×D	2.5×D	2.5×D	2.5×D	2.5×D
Material code (BMC)	HSS-E PM	HSS-E PM	HSS-E	HSS	HSS-E PM	HSS-E PM	HSS	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM
Tap chamfer style (TCS)	C 2-3	C 2-3	C 2-3.5	C 2-3	C 2-3	C 2-3		B 3.5-5	B 3.5-5	B 3.5-5	C 2-3	C 2-3	C 2-3
Flute Geometry (FDC)													
Flute helix angle (FHA)	λ 45°	λ 45°									λ 45°	λ 45°	λ 45°
Hand (Cutting direction)	R	R	R	R	R	R	R	R	R	R	R	R	R
Coating	ST	ST	TiN	Bright	Bright	Bright	Bright	Bright	ST	ST	Bright	ST	ST
Coolant exit style (CXSC)													
Product Family Code	EX11	E013	E288	E108	E225	E275	E515	EP20	EP21	E021	EX20	EX21	E023
	M4 - M30	M4 - M22	M5 - M12	No.5 - 1"	No.4 - 1/4	5/16 - 1.1/2	No.1 - 2"	No.4 - 1"	No.4 - 1"	No.2 - 1"	No.4 - 1"	No.4 - 1"	No.2 - 1"
	141	142	143	144	145	146	147	149	150	151	152	153	154
P	P1	◪	◪	■	■	■	■	■	■	◪	◪	■	◪	◪
	P2	■	■	■	■	■	■	■	■	■	■	■	■	■
	P3	■	■	■	◪	◪	◪	◪	◪	■	■	◪	■	■
	P4	■	■	◪	◪	◪	◪	◪	◪	■	■	◪	■	■
M	M1	◪	◪	■						◪	◪		◪	◪
	M2	◪	◪	■						◪	◪		◪	◪
	M3	◪	◪	■						◪	◪		◪	◪
	M4	◪	◪	◪						◪	◪		◪	◪
K	K1				◪	◪	◪	◪		◪	◪			
	K2				◪	◪	◪	◪		◪	◪			
	K3				◪	◪	◪	◪		◪	◪			
	K4				◪	◪	◪	◪		◪	◪			
	K5				◪	◪	◪	◪		◪	◪			
N	N1			■	■	◪	◪	◪	■			■		
	N2			■	■	◪	◪	◪	■			■		
	N3			◪	■	◪	◪	■	◪					
	N4				◪	◪	◪	◪	◪					
	N5													
S	S1													
	S2													
	S3													
	S4													
H	H1													
	H2													
	H3													
	H4													

■ Primary use ◪ Possible use

	E651	E287	E111	E229	E278	E524	EP30	EP31	E031	EX30	EX31	E033	E654	E286	E570
	UNC	UNC	UNF	UNF	UNF	UNF	UNF	UNF	UNF	UNF	UNF	UNF	UNF	UNF	UN
	DIN DORMER	DIN 2184-1	DIN 2181	DIN 371	DIN 374	ISO 529	DIN 2184-1	DIN 2184-1	ISO 529	DIN 2184-1	DIN 2184-1	ISO 529	DIN DORMER	DIN 2184-1	ISO 529
	2B	2BX	2B	2B	2B	2B	2B	2B	2B	2B	2B	2B	Medium	2BX	2B
	1.5×D	3.5×D	1.5×D	1.5×D	1.5×D	1.5×D	2.5×D	2.5×D	2.5×D	2.5×D	2.5×D	2.5×D	1.5×D	3.5×D	1.5×D
	HSS	HSS-E	HSS	HSS-E PM	HSS-E PM	HSS	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS	HSS-E	HSS
	C 2-3	C 2-3.5	C 2-3	C 2-3	C 2-3		C 2-3	C 2-3	B 3.5-5	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3.5	C 2-3
	λ 30°									λ 45°	λ 45°	λ 45°	λ 30°		
	R	R	R	R	R	R	R	R	R	R	R	R	R	R	R
	ST	TiN	Bright	Bright	Bright	Bright	Bright	ST	ST	Bright	ST	ST	ST	TiN	Bright
															
	No.6 - 5/8	No.4 - 1/2	No.5 - 1"	No.2 - 1/4	5/16 - 1.1/2	No.0 - 1.1/2	No.8 - 1"	No.8 - 1"	No.8 - 1"	No.8 - 1"	No.8 - 1"	No.8 - 1"	No.8 - 5/8	No.4 - 1/2	1/4 - 1.5/16
	155	156	157	158	159	160	162	163	164	165	166	167	168	169	170
P1	■	■	■	■	■	■	■	◪	◪	■	◪	◪	■	■	■
P2	◪	■	◪	■	■	■	■	■	■	■	◪	■	◪	■	■
P3	◪	■	◪	◪	◪	◪	◪	■	■	◪	■	■	◪	■	◪
P4		■	◪	◪	◪	◪	◪	■	■	◪	◪	■		■	◪
M1		■						◪	◪		◪	◪		■	
M2		■						◪	◪		◪	◪		■	
M3		■						◪	◪		◪	◪		■	
M4		■						◪	◪		◪	◪		■	
K1			◪	◪	◪	◪		◪	◪						◪
K2			◪	◪	◪	◪		◪	◪						◪
K3			◪	◪	◪	◪		◪	◪						◪
K4			◪	◪	◪	◪		◪	◪						◪
K5			◪	◪	◪	◪		◪	◪						◪
N1	◪	■	■	◪	◪	◪	■			■			◪	■	◪
N2		■	■	◪	◪	◪	■			■				■	◪
N3	◪	◪	■	◪	◪	■	■						◪	◪	■
N4	◪		■	◪	◪	◪	◪						◪		◪
N5															
S1															
S2															
S3															
S4															
H1															
H2															
H3															
H4															

■ Primary use ◪ Possible use

Thread form (THFT)	BSW	BSW	BSW	BSW	BSF	BSF	BSF	BA	BA	BA	G	G	G
Basic standard group (BSG)	DIN 351	ISO 529	ISO 529	ISO 529	ISO 529	ISO 529	ISO 529	ISO 529	ISO 529	ISO 529	DIN 5157	DIN 5156	ISO 2284
Thread tolerance class (TCTR)	Medium	Medium	Medium	Medium	Medium	Medium	Medium	Normal	Normal	Normal	Normal	Normal	Normal
Threading application	IU	IU	I	U	IU	I	U	IU	I	U	IU	IU	IU
Usable length (ULDR)	1.5×D	1.5×D	2.5×D	2×D	1.5×D	2.5×D	2×D	1.5×D	2.5×D	2×D	1.5×D	1.5×D	1.5×D
Material code (BMC)	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS-E PM	HSS
Tap chamfer style (TCS)	C 2-3		B 3.5-5	C 2-3		B 3.5-5	C 2-3		B 3.5-5	C 2-3	C 2-3	C 2-3	
Flute Geometry (FDC)													
Flute helix angle (FHA)				λ 40°			λ 40°			λ 40°			
Hand (Cutting direction)	R	R	R	R	R	R	R	R	R	R	R	R	R
Coating	Bright	Bright	ST	Bright ST	Bright	ST	Bright ST	Bright	ST	Bright ST	Bright	Bright	Bright
Coolant exit style (CXSC)													
Product Family Code	E115	E531	E534	E533	E536	E539	E538	E542	E545	E544	E119	E282	E547
	1/8 - 1"	1/8 - 1"	1/8 - 3/4	1/8 - 3/4	3/16 - 1"	1/4 - 1/2	1/4 - 1/2	No.10 - No.0	No.10 - No.2	No.8 - No.2	1/8 - 3"	1/8 - 1.1/2	1/8 - 2"
	171	172	174	175	176	178	179	180	182	183	184	186	187
P	P1	■	■	◪	■	■	◪	■	■	◪	■	■	■	■
	P2	■	■	◪	■	◪	■	■	■	■	■	■	■	■
	P3	◪	◪	■	◪	◪	■	■	◪	■	■	◪	◪	◪
	P4	◪	◪	◪	◪	◪	◪	◪	◪	◪	◪	◪	◪	◪
M	M1			◪	◪		■	◪		■	◪				
	M2			◪	◪		◪	◪		◪	◪				
	M3			◪	◪		■	◪		■	◪				
	M4			◪	◪		◪	◪		◪	◪				
K	K1	◪	◪	◪		◪	◪		◪	◪		◪	◪	◪	◪
	K2	◪	◪	◪		◪	◪		◪	◪		◪	◪	◪	◪
	K3	◪	◪	◪		◪	◪		◪	◪		◪	◪	◪	◪
	K4	◪	◪	◪		◪	◪		◪	◪		◪	◪	◪	◪
	K5	◪	◪	◪		◪	◪		◪	◪		◪	◪	◪	◪
N	N1	■	◪			◪		◪	◪		◪	■	◪	◪	◪
	N2	■	◪		◪	◪		◪	◪		◪	■	◪	◪	◪
	N3	■	■			■			◪			■	◪	◪	◪
	N4	■	◪			◪			◪			■	◪	◪	◪
	N5														
S	S1														
	S2														
	S3														
	S4														
H	H1														
	H2														
	H3														
	H4														

■ Primary use ◪ Possible use

	EP40	EP41	E041	EX40	EX41	E043	E620	E621	E550	E714	E710	E721	E711	E653	E712
	G	G	G	G	G	G	EGM	EGM	Rc	NPT	NPT	NPT	NPT	NPT	NPTF
	DIN 5156	DIN 5156	ISO DORMER	DIN 5156	DIN 5156	ISO DORMER	ISO DORMER	ISO DORMER	ISO 2284	ANSI DORMER	ANSI B94.9	ANSI B94.9	ANSI B94.9	ANSI	ANSI B94.9
	Normal	Normal	Normal	Normal	Normal	Normal	6H	6H	Normal	Normal	Normal	Normal	Normal	Normal	Normal
	2.5×D	2.5×D	2.5×D	2.5×D	2.5×D	2.5×D	1.5×D	2×D	1.5×D	1.5×D	1.5×D	1.5×D	1.5×D	1.5×D	1.5×D
	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS	HSS	HSS	HSS-E PM	HSS	HSS	HSS	HSS	HSS
	B 3.5-5	B 3.5-5	B 3.5-5	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3		C 2-3
				λ 45°	λ 45°	λ 45°		λ 40°						λ 27°	
	R	R	R	R	R	R	R	R	R	R	R	R	R	R	R
	Bright	ST	ST	Bright	ST	ST	Bright	Bright	Bright	Bright	Bright	TiN	Bright	Bright	Bright
	1/8 - 1"	1/8 - 1"	1/8 - 3/4	1/8 - 1.1/2	1/8 - 1.1/2	1/8 - 3/4	M3 - M16	M3 - M16	1/8 - 2"	1/8 - 1"	1/16 - 2"	1/8 - 1"	1/8 - 1.1/2	1/8 - 1"	1/16 - 1.1/4
	189	190	191	192	193	194	195	196	197	198	199	200	201	202	203
P1	■	◪	◪	■	◪	◪	■	■	■	■	■	■	◪	■	■
P2	■	■	■	■	■	■	■	■	◪	■	■	◪	◪	◪	■
P3	◪	■	■	◪	■	■	◪	◪	◪	■	◪	◪	■	◪	◪
P4	◪	■	■	◪	■	■	◪	◪	◪	◪	◪	■	◪		◪
M1		◪	◪		◪	◪			◪						
M2		◪	◪		◪	◪			◪						
M3		◪	◪		◪	◪			◪						
M4		◪	◪		◪	◪			◪						
K1		◪	◪				◪		◪	◪	◪	■	◪		◪
K2		◪	◪				◪		◪	◪	◪	■	◪		◪
K3		◪	◪				◪		◪	◪	◪	■	◪		◪
K4		◪	◪				◪		◪	◪	◪	■	◪		◪
K5		◪	◪				◪		◪	◪	◪	■	◪		◪
N1	■			■			◪		◪					◪	
N2	■			■			◪	◪	◪	◪	◪	◪	◪		◪
N3	■						◪		■	■	■	■	◪	◪	■
N4	◪						◪		◪		◪	◪	◪	◪	◪
N5															
S1															
S2															
S3															
S4															
H1															
H2															
H3															
H4															

■ Primary use ◪ Possible use

Thread form (THFT)		NPSF	NPSF	NPSM	PG	M	M		
Basic standard group (BSG)		ANSI B94.9	ANSI B94.9	ANSI B94.9	DIN 40432	DIN 352	ISO DORMER		
Thread tolerance class (TCTR)		Normal	Normal	Normal	Normal	6H	6H		
Threading application		IU	IU	IU	IU	IU			
Usable length (ULDR)		1.5×D	1.5×D	1.5×D	1.5×D	1.5×D	1.5×D		
Material code (BMC)		HSS	HSS	HSS	HSS	HSS	HSS		
Tap chamfer style (TCS)		C 2-3	C 2-3	C 2-3		C 2-3	C 2-3		
Flute Geometry (FDC)									
Flute helix angle (FHA)							λ 30°		
Hand (Cutting direction)		R	R	R	R	R	R		
Coating		Bright	TiN	Bright	Bright	Bright	ST		
Coolant exit style (CXSC)									
									
Product Family Code		E709	E720	E708	E243	L119	L126	L113	L114
		1/8 - 3/4	1/8 - 3/4	1/8 - 1"	No.7 - No.36	Set	Set	Set	Set
		204	205	206	207	208	208	209	209
P	P1	■	◪	■	■				
	P2	■	◪	◪	■				
	P3	■	■	■	◪				
	P4	◪	◪	◪	◪				
M	M1								
	M2								
	M3								
	M4								
K	K1	◪	■	◪	◪				
	K2	◪	■	◪	◪				
	K3	◪	■	◪	◪				
	K4	◪	■	◪	◪				
	K5	◪	■	◪	◪				
N	N1				◪				
	N2	◪	◪	◪	◪				
	N3	■	■	■	■				
	N4	◪	◪	◪	◪				
	N5								
S	S1								
	S2								
	S3								
	S4								
H	H1								
	H2								
	H3								
	H4								

■ Primary use ◪ Possible use

									
	L115	**L000**	**L001**	**L002**	**L120**	**L110**	**L112**		
	Set	Set	Set	Set	Set	16.00 - 4"	BT1 - No.7		
	210	210	211	212	213	214	215		
P1									
P2									
P3									
P4									
M1									
M2									
M3									
M4									
K1									
K2									
K3									
K4									
K5									
N1									
N2									
N3									
N4									
N5									
S1									
S2									
S3									
S4									
H1									
H2									
H3									
H4									

■ Primary use ◪ Possible use

E100

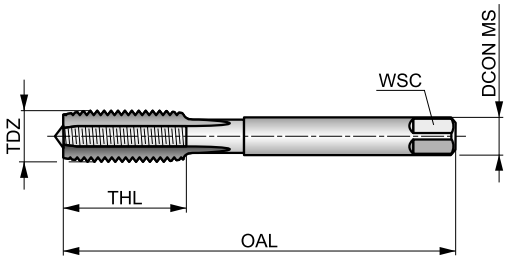
DORMER



HSS Straight Flute Serial Hand Taps, Metric, DIN Standard, Bright Finish

Ideal for hand tapping tough materials. The straight flute design makes it ideal for both through and blind holes. Available as a single finishing tap or as a set of three serial taps, which should be used one after the other to create the full thread. Bright finish.

M	DIN 352	6H
	1.5×D	HSS
C 2-3		R
Bright		



Workpiece material group suitability.

P1.1 ■	P1.2 ■	P1.3 ■	P2.1 ■	P2.2 ■	P2.3 ◪	P3.1 ■	P3.2 ◪	P4.1 ◪	K1.1 ◪	K1.2 ◪	K1.3 ◪	K2.1 ◪	K2.2 ◪
K3.1 ◪	K3.2 ◪	K4.1 ◪	K4.2 ◪	K5.1 ◪	K5.2 ◪	N1.1 ■	N1.2 ■	N1.3 ■	N2.1 ■	N2.2 ■	N2.3 ■	N3.1 ■	N3.2 ■
N3.3 ■	N4.2 ■	N4.3 ■											

Products from this series are also available in set of sizes or with dies. Please see L119 or L120.

Product	TDZ	TP	OAL	THL	DCON MS	WSC	NOF	PHD
		[mm]	[mm]	[mm]	[mm]	[mm]		[mm]
E100M1.6N03	1.6	0.35	32.0	7	2.50	2.10	3	1.25
E100M1.6N08	1.6	0.35	32.0	7	2.50	2.10	3	1.25
E100M2N03	2	0.40	36.0	8	2.80	2.10	3	1.60
E100M2N08	2	0.40	36.0	8	2.80	2.10	3	1.60
E100M2.5N03	2.5	0.45	40.0	9	2.80	2.10	3	2.05
E100M2.5N08	2.5	0.45	40.0	9	2.80	2.10	3	2.05
E100M3N03	3	0.50	40.0	10	3.50	2.70	3	2.50
E100M3N08	3	0.50	40.0	10	3.50	2.70	3	2.50
E100M3.5N03	3.5	0.60	45.0	10	4.00	3.00	3	2.90
E100M3.5N08	3.5	0.60	45.0	10	4.00	3.00	3	2.90
E100M4N03	4	0.70	45.0	12	4.50	3.40	3	3.30
E100M4N08	4	0.70	45.0	12	4.50	3.40	3	3.30
E100M5N03	5	0.80	50.0	14	6.00	4.90	3	4.20
E100M5N08	5	0.80	50.0	14	6.00	4.90	3	4.20
E100M6N03	6	1.00	56.0	16	6.00	4.90	3	5.00
E100M6N08	6	1.00	56.0	16	6.00	4.90	3	5.00
E100M7N03	7	1.00	56.0	16	6.00	4.90	3	6.00
E100M7N08	7	1.00	56.0	16	6.00	4.90	3	6.00
E100M8N03	8	1.25	63.0	19	6.00	4.90	3	6.80
E100M8N08	8	1.25	63.0	19	6.00	4.90	3	6.80
E100M9N03	9	1.25	63.0	20	7.00	5.50	3	7.80
E100M9N08	9	1.25	63.0	20	7.00	5.50	3	7.80
E100M10N03	10	1.50	70.0	22	7.00	5.50	3	8.50
E100M10N08	10	1.50	70.0	22	7.00	5.50	3	8.50
E100M12N03	12	1.75	75.0	25	9.00	7.00	4	10.30
E100M12N08	12	1.75	75.0	25	9.00	7.00	4	10.30
E100M14N03	14	2.00	80.0	25	11.00	9.00	4	12.00

Product	TDZ	TP	OAL	THL	DCON MS	WSC	NOF	PHD
		[mm]	[mm]	[mm]	[mm]	[mm]		[mm]
E100M14NO8	14	2.00	80.0	25	11.00	9.00	4	12.00
E100M16NO3	16	2.00	80.0	25	12.00	9.00	4	14.00
E100M16NO8	16	2.00	80.0	25	12.00	9.00	4	14.00
E100M18NO3	18	2.50	95.0	32	14.00	11.00	4	15.50
E100M18NO8	18	2.50	95.0	32	14.00	11.00	4	15.50
E100M20NO3	20	2.50	95.0	32	16.00	12.00	4	17.50
E100M20NO8	20	2.50	95.0	32	16.00	12.00	4	17.50
E100M22NO3	22	2.50	100.0	34	18.00	14.50	4	19.50
E100M22NO8	22	2.50	100.0	34	18.00	14.50	4	19.50
E100M24NO3	24	3.00	110.0	38	18.00	14.50	4	21.00
E100M24NO8	24	3.00	110.0	38	18.00	14.50	4	21.00
E100M27NO3	27	3.00	110.0	38	20.00	16.00	4	24.00
E100M27NO8	27	3.00	110.0	38	20.00	16.00	4	24.00
E100M30NO3	30	3.50	125.0	45	22.00	18.00	4	26.50
E100M30NO8	30	3.50	125.0	45	22.00	18.00	4	26.50
E100M33NO3	33	3.50	125.0	50	25.00	20.00	4	29.50
E100M33NO8	33	3.50	125.0	50	25.00	20.00	4	29.50
E100M36NO3	36	4.00	150.0	56	28.00	22.00	4	32.00
E100M36NO8	36	4.00	150.0	56	28.00	22.00	4	32.00
E100M39NO3	39	4.00	150.0	60	32.00	24.00	4	35.00
E100M39NO8	39	4.00	150.0	60	32.00	24.00	4	35.00
E100M42NO3	42	4.50	150.0	60	32.00	24.00	4	37.50
E100M42NO8	42	4.50	150.0	60	32.00	24.00	4	37.50
E100M45NO3	45	4.50	160.0	65	36.00	29.00	6	40.50
E100M45NO8	45	4.50	160.0	65	36.00	29.00	6	40.50
E100M48NO3	48	5.00	180.0	70	36.00	29.00	6	43.00
E100M48NO8	48	5.00	180.0	70	36.00	29.00	6	43.00
E100M52NO3	52	5.00	180.0	70	40.00	32.00	6	47.00
E100M52NO8	52	5.00	180.0	70	40.00	32.00	6	47.00

E102

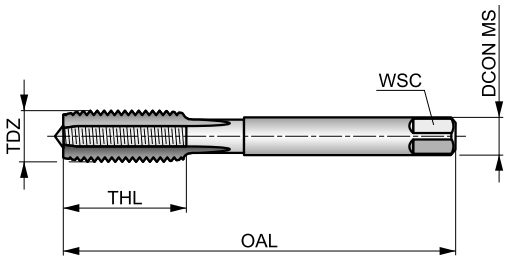
DORMER



HSS-E Straight Flute Serial Hand Taps, Metric, DIN Standard

Ideal for hand tapping tough materials. The straight flute design makes it ideal for both through and blind holes. Available as a set of three serial taps, which should be used one after the other to create the full thread. Steam tempered surface acts to retain cutting fluid to improve lubrication and provide smoother cutting.

M	DIN 352	6HX
1.5×D		HSS-E
C 2-3		R
ST		



Workpiece material group suitability.

P1.1 ◪	P1.2 ◪	P1.3 ◪	P2.1 ◪	P2.2 ◪	P2.3 ■	P3.1 ◪	P3.2 ■	P3.3 ◪	P4.1 ■	P4.2 ◪	M1.1 ■	M1.2 ■	M2.1 ■
M2.2 ◪	M3.1 ■	M3.2 ■	M3.3 ◪	M4.1 ◪	K1.1 ■	K1.2 ■	K1.3 ■	K2.1 ■	K2.2 ■	K2.3 ◪	K3.1 ■	K3.2 ■	K3.3 ◪
K4.1 ■	K4.2 ■	K4.3 ◪	K5.1 ■	K5.2 ■	K5.3 ◪	S1.1 ◪	S2.1 ◪	S3.1 ◪	S4.1 ◪				

No4 with pilot guide.

Product	TDZ	TP	OAL	THL	DCON MS	WSC	NOF	PHD
		[mm]	[mm]	[mm]	[mm]	[mm]		[mm]
E102M3N08	3	0.50	40.0	10	3.50	2.70	3	2.50
E102M4N08	4	0.70	45.0	12	4.50	3.40	3	3.30
E102M5N08	5	0.80	50.0	14	6.00	4.90	3	4.20
E102M6N08	6	1.00	56.0	16	6.00	4.90	3	5.00
E102M8N08	8	1.25	63.0	19	6.00	4.90	3	6.80
E102M10N08	10	1.50	70.0	22	7.00	5.50	3	8.50
E102M12N08	12	1.75	75.0	25	9.00	7.00	4	10.30
E102M14N08	14	2.00	80.0	25	11.00	9.00	4	12.00
E102M16N08	16	2.00	80.0	25	12.00	9.00	4	14.00
E102M18N08	18	2.50	95.0	32	14.00	11.00	4	15.50
E102M20N08	20	2.50	95.0	32	16.00	12.00	4	17.50
E102M24N08	24	3.00	110.0	38	18.00	14.50	4	21.00
E102M27N08	27	3.00	110.0	38	20.00	16.00	4	24.00
E102M30N08	30	3.50	125.0	45	22.00	18.00	4	26.50

E101

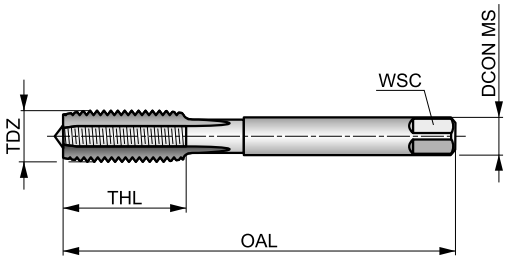
DORMER



HSS Straight Flute Serial Hand Taps, Metric, DIN Standard, Left-Handed

Ideal for hand tapping tough materials. The straight flute design makes it ideal for both through and blind holes. Available as a single finishing tap or as a set of three serial taps, which should be used one after the other to create the full thread. Bright finish.

M	DIN 352	6H
1.5×D		HSS
C 2-3		L
Bright		



Workpiece material group suitability.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	K1.1	K1.2	K1.3	K2.1	K2.2
■	■	■	■	■	◪	■	◪	◪	◪	◪	◪	◪	◪

K3.1	K3.2	K4.1	K4.2	K5.1	K5.2	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2
◪	◪	◪	◪	◪	◪	■	■	■	■	■	■	■	■

N3.3	N4.2	N4.3
■	■	■

Product	TDZ	TP [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	NOF	PHD [mm]
E101M4N03	4	0.70	45.0	12	4.50	3.40	3	3.30
E101M4N08	4	0.70	45.0	12	4.50	3.40	3	3.30
E101M5N03	5	0.80	50.0	14	6.00	4.90	3	4.20
E101M5N08	5	0.80	50.0	14	6.00	4.90	3	4.20
E101M6N03	6	1.00	56.0	16	6.00	4.90	3	5.00
E101M6N08	6	1.00	56.0	16	6.00	4.90	3	5.00
E101M8N03	8	1.25	63.0	19	6.00	4.90	3	6.80
E101M8N08	8	1.25	63.0	19	6.00	4.90	3	6.80
E101M10N03	10	1.50	70.0	22	7.00	5.50	3	8.50
E101M10N08	10	1.50	70.0	22	7.00	5.50	3	8.50
E101M12N03	12	1.75	75.0	25	9.00	7.00	4	10.30
E101M12N08	12	1.75	75.0	25	9.00	7.00	4	10.30
E101M14N03	14	2.00	80.0	25	11.00	9.00	4	12.00
E101M14N08	14	2.00	80.0	25	11.00	9.00	4	12.00
E101M16N03	16	2.00	80.0	25	12.00	9.00	4	14.00
E101M16N08	16	2.00	80.0	25	12.00	9.00	4	14.00

E200

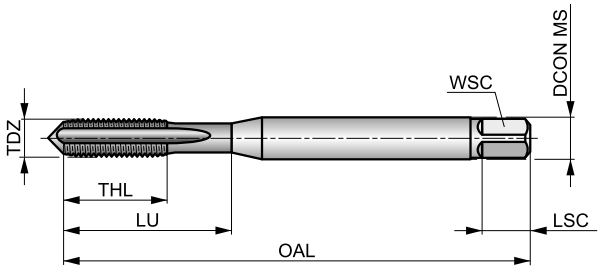
DORMER



HSS-E-PM Straight Flute Machine Tap, Metric, DIN Standard

General purpose straight flute machine tap for through and blind holes. Bright finish to produce more accurate and cleaner threads preventing the workpiece material from sticking to the cutting edges. The reinforced shank increases strength against torsional twist.

M	DIN 371	6H
	1.5×D	HSS-E PM
A 6-8 C 2-3		R
Bright		



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	K1.1	K1.2	K1.3	K2.1	K2.2
■11	■12	■12	■9	■8	◪7	■7	◪6	◪4	◪13	◪10	◪8	◪14	◪11

K3.1	K3.2	K4.1	K4.2	K5.1	K5.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N4.2
◪12	◪9	◪12	◪9	◪12	◪10	◪12	◪15	◪14	◪11	◪21	■14	◪8

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E200M2	2	0.40	45.0	6	2.80	2.10	5	3	1.60	9.00
E200M2.5	2.5	0.45	50.0	8	2.80	2.10	5	3	2.05	12.50
E200M3	3	0.50	56.0	9	3.50	2.70	6	3	2.50	18.00
E200M3NO1	3	0.50	56.0	9	3.50	2.70	6	3	2.50	18.00
E200M4	4	0.70	63.0	12	4.50	3.40	6	3	3.30	21.00
E200M4NO1	4	0.70	63.0	12	4.50	3.40	6	3	3.30	21.00
E200M5	5	0.80	70.0	13	6.00	4.90	8	3	4.20	25.00
E200M5NO1	5	0.80	70.0	13	6.00	4.90	8	3	4.20	25.00
E200M6	6	1.00	80.0	15	6.00	4.90	8	3	5.00	30.00
E200M6NO1	6	1.00	80.0	15	6.00	4.90	8	3	5.00	30.00
E200M8	8	1.25	90.0	18	8.00	6.20	9	3	6.80	35.00
E200M8NO1	8	1.25	90.0	18	8.00	6.20	9	3	6.80	35.00
E200M10	10	1.50	100.0	20	10.00	8.00	11	3	8.50	39.00
E200M10NO1	10	1.50	100.0	20	10.00	8.00	11	3	8.50	39.00

E250

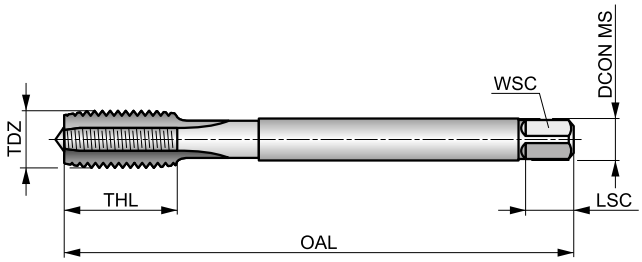
DORMER



HSS-E-PM Straight Flute Machine Tap, Metric, DIN Standard

General purpose straight flute machine tap for through and blind holes. Bright finish to produce more accurate and cleaner threads preventing the workpiece material from sticking to the cutting edges. The reduced shank increases the reach of the tap.

M	DIN 376	6H
1.5×D		HSS-E PM
A 6-8 C 2-3		R
Bright		



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	K1.1	K1.2	K1.3	K2.1	K2.2
■11	■12	■12	■9	■8	◪7	■7	◪6	◪4	◪13	◪10	◪8	◪14	◪11

K3.1	K3.2	K4.1	K4.2	K5.1	K5.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N4.2
◪12	◪9	◪12	◪9	◪12	◪10	◪12	◪15	◪14	◪11	◪21	■14	◪8

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]
E250M3	3	0.50	56.0	10	2.20	1.80	5	3	2.50
E250M4	4	0.70	63.0	12	2.80	2.10	5	3	3.30
E250M5	5	0.80	70.0	13	3.50	2.70	6	3	4.20
E250M6	6	1.00	80.0	15	4.50	3.40	6	3	5.00
E250M6N01	6	1.00	80.0	15	4.50	3.40	6	3	5.00
E250M8	8	1.25	90.0	18	6.00	4.90	8	3	6.80
E250M8N01	8	1.25	90.0	18	6.00	4.90	8	3	6.80
E250M10	10	1.50	100.0	20	7.00	5.50	8	3	8.50
E250M12	12	1.75	110.0	23	9.00	7.00	10	3	10.30
E250M12N01	12	1.75	110.0	23	9.00	7.00	10	3	10.30
E250M14	14	2.00	110.0	25	11.00	9.00	12	3	12.00
E250M14N01	14	2.00	110.0	25	11.00	9.00	12	3	12.00
E250M16	16	2.00	110.0	25	12.00	9.00	12	3	14.00
E250M16N01	16	2.00	110.0	25	12.00	9.00	12	3	14.00
E250M18	18	2.50	125.0	30	14.00	11.00	14	3	15.50
E250M18N01	18	2.50	125.0	30	14.00	11.00	14	3	15.50
E250M20	20	2.50	140.0	30	16.00	12.00	15	3	17.50
E250M20N01	20	2.50	140.0	30	16.00	12.00	15	3	17.50
E250M22	22	2.50	140.0	34	18.00	14.50	17	4	19.50
E250M22N01	22	2.50	140.0	34	18.00	14.50	17	4	19.50
E250M24	24	3.00	160.0	38	18.00	14.50	17	4	21.00
E250M27	27	3.00	160.0	38	20.00	16.00	19	4	24.00
E250M30	30	3.50	180.0	45	22.00	18.00	21	4	26.50
E250M33	33	3.50	180.0	50	25.00	20.00	23	4	29.50
E250M36	36	4.00	200.0	55	28.00	22.00	25	4	32.00
E250M39	39	4.00	200.0	60	32.00	24.00	27	4	35.00
E250M42 [1]	42	4.50	200.0	60	32.00	24.00	27	4	37.50
E250M45 [1]	45	4.50	220.0	65	36.00	29.00	32	6	40.50
E250M48 [1]	48	5.00	250.0	70	36.00	29.00	32	6	43.00
E250M52 [1]	52	5.00	250.0	70	40.00	32.00	35	6	47.00

[1] HSS-E.

E237

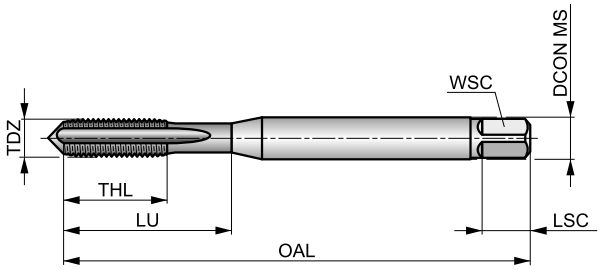
DORMER



HSS-E-PM Straight Flute Machine Tap, Metric, DIN Standard, Left-Handed

General purpose straight flute machine tap for through and blind holes. Bright finish to produce more accurate and cleaner threads preventing the workpiece material from sticking to the cutting edges. The reinforced shank increases strength against torsional twist.

M	DIN 371	6H
	1.5×D	HSS-E PM
C 2-3		L
Bright		



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	K1.1	K1.2	K1.3	K2.1	K2.2
■11	■12	■12	■9	■8	◪7	■7	◪6	◪4	◪13	◪10	◪8	◪14	◪11

K3.1	K3.2	K4.1	K4.2	K5.1	K5.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N4.2
◪13	◪10	◪12	◪9	◪12	◪10	◪12	◪15	◪14	◪11	◪21	■14	◪8

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E237M3	3	0.50	56.0	9	3.50	2.70	6	3	2.50	18.00
E237M4	4	0.70	63.0	12	4.50	3.40	6	3	3.30	21.00
E237M5	5	0.80	70.0	13	6.00	4.90	8	3	4.20	25.00
E237M6	6	1.00	80.0	15	6.00	4.90	8	3	5.00	30.00
E237M8	8	1.25	90.0	18	8.00	6.20	9	3	6.80	35.00
E237M10	10	1.50	100.0	20	10.00	8.00	11	3	8.50	39.00

E251

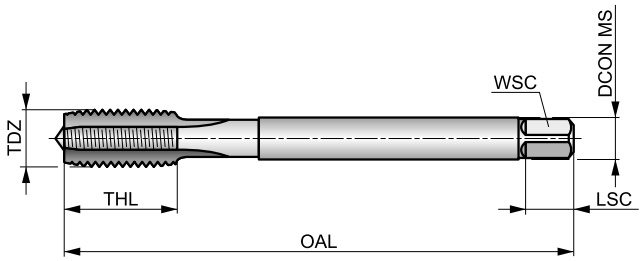
DORMER



HSS-E-PM Straight flute Machine tap, Metric, DIN Standard, Left-handed

General purpose straight flute machine tap for through and blind holes. Bright finish to produce more accurate and cleaner threads preventing the workpiece material from sticking to the cutting edges. The reduced shank increases the reach of the tap.

M	DIN 376	6H
1.5×D		HSS-E PM
C 2-3		L
Bright		



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	K1.1	K1.2	K1.3	K2.1	K2.2
■11	■12	■12	■9	■8	◪7	■7	◪6	◪4	◪13	◪10	◪8	◪14	◪11

K3.1	K3.2	K4.1	K4.2	K5.1	K5.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N4.2
◪12	◪9	◪12	◪9	◪12	◪10	◪12	◪15	◪14	◪11	◪21	◪14	◪8

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]
E251M12	12	1.75	110.0	23	9.00	7.00	10	4	10.30
E251M14	14	2.00	110.0	25	11.00	9.00	12	4	12.00
E251M16	16	2.00	110.0	25	12.00	9.00	12	4	14.00
E251M18	18	2.50	125.0	30	14.00	11.00	14	4	15.50
E251M20	20	2.50	140.0	30	16.00	12.00	15	4	17.50
E251M22	22	2.50	140.0	34	18.00	14.50	17	4	19.50
E251M24	24	3.00	160.0	38	18.00	14.50	17	4	21.00

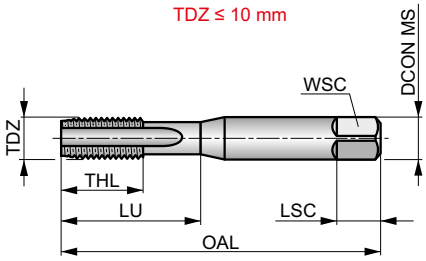
E500

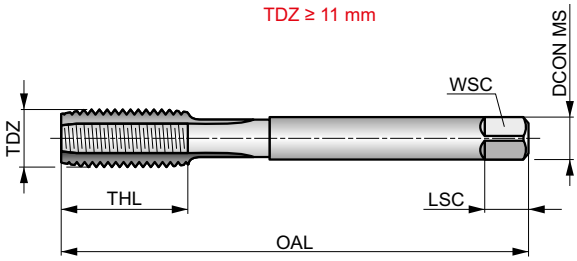
DORMER



Straight Flute Hand Taps, Metric, ISO Standard

A versatile tool, suitable for hand and machine tapping, with a straight flute design for both through and blind holes. As a hand tap set of three N06 or two N07 with different chamfer length, each producing a full thread. Or as a set N08 with three serial taps to be used in sequence to create the full thread.





M	ISO 529	6H
	1.5×D	HSS
	R	Bright

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	P4.2	K1.1	K1.2	K1.3	K2.1
■7	■7	■8	■6	■5	◪4	■4	◪4	◪3	◪2	◪12	◪9	◪7	◪12
K2.2	**K3.1**	**K3.2**	**K4.1**	**K4.2**	**K5.1**	**K5.2**	**N1.3**	**N2.1**	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**
◪10	◪11	◪8	◪10	◪8	◪11	◪9	◪8	◪11	◪10	◪7	◪17	◪10	◪5
N4.2	**N4.3**												
◪5	◪3												

Products from this series are also available in sets with drills or dies. Please see L115, L000 or L120.

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E500M1N01 [1]	1	0.25	38.0	4.5	2.50	2.00	4	2	0.75	4.50
E500M1N02 [1]	1	0.25	38.0	4.5	2.50	2.00	4	2	0.75	4.50
E500M1N03 [1]	1	0.25	38.0	4.5	2.50	2.00	4	2	0.75	4.50
E500M1.2N01 [1]	1.2	0.25	38.0	4.5	2.50	2.00	4	2	0.95	4.50
E500M1.2N02 [1]	1.2	0.25	38.0	4.5	2.50	2.00	4	2	0.95	4.50
E500M1.2N03 [1]	1.2	0.25	38.0	4.5	2.50	2.00	4	2	0.95	4.50
E500M1.4N01 [1]	1.4	0.30	40.0	6	2.50	2.00	4	2	1.10	6.00
E500M1.4N02 [1]	1.4	0.30	40.0	6	2.50	2.00	4	2	1.10	6.00
E500M1.4N03 [1]	1.4	0.30	40.0	6	2.50	2.00	4	2	1.10	6.00
E500M1.6N01	1.6	0.35	41.0	8	2.50	2.00	4	2	1.25	8.00
E500M1.6N02	1.6	0.35	41.0	8	2.50	2.00	4	2	1.25	8.00
E500M1.6N03	1.6	0.35	41.0	8	2.50	2.00	4	2	1.25	8.00
E500M1.6N06	1.6	0.35	41.0	8	2.50	2.00	4	2	1.25	8.00
E500M1.7N01	1.7	0.35	41.0	8	2.50	2.00	4	2	1.35	8.00
E500M1.7N02	1.7	0.35	41.0	8	2.50	2.00	4	2	1.35	8.00
E500M1.7N03	1.7	0.35	41.0	8	2.50	2.00	4	2	1.35	8.00
E500M1.7N06	1.7	0.35	41.0	8	2.50	2.00	4	2	1.35	8.00
E500M1.7N08	1.7	0.35	41.0	8	2.50	2.00	4	2	1.35	8.00
E500M1.8N01	1.8	0.35	41.0	8	2.50	2.00	4	2	1.45	8.00
E500M1.8N02	1.8	0.35	41.0	8	2.50	2.00	4	2	1.45	8.00
E500M1.8N03	1.8	0.35	41.0	8	2.50	2.00	4	2	1.45	8.00
E500M2N01	2	0.40	41.0	8	2.50	2.00	4	3	1.60	8.00
E500M2N02	2	0.40	41.0	8	2.50	2.00	4	3	1.60	8.00
E500M2N03	2	0.40	41.0	8	2.50	2.00	4	3	1.60	8.00
E500M2N06	2	0.40	41.0	8	2.50	2.00	4	3	1.60	8.00
E500M2N08	2	0.40	41.0	8	2.50	2.00	4	3	1.60	8.00
E500M2X.45N01	2	0.45	41.0	8	2.50	2.00	4	3	1.55	8.00

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E500M2X.45N02	2	0.45	41.0	8	2.50	2.00	4	3	1.55	8.00
E500M2X.45N03	2	0.45	41.0	8	2.50	2.00	4	3	1.55	8.00
E500M2.2N01	2.2	0.45	44.5	9.5	2.80	2.24	5	3	1.75	9.50
E500M2.2N02	2.2	0.45	44.5	9.5	2.80	2.24	5	3	1.75	9.50
E500M2.2N03	2.2	0.45	44.5	9.5	2.80	2.24	5	3	1.75	9.50
E500M2.3N01	2.3	0.45	44.5	9.5	2.80	2.24	5	3	1.85	9.50
E500M2.3N02	2.3	0.45	44.5	9.5	2.80	2.24	5	3	1.85	9.50
E500M2.3N03	2.3	0.45	44.5	9.5	2.80	2.24	5	3	1.85	9.50
E500M2.5N01	2.5	0.45	44.5	9.5	2.80	2.24	5	3	2.05	9.50
E500M2.5N02	2.5	0.45	44.5	9.5	2.80	2.24	5	3	2.05	9.50
E500M2.5N03	2.5	0.45	44.5	9.5	2.80	2.24	5	3	2.05	9.50
E500M2.5N06	2.5	0.45	44.5	9.5	2.80	2.24	5	3	2.05	9.50
E500M2.5N08	2.5	0.45	44.5	9.5	2.80	2.24	5	3	2.05	9.50
E500M2.6N01	2.6	0.45	44.5	9.5	2.80	2.24	5	3	2.15	9.50
E500M2.6N02	2.6	0.45	44.5	9.5	2.80	2.24	5	3	2.15	9.50
E500M2.6N03	2.6	0.45	44.5	9.5	2.80	2.24	5	3	2.15	9.50
E500M3N01	3	0.50	48.0	12.5	3.15	2.50	5	3	2.50	12.50
E500M3N02	3	0.50	48.0	12.5	3.15	2.50	5	3	2.50	12.50
E500M3N03	3	0.50	48.0	12.5	3.15	2.50	5	3	2.50	12.50
E500M3N06	3	0.50	48.0	12.5	3.15	2.50	5	3	2.50	12.50
E500M3N07	3	0.50	48.0	12.5	3.15	2.50	5	3	2.50	12.50
E500M3N08	3	0.50	48.0	12.5	3.15	2.50	5	3	2.50	12.50
E500M3X.6N01	3	0.60	48.0	12.5	3.15	2.50	5	3	2.40	12.50
E500M3X.6N02	3	0.60	48.0	12.5	3.15	2.50	5	3	2.40	12.50
E500M3X.6N03	3	0.60	48.0	12.5	3.15	2.50	5	3	2.40	12.50
E500M3.5N01	3.5	0.60	50.0	14	3.55	2.80	5	3	2.90	14.00
E500M3.5N02	3.5	0.60	50.0	14	3.55	2.80	5	3	2.90	14.00
E500M3.5N03	3.5	0.60	50.0	14	3.55	2.80	5	3	2.90	14.00
E500M3.5N06	3.5	0.60	50.0	14	3.55	2.80	5	3	2.90	14.00
E500M4N01	4	0.70	53.0	14	4.00	3.15	6	3	3.30	14.00
E500M4N02	4	0.70	53.0	14	4.00	3.15	6	3	3.30	14.00
E500M4N03	4	0.70	53.0	14	4.00	3.15	6	3	3.30	14.00
E500M4N06	4	0.70	53.0	14	4.00	3.15	6	3	3.30	14.00
E500M4N07	4	0.70	53.0	14	4.00	3.15	6	3	3.30	14.00
E500M4N08	4	0.70	53.0	14	4.00	3.15	6	3	3.30	14.00
E500M4X.75N01	4	0.75	53.0	14	4.00	3.15	6	3	3.25	14.00
E500M4X.75N02	4	0.75	53.0	14	4.00	3.15	6	3	3.25	14.00
E500M4X.75N03	4	0.75	53.0	14	4.00	3.15	6	3	3.25	14.00
E500M4.5N01	4.5	0.75	53.0	9.5	4.50	3.55	6	3	3.80	18.00
E500M4.5N02	4.5	0.75	53.0	9.5	4.50	3.55	6	3	3.80	18.00
E500M4.5N03	4.5	0.75	53.0	9.5	4.50	3.55	6	3	3.80	18.00
E500M4.5N06	4.5	0.75	53.0	9.5	4.50	3.55	6	3	3.80	18.00
E500M5N01	5	0.80	58.0	11	5.00	4.00	7	3	4.20	22.00
E500M5N02	5	0.80	58.0	11	5.00	4.00	7	3	4.20	22.00
E500M5N03	5	0.80	58.0	11	5.00	4.00	7	3	4.20	22.00
E500M5N06	5	0.80	58.0	11	5.00	4.00	7	3	4.20	22.00
E500M5N07	5	0.80	58.0	11	5.00	4.00	7	3	4.20	22.00
E500M5N08	5	0.80	58.0	11	5.00	4.00	7	3	4.20	22.00
E500M5X.9N01	5	0.90	58.0	11	5.00	4.00	7	3	4.10	22.00
E500M5X.9N02	5	0.90	58.0	11	5.00	4.00	7	3	4.10	22.00
E500M5X.9N03	5	0.90	58.0	11	5.00	4.00	7	3	4.10	22.00
E500M5.5X.9N01	5.5	0.90	62.0	12	5.60	4.50	7	3	4.60	21.00
E500M5.5X.9N02	5.5	0.90	62.0	12	5.60	4.50	7	3	4.60	21.00
E500M5.5X.9N03	5.5	0.90	62.0	12	5.60	4.50	7	3	4.60	21.00
E500M6N01	6	1.00	66.0	13	6.30	5.00	8	3	5.00	26.00
E500M6N02	6	1.00	66.0	13	6.30	5.00	8	3	5.00	26.00
E500M6N03	6	1.00	66.0	13	6.30	5.00	8	3	5.00	26.00
E500M6N06	6	1.00	66.0	13	6.30	5.00	8	3	5.00	26.00
E500M6N07	6	1.00	66.0	13	6.30	5.00	8	3	5.00	26.00
E500M6N08	6	1.00	66.0	13	6.30	5.00	8	3	5.00	26.00
E500M7N01	7	1.00	66.0	13	7.10	5.60	8	3	6.00	26.00
E500M7N02	7	1.00	66.0	13	7.10	5.60	8	3	6.00	26.00

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E500M7N03	7	1.00	66.0	13	7.10	5.60	8	3	6.00	26.00
E500M7N06	7	1.00	66.0	13	7.10	5.60	8	3	6.00	26.00
E500M8N01	8	1.25	72.0	16	8.00	6.30	9	3	6.80	29.00
E500M8N02	8	1.25	72.0	16	8.00	6.30	9	3	6.80	29.00
E500M8N03	8	1.25	72.0	16	8.00	6.30	9	3	6.80	29.00
E500M8N06	8	1.25	72.0	16	8.00	6.30	9	3	6.80	29.00
E500M8N07	8	1.25	72.0	16	8.00	6.30	9	3	6.80	29.00
E500M8N08	8	1.25	72.0	16	8.00	6.30	9	3	6.80	29.00
E500M9N01	9	1.25	72.0	16	9.00	7.10	10	3	7.80	29.00
E500M9N02	9	1.25	72.0	16	9.00	7.10	10	3	7.80	29.00
E500M9N03	9	1.25	72.0	16	9.00	7.10	10	3	7.80	29.00
E500M9N06	9	1.25	72.0	16	9.00	7.10	10	3	7.80	29.00
E500M10N01	10	1.50	80.0	18	10.00	8.00	11	3	8.50	34.00
E500M10N02	10	1.50	80.0	18	10.00	8.00	11	3	8.50	34.00
E500M10N03	10	1.50	80.0	18	10.00	8.00	11	3	8.50	34.00
E500M10N06	10	1.50	80.0	18	10.00	8.00	11	3	8.50	34.00
E500M10N07	10	1.50	80.0	18	10.00	8.00	11	3	8.50	34.00
E500M10N08	10	1.50	80.0	18	10.00	8.00	11	3	8.50	34.00
E500M11N01	11	1.50	85.0	19	8.00	6.30	9	3	9.50	–
E500M11N02	11	1.50	85.0	19	8.00	6.30	9	3	9.50	–
E500M11N03	11	1.50	85.0	19	8.00	6.30	9	3	9.50	–
E500M11N06	11	1.50	85.0	19	8.00	6.30	9	3	9.50	–
E500M12N01	12	1.75	89.0	22	9.00	7.10	10	3	10.30	–
E500M12N02	12	1.75	89.0	22	9.00	7.10	10	3	10.30	–
E500M12N03	12	1.75	89.0	22	9.00	7.10	10	3	10.30	–
E500M12N06	12	1.75	89.0	22	9.00	7.10	10	3	10.30	–
E500M12N07	12	1.75	89.0	22	9.00	7.10	10	3	10.30	–
E500M12N08	12	1.75	89.0	22	9.00	7.10	10	3	10.30	–
E500M14N01	14	2.00	95.0	24	11.20	9.00	12	4	12.00	–
E500M14N02	14	2.00	95.0	24	11.20	9.00	12	4	12.00	–
E500M14N03	14	2.00	95.0	24	11.20	9.00	12	4	12.00	–
E500M14N06	14	2.00	95.0	24	11.20	9.00	12	4	12.00	–
E500M14N07	14	2.00	95.0	24	11.20	9.00	12	4	12.00	–
E500M14N08	14	2.00	95.0	24	11.20	9.00	12	4	12.00	–
E500M16N01	16	2.00	102.0	24	12.50	10.00	13	4	14.00	–
E500M16N02	16	2.00	102.0	24	12.50	10.00	13	4	14.00	–
E500M16N03	16	2.00	102.0	24	12.50	10.00	13	4	14.00	–
E500M16N06	16	2.00	102.0	24	12.50	10.00	13	4	14.00	–
E500M16N07	16	2.00	102.0	24	12.50	10.00	13	4	14.00	–
E500M16N08	16	2.00	102.0	24	12.50	10.00	13	4	14.00	–
E500M18N01	18	2.50	112.0	29	14.00	11.20	14	4	15.50	–
E500M18N02	18	2.50	112.0	29	14.00	11.20	14	4	15.50	–
E500M18N03	18	2.50	112.0	29	14.00	11.20	14	4	15.50	–
E500M18N06	18	2.50	112.0	29	14.00	11.20	14	4	15.50	–
E500M20N01	20	2.50	112.0	29	14.00	11.20	14	4	17.50	–
E500M20N02	20	2.50	112.0	29	14.00	11.20	14	4	17.50	–
E500M20N03	20	2.50	112.0	29	14.00	11.20	14	4	17.50	–
E500M20N06	20	2.50	112.0	29	14.00	11.20	14	4	17.50	–
E500M20N07	20	2.50	112.0	29	14.00	11.20	14	4	17.50	–
E500M20N08	20	2.50	112.0	29	14.00	11.20	14	4	17.50	–
E500M22N01	22	2.50	118.0	29	16.00	12.50	16	4	19.50	–
E500M22N02	22	2.50	118.0	29	16.00	12.50	16	4	19.50	–
E500M22N03	22	2.50	118.0	29	16.00	12.50	16	4	19.50	–
E500M22N06	22	2.50	118.0	29	16.00	12.50	16	4	19.50	–
E500M24N01	24	3.00	130.0	35	18.00	14.00	18	4	21.00	–
E500M24N02	24	3.00	130.0	35	18.00	14.00	18	4	21.00	–
E500M24N03	24	3.00	130.0	35	18.00	14.00	18	4	21.00	–
E500M24N06	24	3.00	130.0	35	18.00	14.00	18	4	21.00	–
E500M24N07	24	3.00	130.0	35	18.00	14.00	18	4	21.00	–
E500M27N01	27	3.00	135.0	35	20.00	16.00	20	4	24.00	–
E500M27N02	27	3.00	135.0	35	20.00	16.00	20	4	24.00	–
E500M27N03	27	3.00	135.0	35	20.00	16.00	20	4	24.00	–

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E500M30NO1	30	3.50	138.0	41	20.00	16.00	20	4	26.50	–
E500M30NO2	30	3.50	138.0	41	20.00	16.00	20	4	26.50	–
E500M30NO3	30	3.50	138.0	41	20.00	16.00	20	4	26.50	–
E500M33NO1	33	3.50	151.0	41	22.40	18.00	22	4	29.50	–
E500M33NO2	33	3.50	151.0	41	22.40	18.00	22	4	29.50	–
E500M33NO3	33	3.50	151.0	41	22.40	18.00	22	4	29.50	–
E500M36NO1	36	4.00	162.0	47	25.00	20.00	24	4	32.00	–
E500M36NO2	36	4.00	162.0	47	25.00	20.00	24	4	32.00	–
E500M36NO3	36	4.00	162.0	47	25.00	20.00	24	4	32.00	–
E500M39NO1	39	4.00	170.0	47	28.00	22.40	26	4	35.00	–
E500M39NO2	39	4.00	170.0	47	28.00	22.40	26	4	35.00	–
E500M39NO3	39	4.00	170.0	47	28.00	22.40	26	4	35.00	–
E500M42NO1	42	4.50	170.0	53	28.00	22.40	26	6	37.50	–
E500M42NO2	42	4.50	170.0	53	28.00	22.40	26	6	37.50	–
E500M42NO3	42	4.50	170.0	53	28.00	22.40	26	6	37.50	–
E500M45NO1	45	4.50	187.0	54	31.50	25.00	28	6	40.50	–
E500M45NO2	45	4.50	187.0	54	31.50	25.00	28	6	40.50	–
E500M45NO3	45	4.50	187.0	54	31.50	25.00	28	6	40.50	–
E500M48NO1	48	5.00	187.0	60	31.50	25.00	28	6	43.00	–
E500M48NO2	48	5.00	187.0	60	31.50	25.00	28	6	43.00	–
E500M48NO3	48	5.00	187.0	60	31.50	25.00	28	6	43.00	–
E500M52NO3	52	5.00	200.0	60	35.50	28.00	31	6	47.00	–
E500M56NO3	56	5.50	200.0	60	35.50	28.00	31	6	50.50	–

[1] Supplied in 5H tolerance.

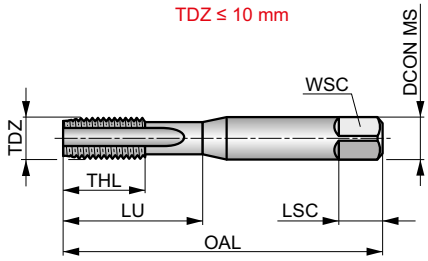
E501

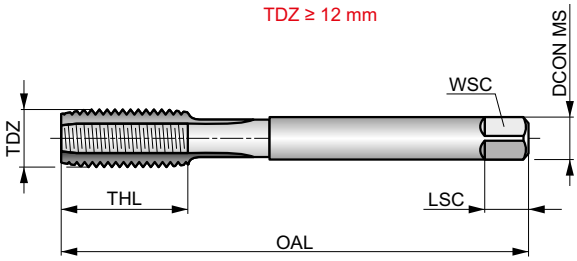
DORMER



HSS Straight Flute Hand Taps, Metric, ISO standard, Left-Handed

A versatile tool, suitable for hand and machine tapping. Available with taper lead N01 for short through holes, plug lead N02 for deeper through holes or bottoming lead N03 for blind holes.





M	ISO 529	6H
	1.5×D	HSS
	L	Bright

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	P4.2	K1.1	K1.2	K1.3	K2.1
■7	■7	■8	■6	■5	◪4	■4	◪4	◪3	◪2	◪12	◪9	◪7	◪12
K2.2	**K3.1**	**K3.2**	**K4.1**	**K4.2**	**K5.1**	**K5.2**	**N1.3**	**N2.1**	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**
◪10	◪11	◪8	◪10	◪8	◪11	◪9	◪8	◪11	◪10	◪7	◪17	◪10	◪5
N4.2	**N4.3**												
◪5	◪3												

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E501M3N01	3	0.50	48.0	12.5	3.15	2.50	5	3	2.50	12.50
E501M3N02	3	0.50	48.0	12.5	3.15	2.50	5	3	2.50	12.50
E501M3N03	3	0.50	48.0	12.5	3.15	2.50	5	3	2.50	12.50
E501M4N01	4	0.70	53.0	14	4.00	3.15	6	3	3.30	14.00
E501M4N02	4	0.70	53.0	14	4.00	3.15	6	3	3.30	14.00
E501M4N03	4	0.70	53.0	14	4.00	3.15	6	3	3.30	14.00
E501M5N02	5	0.80	58.0	11	5.00	4.00	7	3	4.20	22.00
E501M5N03	5	0.80	58.0	11	5.00	4.00	7	3	4.20	22.00
E501M6N01	6	1.00	66.0	13	6.30	5.00	8	3	5.00	26.00
E501M6N02	6	1.00	66.0	13	6.30	5.00	8	3	5.00	26.00
E501M6N03	6	1.00	66.0	13	6.30	5.00	8	3	5.00	26.00
E501M8N01	8	1.25	72.0	16	8.00	6.30	9	3	6.80	29.00
E501M8N02	8	1.25	72.0	16	8.00	6.30	9	3	6.80	29.00
E501M8N03	8	1.25	72.0	16	8.00	6.30	9	3	6.80	29.00
E501M10N01	10	1.50	80.0	18	10.00	8.00	11	3	8.50	34.00
E501M10N02	10	1.50	80.0	18	10.00	8.00	11	3	8.50	34.00
E501M10N03	10	1.50	80.0	18	10.00	8.00	11	3	8.50	34.00
E501M12N01	12	1.75	89.0	22	9.00	7.10	10	3	10.30	–
E501M12N02	12	1.75	89.0	22	9.00	7.10	10	3	10.30	–
E501M12N03	12	1.75	89.0	22	9.00	7.10	10	3	10.30	–
E501M14N01	14	2.00	95.0	24	11.20	9.00	12	4	12.00	–
E501M14N02	14	2.00	95.0	24	11.20	9.00	12	4	12.00	–
E501M14N03	14	2.00	95.0	24	11.20	9.00	12	4	12.00	–
E501M16N01	16	2.00	102.0	24	12.50	10.00	13	4	14.00	–
E501M16N02	16	2.00	102.0	24	12.50	10.00	13	4	14.00	–
E501M16N03	16	2.00	102.0	24	12.50	10.00	13	4	14.00	–
E501M18N03	18	2.50	112.0	29	14.00	11.20	14	4	15.50	–
E501M20N01	20	2.50	112.0	29	14.00	11.20	14	4	17.50	–

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E501M20N02	20	2.50	112.0	29	14.00	11.20	14	4	17.50	–
E501M20N03	20	2.50	112.0	29	14.00	11.20	14	4	17.50	–
E501M22N03	22	2.50	118.0	29	16.00	12.50	16	4	19.50	–
E501M24N02	24	3.00	130.0	35	18.00	14.00	18	4	21.00	–
E501M24N03	24	3.00	130.0	35	18.00	14.00	18	4	21.00	–

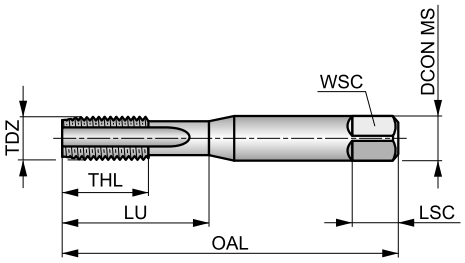
E504

DORMER



HSS Straight Flute Hand Tap with TiN Coating, Metric, ISO Standard

A versatile tool, suitable for machine and also hand tapping, with a straight flute design and bottoming lead for blind and through holes. TiN coated to improve performance and extend tool life.



M	ISO 529	6H
1.5×D		HSS
	R	TiN

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	K1.1	K1.2	K1.3
■ 13	■ 15	■ 15	■ 11	■ 10	◪ 9	■ 9	◪ 7	◪ 6	◪ 5	◪ 4	■ 18	■ 13	■ 10

K2.1	K2.2	K3.1	K3.2	K4.1	K4.2	K5.1	K5.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2
■ 27	■ 22	■ 24	■ 18	■ 22	■ 17	■ 25	■ 19	◪ 16	◪ 22	◪ 19	◪ 14	◪ 34	◪ 20

N3.3	N4.2	N4.3
◪ 10	◪ 10	◪ 6

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E504M3N03	3	0.50	48.0	12.5	3.15	2.50	5	3	2.50	12.50
E504M4N03	4	0.70	53.0	14	4.00	3.15	6	3	3.30	14.00
E504M5N03	5	0.80	58.0	11	5.00	4.00	7	3	4.20	22.00
E504M6N03	6	1.00	66.0	13	6.30	5.00	8	3	5.00	26.00
E504M8N03	8	1.25	72.0	16	8.00	6.30	9	3	6.80	29.00
E504M10N03	10	1.50	80.0	18	10.00	8.00	11	3	8.50	34.00

E303

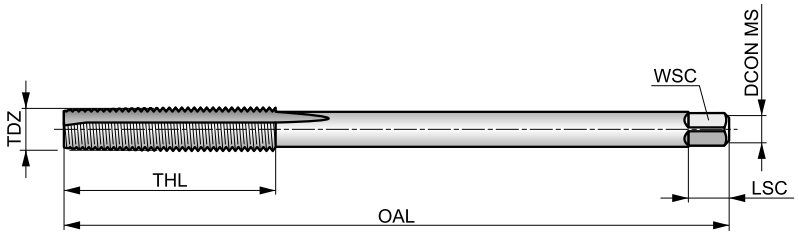
DORMER



HSS-E Straight Flute Nut Taps Metric, DIN Standard

Designed for efficient small production runs in conventional tapping machines, with either extra-long taper lead N01 to reduce torque or with short bottoming lead N03 to reduce cycle times.

M	DIN 357	6H
	2×D	HSS-E
C 2-3 D 18-20		R
Bright		



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	K1.1	K1.2	K1.3	K2.1	K2.2
■9	■10	■10	◪7	◪6	◪5	■6	◪5	◪4	◪11	◪8	◪6	◪11	◪9

K3.1	K3.2	K4.1	K4.2	K5.1	K5.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N4.2
◪10	◪7	◪9	◪7	◪10	◪8	◪7	◪10	◪9	◪6	◪16	◪9	◪5

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]
E303M3N01	3	0.50	70.0	22	2.20	2.10	5	3	2.50
E303M3N03	3	0.50	70.0	22	2.20	2.10	5	3	2.50
E303M4N01	4	0.70	90.0	25	2.80	2.10	5	3	3.30
E303M4N03	4	0.70	90.0	25	2.80	2.10	5	3	3.30
E303M5N01	5	0.80	100.0	28	3.50	2.70	6	3	4.20
E303M5N03	5	0.80	100.0	28	3.50	2.70	6	3	4.20
E303M6N01	6	1.00	110.0	32	4.50	3.40	6	3	5.00
E303M6N03	6	1.00	110.0	32	4.50	3.40	6	3	5.00
E303M8N01	8	1.25	125.0	40	6.00	4.90	8	3	6.80
E303M8N03	8	1.25	125.0	40	6.00	4.90	8	3	6.80
E303M10N01	10	1.50	140.0	45	7.00	5.50	8	3	8.50
E303M10N03	10	1.50	140.0	45	7.00	5.50	8	3	8.50
E303M12N01	12	1.75	180.0	50	9.00	7.00	10	3	10.30
E303M12N03	12	1.75	180.0	50	9.00	7.00	10	3	10.30
E303M14N01	14	2.00	200.0	56	11.00	9.00	12	3	12.00
E303M14N03	14	2.00	200.0	56	11.00	9.00	12	3	12.00
E303M16N01	16	2.00	200.0	63	12.00	9.00	12	3	14.00
E303M16N03	16	2.00	200.0	63	12.00	9.00	12	3	14.00
E303M20N01	20	2.50	250.0	70	16.00	12.00	15	3	17.50
E303M20N03	20	2.50	250.0	70	16.00	12.00	15	3	17.50

E600

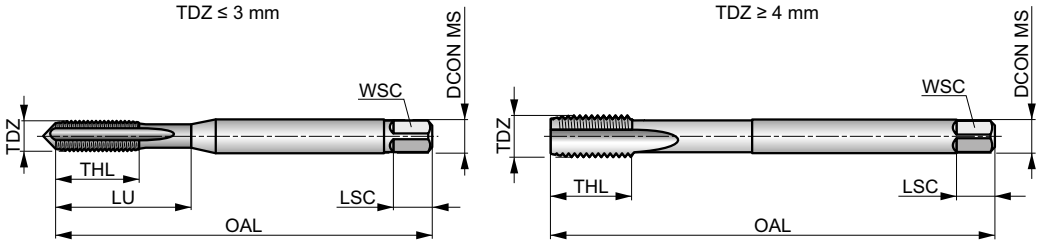
DORMER



HSS-E-PM Straight Flute Long Series Machine Tap, Metric, ISO Standard

General purpose straight flute machine tap with taper lead N01 for short through holes, plug lead N02 for deeper through holes or bottoming lead N03 for blind holes. Bright finish to prevent material from sticking to the cutting edges. Longer design for extra reach when threading difficult to access holes.

M	ISO 2283	6H
	1.5×D	HSS-E PM
C 2-3		R
Bright		



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	K1.1	K1.2	K1.3	K2.1	K2.2
■9	■8	■8	■7	■6	◪5	■6	◪5	◪3	◪12	◪9	◪7	◪12	◪10
K3.1	**K3.2**	**K4.1**	**K4.2**	**K5.1**	**K5.2**	**N1.3**	**N2.1**	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.2**
◪11	◪8	◪10	◪8	◪11	◪9	◪8	◪11	◪10	◪7	◪17	■10	◪5	◪5
N4.3													
◪3													

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E600M3N03	3	0.50	66.0	9	3.15	2.50	5	3	2.50	18.00
E600M4N01	4	0.70	73.0	12	3.15	2.50	5	3	3.30	–
E600M4N02	4	0.70	73.0	12	3.15	2.50	5	3	3.30	–
E600M4N03	4	0.70	73.0	12	3.15	2.50	5	3	3.30	–
E600M5N01	5	0.80	79.0	12	4.00	3.15	6	3	4.20	–
E600M5N02	5	0.80	79.0	12	4.00	3.15	6	3	4.20	–
E600M5N03	5	0.80	79.0	12	4.00	3.15	6	3	4.20	–
E600M6N01	6	1.00	89.0	14	4.50	3.55	6	3	5.00	–
E600M6N02	6	1.00	89.0	14	4.50	3.55	6	3	5.00	–
E600M6N03	6	1.00	89.0	14	4.50	3.55	6	3	5.00	–
E600M8N01	8	1.25	97.0	17	6.30	5.00	8	3	6.80	–
E600M8N02	8	1.25	97.0	17	6.30	5.00	8	3	6.80	–
E600M8N03	8	1.25	97.0	17	6.30	5.00	8	3	6.80	–
E600M10N01	10	1.50	108.0	19	8.00	6.30	9	3	8.50	–
E600M10N02	10	1.50	108.0	19	8.00	6.30	9	3	8.50	–
E600M10N03	10	1.50	108.0	19	8.00	6.30	9	3	8.50	–
E600M12N01	12	1.75	119.0	23	9.00	7.10	10	3	10.30	–
E600M12N02	12	1.75	119.0	23	9.00	7.10	10	3	10.30	–
E600M12N03	12	1.75	119.0	23	9.00	7.10	10	3	10.30	–
E600M16N03	16	2.00	137.0	25	12.50	10.00	13	4	14.00	–
E600M20N03	20	2.50	149.0	30	14.00	11.20	14	4	17.50	–

E610

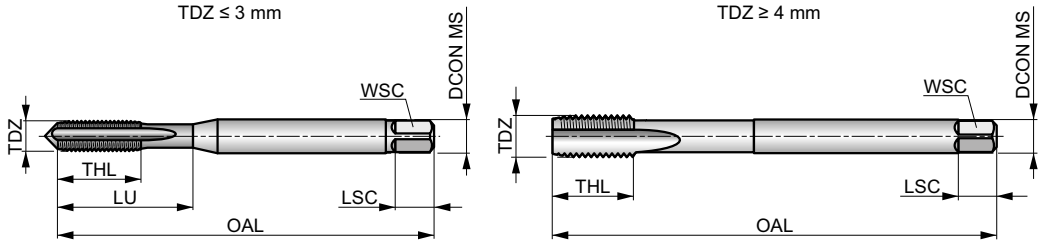
DORMER



HSS-E-PM Straight Flute Long Series Machine tap, Metric, ISO Standard

General purpose straight flute machine tap for through and blind holes. Longer design for extra reach when threading difficult to access holes. TiN coated to allow higher cutting speeds, improve performance and extend tool life.

M	ISO 2283	6H
LU	1.5×D	HSS-E PM
C 2-3		R
TiN		



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	K1.1	K1.2	K1.3
■ 16	■ 18	■ 18	■ 15	■ 13	◪ 11	■ 12	■ 7	◪ 6	■ 5	◪ 4	■ 18	■ 13	■ 10
K2.1	**K2.2**	**K3.1**	**K3.2**	**K4.1**	**K4.2**	**K5.1**	**K5.2**	**N1.3**	**N2.1**	**N2.2**	**N2.3**	**N3.1**	**N3.2**
■ 24	■ 20	■ 22	■ 16	■ 20	■ 16	■ 22	■ 18	◪ 16	◪ 22	◪ 19	◪ 14	◪ 34	■ 20
N3.3	**N4.2**	**N4.3**											
◪ 10	◪ 10	◪ 6											

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E610M3N03	3	0.50	66.0	9	3.15	2.50	5	3	2.50	18.00
E610M4N03	4	0.70	73.0	12	3.15	2.50	5	3	3.30	–
E610M5N03	5	0.80	79.0	12	4.00	3.15	6	3	4.20	–
E610M6N03	6	1.00	89.0	14	4.50	3.55	6	3	5.00	–
E610M8N03	8	1.25	97.0	17	6.30	5.00	8	3	6.80	–
E610M10N03	10	1.50	108.0	19	8.00	6.30	9	3	8.50	–
E610M12N03	12	1.75	119.0	23	9.00	7.10	10	3	10.30	–
E610M16N03	16	2.00	137.0	25	12.50	10.00	13	4	14.00	–

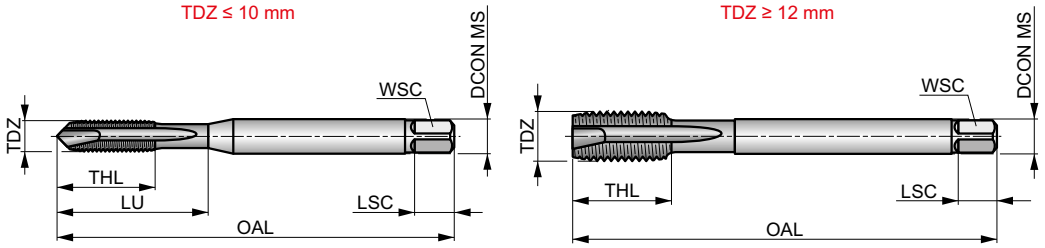
EP006H

DORMER



HSS-E-PM Spiral Point Machine Tap, Metric, DIN Standard

Machine tap to produce normal fit threads within 6H tolerance. The spiral point is suited for through holes only. Bright finish to produce more accurate and cleaner threads preventing the workpiece material from sticking to the cutting edges.



M	DIN 371/376	6H
	2.5×D	HSS-E PM
B 3.5-5		R
Bright		

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	N1.1	N1.2	N1.3	N2.1	N2.2
■ 22	■ 24	■ 25	■ 18	■ 16	◪ 14	■ 13	◪ 10	◪ 8	■ 14	■ 10	■ 7	■ 28	■ 25

N2.3	N3.1	N3.2	N3.3	N4.1
■ 18	■ 44	◪ 27	◪ 13	◪ 22

Products from this series are also available in set with drills. Please see L114 or L001.

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
EP00M2	2	0.40	50.0	6	2.80	2.10	5	2	1.60	9.00
EP00M2.5	2.5	0.45	50.0	8	2.80	2.10	5	2	2.10	12.50
EP00M3	3	0.50	56.0	9	3.50	2.70	6	3	2.50	18.00
EP00M3DIN376	3	0.50	56.0	10	2.20	1.80	4	3	2.50	18.00
EP00M3.5	3.5	0.60	56.0	11	4.00	3.00	6	3	2.90	20.00
EP00M4	4	0.70	63.0	12	4.50	3.40	6	3	3.30	21.00
EP00M4DIN376	4	0.70	63.0	12	2.80	2.10	5	3	3.30	21.00
EP00M4.5	4.5	0.75	70.0	13	6.00	4.90	8	3	3.80	25.00
EP00M5	5	0.80	70.0	13	6.00	4.90	8	3	4.20	25.00
EP00M5DIN376	5	0.80	70.0	13	3.50	2.70	6	3	4.20	25.00
EP00M6	6	1.00	80.0	15	6.00	4.90	8	3	5.00	30.00
EP00M6DIN376	6	1.00	80.0	15	4.50	3.40	6	3	5.00	30.00
EP00M7	7	1.00	80.0	15	7.00	5.50	8	3	6.00	30.00
EP00M8	8	1.25	90.0	18	8.00	6.20	9	3	6.80	35.00
EP00M8DIN376	8	1.25	90.0	18	6.00	4.90	8	3	6.80	35.00
EP00M10	10	1.50	100.0	20	10.00	8.00	11	3	8.50	39.00
EP00M10DIN376	10	1.50	100.0	20	7.00	5.50	8	3	8.50	–
EP00M12	12	1.75	110.0	23	9.00	7.00	10	3	10.30	–
EP00M14	14	2.00	110.0	25	11.00	9.00	12	3	12.00	–
EP00M16	16	2.00	110.0	25	12.00	9.00	12	3	14.00	–
EP00M18	18	2.50	125.0	30	14.00	11.00	14	4	15.50	–
EP00M20	20	2.50	140.0	30	16.00	12.00	15	4	17.50	–
EP00M22	22	2.50	140.0	34	18.00	14.50	17	4	19.50	–
EP00M24	24	3.00	160.0	38	18.00	14.50	17	4	21.00	–
EP00M27	27	3.00	160.0	38	20.00	16.00	19	4	24.00	–
EP00M30	30	3.50	180.0	45	22.00	18.00	21	4	26.50	–

EP006G

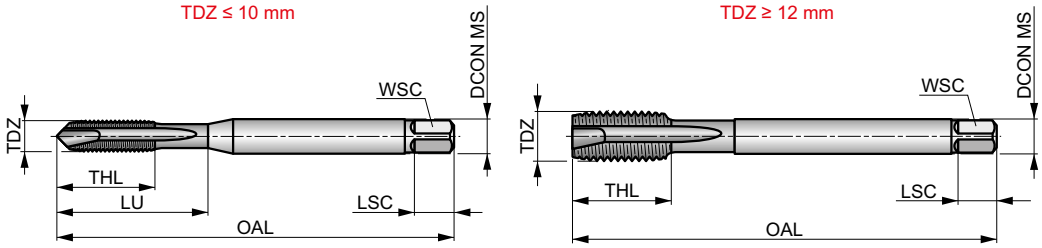
DORMER



HSS-E-PM Spiral Point Machine Tap, Metric, DIN Standard

Machine tap to produce threads within 6G tolerance for a fit with large allowance. The spiral point is suited for through holes only. Bright finish to produce more accurate and cleaner threads preventing the workpiece material from sticking to the cutting edges.

M	DIN 371/376	6G
	2.5×D	HSS-E PM
B 3.5-5		R
Bright		



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	N1.1	N1.2	N1.3	N2.1	N2.2
■ 22	■ 24	■ 25	■ 18	■ 16	◪ 14	■ 13	◪ 10	◪ 8	■ 14	■ 10	■ 7	■ 28	■ 25

N2.3	N3.1	N3.2	N3.3	N4.1
■ 18	■ 44	◪ 27	◪ 13	◪ 22

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
EP006GM3	3	0.50	56.0	9	3.50	2.70	6	3	2.50	18.00
EP006GM4	4	0.70	63.0	12	4.50	3.40	6	3	3.30	21.00
EP006GM5	5	0.80	70.0	13	6.00	4.90	8	3	4.20	25.00
EP006GM6	6	1.00	80.0	15	6.00	4.90	8	3	5.00	30.00
EP006GM8	8	1.25	90.0	18	8.00	6.20	9	3	6.80	35.00
EP006GM10	10	1.50	100.0	20	10.00	8.00	11	3	8.50	39.00
EP006GM12	12	1.75	110.0	23	9.00	7.00	10	3	10.30	–
EP006GM16	16	2.00	110.0	25	12.00	9.00	12	3	14.00	–
EP006GM20	20	2.50	140.0	30	16.00	12.00	15	4	17.50	–

EP00TIN

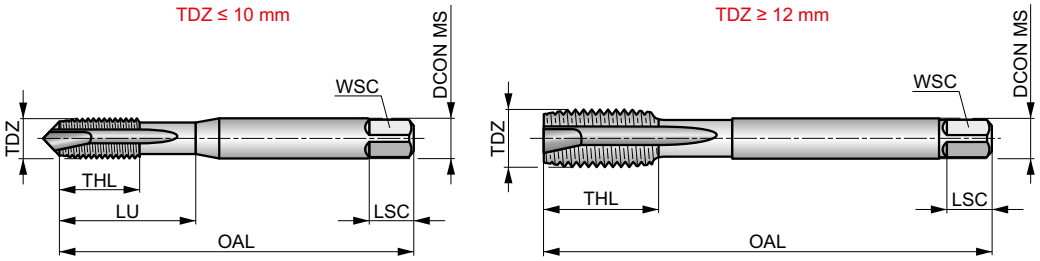
DORMER



HSS-E-PM Spiral Point Machine Tap with TiN Coating, Metric, DIN Standard

High performance machine tap with spiral point for through holes only. Suited for a broad range of workpiece materials. TiN coated to allow higher cutting speeds, improve performance and extend tool life.

M	DIN 371/376	6H
	2.5×D	HSS-E PM
B 3.5-5		R
TiN		



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1
■34	■38	■40	■29	■24	■20	■19	■14	◪12	■10	◪9	■11	■9	■10
M2.2	**M3.1**	**M3.2**	**M3.3**	**M4.1**	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K3.1**	**K3.2**	**K4.1**	**K4.2**
■8	■8	■7	◪6	◪5	◪21	◪16	◪12	◪30	◪24	◪26	◪20	◪24	◪18
K5.1	**K5.2**	**N1.3**	**N2.1**	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N4.1**					
◪28	◪20	■12	■37	■34	■24	◪60	◪36	◪26					

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
EP00TINM3	3	0.50	56.0	9	3.50	2.70	6	3	2.50	18.00
EP00TINM4	4	0.70	63.0	12	4.50	3.40	6	3	3.30	21.00
EP00TINM5	5	0.80	70.0	13	6.00	4.90	8	3	4.20	25.00
EP00TINM6	6	1.00	80.0	15	6.00	4.90	8	3	5.00	30.00
EP00TINM8	8	1.25	90.0	18	8.00	6.20	9	3	6.80	35.00
EP00TINM10	10	1.50	100.0	20	10.00	8.00	11	3	8.50	39.00
EP00TINM12	12	1.75	110.0	23	9.00	7.00	10	3	10.30	–
EP00TINM14	14	2.00	110.0	25	11.00	9.00	12	3	12.00	–
EP00TINM16	16	2.00	110.0	25	12.00	9.00	12	3	14.00	–
EP00TINM18	18	2.50	125.0	30	14.00	11.00	14	4	15.50	–
EP00TINM20	20	2.50	140.0	30	16.00	12.00	15	4	17.50	–
EP00TINM22	22	2.50	140.0	34	18.00	14.50	17	4	19.50	–
EP00TINM24	24	3.00	160.0	38	18.00	14.50	17	4	21.00	–
EP00TINM27	27	3.00	160.0	38	20.00	16.00	19	4	24.00	–
EP00TINM30	30	3.50	180.0	45	22.00	18.00	21	4	26.50	–

EP016H

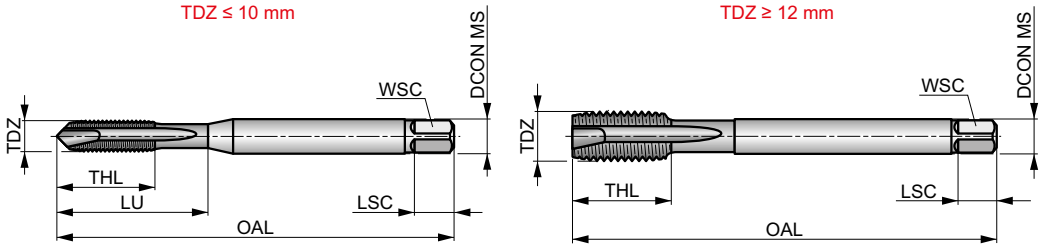
DORMER



HSS-E-PM Spiral Point Machine Tap, Metric, DIN Standard

Machine tap to produce normal fit threads within 6H tolerance. The spiral point is suited for through holes only. Steam tempered surface acts to retain cutting fluid and prevent chip to tool welding.

M	DIN 371/376	6H
	2.5×D	HSS-E PM
B 3.5-5		R
ST		



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P2.2	P2.3	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1	M2.2	M3.1	M3.2	M3.3
◪22	◪16	■14	■10	◪9	■8	◪6	◪10	◪8	◪9	◪7	◪7	◪6	◪5

M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K3.1	K3.2	K4.1	K4.2	K5.1	K5.2
◪4	◪13	◪10	◪7	◪16	◪13	◪14	◪10	◪13	◪9	◪15	◪11

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
EP01M2	2	0.40	50.0	6	2.80	2.10	5	2	1.60	9.00
EP01M2.5	2.5	0.45	50.0	8	2.80	2.10	5	2	2.10	12.50
EP01M3	3	0.50	56.0	9	3.50	2.70	6	3	2.50	18.00
EP01M3DIN376	3	0.50	56.0	10	2.20	1.80	4	3	2.50	18.00
EP01M3.5	3.5	0.60	56.0	11	4.00	3.00	6	3	2.90	20.00
EP01M4	4	0.70	63.0	12	4.50	3.40	6	3	3.30	21.00
EP01M4DIN376	4	0.70	63.0	12	2.80	2.10	5	3	3.30	21.00
EP01M4.5	4.5	0.75	70.0	13	6.00	4.90	8	3	3.80	25.00
EP01M5	5	0.80	70.0	13	6.00	4.90	8	3	4.20	25.00
EP01M5DIN376	5	0.80	70.0	13	3.50	2.70	6	3	4.20	25.00
EP01M6	6	1.00	80.0	15	6.00	4.90	8	3	5.00	30.00
EP01M6DIN376	6	1.00	80.0	15	4.50	3.40	6	3	5.00	30.00
EP01M7	7	1.00	80.0	15	7.00	5.50	8	3	6.00	30.00
EP01M8	8	1.25	90.0	18	8.00	6.20	9	3	6.80	35.00
EP01M8DIN376	8	1.25	90.0	18	6.00	4.90	8	3	6.80	35.00
EP01M10	10	1.50	100.0	20	10.00	8.00	11	3	8.50	39.00
EP01M10DIN376	10	1.50	100.0	20	7.00	5.50	8	3	8.50	–
EP01M12	12	1.75	110.0	23	9.00	7.00	10	3	10.30	–
EP01M14	14	2.00	110.0	25	11.00	9.00	12	3	12.00	–
EP01M16	16	2.00	110.0	25	12.00	9.00	12	3	14.00	–
EP01M18	18	2.50	125.0	30	14.00	11.00	14	4	15.50	–
EP01M20	20	2.50	140.0	30	16.00	12.00	15	4	17.50	–
EP01M22	22	2.50	140.0	34	18.00	14.50	17	4	19.50	–
EP01M24	24	3.00	160.0	38	18.00	14.50	17	4	21.00	–
EP01M27	27	3.00	160.0	38	20.00	16.00	19	4	24.00	–
EP01M30	30	3.50	180.0	45	22.00	18.00	21	4	26.50	–

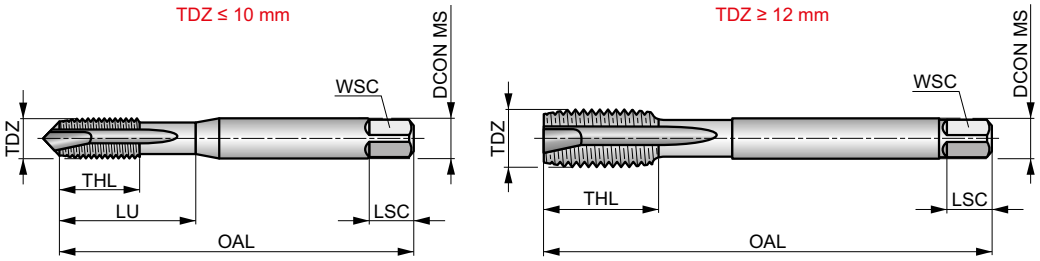
E000

DORMER



HSS-E-PM Spiral Point Machine Tap, Metric, ISO Standard

Machine tap with spiral point suited for through holes only. Bright finish to produce more accurate and cleaner threads preventing the workpiece material from sticking to the cutting edges.



M	ISO 529	6H
	2.5×D	HSS-E PM
B 3.5-5		R
Bright		

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	N1.1	N1.2	N1.3	N2.1	N2.2
■ 22	■ 24	■ 25	■ 18	■ 16	◪ 14	■ 13	◪ 10	◪ 8	■ 14	■ 10	■ 7	■ 28	■ 25

N2.3	N3.1	N3.2	N3.3	N4.1
■ 18	■ 44	◪ 27	◪ 13	◪ 22

Products from this series are also available in set with drills. Please see L113 or L002.

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E000M1.6	1.6	0.35	41.0	7	2.50	2.00	4	2	1.25	7.00
E000M2	2	0.40	41.0	8	2.50	2.00	4	2	1.60	8.00
E000M2.5	2.5	0.45	44.5	9.5	2.80	2.24	5	2	2.05	9.50
E000M3	3	0.50	48.0	15	3.15	2.50	5	3	2.50	15.00
E000M3.5	3.5	0.60	50.0	16	3.55	2.80	5	3	2.90	16.00
E000M4	4	0.70	53.0	17	4.00	3.15	6	3	3.30	17.00
E000M5	5	0.80	58.0	11	5.00	4.00	7	3	4.20	22.00
E000M6	6	1.00	66.0	13	6.30	5.00	8	3	5.00	26.00
E000M8	8	1.25	72.0	16	8.00	6.30	9	3	6.80	29.00
E000M10	10	1.50	80.0	18	10.00	8.00	11	3	8.50	34.00
E000M12	12	1.75	89.0	22	9.00	7.10	10	3	10.30	–
E000M14	14	2.00	95.0	24	11.20	9.00	12	3	12.00	–
E000M16	16	2.00	102.0	24	12.50	10.00	13	3	14.00	–
E000M18	18	2.50	112.0	29	14.00	11.20	14	4	15.50	–
E000M20	20	2.50	112.0	29	14.00	11.20	14	4	17.50	–
E000M22	22	2.50	118.0	29	16.00	12.50	16	4	19.50	–
E000M24	24	3.00	130.0	35	18.00	14.00	18	4	21.00	–

E000TIN

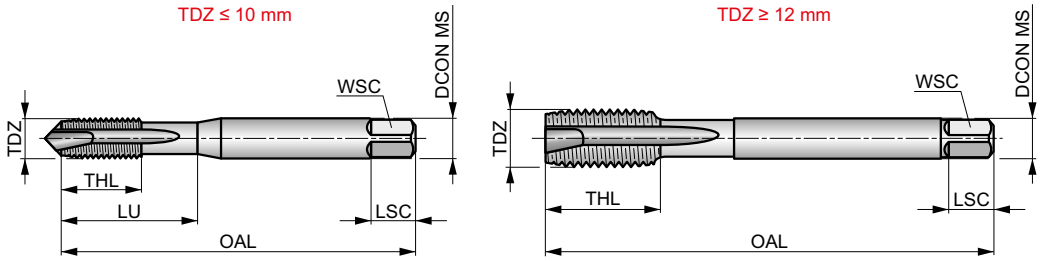
DORMER



HSS-E-PM Spiral Point Machine Tap with TiN Coating, Metric, ISO Standard

High performance machine tap with spiral point for through holes only. Suited for a broad range of workpiece materials. TiN coated to allow higher cutting speeds, improve performance and extend tool life.

M	ISO 529	6H
	2.5×D	HSS-E PM
B 3.5-5		R
TiN		



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1
■34	■38	■40	■29	■24	■20	■19	■14	◪12	■10	◪9	■11	■9	■10
M2.2	**M3.1**	**M3.2**	**M3.3**	**M4.1**	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K3.1**	**K3.2**	**K4.1**	**K4.2**
■8	■8	■7	◪6	◪5	◪21	◪16	◪12	◪30	◪24	◪26	◪20	◪24	◪18
K5.1	**K5.2**	**N1.3**	**N2.1**	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N4.1**					
◪28	◪20	■12	■37	■34	■24	■60	◪36	◪26					

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E000TINM3	3	0.50	48.0	15	3.15	2.50	5	3	2.50	15.00
E000TINM4	4	0.70	53.0	17	4.00	3.15	6	3	3.30	17.00
E000TINM5	5	0.80	58.0	11	5.00	4.00	7	3	4.20	22.00
E000TINM6	6	1.00	66.0	13	6.30	5.00	8	3	5.00	26.00
E000TINM8	8	1.25	72.0	16	8.00	6.30	9	3	6.80	29.00
E000TINM10	10	1.50	80.0	18	10.00	8.00	11	3	8.50	34.00
E000TINM12	12	1.75	89.0	22	9.00	7.10	10	3	10.30	–
E000TINM16	16	2.00	102.0	24	12.50	10.00	13	3	14.00	–
E000TINM20	20	2.50	112.0	29	14.00	11.20	14	4	17.50	–

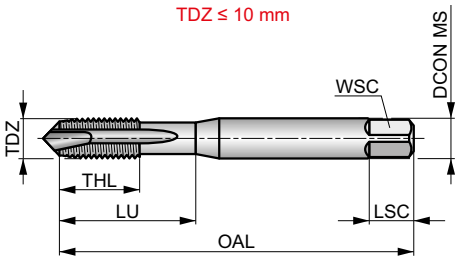
E001

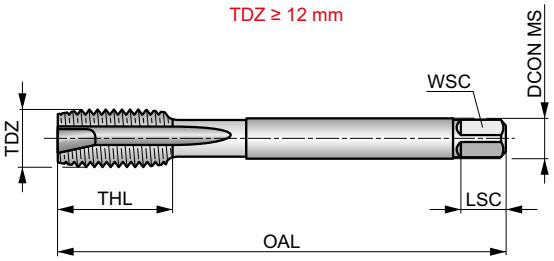
DORMER



HSS-E-PM Spiral Point Machine Tap, Metric, ISO Standard

Machine tap with spiral point suited for through holes only. Steam tempered surface acts to retain cutting fluid and prevent chip to tool welding.





M	ISO 529	6H
2.5×D		HSS-E PM
B 3.5-5		R
ST		

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P2.2	P2.3	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1	M2.2	M3.1	M3.2	M3.3
◪22	◪16	■14	■10	◪9	■8	◪6	◪10	◪8	◪9	◪7	◪7	◪6	◪5

M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K3.1	K3.2	K4.1	K4.2	K5.1	K5.2
◪4	◪13	◪10	◪7	◪16	◪13	◪14	◪10	◪13	◪9	◪15	◪11

Products from this series are also available in set with drills. Please see L113.

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E001M1.6	1.6	0.35	41.0	7	2.50	2.00	4	2	1.25	7.00
E001M2	2	0.40	41.0	8	2.50	2.00	4	2	1.60	8.00
E001M2.5	2.5	0.45	44.5	9.5	2.80	2.24	5	2	2.05	9.50
E001M3	3	0.50	48.0	15	3.15	2.50	5	3	2.50	15.00
E001M3.5	3.5	0.60	50.0	16	3.55	2.80	5	3	2.90	16.00
E001M4	4	0.70	53.0	17	4.00	3.15	6	3	3.30	17.00
E001M5	5	0.80	58.0	11	5.00	4.00	7	3	4.20	22.00
E001M6	6	1.00	66.0	13	6.30	5.00	8	3	5.00	26.00
E001M8	8	1.25	72.0	16	8.00	6.30	9	3	6.80	29.00
E001M10	10	1.50	80.0	18	10.00	8.00	11	3	8.50	34.00
E001M12	12	1.75	89.0	22	9.00	7.10	10	3	10.30	–
E001M14	14	2.00	95.0	24	11.20	9.00	12	3	12.00	–
E001M16	16	2.00	102.0	24	12.50	10.00	13	3	14.00	–
E001M18	18	2.50	112.0	29	14.00	11.20	14	4	15.50	–
E001M20	20	2.50	112.0	29	14.00	11.20	14	4	17.50	–
E001M22	22	2.50	118.0	29	16.00	12.50	16	4	19.50	–
E001M24	24	3.00	130.0	35	18.00	14.00	18	4	21.00	–

E606

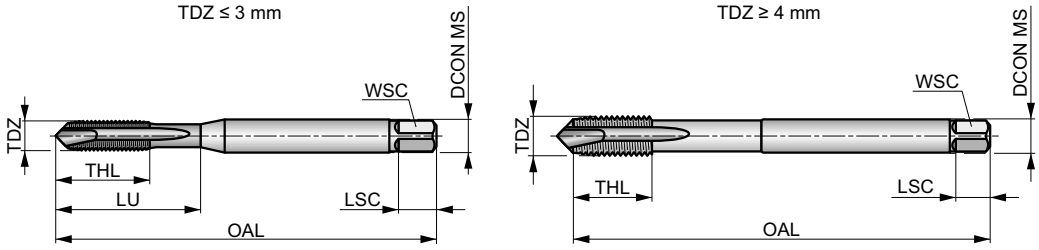
DORMER



HSS-E-PM Spiral Point Long Series Machine Tap, Metric, ISO Standard

Longer design for extra reach when threading difficult to access holes. The spiral point drives the swarf forward ahead of the cutting edges for a safe and reliable process. Suited for through holes only.

M	ISO 2283	6H
	2.5×D	HSS-E PM
B 3.5-5		R
Bright		



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	N1.1	N1.2	N1.3	N2.1	N2.2
■ 12	■ 14	■ 14	■ 11	■ 10	◪ 9	■ 9	◪ 6	◪ 4	◪ 10	◪ 8	◪ 5	◪ 20	◪ 18

N2.3	N3.1	N3.3	N4.1
◪ 13	◪ 33	◪ 10	◪ 20

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E606M3	3	0.50	66.0	9	3.15	2.50	5	3	2.50	18.00
E606M4	4	0.70	73.0	12	3.15	2.50	5	3	3.30	–
E606M5	5	0.80	79.0	12	4.00	3.15	6	3	4.20	–
E606M6	6	1.00	89.0	14	4.50	3.55	6	3	5.00	–
E606M8	8	1.25	97.0	17	6.30	5.00	8	3	6.80	–
E606M10	10	1.50	108.0	19	8.00	6.30	9	3	8.50	–
E606M12	12	1.75	119.0	23	9.00	7.10	10	3	10.30	–
E606M14	14	2.00	127.0	25	11.20	9.00	12	3	12.00	–
E606M16	16	2.00	137.0	25	12.50	10.00	13	3	14.00	–
E606M20	20	2.50	149.0	30	14.00	11.20	14	4	17.50	–
E606M24	24	3.00	172.0	36	18.00	14.00	18	4	21.00	–

E216

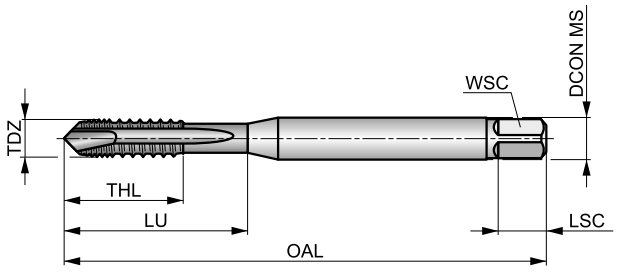
DORMER



HSS-E-PM Spiral Point Interrupted Thread Machine Tap, Metric, DIN Standard

Spiral point machine tap for through holes only. Interrupted threads are designed to lessen the damaging effects of chip wedging on both forward and reverse rotation and reduce friction, permit better lubrication and allow more space for the passage of chips. Reinforced shank increases strength against torsional twist.

M	DIN 371	6H
	3×D	HSS-E PM
B 3.5-5		R
Bright		



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	N1.1	N1.2	N1.3	N2.1	N2.2
■ 21	■ 24	■ 25	■ 18	■ 16	◪ 14	■ 10	◪ 8	◪ 6	■ 16	■ 12	◪ 8	◪ 25	◪ 22

N2.3	N3.1	N3.2	N3.3	N4.1
◪ 16	■ 51	◪ 26	■ 15	◪ 25

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E216M3	3	0.50	56.0	9	3.50	2.70	6	3	2.50	18.00
E216M4	4	0.70	63.0	12	4.50	3.40	6	3	3.30	21.00
E216M5	5	0.80	70.0	13	6.00	4.90	8	3	4.20	25.00
E216M6	6	1.00	80.0	15	6.00	4.90	8	3	5.00	30.00
E216M8	8	1.25	90.0	18	8.00	6.20	9	3	6.80	35.00
E216M10	10	1.50	100.0	20	10.00	8.00	11	3	8.50	39.00

E266

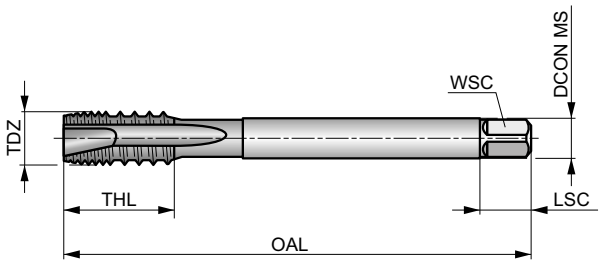
DORMER



HSS-E-PM Spiral Point Interrupted Thread Machine Tap, Metric, DIN Standard

Spiral point machine tap for through holes only. Interrupted threads to lessen the damaging effects of chip wedging on both forward and reverse rotation and reduce friction, permit better lubrication and allow more space for the passage of chips. The reduced shank increases the reach of the tap.

M	DIN 376	6H
	3×D	HSS-E PM
B 3.5-5		R
Bright		



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	N1.1	N1.2	N1.3	N2.1	N2.2
■21	■24	■25	■18	■16	◪14	■10	◪8	◪6	■16	■12	◪8	◪25	◪22

N2.3	N3.1	N3.2	N3.3	N4.1
◪16	■51	◪30	■15	◪25

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]
E266M12	12	1.75	110.0	23	9.00	7.00	10	3	10.30
E266M14	14	2.00	110.0	25	11.00	9.00	12	3	12.00
E266M16	16	2.00	110.0	25	12.00	9.00	12	3	14.00
E266M20	20	2.50	140.0	30	16.00	12.00	15	3	17.50
E266M24	24	3.00	160.0	38	18.00	14.50	17	4	21.00

E422

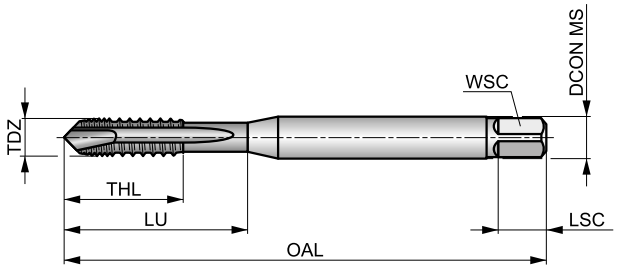
DORMER



HSS-E-PM Spiral Point Interrupted Thread Machine Tap, Metric, DIN Standard

High performance spiral point tap for through holes only. Interrupted threads to lessen the damaging effects of chip wedging, reduce friction, permit better lubrication and allow more space for the passage of chips. The reinforced shank increases the strength and TiN coating enables higher cutting speeds and performance.

M	DIN 371	6H
	3×D	HSS-E PM
B 3.5-5		R
TiN		



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	N1.1	N1.2	N1.3	N2.1	N2.2
■ 37	■ 42	■ 43	■ 32	■ 28	◪ 25	■ 15	◪ 12	◪ 9	■ 25	■ 19	◪ 13	◪ 46	◪ 42

N2.3	N3.1	N3.2	N3.3	N4.1
◪ 30	■ 76	◪ 45	■ 23	◪ 30

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E422M3	3	0.50	56.0	9	3.50	2.70	6	3	2.50	18.00
E422M4	4	0.70	63.0	12	4.50	3.40	6	3	3.30	21.00
E422M5	5	0.80	70.0	13	6.00	4.90	8	3	4.20	25.00
E422M6	6	1.00	80.0	15	6.00	4.90	8	3	5.00	30.00
E422M8	8	1.25	90.0	18	8.00	6.20	9	3	6.80	35.00
E422M10	10	1.50	100.0	20	10.00	8.00	11	3	8.50	39.00

E423

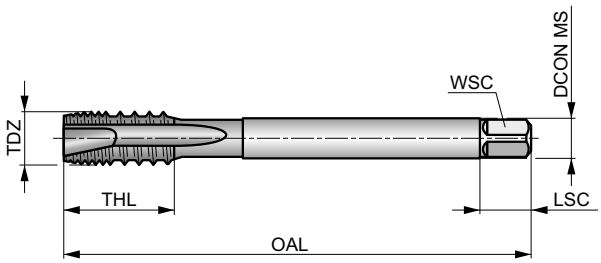
DORMER



HSS-E-PM Spiral Point Interrupted Thread Machine Tap, Metric, DIN Standard

High performance spiral point tap for through holes only. Interrupted threads to lessen the damaging effects of chip wedging, reduce friction, permit better lubrication and allow more space for the passage of chips. The reduced shank increases the reach and TiN coating enables higher cutting speeds and performance.

M	DIN 376	6H
	3×D	HSS-E PM
B 3.5-5		R
TiN		



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	N1.1	N1.2	N1.3	N2.1	N2.2
■37	■42	■43	■32	■28	◪25	■15	◪12	◪9	■25	■19	◪13	◪46	◪42

N2.3	N3.1	N3.2	N3.3	N4.1
◪30	■76	◪45	■23	◪30

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]
E423M12	12	1.75	110.0	23	9.00	7.00	10	3	10.30
E423M14	14	2.00	110.0	25	11.00	9.00	12	3	12.00
E423M16	16	2.00	110.0	25	12.00	9.00	12	3	14.00
E423M20	20	2.50	140.0	30	16.00	12.00	15	3	17.50
E423M24	24	3.00	160.0	38	18.00	14.50	17	4	21.00

E207

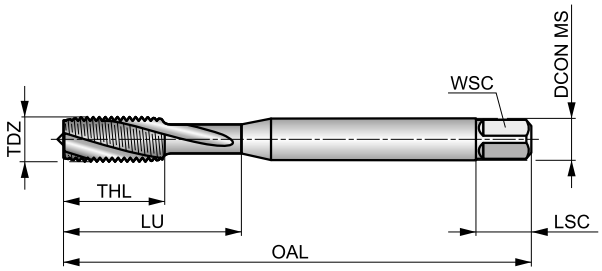
DORMER



HSS-E-PM 15° Spiral Flute Machine Tap, Metric, DIN Standard

Slow spiral flute tap for up to 1.5xD deep blind holes. With 15° helix for more stability threading in harder and higher strength steels. The reinforced shank increases strength against torsional twist.

M	DIN 371	6H
	1.5×D	HSS-E PM
C 2-3		λ 15°
R	Bright	



Workpiece material group suitability and starting values for cutting speed (m/min).

P2.2	P2.3	P3.1	P3.2	P4.1	N1.3	N2.1	N2.2	N2.3
■ 16	◪ 14	■ 10	■ 8	■ 6	◪ 6	◪ 23	◪ 21	◪ 15

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E207M2	2	0.40	45.0	4	2.80	2.10	5	3	1.60	9.00
E207M2.5	2.5	0.45	50.0	4	2.80	2.10	5	3	2.05	12.50
E207M3	3	0.50	56.0	9	3.50	2.70	6	3	2.50	18.00
E207M4	4	0.70	63.0	12	4.50	3.40	6	3	3.30	21.00
E207M5	5	0.80	70.0	13	6.00	4.90	8	3	4.20	25.00
E207M6	6	1.00	80.0	15	6.00	4.90	8	3	5.00	30.00
E207M8	8	1.25	90.0	18	8.00	6.20	9	3	6.80	35.00
E207M10	10	1.50	100.0	20	10.00	8.00	11	3	8.50	39.00

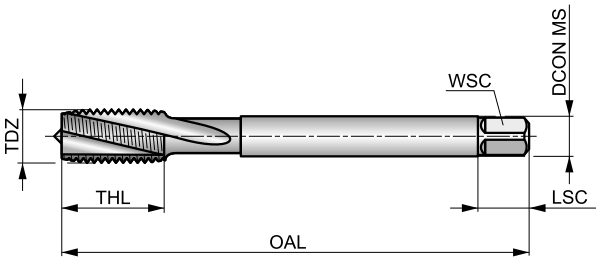
E258



HSS-E-PM 15° Spiral Flute Machine Tap, Metric, DIN Standard

Slow spiral flute tap for up to 1.5xD deep blind holes. With 15° helix for more stability threading in harder and higher strength steels. The reduced shank increases the reach of the tap.

M	DIN 376	6H
	1.5×D	HSS-E PM
C 2-3		λ 15°
R	Bright	



Workpiece material group suitability and starting values for cutting speed (m/min).

P2.2	P2.3	P3.1	P3.2	P4.1	N1.3	N2.1	N2.2	N2.3
■16	◪14	■10	■8	■6	◪6	◪23	◪21	◪15

Product	TDZ	TP [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	LSC [mm]	NOF	PHD [mm]
E258M4	4	0.70	63.0	12	2.80	2.10	5	3	3.30
E258M5	5	0.80	70.0	13	3.50	2.70	6	3	4.20
E258M6	6	1.00	80.0	15	4.50	3.40	6	3	5.00
E258M8	8	1.25	90.0	18	6.00	4.90	8	3	6.80
E258M10	10	1.50	100.0	20	7.00	5.50	8	3	8.50
E258M12	12	1.75	110.0	23	9.00	7.00	10	3	10.30
E258M14	14	2.00	110.0	25	11.00	9.00	12	3	12.00
E258M16	16	2.00	110.0	25	12.00	9.00	12	3	14.00
E258M18	18	2.50	125.0	30	14.00	11.00	14	3	15.50
E258M20	20	2.50	140.0	30	16.00	12.00	15	3	17.50
E258M22	22	2.50	140.0	34	18.00	14.50	17	4	19.50
E258M24	24	3.00	160.0	38	18.00	14.50	17	4	21.00
E258M27	27	3.00	160.0	38	20.00	16.00	19	4	24.00
E258M30	30	3.50	180.0	45	22.00	18.00	21	4	26.50
E258M36	36	4.00	200.0	55	28.00	22.00	25	4	32.00

E212

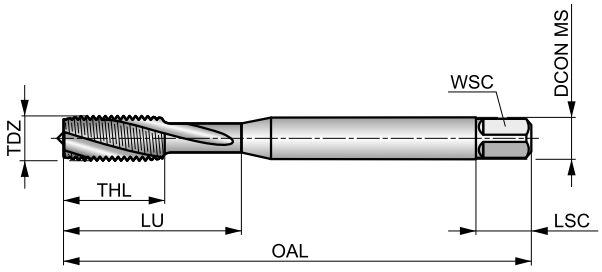
DORMER



HSS-E-PM 15° Spiral Flute Machine Tap, Metric, DIN Standard

High performance slow spiral flute tap for up to 1.5xD deep holes. With 15° helix for more stability threading of harder and higher strength steels. The reinforced shank increases strength against torsional twist. TiN coated to allow higher cutting speeds, improve performance and extend tool life.

M	DIN 371	6H
	1.5×D	HSS-E PM
C 2-3		λ 15°
R	TiN	



Workpiece material group suitability and starting values for cutting speed (m/min).

P2.2	P2.3	P3.1	P3.2	P4.1	N1.3	N2.1	N2.2	N2.3
■ 28	◪ 25	■ 15	■ 12	■ 9	◪ 8	◪ 31	◪ 28	◪ 20

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E212M3	3	0.50	56.0	9	3.50	2.70	6	3	2.50	18.00
E212M4	4	0.70	63.0	12	4.50	3.40	6	3	3.30	21.00
E212M5	5	0.80	70.0	13	6.00	4.90	8	3	4.20	25.00
E212M6	6	1.00	80.0	15	6.00	4.90	8	3	5.00	30.00
E212M8	8	1.25	90.0	18	8.00	6.20	9	3	6.80	35.00
E212M10	10	1.50	100.0	20	10.00	8.00	11	3	8.50	39.00

E263

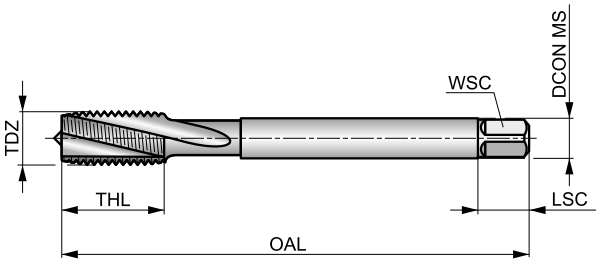
DORMER



HSS-E-PM 15° Spiral Flute Machine Tap, Metric, DIN Standard

High performance slow spiral flute tap for up to 1.5xD deep holes. With 15° helix for more stability threading of harder and higher strength steels. The reduced shank increases the reach of the tap. TiN coated to allow higher cutting speeds, improve performance and extend tool life.

M	DIN 376	6H
1.5×D		HSS-E PM
C 2-3		λ 15°
R	TiN	



Workpiece material group suitability and starting values for cutting speed (m/min).

P2.2	P2.3	P3.1	P3.2	P4.1	N1.3	N2.1	N2.2	N2.3
■ 28	◪ 25	■ 15	■ 12	■ 9	◪ 8	◪ 31	◪ 28	◪ 20

Product	TDZ	TP [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	LSC [mm]	NOF	PHD [mm]
E263M12	12	1.75	110.0	23	9.00	7.00	10	3	10.30
E263M14	14	2.00	110.0	25	11.00	9.00	12	3	12.00
E263M16	16	2.00	110.0	25	12.00	9.00	12	3	14.00
E263M18	18	2.50	125.0	30	14.00	11.00	14	3	15.50
E263M20	20	2.50	140.0	30	16.00	12.00	15	3	17.50
E263M22	22	2.50	140.0	34	18.00	14.50	17	4	19.50
E263M24	24	3.00	160.0	38	18.00	14.50	17	4	21.00
E263M27	27	3.00	160.0	38	20.00	16.00	19	4	24.00
E263M30	30	3.50	180.0	45	22.00	18.00	21	4	26.50
E263M36	36	4.00	200.0	55	28.00	22.00	25	4	32.00

EX006H

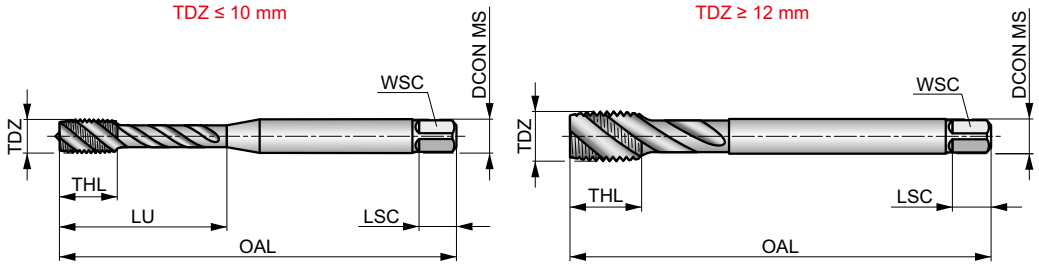
DORMER



HSS-E-PM 45° Spiral Flute Tap, Metric, DIN Standard

Machine tap to produce normal fit threads within 6H tolerance. The spiral flute is suited for blind holes. Bright finish to produce more accurate and cleaner threads preventing the workpiece material from sticking to the cutting edges.

M	DIN 371/376	6H
	2.5×D	HSS-E PM
C 2-3		λ 45°
R	Bright	



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3
■21	■23	■24	■17	■15	◪13	■12	◪9	◪7	■13	■9	■6	■27	■24	■17

Products from this series are also available in set with drills. Please see L114 or L001.

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
EX00M2 [1]	2	0.40	45.0	4	2.80	2.10	5	3	1.60	9.00
EX00M2.5 [1]	2.5	0.45	50.0	4	2.80	2.10	5	3	2.05	12.50
EX00M3	3	0.50	56.0	6	3.50	2.70	6	3	2.50	18.00
EX00M3.5	3.5	0.60	56.0	7	4.00	3.00	6	3	2.90	20.00
EX00M4	4	0.70	63.0	7	4.50	3.40	6	3	3.30	21.00
EX00M5	5	0.80	70.0	8	6.00	4.90	8	3	4.20	25.00
EX00M6	6	1.00	80.0	10	6.00	4.90	8	3	5.00	31.00
EX00M6DIN376	6	1.00	80.0	10	4.50	3.40	6	3	5.00	31.00
EX00M7	7	1.00	80.0	10	7.00	5.50	8	3	6.00	31.00
EX00M8	8	1.25	90.0	12	8.00	6.20	9	3	6.80	35.00
EX00M8DIN376	8	1.25	90.0	13	6.00	4.90	8	3	6.80	35.00
EX00M10	10	1.50	100.0	15	10.00	8.00	11	3	8.50	39.00
EX00M10DIN376	10	1.50	100.0	15	7.00	5.50	8	3	8.50	39.00
EX00M12	12	1.75	110.0	16	9.00	7.00	10	3	10.30	–
EX00M14	14	2.00	110.0	20	11.00	9.00	12	3	12.00	–
EX00M16	16	2.00	110.0	20	12.00	9.00	12	4	14.00	–
EX00M18	18	2.50	125.0	25	14.00	11.00	14	4	15.50	–
EX00M20	20	2.50	140.0	25	16.00	12.00	15	4	17.50	–
EX00M22	22	2.50	140.0	25	18.00	14.50	17	4	19.50	–
EX00M24	24	3.00	160.0	30	18.00	14.50	17	4	21.00	–
EX00M27	27	3.00	160.0	30	20.00	16.00	19	4	24.00	–
EX00M30	30	3.50	180.0	36	22.00	18.00	21	4	26.50	–
EX00M33	33	3.50	180.0	36	25.00	20.00	23	4	29.50	–
EX00M36	36	4.00	200.0	40	28.00	22.00	25	4	32.00	–
EX00M39	39	4.00	200.0	40	32.00	24.00	27	4	35.00	–
EX00M42 [1]	42	4.50	200.0	45	32.00	24.00	27	4	37.50	–
EX00M48 [1]	48	5.00	250.0	50	36.00	29.00	32	4	43.00	–
EX00M52 [1]	52	5.00	250.0	50	40.00	32.00	35	5	47.00	–
EX00M56 [1]	56	5.50	250.0	55	40.00	32.00	35	5	50.50	–
EX00M64 [1]	64	6.00	315.0	60	50.00	39.00	42	6	58.00	–

[1] HSS-E.

EX006G

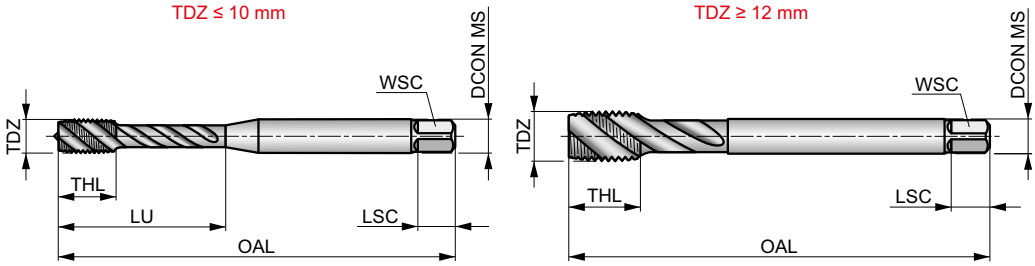
DORMER



HSS-E-PM 45° Spiral Flute Tap, Metric, DIN Standard

Machine tap to produce threads within 6G tolerance for a fit with large allowance. The spiral flute is suited for blind holes. Bright finish to produce more accurate and cleaner threads preventing the workpiece material from sticking to the cutting edges.

M	DIN 371/376	6G
	2.5×D	HSS-E PM
C 2-3		λ 45°
R	Bright	



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3
■21	■23	■24	■17	■15	◪13	■12	◪9	◪7	■13	■9	■6	■27	■24	■17

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
EX00M36G	3	0.50	56.0	6	3.50	2.70	6	3	2.50	18.00
EX00M46G	4	0.70	63.0	7	4.50	3.40	6	3	3.30	21.00
EX00M56G	5	0.80	70.0	8	6.00	4.90	8	3	4.20	25.00
EX00M66G	6	1.00	80.0	10	6.00	4.90	8	3	5.00	31.00
EX00M86G	8	1.25	90.0	12	8.00	6.20	9	3	6.80	35.00
EX00M106G	10	1.50	100.0	15	10.00	8.00	11	3	8.50	39.00
EX00M126G	12	1.75	110.0	16	9.00	7.00	10	3	10.30	–
EX00M146G	14	2.00	110.0	20	11.00	9.00	12	3	12.00	–
EX00M166G	16	2.00	110.0	20	12.00	9.00	12	4	14.00	–
EX00M206G	20	2.50	140.0	25	16.00	12.00	15	4	17.50	–

EX00TIN

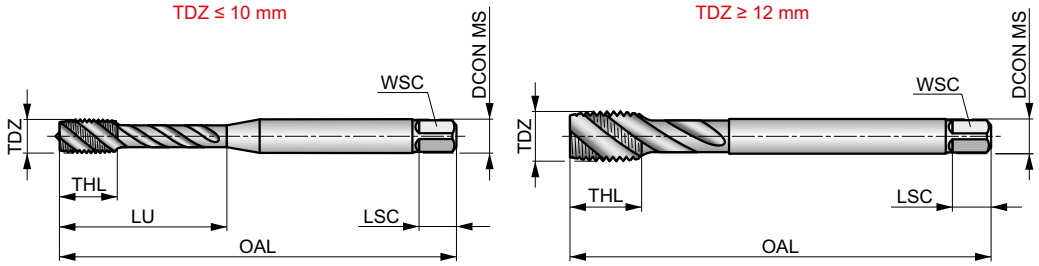
DORMER



HSS-E-PM 45° Spiral Flute Machine Tap, Metric, DIN Standard

High performance machine tap with spiral flute for blind holes. Suited for a broad range of workpiece materials. TiN coated to allow higher cutting speeds, improve performance and extend tool life.

M	DIN 371/376	6H
	2.5×D	HSS-E PM
C 2-3		λ 45°
R	TiN	



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1
■32	■36	■37	■27	■23	■19	■18	■13	◪11	■10	◪8	■10	■8	■9

M2.2	M3.1	M3.2	M3.3	M4.1	N2.1	N2.2	N2.3
■7	■7	■6	◪5	◪4	■35	■32	■23

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
EX00TINM3	3	0.50	56.0	6	3.50	2.70	6	3	2.50	18.00
EX00TINM4	4	0.70	63.0	7	4.50	3.40	6	3	3.30	21.00
EX00TINM5	5	0.80	70.0	8	6.00	4.90	8	3	4.20	25.00
EX00TINM6	6	1.00	80.0	10	6.00	4.90	8	3	5.00	31.00
EX00TINM8	8	1.25	90.0	12	8.00	6.20	9	3	6.80	35.00
EX00TINM10	10	1.50	100.0	15	10.00	8.00	11	3	8.50	39.00
EX00TINM12	12	1.75	110.0	16	9.00	7.00	10	3	10.30	–
EX00TINM14	14	2.00	110.0	20	11.00	9.00	12	3	12.00	–
EX00TINM16	16	2.00	110.0	20	12.00	9.00	12	4	14.00	–
EX00TINM18	18	2.50	125.0	25	14.00	11.00	14	4	15.50	–
EX00TINM20	20	2.50	140.0	25	16.00	12.00	15	4	17.50	–
EX00TINM22	22	2.50	140.0	25	18.00	14.50	17	4	19.50	–
EX00TINM24	24	3.00	160.0	30	18.00	14.50	17	4	21.00	–
EX00TINM27	27	3.00	160.0	30	20.00	16.00	19	4	24.00	–
EX00TINM30	30	3.50	180.0	36	22.00	18.00	21	4	26.50	–

EX016H

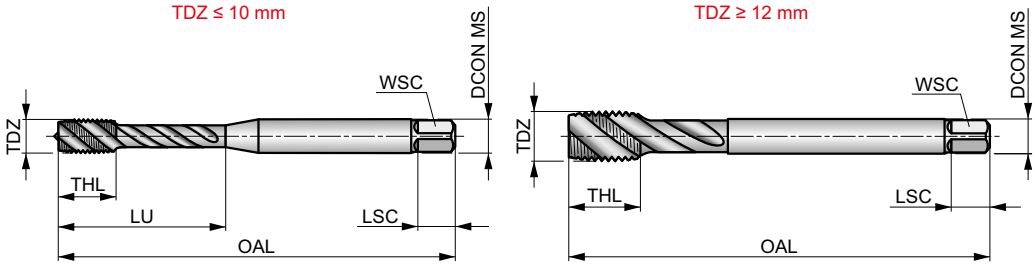
DORMER



HSS-E-PM 45° Spiral Flute Machine Tap, Metric, DIN Standard

Machine tap to produce normal fit threads within 6H tolerance. The spiral flute is suited for blind holes. Steam tempered surface acts to retain cutting fluid and prevent chip to tool welding.

M	DIN 371/376	6H
	2.5×D	HSS-E PM
C 2-3		λ 45°
R	ST	



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P2.2	P2.3	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1	M2.2	M3.1	M3.2	M3.3	M4.1
◪21	◪15	■13	■9	◪8	■7	◪5	◪8	◪6	◪7	◪5	◪5	◪4	◪3	◪3

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
EX01M2 [1]	2	0.40	45.0	4	2.80	2.10	5	3	1.60	9.00
EX01M2.5 [1]	2.5	0.45	50.0	4	2.80	2.10	5	3	2.05	12.50
EX01M3	3	0.50	56.0	6	3.50	2.70	6	3	2.50	18.00
EX01M3.5	3.5	0.60	56.0	7	4.00	3.00	6	3	2.90	20.00
EX01M4	4	0.70	63.0	7	4.50	3.40	6	3	3.30	21.00
EX01M5	5	0.80	70.0	8	6.00	4.90	8	3	4.20	25.00
EX01M6	6	1.00	80.0	10	6.00	4.90	8	3	5.00	31.00
EX01M6DIN376	6	1.00	80.0	10	4.50	3.40	6	3	5.00	31.00
EX01M7	7	1.00	80.0	10	7.00	5.50	8	3	6.00	31.00
EX01M8	8	1.25	90.0	12	8.00	6.20	9	3	6.80	35.00
EX01M8DIN376	8	1.25	90.0	13	6.00	4.90	8	3	6.80	35.00
EX01M10	10	1.50	100.0	15	10.00	8.00	11	3	8.50	39.00
EX01M10DIN376	10	1.50	100.0	15	7.00	5.50	8	3	8.50	39.00
EX01M12	12	1.75	110.0	16	9.00	7.00	10	3	10.30	–
EX01M14	14	2.00	110.0	20	11.00	9.00	12	3	12.00	–
EX01M16	16	2.00	110.0	20	12.00	9.00	12	4	14.00	–
EX01M18	18	2.50	125.0	25	14.00	11.00	14	4	15.50	–
EX01M20	20	2.50	140.0	25	16.00	12.00	15	4	17.50	–
EX01M22	22	2.50	140.0	25	18.00	14.50	17	4	19.50	–
EX01M24	24	3.00	160.0	30	18.00	14.50	17	4	21.00	–
EX01M27	27	3.00	160.0	30	20.00	16.00	19	4	24.00	–
EX01M30	30	3.50	180.0	36	22.00	18.00	21	4	26.50	–
EX01M33	33	3.50	180.0	36	25.00	20.00	23	4	29.50	–
EX01M36	36	4.00	200.0	40	28.00	22.00	25	4	32.00	–
EX01M39	39	4.00	200.0	40	32.00	24.00	27	4	35.00	–
EX01M42 [1]	42	4.50	200.0	45	32.00	24.00	27	4	37.50	–
EX01M48 [1]	48	5.00	250.0	50	36.00	29.00	32	4	43.00	–
EX01M52 [1]	52	5.00	250.0	50	40.00	32.00	35	5	47.00	–
EX01M56 [1]	56	5.50	250.0	55	40.00	32.00	35	5	50.50	–
EX01M64 [1]	64	6.00	315.0	60	50.00	39.00	42	6	58.00	–

[1] HSS-E.

E002

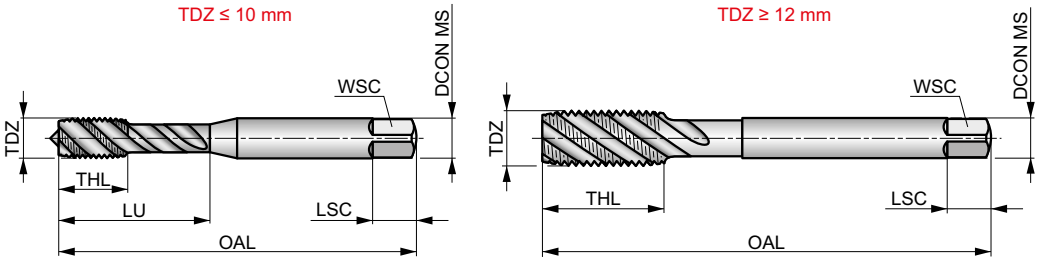
DORMER



HSS-E-PM 45° Spiral Flute Machine Tap, Metric, ISO Standard

Machine tap with spiral flute suited for blind holes. Bright finish to produce more accurate and cleaner threads preventing the workpiece material from sticking to the cutting edges.

M	ISO 529	6H
2.5×D		HSS-E PM
C 2-3		λ 45°
R	Bright	



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3
■21	■23	■24	■17	■15	◪13	■12	◪9	◪7	■13	■9	■6	■27	■24	■17

Products from this series are also available in set with drills. Please see L113 or L002.

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E002M2 [1]	2	0.40	41.0	8	2.50	2.00	4	2	1.60	8.00
E002M2.5 [1]	2.5	0.45	44.5	9.5	2.80	2.24	5	2	2.05	9.50
E002M3	3	0.50	48.0	6	3.15	2.50	5	3	2.50	12.50
E002M4	4	0.70	53.0	7	4.00	3.15	6	3	3.30	19.00
E002M5	5	0.80	58.0	8	5.00	4.00	7	3	4.20	22.00
E002M6	6	1.00	66.0	10	6.30	5.00	8	3	5.00	27.00
E002M8	8	1.25	72.0	12	8.00	6.30	9	3	6.80	31.00
E002M10	10	1.50	80.0	15	10.00	8.00	11	3	8.50	35.00
E002M12	12	1.75	89.0	16	9.00	7.10	10	3	10.30	–
E002M14	14	2.00	95.0	18	11.20	9.00	12	3	12.00	–
E002M16	16	2.00	102.0	18	12.50	10.00	13	4	14.00	–
E002M18	18	2.50	112.0	29	14.00	11.20	14	4	15.50	–
E002M20	20	2.50	112.0	29	14.00	11.20	14	4	17.50	–
E002M22	22	2.50	118.0	29	16.00	12.50	16	4	19.50	–
E002M24	24	3.00	130.0	35	18.00	14.00	18	4	21.00	–

[1] HSS-E.

E002TIN

DORMER

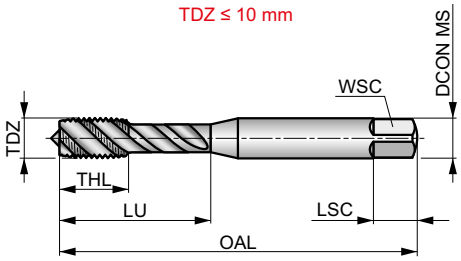


HSS-E-PM 45° Spiral Flute Machine Tap, Metric, ISO Standard

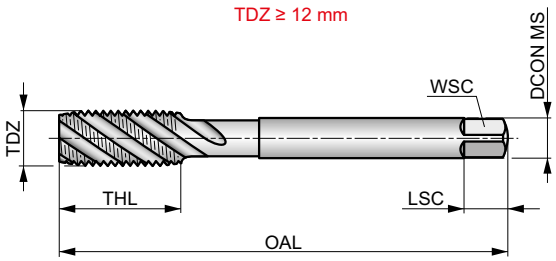
High performance machine tap with spiral flute for blind holes. Suited for a broad range of workpiece materials. TiN coated to allow higher cutting speeds, improve performance and extend tool life.

M	ISO 529	6H
	2.5×D	HSS-E PM
C 2-3		λ 45°
R	TiN	

TDZ ≤ 10 mm



TDZ ≥ 12 mm



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1
■32	■36	■37	■27	■23	■19	■18	■13	◪11	■10	◪8	■10	■8	■9

M2.2	M3.1	M3.2	M3.3	M4.1	N2.1	N2.2	N2.3
■7	■7	■6	◪5	◪4	■35	■32	■23

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E002TINM3	3	0.50	48.0	6	3.15	2.50	5	3	2.50	12.50
E002TINM4	4	0.70	53.0	7	4.00	3.15	6	3	3.30	19.00
E002TINM5	5	0.80	58.0	8	5.00	4.00	7	3	4.20	22.00
E002TINM6	6	1.00	66.0	10	6.30	5.00	8	3	5.00	27.00
E002TINM8	8	1.25	72.0	12	8.00	6.30	9	3	6.80	31.00
E002TINM10	10	1.50	80.0	15	10.00	8.00	11	3	8.50	35.00
E002TINM12	12	1.75	89.0	16	9.00	7.10	10	3	10.30	–
E002TINM16	16	2.00	102.0	18	12.50	10.00	13	4	14.00	–
E002TINM20	20	2.50	112.0	29	14.00	11.20	14	4	17.50	–

E003

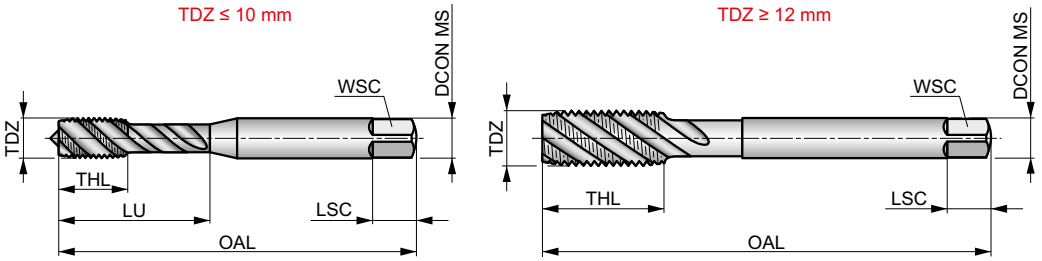
DORMER



HSS-E-PM 45° Spiral Flute Machine Tap, Metric, ISO Standard

Machine tap with spiral flute suited for blind holes. Steam tempered surface acts to retain cutting fluid and prevent chip to tool welding.

M	ISO 529	6H
	2.5×D	HSS-E PM
C 2-3		λ 45°
R	ST	



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P2.2	P2.3	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1	M2.2	M3.1	M3.2	M3.3	M4.1
◪21	◪15	■13	■9	◪8	■7	◪5	◪8	◪6	◪7	◪5	◪5	◪4	◪3	◪3

Products from this series are also available in set with drills. Please see L113.

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E003M2 [1]	2	0.40	41.0	8	2.50	2.00	4	2	1.60	8.00
E003M2.5 [1]	2.5	0.45	44.5	9.5	2.80	2.24	5	2	2.05	9.50
E003M3	3	0.50	48.0	6	3.15	2.50	5	3	2.50	12.50
E003M4	4	0.70	53.0	7	4.00	3.15	6	3	3.30	19.00
E003M5	5	0.80	58.0	8	5.00	4.00	7	3	4.20	22.00
E003M6	6	1.00	66.0	10	6.30	5.00	8	3	5.00	27.00
E003M8	8	1.25	72.0	12	8.00	6.30	9	3	6.80	31.00
E003M10	10	1.50	80.0	15	10.00	8.00	11	3	8.50	35.00
E003M12	12	1.75	89.0	16	9.00	7.10	10	3	10.30	–
E003M14	14	2.00	95.0	18	11.20	9.00	12	3	12.00	–
E003M16	16	2.00	102.0	18	12.50	10.00	13	4	14.00	–
E003M18	18	2.50	112.0	29	14.00	11.20	14	4	15.50	–
E003M20	20	2.50	112.0	29	14.00	11.20	14	4	17.50	–
E003M22	22	2.50	118.0	29	16.00	12.50	16	4	19.50	–
E003M24	24	3.00	130.0	35	18.00	14.00	18	4	21.00	–

[1] HSS-E.

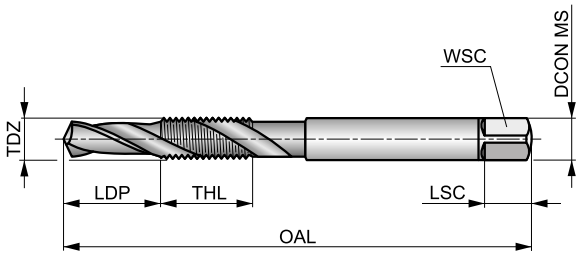
E650

DORMER



HSS Drill-Tap Combination Tool with 30° Spiral Flute, Metric, ISO Standard

Combination of a core-hole drill and tap to produce a thread in one pass. This significantly reduces the time needed to produce the thread on site with the use of a hand-held power tool. There is no need for a tap wrench or tool change. Steam tempered surface acts to retain the lubricant and provide smoother cutting.



M	ISO DORMER	6H
	1.5×D	HSS
C 2-3		λ 30°
R	ST	

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P3.1	P3.2	N1.2	N1.3	N3.1	N3.2	N4.1
■ 18	■ 20	■ 22	■ 20	◪ 18	◪ 15	◪ 12	◪ 14	◪ 9	◪ 20	◪ 15	◪ 25

Products from this series are also available in set. Please see L126.

Product	TDZ [mm]	TP [mm]	TD [mm]	OAL [mm]	THL [mm]	LDP [mm]	DCON MS [mm]	WSC [mm]	LSC [mm]	NOF
E650M3	3	0.50	2.500	56.0	10	6.00	3.15	2.50	5	2
E650M4	4	0.70	3.300	65.0	12	8.00	4.00	3.15	6	2
E650M5	5	0.80	4.200	69.0	15	10.00	5.00	4.00	7	2
E650M6	6	1.00	5.000	84.0	18	12.00	6.30	5.00	8	2
E650M8	8	1.25	6.800	96.0	21	16.00	8.00	6.30	9	2
E650M10	10	1.50	8.500	108.0	22	20.00	10.00	8.00	11	2
E650M12	12	1.75	10.200	113.0	29	24.00	9.00	7.10	10	2
E650M14	14	2.00	12.000	123.0	30	28.00	11.20	9.00	12	2
E650M16	16	2.00	14.000	134.0	32	32.00	12.50	10.00	13	2

E605

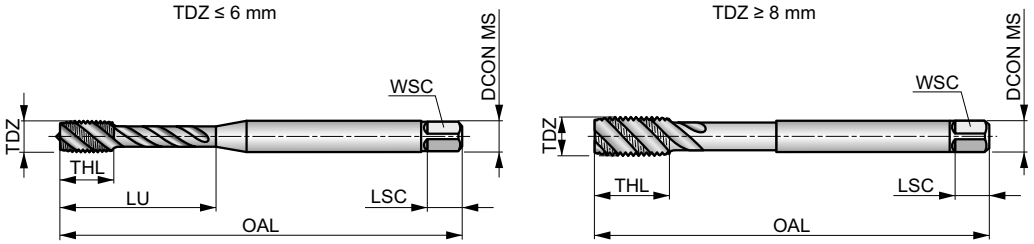
DORMER



HSS-E-PM 40° Spiral Flute Long Series Machine Tap, Metric, ISO Standard

Longer design to give extra reach when threading difficult to access holes. The spiral flutes transport the swarf away from the cutting edges and out of the hole, avoiding packing of swarf in the flutes or at the bottom. Suited for blind holes.

M	ISO 2283	6H
2×D		HSS-E PM
C 2-3		λ 40°
R	Bright	



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3
■ 11	■ 13	■ 13	■ 10	■ 9	◪ 8	■ 8	◪ 5	◪ 3	◪ 9	◪ 7	◪ 4	◪ 19	◪ 17	◪ 12

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E605M3	3	0.50	66.0	9	3.15	2.50	5	2	2.50	21.00
E605M4	4	0.70	73.0	9	4.00	3.15	6	2	3.30	22.00
E605M5	5	0.80	79.0	12	5.00	4.00	7	3	4.20	26.00
E605M6	6	1.00	89.0	12	6.30	5.00	8	3	5.00	29.00
E605M8	8	1.25	97.0	12	6.30	5.00	8	3	6.80	–
E605M10	10	1.50	108.0	14	8.00	6.30	9	3	8.50	–
E605M12	12	1.75	119.0	23	9.00	7.10	10	3	10.30	–
E605M14	14	2.00	127.0	25	11.20	9.00	12	3	12.00	–
E605M16	16	2.00	137.0	25	12.50	10.00	13	3	14.00	–
E605M20	20	2.50	149.0	30	14.00	11.20	14	3	17.50	–

E291

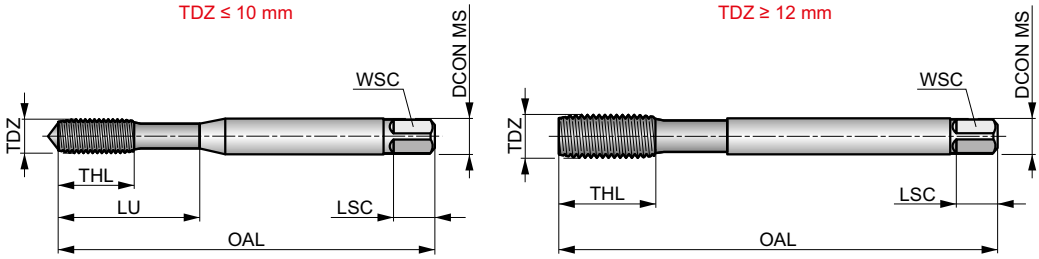
DORMER



HSS-E Thread Forming Tap, Metric, DIN Standard

Fluteless tap to produce high quality thread in blind and through holes. Provides a strong, clean, chip-free and accurate thread with excellent tolerance. Highly versatile for mild to medium strength steel and non-ferrous metal.

M	DIN 2174	6HX
	3×D	HSS-E
C 2-3.5		R
Bright		



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P3.1	P3.2	P4.1	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3
■ 23	■ 26	■ 26	■ 26	■ 23	■ 15	■ 12	■ 9	■ 26	■ 20	■ 13	◪ 34	◪ 30	◪ 22

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E291M1.6	1.6	0.35	40.0	8	2.50	2.10	5	3	1.40	–
E291M2	2	0.40	45.0	6	2.80	2.10	5	3	1.80	11.00
E291M2.5	2.5	0.45	50.0	8	2.80	2.10	5	3	2.30	12.50
E291M3	3	0.50	56.0	9	3.50	2.70	6	4	2.80	18.00
E291M3.5	3.5	0.60	56.0	11	4.00	3.00	6	4	3.20	20.00
E291M4	4	0.70	63.0	12	4.50	3.40	6	5	3.70	21.00
E291M5	5	0.80	70.0	13	6.00	4.90	8	5	4.60	25.00
E291M6	6	1.00	80.0	15	6.00	4.90	8	5	5.50	30.00
E291M8	8	1.25	90.0	18	8.00	6.20	9	5	7.40	35.00
E291M10	10	1.50	100.0	20	10.00	8.00	11	5	9.30	39.00
E291M12	12	1.75	110.0	23	9.00	7.00	10	5	11.20	–
E291M16	16	2.00	110.0	25	12.00	9.00	12	6	15.00	–

E292

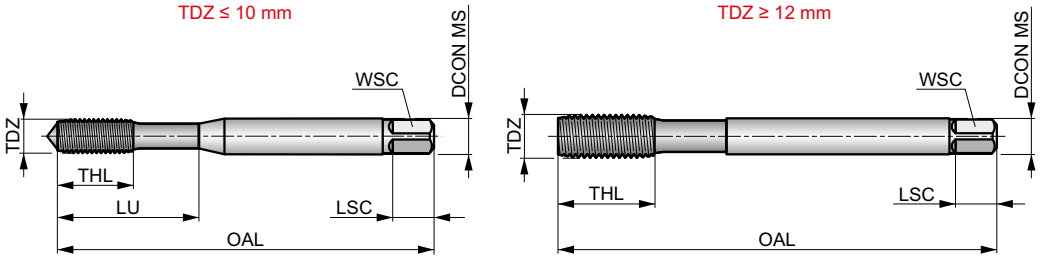
DORMER



HSS-E Thread Forming TiN Coated Tap, Metric, DIN Standard

High performance fluteless tap to produce high quality thread in blind and through holes. Provides a strong, clean, chip-free and accurate thread with excellent tolerance. Highly versatile for steel, stainless steel and non-ferrous metal. TiN coated to allow higher cutting speeds, improve performance and extend tool life.

M	DIN 2174	6HX
LU	3×D	HSS-E
C 2-3.5		R
TiN		



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P3.1	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1	M2.2
■ 45	■ 51	■ 51	■ 51	■ 45	■ 29	■ 24	◪ 18	■ 18	◪ 13	■ 25	■ 21	■ 22	■ 18

M3.1	M3.2	M3.3	M4.1	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.3
■ 17	■ 15	◪ 12	◪ 8	■ 55	■ 41	■ 28	■ 62	■ 55	■ 40	◪ 36	◪ 12

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E292M1.6	1.6	0.35	40.0	8	2.50	2.10	5	3	1.40	–
E292M2	2	0.40	45.0	6	2.80	2.10	5	3	1.80	11.00
E292M2.5	2.5	0.45	50.0	8	2.80	2.10	5	3	2.30	12.50
E292M3	3	0.50	56.0	9	3.50	2.70	6	4	2.80	18.00
E292M3.5	3.5	0.60	56.0	11	4.00	3.00	6	4	3.20	20.00
E292M4	4	0.70	63.0	12	4.50	3.40	6	5	3.70	21.00
E292M5	5	0.80	70.0	13	6.00	4.90	8	5	4.60	25.00
E292M6	6	1.00	80.0	15	6.00	4.90	8	5	5.50	30.00
E292M8	8	1.25	90.0	18	8.00	6.20	9	5	7.40	35.00
E292M10	10	1.50	100.0	20	10.00	8.00	11	5	9.30	39.00
E292M12	12	1.75	110.0	23	9.00	7.00	10	5	11.20	–
E292M16	16	2.00	110.0	25	12.00	9.00	12	6	15.00	–

E294

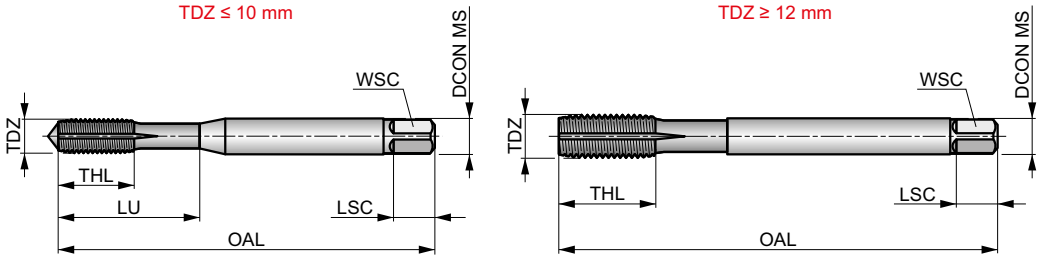
DORMER



HSS-E Thread Forming TiN Coated Tap, Oil-Grooves, Metric, DIN Standard

High performance fluteless tap for blind and through holes. Provide strong, clean, chip-free and accurate threads with excellent tolerance. Highly versatile for steel, stainless steel and non-ferrous metal. TiN coated for higher cutting speeds, performance and tool life. With oil-grooves for better lubrication in deep holes.

M	DIN 2174	6HX
LU	3.5×D	HSS-E
C 2-3.5		R
TiN		



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1
■45	■51	■51	■51	■45	◪40	■29	■24	■20	■18	■15	■25	■21	■22
M2.2	**M2.3**	**M3.1**	**M3.2**	**M3.3**	**M4.1**	**N1.1**	**N1.2**	**N1.3**	**N2.1**	**N2.2**	**N2.3**	**N3.1**	**N3.3**
■18	◪12	■17	■15	■14	■10	■55	■41	■28	■62	■55	■40	◪40	◪12

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E294M3	3	0.50	56.0	9	3.50	2.70	6	4	2.80	18.00
E294M4	4	0.70	63.0	12	4.50	3.40	6	5	3.70	21.00
E294M5	5	0.80	70.0	13	6.00	4.90	8	5	4.60	25.00
E294M6	6	1.00	80.0	15	6.00	4.90	8	5	5.50	30.00
E294M8	8	1.25	90.0	18	8.00	6.20	9	5	7.40	35.00
E294M10	10	1.50	100.0	20	10.00	8.00	11	5	9.30	39.00
E294M12	12	1.75	110.0	23	9.00	7.00	10	5	11.20	–
E294M14	14	2.00	110.0	25	11.00	9.00	12	6	13.00	–
E294M16	16	2.00	110.0	25	12.00	9.00	12	6	15.00	–

E289

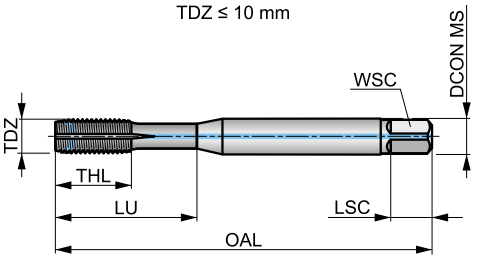
DORMER

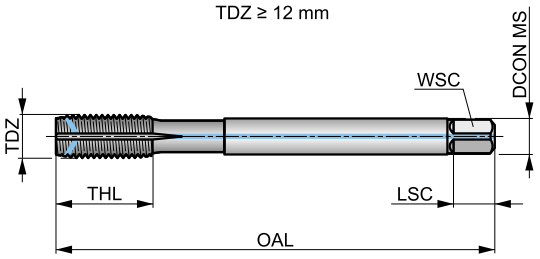


HSS-E Thread Forming TiN Coated Tap, Through Coolant, Metric, DIN Standard

High performance fluteless tap for blind and through holes. Provide strong, clean, chip-free and accurate threads with excellent tolerance. Highly versatile for steel, stainless steel and non-ferrous metal. TiN coated for higher cutting speeds, performance and tool life. Through coolant and oil-grooves for optimal lubrication.

M	DIN 2174	6HX
IU	3.5×D	HSS-E
C 2-3.5		R
TiN		





Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1
■ 50	■ 56	■ 56	■ 56	■ 49	◪ 42	■ 33	■ 26	■ 22	■ 20	■ 16	■ 27	■ 23	■ 24
M2.2	**M2.3**	**M3.1**	**M3.2**	**M3.3**	**M4.1**	**N1.1**	**N1.2**	**N1.3**	**N2.1**	**N2.2**	**N2.3**	**N3.1**	**N3.3**
■ 19	◪ 12	■ 18	■ 16	■ 14	■ 10	■ 60	■ 55	■ 31	■ 68	■ 60	■ 44	◪ 40	◪ 14

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E289M5	5	0.80	70.0	13	6.00	4.90	8	5	4.60	25.00
E289M6	6	1.00	80.0	15	6.00	4.90	8	5	5.50	30.00
E289M8	8	1.25	90.0	18	8.00	6.20	9	5	7.40	35.00
E289M10	10	1.50	100.0	20	10.00	8.00	11	5	9.30	39.00
E289M12	12	1.75	110.0	23	9.00	7.00	10	5	11.20	–

E293

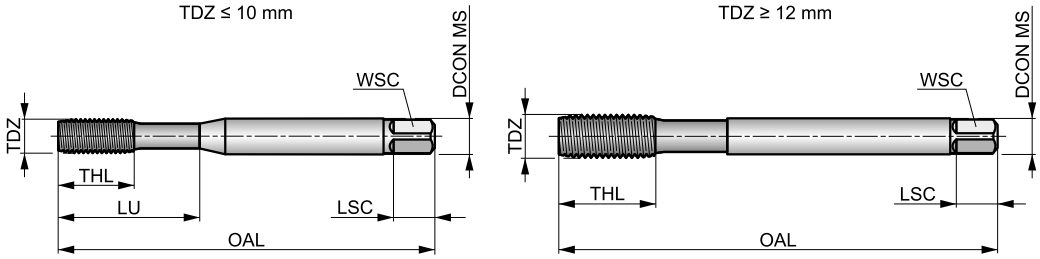
DORMER



HSS-E Thread Forming TiN Coated Tap, Metric, DIN Standard

High performance fluteless tap with full-bottoming lead to produce an almost full thread in blind holes. Provides a strong, clean, chip-free and accurate thread with excellent tolerance. Highly versatile for steel, stainless steel and non-ferrous metal. TiN coated for higher cutting speeds, improve performance and tool life.

M	DIN 2174	6HX
	3×D	HSS-E
E 1.5-2		R
TiN		



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P3.1	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1	M2.2
■45	■51	■51	■51	■45	■29	■24	◪18	■18	◪13	■25	■21	■22	■18

M3.1	M3.2	M3.3	M4.1	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.3
■17	■15	◪12	◪8	■55	■41	■28	■62	■55	■40	◪36	◪12

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E293M3	3	0.50	56.0	9	3.50	2.70	6	4	2.80	18.00
E293M4	4	0.70	63.0	12	4.50	3.40	6	5	3.70	21.00
E293M5	5	0.80	70.0	13	6.00	4.90	8	5	4.60	25.00
E293M6	6	1.00	80.0	15	6.00	4.90	8	5	5.50	30.00
E293M8	8	1.25	90.0	18	8.00	6.20	9	5	7.40	35.00
E293M10	10	1.50	100.0	20	10.00	8.00	11	5	9.30	39.00
E293M12	12	1.75	110.0	23	9.00	7.00	10	5	11.20	–
E293M16	16	2.00	110.0	25	12.00	9.00	12	6	15.00	–

E295

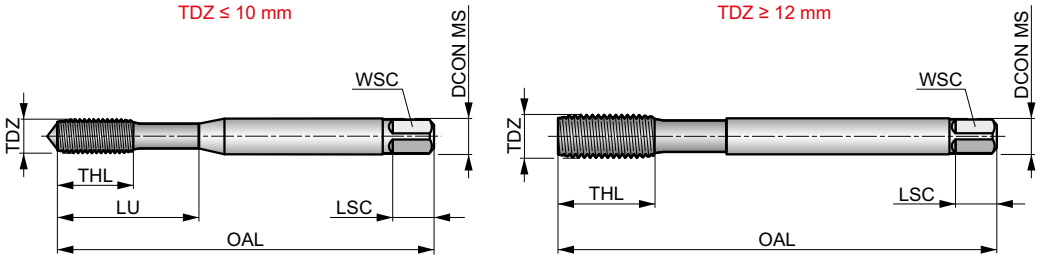
DORMER



HSS-E Thread Forming TiN Coated Tap, Metric, DIN Standard

High performance fluteless tap to produce high quality threads within 6G tolerance for a fit with large allowance. Provides a strong, clean, chip-free and accurate thread with excellent tolerance. Highly versatile for steel, stainless steel and non-ferrous metal. TiN coated for higher cutting speeds and extend tool life.

M	DIN 2174	6GX
LU	3×D	HSS-E
C 2-3.5		R
TiN		



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P3.1	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1	M2.2
■ 45	■ 51	■ 51	■ 51	■ 45	■ 29	■ 24	◪ 18	■ 18	◪ 13	■ 25	■ 21	■ 22	■ 18

M3.1	M3.2	M3.3	M4.1	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.3
■ 17	■ 15	◪ 12	◪ 8	■ 55	■ 41	■ 28	■ 62	■ 55	■ 40	◪ 36	◪ 12

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E295M3	3	0.50	56.0	9	3.50	2.70	6	4	2.80	18.00
E295M3.5	3.5	0.60	56.0	11	4.00	3.00	6	4	3.20	20.00
E295M4	4	0.70	63.0	12	4.50	3.40	6	5	3.70	21.00
E295M5	5	0.80	70.0	13	6.00	4.90	8	5	4.60	25.00
E295M6	6	1.00	80.0	15	6.00	4.90	8	5	5.50	30.00
E295M8	8	1.25	90.0	18	8.00	6.20	9	5	7.40	35.00
E295M10	10	1.50	100.0	20	10.00	8.00	11	5	9.30	39.00
E295M12	12	1.75	110.0	23	9.00	7.00	10	5	11.20	–

E296

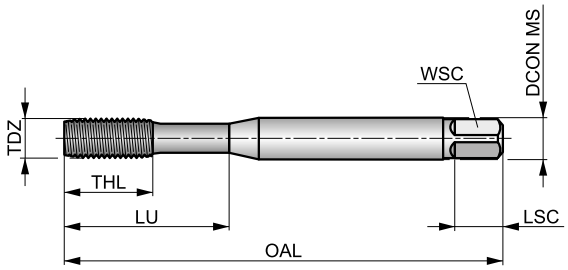
DORMER



HSS-E Thread Forming TiN Coated Tap, Metric, DIN Standard

High performance fluteless tap with full-bottoming lead to produce an almost full blind hole thread within 6G tolerance. Provides a strong, clean, chip-free and accurate thread. Highly versatile for steel, stainless steel and non-ferrous metal. TiN coated for higher cutting speeds, improve performance and tool life.

M	DIN 2174	6GX
	3×D	HSS-E
E 1.5-2		R
TiN		



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P3.1	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1	M2.2
■45	■51	■51	■51	■45	■29	■24	◪18	■18	◪13	■25	■21	■22	■18

M3.1	M3.2	M3.3	M4.1	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.3
■17	■15	◪12	◪8	■55	■41	■28	■62	■55	■40	◪36	◪12

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E296M3	3	0.50	56.0	9	3.50	2.70	6	4	2.80	18.00
E296M4	4	0.70	63.0	12	4.50	3.40	6	5	3.70	21.00
E296M5	5	0.80	70.0	13	6.00	4.90	8	5	4.60	25.00
E296M6	6	1.00	80.0	15	6.00	4.90	8	5	5.50	30.00
E296M8	8	1.25	90.0	18	8.00	6.20	9	5	7.40	35.00
E296M10	10	1.50	100.0	20	10.00	8.00	11	5	9.30	39.00

E105

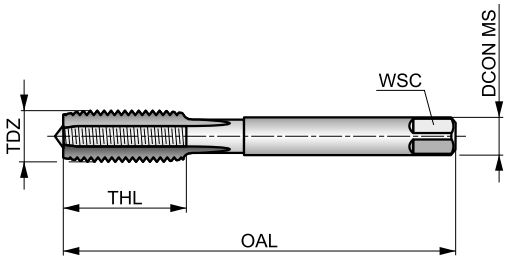
DORMER



HSS Straight Flute Serial Hand Tap, Metric-Fine, DIN Standard

Ideal for hand tapping tough materials. The straight flute design makes it ideal for both through and blind holes. Available as a single finishing tap or as a set of two serial taps, which should be used one after the other to create the full thread.

MF	DIN 2181	6H
	1.5×D	HSS
C 2-3		R
Bright		



Workpiece material group suitability.

P1.1 ■	P1.2 ■	P1.3 ■	P2.1 ■	P2.2 ■	P2.3 ◪	P3.1 ■	P3.2 ◪	P4.1 ◪	K1.1 ◪	K1.2 ◪	K1.3 ◪	K2.1 ◪	K2.2 ◪
K3.1 ◪	K3.2 ◪	K4.1 ◪	K4.2 ◪	K5.1 ◪	K5.2 ◪	N1.1 ■	N1.2 ■	N1.3 ■	N2.1 ■	N2.2 ■	N2.3 ■	N3.1 ■	N3.2 ■
N3.3 ■	N4.2 ■	N4.3 ■											

Product	TDZ	TP	OAL	THL	DCON MS	WSC	NOF	PHD
		[mm]	[mm]	[mm]	[mm]	[mm]		[mm]
E105M2.5X.35NO3	2.5	0.35	40.0	9	2.80	2.10	3	2.15
E105M2.5X.35NO9	2.5	0.35	40.0	9	2.80	2.10	3	2.15
E105M3X.35NO3	3	0.35	40.0	9	3.50	2.70	3	2.65
E105M3X.35NO9	3	0.35	40.0	9	3.50	2.70	3	2.65
E105M3.5X.35NO3	3.5	0.35	45.0	10	4.00	3.00	3	3.20
E105M3.5X.35NO9	3.5	0.35	45.0	10	4.00	3.00	3	3.20
E105M4X.5NO3	4	0.50	45.0	12	4.50	3.40	3	3.50
E105M4X.5NO9	4	0.50	45.0	12	4.50	3.40	3	3.50
E105M5X.5NO3	5	0.50	50.0	14	6.00	4.90	3	4.50
E105M5X.5NO9	5	0.50	50.0	14	6.00	4.90	3	4.50
E105M5.5X.5NO9	5.5	0.50	56.0	16	6.00	4.90	3	5.00
E105M6X.75NO3	6	0.75	56.0	16	6.00	4.90	3	5.30
E105M6X.75NO9	6	0.75	56.0	16	6.00	4.90	3	5.30
E105M7X.75NO3	7	0.75	56.0	16	6.00	4.90	3	6.30
E105M7X.75NO9	7	0.75	56.0	16	6.00	4.90	3	6.30
E105M8X.75NO3	8	0.75	56.0	16	6.00	4.90	3	7.30
E105M8X.75NO9	8	0.75	56.0	16	6.00	4.90	3	7.30
E105M8X1.0NO3	8	1.00	63.0	19	6.00	4.90	3	7.00
E105M8X1.0NO9	8	1.00	63.0	19	6.00	4.90	3	7.00
E105M9X.75NO3	9	0.75	63.0	19	7.00	5.50	3	8.30
E105M9X.75NO9	9	0.75	63.0	19	7.00	5.50	3	8.30
E105M9X1.0NO3	9	1.00	63.0	19	7.00	5.50	3	8.00
E105M9X1.0NO9	9	1.00	63.0	19	7.00	5.50	3	8.00
E105M10X.75NO3	10	0.75	63.0	16	7.00	5.50	3	9.30
E105M10X.75NO9	10	0.75	63.0	16	7.00	5.50	3	9.30
E105M10X1.0NO3	10	1.00	63.0	16	7.00	5.50	3	9.00
E105M10X1.0NO9	10	1.00	63.0	16	7.00	5.50	3	9.00
E105M10X1.25NO3	10	1.25	70.0	22	7.00	5.50	3	8.80

Product	TDZ	TP	OAL	THL	DCON MS	WSC	NOF	PHD
		[mm]	[mm]	[mm]	[mm]	[mm]		[mm]
E105M10X1.25NO9	10	1.25	70.0	22	7.00	5.50	3	8.80
E105M11X.75NO3	11	0.75	63.0	15	8.00	6.20	3	10.30
E105M11X.75NO9	11	0.75	63.0	15	8.00	6.20	3	10.30
E105M11X1.0NO3	11	1.00	63.0	15	8.00	6.20	3	10.00
E105M11X1.0NO9	11	1.00	63.0	15	8.00	6.20	3	10.00
E105M12X1.0NO3	12	1.00	70.0	16	9.00	7.00	3	11.00
E105M12X1.0NO9	12	1.00	70.0	16	9.00	7.00	3	11.00
E105M12X1.25NO3	12	1.25	70.0	16	9.00	7.00	3	10.80
E105M12X1.25NO9	12	1.25	70.0	16	9.00	7.00	3	10.80
E105M12X1.5NO3	12	1.50	70.0	16	9.00	7.00	3	10.50
E105M12X1.5NO9	12	1.50	70.0	16	9.00	7.00	3	10.50
E105M14X1.0NO3	14	1.00	70.0	16	11.00	9.00	4	13.00
E105M14X1.0NO9	14	1.00	70.0	16	11.00	9.00	4	13.00
E105M14X1.25NO3	14	1.25	70.0	16	11.00	9.00	4	12.80
E105M14X1.25NO9	14	1.25	70.0	16	11.00	9.00	4	12.80
E105M14X1.5NO3	14	1.50	70.0	16	11.00	9.00	4	12.50
E105M14X1.5NO9	14	1.50	70.0	16	11.00	9.00	4	12.50
E105M15X1.0NO3	15	1.00	70.0	16	12.00	9.00	4	14.00
E105M15X1.0NO9	15	1.00	70.0	16	12.00	9.00	4	14.00
E105M15X1.5NO3	15	1.50	70.0	16	12.00	9.00	4	13.50
E105M15X1.5NO9	15	1.50	70.0	16	12.00	9.00	4	13.50
E105M16X1.0NO3	16	1.00	70.0	16	12.00	9.00	4	15.00
E105M16X1.0NO9	16	1.00	70.0	16	12.00	9.00	4	15.00
E105M16X1.5NO3	16	1.50	70.0	16	12.00	9.00	4	14.50
E105M16X1.5NO9	16	1.50	70.0	16	12.00	9.00	4	14.50
E105M18X1.0NO3	18	1.00	80.0	18	14.00	11.00	4	17.00
E105M18X1.0NO9	18	1.00	80.0	18	14.00	11.00	4	17.00
E105M18X1.5NO3	18	1.50	80.0	18	14.00	11.00	4	16.50
E105M18X1.5NO9	18	1.50	80.0	18	14.00	11.00	4	16.50
E105M20X1.0NO3	20	1.00	80.0	18	16.00	12.00	4	19.00
E105M20X1.0NO9	20	1.00	80.0	18	16.00	12.00	4	19.00
E105M20X1.5NO3	20	1.50	80.0	18	16.00	12.00	4	18.50
E105M20X1.5NO9	20	1.50	80.0	18	16.00	12.00	4	18.50
E105M22X1.0NO3	22	1.00	80.0	22	18.00	14.50	4	21.00
E105M22X1.0NO9	22	1.00	80.0	22	18.00	14.50	4	21.00
E105M22X1.5NO3	22	1.50	80.0	22	18.00	14.50	4	20.50
E105M22X1.5NO9	22	1.50	80.0	22	18.00	14.50	4	20.50
E105M24X1.0NO3	24	1.00	90.0	22	18.00	14.50	4	23.00
E105M24X1.0NO9	24	1.00	90.0	22	18.00	14.50	4	23.00
E105M24X1.5NO3	24	1.50	90.0	22	18.00	14.50	4	22.50
E105M24X1.5NO9	24	1.50	90.0	22	18.00	14.50	4	22.50
E105M24X2.0NO3	24	2.00	90.0	22	18.00	14.50	4	22.00
E105M24X2.0NO9	24	2.00	90.0	22	18.00	14.50	4	22.00
E105M25X1.5NO3	25	1.50	90.0	22	18.00	14.50	4	23.50
E105M25X1.5NO9	25	1.50	90.0	22	18.00	14.50	4	23.50
E105M25X2.0NO3	25	2.00	90.0	22	18.00	14.50	4	23.00
E105M25X2.0NO9	25	2.00	90.0	22	18.00	14.50	4	23.00
E105M27X1.5NO3	27	1.50	90.0	22	20.00	16.00	4	25.50
E105M27X1.5NO9	27	1.50	90.0	22	20.00	16.00	4	25.50
E105M27X2.0NO3	27	2.00	90.0	22	20.00	16.00	4	25.00
E105M27X2.0NO9	27	2.00	90.0	22	20.00	16.00	4	25.00
E105M28X1.5NO3	28	1.50	90.0	22	20.00	16.00	4	26.50
E105M28X1.5NO9	28	1.50	90.0	22	20.00	16.00	4	26.50
E105M28X2.0NO3	28	2.00	90.0	22	20.00	16.00	4	26.00
E105M28X2.0NO9	28	2.00	90.0	22	20.00	16.00	4	26.00
E105M30X1.5NO3	30	1.50	90.0	22	22.00	18.00	4	28.50
E105M30X1.5NO9	30	1.50	90.0	22	22.00	18.00	4	28.50
E105M30X2.0NO3	30	2.00	90.0	22	22.00	18.00	4	28.00
E105M30X2.0NO9	30	2.00	90.0	22	22.00	18.00	4	28.00
E105M32X1.5NO3	32	1.50	90.0	22	22.00	18.00	4	30.50
E105M32X1.5NO9	32	1.50	90.0	22	22.00	18.00	4	30.50
E105M32X2.0NO3	32	2.00	90.0	22	22.00	18.00	4	30.00

Product	TDZ	TP	OAL	THL	DCON MS	WSC	NOF	PHD
		[mm]	[mm]	[mm]	[mm]	[mm]		[mm]
E105M32X2.0N09	32	2.00	90.0	22	22.00	18.00	4	30.00
E105M36X1.5N03	36	1.50	100.0	25	28.00	22.00	4	34.50
E105M36X1.5N09	36	1.50	100.0	25	28.00	22.00	4	34.50
E105M36X2.0N03	36	2.00	125.0	40	28.00	22.00	4	34.00
E105M36X2.0N09	36	2.00	125.0	40	28.00	22.00	4	34.00
E105M36X3.0N03	36	3.00	125.0	40	28.00	22.00	4	33.00
E105M36X3.0N09	36	3.00	125.0	40	28.00	22.00	4	33.00
E105M40X1.5N03	40	1.50	110.0	25	32.00	24.00	4	38.50
E105M40X1.5N09	40	1.50	110.0	25	32.00	24.00	4	38.50
E105M40X2.0N03	40	2.00	125.0	40	32.00	24.00	4	38.00
E105M40X2.0N09	40	2.00	125.0	40	32.00	24.00	4	38.00
E105M40X3.0N03	40	3.00	125.0	40	32.00	24.00	4	37.00
E105M40X3.0N09	40	3.00	125.0	40	32.00	24.00	4	37.00
E105M42X1.5N03	42	1.50	110.0	25	32.00	24.00	4	40.50
E105M42X1.5N09	42	1.50	110.0	25	32.00	24.00	4	40.50
E105M42X2.0N03	42	2.00	125.0	40	32.00	24.00	4	40.00
E105M42X2.0N09	42	2.00	125.0	40	32.00	24.00	4	40.00
E105M42X3.0N03	42	3.00	125.0	40	32.00	24.00	4	39.00
E105M42X3.0N09	42	3.00	125.0	40	32.00	24.00	4	39.00
E105M45X1.5N03	45	1.50	110.0	25	36.00	29.00	6	43.50
E105M45X1.5N09	45	1.50	110.0	25	36.00	29.00	6	43.50
E105M45X2.0N03	45	2.00	125.0	40	36.00	29.00	6	43.00
E105M45X2.0N09	45	2.00	125.0	40	36.00	29.00	6	43.00
E105M45X3.0N03	45	3.00	125.0	40	36.00	29.00	6	42.00
E105M45X3.0N09	45	3.00	125.0	40	36.00	29.00	6	42.00
E105M48X1.5N03	48	1.50	140.0	40	36.00	29.00	6	46.50
E105M48X1.5N09	48	1.50	140.0	40	36.00	29.00	6	46.50
E105M48X2.0N03	48	2.00	140.0	40	36.00	29.00	6	46.00
E105M48X2.0N09	48	2.00	140.0	40	36.00	29.00	6	46.00
E105M48X3.0N03	48	3.00	140.0	40	36.00	29.00	6	45.00
E105M48X3.0N09	48	3.00	140.0	40	36.00	29.00	6	45.00
E105M50X1.5N03	50	1.50	140.0	40	36.00	29.00	6	48.50
E105M50X1.5N09	50	1.50	140.0	40	36.00	29.00	6	48.50
E105M50X2.0N03	50	2.00	140.0	40	36.00	29.00	6	48.00
E105M50X2.0N09	50	2.00	140.0	40	36.00	29.00	6	48.00
E105M50X3.0N03	50	3.00	140.0	40	36.00	29.00	6	47.00
E105M50X3.0N09	50	3.00	140.0	40	36.00	29.00	6	47.00

E268

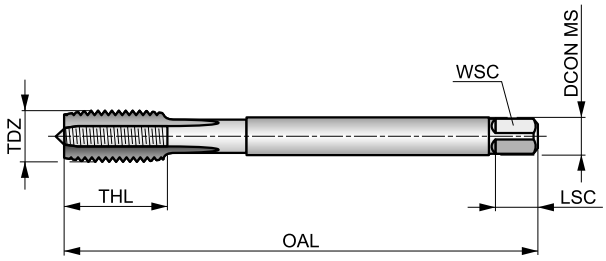
DORMER



HSS-E-PM Straight Flute Machine Tap, Metric-Fine, DIN Standard

General purpose straight flute machine tap for through and blind holes. Bright finish to produce more accurate and cleaner threads preventing the workpiece material from sticking to the cutting edges. The reduced shank increases the reach of the tap.

MF	DIN 374	6H
	1.5×D	HSS-E PM
C 2-3		R
Bright		



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	K1.1	K1.2	K1.3	K2.1	K2.2
■11	■12	■12	■9	■8	◪7	■7	◪6	◪4	◪13	◪10	◪8	◪14	◪11

K3.1	K3.2	K4.1	K4.2	K5.1	K5.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N4.2
◪13	◪10	◪12	◪9	◪12	◪10	◪12	◪15	◪14	◪11	◪21	■14	◪8

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]
E268M4X.5	4	0.50	63.0	10	2.80	2.10	5	3	3.50
E268M5X.5	5	0.50	70.0	13	3.50	2.70	6	3	4.50
E268M6X.75	6	0.75	80.0	15	4.50	3.40	6	3	5.30
E268M7X.75	7	0.75	80.0	15	5.50	4.30	7	3	6.30
E268M8X.75	8	0.75	80.0	15	6.00	4.90	8	3	7.30
E268M8X1.0	8	1.00	90.0	18	6.00	4.90	8	3	7.00
E268M9X1.0	9	1.00	90.0	18	6.00	4.90	8	3	8.00
E268M10X.75	10	0.75	90.0	20	7.00	5.50	8	3	9.30
E268M10X1.0	10	1.00	90.0	20	7.00	5.50	8	3	9.00
E268M10X1.25	10	1.25	100.0	20	7.00	5.50	8	3	8.80
E268M11X1.0	11	1.00	90.0	20	8.00	6.20	9	3	10.00
E268M12X1.0	12	1.00	100.0	21	9.00	7.00	10	4	11.00
E268M12X1.25	12	1.25	100.0	21	9.00	7.00	10	4	10.80
E268M12X1.5	12	1.50	100.0	21	9.00	7.00	10	4	10.50
E268M14X1.0	14	1.00	100.0	21	11.00	9.00	12	4	13.00
E268M14X1.25	14	1.25	100.0	21	11.00	9.00	12	4	12.80
E268M14X1.5	14	1.50	100.0	21	11.00	9.00	12	4	12.50
E268M15X1.5	15	1.50	100.0	21	12.00	9.00	12	4	13.50
E268M16X1.0	16	1.00	100.0	21	12.00	9.00	12	4	15.00
E268M16X1.5	16	1.50	100.0	21	12.00	9.00	12	4	14.50
E268M18X1.0	18	1.00	110.0	24	14.00	11.00	14	4	17.00
E268M18X1.5	18	1.50	110.0	24	14.00	11.00	14	4	16.50
E268M20X1.0	20	1.00	125.0	24	16.00	12.00	15	4	19.00
E268M20X1.5	20	1.50	125.0	24	16.00	12.00	15	4	18.50
E268M22X1.0	22	1.00	125.0	25	18.00	14.50	17	4	21.00
E268M22X1.5	22	1.50	125.0	25	18.00	14.50	17	4	20.50
E268M24X1.0	24	1.00	140.0	28	18.00	14.50	17	4	23.00
E268M24X1.5	24	1.50	140.0	28	18.00	14.50	17	4	22.50
E268M24X2.0	24	2.00	140.0	28	18.00	14.50	17	4	22.00
E268M25X1.5	25	1.50	140.0	28	18.00	14.50	17	4	23.50

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]
E268M25X2.0	25	2.00	140.0	28	18.00	14.50	17	4	23.00
E268M26X1.5	26	1.50	140.0	28	18.00	14.50	17	4	24.50
E268M26X2.0	26	2.00	140.0	28	18.00	14.50	17	4	24.00
E268M27X1.5	27	1.50	140.0	28	20.00	16.00	19	4	25.50
E268M27X2.0	27	2.00	140.0	28	20.00	16.00	19	4	25.00
E268M28X1.5	28	1.50	140.0	28	20.00	16.00	19	4	26.50
E268M28X2.0	28	2.00	140.0	28	20.00	16.00	19	4	26.00
E268M30X1.5	30	1.50	150.0	28	22.00	18.00	21	4	28.50
E268M30X2.0	30	2.00	150.0	28	22.00	18.00	21	4	28.00
E268M32X1.5	32	1.50	150.0	28	22.00	18.00	21	4	30.50
E268M32X2.0	32	2.00	150.0	28	22.00	18.00	21	4	30.00
E268M33X1.5	33	1.50	160.0	30	25.00	20.00	23	4	31.50
E268M34X1.5	34	1.50	170.0	30	28.00	22.00	25	4	32.50
E268M35X1.5	35	1.50	170.0	30	28.00	22.00	25	4	33.50
E268M36X1.5	36	1.50	170.0	30	28.00	22.00	25	4	34.50
E268M36X2.0	36	2.00	170.0	30	28.00	22.00	25	4	34.00
E268M36X3.0	36	3.00	200.0	55	28.00	22.00	25	4	33.00
E268M40X1.5 [1)]	40	1.50	170.0	30	32.00	24.00	27	4	38.50
E268M40X2.0 [1)]	40	2.00	170.0	30	32.00	24.00	27	4	38.00
E268M40X3.0 [1)]	40	3.00	200.0	60	32.00	24.00	27	4	37.00
E268M42X1.5 [1)]	42	1.50	170.0	30	32.00	24.00	27	4	40.50
E268M42X2.0 [1)]	42	2.00	170.0	30	32.00	24.00	27	4	40.00
E268M42X3.0 [1)]	42	3.00	200.0	60	32.00	24.00	27	4	39.00
E268M45X1.5 [1)]	45	1.50	180.0	32	36.00	29.00	32	6	43.50
E268M45X2.0 [1)]	45	2.00	180.0	32	36.00	29.00	32	6	43.00
E268M45X3.0 [1)]	45	3.00	200.0	42	36.00	29.00	32	6	42.00
E268M48X1.5 [1)]	48	1.50	190.0	32	36.00	29.00	32	6	46.50
E268M48X2.0 [1)]	48	2.00	190.0	32	36.00	29.00	32	6	46.00
E268M48X3.0 [1)]	48	3.00	225.0	50	36.00	29.00	32	6	45.00
E268M50X1.5 [1)]	50	1.50	190.0	32	36.00	29.00	32	6	48.50
E268M50X2.0 [1)]	50	2.00	190.0	30	36.00	29.00	32	6	48.00
E268M50X3.0 [1)]	50	3.00	225.0	50	36.00	29.00	32	6	47.00

[1)] HSS-E.

E242

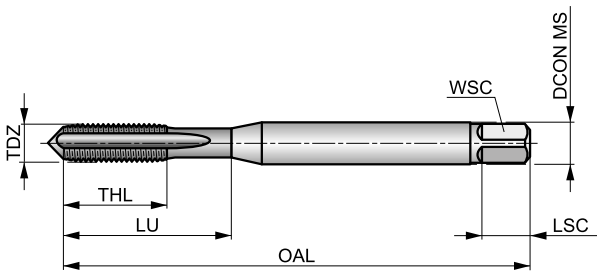
DORMER



HSS-E-PM Straight Flute Machine Tap, Metric Fine, DIN Left-Handed

General purpose straight flute machine tap for through and blind holes. Bright finish to produce more accurate and cleaner threads preventing the workpiece material from sticking to the cutting edges. The reinforced shank increases strength against torsional twist.

MF	DIN 371	6H
1.5×D		HSS-E PM
C 2-3		L
Bright		



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	K1.1	K1.2	K1.3	K2.1	K2.2
■11	■12	■12	■9	■8	◪7	■7	◪6	◪4	◪13	◪10	◪8	◪14	◪11

K3.1	K3.2	K4.1	K4.2	K5.1	K5.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N4.2
◪13	◪10	◪12	◪9	◪12	◪10	◪12	◪15	◪14	◪11	◪21	■14	◪8

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E242M8X1.0	8	1.00	90.0	18	8.00	6.20	9	3	7.00	35.00
E242M10X1.0	10	1.00	100.0	20	10.00	8.00	11	3	9.00	39.00

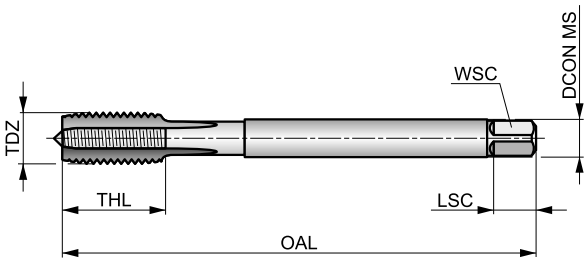
E290

DORMER



HSS-E-PM Straight Flute Machine Tap Metric Fine, DIN Left-Handed

General purpose straight flute machine tap for through and blind holes. Bright finish to produce more accurate and cleaner threads preventing the workpiece material from sticking to the cutting edges. The reduced shank increases the reach of the tap.



MF	DIN 374	6H
	1.5×D	HSS-E PM
C 2-3		
Bright		

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	K1.1	K1.2	K1.3	K2.1	K2.2
■11	■12	■12	■9	■8	◪7	■7	◪6	◪4	◪13	◪10	◪8	◪14	◪11

K3.1	K3.2	K4.1	K4.2	K5.1	K5.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N4.2
◪13	◪10	◪12	◪9	◪12	◪10	◪12	◪15	◪14	◪11	◪21	■14	◪8

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]
E290M12X1.0	12	1.00	100.0	21	9.00	7.00	10	4	11.00
E290M12X1.5	12	1.50	100.0	21	9.00	7.00	10	4	10.50
E290M14X1.0	14	1.00	100.0	21	11.00	9.00	12	4	13.00
E290M14X1.5	14	1.50	100.0	21	11.00	9.00	12	4	12.50
E290M16X1.0	16	1.00	100.0	21	12.00	9.00	12	4	15.00
E290M16X1.5	16	1.50	100.0	21	12.00	9.00	12	4	14.50
E290M18X1.5	18	1.50	110.0	24	14.00	11.00	14	4	16.50
E290M20X1.5	20	1.50	125.0	24	16.00	12.00	15	4	18.50
E290M22X1.5	22	1.50	125.0	25	18.00	14.50	17	4	20.50
E290M24X1.5	24	1.50	140.0	28	18.00	14.50	17	4	22.50

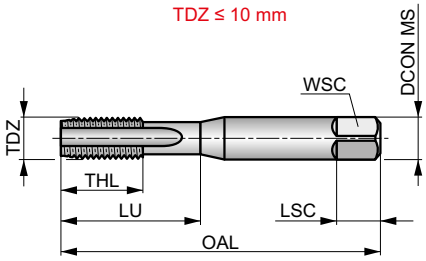
E513

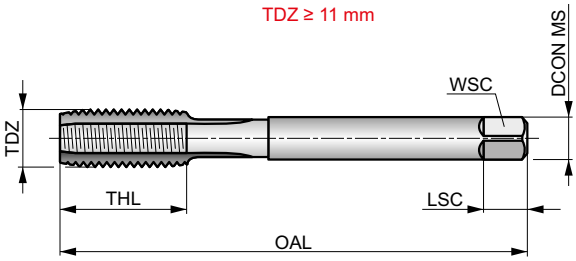
DORMER



HSS Straight Flute Hand Tap, Metric Fine, ISO Standard

A versatile tool, suitable for hand and machine tapping, with a straight flute design for both through and blind holes. Available with taper lead N01 for short through holes, plug lead N02 for deeper through holes or bottoming lead N03 for blind holes. Also, as a set N07 with a plug lead and bottoming lead tap.





MF	ISO 529	6H
	1.5×D	HSS
	R	Bright

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	K1.1	K1.2	K1.3	K2.1	K2.2
■7	■7	■8	■6	■5	◪4	■4	◪4	◪3	◪12	◪9	◪7	◪12	◪10

K3.1	K3.2	K4.1	K4.2	K5.1	K5.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	N4.2
◪11	◪8	◪10	◪8	◪11	◪9	◪8	◪11	◪10	◪7	■17	■10	◪5	◪5

N4.3
◪3

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E513M3X.35N01	3	0.35	48.0	12.5	3.15	2.50	5	3	2.65	12.50
E513M3X.35N02	3	0.35	48.0	12.5	3.15	2.50	5	3	2.65	12.50
E513M3X.35N03	3	0.35	48.0	12.5	3.15	2.50	5	3	2.65	12.50
E513M3.5X.35N03	3.5	0.35	48.0	12.5	3.15	2.50	5	3	3.20	12.50
E513M4X.5N01	4	0.50	53.0	14	4.00	3.15	6	3	3.50	14.00
E513M4X.5N02	4	0.50	53.0	14	4.00	3.15	6	3	3.50	14.00
E513M4X.5N03	4	0.50	53.0	14	4.00	3.15	6	3	3.50	14.00
E513M4X.5N07	4	0.50	53.0	14	4.00	3.15	6	3	3.50	14.00
E513M5X.5N01	5	0.50	58.0	11	5.00	4.00	7	3	4.50	22.00
E513M5X.5N02	5	0.50	58.0	11	5.00	4.00	7	3	4.50	22.00
E513M5X.5N03	5	0.50	58.0	11	5.00	4.00	7	3	4.50	22.00
E513M5X.5N07	5	0.50	58.0	11	5.00	4.00	7	3	4.50	22.00
E513M5X.75N01	5	0.75	58.0	11	5.00	4.00	7	3	4.30	22.00
E513M5X.75N02	5	0.75	58.0	11	5.00	4.00	7	3	4.30	22.00
E513M5X.75N03	5	0.75	58.0	11	5.00	4.00	7	3	4.30	22.00
E513M6X.5N01	6	0.50	66.0	13	6.30	5.00	8	3	5.50	26.00
E513M6X.5N02	6	0.50	66.0	13	6.30	5.00	8	3	5.50	26.00
E513M6X.5N03	6	0.50	66.0	13	6.30	5.00	8	3	5.50	26.00
E513M6X.75N01	6	0.75	66.0	13	6.30	5.00	8	3	5.30	26.00
E513M6X.75N02	6	0.75	66.0	13	6.30	5.00	8	3	5.30	26.00
E513M6X.75N03	6	0.75	66.0	13	6.30	5.00	8	3	5.30	26.00
E513M6X.75N07	6	0.75	66.0	13	6.30	5.00	8	3	5.30	26.00
E513M7X.75N01	7	0.75	66.0	13	7.10	5.60	8	3	6.30	26.00
E513M7X.75N02	7	0.75	66.0	13	7.10	5.60	8	3	6.30	26.00
E513M7X.75N03	7	0.75	66.0	13	7.10	5.60	8	3	6.30	26.00
E513M8X.5N01	8	0.50	72.0	16	8.00	6.30	9	3	7.50	29.00
E513M8X.5N02	8	0.50	72.0	16	8.00	6.30	9	3	7.50	29.00
E513M8X.5N03	8	0.50	72.0	16	8.00	6.30	9	3	7.50	29.00

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E513M8X.75N01	8	0.75	72.0	16	8.00	6.30	9	3	7.30	29.00
E513M8X.75N02	8	0.75	72.0	16	8.00	6.30	9	3	7.30	29.00
E513M8X.75N03	8	0.75	72.0	16	8.00	6.30	9	3	7.30	29.00
E513M8X.75N07	8	0.75	72.0	16	8.00	6.30	9	3	7.30	29.00
E513M8X1.0N01	8	1.00	72.0	16	8.00	6.30	9	3	7.00	29.00
E513M8X1.0N02	8	1.00	72.0	16	8.00	6.30	9	3	7.00	29.00
E513M8X1.0N03	8	1.00	72.0	16	8.00	6.30	9	3	7.00	29.00
E513M8X1.0N07	8	1.00	72.0	16	8.00	6.30	9	3	7.00	29.00
E513M9X.75N03	9	0.75	72.0	16	9.00	7.10	10	3	8.30	29.00
E513M9X1.0N01	9	1.00	72.0	16	9.00	7.10	10	3	8.00	29.00
E513M9X1.0N02	9	1.00	72.0	16	9.00	7.10	10	3	8.00	29.00
E513M9X1.0N03	9	1.00	72.0	16	9.00	7.10	10	3	8.00	29.00
E513M10X.5N03	10	0.50	80.0	18	10.00	8.00	11	3	9.50	34.00
E513M10X.75N01	10	0.75	80.0	18	10.00	8.00	11	3	9.30	34.00
E513M10X.75N02	10	0.75	80.0	18	10.00	8.00	11	3	9.30	34.00
E513M10X.75N03	10	0.75	80.0	18	10.00	8.00	11	3	9.30	34.00
E513M10X1.0N01	10	1.00	80.0	18	10.00	8.00	11	3	9.00	34.00
E513M10X1.0N02	10	1.00	80.0	18	10.00	8.00	11	3	9.00	34.00
E513M10X1.0N03	10	1.00	80.0	18	10.00	8.00	11	3	9.00	34.00
E513M10X1.0N06	10	1.00	80.0	18	10.00	8.00	11	3	9.00	34.00
E513M10X1.0N07	10	1.00	80.0	18	10.00	8.00	11	3	9.00	34.00
E513M10X1.25N01	10	1.25	80.0	18	10.00	8.00	11	3	8.80	34.00
E513M10X1.25N02	10	1.25	80.0	18	10.00	8.00	11	3	8.80	34.00
E513M10X1.25N03	10	1.25	80.0	18	10.00	8.00	11	3	8.80	34.00
E513M10X1.25N06	10	1.25	80.0	18	10.00	8.00	11	3	8.80	34.00
E513M10X1.25N07	10	1.25	80.0	18	10.00	8.00	11	3	8.80	34.00
E513M11X.75N01	11	0.75	85.0	19	8.00	6.30	9	3	10.30	–
E513M11X.75N02	11	0.75	85.0	19	8.00	6.30	9	3	10.30	–
E513M11X.75N03	11	0.75	85.0	19	8.00	6.30	9	3	10.30	–
E513M11X1.0N01	11	1.00	85.0	19	8.00	6.30	9	3	10.00	–
E513M11X1.0N02	11	1.00	85.0	19	8.00	6.30	9	3	10.00	–
E513M11X1.0N03	11	1.00	85.0	19	8.00	6.30	9	3	10.00	–
E513M11X1.25N03	11	1.25	85.0	19	8.00	6.30	9	3	9.80	–
E513M12X.75N03	12	0.75	89.0	22	9.00	7.10	10	3	11.30	–
E513M12X1.0N01	12	1.00	89.0	22	9.00	7.10	10	3	11.00	–
E513M12X1.0N02	12	1.00	89.0	22	9.00	7.10	10	3	11.00	–
E513M12X1.0N03	12	1.00	89.0	22	9.00	7.10	10	3	11.00	–
E513M12X1.0N07	12	1.00	89.0	22	9.00	7.10	10	3	11.00	–
E513M12X1.25N01	12	1.25	89.0	22	9.00	7.10	10	3	10.80	–
E513M12X1.25N02	12	1.25	89.0	22	9.00	7.10	10	3	10.80	–
E513M12X1.25N03	12	1.25	89.0	22	9.00	7.10	10	3	10.80	–
E513M12X1.25N06	12	1.25	89.0	22	9.00	7.10	10	3	10.80	–
E513M12X1.25N07	12	1.25	89.0	22	9.00	7.10	10	3	10.80	–
E513M12X1.5N01	12	1.50	89.0	22	9.00	7.10	10	3	10.50	–
E513M12X1.5N02	12	1.50	89.0	22	9.00	7.10	10	3	10.50	–
E513M12X1.5N03	12	1.50	89.0	22	9.00	7.10	10	3	10.50	–
E513M12X1.5N06	12	1.50	89.0	22	9.00	7.10	10	3	10.50	–
E513M12X1.5N07	12	1.50	89.0	22	9.00	7.10	10	3	10.50	–
E513M13X1.5N03	13	1.50	89.0	22	9.00	7.10	10	3	11.50	–
E513M14X1.0N01	14	1.00	95.0	24	11.20	9.00	12	4	13.00	–
E513M14X1.0N02	14	1.00	95.0	24	11.20	9.00	12	4	13.00	–
E513M14X1.0N03	14	1.00	95.0	24	11.20	9.00	12	4	13.00	–
E513M14X1.0N07	14	1.00	95.0	24	11.20	9.00	12	4	13.00	–
E513M14X1.25N01	14	1.25	95.0	24	11.20	9.00	12	4	12.80	–
E513M14X1.25N02	14	1.25	95.0	24	11.20	9.00	12	4	12.80	–
E513M14X1.25N03	14	1.25	95.0	24	11.20	9.00	12	4	12.80	–
E513M14X1.25N06	14	1.25	95.0	24	11.20	9.00	12	4	12.80	–
E513M14X1.5N01	14	1.50	95.0	24	11.20	9.00	12	4	12.50	–
E513M14X1.5N02	14	1.50	95.0	24	11.20	9.00	12	4	12.50	–
E513M14X1.5N03	14	1.50	95.0	24	11.20	9.00	12	4	12.50	–
E513M14X1.5N06	14	1.50	95.0	24	11.20	9.00	12	4	12.50	–
E513M14X1.5N07	14	1.50	95.0	24	11.20	9.00	12	4	12.50	–

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E513M15X1.5N02	15	1.50	95.0	24	11.20	9.00	12	4	13.50	–
E513M15X1.5N03	15	1.50	95.0	24	11.20	9.00	12	4	13.50	–
E513M16X1.0N01	16	1.00	102.0	24	12.50	10.00	13	4	15.00	–
E513M16X1.0N02	16	1.00	102.0	24	12.50	10.00	13	4	15.00	–
E513M16X1.0N03	16	1.00	102.0	24	12.50	10.00	13	4	15.00	–
E513M16X1.0N07	16	1.00	102.0	24	12.50	10.00	13	4	15.00	–
E513M16X1.25N03	16	1.25	102.0	24	12.50	10.00	13	4	14.80	–
E513M16X1.5N01	16	1.50	102.0	24	12.50	10.00	13	4	14.50	–
E513M16X1.5N02	16	1.50	102.0	24	12.50	10.00	13	4	14.50	–
E513M16X1.5N03	16	1.50	102.0	24	12.50	10.00	13	4	14.50	–
E513M16X1.5N06	16	1.50	102.0	24	12.50	10.00	13	4	14.50	–
E513M16X1.5N07	16	1.50	102.0	24	12.50	10.00	13	4	14.50	–
E513M18X1.0N01	18	1.00	112.0	29	14.00	11.20	14	4	17.00	–
E513M18X1.0N02	18	1.00	112.0	29	14.00	11.20	14	4	17.00	–
E513M18X1.0N03	18	1.00	112.0	29	14.00	11.20	14	4	17.00	–
E513M18X1.0N07	18	1.00	112.0	29	14.00	11.20	14	4	17.00	–
E513M18X1.5N01	18	1.50	112.0	29	14.00	11.20	14	4	16.50	–
E513M18X1.5N02	18	1.50	112.0	29	14.00	11.20	14	4	16.50	–
E513M18X1.5N03	18	1.50	112.0	29	14.00	11.20	14	4	16.50	–
E513M18X1.5N06	18	1.50	112.0	29	14.00	11.20	14	4	16.50	–
E513M18X1.5N07	18	1.50	112.0	29	14.00	11.20	14	4	16.50	–
E513M18X2.0N01	18	2.00	112.0	29	14.00	11.20	14	4	16.00	–
E513M18X2.0N02	18	2.00	112.0	29	14.00	11.20	14	4	16.00	–
E513M18X2.0N03	18	2.00	112.0	29	14.00	11.20	14	4	16.00	–
E513M18X2.0N07	18	2.00	112.0	29	14.00	11.20	14	4	16.00	–
E513M20X1.0N01	20	1.00	112.0	29	14.00	11.20	14	4	19.00	–
E513M20X1.0N02	20	1.00	112.0	29	14.00	11.20	14	4	19.00	–
E513M20X1.0N03	20	1.00	112.0	29	14.00	11.20	14	4	19.00	–
E513M20X1.0N07	20	1.00	112.0	29	14.00	11.20	14	4	19.00	–
E513M20X1.5N01	20	1.50	112.0	29	14.00	11.20	14	4	18.50	–
E513M20X1.5N02	20	1.50	112.0	29	14.00	11.20	14	4	18.50	–
E513M20X1.5N03	20	1.50	112.0	29	14.00	11.20	14	4	18.50	–
E513M20X1.5N06	20	1.50	112.0	29	14.00	11.20	14	4	18.50	–
E513M20X1.5N07	20	1.50	112.0	29	14.00	11.20	14	4	18.50	–
E513M20X2.0N01	20	2.00	112.0	29	14.00	11.20	14	4	18.00	–
E513M20X2.0N02	20	2.00	112.0	29	14.00	11.20	14	4	18.00	–
E513M20X2.0N03	20	2.00	112.0	29	14.00	11.20	14	4	18.00	–
E513M20X2.0N07	20	2.00	112.0	29	14.00	11.20	14	4	18.00	–
E513M22X1.0N02	22	1.00	118.0	29	16.00	12.50	16	4	21.00	–
E513M22X1.0N03	22	1.00	118.0	29	16.00	12.50	16	4	21.00	–
E513M22X1.0N07	22	1.00	118.0	29	16.00	12.50	16	4	21.00	–
E513M22X1.5N01	22	1.50	118.0	29	16.00	12.50	16	4	20.50	–
E513M22X1.5N02	22	1.50	118.0	29	16.00	12.50	16	4	20.50	–
E513M22X1.5N03	22	1.50	118.0	29	16.00	12.50	16	4	20.50	–
E513M22X1.5N07	22	1.50	118.0	29	16.00	12.50	16	4	20.50	–
E513M22X2.0N01	22	2.00	118.0	29	16.00	12.50	16	4	20.00	–
E513M22X2.0N02	22	2.00	118.0	29	16.00	12.50	16	4	20.00	–
E513M22X2.0N03	22	2.00	118.0	29	16.00	12.50	16	4	20.00	–
E513M22X2.0N07	22	2.00	118.0	29	16.00	12.50	16	4	20.00	–
E513M24X1.0N02	24	1.00	130.0	35	18.00	14.00	18	4	23.00	–
E513M24X1.0N03	24	1.00	130.0	35	18.00	14.00	18	4	23.00	–
E513M24X1.5N01	24	1.50	130.0	35	18.00	14.00	18	4	22.50	–
E513M24X1.5N02	24	1.50	130.0	35	18.00	14.00	18	4	22.50	–
E513M24X1.5N03	24	1.50	130.0	35	18.00	14.00	18	4	22.50	–
E513M24X1.5N07	24	1.50	130.0	35	18.00	14.00	18	4	22.50	–
E513M24X2.0N01	24	2.00	130.0	35	18.00	14.00	18	4	22.00	–
E513M24X2.0N02	24	2.00	130.0	35	18.00	14.00	18	4	22.00	–
E513M24X2.0N03	24	2.00	130.0	35	18.00	14.00	18	4	22.00	–
E513M24X2.0N07	24	2.00	130.0	35	18.00	14.00	18	4	22.00	–
E513M25X1.5N01	25	1.50	130.0	35	18.00	14.00	18	4	23.50	–
E513M25X1.5N02	25	1.50	130.0	35	18.00	14.00	18	4	23.50	–
E513M25X1.5N03	25	1.50	130.0	35	18.00	14.00	18	4	23.50	–

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E513M25X1.5N06	25	1.50	130.0	35	18.00	14.00	18	4	23.50	–
E513M25X1.5N07	25	1.50	130.0	35	18.00	14.00	18	4	23.50	–
E513M26X1.5N02	26	1.50	130.0	35	18.00	14.00	18	4	24.50	–
E513M26X1.5N03	26	1.50	130.0	35	18.00	14.00	18	4	24.50	–
E513M27X1.5N02	27	1.50	135.0	35	20.00	16.00	20	4	25.50	–
E513M27X1.5N03	27	1.50	135.0	35	20.00	16.00	20	4	25.50	–
E513M27X2.0N03	27	2.00	135.0	35	20.00	16.00	20	4	25.00	–
E513M28X1.5N02	28	1.50	138.0	35	20.00	16.00	20	4	26.50	–
E513M28X1.5N03	28	1.50	138.0	35	20.00	16.00	20	4	26.50	–
E513M30X1.5N02	30	1.50	138.0	41	20.00	16.00	20	4	28.50	–
E513M30X1.5N03	30	1.50	138.0	41	20.00	16.00	20	4	28.50	–
E513M30X2.0N02	30	2.00	138.0	41	20.00	16.00	20	4	28.00	–
E513M30X2.0N03	30	2.00	138.0	41	20.00	16.00	20	4	28.00	–
E513M32X1.5N01	32	1.50	151.0	41	22.40	18.00	22	4	30.50	–
E513M32X1.5N02	32	1.50	151.0	41	22.40	18.00	22	4	30.50	–
E513M32X1.5N03	32	1.50	151.0	41	22.40	18.00	22	4	30.50	–
E513M33X2.0N02	33	2.00	151.0	41	22.40	18.00	22	4	31.00	–
E513M33X2.0N03	33	2.00	151.0	41	22.40	18.00	22	4	31.00	–
E513M35X1.5N02	35	1.50	162.0	47	25.00	20.00	24	4	33.50	–
E513M35X1.5N03	35	1.50	162.0	47	25.00	20.00	24	4	33.50	–
E513M36X1.5N03	36	1.50	162.0	47	25.00	20.00	24	4	34.50	–
E513M36X2.0N02	36	2.00	162.0	47	25.00	20.00	24	4	34.00	–
E513M36X2.0N03	36	2.00	162.0	47	25.00	20.00	24	4	34.00	–
E513M36X3.0N02	36	3.00	162.0	47	25.00	20.00	24	4	33.00	–
E513M36X3.0N03	36	3.00	162.0	47	25.00	20.00	24	4	33.00	–
E513M39X3.0N02	39	3.00	170.0	47	28.00	22.40	26	4	36.00	–
E513M39X3.0N03	39	3.00	170.0	47	28.00	22.40	26	4	36.00	–
E513M40X1.5N02	40	1.50	170.0	53	28.00	22.40	26	6	38.50	–
E513M40X1.5N03	40	1.50	170.0	53	28.00	22.40	26	6	38.50	–
E513M42X1.5N02	42	1.50	170.0	53	28.00	22.40	26	6	40.50	–
E513M42X1.5N03	42	1.50	170.0	53	28.00	22.40	26	6	40.50	–
E513M42X3.0N03	42	3.00	170.0	53	28.00	22.40	26	6	39.00	–
E513M45X1.5N02	45	1.50	187.0	54	31.50	25.00	28	6	43.50	–
E513M45X1.5N03	45	1.50	187.0	54	31.50	25.00	28	6	43.50	–
E513M48X1.5N03	48	1.50	187.0	60	31.50	25.00	28	6	46.50	–
E513M48X2.0N03	48	2.00	187.0	60	31.50	25.00	28	6	46.00	–
E513M48X3.0N03	48	3.00	187.0	60	31.50	25.00	28	6	45.00	–
E513M50X1.5N02	50	1.50	187.0	60	31.50	25.00	28	6	48.50	–
E513M50X1.5N03	50	1.50	187.0	60	31.50	25.00	28	6	48.50	–

EP10

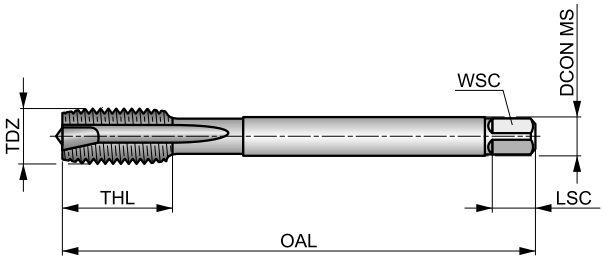
DORMER



HSS-E-PM Spiral Point Machine Tap, Metric Fine, DIN Standard

Machine tap with spiral point suited for through holes only. Bright finish to produce more accurate and cleaner threads preventing the workpiece material from sticking to the cutting edges. The reduced shank increases the reach of the tap.

MF	DIN 374	6H
	2.5×D	HSS-E PM
B 3.5-5		R
Bright		



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	N1.1	N1.2	N1.3	N2.1	N2.2
■22	■24	■25	■18	■16	◪14	■13	◪10	◪8	■14	■10	■7	■28	■25

N2.3	N3.1	N3.2	N3.3	N4.1
■18	■44	◪27	◪13	◪22

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]
EP10M4X.5	4	0.50	63.0	12	2.80	2.10	5	3	3.50
EP10M5X.5	5	0.50	70.0	13	3.50	2.70	6	3	4.50
EP10M6X.75	6	0.75	80.0	15	4.50	3.40	6	3	5.30
EP10M8X.75	8	0.75	80.0	15	6.00	4.90	8	3	7.30
EP10M8X1.0	8	1.00	90.0	18	6.00	4.90	8	3	7.00
EP10M10X.75	10	0.75	90.0	18	7.00	5.50	8	3	9.30
EP10M10X1.0	10	1.00	90.0	18	7.00	5.50	8	3	9.00
EP10M10X1.25	10	1.25	100.0	20	7.00	5.50	8	3	8.80
EP10M12X1.0	12	1.00	100.0	21	9.00	7.00	10	3	11.00
EP10M12X1.25	12	1.25	100.0	21	9.00	7.00	10	3	10.80
EP10M12X1.5	12	1.50	100.0	21	9.00	7.00	10	3	10.50
EP10M14X1.0	14	1.00	100.0	21	11.00	9.00	12	3	13.00
EP10M14X1.25	14	1.25	100.0	21	11.00	9.00	12	3	13.00
EP10M14X1.5	14	1.50	100.0	21	11.00	9.00	12	3	12.50
EP10M16X1.0	16	1.00	100.0	21	12.00	9.00	12	3	15.00
EP10M16X1.5	16	1.50	100.0	21	12.00	9.00	12	3	14.50
EP10M18X1.0	18	1.00	110.0	24	14.00	11.00	14	4	17.00
EP10M18X1.5	18	1.50	110.0	24	14.00	11.00	14	4	16.50
EP10M20X1.0	20	1.00	125.0	24	16.00	12.00	15	4	19.00
EP10M20X1.5	20	1.50	125.0	24	16.00	12.00	15	4	18.50
EP10M22X1.5	22	1.50	125.0	25	18.00	14.50	17	4	20.50
EP10M24X1.5	24	1.50	140.0	28	18.00	14.50	17	4	22.50
EP10M24X2.0	24	2.00	140.0	28	18.00	14.50	17	4	22.00
EP10M25X1.5	25	1.50	140.0	28	18.00	14.50	17	4	23.50
EP10M26X1.5	26	1.50	140.0	28	18.00	14.50	17	4	24.50
EP10M27X1.5	27	1.50	140.0	28	20.00	16.00	19	4	25.50
EP10M27X2.0	27	2.00	140.0	28	20.00	16.00	19	4	25.00
EP10M28X1.5	28	1.50	140.0	28	20.00	16.00	19	4	26.50
EP10M30X1.5	30	1.50	150.0	28	22.00	18.00	21	4	28.50
EP10M30X2.0	30	2.00	150.0	28	22.00	18.00	21	4	28.00

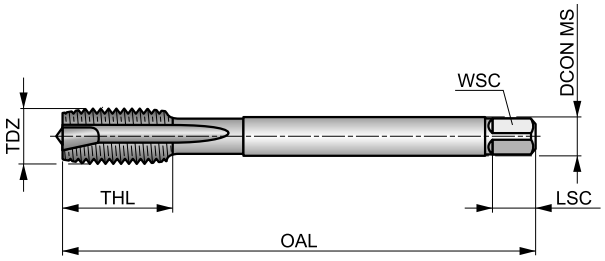
EP10TIN

DORMER



HSS-E-PM Spiral Point Machine Tap, Metric Fine, TiN Coating, DIN Standard

High performance machine tap with spiral point for through holes only. Suited for a broad range of workpiece materials. TiN coating allows higher cutting speeds, improves performance and extends tool life. The reduced shank increases the reach of the tap.



MF	DIN 374	6H
	2.5×D	HSS-E PM
B 3.5-5		R
TiN		

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1
■34	■38	■40	■29	■24	■20	■19	■14	◪12	■10	◪9	■11	■9	■10
M2.2	**M3.1**	**M3.2**	**M3.3**	**M4.1**	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K3.1**	**K3.2**	**K4.1**	**K4.2**
■8	■8	■7	◪6	◪5	◪21	◪16	◪12	◪30	◪24	◪26	◪20	◪24	◪18
K5.1	**K5.2**	**N1.3**	**N2.1**	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N4.1**					
◪28	◪20	■12	■37	■34	■24	■60	◪36	◪26					

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]
EP10TINM8X1.0	8	1.00	90.0	18	6.00	4.90	8	3	7.00
EP10TINM10X1.0	10	1.00	90.0	18	7.00	5.50	8	3	9.00
EP10TINM10X1.25	10	1.25	100.0	20	7.00	5.50	8	3	8.80
EP10TINM12X1.0	12	1.00	100.0	21	9.00	7.00	10	3	11.00
EP10TINM12X1.25	12	1.25	100.0	21	9.00	7.00	10	3	10.80
EP10TINM12X1.5	12	1.50	100.0	21	9.00	7.00	10	3	10.50
EP10TINM14X1.5	14	1.50	100.0	21	11.00	9.00	12	3	12.50
EP10TINM16X1.5	16	1.50	100.0	21	12.00	9.00	12	3	14.50
EP10TINM18X1.5	18	1.50	110.0	24	14.00	11.00	14	4	16.50
EP10TINM20X1.5	20	1.50	125.0	24	16.00	12.00	15	4	18.50

EP11

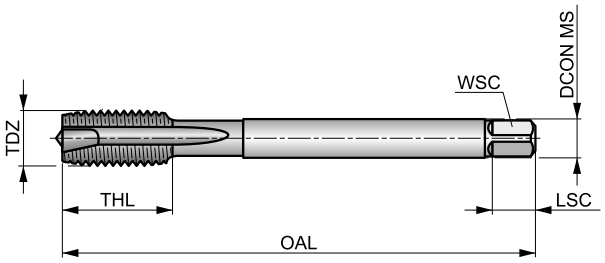
DORMER



HSS-E-PM Spiral Point Machine Tap, Metric Fine, DIN Standard

Machine tap with spiral point suited for through holes only. Steam tempered surface acts to retain cutting fluid and prevent chip to tool welding. The reduced shank increases the reach of the tap.

MF	DIN 374	6H
	2.5×D	HSS-E PM
B 3.5-5		R
ST		



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P2.2	P2.3	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1	M2.2	M3.1	M3.2	M3.3
◪22	◪16	■14	■10	◪9	■8	◪6	◪10	◪8	◪9	◪7	◪7	◪6	◪5

M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K3.1	K3.2	K4.1	K4.2	K5.1	K5.2
◪4	◪13	◪10	◪7	◪16	◪13	◪14	◪10	◪13	◪9	◪15	◪11

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]
EP11M4X.5	4	0.50	63.0	12	2.80	2.10	5	3	3.50
EP11M5X.5	5	0.50	70.0	13	3.50	2.70	6	3	4.50
EP11M6X.75	6	0.75	80.0	15	4.50	3.40	6	3	5.30
EP11M8X.75	8	0.75	80.0	15	6.00	4.90	8	3	7.30
EP11M8X1.0	8	1.00	90.0	18	6.00	4.90	8	3	7.00
EP11M10X.75	10	0.75	90.0	18	7.00	5.50	8	3	9.30
EP11M10X1.0	10	1.00	90.0	18	7.00	5.50	8	3	9.00
EP11M10X1.25	10	1.25	100.0	20	7.00	5.50	8	3	8.80
EP11M12X1.0	12	1.00	100.0	21	9.00	7.00	10	3	11.00
EP11M12X1.25	12	1.25	100.0	21	9.00	7.00	10	3	10.80
EP11M12X1.5	12	1.50	100.0	21	9.00	7.00	10	3	10.50
EP11M14X1.0	14	1.00	100.0	21	11.00	9.00	12	3	13.00
EP11M14X1.25	14	1.25	100.0	21	11.00	9.00	12	3	13.00
EP11M14X1.5	14	1.50	100.0	21	11.00	9.00	12	3	12.50
EP11M16X1.0	16	1.00	100.0	21	12.00	9.00	12	3	15.00
EP11M16X1.5	16	1.50	100.0	21	12.00	9.00	12	3	14.50
EP11M18X1.0	18	1.00	110.0	24	14.00	11.00	14	4	17.00
EP11M18X1.5	18	1.50	110.0	24	14.00	11.00	14	4	16.50
EP11M20X1.0	20	1.00	125.0	24	16.00	12.00	15	4	19.00
EP11M20X1.5	20	1.50	125.0	24	16.00	12.00	15	4	18.50
EP11M22X1.5	22	1.50	125.0	25	18.00	14.50	17	4	20.50
EP11M24X1.5	24	1.50	140.0	28	18.00	14.50	17	4	22.50
EP11M24X2.0	24	2.00	140.0	28	18.00	14.50	17	4	22.00
EP11M25X1.5	25	1.50	140.0	28	18.00	14.50	17	4	23.50
EP11M26X1.5	26	1.50	140.0	28	18.00	14.50	17	4	24.50
EP11M27X1.5	27	1.50	140.0	28	20.00	16.00	19	4	25.50
EP11M27X2.0	27	2.00	140.0	28	20.00	16.00	19	4	25.00
EP11M28X1.5	28	1.50	140.0	28	20.00	16.00	19	4	26.50
EP11M30X1.5	30	1.50	150.0	28	22.00	18.00	21	4	28.50
EP11M30X2.0	30	2.00	150.0	28	22.00	18.00	21	4	28.00

E011

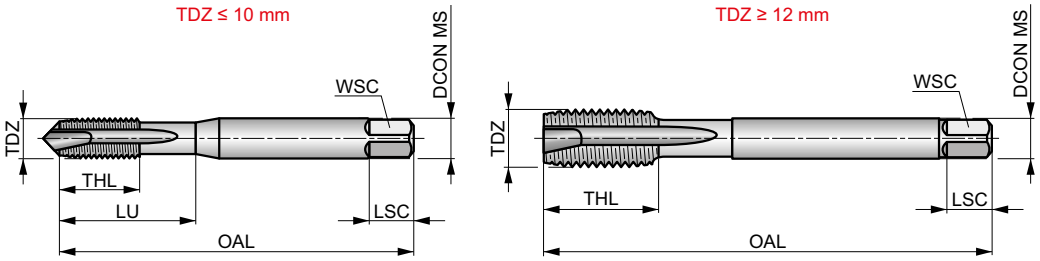
DORMER



HSS-E-PM Spiral Point Machine Tap, Metric Fine, ISO Standard

Machine tap with spiral point suited for through holes only. Steam tempered surface acts to retain cutting fluid and prevent chip to tool welding.

MF	ISO 529	6H
2.5×D		HSS-E PM
B 3.5-5		R
ST		



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P2.2	P2.3	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1	M2.2	M3.1	M3.2	M3.3
◪22	◪16	■14	■10	◪9	■8	◪6	◪10	◪8	◪9	◪7	◪7	◪6	◪5

M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K3.1	K3.2	K4.1	K4.2	K5.1	K5.2
◪4	◪13	◪10	◪7	◪16	◪13	◪14	◪10	◪13	◪9	◪15	◪11

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E011M4X.5	4	0.50	53.0	17	4.00	3.15	6	3	3.50	17.00
E011M5X.5	5	0.50	58.0	11	5.00	4.00	7	3	4.50	22.00
E011M6X.5	6	0.50	66.0	13	6.30	5.00	8	3	5.50	26.00
E011M6X.75	6	0.75	66.0	13	6.30	5.00	8	3	5.30	26.00
E011M8X.75	8	0.75	72.0	16	8.00	6.30	9	3	7.30	29.00
E011M8X1.0	8	1.00	72.0	16	8.00	6.30	9	3	7.00	29.00
E011M10X1.0	10	1.00	80.0	18	10.00	8.00	11	3	9.00	34.00
E011M10X1.25	10	1.25	80.0	18	10.00	8.00	11	3	8.80	34.00
E011M12X1.0	12	1.00	89.0	22	9.00	7.10	10	3	11.00	–
E011M12X1.25	12	1.25	89.0	22	9.00	7.10	10	3	10.80	–
E011M12X1.5	12	1.50	89.0	22	9.00	7.10	10	3	10.50	–
E011M14X1.0	14	1.00	95.0	24	11.20	9.00	12	3	13.00	–
E011M14X1.25	14	1.25	95.0	24	11.20	9.00	12	3	12.80	–
E011M14X1.5	14	1.50	95.0	24	11.20	9.00	12	3	12.50	–
E011M16X1.0	16	1.00	102.0	24	12.50	10.00	13	3	15.00	–
E011M16X1.5	16	1.50	102.0	24	12.50	10.00	13	3	14.50	–
E011M18X1.0	18	1.00	112.0	29	14.00	11.20	14	4	17.00	–
E011M18X1.5	18	1.50	112.0	29	14.00	11.20	14	4	16.50	–
E011M20X1.0	20	1.00	112.0	29	14.00	11.20	14	4	19.00	–
E011M20X1.5	20	1.50	112.0	29	14.00	11.20	14	4	18.50	–
E011M20X2.0	20	2.00	112.0	29	14.00	11.20	14	4	18.00	–
E011M22X1.5	22	1.50	118.0	29	16.00	12.50	16	4	20.50	–
E011M24X1.5	24	1.50	130.0	35	18.00	14.00	18	4	22.50	–
E011M24X2.0	24	2.00	130.0	35	18.00	14.00	18	4	22.00	–

EX10

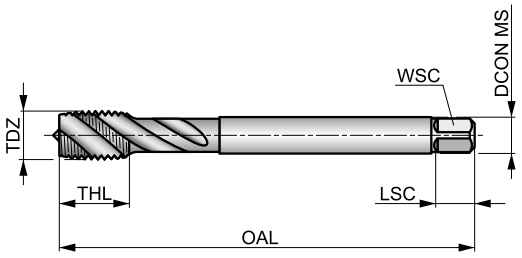
DORMER



HSS-E-PM Spiral Flute Machine Tap, Metric Fine, DIN Standard

Machine tap with spiral flute suited for blind holes. Bright finish to produce more accurate and cleaner threads preventing the workpiece material from sticking to the cutting edges. The reduced shank increases the reach of the tap.

MF	DIN 374	6H
	2.5×D	HSS-E PM
C 2-3		λ 45°
R	Bright	



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3
■21	■23	■24	■17	■15	◪13	■12	◪9	◪7	■13	■9	■6	■27	■24	■17

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]
EX10M4X.50	4	0.50	63.0	7	2.80	2.10	5	3	3.50
EX10M5X.50	5	0.50	70.0	8	3.50	2.70	6	3	4.50
EX10M6X.75	6	0.75	80.0	10	4.50	3.40	6	3	5.30
EX10M8X.75	8	0.75	80.0	13	6.00	4.90	8	3	7.30
EX10M8X1.0	8	1.00	90.0	13	6.00	4.90	8	3	7.00
EX10M10X.75	10	0.75	90.0	13	7.00	5.50	8	3	9.30
EX10M10X1.0	10	1.00	90.0	13	7.00	5.50	8	3	9.00
EX10M10X1.25	10	1.25	100.0	15	7.00	5.50	8	3	8.80
EX10M12X1.0	12	1.00	100.0	15	9.00	7.00	10	3	11.00
EX10M12X1.25	12	1.25	100.0	15	9.00	7.00	10	3	10.80
EX10M12X1.5	12	1.50	100.0	15	9.00	7.00	10	3	10.50
EX10M14X1.0	14	1.00	100.0	15	11.00	9.00	12	3	13.00
EX10M14X1.25	14	1.25	100.0	15	11.00	9.00	12	3	12.80
EX10M14X1.5	14	1.50	100.0	15	11.00	9.00	12	3	12.50
EX10M16X1.0	16	1.00	100.0	15	12.00	9.00	12	4	15.00
EX10M16X1.5	16	1.50	100.0	15	12.00	9.00	12	4	14.50
EX10M18X1.0	18	1.00	110.0	17	14.00	11.00	14	4	17.00
EX10M18X1.5	18	1.50	110.0	17	14.00	11.00	14	4	16.50
EX10M20X1.0	20	1.00	125.0	17	16.00	12.00	15	4	19.00
EX10M20X1.5	20	1.50	125.0	17	16.00	12.00	15	4	18.50
EX10M22X1.5	22	1.50	125.0	17	18.00	14.50	17	4	20.50
EX10M24X1.5	24	1.50	140.0	20	18.00	14.50	17	4	22.50
EX10M24X2.0	24	2.00	140.0	20	18.00	14.50	17	4	22.00
EX10M25X1.5	25	1.50	140.0	20	18.00	14.50	17	4	23.50
EX10M26X1.5	26	1.50	140.0	20	18.00	14.50	17	4	24.50
EX10M27X1.5	27	1.50	140.0	20	20.00	16.00	19	4	25.50
EX10M27X2.0	27	2.00	140.0	20	20.00	16.00	19	4	25.00
EX10M28X1.5	28	1.50	140.0	20	20.00	16.00	19	4	26.50
EX10M30X1.5	30	1.50	150.0	20	22.00	18.00	21	4	28.50
EX10M30X2.0	30	2.00	150.0	20	22.00	18.00	21	4	28.00

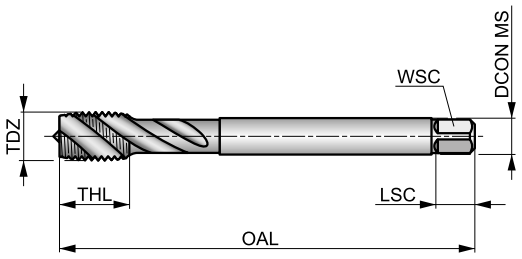
EX10TIN

DORMER



HSS-E-PM Spiral Flute Machine Tap, Metric Fine, TiN Coating, DIN Standard

High performance machine tap with spiral flute for blind holes. Suited for a broad range of workpiece materials. TiN coated to allow higher cutting speeds, improve performance and extend tool life. The reduced shank increases the reach of the tap.



MF	DIN 374	6H
	2.5×D	HSS-E PM
C 2-3		λ 45°
R	TiN	

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1
■32	■36	■37	■27	■23	■19	■18	■13	◪11	■10	◪8	■10	■8	■9

M2.2	M3.1	M3.2	M3.3	M4.1	N2.1	N2.2	N2.3
■7	■7	■6	◪5	◪4	■35	■32	■23

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]
EX10TINM8X1.0	8	1.00	90.0	13	6.00	4.90	8	3	7.00
EX10TINM10X1.0	10	1.00	90.0	13	7.00	5.50	8	3	9.00
EX10TINM10X1.25	10	1.25	100.0	15	7.00	5.50	8	3	8.80
EX10TINM12X1.0	12	1.00	100.0	15	9.00	7.00	10	3	11.00
EX10TINM12X1.25	12	1.25	100.0	15	9.00	7.00	10	3	10.80
EX10TINM12X1.5	12	1.50	100.0	15	9.00	7.00	10	3	10.50
EX10TINM14X1.5	14	1.50	100.0	15	11.00	9.00	12	3	12.50
EX10TINM16X1.5	16	1.50	100.0	15	12.00	9.00	12	4	14.50
EX10TINM18X1.5	18	1.50	110.0	17	14.00	11.00	14	4	16.50
EX10TINM20X1.5	20	1.50	125.0	17	16.00	12.00	15	4	18.50

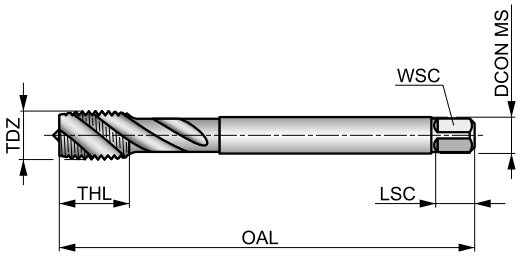
EX11

DORMER



HSS-E-PM Spiral Flute Machine Tap, Metric Fine, DIN Standard

Machine tap with spiral flute suited for blind holes. Steam tempered surface acts to retain cutting fluid and prevent chip to tool welding. The reduced shank increases the reach of the tap.



MF	DIN 374	6H
	2.5×D	HSS-E PM
C 2-3		λ 45°
R	ST	

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P2.2	P2.3	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1	M2.2	M3.1	M3.2	M3.3	M4.1
◪21	◪15	■13	■9	◪8	■7	◪5	◪8	◪6	◪7	◪5	◪5	◪4	◪3	◪3

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]
EX11M4X.50	4	0.50	63.0	7	2.80	2.10	5	3	3.50
EX11M5X.50	5	0.50	70.0	8	3.50	2.70	6	3	4.50
EX11M6X.75	6	0.75	80.0	10	4.50	3.40	6	3	5.30
EX11M8X.75	8	0.75	80.0	13	6.00	4.90	8	3	7.30
EX11M8X1.0	8	1.00	90.0	13	6.00	4.90	8	3	7.00
EX11M10X.75	10	0.75	90.0	13	7.00	5.50	8	3	9.30
EX11M10X1.0	10	1.00	90.0	13	7.00	5.50	8	3	9.00
EX11M10X1.25	10	1.25	100.0	15	7.00	5.50	8	3	8.80
EX11M12X1.0	12	1.00	100.0	15	9.00	7.00	10	3	11.00
EX11M12X1.25	12	1.25	100.0	15	9.00	7.00	10	3	10.80
EX11M12X1.5	12	1.50	100.0	15	9.00	7.00	10	3	10.50
EX11M14X1.0	14	1.00	100.0	15	11.00	9.00	12	3	13.00
EX11M14X1.25	14	1.25	100.0	15	11.00	9.00	12	3	12.80
EX11M14X1.5	14	1.50	100.0	15	11.00	9.00	12	3	12.50
EX11M16X1.0	16	1.00	100.0	15	12.00	9.00	12	4	15.00
EX11M16X1.5	16	1.50	100.0	15	12.00	9.00	12	4	14.50
EX11M18X1.0	18	1.00	110.0	17	14.00	11.00	14	4	17.00
EX11M18X1.5	18	1.50	110.0	17	14.00	11.00	14	4	16.50
EX11M20X1.0	20	1.00	125.0	17	16.00	12.00	15	4	19.00
EX11M20X1.5	20	1.50	125.0	17	16.00	12.00	15	4	18.50
EX11M22X1.5	22	1.50	125.0	17	18.00	14.50	17	4	20.50
EX11M24X1.5	24	1.50	140.0	20	18.00	14.50	17	4	22.50
EX11M24X2.0	24	2.00	140.0	20	18.00	14.50	17	4	22.00
EX11M25X1.5	25	1.50	140.0	20	18.00	14.50	17	4	23.50
EX11M26X1.5	26	1.50	140.0	20	18.00	14.50	17	4	24.50
EX11M27X1.5	27	1.50	140.0	20	20.00	16.00	19	4	25.50
EX11M27X2.0	27	2.00	140.0	20	20.00	16.00	19	4	25.00
EX11M28X1.5	28	1.50	140.0	20	20.00	16.00	19	4	26.50
EX11M30X1.5	30	1.50	150.0	20	22.00	18.00	21	4	28.50
EX11M30X2.0	30	2.00	150.0	20	22.00	18.00	21	4	28.00

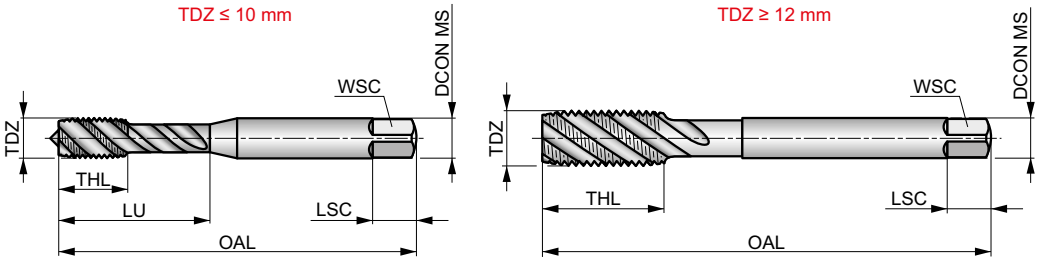
E013

DORMER



HSS-E-PM Spiral Flute Machine Tap, Metric Fine, ISO Standard

Machine tap with spiral flute suited for blind holes. Steam tempered surface acts to retain cutting fluid and prevent chip to tool welding.



MF	ISO 529	6H
	2.5×D	HSS-E PM
C 2-3		λ 45°
R	ST	

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P2.2	P2.3	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1	M2.2	M3.1	M3.2	M3.3	M4.1
◪21	◪15	■13	■9	◪8	■7	◪5	◪8	◪6	◪7	◪5	◪5	◪4	◪3	◪3

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E013M4X.5	4	0.50	53.0	7	4.00	3.15	6	3	3.50	19.00
E013M5X.5	5	0.50	58.0	8	5.00	4.00	7	3	4.50	22.00
E013M6X.5	6	0.50	66.0	10	6.30	5.00	8	3	5.50	27.00
E013M6X.75	6	0.75	66.0	10	6.30	5.00	8	3	5.30	27.00
E013M8X.75	8	0.75	72.0	12	8.00	6.30	9	3	7.30	31.00
E013M8X1.0	8	1.00	72.0	12	8.00	6.30	9	3	7.00	31.00
E013M10X1.0	10	1.00	80.0	15	10.00	8.00	11	3	9.00	35.00
E013M10X1.25	10	1.25	80.0	15	10.00	8.00	11	3	8.80	35.00
E013M12X1.0	12	1.00	89.0	16	9.00	7.10	10	3	11.00	–
E013M12X1.25	12	1.25	89.0	16	9.00	7.10	10	3	10.80	–
E013M12X1.5	12	1.50	89.0	16	9.00	7.10	10	3	10.50	–
E013M14X1.5	14	1.50	95.0	18	11.20	9.00	12	3	12.50	–
E013M16X1.0	16	1.00	102.0	18	12.50	10.00	13	4	15.00	–
E013M16X1.5	16	1.50	102.0	18	12.50	10.00	13	4	14.50	–
E013M18X1.5	18	1.50	112.0	29	14.00	11.20	14	4	16.50	–
E013M20X1.5	20	1.50	112.0	29	14.00	11.20	14	4	18.50	–
E013M22X1.5	22	1.50	118.0	29	16.00	12.50	16	4	20.50	–

E288

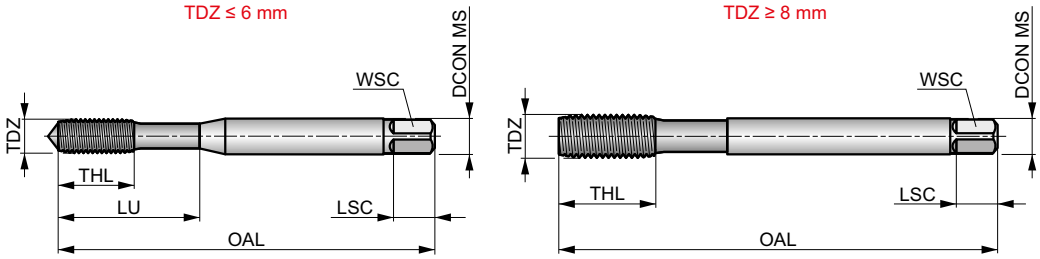
DORMER



HSS-E Fluteless Machine Tap, Metric Fine with TiN Coating, DIN Standard

High performance fluteless tap to produce high quality thread in blind and through holes. Provides a strong, clean, chip-free and accurate thread with excellent tolerance. Highly versatile for steel, stainless steel and non-ferrous metal. TiN coated for higher cutting speeds, improve performance and tool life.

MF	DIN 2174	6HX
	3×D	HSS-E
C 2-3.5		R
TiN		



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P3.1	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1	M2.2
■45	■51	■51	■51	■45	■29	■24	◪18	■18	◪13	■25	■21	■22	■18

M3.1	M3.2	M3.3	M4.1	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.3
■17	■15	◪12	◪8	■55	■41	■28	■62	■55	■40	◪36	◪12

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E288M5X.5	5	0.50	70.0	13	6.00	4.90	8	5	4.80	25.00
E288M6X.75	6	0.75	80.0	15	6.00	4.90	8	5	5.70	30.00
E288M8X1.0	8	1.00	90.0	18	6.00	4.90	8	5	7.50	–
E288M10X1.0	10	1.00	90.0	20	7.00	5.50	8	5	9.50	–
E288M10X1.25	10	1.25	100.0	20	7.00	5.50	8	5	9.40	–
E288M12X1.5	12	1.50	100.0	21	9.00	7.00	10	5	11.30	–

E108

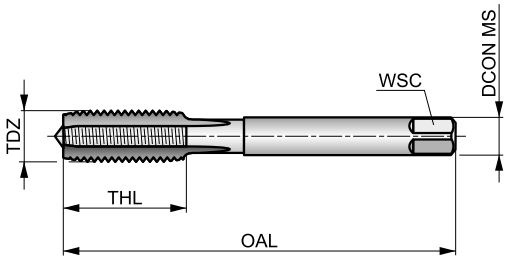
DORMER



HSS Straight Flute Serial Hand Tap, UNC, DIN Standard

Ideal for hand tapping tough materials. The straight flute design makes it ideal for both through and blind holes. Available as a single finishing tap or as a set of three serial taps, which should be used one after the other to create the full thread.

UNC	DIN 352	2B
	1.5×D	HSS
C 2-3		R
Bright		



Workpiece material group suitability.

P1.1 ■	P1.2 ■	P1.3 ■	P2.1 ■	P2.2 ■	P2.3 ◪	P3.1 ■	P3.2 ◪	P4.1 ◪	K1.1 ◪	K1.2 ◪	K1.3 ◪	K2.1 ◪	K2.2 ◪
K3.1 ◪	K3.2 ◪	K4.1 ◪	K4.2 ◪	K5.1 ◪	K5.2 ◪	N1.1 ■	N1.2 ■	N1.3 ■	N2.1 ■	N2.2 ■	N2.3 ■	N3.1 ■	N3.2 ■
N3.3 ■	N4.2 ■	N4.3 ■											

Product	TDZ	TPI	TD [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	NOF	PHD [mm]
E1085-40N03	5	40	3.180	45.0	13	4.00	3.00	3	2.65
E1085-40N08	5	40	3.180	45.0	13	4.00	3.00	3	2.65
E1086-32N03	6	32	3.510	45.0	10	4.00	3.00	3	2.85
E1086-32N08	6	32	3.510	45.0	10	4.00	3.00	3	2.85
E1088-32N03	8	32	4.170	50.0	14	6.00	4.90	3	3.50
E1088-32N08	8	32	4.170	50.0	14	6.00	4.90	3	3.50
E10810-24N03	10	24	4.830	50.0	14	6.00	4.90	3	3.90
E10810-24N08	10	24	4.830	50.0	14	6.00	4.90	3	3.90
E10812-24N03	12	24	5.490	56.0	16	6.00	4.90	3	4.50
E10812-24N08	12	24	5.490	56.0	16	6.00	4.90	3	4.50
E1081/4N03	1/4	20	6.350	56.0	17	6.00	4.90	3	5.10
E1081/4N08	1/4	20	6.350	56.0	17	6.00	4.90	3	5.10
E1085/16N03	5/16	18	7.940	63.0	19	6.00	4.90	3	6.60
E1085/16N08	5/16	18	7.940	63.0	19	6.00	4.90	3	6.60
E1083/8N03	3/8	16	9.530	70.0	22	7.00	5.50	3	8.00
E1083/8N08	3/8	16	9.530	70.0	22	7.00	5.50	3	8.00
E1087/16N03	7/16	14	11.110	75.0	30	8.00	6.20	3	9.40
E1087/16N08	7/16	14	11.110	75.0	30	8.00	6.20	3	9.40
E1081/2N03	1/2	13	12.700	75.0	27	9.00	7.00	3	10.80
E1081/2N08	1/2	13	12.700	75.0	27	9.00	7.00	3	10.80
E1089/16N03	9/16	12	14.290	80.0	30	11.00	9.00	4	12.20
E1089/16N08	9/16	12	14.290	80.0	30	11.00	9.00	4	12.20
E1085/8N03	5/8	11	15.880	80.0	32	12.00	9.00	4	13.50
E1085/8N08	5/8	11	15.880	80.0	32	12.00	9.00	4	13.50
E1083/4N03	3/4	10	19.050	95.0	34	14.00	11.00	4	16.50
E1083/4N08	3/4	10	19.050	95.0	34	14.00	11.00	4	16.50
E1087/8N03	7/8	9	22.230	110.0	38	18.00	14.50	4	19.50
E1087/8N08	7/8	9	22.230	110.0	38	18.00	14.50	4	19.50
E1081N08	1″	8	25.400	110.0	38	20.00	16.00	4	22.25

E225

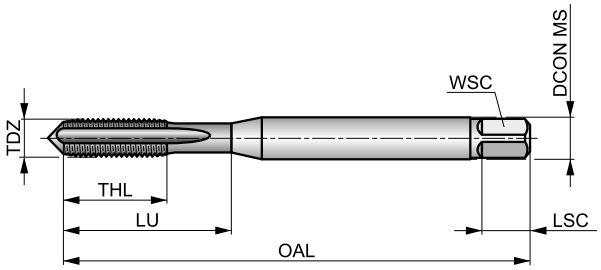
DORMER



HSS-E-PM Straight Flute Machine Tap, UNC, DIN Standard

General purpose straight flute machine tap for through and blind holes. Bright finish to produce more accurate and cleaner threads preventing the workpiece material from sticking to the cutting edges. The reinforced shank increases strength against torsional twist.

UNC	DIN 371	2B
	1.5×D	HSS-E PM
C 2-3		R
Bright		



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	K1.1	K1.2	K1.3	K2.1	K2.2
■11	■12	■12	■9	■8	◪7	■7	◪6	◪4	◪13	◪10	◪8	◪14	◪11

K3.1	K3.2	K4.1	K4.2	K5.1	K5.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N4.2
◪13	◪10	◪12	◪9	◪12	◪10	◪12	◪15	◪14	◪11	◪21	■14	◪8

Product	TDZ	TPI	TD [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	LSC [mm]	NOF	PHD [mm]	LU [mm]
E2254-40	4	40	2.845	56.0	9	3.50	2.70	6	3	2.35	18.00
E2255-40	5	40	3.175	56.0	10	3.50	2.70	6	3	2.65	18.00
E2256-32	6	32	3.505	56.0	11	4.00	3.00	6	3	2.85	20.00
E2258-32	8	32	4.166	63.0	12	4.50	3.40	8	3	3.50	21.00
E22510-24	10	24	4.826	70.0	13	6.00	4.90	8	3	3.90	25.00
E22512-24	12	24	5.486	80.0	15	6.00	4.90	8	3	4.50	30.00
E2251/4	1/4	20	6.350	80.0	16	7.00	5.50	8	3	5.10	30.00

E275

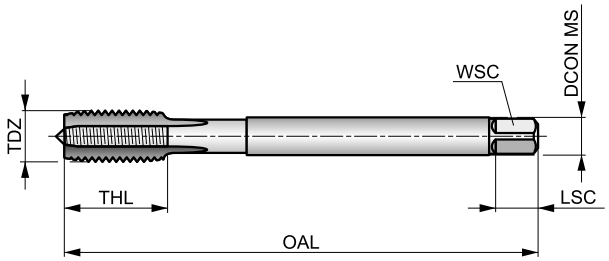
DORMER



HSS-E-PM Straight Flute Machine Tap, UNC, DIN Standard

General purpose straight flute machine tap for through and blind holes. Bright finish to produce more accurate and cleaner threads preventing the workpiece material from sticking to the cutting edges. The reduced shank increases the reach of the tap.

UNC	DIN 376	2B
	1.5×D	HSS-E PM
C 2-3		R
Bright		



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	K1.1	K1.2	K1.3	K2.1	K2.2
■11	■12	■12	■9	■8	◪7	■7	◪6	◪4	◪13	◪10	◪8	◪14	◪11

K3.1	K3.2	K4.1	K4.2	K5.1	K5.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N4.2
◪13	◪10	◪12	◪9	◪12	◪10	◪12	◪15	◪14	◪11	◪21	■14	◪8

Product	TDZ	TPI	TD [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	LSC [mm]	NOF	PHD [mm]
E2755/16	5/16	18	7.940	90.0	18	6.00	4.90	8	3	6.60
E2753/8	3/8	16	9.530	100.0	24	7.00	5.50	8	3	8.00
E2757/16	7/16	14	11.110	110.0	23	9.00	7.00	10	3	9.40
E2751/2	1/2	13	12.700	110.0	23	9.00	7.00	10	3	10.80
E2759/16	9/16	12	14.290	110.0	25	11.00	9.00	12	3	12.20
E2755/8	5/8	11	15.880	110.0	25	12.00	9.00	12	4	13.50
E2753/4	3/4	10	19.050	140.0	34	14.00	11.00	14	4	16.50
E2757/8	7/8	9	22.230	140.0	34	18.00	14.50	17	4	19.50
E2751	1″	8	25.400	160.0	38	20.00	16.00	19	4	22.25
E2751.1/8	1.1/8	7	28.580	180.0	45	22.00	18.00	21	4	25.00
E2751.1/4	1.1/4	7	31.750	180.0	50	25.00	20.00	23	4	28.00
E2751.1/2	1.1/2	6	38.100	200.0	60	32.00	24.00	27	4	34.00

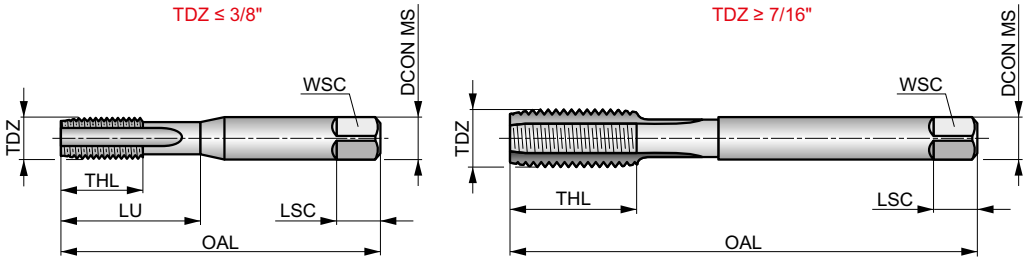
E515

DORMER



HSS Straight Flute Hand Tap, UNC, ISO Standard

A versatile tool, suitable for hand and machine tapping. With a straight flute design for both through and blind holes. Available as a set of three N06 or as separate taps with taper lead N01 for short through holes, plug lead N02 for deeper through holes or bottoming lead N03 for blind holes.



UNC	ISO 529	2B
	1.5×D	HSS
	R	Bright

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	K1.1	K1.2	K1.3	K2.1	K2.2
■7	■7	■8	■6	■5	◪4	■4	◪4	◪3	◪12	◪9	◪7	◪12	◪10

K3.1	K3.2	K4.1	K4.2	K5.1	K5.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	N4.2
◪11	◪8	◪10	◪8	◪11	◪9	◪8	◪11	◪10	◪7	■17	■10	◪5	◪5

N4.3
◪3

Products from this series are also available in set with dies. Please see L120.

Product	TDZ	TPI	TD [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	LSC [mm]	NOF	PHD [mm]	LU [mm]
E5151-64N01	1	64	1.854	41.0	8	2.50	2.00	4	2	1.55	8.00
E5151-64N02	1	64	1.854	41.0	8	2.50	2.00	4	2	1.55	8.00
E5151-64N03	1	64	1.854	41.0	8	2.50	2.00	4	2	1.55	8.00
E5151-64N06	1	64	1.854	41.0	8	2.50	2.00	4	2	1.55	8.00
E5152-56N01	2	56	2.184	44.5	9.5	2.80	2.24	5	3	1.85	9.50
E5152-56N02	2	56	2.184	44.5	9.5	2.80	2.24	5	3	1.85	9.50
E5152-56N03	2	56	2.184	44.5	9.5	2.80	2.24	5	3	1.85	9.50
E5152-56N06	2	56	2.184	44.5	9.5	2.80	2.24	5	3	1.85	9.50
E5153-48N01	3	48	2.515	44.5	9.5	2.80	2.24	5	3	2.10	9.50
E5153-48N02	3	48	2.515	44.5	9.5	2.80	2.24	5	3	2.10	9.50
E5153-48N03	3	48	2.515	44.5	9.5	2.80	2.24	5	3	2.10	9.50
E5153-48N06	3	48	2.515	44.5	9.5	2.80	2.24	5	3	2.10	9.50
E5154-40N01	4	40	2.845	48.0	12.5	3.15	2.50	5	3	2.35	12.50
E5154-40N02	4	40	2.845	48.0	12.5	3.15	2.50	5	3	2.35	12.50
E5154-40N03	4	40	2.845	48.0	12.5	3.15	2.50	5	3	2.35	12.50
E5154-40N06	4	40	2.845	48.0	12.5	3.15	2.50	5	3	2.35	12.50
E5155-40N01	5	40	3.175	48.0	12.5	3.15	2.50	5	3	2.65	12.50
E5155-40N02	5	40	3.175	48.0	12.5	3.15	2.50	5	3	2.65	12.50
E5155-40N03	5	40	3.175	48.0	12.5	3.15	2.50	5	3	2.65	12.50
E5155-40N06	5	40	3.175	48.0	12.5	3.15	2.50	5	3	2.65	12.50
E5156-32N01	6	32	3.505	50.0	14	3.55	2.80	5	3	2.85	14.00
E5156-32N02	6	32	3.505	50.0	14	3.55	2.80	5	3	2.85	14.00
E5156-32N03	6	32	3.505	50.0	14	3.55	2.80	5	3	2.85	14.00
E5156-32N06	6	32	3.505	50.0	14	3.55	2.80	5	3	2.85	14.00
E5158-32N01	8	32	4.166	53.0	9.5	4.50	3.55	6	3	3.50	17.00
E5158-32N02	8	32	4.166	53.0	9.5	4.50	3.55	6	3	3.50	17.00
E5158-32N03	8	32	4.166	53.0	9.5	4.50	3.55	6	3	3.50	17.00

Product	TDZ	TPI	TD	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
			[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E5158-32N06	8	32	4.166	53.0	9.5	4.50	3.55	6	3	3.50	17.00
E51510-24N01	10	24	4.826	58.0	11	5.00	4.00	7	3	3.90	20.00
E51510-24N02	10	24	4.826	58.0	11	5.00	4.00	7	3	3.90	20.00
E51510-24N03	10	24	4.826	58.0	11	5.00	4.00	7	3	3.90	20.00
E51510-24N06	10	24	4.826	58.0	11	5.00	4.00	7	3	3.90	20.00
E51512-24N01	12	24	5.486	62.0	12	5.60	4.50	7	3	4.50	21.00
E51512-24N02	12	24	5.486	62.0	12	5.60	4.50	7	3	4.50	21.00
E51512-24N03	12	24	5.486	62.0	12	5.60	4.50	7	3	4.50	21.00
E51512-24N06	12	24	5.486	62.0	12	5.60	4.50	7	3	4.50	21.00
E5151/4N01	1/4	20	6.350	66.0	13	6.30	5.00	8	3	5.10	26.00
E5151/4N02	1/4	20	6.350	66.0	13	6.30	5.00	8	3	5.10	26.00
E5151/4N03	1/4	20	6.350	66.0	13	6.30	5.00	8	3	5.10	26.00
E5151/4N06	1/4	20	6.350	66.0	13	6.30	5.00	8	3	5.10	26.00
E5155/16N01	5/16	18	7.938	72.0	16	8.00	6.30	9	3	6.60	29.00
E5155/16N02	5/16	18	7.938	72.0	16	8.00	6.30	9	3	6.60	29.00
E5155/16N03	5/16	18	7.938	72.0	16	8.00	6.30	9	3	6.60	29.00
E5155/16N06	5/16	18	7.938	72.0	16	8.00	6.30	9	3	6.60	29.00
E5153/8N01	3/8	16	9.525	80.0	18	10.00	8.00	11	3	8.00	32.00
E5153/8N02	3/8	16	9.525	80.0	18	10.00	8.00	11	3	8.00	32.00
E5153/8N03	3/8	16	9.525	80.0	18	10.00	8.00	11	3	8.00	32.00
E5153/8N06	3/8	16	9.525	80.0	18	10.00	8.00	11	3	8.00	32.00
E5157/16N01	7/16	14	11.112	85.0	19	8.00	6.30	9	3	9.40	–
E5157/16N02	7/16	14	11.112	85.0	19	8.00	6.30	9	3	9.40	–
E5157/16N03	7/16	14	11.112	85.0	19	8.00	6.30	9	3	9.40	–
E5157/16N06	7/16	14	11.112	85.0	19	8.00	6.30	9	3	9.40	–
E5151/2N01	1/2	13	12.700	89.0	22	9.00	7.10	10	3	10.80	–
E5151/2N02	1/2	13	12.700	89.0	22	9.00	7.10	10	3	10.80	–
E5151/2N03	1/2	13	12.700	89.0	22	9.00	7.10	10	3	10.80	–
E5151/2N06	1/2	13	12.700	89.0	22	9.00	7.10	10	3	10.80	–
E5159/16N01	9/16	12	14.288	95.0	24	11.20	9.00	12	4	12.20	–
E5159/16N02	9/16	12	14.288	95.0	24	11.20	9.00	12	4	12.20	–
E5159/16N03	9/16	12	14.288	95.0	24	11.20	9.00	12	4	12.20	–
E5159/16N06	9/16	12	14.288	95.0	24	11.20	9.00	12	4	12.20	–
E5155/8N01	5/8	11	15.875	102.0	24	12.50	10.00	13	4	13.50	–
E5155/8N02	5/8	11	15.875	102.0	24	12.50	10.00	13	4	13.50	–
E5155/8N03	5/8	11	15.875	102.0	24	12.50	10.00	13	4	13.50	–
E5155/8N06	5/8	11	15.875	102.0	24	12.50	10.00	13	4	13.50	–
E5153/4N01	3/4	10	19.050	112.0	29	14.00	11.20	14	4	16.50	–
E5153/4N02	3/4	10	19.050	112.0	29	14.00	11.20	14	4	16.50	–
E5153/4N03	3/4	10	19.050	112.0	29	14.00	11.20	14	4	16.50	–
E5153/4N06	3/4	10	19.050	112.0	29	14.00	11.20	14	4	16.50	–
E5157/8N01	7/8	9	22.225	118.0	29	16.00	12.50	16	4	19.50	–
E5157/8N02	7/8	9	22.225	118.0	29	16.00	12.50	16	4	19.50	–
E5157/8N03	7/8	9	22.225	118.0	29	16.00	12.50	16	4	19.50	–
E5157/8N06	7/8	9	22.225	118.0	29	16.00	12.50	16	4	19.50	–
E5151N03	1″	8	25.400	130.0	35	18.00	14.00	18	4	22.25	–
E5151N01	1″	8	25.400	130.0	35	18.00	14.00	18	4	22.25	–
E5151N02	1″	8	25.400	130.0	35	18.00	14.00	18	4	22.25	–
E5151N06	1″	8	25.400	130.0	35	18.00	14.00	18	4	22.25	–
E5151.1/8N01	1.1/8	7	28.575	138.0	35	20.00	16.00	20	4	25.00	–
E5151.1/8N02	1.1/8	7	28.575	138.0	35	20.00	16.00	20	4	25.00	–
E5151.1/8N03	1.1/8	7	28.575	138.0	35	20.00	16.00	20	4	25.00	–
E5151.1/4N01	1.1/4	7	31.750	151.0	41	22.40	18.00	22	4	28.00	–
E5151.1/4N02	1.1/4	7	31.750	151.0	41	22.40	18.00	22	4	28.00	–
E5151.1/4N03	1.1/4	7	31.750	151.0	41	22.40	18.00	22	4	28.00	–
E5151.3/8N01	1.3/8	6	34.925	162.0	47	25.00	20.00	24	4	30.75	–
E5151.3/8N02	1.3/8	6	34.925	162.0	47	25.00	20.00	24	4	30.75	–
E5151.3/8N03	1.3/8	6	34.925	162.0	47	25.00	20.00	24	4	30.75	–
E5151.1/2N01	1.1/2	6	38.100	170.0	47	28.00	22.40	26	4	34.00	–
E5151.1/2N02	1.1/2	6	38.100	170.0	47	28.00	22.40	26	4	34.00	–
E5151.1/2N03	1.1/2	6	38.100	170.0	47	28.00	22.40	26	4	34.00	–
E5151.3/4N01	1.3/4	5	44.450	187.0	54	31.50	25.00	28	6	39.50	–
E5151.3/4N02	1.3/4	5	44.450	187.0	54	31.50	25.00	28	6	39.50	–
E5151.3/4N03	1.3/4	5	44.450	187.0	54	31.50	25.00	28	6	39.50	–
E5152N03	2″	4.5	50.800	200.0	60	35.50	28.00	31	6	45.00	–
E5152N01	2″	4.5	50.800	200.0	60	35.50	28.00	31	6	45.00	–
E5152N02	2″	4.5	50.800	200.0	60	35.50	28.00	31	6	45.00	–

EP20

DORMER

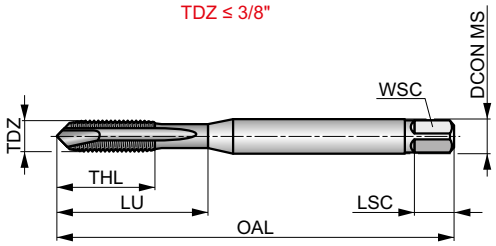


HSS-E-PM Spiral Point Machine Tap, UNC, DIN Standard

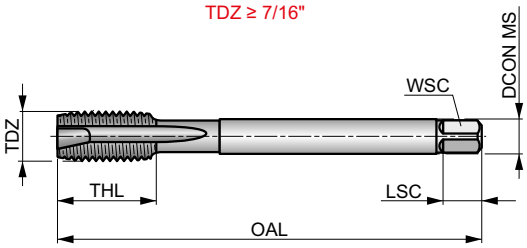
Machine tap with spiral point suited for through holes only. Bright finish to produce more accurate and cleaner threads preventing the workpiece material from sticking to the cutting edges.

UNC	DIN 2184-1	2B
2.5×D		HSS-E PM
B 3.5-5		R
Bright		

TDZ ≤ 3/8"



TDZ ≥ 7/16"



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	N1.1	N1.2	N1.3	N2.1	N2.2
■ 22	■ 24	■ 25	■ 18	■ 16	◪ 14	■ 13	◪ 10	◪ 8	■ 14	■ 10	■ 7	■ 28	■ 25

N2.3	N3.1	N3.2	N3.3	N4.1
■ 18	■ 44	◪ 27	◪ 13	◪ 22

Product	TDZ	TPI	TD [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	LSC [mm]	NOF	PHD [mm]	LU [mm]
EP204-40	4	40	2.845	56.0	9	3.50	2.70	6	3	2.35	18.00
EP205-40	5	40	3.175	56.0	10	3.50	2.70	6	3	2.65	18.00
EP206-32	6	32	3.505	56.0	11	4.00	3.00	6	3	2.85	20.00
EP208-32	8	32	4.166	63.0	12	4.50	3.40	8	3	3.50	21.00
EP2010-24	10	24	4.826	70.0	13	6.00	4.90	8	3	3.90	25.00
EP2012-24	12	24	5.486	80.0	15	6.00	4.90	8	3	4.50	30.00
EP201/4	1/4	20	6.350	80.0	15	7.00	5.50	8	3	5.10	30.00
EP205/16	5/16	18	7.938	90.0	18	8.00	6.20	9	3	6.60	35.00
EP203/8	3/8	16	9.525	100.0	20	10.00	8.00	11	3	8.00	39.00
EP207/16	7/16	14	11.112	100.0	20	8.00	6.20	9	3	9.40	–
EP201/2	1/2	13	12.700	110.0	23	9.00	7.00	10	3	10.80	–
EP205/8	5/8	11	15.875	110.0	25	12.00	9.00	12	3	13.50	–
EP203/4	3/4	10	19.050	125.0	30	14.00	11.00	14	4	16.50	–
EP207/8	7/8	9	22.225	140.0	34	18.00	14.50	17	4	19.50	–
EP201	1″	8	25.400	160.0	38	18.00	14.50	17	4	22.25	–

EP21

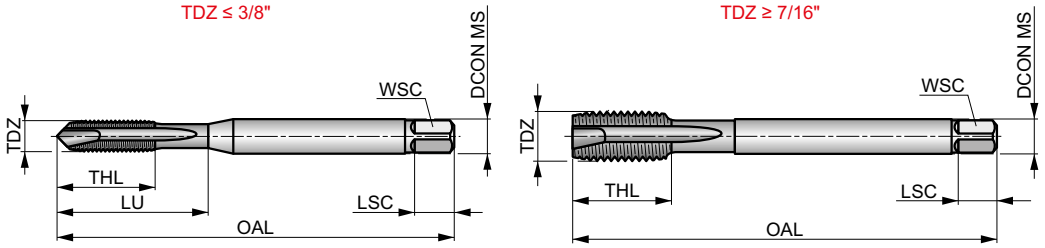
DORMER



HSS-E-PM Spiral Point Machine Tap, UNC, DIN Standard

Machine tap with spiral point suited for through holes only. Steam tempered surface acts to retain cutting fluid and prevent chip to tool welding.

UNC	DIN 2184-1	2B
	2.5×D	HSS-E PM
B 3.5-5		R
ST		



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P2.2	P2.3	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1	M2.2	M3.1	M3.2	M3.3
◪22	◪16	■14	■10	◪9	■8	◪6	◪10	◪8	◪9	◪7	◪7	◪6	◪5

M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K3.1	K3.2	K4.1	K4.2	K5.1	K5.2
◪4	◪13	◪10	◪7	◪16	◪13	◪14	◪10	◪13	◪9	◪15	◪11

Product	TDZ	TPI	TD [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	LSC [mm]	NOF	PHD [mm]	LU [mm]
EP214-40	4	40	2.845	56.0	9	3.50	2.70	6	3	2.35	18.00
EP215-40	5	40	3.175	56.0	10	3.50	2.70	6	3	2.65	18.00
EP216-32	6	32	3.505	56.0	11	4.00	3.00	6	3	2.85	20.00
EP218-32	8	32	4.166	63.0	12	4.50	3.40	8	3	3.50	21.00
EP2110-24	10	24	4.826	70.0	13	6.00	4.90	8	3	3.90	25.00
EP2112-24	12	24	5.486	80.0	15	6.00	4.90	8	3	4.50	30.00
EP211/4	1/4	20	6.350	80.0	15	7.00	5.50	8	3	5.10	30.00
EP215/16	5/16	18	7.938	90.0	18	8.00	6.20	9	3	6.60	35.00
EP213/8	3/8	16	9.525	100.0	20	10.00	8.00	11	3	8.00	39.00
EP217/16	7/16	14	11.112	100.0	20	8.00	6.20	9	3	9.40	–
EP211/2	1/2	13	12.700	110.0	23	9.00	7.00	10	3	10.80	–
EP215/8	5/8	11	15.875	110.0	25	12.00	9.00	12	3	13.50	–
EP213/4	3/4	10	19.050	125.0	30	14.00	11.00	14	4	16.50	–
EP217/8	7/8	9	22.225	140.0	34	18.00	14.50	17	4	19.50	–
EP211	1″	8	25.400	160.0	38	18.00	14.50	17	4	22.25	–

E021

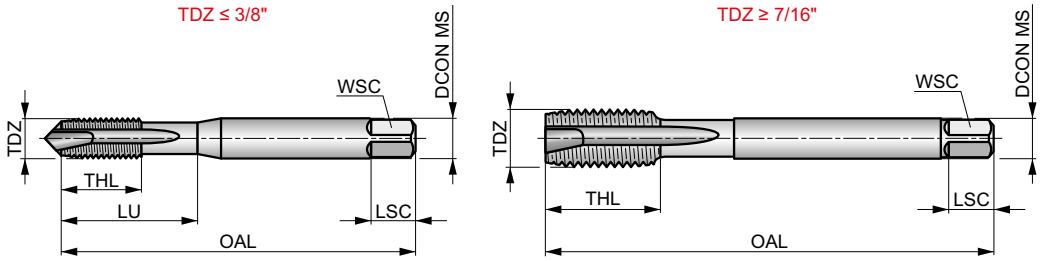
DORMER



HSS-E-PM Spiral Point Machine Tap, UNC, ISO Standard

Machine tap with spiral point suited for through holes only. Steam tempered surface acts to retain cutting fluid and prevent chip to tool welding.

UNC	ISO 529	2B
	2.5×D	HSS-E PM
B 3.5-5		R
ST		



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P2.2	P2.3	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1	M2.2	M3.1	M3.2	M3.3
◪22	◪16	■14	■10	◪9	■8	◪6	◪10	◪8	◪9	◪7	◪7	◪6	◪5

M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K3.1	K3.2	K4.1	K4.2	K5.1	K5.2
◪4	◪13	◪10	◪7	◪16	◪13	◪14	◪10	◪13	◪9	◪15	◪11

Product	TDZ	TPI	TD [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	LSC [mm]	NOF	PHD [mm]	LU [mm]
E0212-56	2	56	2.184	44.5	9.5	2.80	2.24	5	2	1.85	9.50
E0214-40	4	40	2.845	48.0	14	3.15	2.50	5	3	2.35	14.00
E0215-40	5	40	3.175	48.0	12.5	3.15	2.50	5	3	2.65	12.50
E0216-32	6	32	3.505	50.0	16	3.55	2.80	5	3	2.85	16.00
E0218-32	8	32	4.166	53.0	9.5	4.50	3.55	6	3	3.50	17.00
E02110-24	10	24	4.826	58.0	11	5.00	4.00	7	3	3.90	20.00
E02112-24	12	24	5.486	62.0	12	5.60	4.50	7	3	4.50	21.00
E0211/4	1/4	20	6.350	66.0	13	6.30	5.00	8	3	5.10	26.00
E0215/16	5/16	18	7.938	72.0	16	8.00	6.30	9	3	6.60	29.00
E0213/8	3/8	16	9.525	80.0	18	10.00	8.00	11	3	8.00	32.00
E0217/16	7/16	14	11.112	85.0	19	8.00	6.30	9	3	9.40	–
E0211/2	1/2	13	12.700	89.0	22	9.00	7.10	10	3	10.80	–
E0215/8	5/8	11	15.875	102.0	24	12.50	10.00	13	3	13.50	–
E0213/4	3/4	10	19.050	112.0	29	14.00	11.20	14	4	16.50	–
E0217/8	7/8	9	22.225	118.0	29	16.00	12.50	16	4	19.50	–
E0211	1″	8	25.400	130.0	35	18.00	14.00	18	4	22.25	–

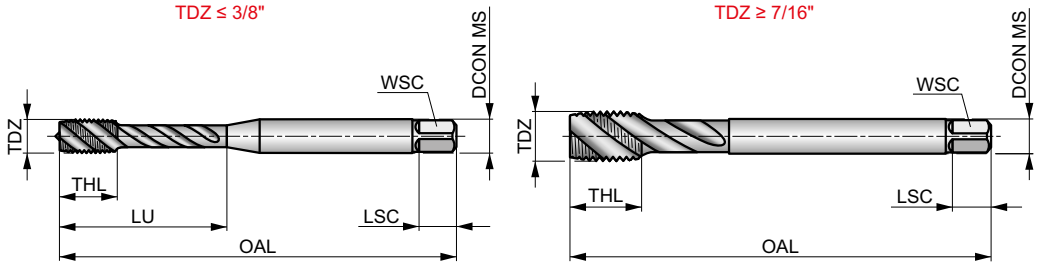
EX20



HSS-E-PM Spiral Flute Machine Tap, UNC, DIN Standard

Machine tap with spiral flute suited for blind holes. Steam tempered surface acts to retain cutting fluid and prevent chip to tool welding.

UNC	DIN 2184-1	2B
	2.5×D	HSS-E PM
C 2-3		λ 45°
R	Bright	



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3
■21	■23	■24	■17	■15	◪13	■12	◪9	◪7	■13	■9	■6	■27	■24	■17

Product	TDZ	TPI	TD	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
			[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
EX204-40	4	40	2.845	56.0	6	3.50	2.70	6	3	2.35	18.00
EX205-40	5	40	3.175	56.0	6	3.50	2.70	6	3	2.65	18.00
EX206-32	6	32	3.505	56.0	7	4.00	3.00	6	3	2.85	20.00
EX208-32	8	32	4.166	63.0	7	4.50	3.40	8	3	3.50	21.00
EX2010-24	10	24	4.826	70.0	8	6.00	4.90	8	3	3.90	25.00
EX2012-24	12	24	5.486	80.0	10	6.00	4.90	8	3	4.50	30.00
EX201/4	1/4	20	6.350	80.0	10	7.00	5.50	8	3	5.10	30.00
EX205/16	5/16	18	7.938	90.0	12	8.00	6.20	9	3	6.60	35.00
EX203/8	3/8	16	9.525	100.0	15	10.00	8.00	11	3	8.00	39.00
EX207/16	7/16	14	11.112	100.0	15	8.00	6.20	9	3	9.40	–
EX201/2	1/2	13	12.700	110.0	18	9.00	7.00	10	3	10.80	–
EX205/8	5/8	11	15.875	110.0	20	12.00	9.00	12	4	13.50	–
EX203/4	3/4	10	19.050	125.0	25	14.00	11.00	14	4	16.50	–
EX207/8	7/8	9	22.225	140.0	25	18.00	14.50	17	4	19.50	–
EX201	1″	8	25.400	160.0	30	18.00	14.50	17	4	22.25	–

EX21

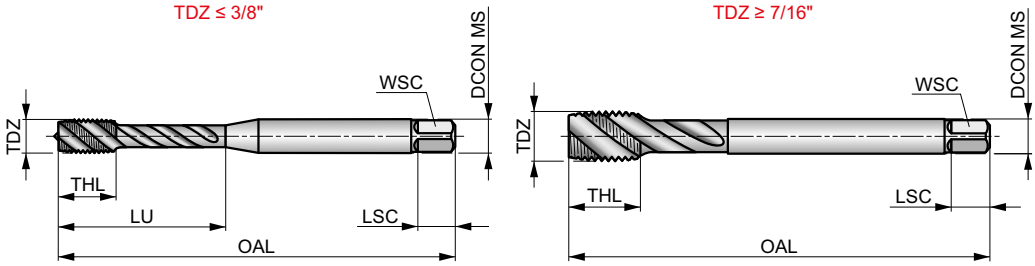
DORMER



HSS-E-PM Spiral Flute Machine Tap, UNC, DIN Standard

Machine tap to produce normal fit threads within 2B tolerance. The spiral flute is suited for blind holes. Steam tempered surface acts to retain cutting fluid and prevent chip to tool welding.

UNC	DIN 2184-1	2B
	2.5×D	HSS-E PM
C 2-3		λ 45°
R	ST	



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P2.2	P2.3	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1	M2.2	M3.1	M3.2	M3.3	M4.1
◪21	◪15	■13	■9	◪8	■7	◪5	◪8	◪6	◪7	◪5	◪5	◪4	◪3	◪3

Product	TDZ	TPI	TD [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	LSC [mm]	NOF	PHD [mm]	LU [mm]
EX214-40	4	40	2.845	56.0	6	3.50	2.70	6	3	2.35	18.00
EX215-40	5	40	3.175	56.0	6	3.50	2.70	6	3	2.65	18.00
EX216-32	6	32	3.505	56.0	7	4.00	3.00	6	3	2.85	20.00
EX218-32	8	32	4.166	63.0	7	4.50	3.40	8	3	3.50	21.00
EX2110-24	10	24	4.826	70.0	8	6.00	4.90	8	3	3.90	25.00
EX2112-24	12	24	5.486	80.0	10	6.00	4.90	8	3	4.50	30.00
EX211/4	1/4	20	6.350	80.0	10	7.00	5.50	8	3	5.10	30.00
EX215/16	5/16	18	7.938	90.0	12	8.00	6.20	9	3	6.60	35.00
EX213/8	3/8	16	9.525	100.0	15	10.00	8.00	11	3	8.00	39.00
EX217/16	7/16	14	11.112	100.0	15	8.00	6.20	9	3	9.40	–
EX211/2	1/2	13	12.700	110.0	18	9.00	7.00	10	3	10.80	–
EX215/8	5/8	11	15.875	110.0	20	12.00	9.00	12	4	13.50	–
EX213/4	3/4	10	19.050	125.0	25	14.00	11.00	14	4	16.50	–
EX217/8	7/8	9	22.225	140.0	25	18.00	14.50	17	4	19.50	–
EX211	1″	8	25.400	160.0	30	18.00	14.50	17	4	22.25	–

E023

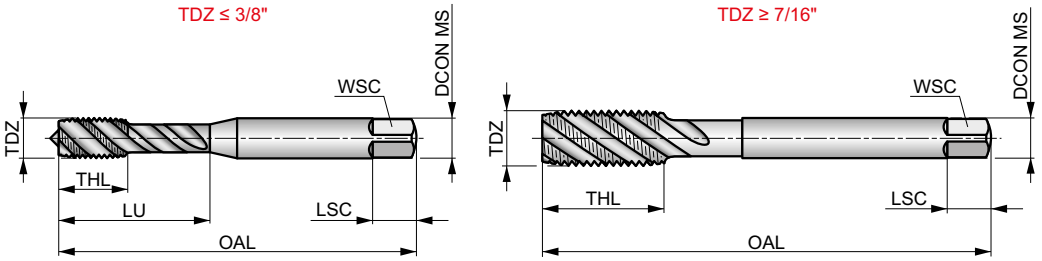
DORMER



HSS-E-PM Spiral Flute Machine Tap, UNC, ISO Standard

Machine tap with spiral flute suited for blind holes. Steam tempered surface acts to retain cutting fluid and prevent chip to tool welding.

UNC	ISO 529	2B
	2.5×D	HSS-E PM
C 2-3		λ 45°
R	ST	



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P2.2	P2.3	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1	M2.2	M3.1	M3.2	M3.3	M4.1
◪21	◪15	■13	■9	◪8	■7	◪5	◪8	◪6	◪7	◪5	◪5	◪4	◪3	◪3

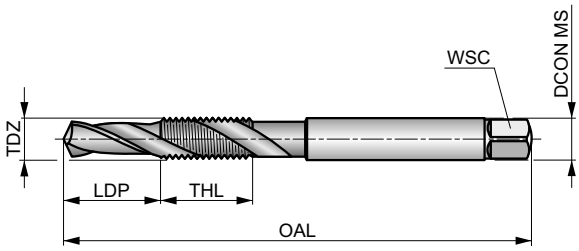
Product	TDZ	TPI	TD [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	LSC [mm]	NOF	PHD [mm]	LU [mm]
E0232-56	2	56	2.184	44.5	9.5	2.80	2.24	5	2	1.85	9.50
E0234-40	4	40	2.845	48.0	6	3.15	2.50	5	3	2.35	14.00
E0235-40	5	40	3.175	48.0	6	3.15	2.50	5	3	2.65	12.50
E0236-32	6	32	3.505	50.0	6	3.55	2.80	5	3	2.85	16.00
E0238-32	8	32	4.166	53.0	7	4.50	3.55	6	3	3.50	17.00
E02310-24	10	24	4.826	58.0	8	5.00	4.00	7	3	3.90	20.00
E02312-24	12	24	5.486	62.0	12	5.60	4.50	7	3	4.50	21.00
E0231/4	1/4	20	6.350	66.0	10	6.30	5.00	8	3	5.10	28.00
E0235/16	5/16	18	7.938	72.0	12	8.00	6.30	9	3	6.60	31.00
E0233/8	3/8	16	9.525	80.0	15	10.00	8.00	11	3	8.00	34.00
E0237/16	7/16	14	11.112	85.0	19	8.00	6.30	9	3	9.40	–
E0231/2	1/2	13	12.700	89.0	19	9.00	7.10	10	3	10.80	–
E0235/8	5/8	11	15.875	102.0	24	12.50	10.00	13	4	13.50	–
E0233/4	3/4	10	19.050	112.0	29	14.00	11.20	14	4	16.50	–
E0237/8	7/8	9	22.225	118.0	29	16.00	12.50	16	4	19.50	–
E0231	1″	8	25.400	130.0	35	18.00	14.00	18	4	22.25	–

E651



HSS Drill-Tap Combination Tool with 30° Spiral Flute, UNC, DIN Standard

Combination of a core-hole drill and tap to produce a thread in one pass. This significantly reduces the time needed to produce the thread on site with the use of a hand-held power tool. There is no need for a tap wrench or tool change. Steam tempered surface acts to retain the lubricant and provide smoother cutting.



UNC	DIN DORMER	2B
	1.5×D	HSS
C 2-3		λ 30°
R	ST	

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P3.1	P3.2	N1.2	N1.3	N3.1	N3.2	N4.1
■ 18	■ 20	■ 22	■ 20	◪ 18	◪ 15	◪ 12	◪ 14	◪ 9	◪ 20	◪ 15	◪ 25

Product	TDZ	TPI	TD [mm]	OAL [mm]	THL [mm]	LDP [mm]	DCON MS [mm]	WSC [mm]	NOF
E6516-32	6	32	2.850	56.9	12	6.00	3.50	2.90	2
E6518-32	8	32	3.500	64.0	12	8.00	4.50	3.55	2
E65110-24	10	24	3.900	72.0	15	10.00	5.00	4.00	2
E65112-24	12	24	4.500	77.0	15	11.00	5.60	4.50	2
E6511/4	1/4	20	5.100	83.0	17	13.00	6.30	5.00	2
E6515/16	5/16	18	6.600	94.0	21	16.00	8.00	6.30	2
E6513/8	3/8	16	8.000	107.0	23	19.00	10.00	8.00	2
E6517/16	7/16	14	9.400	107.0	25	22.00	8.00	6.30	2
E6511/2	1/2	13	10.800	114.0	29	25.00	9.00	7.10	2
E6519/16	9/16	12	12.200	124.0	29	28.00	11.20	9.00	2
E6515/8	5/8	11	13.500	134.0	31	32.50	12.50	10.00	2

E287

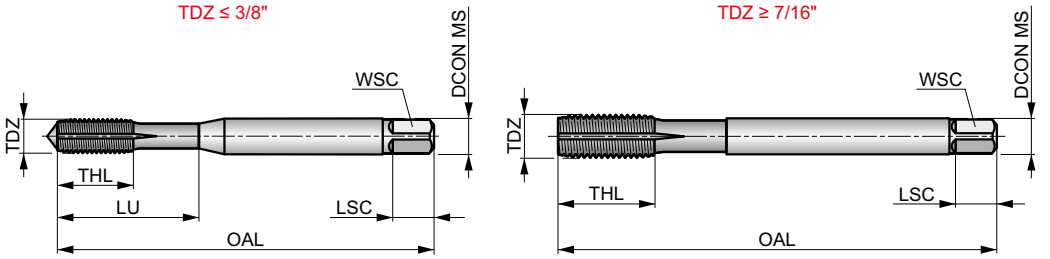
DORMER



HSS-E Thread Forming TiN Coated Tap, Oil-Grooves, UNC, DIN Standard

High performance fluteless tap for blind and through holes. Provide strong, clean, chip-free and accurate threads with excellent tolerance. Highly versatile for steel, stainless steel and non-ferrous metal. TiN coated for higher cutting speeds, performance and tool life. With oil-grooves for better lubrication in deep holes.

UNC	DIN 2184-1	2BX
	3.5×D	HSS-E
C 2-3.5		R
TiN		



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1
■ 45	■ 51	■ 51	■ 51	■ 45	◪ 40	■ 29	■ 24	■ 20	■ 18	■ 15	■ 25	■ 21	■ 22
M2.2	**M2.3**	**M3.1**	**M3.2**	**M3.3**	**M4.1**	**N1.1**	**N1.2**	**N1.3**	**N2.1**	**N2.2**	**N2.3**	**N3.1**	**N3.3**
■ 18	◪ 12	■ 17	■ 15	■ 14	■ 10	■ 55	■ 41	■ 28	■ 62	■ 55	■ 40	◪ 40	◪ 12

Product	TDZ	TPI	TD	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
			[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E2874-40	4	40	2.845	56.0	9	3.50	2.70	6	4	2.60	18.00
E2876-32	6	32	3.505	56.0	11	4.00	3.00	6	4	3.20	20.00
E2878-32	8	32	4.166	63.0	12	4.50	3.40	6	5	3.80	21.00
E28710-24	10	24	4.826	70.0	13	6.00	4.90	8	5	4.40	25.00
E2871/4	1/4	20	6.350	80.0	15	7.00	5.50	8	5	5.80	30.00
E2875/16	5/16	18	7.938	90.0	18	8.00	6.20	9	5	7.30	35.00
E2873/8	3/8	16	9.525	100.0	20	10.00	8.00	11	5	8.80	39.00
E2877/16	7/16	14	11.112	100.0	20	8.00	6.20	9	5	10.30	–
E2871/2	1/2	13	12.700	110.0	23	9.00	7.00	10	5	11.90	–

E111

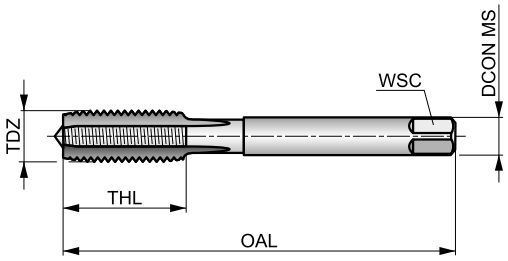
DORMER



HSS Straight Flute Serial Hand Tap, UNF, DIN Standard

Ideal for hand tapping tough materials. The straight flute design makes it suited for both through and blind holes. Available as a single finishing tap or as a set of two serial taps, which should be used one after the other to create the full thread.

UNF	DIN 2181	2B
	1.5×D	HSS
C 2-3		R
Bright		



Workpiece material group suitability.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	K1.1	K1.2	K1.3	K2.1	K2.2
■	■	■	■	■	◪	■	◪	◪	◪	◪	◪	◪	◪

K3.1	K3.2	K4.1	K4.2	K5.1	K5.2	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2
◪	◪	◪	◪	◪	◪	■	■	■	■	■	■	■	■

N3.3	N4.2	N4.3
■	■	■

Product	TDZ	TPI	TD [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	NOF	PHD [mm]
E1115-44N03	5	44	3.180	45.0	13	4.00	3.00	3	2.70
E1115-44N09	5	44	3.180	45.0	13	4.00	3.00	3	2.70
E1116-40N03	6	40	3.510	45.0	10	4.00	3.00	3	2.95
E1116-40N09	6	40	3.510	45.0	10	4.00	3.00	3	2.95
E1118-36N03	8	36	4.170	50.0	14	6.00	4.90	3	3.50
E1118-36N09	8	36	4.170	50.0	14	6.00	4.90	3	3.50
E11110-32N03	10	32	4.820	50.0	14	6.00	4.90	3	4.10
E11110-32N09	10	32	4.820	50.0	14	6.00	4.90	3	4.10
E1111/4N03	1/4	28	6.350	56.0	17	6.00	4.90	3	5.50
E1111/4N09	1/4	28	6.350	56.0	17	6.00	4.90	3	5.50
E1115/16N03	5/16	24	7.940	63.0	19	6.00	4.90	3	6.90
E1115/16N09	5/16	24	7.940	63.0	19	6.00	4.90	3	6.90
E1113/8N03	3/8	24	9.530	63.0	16	7.00	5.50	3	8.50
E1113/8N09	3/8	24	9.530	63.0	16	7.00	5.50	3	8.50
E1117/16N03	7/16	20	11.110	63.0	15	8.00	6.20	3	9.90
E1117/16N09	7/16	20	11.110	63.0	15	8.00	6.20	3	9.90
E1111/2N03	1/2	20	12.700	70.0	22	9.00	7.00	3	11.50
E1111/2N09	1/2	20	12.700	70.0	22	9.00	7.00	3	11.50
E1119/16N03	9/16	18	14.290	70.0	16	11.00	9.00	4	12.90
E1119/16N09	9/16	18	14.290	70.0	16	11.00	9.00	4	12.90
E1115/8N03	5/8	18	15.880	70.0	16	12.00	9.00	4	14.50
E1115/8N09	5/8	18	15.880	70.0	16	12.00	9.00	4	14.50
E1113/4N03	3/4	16	19.050	80.0	22	14.00	11.00	4	17.50
E1113/4N09	3/4	16	19.050	80.0	22	14.00	11.00	4	17.50
E1117/8N03	7/8	14	22.230	90.0	22	18.00	14.50	4	20.40
E1117/8N09	7/8	14	22.230	90.0	22	18.00	14.50	4	20.40
E1111N03	1"	12	25.400	90.0	22	20.00	16.00	4	23.25
E1111N09	1"	12	25.400	90.0	22	20.00	16.00	4	23.25

E229

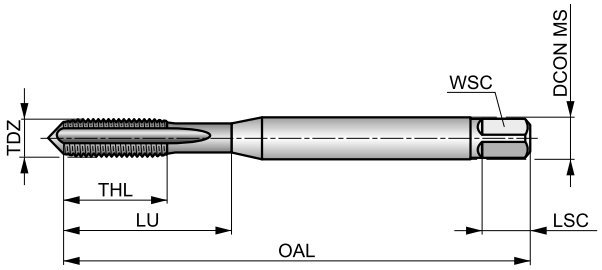
DORMER



HSS-E-PM Straight Flute Machine Tap, UNF, DIN Standard

General purpose straight flute machine tap for through and blind holes. Bright finish to produce more accurate and cleaner threads preventing the workpiece material from sticking to the cutting edges. The reinforced shank increases strength against torsional twist.

UNF	DIN 371	2B
	1.5×D	HSS-E PM
C 2-3		R
Bright		



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	K1.1	K1.2	K1.3	K2.1	K2.2
■11	■12	■12	■9	■8	◪7	■7	◪6	◪4	◪13	◪10	◪8	◪14	◪11

K3.1	K3.2	K4.1	K4.2	K5.1	K5.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N4.2
◪13	◪10	◪12	◪9	◪12	◪10	◪12	◪15	◪14	◪11	◪21	■14	◪8

Product	TDZ	TPI	TD [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	LSC [mm]	NOF	PHD [mm]	LU [mm]
E2292-64	2	64	2.184	45.0	7	2.80	2.10	5	3	1.90	12.00
E2293-56	3	56	2.515	50.0	8	2.80	2.10	5	3	2.15	12.50
E2294-48	4	48	2.845	56.0	9	3.50	2.70	6	3	2.40	18.00
E2295-44	5	44	3.175	56.0	10	3.50	2.70	6	3	2.70	18.00
E2296-40	6	40	3.505	56.0	11	4.00	3.00	6	3	2.95	20.00
E2298-36	8	36	4.166	63.0	12	4.50	3.40	6	3	3.50	21.00
E22910-32	10	32	4.826	70.0	13	6.00	4.90	8	3	4.10	25.00
E22912-28	12	28	5.486	80.0	15	6.00	4.90	8	3	4.70	30.00
E2291/4	1/4	28	6.350	80.0	15	7.00	5.50	8	3	5.50	30.00

E278

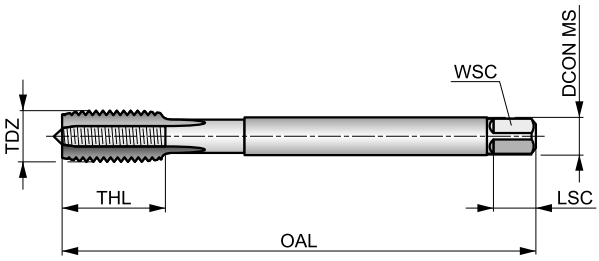
DORMER



HSS-E-PM Straight Flute Machine Tap, UNF, DIN Standard

General purpose straight flute machine tap for through and blind holes. Bright finish to produce more accurate and cleaner threads preventing the workpiece material from sticking to the cutting edges. The reduced shank increases the reach of the tap.

UNF	DIN 374	2B
	1.5×D	HSS-E PM
C 2-3		R
Bright		



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	K1.1	K1.2	K1.3	K2.1	K2.2
■11	■12	■12	■9	■8	◪7	■7	◪6	◪4	◪13	◪10	◪8	◪14	◪11

K3.1	K3.2	K4.1	K4.2	K5.1	K5.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N4.2
◪13	◪10	◪12	◪9	◪12	◪10	◪12	◪15	◪14	◪11	◪21	■14	◪8

Product	TDZ	TPI	TD	OAL	THL	DCON MS	WSC	LSC	NOF	PHD
			[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]
E2785/16	5/16	24	7.940	90.0	18	6.00	4.90	8	3	6.90
E2783/8	3/8	24	9.530	100.0	24	7.00	5.50	8	3	8.50
E2787/16	7/16	20	11.110	100.0	22	9.00	7.00	10	3	9.90
E2781/2	1/2	20	12.700	100.0	21	9.00	7.00	10	3	11.50
E2789/16	9/16	18	14.290	100.0	21	11.00	9.00	12	4	12.90
E2785/8	5/8	18	15.880	100.0	21	12.00	9.00	12	4	14.50
E2783/4	3/4	16	19.050	125.0	25	14.00	11.00	14	4	17.50
E2787/8	7/8	14	22.230	140.0	28	18.00	14.50	17	4	20.40
E2781	1″	12	25.400	140.0	26	18.00	14.50	17	4	23.25
E2781.1/8	1.1/8	12	28.580	150.0	28	22.00	18.00	21	4	26.50
E2781.1/4	1.1/4	12	31.750	150.0	28	25.00	20.00	23	4	29.50
E2781.3/8	1.3/8	12	34.930	170.0	30	28.00	22.00	25	4	32.75
E2781.1/2 [1]	1.1/2	12	38.100	170.0	30	32.00	24.00	27	4	36.00

[1] HSS-E.

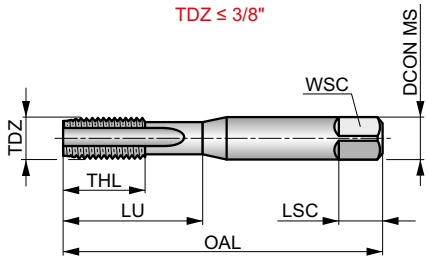
E524

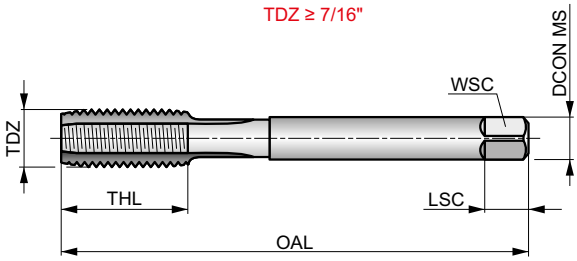
DORMER



HSS Straight Flute Hand Tap, UNF, ISO Standard

A versatile tool, suitable for hand and machine tapping. With a straight flute design for both through and blind holes. Available as a set of three NO6 or as separate taps with taper lead NO1 for short through holes, plug lead NO2 for deeper through holes or bottoming lead NO3 for blind holes.





UNF	ISO 529	2B
	1.5×D	HSS
	R	Bright

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	K1.1	K1.2	K1.3	K2.1	K2.2
■7	■7	■8	■6	■5	◪4	■4	◪4	◪3	◪12	◪9	◪7	◪12	◪10

K3.1	K3.2	K4.1	K4.2	K5.1	K5.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	N4.2	N4.3
◪11	◪8	◪10	◪8	◪11	◪9	◪8	◪11	◪10	◪7	■17	■10	◪5	◪5	◪3

Products from this series are also available in set with dies. Please see L120.

Product	TDZ	TPI	TD	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
			[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E5240-80N01	0	80	1.524	41.0	7	2.50	2.00	4	2	1.25	7.00
E5240-80N02	0	80	1.524	41.0	7	2.50	2.00	4	2	1.25	7.00
E5240-80N03	0	80	1.524	41.0	7	2.50	2.00	4	2	1.25	7.00
E5241-72N01	1	72	1.854	41.0	8	2.50	2.00	4	2	1.55	8.00
E5241-72N02	1	72	1.854	41.0	8	2.50	2.00	4	2	1.55	8.00
E5241-72N03	1	72	1.854	41.0	8	2.50	2.00	4	2	1.55	8.00
E5242-64N01	2	64	2.184	44.5	9.5	2.80	2.24	5	3	1.90	9.50
E5242-64N02	2	64	2.184	44.5	9.5	2.80	2.24	5	3	1.90	9.50
E5242-64N03	2	64	2.184	44.5	9.5	2.80	2.24	5	3	1.90	9.50
E5244-48N01	4	48	2.845	48.0	12.5	3.15	2.50	5	3	2.40	12.50
E5244-48N02	4	48	2.845	48.0	12.5	3.15	2.50	5	3	2.40	12.50
E5244-48N03	4	48	2.845	48.0	12.5	3.15	2.50	5	3	2.40	12.50
E5245-44N01	5	44	3.175	48.0	12.5	3.15	2.50	5	3	2.70	12.50
E5245-44N02	5	44	3.175	48.0	12.5	3.15	2.50	5	3	2.70	12.50
E5245-44N03	5	44	3.175	48.0	12.5	3.15	2.50	5	3	2.70	12.50
E5246-40N01	6	40	3.505	50.0	14	3.55	2.80	5	3	2.95	14.00
E5246-40N02	6	40	3.505	50.0	14	3.55	2.80	5	3	2.95	14.00
E5246-40N03	6	40	3.505	50.0	14	3.55	2.80	5	3	2.95	14.00
E5248-36N01	8	36	4.166	53.0	9.5	4.50	3.55	6	3	3.50	17.00
E5248-36N02	8	36	4.166	53.0	9.5	4.50	3.55	6	3	3.50	17.00
E5248-36N03	8	36	4.166	53.0	9.5	4.50	3.55	6	3	3.50	17.00
E52410-32N01	10	32	4.826	58.0	11	5.00	4.00	7	3	4.10	20.00
E52410-32N02	10	32	4.826	58.0	11	5.00	4.00	7	3	4.10	20.00
E52410-32N03	10	32	4.826	58.0	11	5.00	4.00	7	3	4.10	20.00
E52410-32N06	10	32	4.826	58.0	11	5.00	4.00	7	3	4.10	20.00
E52412-28N01	12	28	5.486	62.0	12	5.60	4.50	7	3	4.70	21.00
E52412-28N02	12	28	5.486	62.0	12	5.60	4.50	7	3	4.70	21.00

Product	TDZ	TPI	TD	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
			[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E52412-28N03	12	28	5.486	62.0	12	5.60	4.50	7	3	4.70	21.00
E52412-28N06	12	28	5.486	62.0	12	5.60	4.50	7	3	4.70	21.00
E5241/4N01	1/4	28	6.350	66.0	13	6.30	5.00	8	3	5.50	26.00
E5241/4N02	1/4	28	6.350	66.0	13	6.30	5.00	8	3	5.50	26.00
E5241/4N03	1/4	28	6.350	66.0	13	6.30	5.00	8	3	5.50	26.00
E5241/4N06	1/4	28	6.350	66.0	13	6.30	5.00	8	3	5.50	26.00
E5245/16N01	5/16	24	7.938	72.0	16	8.00	6.30	9	3	6.90	29.00
E5245/16N02	5/16	24	7.938	72.0	16	8.00	6.30	9	3	6.90	29.00
E5245/16N03	5/16	24	7.938	72.0	16	8.00	6.30	9	3	6.90	29.00
E5245/16N06	5/16	24	7.938	72.0	16	8.00	6.30	9	3	6.90	29.00
E5243/8N01	3/8	24	9.525	80.0	18	10.00	8.00	11	3	8.50	32.00
E5243/8N02	3/8	24	9.525	80.0	18	10.00	8.00	11	3	8.50	32.00
E5243/8N03	3/8	24	9.525	80.0	18	10.00	8.00	11	3	8.50	32.00
E5243/8N06	3/8	24	9.525	80.0	18	10.00	8.00	11	3	8.50	32.00
E5247/16N01	7/16	20	11.112	85.0	19	8.00	6.30	9	3	9.90	–
E5247/16N02	7/16	20	11.112	85.0	19	8.00	6.30	9	3	9.90	–
E5247/16N03	7/16	20	11.112	85.0	19	8.00	6.30	9	3	9.90	–
E5247/16N06	7/16	20	11.112	85.0	19	8.00	6.30	9	3	9.90	–
E5241/2N01	1/2	20	12.700	89.0	22	9.00	7.10	10	3	11.50	–
E5241/2N02	1/2	20	12.700	89.0	22	9.00	7.10	10	3	11.50	–
E5241/2N03	1/2	20	12.700	89.0	22	9.00	7.10	10	3	11.50	–
E5241/2N06	1/2	20	12.700	89.0	22	9.00	7.10	10	3	11.50	–
E5249/16N01	9/16	18	14.288	95.0	24	11.20	9.00	12	4	12.90	–
E5249/16N02	9/16	18	14.288	95.0	24	11.20	9.00	12	4	12.90	–
E5249/16N03	9/16	18	14.288	95.0	24	11.20	9.00	12	4	12.90	–
E5249/16N06	9/16	18	14.288	95.0	24	11.20	9.00	12	4	12.90	–
E5245/8N01	5/8	18	15.875	102.0	24	12.50	10.00	13	4	14.50	–
E5245/8N02	5/8	18	15.875	102.0	24	12.50	10.00	13	4	14.50	–
E5245/8N03	5/8	18	15.875	102.0	24	12.50	10.00	13	4	14.50	–
E5245/8N06	5/8	18	15.875	102.0	24	12.50	10.00	13	4	14.50	–
E5243/4N01	3/4	16	19.050	112.0	29	14.00	11.20	14	4	17.50	–
E5243/4N02	3/4	16	19.050	112.0	29	14.00	11.20	14	4	17.50	–
E5243/4N03	3/4	16	19.050	112.0	29	14.00	11.20	14	4	17.50	–
E5243/4N06	3/4	16	19.050	112.0	29	14.00	11.20	14	4	17.50	–
E5247/8N01	7/8	14	22.225	118.0	29	16.00	12.50	16	4	20.40	–
E5247/8N02	7/8	14	22.225	118.0	29	16.00	12.50	16	4	20.40	–
E5247/8N03	7/8	14	22.225	118.0	29	16.00	12.50	16	4	20.40	–
E5247/8N06	7/8	14	22.225	118.0	29	16.00	12.50	16	4	20.40	–
E5241N01	1″	12	25.400	130.0	35	18.00	14.00	18	4	23.25	–
E5241N02	1″	12	25.400	130.0	35	18.00	14.00	18	4	23.25	–
E5241N03	1″	12	25.400	130.0	35	18.00	14.00	18	4	23.25	–
E5241N06	1″	12	25.400	130.0	35	18.00	14.00	18	4	23.25	–
E5241.1/8N01	1.1/8	12	28.575	138.0	35	20.00	16.00	20	4	26.50	–
E5241.1/8N02	1.1/8	12	28.575	138.0	35	20.00	16.00	20	4	26.50	–
E5241.1/8N03	1.1/8	12	28.575	138.0	35	20.00	16.00	20	4	26.50	–
E5241.1/4N01	1.1/4	12	31.750	151.0	41	22.40	18.00	22	4	29.50	–
E5241.1/4N02	1.1/4	12	31.750	151.0	41	22.40	18.00	22	4	29.50	–
E5241.1/4N03	1.1/4	12	31.750	151.0	41	22.40	18.00	22	4	29.50	–
E5241.3/8N01	1.3/8	12	34.925	162.0	47	25.00	20.00	24	4	32.75	–
E5241.3/8N02	1.3/8	12	34.925	162.0	47	25.00	20.00	24	4	32.75	–
E5241.3/8N03	1.3/8	12	34.925	162.0	47	25.00	20.00	24	4	32.75	–
E5241.1/2N01	1.1/2	12	38.100	170.0	47	28.00	22.40	26	4	36.00	–
E5241.1/2N02	1.1/2	12	38.100	170.0	47	28.00	22.40	26	4	36.00	–
E5241.1/2N03	1.1/2	12	38.100	170.0	47	28.00	22.40	26	4	36.00	–

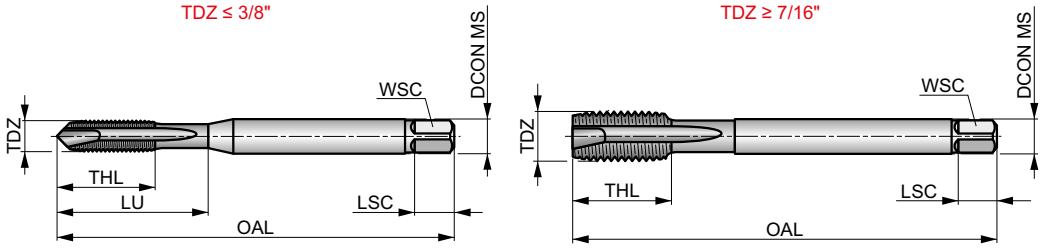
EP30



HSS-E-PM Spiral Point Machine Tap, UNF, DIN Standard

Machine tap with spiral point suited for through holes only. Bright finish to produce more accurate and cleaner threads preventing the workpiece material from sticking to the cutting edges.

UNF	DIN 2184-1	2B
	2.5×D	HSS-E PM
C 2-3		R
Bright		



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	N1.1	N1.2	N1.3	N2.1	N2.2
■ 22	■ 24	■ 25	■ 18	■ 16	◪ 14	■ 13	◪ 10	◪ 8	■ 14	■ 10	■ 7	■ 28	■ 25

N2.3	N3.1	N3.2	N3.3	N4.1
■ 18	■ 44	◪ 27	■ 13	◪ 22

Product	TDZ	TPI	TD [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	LSC [mm]	NOF	PHD [mm]	LU [mm]
EP308-36	8	36	4.166	63.0	12	4.50	3.40	8	3	3.50	21.00
EP3010-32	10	32	4.826	70.0	13	6.00	4.90	8	3	4.10	25.00
EP301/4	1/4	28	6.350	80.0	15	7.00	5.50	8	3	5.50	30.00
EP305/16	5/16	24	7.938	90.0	18	8.00	6.20	9	3	6.90	35.00
EP303/8	3/8	24	9.525	100.0	20	10.00	8.00	11	3	8.50	39.00
EP307/16	7/16	20	11.112	100.0	20	8.00	6.20	9	3	9.90	–
EP301/2	1/2	20	12.700	110.0	23	9.00	7.00	10	3	11.50	–
EP305/8	5/8	18	15.875	110.0	25	12.00	9.00	12	3	14.50	–
EP303/4	3/4	16	19.050	125.0	30	14.00	11.00	14	4	17.50	–
EP307/8	7/8	14	22.225	140.0	34	18.00	14.50	17	4	20.40	–
EP301	1"	12	25.400	160.0	38	18.00	14.50	17	4	23.25	–

EP31

DORMER

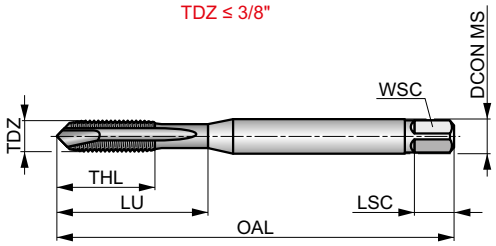


HSS-E-PM Spiral Point Machine Tap, UNF, DIN Standard

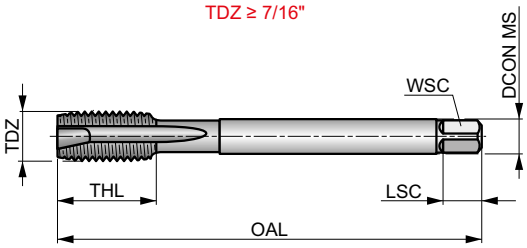
Machine tap with spiral point suited for through holes only. Steam tempered surface acts to retain cutting fluid and prevent chip to tool welding.

UNF	DIN 2184-1	2B
	2.5×D	HSS-E PM
C 2-3		R
ST		

TDZ ≤ 3/8"



TDZ ≥ 7/16"



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P2.2	P2.3	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1	M2.2	M3.1	M3.2	M3.3
◪22	◪16	■14	■10	◪9	■8	◪6	◪10	◪8	◪9	◪7	◪7	◪6	◪5
M4.1	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K3.1**	**K3.2**	**K4.1**	**K4.2**	**K5.1**	**K5.2**		
◪4	◪13	◪10	◪7	◪16	◪13	◪14	◪10	◪13	◪9	◪15	◪11		

Product	TDZ	TPI	TD	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
			[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
EP318-36	8	36	4.166	63.0	12	4.50	3.40	8	3	3.50	21.00
EP3110-32	10	32	4.826	70.0	13	6.00	4.90	8	3	4.10	25.00
EP311/4	1/4	28	6.350	80.0	15	7.00	5.50	8	3	5.50	30.00
EP315/16	5/16	24	7.938	90.0	18	8.00	6.20	9	3	6.90	35.00
EP313/8	3/8	24	9.525	100.0	20	10.00	8.00	11	3	8.50	39.00
EP317/16	7/16	20	11.112	100.0	20	8.00	6.20	9	3	9.90	–
EP311/2	1/2	20	12.700	110.0	23	9.00	7.00	10	3	11.50	–
EP315/8	5/8	18	15.875	110.0	25	12.00	9.00	12	3	14.50	–
EP313/4	3/4	16	19.050	125.0	30	14.00	11.00	14	4	17.50	–
EP317/8	7/8	14	22.225	140.0	34	18.00	14.50	17	4	20.40	–
EP311	1"	12	25.400	160.0	38	18.00	14.50	17	4	23.25	–

E031

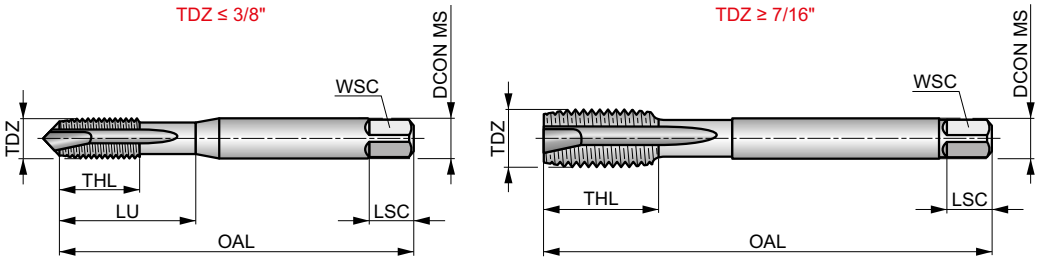
DORMER



HSS-E-PM Spiral Point Machine Tap, UNF, ISO Standard

Machine tap with spiral point suited for through holes only. Steam tempered surface acts to retain cutting fluid and prevent chip to tool welding.

UNF	ISO 529	2B
	2.5×D	HSS-E PM
B 3.5-5		R
ST		



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P2.2	P2.3	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1	M2.2	M3.1	M3.2	M3.3
◪22	◪16	■14	■10	◪9	■8	◪6	◪10	◪8	◪9	◪7	◪7	◪6	◪5

M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K3.1	K3.2	K4.1	K4.2	K5.1	K5.2
◪4	◪13	◪10	◪7	◪16	◪13	◪14	◪10	◪13	◪9	◪15	◪11

Product	TDZ	TPI	TD [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	LSC [mm]	NOF	PHD [mm]	LU [mm]
E0318-36	8	36	4.166	53.0	9.5	4.50	3.55	6	3	3.50	17.00
E03110-32	10	32	4.826	58.0	11	5.00	4.00	7	3	4.10	20.00
E0311/4	1/4	28	6.350	66.0	13	6.30	5.00	8	3	5.50	26.00
E0315/16	5/16	24	7.938	72.0	16	8.00	6.30	9	3	6.90	29.00
E0313/8	3/8	24	9.525	80.0	18	10.00	8.00	11	3	8.50	32.00
E0317/16	7/16	20	11.112	85.0	19	8.00	6.30	9	3	9.90	–
E0311/2	1/2	20	12.700	89.0	22	9.00	7.10	10	3	11.50	–
E0319/16	9/16	18	14.288	95.0	24	11.20	9.00	12	3	12.90	–
E0315/8	5/8	18	15.875	102.0	24	12.50	10.00	13	3	14.50	–
E0313/4	3/4	16	19.050	112.0	29	14.00	11.20	14	4	17.50	–
E0317/8	7/8	14	22.225	118.0	29	16.00	12.50	16	4	20.40	–
E0311	1"	12	25.400	130.0	35	18.00	14.00	18	4	23.25	–

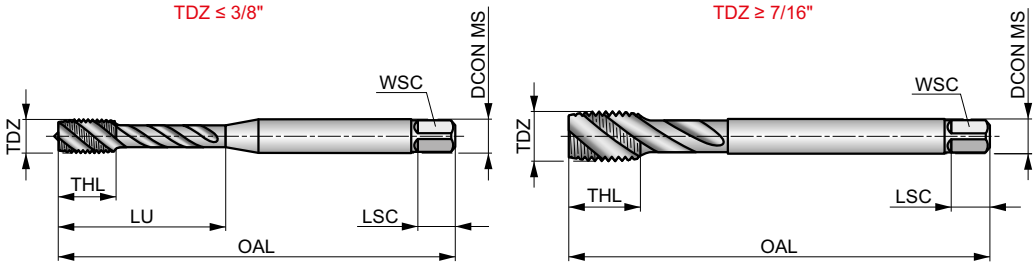
EX30



HSS-E-PM Spiral Flute Machine Tap, UNF, DIN Standard

Machine tap with spiral flute suited for blind holes. Bright finish to produce more accurate and cleaner threads preventing the workpiece material from sticking to the cutting edges.

UNF	DIN 2184-1	2B
	2.5×D	HSS-E PM
C 2-3		λ 45°
R	Bright	



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3
■21	■23	■24	■17	■15	◪13	■12	◪9	◪7	■13	■9	■6	■27	■24	■17

Product	TDZ	TPI	TD [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	LSC [mm]	NOF	PHD [mm]	LU [mm]
EX308-36	8	36	4.166	63.0	7	4.50	3.40	8	3	3.50	21.00
EX3010-32	10	32	4.826	70.0	8	6.00	4.90	8	3	4.10	25.00
EX301/4	1/4	28	6.350	80.0	10	7.00	5.50	8	3	5.50	30.00
EX305/16	5/16	24	7.938	90.0	12	8.00	6.20	9	3	6.90	35.00
EX303/8	3/8	24	9.525	100.0	15	10.00	8.00	11	3	8.50	39.00
EX307/16	7/16	20	11.112	100.0	15	8.00	6.20	9	3	9.90	–
EX301/2	1/2	20	12.700	110.0	18	9.00	7.00	10	3	11.50	–
EX305/8	5/8	18	15.875	110.0	20	12.00	9.00	12	4	14.50	–
EX303/4	3/4	16	19.050	125.0	25	14.00	11.00	14	4	17.50	–
EX307/8	7/8	14	22.225	140.0	25	18.00	14.50	17	4	20.40	–
EX301	1"	12	25.400	160.0	30	18.00	14.50	17	4	23.25	–

EX31

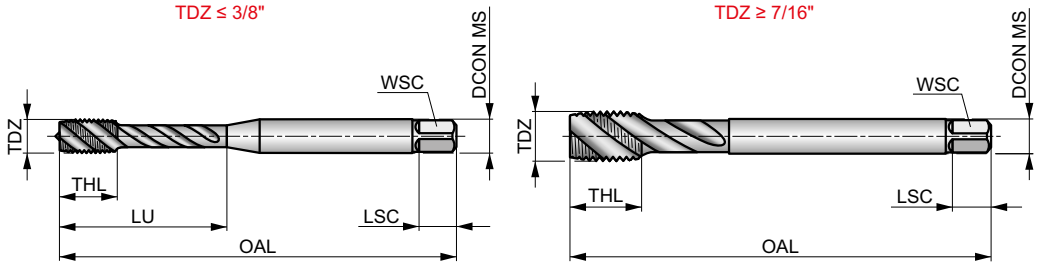
DORMER

HSS-E-PM Spiral Flute Machine Tap, UNF, DIN Standard

Machine tap with spiral flute suited for blind holes. Steam tempered surface acts to retain cutting fluid and prevent chip to tool welding.



UNF	DIN 2184-1	2B
	2.5×D	HSS-E PM
C 2-3		λ 45°
R	ST	



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P2.2	P2.3	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1	M2.2	M3.1	M3.2	M3.3	M4.1
◪21	◪15	■13	■9	◪8	■7	◪5	◪8	◪6	◪7	◪5	◪5	◪4	◪3	◪3

Product	TDZ	TPI	TD [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	LSC [mm]	NOF	PHD [mm]	LU [mm]
EX318-36	8	36	4.166	63.0	7	4.50	3.40	8	3	3.50	21.00
EX3110-32	10	32	4.826	70.0	8	6.00	4.90	8	3	4.10	25.00
EX311/4	1/4	28	6.350	80.0	10	7.00	5.50	8	3	5.50	30.00
EX315/16	5/16	24	7.938	90.0	12	8.00	6.20	9	3	6.90	35.00
EX313/8	3/8	24	9.525	100.0	15	10.00	8.00	11	3	8.50	39.00
EX317/16	7/16	20	11.112	100.0	15	8.00	6.20	9	3	9.90	–
EX311/2	1/2	20	12.700	110.0	18	9.00	7.00	10	3	11.50	–
EX315/8	5/8	18	15.875	110.0	20	12.00	9.00	12	4	14.50	–
EX313/4	3/4	16	19.050	125.0	25	14.00	11.00	14	4	17.50	–
EX317/8	7/8	14	22.225	140.0	25	18.00	14.50	17	4	20.40	–
EX311	1″	12	25.400	160.0	30	18.00	14.50	17	4	23.25	–

E033

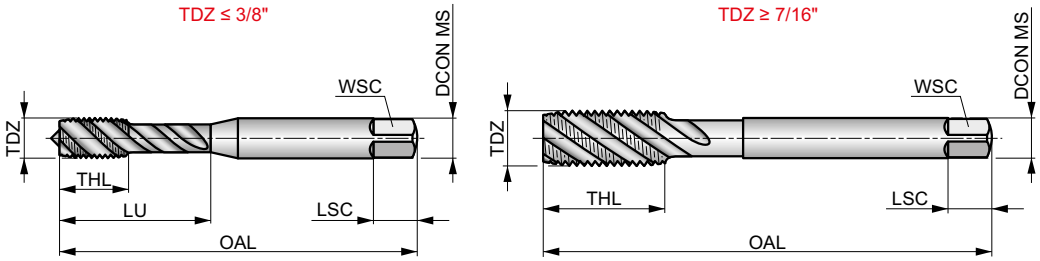
DORMER



HSS-E-PM Spiral Flute Machine Tap, UNF, ISO Standard

Machine tap with spiral flute suited for blind holes. Steam tempered surface acts to retain cutting fluid and prevent chip to tool welding.

UNF	ISO 529	2B
	2.5×D	HSS-E PM
C 2-3		λ 45°
R	ST	



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P2.2	P2.3	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1	M2.2	M3.1	M3.2	M3.3	M4.1
◪21	◪15	■13	■9	◪8	■7	◪5	◪8	◪6	◪7	◪5	◪5	◪4	◪3	◪3

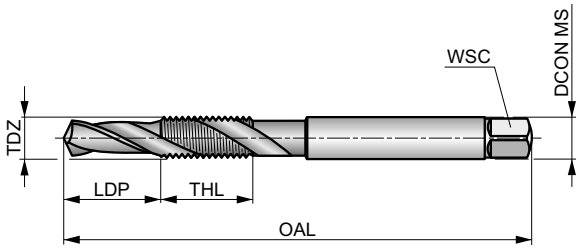
Product	TDZ	TPI	TD [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	LSC [mm]	NOF	PHD [mm]	LU [mm]
E0338-36	8	36	4.166	53.0	7	4.50	3.55	6	3	3.50	17.00
E03310-32	10	32	4.826	58.0	8	5.00	4.00	7	3	4.10	20.00
E0331/4	1/4	28	6.350	66.0	10	6.30	5.00	8	3	5.50	28.00
E0335/16	5/16	24	7.938	72.0	12	8.00	6.30	9	3	6.90	31.00
E0333/8	3/8	24	9.525	80.0	15	10.00	8.00	11	3	8.50	34.00
E0337/16	7/16	20	11.112	85.0	19	8.00	6.30	9	3	9.90	–
E0331/2	1/2	20	12.700	89.0	22	9.00	7.10	10	3	11.50	–
E0339/16	9/16	18	14.288	95.0	24	11.20	9.00	12	3	12.90	–
E0335/8	5/8	18	15.875	102.0	24	12.50	10.00	13	4	14.50	–
E0333/4	3/4	16	19.050	112.0	29	14.00	11.20	14	4	17.50	–
E0337/8	7/8	14	22.225	118.0	29	16.00	12.50	16	4	20.40	–
E0331	1″	12	25.400	130.0	35	18.00	14.00	18	4	23.25	–

E654



HSS Drill-Tap Combination Tool with 30° Spiral Flute, UNF, DIN Standard

Combination of a core-hole drill and tap to produce a thread in one pass. This significantly reduces the time needed to produce the thread on site with the use of a hand-held power tool. There is no need for a tap wrench or tool change. Steam tempered surface acts to retain the lubricant and provide smoother cutting.



UNF	DIN DORMER	Medium
	1.5×D	HSS
C 2-3		λ 30°
R	ST	

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P3.1	P3.2	N1.2	N1.3	N3.1	N3.2	N4.1
■ 18	■ 20	■ 22	■ 20	◪ 18	◪ 15	◪ 12	◪ 14	◪ 9	◪ 20	◪ 15	◪ 25

Product	TDZ	TPI	TD [mm]	OAL [mm]	THL [mm]	LDP [mm]	DCON MS [mm]	WSC [mm]	NOF
E6548-36	8	36	3.500	64.0	13	8.00	4.50	3.55	2
E65410-32	10	32	4.100	72.0	16	10.00	5.00	4.00	2
E65412-28	12	28	4.700	77.0	17	11.00	5.60	4.50	2
E6541/4	1/4	28	5.500	83.0	19	13.00	6.30	5.00	2
E6545/16	5/16	24	6.900	94.0	22	16.00	8.00	6.30	2
E6543/8	3/8	24	8.500	104.0	24	19.00	10.00	8.00	2
E6547/16	7/16	20	9.900	107.0	25	22.00	8.00	6.30	2
E6541/2	1/2	20	11.500	114.0	29	25.00	9.00	7.10	2
E6545/8	5/8	18	14.500	134.0	32	32.00	12.50	10.00	2

E286

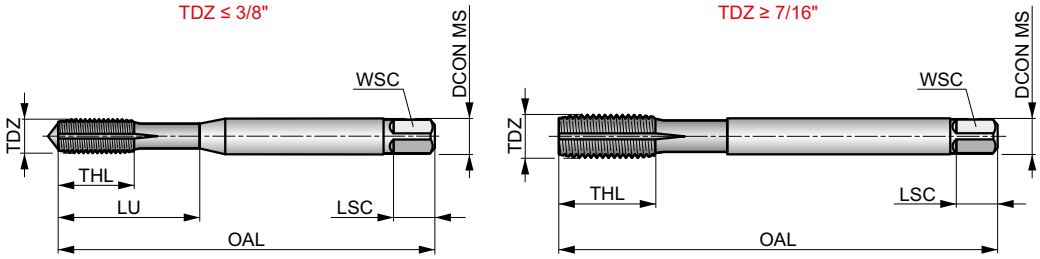
DORMER



HSS-E Thread Forming TiN Coated Tap, Oil-Grooves, UNF, DIN Standard

High performance fluteless tap for blind and through holes. Provide strong, clean, chip-free and accurate threads with excellent tolerance. Highly versatile for steel, stainless steel and non-ferrous metal. TiN coated for higher cutting speeds and extend tool life. With oil-grooves for better lubrication in deep holes.

UNF	DIN 2184-1	2BX
	3.5×D	HSS-E
C 2-3.5		R
TiN		



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1
■45	■51	■51	◪51	■45	◪40	■29	■24	■20	■18	■15	■25	■21	■22
M2.2	**M2.3**	**M3.1**	**M3.2**	**M3.3**	**M4.1**	**N1.1**	**N1.2**	**N1.3**	**N2.1**	**N2.2**	**N2.3**	**N3.1**	**N3.3**
■18	◪15	■17	■15	■14	■10	■55	■41	■28	■62	■55	■40	◪40	◪12

Product	TDZ	TPI	TD	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
			[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E2864-48	4	48	2.845	56.0	9	3.50	2.70	6	4	2.60	18.00
E2866-40	6	40	3.505	56.0	11	4.00	3.00	6	4	3.20	20.00
E2868-36	8	36	4.166	63.0	12	4.50	3.40	6	5	3.90	21.00
E28610-32	10	32	4.826	70.0	13	6.00	4.90	8	5	4.50	25.00
E2861/4	1/4	28	6.350	80.0	15	7.00	5.50	8	5	6.00	30.00
E2865/16	5/16	24	7.938	90.0	18	8.00	6.20	9	5	7.50	35.00
E2863/8	3/8	24	9.525	100.0	20	10.00	8.00	11	5	9.10	39.00
E2867/16	7/16	20	11.112	100.0	20	8.00	6.20	9	5	10.60	–
E2861/2	1/2	20	12.700	100.0	21	9.00	7.00	10	5	12.10	–

E570

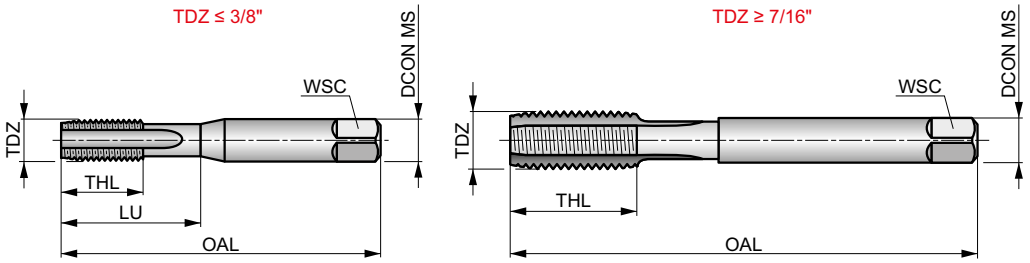
DORMER



HSS Straight Flute Hand Tap, UN, ISO Standard

A versatile tool, suitable for machine and also hand tapping. With a straight flute design and bottoming lead for blind and through holes.

UN	ISO 529	2B
	1.5×D	HSS
C 2-3		R
Bright		



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	K1.1	K1.2	K1.3	K2.1	K2.2
■7	■7	■8	■6	■5	◪4	■4	◪4	◪3	◪12	◪9	◪7	◪12	◪10
K3.1	**K3.2**	**K4.1**	**K4.2**	**K5.1**	**K5.2**	**N1.3**	**N2.1**	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.2**
◪11	◪8	◪10	◪8	◪11	◪9	◪8	◪11	◪10	◪7	■17	■10	◪5	◪5
N4.3													
◪3													

Product	TDZ	TPI	TD [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	NOF	PHD [mm]	LU [mm]
E5701/4X32NO3	1/4	32	6.350	66.0	13	6.30	5.00	3	5.60	26.00
E5701/4X36NO3	1/4	36	6.350	66.0	13	6.30	5.00	3	5.70	26.00
E5701/4X40NO3	1/4	40	6.350	66.0	13	6.30	5.00	3	5.70	26.00
E5705/16X32NO3	5/16	32	7.938	72.0	16	8.00	6.30	3	7.20	29.00
E5703/8X32NO3	3/8	32	9.525	80.0	18	10.00	8.00	3	8.80	32.00
E5707/16X24NO3	7/16	24	11.112	85.0	19	8.00	6.30	3	10.00	–
E5707/16X28NO3	7/16	28	11.112	85.0	19	8.00	6.30	3	10.20	–
E5701/2X28NO3	1/2	28	12.700	89.0	22	9.00	7.10	3	11.80	–
E5709/16X24NO3	9/16	24	14.288	95.0	24	11.20	9.00	4	13.25	–
E5705/8X24NO3	5/8	24	15.875	102.0	24	12.50	10.00	4	14.80	–
E5703/4X20NO3	3/4	20	19.050	112.0	29	14.00	11.20	4	17.80	–
E5707/8X20NO3	7/8	20	22.225	118.0	30	16.00	12.50	4	21.00	–
E5701X14NO3	1″	14	25.400	130.0	36	18.00	14.00	4	23.50	–
E5701.1/16X12NO3	1.1/16	12	26.988	127.0	37	20.00	16.00	4	24.75	–
E5701.1/8X8NO3	1.1/8	8	28.575	138.0	35	20.00	16.00	4	25.50	–
E5701.3/16X12NO3	1.3/16	12	30.163	137.0	37	22.40	18.00	4	28.00	–
E5701.1/4X8NO3	1.1/4	8	31.750	151.0	41	22.40	18.00	4	28.50	–
E5701.5/16X12NO3	1.5/16	12	33.338	137.0	37	22.40	18.00	4	31.25	–

E115

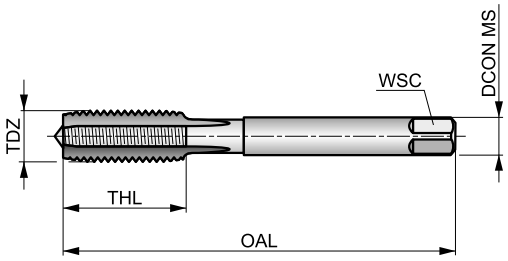
DORMER



HSS Straight Flute Serial Hand Tap, BSW, DIN352 Standard

Ideal for hand tapping tough materials. The straight flute design makes it ideal for both through and blind holes. Available as a single finishing tap or as a set of three serial taps, which should be used one after the other to create the full thread.

BSW	DIN 351	Medium
	1.5×D	HSS
C 2-3		R
Bright		



Workpiece material group suitability.

P1.1 ■	P1.2 ■	P1.3 ■	P2.1 ■	P2.2 ■	P2.3 ◪	P3.1 ■	P3.2 ◪	P4.1 ◪	K1.1 ◪	K1.2 ◪	K1.3 ◪	K2.1 ◪	K2.2 ◪
K3.1 ◪	K3.2 ◪	K4.1 ◪	K4.2 ◪	K5.1 ◪	K5.2 ◪	N1.1 ■	N1.2 ■	N1.3 ■	N2.1 ■	N2.2 ■	N2.3 ■	N3.1 ■	N3.2 ■
N3.3 ■	N4.2 ■	N4.3 ■											

Product	TDZ	TPI	TD [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	NOF	PHD [mm]
E1151/8N03	1/8	40	3.175	40.0	10	3.50	2.70	3	2.55
E1151/8N08	1/8	40	3.175	40.0	10	3.50	2.70	3	2.55
E1155/32N03	5/32	32	3.969	45.0	12	4.50	3.40	3	3.20
E1155/32N08	5/32	32	3.969	45.0	12	4.50	3.40	3	3.20
E1153/16N03	3/16	24	4.763	50.0	16	5.50	4.30	3	3.70
E1153/16N08	3/16	24	4.763	50.0	16	5.50	4.30	3	3.70
E1151/4N03	1/4	20	6.350	56.0	17	6.00	4.90	3	5.10
E1151/4N08	1/4	20	6.350	56.0	17	6.00	4.90	3	5.10
E1155/16N03	5/16	18	7.938	63.0	25	6.00	4.90	3	6.50
E1155/16N08	5/16	18	7.938	63.0	25	6.00	4.90	3	6.50
E1153/8N03	3/8	16	9.525	70.0	22	7.00	5.50	3	7.90
E1153/8N08	3/8	16	9.525	70.0	22	7.00	5.50	3	7.90
E1157/16N03	7/16	14	11.113	75.0	30	8.00	6.20	3	9.20
E1157/16N08	7/16	14	11.113	75.0	30	8.00	6.20	3	9.20
E1151/2N03	1/2	12	12.700	80.0	30	9.00	7.00	3	10.50
E1151/2N08	1/2	12	12.700	80.0	30	9.00	7.00	3	10.50
E1159/16N03	9/16	12	14.288	80.0	30	11.00	9.00	4	12.00
E1159/16N08	9/16	12	14.288	80.0	30	11.00	9.00	4	12.00
E1155/8N03	5/8	11	15.875	90.0	36	12.00	9.00	4	13.50
E1155/8N08	5/8	11	15.875	90.0	36	12.00	9.00	4	13.50
E1153/4N03	3/4	10	19.050	105.0	40	14.00	11.00	4	16.50
E1153/4N08	3/4	10	19.050	105.0	40	14.00	11.00	4	16.50
E1157/8N03	7/8	9	22.225	110.0	45	18.00	14.50	4	19.25
E1157/8N08	7/8	9	22.225	110.0	45	18.00	14.50	4	19.25
E1151N03	1″	8	25.400	110.0	50	20.00	16.00	4	22.00
E1151N08	1″	8	25.400	110.0	50	20.00	16.00	4	22.00

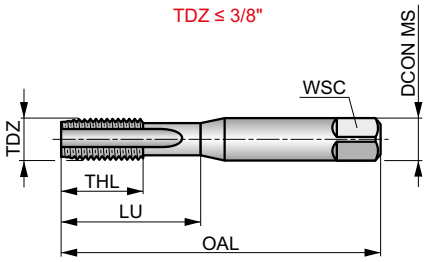
E531

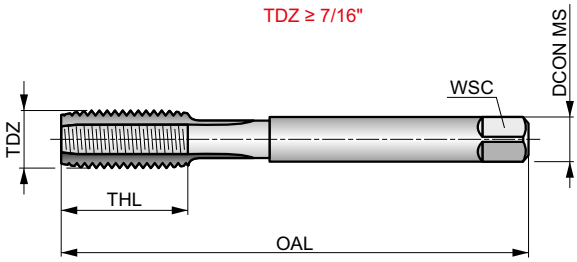
DORMER



HSS Straight Flute Hand Tap, BSW, ISO Standard

A versatile tool, suitable for hand and machine tapping, with a straight flute design for both through and blind holes. Available as a set of three NO6 or as separate taps with taper lead NO1 for short through holes, plug lead NO2 for deeper through holes or bottoming lead NO3 for blind holes.





BSW	ISO 529	Medium
	1.5×D	HSS
	R	Bright

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	K1.1	K1.2	K1.3	K2.1	K2.2
■7	■7	■8	■6	■5	◪4	■4	◪4	◪3	◪12	◪9	◪7	◪12	◪10
K3.1	**K3.2**	**K4.1**	**K4.2**	**K5.1**	**K5.2**	**N1.3**	**N2.1**	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.2**
◪11	◪8	◪10	◪8	◪11	◪9	◪8	◪11	◪10	◪7	■17	■10	◪5	◪5
N4.3													
◪3													

Product	TDZ	TPI	TD [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	NOF	PHD [mm]	LU [mm]
E5311/8N01	1/8	40	3.175	48.0	12.5	3.15	2.50	3	2.55	12.50
E5311/8N02	1/8	40	3.175	48.0	12.5	3.15	2.50	3	2.55	12.50
E5311/8N03	1/8	40	3.175	48.0	12.5	3.15	2.50	3	2.55	12.50
E5311/8N06	1/8	40	3.175	48.0	12.5	3.15	2.50	3	2.55	12.50
E5315/32N01	5/32	32	3.969	53.0	14	4.00	3.15	3	3.20	14.00
E5315/32N02	5/32	32	3.969	53.0	14	4.00	3.15	3	3.20	14.00
E5315/32N03	5/32	32	3.969	53.0	14	4.00	3.15	3	3.20	14.00
E5315/32N06	5/32	32	3.969	53.0	14	4.00	3.15	3	3.20	14.00
E5313/16N01	3/16	24	4.763	58.0	11	5.00	4.00	3	3.70	20.00
E5313/16N02	3/16	24	4.763	58.0	11	5.00	4.00	3	3.70	20.00
E5313/16N03	3/16	24	4.763	58.0	11	5.00	4.00	3	3.70	20.00
E5313/16N06	3/16	24	4.763	58.0	11	5.00	4.00	3	3.70	20.00
E5311/4N01	1/4	20	6.350	66.0	13	6.30	5.00	3	5.10	26.00
E5311/4N02	1/4	20	6.350	66.0	13	6.30	5.00	3	5.10	26.00
E5311/4N03	1/4	20	6.350	66.0	13	6.30	5.00	3	5.10	26.00
E5311/4N06	1/4	20	6.350	66.0	13	6.30	5.00	3	5.10	26.00
E5315/16N01	5/16	18	7.938	72.0	16	8.00	6.30	3	6.50	29.00
E5315/16N02	5/16	18	7.938	72.0	16	8.00	6.30	3	6.50	29.00
E5315/16N03	5/16	18	7.938	72.0	16	8.00	6.30	3	6.50	29.00
E5315/16N06	5/16	18	7.938	72.0	16	8.00	6.30	3	6.50	29.00
E5313/8N01	3/8	16	9.525	80.0	18	10.00	8.00	3	7.90	32.00
E5313/8N02	3/8	16	9.525	80.0	18	10.00	8.00	3	7.90	32.00
E5313/8N03	3/8	16	9.525	80.0	18	10.00	8.00	3	7.90	32.00
E5313/8N06	3/8	16	9.525	80.0	18	10.00	8.00	3	7.90	32.00
E5317/16N01	7/16	14	11.112	85.0	19	8.00	6.30	3	9.20	–
E5317/16N02	7/16	14	11.112	85.0	19	8.00	6.30	3	9.20	–
E5317/16N03	7/16	14	11.112	85.0	19	8.00	6.30	3	9.20	–
E5317/16N06	7/16	14	11.112	85.0	19	8.00	6.30	3	9.20	–

Product	TDZ	TPI	TD	OAL	THL	DCON MS	WSC	NOF	PHD	LU
			[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E5311/2N01	1/2	12	12.700	89.0	22	9.00	7.10	3	10.50	–
E5311/2N02	1/2	12	12.700	89.0	22	9.00	7.10	3	10.50	–
E5311/2N03	1/2	12	12.700	89.0	22	9.00	7.10	3	10.50	–
E5311/2N06	1/2	12	12.700	89.0	22	9.00	7.10	3	10.50	–
E5315/8N01	5/8	11	15.875	102.0	24	12.50	10.00	4	13.50	–
E5315/8N02	5/8	11	15.875	102.0	24	12.50	10.00	4	13.50	–
E5315/8N03	5/8	11	15.875	102.0	24	12.50	10.00	4	13.50	–
E5315/8N06	5/8	11	15.875	102.0	24	12.50	10.00	4	13.50	–
E5313/4N01	3/4	10	19.050	112.0	29	14.00	11.20	4	16.50	–
E5313/4N02	3/4	10	19.050	112.0	29	14.00	11.20	4	16.50	–
E5313/4N03	3/4	10	19.050	112.0	29	14.00	11.20	4	16.50	–
E5313/4N06	3/4	10	19.050	112.0	29	14.00	11.20	4	16.50	–
E5311N01	1″	8	25.400	130.0	35	18.00	14.00	4	22.00	–
E5311N02	1″	8	25.400	130.0	35	18.00	14.00	4	22.00	–
E5311N03	1″	8	25.400	130.0	35	18.00	14.00	4	22.00	–
E5311N06	1″	8	25.400	130.0	35	18.00	14.00	4	22.00	–

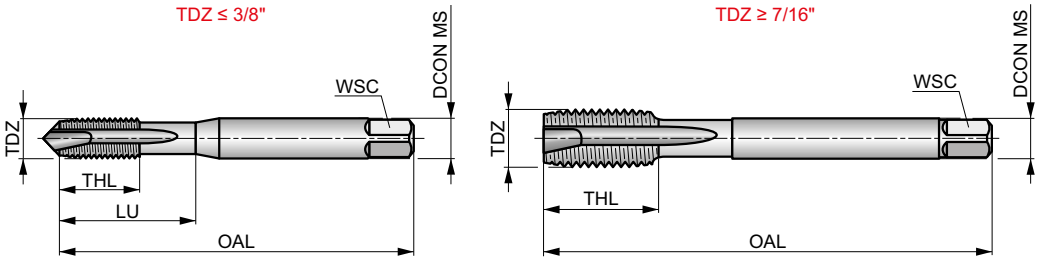
E534

DORMER



HSS Spiral Point Machine Tap, BSW, ISO Standard

Machine tap with spiral point suited for through holes only. Steam tempered surface acts to retain cutting fluid and prevent chip to tool welding.



BSW	ISO 529	Medium
	2.5×D	HSS
B 3.5-5		R
ST		

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	P4.2	M1.1	M1.2	M2.1	M2.2
■11	◪12	◪14	◪9	■8	■7	◪8	■6	■5	◪4	■7	◪6	◪6	◪5
M3.1	**M3.2**	**M3.3**	**M4.1**	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K3.1**	**K3.2**	**K4.1**	**K4.2**	**K5.1**
■5	◪4	◪3	◪2	◪9	◪6	◪4	◪12	◪9	◪10	◪6	◪9	◪5	◪11
K5.2													
◪7													

Product	TDZ	TPI	TD [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	NOF	PHD [mm]	LU [mm]
E5341/8	1/8	40	3.175	48.0	12.5	3.15	2.50	3	2.55	12.50
E5345/32	5/32	32	3.969	53.0	14	4.00	3.15	3	3.20	14.00
E5343/16	3/16	24	4.763	58.0	11	5.00	4.00	3	3.70	20.00
E5341/4	1/4	20	6.350	66.0	13	6.30	5.00	3	5.10	26.00
E5345/16	5/16	18	7.938	72.0	16	8.00	6.30	3	6.50	29.00
E5343/8	3/8	16	9.525	80.0	18	10.00	8.00	3	7.90	32.00
E5347/16	7/16	14	11.112	85.0	19	8.00	6.30	3	9.20	–
E5341/2	1/2	12	12.700	89.0	22	9.00	7.10	3	10.50	–
E5345/8	5/8	11	15.875	102.0	24	12.50	10.00	3	13.50	–
E5343/4	3/4	10	19.050	112.0	29	14.00	11.20	4	16.50	–

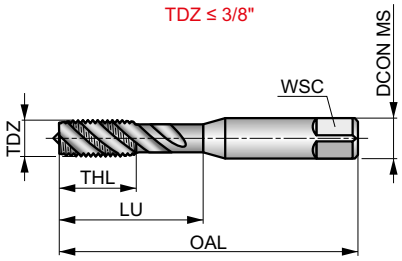
E533

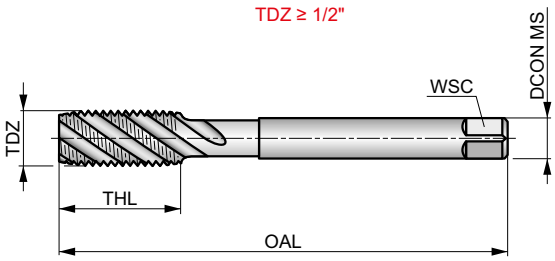
DORMER



HSS Spiral Flute Machine Tap, BSW, ISO Standard

Machine tap with spiral flute suited for blind holes. Available with bright finish to produce more accurate and cleaner threads, preventing the workpiece material from sticking to the cutting edges or BLUE finish with steam tempered surface, which acts to retain cutting fluid and prevent chip to tool welding.





BSW	ISO 529	Medium
	2×D	HSS
C 2-3		λ 40°
R	Bright ST	

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1
■10	■11	■13	■8	■7	■6	■7	■5	◪4	■4	◪3	■6	◪5	◪4

M2.2	M2.3	M3.1	M3.2	M3.3	M4.1	N1.3	N2.1	N2.2	N2.3
◪5	◪5	■5	◪4	◪3	◪2	◪5	◪12	◪10	◪8

Product	TDZ	TPI	TD [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	NOF	PHD [mm]	LU [mm]
E5331/8 [1]	1/8	40	3.175	48.0	12.5	3.15	2.50	3	2.55	12.50
E5331/8BLUE	1/8	40	3.175	48.0	12.5	3.15	2.50	3	2.55	12.50
E5333/16 [1]	3/16	24	4.763	58.0	11	5.00	4.00	3	3.70	20.00
E5333/16BLUE	3/16	24	4.763	58.0	11	5.00	4.00	3	3.70	20.00
E5331/4 [1]	1/4	20	6.350	66.0	13	6.30	5.00	3	5.10	26.00
E5331/4BLUE	1/4	20	6.350	66.0	13	6.30	5.00	3	5.10	26.00
E5335/16 [1]	5/16	18	7.938	72.0	16	8.00	6.30	3	6.50	31.00
E5335/16BLUE	5/16	18	7.938	72.0	16	8.00	6.30	3	6.50	31.00
E5333/8 [1]	3/8	16	9.525	80.0	18	10.00	8.00	3	7.90	34.00
E5333/8BLUE	3/8	16	9.525	80.0	18	10.00	8.00	3	7.90	34.00
E5331/2 [1]	1/2	12	12.700	89.0	22	9.00	7.10	3	10.50	–
E5331/2BLUE	1/2	12	12.700	89.0	22	9.00	7.10	3	10.50	–
E5335/8 [1]	5/8	11	15.875	102.0	24	12.50	10.00	3	13.50	–
E5335/8BLUE	5/8	11	15.875	102.0	24	12.50	10.00	3	13.50	–
E5333/4 [1]	3/4	10	19.050	112.0	29	14.00	11.20	3	16.50	–
E5333/4BLUE	3/4	10	19.050	112.0	29	14.00	11.20	3	16.50	–

[1] Bright Finish.

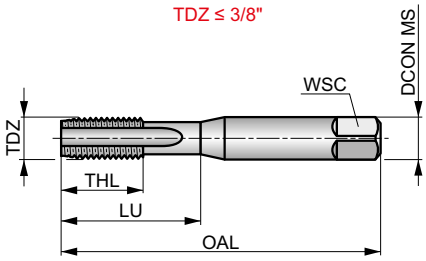
E536

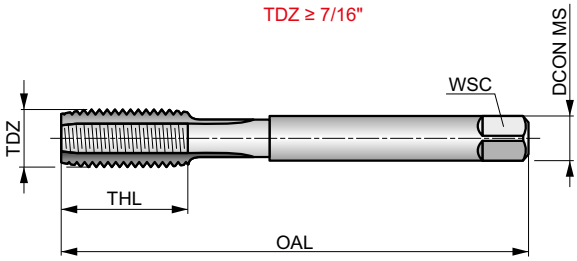
DORMER



HSS Straight Flute Hand Tap, BSF, ISO Standard

A versatile tool, suitable for hand and machine tapping, with a straight flute design for both through and blind holes. Available as a set of three N06 or as separate taps with taper lead N01 for short through holes, plug lead N02 for deeper through holes or bottoming lead N03 for blind holes.





BSF	ISO 529	Medium
	1.5×D	HSS
	R	Bright

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	K1.1	K1.2	K1.3	K2.1	K2.2
■7	■7	■8	■6	■5	◪4	■4	◪4	◪3	◪12	◪9	◪7	◪12	◪10

K3.1	K3.2	K4.1	K4.2	K5.1	K5.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	N4.2	N4.3
◪11	◪8	◪10	◪8	◪11	◪9	◪8	◪11	◪10	◪7	■17	■10	◪5	◪5	◪3

Product	TDZ	TPI	TD [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	NOF	PHD [mm]	LU [mm]
E5363/16N01	3/16	32	4.760	58.0	12	5.00	4.00	3	4.00	20.00
E5363/16N02	3/16	32	4.760	58.0	12	5.00	4.00	3	4.00	20.00
E5363/16N03	3/16	32	4.760	58.0	12	5.00	4.00	3	4.00	20.00
E5363/16N06	3/16	32	4.760	58.0	12	5.00	4.00	3	4.00	20.00
E5361/4N01	1/4	26	6.350	66.0	14	6.30	5.00	3	5.30	26.00
E5361/4N02	1/4	26	6.350	66.0	14	6.30	5.00	3	5.30	26.00
E5361/4N03	1/4	26	6.350	66.0	14	6.30	5.00	3	5.30	26.00
E5361/4N06	1/4	26	6.350	66.0	14	6.30	5.00	3	5.30	26.00
E5365/16N01	5/16	22	7.940	72.0	18	8.00	6.30	3	6.80	29.00
E5365/16N02	5/16	22	7.940	72.0	18	8.00	6.30	3	6.80	29.00
E5365/16N03	5/16	22	7.940	72.0	18	8.00	6.30	3	6.80	29.00
E5365/16N06	5/16	22	7.940	72.0	18	8.00	6.30	3	6.80	29.00
E5363/8N01	3/8	20	9.530	80.0	20	10.00	8.00	3	8.30	32.00
E5363/8N02	3/8	20	9.530	80.0	20	10.00	8.00	3	8.30	32.00
E5363/8N03	3/8	20	9.530	80.0	20	10.00	8.00	3	8.30	32.00
E5363/8N06	3/8	20	9.530	80.0	20	10.00	8.00	3	8.30	32.00
E5367/16N01	7/16	18	11.110	85.0	20	8.00	6.30	3	9.70	–
E5367/16N02	7/16	18	11.110	85.0	20	8.00	6.30	3	9.70	–
E5367/16N03	7/16	18	11.110	85.0	20	8.00	6.30	3	9.70	–
E5361/2N01	1/2	16	12.700	89.0	23	9.00	7.10	3	11.00	–
E5361/2N02	1/2	16	12.700	89.0	23	9.00	7.10	3	11.00	–
E5361/2N03	1/2	16	12.700	89.0	23	9.00	7.10	3	11.00	–
E5361/2N06	1/2	16	12.700	89.0	23	9.00	7.10	3	11.00	–
E5369/16N01	9/16	16	14.280	95.0	25	11.20	9.00	4	12.70	–
E5369/16N02	9/16	16	14.280	95.0	25	11.20	9.00	4	12.70	–
E5369/16N03	9/16	16	14.280	95.0	25	11.20	9.00	4	12.70	–
E5365/8N01	5/8	14	15.880	102.0	25	12.50	10.00	4	14.00	–
E5365/8N02	5/8	14	15.880	102.0	25	12.50	10.00	4	14.00	–

Product	TDZ	TPI	TD	OAL	THL	DCON MS	WSC	NOF	PHD	LU
			[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E5365/8N03	5/8	14	15.880	102.0	25	12.50	10.00	4	14.00	–
E5363/4N01	3/4	12	19.050	112.0	30	14.00	11.20	4	17.00	–
E5363/4N02	3/4	12	19.050	112.0	30	14.00	11.20	4	17.00	–
E5363/4N03	3/4	12	19.050	112.0	30	14.00	11.20	4	17.00	–
E5367/8N01	7/8	11	22.230	118.0	30	16.00	12.50	4	19.75	–
E5367/8N02	7/8	11	22.230	118.0	30	16.00	12.50	4	19.75	–
E5367/8N03	7/8	11	22.230	118.0	30	16.00	12.50	4	19.75	–
E5367/8N06	7/8	11	22.230	118.0	30	16.00	12.50	4	19.75	–
E5361N01	1″	10	25.400	130.0	36	18.00	14.00	4	22.75	–
E5361N02	1″	10	25.400	130.0	36	18.00	14.00	4	22.75	–
E5361N03	1″	10	25.400	130.0	36	18.00	14.00	4	22.75	–

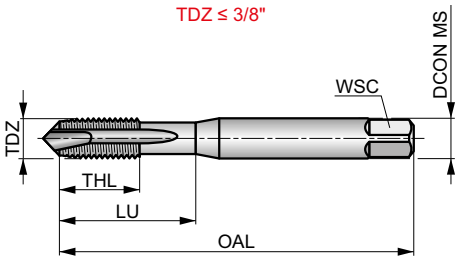
E539

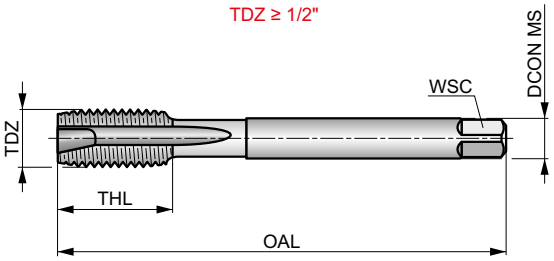
DORMER



HSS Spiral Point Machine Tap, BSF, ISO Standard

Machine tap with spiral point suited for through holes only. Steam tempered surface acts to retain cutting fluid and prevent chip to tool welding.





BSF	ISO 529	Medium
	2.5×D	HSS
B 3.5-5		R
ST		

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	P4.2	M1.1	M1.2	M2.1	M2.2
◪11	◪12	◪14	◪9	◪8	■7	◪8	■6	■5	◪4	■7	■6	◪6	◪5
M3.1	**M3.2**	**M3.3**	**M4.1**	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K3.1**	**K3.2**	**K4.1**	**K4.2**	**K5.1**
■5	◪4	◪3	◪2	◪9	◪6	◪4	◪12	◪9	◪10	◪6	◪9	◪5	◪11
K5.2													
◪7													

Product	TDZ	TPI	TD [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	NOF	PHD [mm]	LU [mm]
E5391/4	1/4	26	6.350	66.0	14	6.30	5.00	3	5.30	26.00
E5395/16	5/16	22	7.940	72.0	18	8.00	6.30	3	6.80	29.00
E5393/8	3/8	20	9.530	80.0	20	10.00	8.00	3	8.30	32.00
E5391/2	1/2	16	12.700	89.0	23	9.00	7.10	3	11.00	–

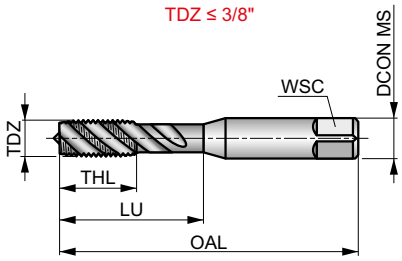
E538

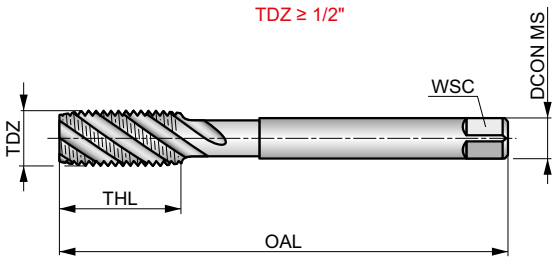
DORMER



HSS Spiral Flute Machine Tap, BSF, ISO Standard

Machine tap with spiral flute suited for blind holes. Available with bright finish to produce more accurate and cleaner threads, preventing the workpiece material from sticking to the cutting edges or BLUE finish with steam tempered surface, which acts to retain cutting fluid and prevent chip to tool welding.





BSF	ISO 529	Medium
2×D		HSS
C 2-3		λ 40°
R	Bright ST	

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1
■10	■11	■13	■8	■7	■6	■7	■5	◪4	■4	◪3	■6	◪5	◪4

M2.2	M2.3	M3.1	M3.2	M3.3	M4.1	N1.3	N2.1	N2.2	N2.3
◪5	◪5	■5	◪4	◪3	◪2	◪5	◪12	◪10	◪8

Product	TDZ	TPI	TD [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	NOF	PHD [mm]	LU [mm]
E5381/4 [1]	1/4	26	6.350	66.0	13	6.30	5.00	3	5.30	26.00
E5381/4BLUE	1/4	26	6.350	66.0	13	6.30	5.00	3	5.30	26.00
E5385/16 [1]	5/16	22	7.938	72.0	16	8.00	6.30	3	6.80	31.00
E5385/16BLUE	5/16	22	7.938	72.0	16	8.00	6.30	3	6.80	31.00
E5383/8 [1]	3/8	20	9.525	80.0	18	10.00	8.00	3	8.30	34.00
E5383/8BLUE	3/8	20	9.525	80.0	18	10.00	8.00	3	8.30	34.00
E5381/2 [1]	1/2	16	12.700	89.0	22	9.00	7.10	3	11.00	–
E5381/2BLUE	1/2	16	12.700	89.0	22	9.00	7.10	3	11.00	–

[1] Bright Finish.

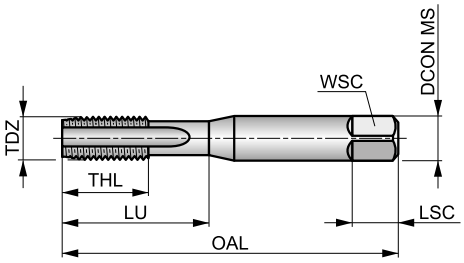
E542

DORMER



HSS Straight Flute Hand Tap, BA, ISO Standard

A versatile tool, suitable for hand and machine tapping, with a straight flute design for both through and blind holes. Available as a set of three NO6 or as separate taps with taper lead NO1 for short through holes, plug lead NO2 for deeper through holes or bottoming lead NO3 for blind holes.



BA	ISO 529	Normal
	1.5×D	HSS
	R	Bright

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	K1.1	K1.2	K1.3	K2.1	K2.2
■7	■7	■8	■6	■5	◪4	■4	◪4	◪3	◪12	◪9	◪7	◪12	◪10

K3.1	K3.2	K4.1	K4.2	K5.1	K5.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	N4.2	N4.3
◪11	◪8	◪10	◪8	◪11	◪9	◪8	◪11	◪10	◪7	■17	■10	◪5	◪5	◪3

Product	TDZ	TP [mm]	TD [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	LSC [mm]	NOF	PHD [mm]	LU [mm]
E542BA10NO1	BA10	0.35	1.700	41.0	7	2.50	2.00	4	2	1.30	7.00
E542BA10NO2	BA10	0.35	1.700	41.0	7	2.50	2.00	4	2	1.30	7.00
E542BA10NO3	BA10	0.35	1.700	41.0	7	2.50	2.00	4	2	1.30	7.00
E542BA10NO6	BA10	0.35	1.700	41.0	7	2.50	2.00	4	2	1.30	7.00
E542BA8NO1	BA 8	0.43	2.200	44.5	9.5	2.80	2.20	5	3	1.80	9.50
E542BA8NO2	BA 8	0.43	2.200	44.5	9.5	2.80	2.20	5	3	1.80	9.50
E542BA8NO3	BA 8	0.43	2.200	44.5	9.5	2.80	2.20	5	3	1.80	9.50
E542BA8NO6	BA 8	0.43	2.200	44.5	9.5	2.80	2.20	5	3	1.80	9.50
E542BA6NO1	BA 6	0.53	2.800	44.5	9.5	2.80	2.20	5	3	2.30	9.50
E542BA6NO2	BA 6	0.53	2.800	44.5	9.5	2.80	2.20	5	3	2.30	9.50
E542BA6NO3	BA 6	0.53	2.800	44.5	9.5	2.80	2.20	5	3	2.30	9.50
E542BA6NO6	BA 6	0.53	2.800	44.5	9.5	2.80	2.20	5	3	2.30	9.50
E542BA5NO1	BA 5	0.59	3.200	48.0	14.5	3.15	2.50	5	3	2.65	14.50
E542BA5NO2	BA 5	0.59	3.200	48.0	14.5	3.15	2.50	5	3	2.65	14.50
E542BA5NO3	BA 5	0.59	3.200	48.0	14.5	3.15	2.50	5	3	2.65	14.50
E542BA5NO6	BA 5	0.59	3.200	48.0	14.5	3.15	2.50	5	3	2.65	14.50
E542BA4NO1	BA 4	0.66	3.600	50.0	16.5	3.55	2.80	5	3	3.00	16.50
E542BA4NO2	BA 4	0.66	3.600	50.0	16.5	3.55	2.80	5	3	3.00	16.50
E542BA4NO3	BA 4	0.66	3.600	50.0	16.5	3.55	2.80	5	3	3.00	16.50
E542BA4NO6	BA 4	0.66	3.600	50.0	16.5	3.55	2.80	5	3	3.00	16.50
E542BA3NO1	BA 3	0.73	4.100	53.0	10	4.50	3.50	6	3	3.40	17.00
E542BA3NO2	BA 3	0.73	4.100	53.0	10	4.50	3.50	6	3	3.40	17.00
E542BA3NO3	BA 3	0.73	4.100	53.0	10	4.50	3.50	6	3	3.40	17.00
E542BA3NO6	BA 3	0.73	4.100	53.0	10	4.50	3.50	6	3	3.40	17.00
E542BA2NO1	BA 2	0.81	4.700	58.0	12	5.00	4.00	7	3	4.00	20.00
E542BA2NO2	BA 2	0.81	4.700	58.0	12	5.00	4.00	7	3	4.00	20.00
E542BA2NO3	BA 2	0.81	4.700	58.0	12	5.00	4.00	7	3	4.00	20.00
E542BA2NO6	BA 2	0.81	4.700	58.0	12	5.00	4.00	7	3	4.00	20.00

Product	TDZ	TP	TD	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E542BA0N01	BA 0	1.00	6.000	66.0	14	6.30	5.00	8	3	5.10	26.00
E542BA0N02	BA 0	1.00	6.000	66.0	14	6.30	5.00	8	3	5.10	26.00
E542BA0N03	BA 0	1.00	6.000	66.0	14	6.30	5.00	8	3	5.10	26.00
E542BA0N06	BA 0	1.00	6.000	66.0	14	6.30	5.00	8	3	5.10	26.00

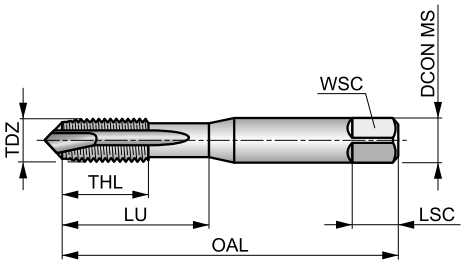
E545

DORMER



HSS Spiral Point Machine Tap, BA, ISO Standard

Machine tap with spiral point suited for through holes only. Steam tempered surface acts to retain cutting fluid and prevent chip to tool welding.



BA	ISO 529	Normal
	2.5×D	HSS
B 3.5-5		
ST		

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	P4.2	M1.1	M1.2	M2.1	M2.2
◪11	◪12	◪14	◪9	◪8	■7	◪8	■6	■5	◪4	■7	■6	◪4	◪5
M3.1	**M3.2**	**M3.3**	**M4.1**	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K3.1**	**K3.2**	**K4.1**	**K4.2**	**K5.1**
■5	◪4	◪3	◪2	◪9	◪6	◪4	◪12	◪9	◪10	◪6	◪9	◪5	◪11
K5.2													
◪7													

Product	TDZ	TP [mm]	TD [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	LSC [mm]	NOF	PHD [mm]	LU [mm]
E545BA10	BA10	0.35	1.700	41.0	7	2.50	2.00	4	2	1.30	7.00
E545BA8	BA 8	0.43	2.200	44.5	9.5	2.80	2.20	5	3	1.80	9.50
E545BA6	BA 6	0.53	2.800	44.5	9.5	2.80	2.20	5	3	2.30	9.50
E545BA4	BA 4	0.66	3.600	50.0	16.5	3.55	2.80	5	3	3.00	16.50
E545BA2	BA 2	0.81	4.700	58.0	12	5.00	4.00	7	3	4.00	20.00

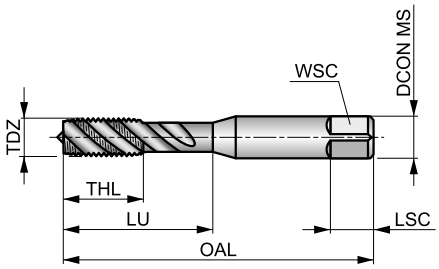
E544

DORMER



HSS Spiral Flute Machine Tap, BA, ISO Standard

Machine tap with spiral flute suited for blind holes. Available with bright finish to produce more accurate and cleaner threads, preventing the workpiece material from sticking to the cutting edges or BLUE finish with steam tempered surface, which acts to retain cutting fluid and prevent chip to tool welding.



BA	ISO 529	Normal
	2×D	HSS
C 2-3		λ 40°
R	Bright ST	

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1
■10	■11	■13	■8	■7	■6	■7	■5	◪4	■4	◪3	■6	◪5	◪4

M2.2	M2.3	M3.1	M3.2	M3.3	M4.1	N1.3	N2.1	N2.2	N2.3
◪5	◪5	■5	◪4	◪3	◪2	◪5	◪12	◪10	◪8

Product	TDZ	TP	TD	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E544BA8 [1]	BA 8	0.43	2.200	44.5	9.5	2.80	2.20	5	2	1.80	9.50
E544BA8BLUE	BA 8	0.43	2.200	44.5	9.5	2.80	2.20	5	2	1.80	9.50
E544BA6 [1]	BA 6	0.53	2.800	44.5	9.5	2.80	2.20	5	2	2.30	9.50
E544BA6BLUE	BA 6	0.53	2.800	44.5	9.5	2.80	2.20	5	2	2.30	9.50
E544BA4 [1]	BA 4	0.66	3.600	50.0	16.5	3.55	2.80	5	3	3.00	16.50
E544BA4BLUE	BA 4	0.66	3.600	50.0	16.5	3.55	2.80	5	3	3.00	16.50
E544BA2 [1]	BA 2	0.81	4.700	58.0	12	5.00	4.00	7	3	4.00	20.00
E544BA2BLUE	BA 2	0.81	4.700	58.0	12	5.00	4.00	7	3	4.00	20.00

[1] Bright Finish.

E119

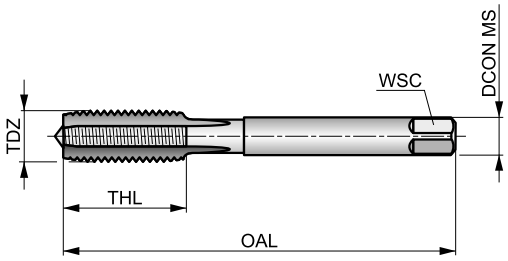
DORMER

HSS Straight Flute Serial Hand Tap, G(BSP), DIN Standard

Ideal for hand tapping tough materials. The straight flute design makes it ideal for both through and blind holes. Available as a single finishing tap or as a set of two serial taps, which should be used one after the other to create the full thread.



G	DIN 5157	Normal
	1.5×D	HSS
C 2-3		R
Bright		



Workpiece material group suitability.

P1.1 ■	P1.2 ■	P1.3 ■	P2.1 ■	P2.2 ■	P2.3 ◪	P3.1 ■	P3.2 ◪	P4.1 ◪	K1.1 ◪	K1.2 ◪	K1.3 ◪	K2.1 ◪	K2.2 ◪
K3.1 ◪	K3.2 ◪	K4.1 ◪	K4.2 ◪	K5.1 ◪	K5.2 ◪	N1.1 ■	N1.2 ■	N1.3 ■	N2.1 ■	N2.2 ■	N2.3 ■	N3.1 ■	N3.2 ■
N3.3 ■	N4.2 ■	N4.3 ■											

Product	TDZ	TPI	TD [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	NOF	PHD [mm]
E1191/8N03	1/8	28	9.730	63.0	15	7.00	5.50	3	8.80
E1191/8N09	1/8	28	9.730	63.0	15	7.00	5.50	3	8.80
E1191/4N03	1/4	19	13.160	70.0	16	11.00	9.00	4	11.80
E1191/4N09	1/4	19	13.160	70.0	16	11.00	9.00	4	11.80
E1193/8N03	3/8	19	16.660	70.0	16	12.00	9.00	4	15.25
E1193/8N09	3/8	19	16.660	70.0	16	12.00	9.00	4	15.25
E1191/2N03	1/2	14	20.960	80.0	18	16.00	12.00	4	19.00
E1191/2N09	1/2	14	20.960	80.0	18	16.00	12.00	4	19.00
E1195/8N03	5/8	14	22.910	80.0	22	18.00	14.50	4	21.00
E1195/8N09	5/8	14	22.910	80.0	22	18.00	14.50	4	21.00
E1193/4N03	3/4	14	26.440	90.0	22	20.00	16.00	4	24.50
E1193/4N09	3/4	14	26.440	90.0	22	20.00	16.00	4	24.50
E1197/8N03	7/8	14	30.200	90.0	22	22.00	18.00	6	28.25
E1197/8N09	7/8	14	30.200	90.0	22	22.00	18.00	6	28.25
E1191N03	1″	11	33.250	100.0	25	25.00	20.00	6	30.75
E1191N09	1″	11	33.250	100.0	25	25.00	20.00	6	30.75
E1191.1/8N03	1.1/8	11	37.900	125.0	40	28.00	22.00	6	35.00
E1191.1/8N09	1.1/8	11	37.900	125.0	40	28.00	22.00	6	35.00
E1191.1/4N03	1.1/4	11	41.910	125.0	40	32.00	24.00	6	39.50
E1191.1/4N09	1.1/4	11	41.910	125.0	40	32.00	24.00	6	39.50
E1191.1/2N03	1.1/2	11	47.800	140.0	40	36.00	29.00	6	45.00
E1191.1/2N09	1.1/2	11	47.800	140.0	40	36.00	29.00	6	45.00
E1191.3/4N03	1.3/4	11	53.750	140.0	40	40.00	32.00	6	51.00
E1191.3/4N09	1.3/4	11	53.750	140.0	40	40.00	32.00	6	51.00
E1192N03	2″	11	59.610	160.0	40	45.00	35.00	6	57.00
E1192N09	2″	11	59.610	160.0	40	45.00	35.00	6	57.00
E1192.1/4N03	2.1/4	11	65.710	160.0	40	50.00	39.00	6	63.00
E1192.1/4N09	2.1/4	11	65.710	160.0	40	50.00	39.00	6	63.00

Product	TDZ	TPI	TD	OAL	THL	DCON MS	WSC	NOF	PHD
			[mm]	[mm]	[mm]	[mm]	[mm]		[mm]
E1192.1/2N03	2.1/2	11	75.180	160.0	40	50.00	39.00	6	72.50
E1192.1/2N09	2.1/2	11	75.180	160.0	40	50.00	39.00	6	72.50
E1192.3/4N03	2.3/4	11	81.530	160.0	40	50.00	39.00	8	79.00
E1192.3/4N09	2.3/4	11	81.530	160.0	40	50.00	39.00	8	79.00
E1193N03	3″	11	87.880	160.0	40	50.00	39.00	8	85.50
E1193N09	3″	11	87.880	160.0	40	50.00	39.00	8	85.50

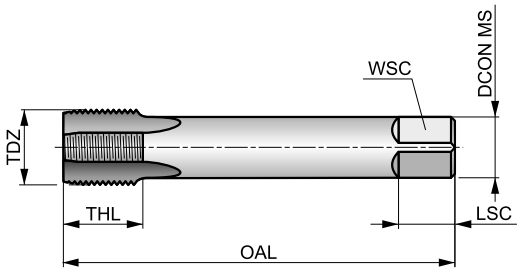
E282

DORMER



HSS-E-PM Straight Flute Machine Tap G(BSP), DIN Standard

General purpose straight flute machine tap for through and blind holes. Bright finish to produce more accurate and cleaner threads, preventing the workpiece material from sticking to the cutting edges. The reduced shank increases the reach of the tap.



G	DIN 5156	Normal
	1.5×D	HSS-E PM
C 2-3		R
Bright		

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	K1.1	K1.2	K1.3	K2.1	K2.2
■11	■12	■12	■9	■8	◪7	■7	◪6	◪4	◪13	◪10	◪8	◪14	◪11

K3.1	K3.2	K4.1	K4.2	K5.1	K5.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N4.2
◪13	◪10	◪12	◪9	◪12	◪10	◪12	◪15	◪14	◪11	◪21	■14	◪8

Product	TDZ	TPI	TD [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	LSC [mm]	NOF	PHD [mm]
E2821/8	1/8	28	9.730	90.0	20	7.00	5.50	8	3	8.80
E2821/4	1/4	19	13.160	100.0	21	11.00	9.00	12	4	11.80
E2823/8	3/8	19	16.660	100.0	21	12.00	9.00	12	4	15.25
E2821/2	1/2	14	20.960	125.0	24	16.00	12.00	15	4	19.00
E2823/4	3/4	14	26.440	140.0	28	20.00	16.00	19	4	24.50
E2821	1″	11	33.250	160.0	30	25.00	20.00	23	4	30.75
E2821.1/4 [1)]	1.1/4	11	41.910	170.0	30	32.00	24.00	27	4	39.50
E2821.1/2 [1)]	1.1/2	11	47.800	190.0	32	36.00	29.00	32	6	45.00

[1)] HSS-E.

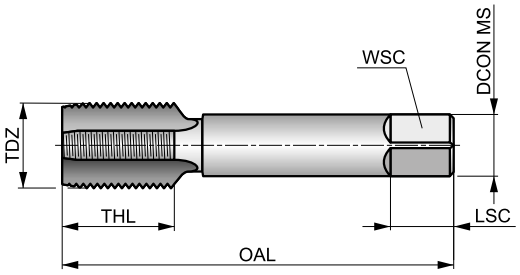
E547

DORMER



HSS Straight Flute Hand Tap G(BSP), ISO Standard

A versatile tool, suitable for hand and machine tapping, with a straight flute design for both through and blind holes. Available with taper lead N01 for short through holes, plug lead N02 for deeper through holes or bottoming lead N03 for blind holes. Also, as set N07 with a plug lead and bottoming lead tap.



G	ISO 2284	Normal
	1.5×D	HSS
	R	Bright

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	K1.1	K1.2	K1.3	K2.1	K2.2
■7	■7	■8	■6	■5	◪4	■4	◪4	◪3	◪12	◪9	◪7	◪12	◪10

K3.1	K3.2	K4.1	K4.2	K5.1	K5.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	N4.2	N4.3
◪11	◪8	◪10	◪8	◪11	◪9	◪8	◪11	◪10	◪7	◪17	◪10	◪5	◪5	◪3

Product	TDZ	TPI	TD [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	LSC [mm]	NOF	PHD [mm]
E5471/8N01	1/8	28	9.728	59.0	15	8.00	8.00	9	4	8.80
E5471/8N02	1/8	28	9.728	59.0	15	8.00	6.30	9	4	8.80
E5471/8N03	1/8	28	9.728	59.0	15	8.00	6.30	9	4	8.80
E5471/8N07	1/8	28	9.728	59.0	15	8.00	6.30	9	4	8.80
E5471/4N01	1/4	19	13.157	67.0	19	10.00	8.00	11	4	11.80
E5471/4N02	1/4	19	13.157	67.0	19	10.00	8.00	11	4	11.80
E5471/4N03	1/4	19	13.157	67.0	19	10.00	8.00	11	4	11.80
E5471/4N07	1/4	19	13.157	67.0	19	10.00	8.00	11	4	11.80
E5473/8N01	3/8	19	16.662	75.0	21	12.50	10.00	13	4	15.25
E5473/8N02	3/8	19	16.662	75.0	21	12.50	10.00	13	4	15.25
E5473/8N03	3/8	19	16.662	75.0	21	12.50	10.00	13	4	15.25
E5473/8N07	3/8	19	16.662	75.0	21	12.50	10.00	13	4	15.25
E5471/2N01	1/2	14	20.955	87.0	26	16.00	12.50	16	4	19.00
E5471/2N02	1/2	14	20.955	87.0	26	16.00	12.50	16	4	19.00
E5471/2N03	1/2	14	20.955	87.0	26	16.00	12.50	16	4	19.00
E5471/2N07	1/2	14	20.955	87.0	26	16.00	12.50	16	4	19.00
E5475/8N01	5/8	14	22.911	91.0	26	18.00	14.00	18	4	21.00
E5475/8N02	5/8	14	22.911	91.0	26	18.00	14.00	18	4	21.00
E5475/8N03	5/8	14	22.911	91.0	26	18.00	14.00	18	4	21.00
E5475/8N07	5/8	14	22.911	91.0	26	18.00	14.00	18	4	21.00
E5473/4N01	3/4	14	26.441	96.0	28	20.00	16.00	20	4	24.50
E5473/4N02	3/4	14	26.441	96.0	28	20.00	16.00	20	4	24.50
E5473/4N03	3/4	14	26.441	96.0	28	20.00	16.00	20	4	24.50
E5473/4N07	3/4	14	26.441	96.0	28	20.00	16.00	20	4	24.50
E5477/8N01	7/8	14	30.201	102.0	29	22.40	18.00	22	4	28.25
E5477/8N02	7/8	14	30.201	102.0	29	22.40	18.00	22	4	28.25
E5477/8N03	7/8	14	30.201	102.0	29	22.40	18.00	22	4	28.25
E5471N01	1"	11	33.249	109.0	33	25.00	20.00	24	4	30.75

Product	TDZ	TPI	TD	OAL	THL	DCON MS	WSC	LSC	NOF	PHD
			[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]
E5471N02	1″	11	33.249	109.0	33	25.00	20.00	24	4	30.75
E5471N03	1″	11	33.249	109.0	33	25.00	20.00	24	4	30.75
E5471.1/4N01	1.1/4	11	41.910	119.0	36	31.50	25.00	28	6	39.50
E5471.1/4N02	1.1/4	11	41.910	119.0	36	31.50	25.00	28	6	39.50
E5471.1/4N03	1.1/4	11	41.910	119.0	36	31.50	25.00	28	6	39.50
E5471.1/2N01	1.1/2	11	47.803	125.0	37	35.50	28.00	31	6	45.00
E5471.1/2N02	1.1/2	11	47.803	125.0	37	35.50	28.00	31	6	45.00
E5471.1/2N03	1.1/2	11	47.803	125.0	37	35.50	28.00	31	6	45.00
E5472N01	2″	11	59.614	140.0	41	40.00	31.50	34	6	57.00
E5472N02	2″	11	59.614	140.0	41	40.00	31.50	34	6	57.00
E5472N03	2″	11	59.614	140.0	41	40.00	31.50	34	6	57.00

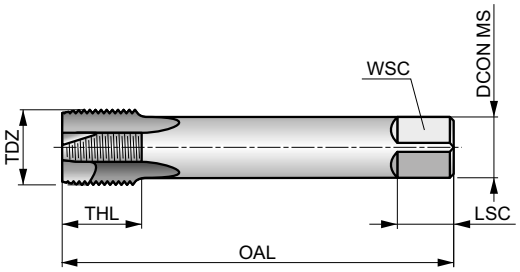
EP40

DORMER



HSS-E-PM Spiral Point Machine Tap G(BSP), DIN Standard

Machine tap with spiral point suited for through holes only. Bright finish to produce more accurate and cleaner threads, preventing the workpiece material from sticking to the cutting edges. The reduced shank increases the reach of the tap.



G	DIN 5156	Normal
	2.5×D	HSS-E PM
B 3.5-5		R
Bright		

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	N1.1	N1.2	N1.3	N2.1	N2.2
■ 22	■ 24	■ 25	■ 18	■ 16	◪ 14	■ 13	◪ 10	◪ 8	■ 14	■ 10	■ 7	■ 28	■ 25

N2.3	N3.1	N3.2	N3.3	N4.1
■ 18	■ 44	◪ 27	■ 13	◪ 22

Product	TDZ	TPI	TD	OAL	THL	DCON MS	WSC	LSC	NOF	PHD
			[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]
EP401/8	1/8	28	9.728	90.0	18	7.00	5.50	8	3	8.80
EP401/4	1/4	19	13.157	100.0	21	11.00	9.00	12	3	11.80
EP403/8	3/8	19	16.662	100.0	21	12.00	9.00	12	4	15.25
EP401/2	1/2	14	20.955	125.0	24	16.00	12.00	15	4	19.00
EP405/8	5/8	14	22.911	125.0	24	18.00	14.50	17	4	21.00
EP403/4	3/4	14	26.441	140.0	28	20.00	16.00	19	4	24.50
EP407/8	7/8	14	30.201	150.0	28	22.00	18.00	21	4	28.25
EP401	1"	11	33.249	160.0	30	25.00	20.00	23	4	30.75

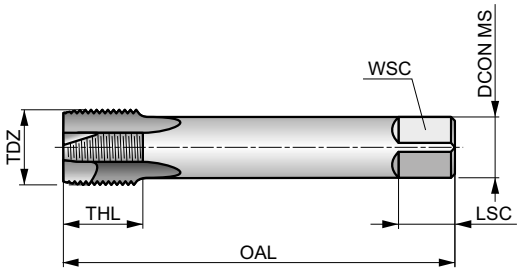
EP41

DORMER



HSS-E-PM Spiral Point Machine Tap, G(BSP), DIN Standard

Machine tap with spiral point suited for through holes only. Steam tempered surface acts to retain cutting fluid and prevent chip to tool welding. The reduced shank increases the reach of the tap.



G	DIN 5156	Normal
	2.5×D	HSS-E PM
B 3.5-5		R
ST		

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P2.2	P2.3	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1	M2.2	M3.1	M3.2	M3.3
◪22	◪16	■14	■10	◪9	■8	◪6	◪10	◪8	◪9	◪7	◪7	◪6	◪5

M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K3.1	K3.2	K4.1	K4.2	K5.1	K5.2
◪4	◪13	◪10	◪7	◪16	◪13	◪14	◪10	◪13	◪9	◪15	◪11

Product	TDZ	TPI	TD [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	LSC [mm]	NOF	PHD [mm]
EP411/8	1/8	28	9.728	90.0	18	7.00	5.50	8	3	8.80
EP411/4	1/4	19	13.157	100.0	21	11.00	9.00	12	3	11.80
EP413/8	3/8	19	16.662	100.0	21	12.00	9.00	12	4	15.25
EP411/2	1/2	14	20.955	125.0	24	16.00	12.00	15	4	19.00
EP415/8	5/8	14	22.911	125.0	24	18.00	14.50	17	4	21.00
EP413/4	3/4	14	26.441	140.0	28	20.00	16.00	19	4	24.50
EP417/8	7/8	14	30.201	150.0	28	22.00	18.00	21	4	28.25
EP411	1″	11	33.249	160.0	30	25.00	20.00	23	4	30.75

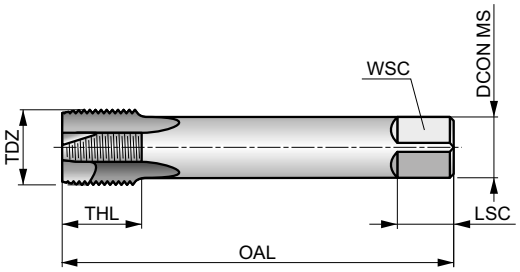
E041

DORMER



HSS-E-PM Spiral Point Machine Tap, G(BSP), ISO Standard

Machine tap with spiral point suited for through holes only. Steam tempered surface acts to retain cutting fluid and prevent chip to tool welding. The reduced shank increases the reach of the tap.



G	ISO DORMER	Normal
	2.5×D	HSS-E PM
B 3.5-5		R
ST		

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P2.2	P2.3	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1	M2.2	M3.1	M3.2	M3.3
◪22	◪16	■14	■10	◪9	■8	◪6	◪10	◪8	◪9	◪7	◪7	◪6	◪5

M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K3.1	K3.2	K4.1	K4.2	K5.1	K5.2
◪4	◪13	◪10	◪7	◪16	◪13	◪14	◪10	◪13	◪9	◪15	◪11

Product	TDZ	TPI	TD	OAL	THL	DCON MS	WSC	LSC	NOF	PHD
			[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]
E0411/8	1/8	28	9.728	90.0	15	8.00	6.30	9	3	8.80
E0411/4	1/4	19	13.157	100.0	19	10.00	8.00	11	3	11.80
E0413/8	3/8	19	16.662	100.0	21	12.50	10.00	13	3	15.25
E0411/2	1/2	14	20.955	125.0	26	16.00	12.50	16	4	19.00
E0413/4	3/4	14	26.441	140.0	28	20.00	16.00	20	4	24.50

EX40

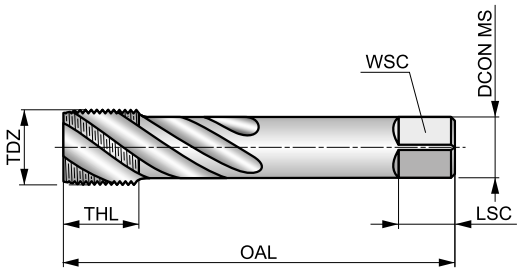
DORMER



HSS-E-PM Spiral Flute Machine Tap, UNC, DIN Standard

Machine tap with spiral flute suited for blind holes. Bright finish to produce more accurate and cleaner threads preventing the workpiece material from sticking to the cutting edges.

G	DIN 5156	Normal
	2.5×D	HSS-E PM
C 2-3		λ 45°
R	Bright	



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3
■ 21	■ 23	■ 24	■ 17	■ 15	◪ 13	■ 12	◪ 9	◪ 7	■ 13	■ 9	■ 6	■ 27	■ 24	■ 17

Product	TDZ	TPI	TD [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	LSC [mm]	NOF	PHD [mm]
EX401/8	1/8	28	9.728	90.0	13	7.00	5.50	8	3	8.80
EX401/4	1/4	19	13.157	100.0	15	11.00	9.00	12	3	11.80
EX403/8	3/8	19	16.662	100.0	15	12.00	9.00	12	4	15.25
EX401/2	1/2	14	20.955	125.0	18	16.00	12.00	15	4	19.00
EX405/8	5/8	14	22.911	125.0	18	18.00	14.50	17	4	21.00
EX403/4	3/4	14	26.441	140.0	20	20.00	16.00	19	4	24.50
EX407/8	7/8	14	30.201	150.0	20	22.00	18.00	21	4	28.25
EX401	1″	11	33.249	160.0	22	25.00	20.00	23	4	30.75
EX401.1/8	1.1/8	11	37.897	170.0	22	28.00	22.00	25	4	35.00
EX401.1/4 [1]	1.1/4	11	41.910	170.0	22	32.00	24.00	27	4	39.50
EX401.1/2 [1]	1.1/2	11	47.803	190.0	23	36.00	29.00	32	4	45.00

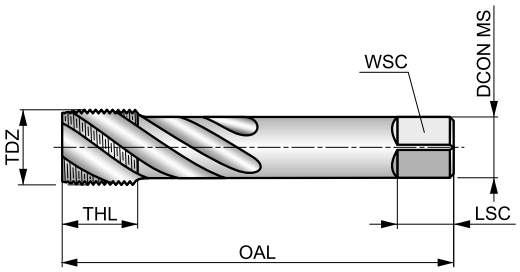
[1] HSS-E.

EX41



HSS-E-PM Spiral Flute Machine Tap, G(BSP), DIN Standard

Machine tap with spiral flute suited for blind holes. Steam tempered surface acts to retain cutting fluid and prevent chip to tool welding. The reduced shank increases the reach of the tap.



G	DIN 5156	Normal
	2.5×D	HSS-E PM
C 2-3		λ 45°
R	ST	

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P2.2	P2.3	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1	M2.2	M3.1	M3.2	M3.3	M4.1
◪21	◪15	■13	■9	◪8	■7	◪5	◪8	◪6	◪7	◪5	◪5	◪4	◪3	◪3

Product	TDZ	TPI	TD	OAL	THL	DCON MS	WSC	LSC	NOF	PHD
			[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]
EX411/8	1/8	28	9.728	90.0	13	7.00	5.50	8	3	8.80
EX411/4	1/4	19	13.157	100.0	15	11.00	9.00	12	3	11.80
EX413/8	3/8	19	16.662	100.0	15	12.00	9.00	12	4	15.25
EX411/2	1/2	14	20.955	125.0	18	16.00	12.00	15	4	19.00
EX415/8	5/8	14	22.911	125.0	18	18.00	14.50	17	4	21.00
EX413/4	3/4	14	26.441	140.0	20	20.00	16.00	19	4	24.50
EX417/8	7/8	14	30.201	150.0	20	22.00	18.00	21	4	28.25
EX411	1″	11	33.249	160.0	22	25.00	20.00	23	4	30.75
EX411.1/8	1.1/8	11	37.897	170.0	22	28.00	22.00	25	4	35.00
EX411.1/4 [1]	1.1/4	11	41.910	170.0	22	32.00	24.00	27	4	39.50
EX411.1/2 [1]	1.1/2	11	47.803	190.0	23	36.00	29.00	32	4	45.00

[1] HSS-E.

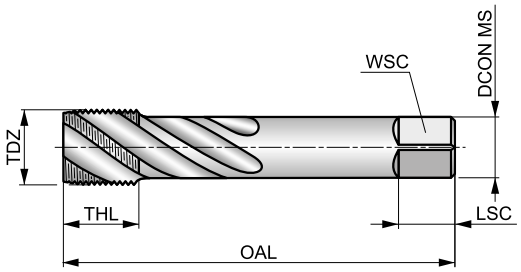
E043

DORMER



HSS-E-PM Spiral Flute Machine tap, G(BSP), ISO Standard

Machine tap with spiral flute suited for blind holes. Steam tempered surface acts to retain cutting fluid and prevent chip to tool welding. The reduced shank increases the reach of the tap.



G	ISO DORMER	Normal
	2.5×D	HSS-E PM
C 2-3		λ 45°
R	ST	

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P2.2	P2.3	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1	M2.2	M3.1	M3.2	M3.3	M4.1
◪21	◪15	■13	■9	◪8	■7	◪5	◪8	◪6	◪7	◪5	◪5	◪4	◪3	◪3

Product	TDZ	TPI	TD [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	LSC [mm]	NOF	PHD [mm]
E0431/8	1/8	28	9.728	90.0	15	8.00	6.30	9	3	8.80
E0431/4	1/4	19	13.157	100.0	19	10.00	8.00	11	3	11.80
E0433/8	3/8	19	16.662	100.0	21	12.50	10.00	13	4	15.25
E0431/2	1/2	14	20.955	125.0	26	16.00	12.50	16	4	19.00
E0433/4	3/4	14	26.441	140.0	28	20.00	16.00	20	4	24.50

E620

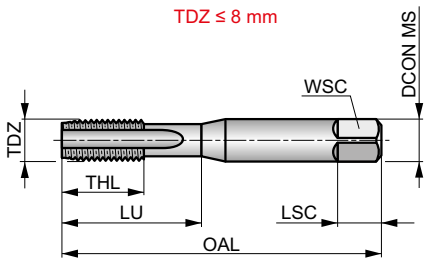
DORMER

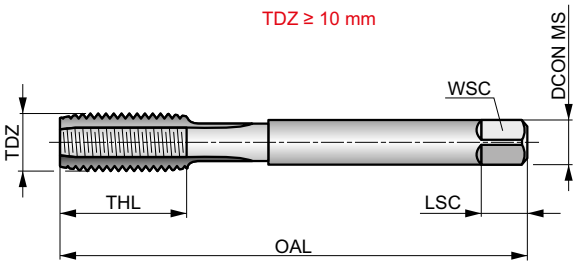


HSS Straight Flute Machine Tap, Metric for Helicoil Insert, ISO Standard

General purpose straight flute machine tap for through and blind holes. Bright finish to produce more accurate and cleaner threads for Screw-Thread-Inserts. These STIs are inserted into the threaded hole, produced with this tap, to reinforce the original thread or repair damaged ones.

EGM	ISO DORMER	6H
LU	1.5×D	HSS
C 2-3		R
Bright		





Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	K1.1	K1.2	K1.3	K2.1	K2.2
■7	■7	■8	■6	■5	◪4	■4	◪4	◪3	◪12	◪9	◪7	◪12	◪10

K3.1	K3.2	K4.1	K4.2	K5.1	K5.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	N4.2
◪11	◪8	◪10	◪8	◪11	◪9	◪8	◪11	◪10	◪7	■17	■10	◪5	◪5

N4.3
◪3

Product	TDZ	TP	TD	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]
E620M3	3	0.50	3.650	53.0	14	4.00	3.15	6	3	3.20	14.00
E620M4	4	0.70	4.910	58.0	11	5.00	4.00	7	3	4.20	20.00
E620M5	5	0.80	6.040	66.0	13	6.30	5.00	8	3	5.20	26.00
E620M6	6	1.00	7.300	72.0	16	8.00	6.30	9	3	6.30	29.00
E620M8	8	1.25	9.620	80.0	18	10.00	8.00	11	3	8.40	32.00
E620M10	10	1.50	11.950	89.0	22	9.00	7.10	10	3	10.50	–
E620M12	12	1.75	14.270	95.0	24	11.20	9.00	12	4	12.50	–
E620M14	14	2.00	16.600	112.0	29	14.00	11.20	14	4	14.50	–
E620M16	16	2.00	18.600	112.0	29	14.00	11.20	14	4	16.50	–

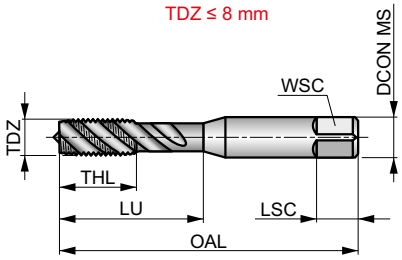
E621

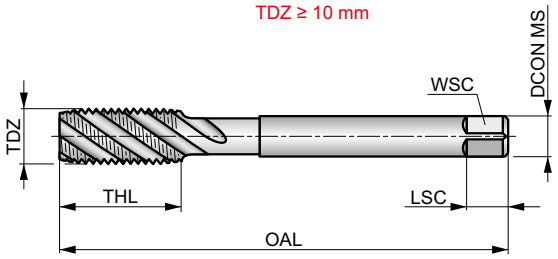


HSS Spiral Flute Machine Tap, Metric for Helicoil Insert, ISO Standard

Machine tap with spiral flute suited for blind holes. Bright finish to produce more accurate and cleaner threads for Screw-Thread-Inserts. These STIs are inserted into the threaded hole, produced with this tap, to reinforce the original thread or repair damaged ones.

EGM	ISO DORMER	6H
	2×D	HSS
C 2-3		λ 40°
R	Bright	





Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	N1.3	N2.1	N2.2	N2.3
■10	■11	■13	■8	■7	◪6	■7	◪5	◪4	◪5	◪12	◪10	◪8

Product	TDZ	TP [mm]	TD [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	LSC [mm]	NOF	PHD [mm]	LU [mm]
E621M3	3	0.50	3.650	53.0	14	4.00	3.15	6	3	3.20	14.00
E621M4	4	0.70	4.910	58.0	11	5.00	4.00	7	3	4.20	20.00
E621M5	5	0.80	6.040	66.0	13	6.30	5.00	8	3	5.20	26.00
E621M6	6	1.00	7.300	72.0	16	8.00	6.30	9	3	6.30	31.00
E621M8	8	1.25	9.620	80.0	18	10.00	8.00	11	3	8.40	34.00
E621M10	10	1.50	11.950	89.0	22	9.00	7.10	10	3	10.50	–
E621M12	12	1.75	14.270	95.0	24	11.20	9.00	12	3	12.50	–
E621M14	14	2.00	16.600	112.0	29	14.00	11.20	14	3	14.50	–
E621M16	16	2.00	18.600	112.0	29	14.00	11.20	14	3	16.50	–

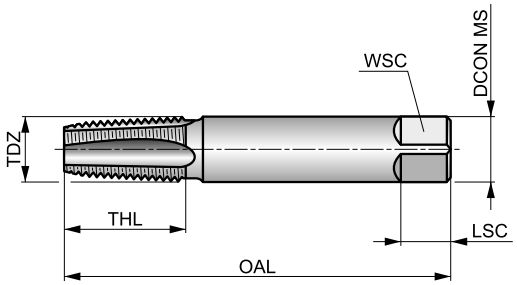
E550

DORMER



HSS Straight Flute Serial Hand Tap, Rc(BSPT), ISO Standard

Ideal for hand tapping tough materials. The straight flute design makes it ideal for both through and blind holes. Available as a single finishing tap or as a set of two serial taps, which should be used one after the other to create the full thread.



Rc	ISO 2284	Normal
	1.5×D	HSS
C 2-3		R
Bright		

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	M1.1	M1.2	M2.1	M2.2	M3.1
■7	■7	■8	■6	■5	◪4	■4	◪4	◪3	◪5	◪4	◪5	◪4	◪5
M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K3.1	K3.2	K4.1	K4.2	K5.1	K5.2
◪4	◪3	◪3	◪6	◪4	◪3	◪7	◪6	◪7	◪5	◪6	◪5	◪7	◪5
N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	N4.2	N4.3					
◪8	◪11	◪10	◪7	■17	■10	◪5	◪5	◪3					

Product	TDZ	TPI	TD [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	LSC [mm]	NOF	PHD [mm]
E5501/8	1/8	28	9.728	59.0	15	8.00	6.30	9	3	8.40
E5501/8N07	1/8	28	9.728	59.0	15	8.00	6.30	9	3	8.40
E5501/4	1/4	19	13.157	67.0	19	10.00	8.00	11	3	11.20
E5501/4N07	1/4	19	13.157	67.0	19	10.00	8.00	11	3	11.20
E5503/8	3/8	19	16.662	75.0	21	12.50	10.00	13	3	14.75
E5503/8N07	3/8	19	16.662	75.0	21	12.50	10.00	13	3	14.75
E5501/2	1/2	14	20.955	87.0	26	16.00	12.50	16	5	18.25
E5501/2N07	1/2	14	20.955	87.0	26	16.00	12.50	16	5	18.25
E5503/4	3/4	14	26.441	96.0	28	20.00	16.00	20	5	23.75
E5503/4N07	3/4	14	26.441	96.0	28	20.00	16.00	20	5	23.75
E5501	1″	11	33.249	109.0	33	25.00	20.00	24	5	30.00
E5501.1/4	1.1/4	11	41.910	119.0	36	31.50	25.00	28	5	38.50
E5501.1/2	1.1/2	11	47.803	125.0	37	35.50	28.00	31	7	44.50
E5502	2″	11	59.614	140.0	41	40.00	31.50	34	7	56.00

E714

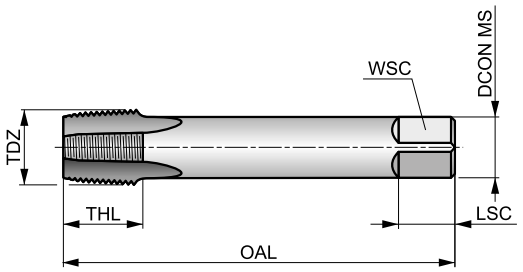
DORMER



HSS-E-PM Straight Flute Machine Tap, NPT, ANSI Standard

General purpose straight flute machine tap for through and blind holes. Bright finish to produce more accurate and cleaner threads, preventing the workpiece material from sticking to the cutting edges.

NPT	ANSI DORMER	Normal
	1.5×D	HSS-E PM
C 2-3		R
Bright		



Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	K1.1	K1.2	K1.3
■8	■9	■9	■7	■6	◪5	■4	◪4	◪3	■3	◪2	◪6	◪4	◪3
K2.1	**K2.2**	**K3.1**	**K3.2**	**K4.1**	**K4.2**	**K5.1**	**K5.2**	**N1.3**	**N2.1**	**N2.2**	**N2.3**	**N3.1**	**N3.2**
◪7	◪6	◪7	◪5	◪6	◪5	◪7	◪5	◪9	◪12	◪11	◪8	■18	■11

Product	TDZ	TPI	TD [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	LSC [mm]	NOF	PHD [mm]
E7141/8	1/8	27	10.230	90.0	14	11.00	9.00	12	3	8.50
E7141/4	1/4	18	13.600	100.0	20	14.00	11.00	14	3	11.00
E7143/8	3/8	18	17.040	110.0	20	16.00	12.00	15	4	14.50
E7141/2	1/2	14	21.200	125.0	26	18.00	14.50	17	4	18.00
E7143/4	3/4	14	26.540	140.0	26	22.00	18.00	21	5	23.00
E7141	1″	11.5	33.200	150.0	31	28.00	22.00	25	5	29.00

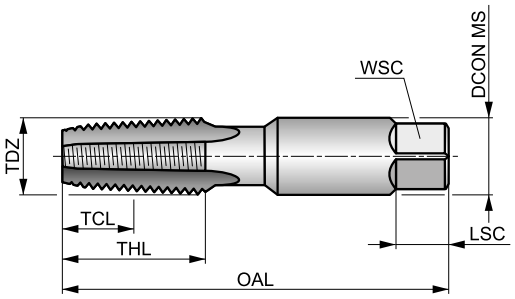
E710

DORMER



HSS Straight Flute Serial Hand Tap, NPT, ANSI Standard

Ideal for hand tapping tough materials. The straight flute design makes it ideal for both through and blind holes. Available as a single finishing tap or as a set of two serial taps, which should be used one after the other to create the full thread.



NPT	ANSI B94.9	Normal
	1.5×D	HSS
C 2-3		R
Bright		

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	K1.1	K1.2	K1.3	K2.1	K2.2
■7	■7	■8	■6	■5	◪4	■4	◪4	◪3	◪6	◪4	◪3	◪7	◪6

K3.1	K3.2	K4.1	K4.2	K5.1	K5.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	N4.2
◪7	◪5	◪6	◪5	◪7	◪5	◪8	◪11	◪10	◪7	■17	■10	◪5	◪5

N4.3
◪3

Product	TDZ	TPI	TD [mm]	OAL [mm]	THL [mm]	TCL [mm]	DCON MS [mm]	WSC [mm]	LSC [mm]	NOF	PHD [mm]
E7101/16N03	1/16	27	7.940	65.0	17	11.70	8.10	6.00	8	4	6.30
E7101/8	1/8	27	10.290	70.0	19	11.90	11.10	8.30	10	4	8.50
E7101/8N07	1/8	27	10.290	70.0	19	11.90	11.10	8.30	10	4	8.50
E7101/4	1/4	18	13.720	75.0	27	17.60	14.30	10.70	11	4	11.00
E7101/4N07	1/4	18	13.720	75.0	27	17.60	14.30	10.70	11	4	11.00
E7103/8	3/8	18	17.150	80.0	27	19.50	17.80	13.50	13	4	14.50
E7103/8N07	3/8	18	17.150	80.0	27	19.50	17.80	13.50	13	4	14.50
E7101/2	1/2	14	21.340	100.0	35	22.70	17.50	13.10	16	4	18.00
E7101/2N07	1/2	14	21.340	100.0	35	22.70	17.50	13.10	16	4	18.00
E7103/4	3/4	14	26.670	105.0	35	24.40	23.00	17.20	17	5	23.00
E7103/4N07	3/4	14	26.670	105.0	35	24.40	23.00	17.20	17	5	23.00
E7101	1″	11.5	33.400	115.0	43	29.40	28.60	21.40	21	5	29.00
E7101.1/4	1.1/4	11.5	42.160	125.0	43	27.70	33.30	25.00	24	5	38.00
E7101.1/2	1.1/2	11.5	48.260	135.0	43	28.90	38.10	28.60	25	7	44.00
E7102	2″	11.5	60.330	145.0	43	26.60	47.60	35.70	29	7	56.00

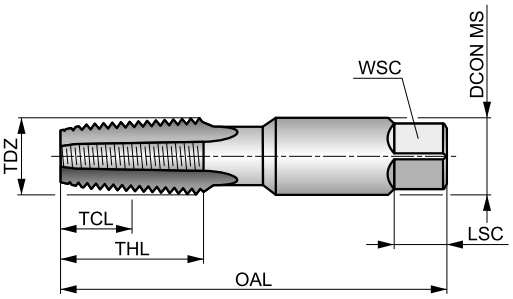
E721

DORMER



HSS Straight Flute Hand Tap with TiN Coating, NPT, ANSI Standard

A versatile tool, suitable for machine and also hand tapping. With a straight flute design and bottoming lead for blind and through holes. TiN coated to improve performance and extend tool life.



NPT	ANSI B94.9	Normal
	1.5×D	HSS
C 2-3		R
TiN		

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	K1.1	K1.2	K1.3
◪12	◪13	■13	◪12	■11	◪9	◪7	■6	◪4	■5	◪3	■12	■9	■7

K2.1	K2.2	K3.1	K3.2	K4.1	K4.2	K5.1	K5.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2
■12	■10	■11	■8	■10	■8	■11	■9	◪10	◪17	◪15	■11	■19	■11

N3.3	N4.2	N4.3
◪6	◪7	◪5

Product	TDZ	TPI	TD [mm]	OAL [mm]	THL [mm]	TCL [mm]	DCON MS [mm]	WSC [mm]	LSC [mm]	NOF	PHD [mm]
E7211/8	1/8	27	10.290	70.0	19	11.90	11.10	8.30	10	4	8.50
E7211/4	1/4	18	13.720	75.0	27	17.60	14.30	10.70	11	4	11.00
E7213/8	3/8	18	17.150	80.0	27	19.50	17.80	13.50	13	4	14.50
E7211/2	1/2	14	21.340	100.0	35	22.70	17.50	13.10	16	4	18.00
E7213/4	3/4	14	26.670	105.0	35	24.40	23.00	17.20	17	5	23.00
E7211	1"	11.5	33.400	115.0	43	29.40	28.60	21.40	21	5	29.00

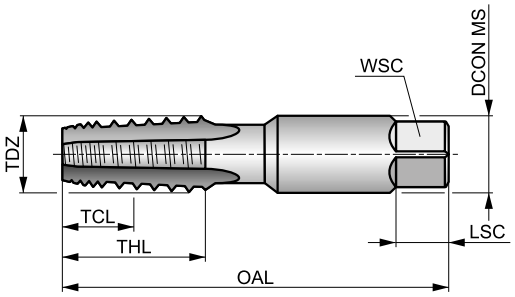
E711

DORMER



HSS Straight Flute Interrupted Thread Hand Tap, NPT, ANSI Standard

A versatile tool, suitable for machine and also hand tapping. Interrupted threads lessen the damaging effects of chip wedging on both forward and reverse rotation and reduce friction, permit better lubrication and allow more space for the passage of chips. The reduced shank increases the reach of the tap.



NPT	ANSI B94.9	Normal
	1.5×D	HSS
C 2-3		R
Bright		

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	K1.1	K1.2	K1.3	K2.1	K2.2
◪7	◪7	■8	◪6	■5	◪4	◪4	■4	■3	◪6	◪4	◪3	◪7	◪6
K3.1	**K3.2**	**K4.1**	**K4.2**	**K5.1**	**K5.2**	**N1.3**	**N2.1**	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.2**
◪7	◪5	◪6	◪5	◪7	◪5	◪8	◪11	◪10	◪7	■17	■10	◪5	◪5
N4.3													
◪3													

Product	TDZ	TPI	TD [mm]	OAL [mm]	THL [mm]	TCL [mm]	DCON MS [mm]	WSC [mm]	LSC [mm]	NOF	PHD [mm]
E7111/8	1/8	27	10.290	70.0	19	11.90	11.10	8.30	10	5	8.50
E7111/4	1/4	18	13.720	75.0	27	17.60	14.30	10.70	11	5	11.00
E7113/8	3/8	18	17.150	80.0	27	19.50	17.80	13.50	13	5	14.50
E7111/2	1/2	14	21.330	100.0	35	22.70	17.50	13.10	16	5	18.00
E7113/4	3/4	14	26.670	105.0	35	24.40	23.00	17.20	17	5	23.00
E7111	1"	11.5	33.400	115.0	43	29.40	28.60	21.40	21	5	29.00
E7111.1/2	1.1/2	11.5	48.260	135.0	43	28.90	38.10	28.60	25	7	44.00

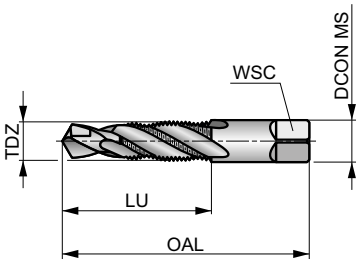
E653

DORMER



HSS Drill-Tap Combination Tool with 27° Spiral Flute, NPT, ANSI Standard

Combination of a core-hole drill and tap to produce a thread in one pass. This significantly reduces the time needed to produce the thread on site with the use of a hand-held power tool. There is no need for a tap wrench or tool change. Steam tempered surface acts to retain the lubricant and provide smoother cutting.



NPT	ANSI	Normal
1.5×D		HSS
λ 27°		R
Bright		

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P3.1	P3.2	N1.2	N1.3	N3.1	N3.2	N4.1
■ 18	■ 20	■ 22	■ 20	◪ 18	◪ 15	◪ 12	◪ 14	◪ 9	◪ 20	◪ 15	◪ 25

Product	TDZ	TPI	TD [inch]	OAL [inch]	LU [inch]	DCON MS [inch]	WSC [inch]	NOF
E6531/8	1/8	27	0.3346	2.7/8	3/4	0.4370	0.3280	2
E6531/4	1/4	18	0.4331	3.5/16	1.1/16	0.5620	0.4210	2
E6533/8	3/8	18	0.5709	3.1/2	1.1/16	0.7000	0.5310	2
E6531/2	1/2	14	0.7087	4.3/8	1.3/8	0.6870	0.5150	2
E6533/4	3/4	14	0.9055	4.9/16	1.3/8	0.9060	0.6790	2
E6531	1"	11.5	1.1417	5.3/8	1.3/4	1.1250	0.8430	2

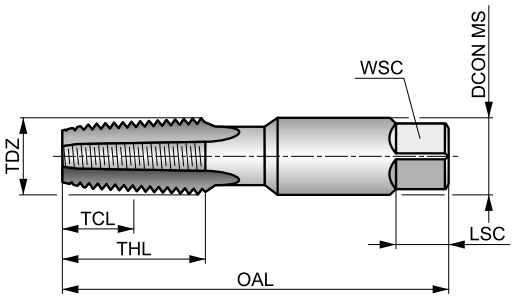
E712

DORMER



HSS Straight Flute Hand Tap, NPTF, ANSI Standard

A versatile tool, suitable for machine and also hand tapping. With a straight flute design and bottoming lead for blind and through holes. Bright finish to produce more accurate and cleaner threads, preventing the workpiece material from sticking to the cutting edges.



NPTF	ANSI B94.9	Normal
	1.5×D	HSS
C 2-3		R
Bright		

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	K1.1	K1.2	K1.3	K2.1	K2.2
■7	■7	■8	■6	■5	◪4	■4	◪4	◪3	◪6	◪4	◪3	◪7	◪6
K3.1	**K3.2**	**K4.1**	**K4.2**	**K5.1**	**K5.2**	**N1.3**	**N2.1**	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.2**
◪7	◪5	◪6	◪5	◪7	◪5	◪8	◪11	◪10	◪7	■17	■10	◪5	◪5
N4.3													
◪3													

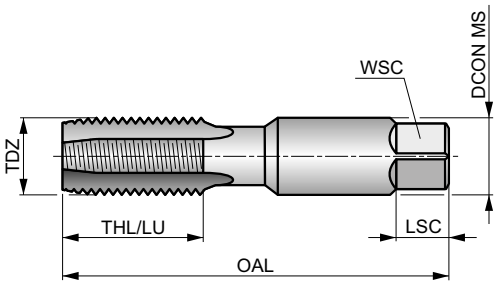
Product	TDZ	TPI	TD [mm]	OAL [mm]	THL [mm]	TCL [mm]	DCON MS [mm]	WSC [mm]	LSC [mm]	NOF	PHD [mm]
E7121/16	1/16	27	7.940	65.0	17	11.70	8.10	6.00	8	4	6.20
E7121/8	1/8	27	10.290	70.0	19	11.90	11.10	8.30	10	4	8.40
E7121/4	1/4	18	13.720	75.0	27	17.60	14.30	10.70	11	4	10.90
E7123/8	3/8	18	17.150	80.0	27	19.50	17.80	13.50	13	4	14.25
E7121/2	1/2	14	21.340	100.0	35	22.70	17.50	13.10	16	4	17.75
E7123/4	3/4	14	26.670	105.0	35	24.40	23.00	17.20	17	5	23.00
E7121	1"	11.5	33.400	115.0	43	29.40	28.60	21.40	21	5	29.00
E7121.1/4	1.1/4	11.5	42.160	125.0	43	27.70	33.40	24.90	23	5	37.75

E709



HSS Straight Flute Machine Tap, NPSF, ANSI Standard

General purpose straight flute machine tap for through and blind holes. Bright finish to produce more accurate and cleaner threads, preventing the workpiece material from sticking to the cutting edges.



NPSF	ANSI B94.9	Normal
	1.5×D	HSS
C 2-3		R
Bright		

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	K1.1	K1.2	K1.3	K2.1	K2.2
■7	■7	■8	■6	■5	◪4	■4	◪4	◪3	◪6	◪4	◪3	◪7	◪6
K3.1	**K3.2**	**K4.1**	**K4.2**	**K5.1**	**K5.2**	**N1.3**	**N2.1**	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.2**
◪7	◪5	◪6	◪5	◪7	◪5	◪8	◪11	◪10	◪7	■17	■10	◪5	◪5
N4.3													
◪3													

Product	TDZ	TPI	TD [mm]	OAL [mm]	THL [mm]	LU [mm]	DCON MS [mm]	WSC [mm]	LSC [mm]	NOF	PHD [mm]
E7091/8	1/8	27	10.290	70.0	19	19.00	11.10	8.30	10	4	8.70
E7091/4	1/4	18	13.720	75.0	27	27.00	14.30	10.70	11	4	11.30
E7093/8	3/8	18	17.150	80.0	27	27.00	17.80	13.50	13	4	14.75
E7091/2	1/2	14	21.340	100.0	35	–	17.50	13.10	16	4	18.25
E7093/4	3/4	14	26.670	105.0	35	–	23.00	17.20	17	5	23.50

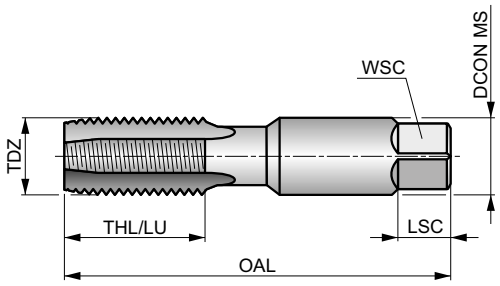
E720

DORMER



HSS Straight Flute Machine Tap with TiN Coating, NPSF, ANSI Standard

General purpose straight flute machine tap for through and blind holes. TiN coated to improve performance and extend tool life.



NPSF	ANSI B94.9	Normal
LU	1.5×D	HSS
C 2-3		R
TiN		

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	K1.1	K1.2	K1.3
◪8	◪9	■9	◪7	■6	◪5	◪4	■4	◪3	■3	◪2	■12	■9	■7
K2.1	**K2.2**	**K3.1**	**K3.2**	**K4.1**	**K4.2**	**K5.1**	**K5.2**	**N1.3**	**N2.1**	**N2.2**	**N2.3**	**N3.1**	**N3.2**
■12	■10	■11	■8	■10	■8	■11	■9	◪10	◪17	◪15	■11	■19	■11
N3.3	**N4.2**	**N4.3**											
◪6	◪7	◪5											

Product	TDZ	TPI	TD [mm]	OAL [mm]	THL [mm]	LU [mm]	DCON MS [mm]	WSC [mm]	LSC [mm]	NOF	PHD [mm]
E7201/8N03	1/8	27	10.290	70.0	19	19.00	11.10	8.30	10	4	8.70
E7201/4N03	1/4	18	13.720	75.0	27	27.00	14.30	10.70	11	4	11.30
E7203/8N03	3/8	18	17.150	80.0	27	27.00	17.80	13.50	13	4	14.75
E7201/2N03	1/2	14	21.340	100.0	35	–	17.50	13.10	13	4	18.25
E7203/4N03	3/4	14	26.670	105.0	35	–	23.00	17.20	17	5	23.50

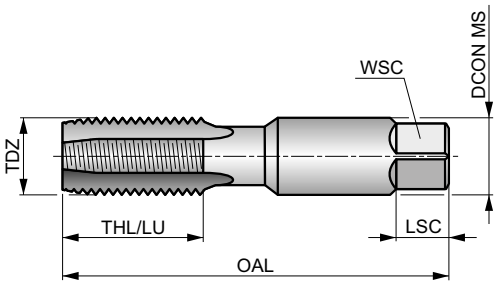
E708

DORMER



HSS Straight Flute Machine Tap, NPSM, ANSI Standard

General purpose straight flute machine tap for through and blind holes. Bright finish to produce more accurate and cleaner threads, preventing the workpiece material from sticking to the cutting edges.



NPSM	ANSI B94.9	Normal
LU	1.5×D	HSS
C 2-3		R
Bright		

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	K1.1	K1.2	K1.3	K2.1	K2.2
■7	■7	■8	■6	■5	◪4	■4	◪4	◪3	◪6	◪4	◪3	◪7	◪6
K3.1	**K3.2**	**K4.1**	**K4.2**	**K5.1**	**K5.2**	**N1.3**	**N2.1**	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.2**
◪7	◪5	◪6	◪5	◪7	◪5	◪8	◪11	◪10	◪7	■17	■10	◪5	◪5
N4.3													
◪3													

Product	TDZ	TPI	TD [mm]	OAL [mm]	THL [mm]	LU [mm]	DCON MS [mm]	WSC [mm]	LSC [mm]	NOF	PHD [mm]
E7081/8	1/8	27	10.290	70.0	19	19.00	11.10	8.30	10	4	9.10
E7081/4	1/4	18	13.720	75.0	27	27.00	14.30	10.70	11	4	12.00
E7083/8	3/8	18	17.150	80.0	27	27.00	17.80	13.50	13	4	15.50
E7081/2	1/2	14	21.330	100.0	35	–	17.50	13.10	16	4	19.00
E7083/4	3/4	14	26.670	105.0	35	–	23.00	17.20	17	5	24.50
E7081	1″	11.5	33.400	115.0	43	–	28.60	21.40	21	5	30.50

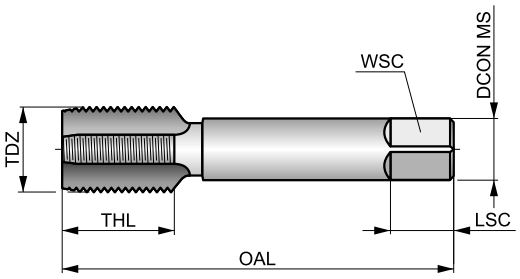
E243

DORMER



HSS Straight Flute Hand Tap, PG Conduit Thread, DIN Standard

A versatile tool, suitable for hand and machine tapping, with a straight flute design for both through and blind holes. Available tap with plug lead NO2 for through holes or bottoming lead NO3 for blind holes.



PG	DIN 40432	Normal
	1.5×D	HSS
	R	Bright

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	K1.1	K1.2	K1.3	K2.1	K2.2
■7	■7	■8	■6	■5	◪4	■4	◪4	◪3	◪6	◪4	◪3	◪7	◪6

K3.1	K3.2	K4.1	K4.2	K5.1	K5.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	N4.2
◪7	◪5	◪6	◪5	◪7	◪5	◪8	◪11	◪10	◪7	■17	■10	◪5	◪5

N4.3
◪3

Product	TDZ	TPI	TD [mm]	OAL [mm]	THL [mm]	DCON MS [mm]	WSC [mm]	LSC [mm]	NOF	PHD [mm]
E243PG7NO2	7	20	12.500	70.0	22	9.00	7.00	10	4	11.40
E243PG7NO3	7	20	12.500	70.0	22	9.00	7.00	10	4	11.40
E243PG9NO2	9	18	15.200	70.0	22	12.00	9.00	12	4	13.90
E243PG9NO3	9	18	15.200	70.0	22	12.00	9.00	12	4	13.90
E243PG11NO2	11	18	18.600	80.0	22	14.00	11.00	14	4	17.25
E243PG11NO3	11	18	18.600	80.0	22	14.00	11.00	14	4	17.25
E243PG13.5NO2	13.5	18	20.400	80.0	22	16.00	12.00	15	4	19.00
E243PG13.5NO3	13.5	18	20.400	80.0	22	16.00	12.00	15	4	19.00
E243PG16NO2	16	18	22.500	80.0	22	18.00	14.50	17	4	21.25
E243PG16NO3	16	18	22.500	80.0	22	18.00	14.50	17	4	21.25
E243PG21NO2	21	16	28.300	90.0	22	22.00	18.00	21	4	27.00
E243PG21NO3	21	16	28.300	90.0	22	22.00	18.00	21	4	27.00
E243PG29NO2	29	16	37.000	100.0	25	28.00	22.00	25	6	35.50
E243PG29NO3	29	16	37.000	100.0	25	28.00	22.00	25	6	35.50
E243PG36NO2	36	16	47.000	140.0	32	36.00	29.00	32	6	45.50
E243PG36NO3	36	16	47.000	140.0	32	36.00	29.00	32	6	45.50

L119



HSS Straight Flute Serial Hand Tap, Set of 21 Pieces, Metric, DIN Standard

Metal cassette containing seven sets of serial hand taps according to DIN standard. Ideal for hand tapping tough materials. The straight flute design makes it suitable for both through and blind holes. Each set of three serial taps should be used one after the other to create the full thread.

Nr. =Set number, A=Styles in Set, B=No. in Set, C=Tap diameters in Set

Product	Nr.	A	B	C
L11917	Nr.17	E100	21	E100M3NO8, E100M4NO8, E100M5NO8, E100M6NO8, E100M8NO8, E100M10NO8, E100M12NO8

L126



HSS Drill-Taps with 30° Spiral Flute, Set of 6 pieces, Metric, ISO Standard

Metal cassette containing six drill-taps to produce threads in one pass. This significantly reduces the time needed to produce the thread on site with the use of a hand-held power tool. There is no need for a tap wrench or tool change. Steam tempered surface acts to retain the lubricant and provide smoother cutting.

Nr. =Set number, A=Styles in Set, B=No. in Set, C=Tap diameters in Set

Product	Nr.	A	B	C
L126650	Nr. 650	E650	6	E650M4, E650M5, E650M6, E650M8, E650M10, E650M12

L113

DORMER



Set with Taps and A002 Drills

Shock-proof plastic box containing seven machine taps according to ISO standard with corresponding drills. Includes either spiral point taps for through holes only Nr.201 with bright finish or Nr.202 steam tempered. Spiral flute taps for blind holes Nr.203 with bright finish or Nr.204 steam tempered.

Nr. =Set number, A=Styles in Set, B=No. in Set, C=Tap diameters in Set, D=Drill diameters in Set.

Product	Nr.	A	B	C	D
L113201	Nr.201	E000 + A002	14	E000M3, E000M4, E000M5, E000M6, E000M8, E000M10, E000M12	A0022.5, A0023.3, A0024.2, A0025.0, A0026.8, A0028.5, A00210.2
L113202	Nr.202	E001 + A002	14	E001M3, E001M4, E001M5, E001M6, E001M8, E001M10, E001M12	A0022.5, A0023.3, A0024.2, A0025.0, A0026.8, A0028.5, A00210.2
L113203	Nr.203	E002 + A002	14	E002M3, E002M4, E002M5, E002M6, E002M8, E002M10, E002M12	A0022.5, A0023.3, A0024.2, A0025.0, A0026.8, A0028.5, A00210.2
L113204	Nr.204	E003 + A002	14	E003M3, E003M4, E003M5, E003M6, E003M8, E003M10, E003M12	A0022.5, A0023.3, A0024.2, A0025.0, A0026.8, A0028.5, A00210.2

L114

DORMER



Set of EP/EX or Shark Line Taps with A002 or A108 Drills

Plastic box with 7 machine taps and corresponding drills. Either with spiral point taps for through holes only Nr.301 with bright finish, Nr.303 Yellow Shark with hard-chrome coating or Nr.305 Blue Shark for stainless steel. Spiral flute taps for blind holes Nr.302 with bright finish, Nr.304 Yellow Shark or Nr.306 Blue Shark.

Nr. =Set number, A=Styles in Set, B=No. in Set, C=Tap diameters in Set, D=Drill diameters in Set.

Product	Nr.	A	B	C	D
L114301	Nr.301	EP006H + A002	14	EP00M3, EP00M4, EP00M5, EP00M6, EP00M8, EP00M10, EP00M12	A0022.5, A0023.3, A0024.2, A0025.0, A0026.8, A0028.5, A00210.2
L114302	Nr.302	EX006H + A002	14	EX00M3, EX00M4, EX00M5, EX00M6, EX00M8, EX00M10, EX00M12	A0022.5, A0023.3, A0024.2, A0025.0, A0026.8, A0028.5, A00210.2
L114303	Nr.303	E297 + A002	14	E297M3, E297M4, E297M5, E297M6, E297M8, E297M10, E297M12	A0022.5, A0023.3, A0024.2, A0025.0, A0026.8, A0028.5, A00210.2
L114304	Nr.304	E298 + A002	14	E298M3, E298M4, E298M5, E298M6, E298M8, E298M10, E298M12	A0022.5, A0023.3, A0024.2, A0025.0, A0026.8, A0028.5, A00210.2
L114305	Nr.305	E238 + A108	14	E238M3, E238M4, E238M5, E238M6, E238M8, E238M10, E238M12	A1082.5, A1083.3, A1084.2, A1085.0, A1086.8, A1088.5, A10810.2
L114306	Nr.306	E240 + A108	14	E240M3, E240M4, E240M5, E240M6, E240M8, E240M10, E240M12	A1082.5, A1083.3, A1084.2, A1085.0, A1086.8, A1088.5, A10810.2

L115

DORMER



Set of E500 Taps and A002 or A022 Drills

Shock-proof plastic box containing straight flute taps according to ISO standard with corresponding drills. Suitable for hand and machine tapping. Nr.101 with bottoming lead taps NO3 for blind holes and A002 jobber drills or Nr.100 with NO3 and NO2 plug lead taps for through holes and A022 stub drills.

Nr. =Set number, A=Styles in Set, B=No. in Set, C=Tap diameters in Set, D=Drill diameters in Set.

Product	Nr.	A	B	C	D
L115100	Nr.100	E500 + A022	21	E500M3NO2, E500M3NO3, E500M4NO2, E500M4NO3, E500M-5NO2, E500M5NO3, E500M6NO2, E500M6NO3, E500M8NO2, E500M8NO3, E500M10NO2, E500M10NO3, E500M12NO2, E500M12NO3	A0222.5, A0223.3, A0224.2, A0225.0, A0226.8, A0228.5, A02210.2
L115101	Nr.101	E500 + A002	14	E500M3NO3, E500M4NO3, E500M5NO3, E500M6NO3, E500M8NO3, E500M10NO3, E500M12NO3	A0022.5, A0023.3, A0024.2, A0025.0, A0026.8, A0028.5, A00210.2

L000

DORMER



DuoPack with E500 Tap and A002 Drill, Various Sizes

DuoPack containing a straight flute hand tap according to ISO standard with corresponding drill. Suitable for hand and machine tapping. Available with plug lead NO2 for through holes or bottoming lead NO3 for blind holes. The convenient packaging ensures the right drill size to make a perfect thread.

Nr. =Set number, A=Styles in Set, B=No. in Set, C=Tap diameters in Set, D=Drill diameters in Set.

Product	Nr.	A	B	C	D
L000E500M3NO2XA002	Nr.1	E500 + A002	2	E500M3NO2	A0022.5
L000E500M4NO2XA002	Nr.2	E500 + A002	2	E500M4NO2	A0023.3
L000E500M5NO2XA002	Nr.3	E500 + A002	2	E500M5NO2	A0024.2
L000E500M6NO2XA002	Nr.4	E500 + A002	2	E500M6NO2	A0025.0
L000E500M8NO2XA002	Nr.5	E500 + A002	2	E500M8NO2	A0026.8
L000E500M10NO2XA002	Nr.6	E500 + A002	2	E500M10NO2	A0028.5
L000E500M12NO2XA002	Nr.7	E500 + A002	2	E500M12NO2	A00210.2
L000E500M3NO3XA002	Nr.8	E500 + A002	2	E500M3NO3	A0022.5
L000E500M4NO3XA002	Nr.9	E500 + A002	2	E500M4NO3	A0023.3
L000E500M5NO3XA002	Nr.10	E500 + A002	2	E500M5NO3	A0024.2
L000E500M6NO3XA002	Nr.11	E500 + A002	2	E500M6NO3	A0025.0
L000E500M8NO3XA002	Nr.12	E500 + A002	2	E500M8NO3	A0026.8
L000E500M10NO3XA002	Nr.13	E500 + A002	2	E500M10NO3	A0028.5
L000E500M12NO3XA002	Nr.14	E500 + A002	2	E500M12NO3	A00210.2

L001



DuoPack with EP00 or EX00 Tap and A002 Drill, Various Sizes

DuoPack containing a machine tap according to DIN standard with corresponding drill. Either with a spiral point tap EP00 for through holes only or spiral flute tap EX00 for blind holes. The convenient packaging ensures the right drill size to make a perfect thread.

Nr. =Set number, A=Styles in Set, B=No. in Set, C=Tap diameters in Set, D=Drill diameters in Set.

Product	Nr.	A	B	C	D
L001EP00M3XA002	Nr.1	EP006H + A002	2	EP00M3	A0022.5
L001EP00M4XA002	Nr.2	EP006H + A002	2	EP00M4	A0023.3
L001EP00M5XA002	Nr.3	EP006H + A002	2	EP00M5	A0024.2
L001EP00M6XA002	Nr.4	EP006H + A002	2	EP00M6	A0025.0
L001EP00M8XA002	Nr.5	EP006H + A002	2	EP00M8	A0026.8
L001EP00M10XA002	Nr.6	EP006H + A002	2	EP00M10	A0028.5
L001EP00M12XA002	Nr.7	EP006H + A002	2	EP00M12	A00210.2
L001EX00M3XA002	Nr.8	EX006H + A002	2	EX00M3	A0022.5
L001EX00M4XA002	Nr.9	EX006H + A002	2	EX00M4	A0023.3
L001EX00M5XA002	Nr.10	EX006H + A002	2	EX00M5	A0024.2
L001EX00M6XA002	Nr.11	EX006H + A002	2	EX00M6	A0025.0
L001EX00M8XA002	Nr.12	EX006H + A002	2	EX00M8	A0026.8
L001EX00M10XA002	Nr.13	EX006H + A002	2	EX00M10	A0028.5
L001EX00M12XA002	Nr.14	EX006H + A002	2	EX00M12	A00210.2

L002



DuoPack with E000 or E002 Tap and A002 Drill, Various Sizes

DuoPack containing a machine tap according to ISO standard with corresponding drill. Either with a spiral point tap E000 for through holes only or spiral flute tap E002 for blind holes. The convenient packaging ensures the right drill size to make a perfect thread.

Nr. =Set number, A=Styles in Set, B=No. in Set, C=Tap diameters in Set, D=Drill diameters in Set.

Product	Nr.	A	B	C	D
L002E000M3XA002	Nr.1	E000 + A002	2	E000M3	A0022.5
L002E000M4XA002	Nr.2	E000 + A002	2	E000M4	A0023.3
L002E000M5XA002	Nr.3	E000 + A002	2	E000M5	A0024.2
L002E000M6XA002	Nr.4	E000 + A002	2	E000M6	A0025.0
L002E000M8XA002	Nr.5	E000 + A002	2	E000M8	A0026.8
L002E000M10XA002	Nr.6	E000 + A002	2	E000M10	A0028.5
L002E000M12XA002	Nr.7	E000 + A002	2	E000M12	A00210.2
L002E002M3XA002	Nr.8	E002 + A002	2	E002M3	A0022.5
L002E002M4XA002	Nr.9	E002 + A002	2	E002M4	A0023.3
L002E002M5XA002	Nr.10	E002 + A002	2	E002M5	A0024.2
L002E002M6XA002	Nr.11	E002 + A002	2	E002M6	A0025.0
L002E002M8XA002	Nr.12	E002 + A002	2	E002M8	A0026.8
L002E002M10XA002	Nr.13	E002 + A002	2	E002M10	A0028.5
L002E002M12XA002	Nr.14	E002 + A002	2	E002M12	A00210.2

L120



Set of Taps, Dies and Tap Wrenches, Various Sizes

Threading kit for either ISO-Metric, UNC or UNF thread. Containing sets of hand or serial hand taps, dies, tap wrenches and die stocks, all together in a smart metal case with carry handle and latch-lock fasteners.

Nr. =Set number, A=No. in Set, B=Styles in Set, C=Diameters in set.

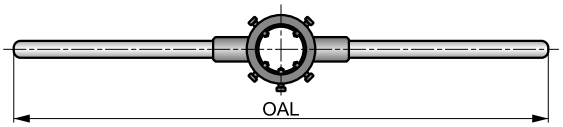
Product	Nr.	A	B	C
L12021	21	21	E100	E100M3N08, E100M4N08, E100M5N08, E100M6N08, E100M8N08, E100M10N08, E100M12N08
			F100	F100M3, F100M4, F100M5, F100M6, F100M8, F100M10, F100M12
			L112	L112N01.1/2, L112N03
			L110	L1102A, L1102B, L1103, L1104, L1105
L12030	30	30	E100	E100M3N08, E100M4N08, E100M5N08, E100M6N08, E100M8N08, E100M10N08, E100M12N08, E100M14N08, E100M16N08, E100M18N08, E100M20N08
			F100	F100M3, F100M4, F100M5, F100M6, F100M8, F100M10, F100M12, F100M14, F100M16, F100M18, F100M20
			L112	L112N01.1/2, L112N04
			L110	L1102A, L1102B, L1103, L1104, L1105, L1106
L1202M	HS-2M	23	E500	E500M2N01, E500M2N03, E500M2.5N01, E500M2.5N03, E500M3N01, E500M3N03, E500M3.5N01, E500M3.5N03, E500M4N01, E500M4N03, E500M5N01, E500M-5N03, E500M6N01, E500M6N03
			F300	F300M2X13/16, F300M2.5X13/16, F300M3X13/16, F300M3.5X13/16, F300M4X13/16, F300M5X13/16, F300M6X13/16
			L112	L112BT1
			L110	L11013/16
L1204M	HS-4M	32	E500	E500M5N01, E500M5N03, E500M6N01, E500M6N03, E500M7N01, E500M7N03, E500M8N01, E500M8N03, E500M9N01, E500M9N03, E500M10N01, E500M10N03, E500M11N01, E500M11N03, E500M12N01, E500M12N03
			F300	F300M5X13/16, F300M6X13/16, F300M7X13/16, F300M8X1.5/16, F300M9X1.5/16, F300M10X1.5/16, F300M11X1.5/16, F300M12X1.5/16, F300M5X13/16, F300M6X13/16, F300M7X13/16, F300M8X1.5/16, F300M9X1.5/16
			L112	L112BT2
			L110	L11013/16, L1101.5/16
L1208M	HS-8M	17	E500	E500M2N01, E500M2N03, E500M3N01, E500M3N03, E500M4N01, E500M4N03, E500M5N01, E500M5N03, E500M6N01, E500M6N03
			F300	F300M2X13/16, F300M3X13/16, F300M4X13/16, F300M5X13/16, F300M6X13/16
			L112	L112BT1
			L110	L11013/16
L12010M	HS-10M	27	E500	E500M3N01, E500M3N03, E500M4N01, E500M4N03, E500M5N01, E500M5N03, E500M6N01, E500M6N03, E500M7N01, E500M7N03, E500M8N01, E500M8N03, E500M9N01, E500M9N03, E500M10N01, E500M10N03
			F300	F300M3X13/16, F300M4X13/16, F300M5X13/16, F300M6X1, F300M7X1, F300M8X1, F300M9X1, F300M10X1
			L112	L112BT2
			L110	L11013/16, L1101INCH
L12012M	HS-12M	35	E500	E500M2N01, E500M2N03, E500M3N01, E500M3N03, E500M4N01, E500M4N03, E500M5N01, E500M5N03, E500M6N01, E500M6N03, E500M7N01, E500M7N03, E500M8N01, E500M8N03, E500M9N01, E500M9N03, E500M10N01, E500M10N03, E500M12N01, E500M12N03
			F300	F300M2X13/16, F300M3X13/16, F300M4X13/16, F300M5X13/16, F300M6X13/16, F300M7X13/16, F300M8X1, F300M9X1, F300M10X1, F300M12X1.5/16
			L112	L112BT1, L112BT2
			L110	L11013/16, L1101INCH, L1101.5/16
L12014M	HS-14M	34	E500	E500M6N01, E500M6N03, E500M7N01, E500M7N03, E500M8N01, E500M8N03, E500M9N01, E500M9N03, E500M10N01, E500M10N03, E500M12N01, E500M12N03, E500M14N01, E500M14N03, E500M16N01, E500M16N03, E500M18N01, E500M18N03, E500M20N01, E500M20N03
			F300	F300M6X1, F300M7X1, F300M8X1, F300M9X1, F300M10X1, F300M12X1.5/16, F300M14X1.5/16, F300M16X1.1/2, F300M18X1.1/2, F300M20X1.1/2
			L112	L112N03
			L110	L1101INCH, L1101.5/16, L1101.1/2

L110



Die Stock

The die stock is an accessory to make it easy to use dies by hand. The die is held securely in the metal ring, whilst the arms at either end are used to rotate the die around the outside of the metal cylinder to be threaded. The L110 series comes in an extensive range to hold all sizes of round dies.



Products from this series are also available in set with taps and dies. Please see L120.

Product	Nr.	OAL [mm]	Die BD x Die OAL
L1101	1″	160.0	16 x 5
L1102A	2a	200.0	20 x 5
L1102B	2b	200.0	20 x 7
L1103	3	224.0	25 x 9
L1104	4″	280.0	30 x 11
L1105	5	315.0	38 x 14
L1105F	5f	315.0	38 x 10
L1106	6	450.0	45 x 18
L1106F	6f	450.0	45 x 14
L1107	7	560.0	55 x 22
L1107F	7f	560.0	55 x 16
L1108	8	630.0	65 x 25
L1108F	8f	630.0	65 x 18
L1109	9	800.0	75 x 30
L1109F	9f	800.0	75 x 20
L11010	10	900.0	90 x 36
L11010F	10f	900.0	90 x 22
L11013/16	–	200.0	13/16 x 1/4
L1101INCH	–	224.0	1 x 3/8
L1101.5/16	–	270.0	1.5/16 x 7/16
L1101.1/2	–	315.0	1.1/2 x 1/2
L1102INCH	–	560.0	2 x 5/8
L1102.1/4	–	560.0	2.1/4 x 11/16
L1103INCH	–	900.0	3 x 7/8
L1104INCH	–	1000.0	4 x 1

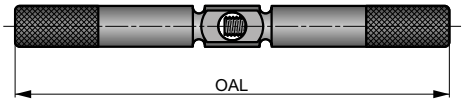
L112



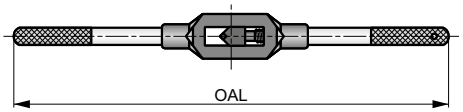
Tap Wrench

Adjustable, so one tap wrench can be used to hold several different tap sizes. The square end of the tap is inserted into the wrench which is then tightened to hold the tap securely. The two metal bars on either side of the wrench are used to rotate the tap in the hole of the workpiece to create the thread.

BT1-BT2



NO0-NO7



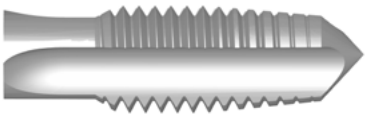
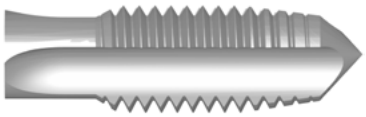
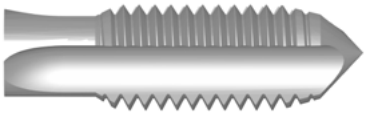
Products from this series are also available in set with taps and dies. Please see L120.

Product	Nr.	OAL [mm]	WSCN [mm]	WSCX [mm]	WSCN [inch]	WSCX [inch]	Tap Range (M)	Tap Range (Inch)
L112BT1	BT1	105.0	1.00	6.50	0.0394	0.2559	M1 - M8	No. 0 - 5/16
L112BT2	BT2	162.0	1.00	10.00	0.0394	0.3937	M1 - M14	No. 0 - 5/8
L112N00	No. 0	130.0	2.00	5.00	0.0787	0.1969	M1 - M5	No. 0 - 1/4
L112N01.1/2	No. 1.1/2	205.0	2.10	8.00	0.0827	0.3150	M2.2 - M12	No. 0 - 1/2
L112N03	No. 3	380.0	4.90	12.00	0.1929	0.4724	M5 - M20	5/16 - 3/4
L112N04	No. 4	500.0	5.50	16.00	0.2165	0.6299	M7 - M30	5/16 - 1″
L112N06	No. 6	1000.0	11.00	24.00	0.4331	0.9449	M18 - M42	3/4 - 1.1/2
L112N07	No. 7	1250.0	16.00	32.00	0.6299	1.2598	M27 - M48	1.1/8 - 2″



TAPS
TECHNICAL INFORMATION

Hand taps (ISO standard) with different chamfer lengths each producing a full thread profile.

NO1 =	 Taper lead	**A** 6-8	
NO2 =	 Plug lead	**B** 4-6	
NO3 =	 Bottoming lead	**C** 2-3	

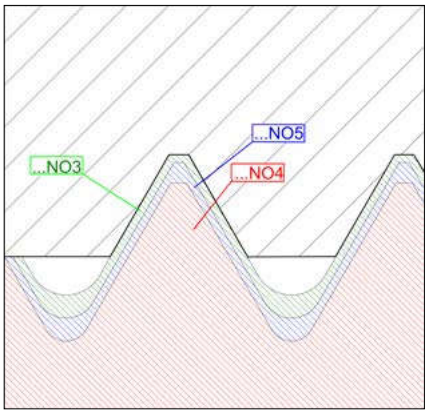
ISO	**NO6 =**	NO1 + NO2 + NO3
	NO7 =	NO2 + NO3 *

ANSI	**NO6 =**	NO1 (taper) + NO2 (plug) + NO3 (bottoming)

*** E550, E710** **NO7 =** NO3 (truncated) + NO3

Serial taps (DIN standard) with each sequencing tap cutting a part of the profile, the NO3 tap is needed to complete a full thread profile.

NO4 =	 Starter tap	**A** 6-8	
NO5 =	 Seconding tap	**B** 3.5-5	
NO3 =	 Finishing (bottoming lead) tap	**C** 2-3	



DIN ISO	**NO8 =**	NO3 + NO4 + NO5
	NO9 =	NO3 + NO5

THREAD MILLS



📖 6		WMG & ISO 13399
📖 12	TAPS	INSTRUCTIONS
📖 15	TAPS	SOLID CARBIDE TAPS
📖 25	TAPS	MATERIAL SPECIFIC SHARK TAPS
📖 62	TAPS	HSS HAND & MACHINE TAPS
📖 216	TAPS	TECHNICAL INFORMATION
📖 **218**		**THREAD MILLS**
📖 238		DIES
📖 270		CUTTING FLUIDS
📖 274		GENERAL TECHNICAL INFORMATION

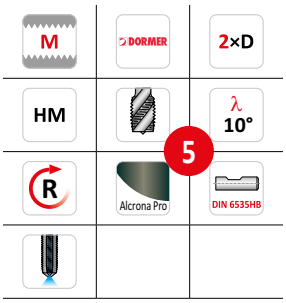
1 **J205**

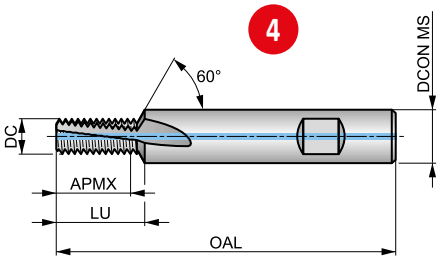
DORMER



Solid Carbide Thread Mill with Through Coolant and Countersink, Metric 2

Universal high performance tool to machine same or bigger diameters than the TDZ with the same pitch. Left or right-hand, through or blind holes almost down to the bottom. With 60° countersink for chamfering. Alcrona Pro coated for the best machining result with through coolant for better chip evacuation.





Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■172	■193	■200	■148	■130	■115	■133	■107	■90	■79	■67	◪55	■62	■52
M2.1	M2.2	M2.3	M3.1	M3.2	M3.3	M4.1	M4.2	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3
■55	■45	■38	■47	■40	■36	■30	◪26	■130	■96	■72	■123	■100	■80
K3.1	K3.2	K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3
■109	■83	■67	■101	■76	■56	■48	◪40	■114	■86	■66	■400	■300	■200
N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	N4.1	N4.2	N4.3	S1.1	S1.2	S1.3	S2.1	S2.2
■262	■235	■170	■610	■360	■180	■290	■145	■65	■40	■40	◪30	■33	◪25
S3.1	S3.2	S4.1	S4.2	H1.1									
■25	◪21	■20	◪16	◪60									

6

Internal Thread.

7 t	TDZ	TP	DC	APMX 8	OAL	DCON MS	NOF	LU
		[mm]	[mm]	[mm]	[mm]	[mm]		[mm]
J2056.5X1.25	M8	1.25	6.50	17.50	72.0	10.00	3	19.10
J2058.2X1.50	M10	1.50	8.20	21.00	83.0	12.00	3	22.80
J2059.9X1.75	M12	1.75	9.90	26.25	83.0	14.00	4	28.20
J20511.6X2.0	M14	2.00	11.60	30.00	92.0	16.00	4	32.20

Pos.	Description
1	Designation of thread mills
2	Product description
3	Illustrative picture
4	Schematic drawing of tool

Pos.	Description
5	Product features
6	Material group recommendations incl. speed and feed guidance
7	Product code
8	Product dimensions

Typical page with thread mills displayed – specific page details will differ.

THREAD MILLS – ICONS OVERVIEW

General Icons

■	Primary use
◪	Possible use

Thread Form (THFT)

G	Thread Form, British Standard Pipe	MF	Thread Form, Metric Fine	UNC	Thread Form, Unified Coarse
M	Thread Form, Metric Coarse	NPT	Thread Form, American National Pipe Taper	UNF	Thread Form, Unified Fine

Basic Standard Group (BSG)

DORMER	Dormer Standards

Usable Length (ULDR)

1.5×D	1.5×D Usable Tool Depth to Diameter Ratio	2×D	2×D Usable Tool Depth to Diameter Ratio

Material Code (BMC)

HM	Hard Material (Solid Carbide)

Flute Geometry (FDC)

	Spiral Flute Geometry

Flute Helix Angle (FHA)

λ 10°	10° Helix Angle (Flute)	λ 27°	27° Helix Angle (Flute)

Hand (Cutting direction)

R	Right Hand Rotation / Cutting

Coating

Alcrona Pro	Aluminium Chromium Nitride (special optimized process)

Shank

DIN 6535HA	DIN 6535 HA Cylindrical Shank	DIN 6535HB	DIN 6535 HB Weldon Shank

Coolant Exit Style (CXSC)

	Through Tool Coolant - Axial Exit

THREAD MILLS – TOOL MATERIALS AND SURFACE COATINGS NAVIGATOR

HM materials

Carbide Materials (or Hard Materials)	HM	A sintered powder metallurgy substrate, consisting of a metallic carbide composite with binder metal. The most central raw material is tungsten carbide (WC). Tungsten carbide contributes to the hardness of the material. Tantalum carbide (TaC), titanium carbide (TiC) and niobium carbide (NbC) complements WC and adjusts the properties to what is desired. These three materials are called cubic carbides. Cobalt (Co) acts as a binder and keeps the material together. Carbide materials are often characterised by high compression strength, high hardness and therefore high wear resistance, but also by limited flexural strength and toughness. Carbide is used in taps, reamers, milling cutters, drills and thread milling cutters.

Surface Coatings

Alcrona coatings (Alcrona Pro)		The Alcrona (AlCrN) family of coatings are aluminium chromium nitride coatings mostly used for milling cutters. The two unique properties of these coatings are high hot hardness and high oxidation resistance. When used on tools for machining applications involving heavy mechanical and thermal stresses, these properties translate into superior wear resistance. Multiple levels or specific versions of these coatings are available and specific for various tools and applications.

Thread form (THFT)		M	M	M	M	MF	MF	UNC	UNF	G	NPT
Basic standard group (BSG)		DORMER	DORMER	DORMER	DORMER	DORMER	DORMER	DORMER	DORMER	DORMER	DORMER
Usable length (ULDR)		2×D	2×D	2×D	2×D	1.5×D	1.5×D	2×D	2×D	1.5×D	
Material code (BMC)		HM	HM	HM	HM	HM	HM	HM	HM	HM	HM
Flute Geometry (FDC)											
Flute helix angle (FHA)		λ 10°	λ 10°	λ 27°	λ 27°	λ 10°	λ 10°	λ 10°	λ 10°	λ 10°	λ 10°
Hand (Cutting direction)		R	R	R	R	R	R	R	R	R	R
Coating		Alcrona Pro	Alcrona Pro	Alcrona Pro	Alcrona Pro	Alcrona Pro	Alcrona Pro	Alcrona Pro	Alcrona Pro	Alcrona Pro	Alcrona Pro
Shank		DIN 6535HA	DIN 6535HB	DIN 6535HA	DIN 6535HA	DIN 6535HA	DIN 6535HB	DIN 6535HB	DIN 6535HB	DIN 6535HA	DIN 6535HB
Coolant exit style (CXSC)											
Product Family Code		J200	J205	J210	J215	J220	J225	J235	J245	J280	J260
		M4 - M16	M8 - M16	M6 - M16	M6 - M16	M6 - M24	M10 - M18	1/4 - 3/4	1/4 - 3/4	1/8 - 3"	1/8 - 2"
		224	225	226	227	228	229	230	231	232	233
P	P1	■	■	■	■	■	■	■	■	■	■
	P2	■	■	■	■	■	■	■	■	■	■
	P3	■	■	■	■	■	■	■	■	■	■
	P4	■	■	■	■	■	■	■	■	■	■
M	M1	■	■	■	■	■	■	■	■	■	■
	M2	■	■	■	■	■	■	■	■	■	■
	M3	■	■	■	■	■	■	■	■	■	■
	M4	◪	◪	■	■	◪	◪	■	■	■	■
K	K1	■	■	■	■	■	■	■	■	■	■
	K2	■	■	■	■	■	■	■	■	■	■
	K3	■	■	■	■	■	■	■	■	■	■
	K4	■	■	■	■	■	■	■	■	■	■
	K5	■	■	■	■	■	■	■	■	■	■
N	N1	■	■	■	■	■	■	■	■	■	■
	N2	■	■	■	■	■	■	■	■	■	■
	N3	■	■	■	■	■	■	■	■	■	■
	N4	■	■	■	■	■	■	■	■	■	■
	N5										
S	S1	◪	■	◪	■	◪	■	■	■	■	■
	S2	◪	◪	◪	◪	◪	◪	◪	◪	◪	◪
	S3	◪	◪	◪	◪	◪	◪	◪	◪	◪	◪
	S4	◪	◪	◪	◪	◪	■	◪	◪	◪	◪
H	H1	◪	◪	■	■	■	■	■	■	■	■
	H2										
	H3			◪	◪	◪	◪	◪	◪	◪	◪
	H4										

■ Primary use ◪ Possible use

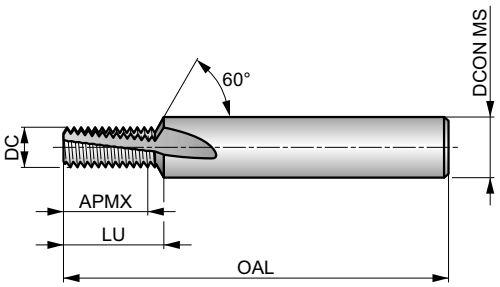
J200

DORMER



Solid Carbide Thread Mill with Countersink, Metric

Universal high performance tool to machine same or bigger diameters than the TDZ with the same pitch. Left or right-hand, through or blind holes almost down to the bottom. With 60° countersink for chamfering in a single machining cycle. Alcrona Pro coated for the best machining result in a wide range of materials.



M	DORMER	2×D
HM		λ 10°
R	Alcrona Pro	DIN 6535HA

Workpiece material group suitability, starting values for cutting speed (m/min) and Alpha Code. Tables with feed per tooth and correction factors can be found starting from page 234.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■172 B	■193 B	■200 B	■148 B	■130 B	■115 B	■133 B	■107 B	■90 B	■79 B	■67 B	◪55 B	■62 B	■52 B
M2.1	**M2.2**	**M2.3**	**M3.1**	**M3.2**	**M3.3**	**M4.1**	**M4.2**	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**
■55 B	■45 B	◪38 B	■47 A	■40 A	◪36 A	■30 A	◪26 A	■130 B	■96 B	■72 B	■123 B	■100 B	■80 B
K3.1	**K3.2**	**K3.3**	**K4.1**	**K4.2**	**K4.3**	**K4.4**	**K4.5**	**K5.1**	**K5.2**	**K5.3**	**N1.1**	**N1.2**	**N1.3**
■109 B	■83 B	■67 B	■101 A	■76 A	■56 A	■48 A	◪40 A	■114 B	■86 B	■66 B	■400 C	■300 C	■200 C
N2.1	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**N4.2**	**N4.3**	**S1.1**	**S1.2**	**S1.3**	**S2.1**	**S2.2**
■262 C	■235 C	■170 C	■610 C	■360 C	■180 C	■290 C	■145 C	■65 C	■40 A	◪40 A	◪30 A	◪33 A	◪25 A
S3.1	**S3.2**	**S4.1**	**S4.2**	**H1.1**									
◪25 A	◪21 A	◪20 A	◪16 A	◪60 A									

Internal Thread.

Product	TDZ	TP [mm]	DC [mm]	APMX [mm]	OAL [mm]	DCON MS [mm]	NOF	LU [mm]
J2003.2X.7	M4	0.70	3.20	8.40	57.0	6.00	3	9.50
J2004.1X.8	M5	0.80	4.10	11.20	57.0	6.00	3	12.10
J2004.8X1.0	M6	1.00	4.80	13.00	63.0	8.00	3	14.40
J2006.5X1.25	M8	1.25	6.50	17.50	72.0	10.00	3	19.10
J2008.2X1.5	M10	1.50	8.20	21.00	83.0	12.00	3	22.80
J2009.9X1.75	M12	1.75	9.90	26.25	83.0	14.00	4	28.20
J20011.6X2.0	M14	2.00	11.60	30.00	92.0	16.00	4	32.20
J20013.6X2.0	M16	2.00	13.60	34.00	92.0	18.00	4	36.20

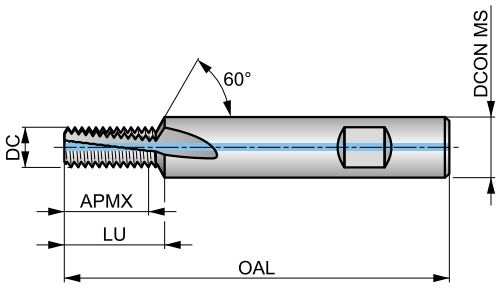
J205

DORMER



Solid Carbide Thread Mill with Through Coolant and Countersink, Metric

Universal high performance tool to machine same or bigger diameters than the TDZ with the same pitch. Left or right-hand, through or blind holes almost down to the bottom. With 60° countersink for chamfering. Alcrona Pro coated for the best machining result with through coolant for better chip evacuation.



M	DORMER	2×D
HM		λ 10°
R	Alcrona Pro	DIN 6535HB

Workpiece material group suitability, starting values for cutting speed (m/min) and Alpha Code. Tables with feed per tooth and correction factors can be found starting from page 234.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 172 B	■ 193 B	■ 200 B	■ 148 B	■ 130 B	■ 115 B	■ 133 B	■ 107 B	■ 90 B	■ 79 B	■ 67 B	◪ 55 B	■ 62 B	■ 52 B
M2.1	**M2.2**	**M2.3**	**M3.1**	**M3.2**	**M3.3**	**M4.1**	**M4.2**	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**
■ 55 B	■ 45 B	■ 38 B	■ 47 A	■ 40 A	■ 36 A	■ 30 A	◪ 26 A	■ 130 B	■ 96 B	■ 72 B	■ 123 B	■ 100 B	■ 80 B
K3.1	**K3.2**	**K3.3**	**K4.1**	**K4.2**	**K4.3**	**K4.4**	**K4.5**	**K5.1**	**K5.2**	**K5.3**	**N1.1**	**N1.2**	**N1.3**
■ 109 B	■ 83 B	■ 67 B	■ 101 A	■ 76 A	■ 56 A	■ 48 A	◪ 40 A	■ 114 B	■ 86 B	■ 66 B	■ 400 C	■ 300 C	■ 200 C
N2.1	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**N4.2**	**N4.3**	**S1.1**	**S1.2**	**S1.3**	**S2.1**	**S2.2**
■ 262 C	■ 235 C	■ 170 C	■ 610 C	■ 360 C	■ 180 C	■ 290 C	■ 145 C	■ 65 C	■ 40 A	■ 40 A	◪ 30 A	■ 33 A	◪ 25 A
S3.1	**S3.2**	**S4.1**	**S4.2**	**H1.1**									
■ 25 A	◪ 21 A	■ 20 A	◪ 16 A	◪ 60 A									

Internal Thread.

Product	TDZ	TP [mm]	DC [mm]	APMX [mm]	OAL [mm]	DCON MS [mm]	NOF	LU [mm]
J2056.5X1.25	M8	1.25	6.50	17.50	72.0	10.00	3	19.10
J2058.2X1.50	M10	1.50	8.20	21.00	83.0	12.00	3	22.80
J2059.9X1.75	M12	1.75	9.90	26.25	83.0	14.00	4	28.20
J20511.6X2.0	M14	2.00	11.60	30.00	92.0	16.00	4	32.20
J20513.6X2.0	M16	2.00	13.60	34.00	92.0	18.00	4	36.20

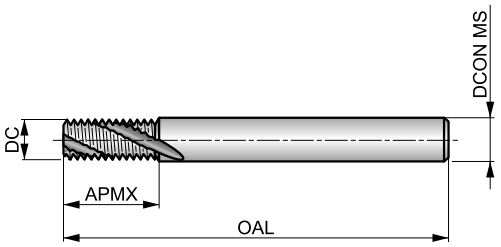
J210

DORMER

Solid Carbide Thread Mill with High Helix, Metric

Universal high performance tool to machine same or bigger diameters than the TDZ with the same pitch. Left or right-hand, through or blind holes almost down to the bottom. With Alcrona Pro coated for the best machining result in a wide range of materials and 27° helix for a smoother cutting action.





M	DORMER	2×D
HM		λ 27°
R	Alcrona Pro	DIN 6535HA

Workpiece material group suitability, starting values for cutting speed (m/min) and Alpha Code. Tables with feed per tooth and correction factors can be found starting from page 234.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■181 B	■203 B	■210 B	■156 B	■137 B	■121 B	■140 B	■112 B	■95 B	■83 B	■70 B	◪58 B	■65 B	■55 B
M2.1	**M2.2**	**M2.3**	**M3.1**	**M3.2**	**M3.3**	**M4.1**	**M4.2**	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**
■58 B	■47 B	◪40 B	■50 A	■42 A	◪38 A	■32 A	◪27 A	■137 B	■101 B	■76 B	■129 B	■105 B	■84 B
K3.1	**K3.2**	**K3.3**	**K4.1**	**K4.2**	**K4.3**	**K4.4**	**K4.5**	**K5.1**	**K5.2**	**K5.3**	**N1.1**	**N1.2**	**N1.3**
■115 B	■87 B	■71 B	■106 A	■80 A	■59 A	■51 A	◪42 A	■120 B	■90 B	■70 B	■420 C	■315 C	■210 C
N2.1	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**N4.2**	**N4.3**	**S1.1**	**S1.2**	**S1.3**	**S2.1**	**S2.2**
■275 C	■247 C	■179 C	■640 C	■378 C	■189 C	■305 C	■153 C	■69 C	■42 A	◪42 A	◪32 A	◪35 A	◪26 A
S3.1	**S3.2**	**S4.1**	**S4.2**	**H1.1**	**H3.1**								
◪26 A	◪22 A	◪21 A	◪17 A	■63 A	◪45 A								

Internal Thread.

Product	TDZ	TP [mm]	DC [mm]	APMX [mm]	OAL [mm]	DCON MS [mm]	NOF
J2104.5X1.0	M6	1.00	4.50	13.00	57.0	6.00	3
J2106.0X1.25	M8	1.25	6.00	17.50	65.0	6.00	3
J2107.5X1.5	M10	1.50	7.50	21.00	72.0	8.00	3
J2109.5X1.75	M12	1.75	9.50	26.25	80.0	10.00	3
J21010.0X2.0	M14	2.00	10.00	30.00	83.0	10.00	4
J21012.0X2.0	M16	2.00	12.00	34.00	92.0	12.00	4

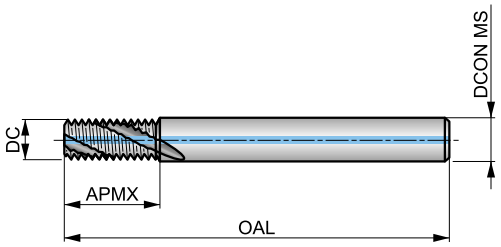
J215

DORMER



Solid Carbide Thread Mill with High Helix and Through Coolant, Metric

Universal high performance tool to machine same or bigger diameters than the TDZ with the same pitch. Left or right-hand, through or blind holes almost down to the bottom. Alcrona Pro coated for the best machining result with through coolant for better chip evacuation and 27° helix for a smoother cutting action.





Workpiece material group suitability, starting values for cutting speed (m/min) and Alpha Code. Tables with feed per tooth and correction factors can be found starting from page 234.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 181 B	■ 203 B	■ 210 B	■ 156 B	■ 137 B	■ 121 B	■ 140 B	■ 112 B	■ 95 B	■ 83 B	■ 70 B	■ 58 B	■ 65 B	■ 55 B
M2.1	**M2.2**	**M2.3**	**M3.1**	**M3.2**	**M3.3**	**M4.1**	**M4.2**	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**
■ 58 B	■ 47 B	■ 40 B	■ 50 A	■ 42 A	■ 38 A	■ 32 A	◪ 27 A	■ 137 B	■ 101 B	■ 76 B	■ 129 B	■ 105 B	■ 84 B
K3.1	**K3.2**	**K3.3**	**K4.1**	**K4.2**	**K4.3**	**K4.4**	**K4.5**	**K5.1**	**K5.2**	**K5.3**	**N1.1**	**N1.2**	**N1.3**
■ 115 B	■ 87 B	■ 71 B	■ 106 A	■ 80 A	■ 59 A	■ 51 A	■ 42 A	■ 120 B	■ 90 B	■ 70 B	■ 420 C	■ 315 C	■ 210 C
N2.1	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**N4.2**	**N4.3**	**S1.1**	**S1.2**	**S1.3**	**S2.1**	**S2.2**
■ 275 C	■ 247 C	■ 179 C	■ 640 C	■ 378 C	■ 189 C	■ 305 C	■ 153 C	■ 69 C	■ 42 A	■ 42 A	◪ 32 A	■ 35 A	◪ 26 A
S3.1	**S3.2**	**S4.1**	**S4.2**	**H1.1**	**H3.1**								
■ 26 A	◪ 22 A	■ 21 A	◪ 17 A	■ 63 A	◪ 45 A								

Internal Thread.

Product	TDZ	TP [mm]	DC [mm]	APMX [mm]	OAL [mm]	DCON MS [mm]	NOF
J2154.5X1.0	M6	1.00	4.50	13.00	57.0	6.00	3
J2156.0X1.25	M8	1.25	6.00	17.50	65.0	6.00	3
J2157.5X1.5	M10	1.50	7.50	21.00	72.0	8.00	3
J2159.5X1.75	M12	1.75	9.50	26.25	80.0	10.00	3
J21510.0X2.0	M14	2.00	10.00	30.00	83.0	10.00	4
J21512.0X2.0	M16	2.00	12.00	34.00	92.0	12.00	4

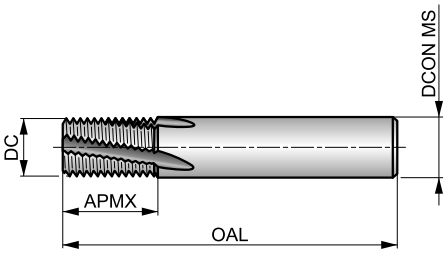
J220

DORMER



Solid Carbide Thread Mill, Metric Fine

Universal high performance tool to machine same or bigger diameters than the TDZ with the same pitch. Left or right-hand, through or blind holes almost down to the bottom. Alcrona Pro coated for the best machining result in a wide range of materials.



MF	DORMER	1.5×D
HM		λ 10°
R	Alcrona Pro	DIN 6535HA

Workpiece material group suitability, starting values for cutting speed (m/min) and Alpha Code. Tables with feed per tooth and correction factors can be found starting from page 234.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■190 E	■212 E	■242 E	■163 E	■143 E	■127 E	■146 E	■118 E	■99 E	■87 E	■74 E	■61 E	■69 E	■58 E
M2.1	**M2.2**	**M2.3**	**M3.1**	**M3.2**	**M3.3**	**M4.1**	**M4.2**	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**
■61 E	■50 E	◪42 E	■52 D	■44 D	◪40 D	■33 D	◪29 D	■143 E	■106 E	■80 E	■136 E	■110 E	■88 E
K3.1	**K3.2**	**K3.3**	**K4.1**	**K4.2**	**K4.3**	**K4.4**	**K4.5**	**K5.1**	**K5.2**	**K5.3**	**N1.1**	**N1.2**	**N1.3**
■120 E	■91 E	■74 E	■111 D	■84 D	■62 D	■53 D	◪44 D	■126 E	■95 E	■73 E	■440 F	■330 F	■220 F
N2.1	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**N4.2**	**N4.3**	**S1.1**	**S1.2**	**S1.3**	**S2.1**	**S2.2**
■288 F	■259 F	■187 F	■671 F	■396 F	■198 F	■319 F	■160 F	■72 F	■44 D	◪44 D	◪33 D	◪36 D	◪28 D
S3.1	**S3.2**	**S4.1**	**S4.2**	**H1.1**	**H3.1**								
◪28 D	◪23 D	◪22 D	◪18 D	■66 D	◪48 D								

Internal Thread.

Product	TDZ	TP [mm]	DC [mm]	APMX [mm]	OAL [mm]	DCON MS [mm]	NOF
J2204.8X.5	M6	0.50	4.80	10.00	57.0	6.00	3
J2206.0X.75	M8	0.75	6.00	12.00	57.0	6.00	3
J2206.0X1.0	M8	1.00	6.00	12.00	57.0	6.00	3
J2208.0X1.0	M10	1.00	8.00	16.00	63.0	8.00	4
J22010.0X1.0	M12	1.00	10.00	20.00	72.0	10.00	4
J22010.0X1.5	M12	1.50	10.00	20.00	72.0	10.00	4
J22012.0X1.0	M14	1.00	12.00	22.00	83.0	12.00	4
J22012.0X1.5	M14	1.50	12.00	22.00	83.0	12.00	4
J22014.0X1.0	M16	1.00	14.00	26.00	83.0	14.00	5
J22014.0X1.5	M16	1.50	14.00	26.00	83.0	14.00	5
J22016.0X2.0	M20	2.00	16.00	30.00	92.0	16.00	5
J22016.0X2.5	M20	2.50	16.00	42.50	105.0	16.00	5
J22019.0X3.0	M24	3.00	19.00	50.00	125.0	20.00	5
J22020.0X2.0	M24	2.00	20.00	35.00	104.0	20.00	5

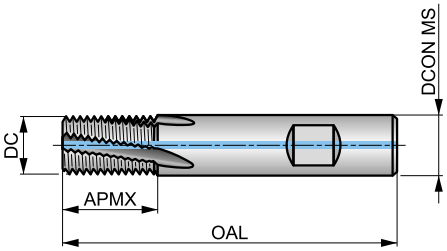
J225

DORMER



Solid Carbide Thread Mill with Through Coolant, Metric Fine

Universal high performance tool to machine same or bigger diameters than the TDZ with the same pitch. Left or right-hand, through or blind holes almost down to the bottom. With Alcrona Pro coated for the best machining result and through coolant for better chip evacuation.



MF	DORMER	1.5×D
HM		λ 10°
R	Alcrona Pro	DIN 6535HB

Workpiece material group suitability, starting values for cutting speed (m/min) and Alpha Code. Tables with feed per tooth and correction factors can be found starting from page 234.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■190 E	■212 E	■242 E	■163 E	■143 E	■127 E	■146 E	■118 E	■99 E	■87 E	■74 E	■61 E	■69 E	■58 E
M2.1	**M2.2**	**M2.3**	**M3.1**	**M3.2**	**M3.3**	**M4.1**	**M4.2**	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**
■61 E	■50 E	■42 E	■52 D	■44 D	■40 D	■33 D	◪29 D	■143 E	■106 E	■80 E	■136 E	■110 E	■88 E
K3.1	**K3.2**	**K3.3**	**K4.1**	**K4.2**	**K4.3**	**K4.4**	**K4.5**	**K5.1**	**K5.2**	**K5.3**	**N1.1**	**N1.2**	**N1.3**
■120 E	■91 E	■74 E	■111 D	■84 D	■62 D	■53 D	■44 D	■126 E	■95 E	■73 E	■440 F	■330 F	■220 F
N2.1	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**N4.2**	**N4.3**	**S1.1**	**S1.2**	**S1.3**	**S2.1**	**S2.2**
■288 F	■259 F	■187 F	■671 F	■396 F	■198 F	■319 F	■160 F	■72 F	■44 D	■44 D	◪33 D	■36 D	◪28 D
S3.1	**S3.2**	**S4.1**	**S4.2**	**H1.1**	**H3.1**								
■28 D	◪23 D	■22 D	◪18 D	■66 D	◪48 D								

Internal Thread.

Product	TDZ	TP [mm]	DC [mm]	APMX [mm]	OAL [mm]	DCON MS [mm]	NOF
J2258.0X1.0	M10	1.00	8.00	16.00	63.0	8.00	4
J22510.0X1.0	M12	1.00	10.00	20.00	72.0	10.00	4
J22510.0X1.5	M12	1.50	10.00	20.00	72.0	10.00	4
J22512.0X1.0	M14	1.00	12.00	22.00	83.0	12.00	4
J22512.0X1.5	M14	1.50	12.00	22.00	83.0	12.00	4
J22514.0X1.0	M16	1.00	14.00	26.00	83.0	14.00	5
J22514.0X1.5	M16	1.50	14.00	26.00	83.0	14.00	5
J22516.0X1.5	M18	1.50	16.00	30.00	92.0	16.00	5

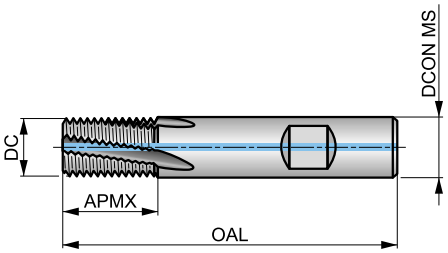
J235

DORMER



Solid Carbide Thread Mill with Through Coolant, UNC

Universal high performance tool to machine same or bigger diameters than the TDZ with the same pitch. Left or right-hand, through or blind holes almost down to the bottom. With Alcrona Pro coated for the best machining result and through coolant for better chip evacuation.



UNC	DORMER	2×D
HM		λ 10°
R	Alcrona Pro	DIN 6535HB

Workpiece material group suitability, starting values for cutting speed (m/min) and Alpha Code. Tables with feed per tooth and correction factors can be found starting from page 234.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 181 H	■ 203 H	■ 210 H	■ 156 H	■ 137 H	■ 121 H	■ 140 H	■ 112 H	■ 95 H	■ 83 H	■ 70 H	■ 58 H	■ 65 H	■ 55 H
M2.1	**M2.2**	**M2.3**	**M3.1**	**M3.2**	**M3.3**	**M4.1**	**M4.2**	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**
■ 58 H	■ 47 H	■ 40 H	■ 50 G	■ 42 G	■ 38 G	■ 32 G	◪ 27 G	■ 137 H	■ 101 H	■ 76 H	■ 129 H	■ 105 H	■ 84 H
K3.1	**K3.2**	**K3.3**	**K4.1**	**K4.2**	**K4.3**	**K4.4**	**K4.5**	**K5.1**	**K5.2**	**K5.3**	**N1.1**	**N1.2**	**N1.3**
■ 115 H	■ 87 H	■ 71 H	■ 106 G	■ 80 G	■ 59 G	■ 51 G	■ 42 G	■ 120 H	■ 90 H	■ 70 H	■ 420 I	■ 315 I	■ 210 I
N2.1	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**N4.2**	**N4.3**	**S1.1**	**S1.2**	**S1.3**	**S2.1**	**S2.2**
■ 275 I	■ 247 I	■ 179 I	■ 640 I	■ 378 I	■ 189 I	■ 305 I	■ 153 I	■ 69 I	■ 42 G	■ 42 G	◪ 32 G	■ 35 G	◪ 26 G
S3.1	**S3.2**	**S4.1**	**S4.2**	**H1.1**	**H3.1**								
■ 26 G	◪ 22 G	■ 21 G	◪ 17 G	■ 63 G	◪ 45 G								

Internal Thread.

Product	TDZ	TPI	DC [mm]	APMX [mm]	OAL [mm]	DCON MS [mm]	NOF
J2354.8-20	1/4	20	4.80	14.00	57.0	6.00	3
J2355.5-18	5/16	18	5.50	14.00	57.0	6.00	3
J2357.5-16	3/8	16	7.50	19.00	63.0	8.00	4
J2358.0-14	7/16	14	8.00	19.00	63.0	8.00	4
J23510.0-13	1/2	13	10.00	22.00	72.0	10.00	4
J23510.0-12	9/16	12	10.00	22.00	72.0	10.00	4
J23512.0-11	5/8	11	12.00	26.00	83.0	12.00	4
J23514.0-10	3/4	10	14.00	32.00	83.0	14.00	5

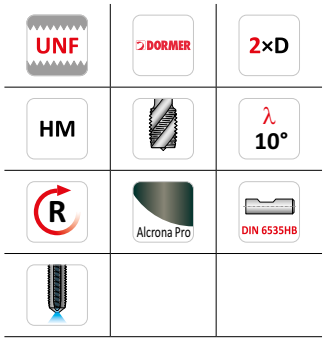
J245

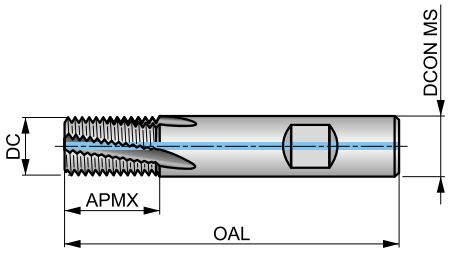
DORMER



Solid Carbide Thread Mill with Through Coolant, UNF

Universal high performance tool to machine same or bigger diameters than the TDZ with the same pitch. Left or right-hand, through or blind holes almost down to the bottom. With Alcrona Pro coated for the best machining result and through coolant for better chip evacuation.





Workpiece material group suitability, starting values for cutting speed (m/min) and Alpha Code. Tables with feed per tooth and correction factors can be found starting from page 234.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■181 K	■203 K	■210 K	■156 K	■137 K	■121 K	■140 K	■112 K	■95 K	■83 K	■70 K	■58 K	■65 K	■55 K
M2.1	**M2.2**	**M2.3**	**M3.1**	**M3.2**	**M3.3**	**M4.1**	**M4.2**	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**
■58 K	■47 K	■40 K	■50 J	■42 J	■38 J	■32 J	◪27 J	■137 K	■101 K	■76 K	■129 K	■105 K	■84 K
K3.1	**K3.2**	**K3.3**	**K4.1**	**K4.2**	**K4.3**	**K4.4**	**K4.5**	**K5.1**	**K5.2**	**K5.3**	**N1.1**	**N1.2**	**N1.3**
■115 K	■87 K	■71 K	■106 J	■80 J	■59 J	■51 J	■42 J	■120 K	■90 K	■70 K	■420 L	■315 L	■210 L
N2.1	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**N4.2**	**N4.3**	**S1.1**	**S1.2**	**S1.3**	**S2.1**	**S2.2**
■275 L	■247 L	■179 L	■640 L	■378 L	■189 L	■305 L	■153 L	■69 L	■42 J	■42 J	◪32 J	■35 J	◪26 J
S3.1	**S3.2**	**S4.1**	**S4.2**	**H1.1**	**H3.1**								
■26 J	◪22 J	■21 J	◪17 J	■63 J	◪45 J								

Internal Thread.

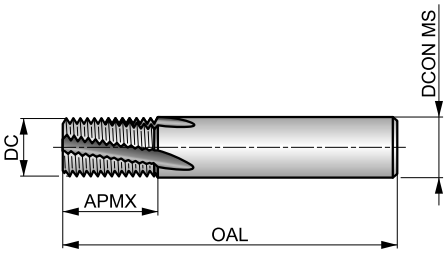
Product	TDZ	TPI	DC [mm]	APMX [mm]	OAL [mm]	DCON MS [mm]	NOF
J2454.8-28	1/4	28	4.80	14.00	57.0	6.00	3
J2456.0-24	5/16. 3/8	24	6.00	14.00	57.0	6.00	3
J2458.0-20	7/16. 1/2	20	8.00	19.00	63.0	8.00	4
J24510.0-18	9/16. 5/8	18	10.00	22.00	72.0	10.00	4
J24514.0-16	3/4	16	14.00	32.00	83.0	14.00	5

J280



Solid Carbide Thread Mill, G(BSP)

Universal high performance tool to machine same or bigger diameters than the TDZ with the same pitch. Left or right-hand, through or blind holes almost down to the bottom. Alcrona Pro coated for the best machining result in a wide range of materials. Suited for producing internal and external threads.



G	DORMER	1.5×D
HM		λ 10°
R	Alcrona Pro	DIN 6535HA

Workpiece material group suitability, starting values for cutting speed (m/min) and Alpha Code. Tables with feed per tooth and correction factors can be found starting from page 234.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 190 N	■ 212 N	■ 242 N	■ 163 N	■ 143 N	■ 127 N	■ 146 N	■ 118 N	■ 99 N	■ 87 N	■ 74 N	■ 61 N	■ 69 N	■ 58 N
M2.1	**M2.2**	**M2.3**	**M3.1**	**M3.2**	**M3.3**	**M4.1**	**M4.2**	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**
■ 61 N	■ 50 N	■ 42 N	■ 52 M	■ 44 M	■ 40 M	■ 33 M	◪ 29 M	■ 143 N	■ 106 N	■ 80 N	■ 136 N	■ 110 N	■ 88 N
K3.1	**K3.2**	**K3.3**	**K4.1**	**K4.2**	**K4.3**	**K4.4**	**K4.5**	**K5.1**	**K5.2**	**K5.3**	**N1.1**	**N1.2**	**N1.3**
■ 120 N	■ 91 N	■ 74 N	■ 111 M	■ 84 M	■ 62 M	■ 53 M	■ 44 M	■ 126 N	■ 95 N	■ 76 N	■ 440 O	■ 330 O	■ 220 O
N2.1	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**N4.2**	**N4.3**	**S1.1**	**S1.2**	**S1.3**	**S2.1**	**S2.2**
■ 288 O	■ 259 O	■ 187 O	■ 671 O	■ 396 O	■ 198 O	■ 319 O	■ 160 O	■ 72 O	■ 44 M	■ 44 M	◪ 33 M	■ 36 M	◪ 28 M
S3.1	**S3.2**	**S4.1**	**S4.2**	**H1.1**	**H3.1**								
■ 28 M	◪ 23 M	■ 22 M	◪ 18 M	■ 66 M	◪ 48 M								

Internal and External Thread.

Product	TDZ	TPI	DC [mm]	APMX [mm]	OAL [mm]	DCON MS [mm]	NOF
J2806.0-28	1/8	28	6.00	15.00	57.0	6.00	3
J28010.0-19	1/4	19	10.00	20.00	72.0	10.00	4
J28014.0-19	3/8	19	14.00	26.00	83.0	14.00	5
J28016.0-14	1/2. 5/8	14	16.00	30.00	92.0	16.00	5
J28020.0-14	5/8. 3/4. 7/8	14	20.00	35.00	104.0	20.00	5
J28025.0-11	1". 3"	11	25.00	45.00	121.0	25.00	6

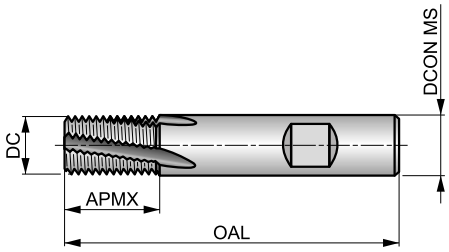
J260

DORMER



Solid Carbide Thread Mill, NPT

Universal high performance tool to machine same or bigger diameters than the TDZ with the same pitch. Left or right-hand, through or blind holes almost down to the bottom. Alcrona Pro coated for the best machining result in a wide range of materials.





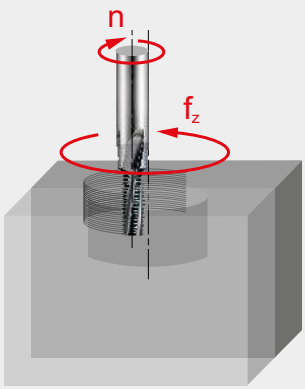
Workpiece material group suitability, starting values for cutting speed (m/min) and Alpha Code. Tables with feed per tooth and correction factors can be found starting from page 234.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 190 R	■ 212 R	■ 242 R	■ 163 R	■ 143 R	■ 127 R	■ 146 R	■ 118 R	■ 99 R	■ 87 R	■ 74 R	■ 61 R	■ 69 R	■ 58 R
M2.1	**M2.2**	**M2.3**	**M3.1**	**M3.2**	**M3.3**	**M4.1**	**M4.2**	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**
■ 61 R	■ 50 R	■ 42 R	■ 52 Q	■ 44 Q	■ 40 Q	■ 33 Q	◪ 29 Q	■ 143 R	■ 106 R	■ 80 R	■ 136 R	■ 110 R	■ 88 R
K3.1	**K3.2**	**K3.3**	**K4.1**	**K4.2**	**K4.3**	**K4.4**	**K4.5**	**K5.1**	**K5.2**	**K5.3**	**N1.1**	**N1.2**	**N1.3**
■ 120 R	■ 91 R	■ 74 R	■ 111 Q	■ 84 Q	■ 62 Q	■ 53 Q	■ 44 Q	■ 126 R	■ 95 R	■ 73 R	■ 440 S	■ 330 S	■ 220 S
N2.1	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**N4.2**	**N4.3**	**S1.1**	**S1.2**	**S1.3**	**S2.1**	**S2.2**
■ 288 S	■ 259 S	■ 187 S	■ 671 S	■ 396 S	■ 198 S	■ 319 S	■ 160 S	■ 72 S	■ 44 Q	■ 44 Q	◪ 33 Q	■ 36 Q	◪ 28 Q
S3.1	**S3.2**	**S4.1**	**S4.2**	**H1.1**	**H3.1**								
■ 28 Q	◪ 23 Q	■ 22 Q	◪ 18 Q	■ 66 Q	◪ 48 Q								

Internal Thread.

Product	TDZ	TPI	DC [mm]	APMX [mm]	OAL [mm]	DCON MS [mm]	NOF
J2607.9-27	1/8	27	7.90	11.50	58.0	8.00	3
J2609.9-18	1/4. 3/8	18	9.90	15.92	66.0	10.00	3
J26015.9-14	1/2. 3/4	14	15.90	20.46	82.0	16.00	4
J26019.9-11.5	1". 2"	11.5	19.90	27.12	92.0	20.00	5

THREAD MILLS – FEED PER TOOTH TABLE



Feed per tooth per revolution (f_z in mm/rev).
The specified values are the recommended starting values for machining the full thread depth in one pass.

How to use this table to find the feed per tooth (f_z):

1. Find your Alpha Code on the product page (example: 181B, "B" is the Alpha Code).
2. Select the column matching your cutter diameter in the top row of the table with the Thread pitch ***P*** or ***TPI*** (in the rows with icons on the left).
3. Find your Alpha Code in the left column of the table.
4. The intersection (cell) of the Diameter + Pitch column and Alpha Code is the feed per tooth (f_z).

Correction of the feed per tooth for multiple passes:

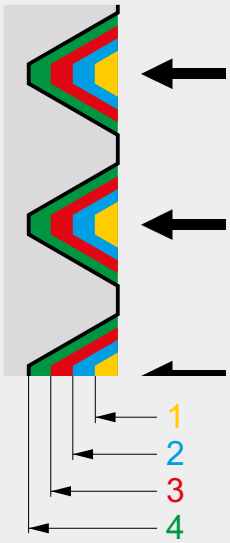
5. In case the thread is being machined in **2 passes** the feed values mentioned in the table should be increased by **30 to 40%**.
6. In case the thread is being machined in **3 passes** the feed values mentioned in the table should be increased by **55 to 65%**.
7. In case the thread is being machined in **4 passes** the feed values mentionedin the table should be increased by **80 to 90%**.

(Example: J2003.2X.7 machining WMG M4.1 with feed rate A in 4-passes the $f_z = 0.017 \times 1.80 = 0.031$ mm/z).

Feed rates

	ø DC [mm]																											
	3.20	**4.10**	**4.50**	**4.80**	**5.50**	**6.00**		**6.50**	**7.50**	**7.90**	**8.00**	**8.20**	**9.50**	**9.90**	**10.00**		**11.60**	**12.00**		**13.60**	**14.00**		**16.00**			**19.00**	**20.00**	**25.00**
	0.70	**0.80**	**1.00**	**1.00**		**1.25**		**1.25**	**1.50**			**1.50**	**1.75**	**1.75**	**2.00**		**2.50**	**2.00**		**2.00**								
A	0.017	0.022	0.023	0.024	–	0.024	–	0.029	0.036	–	–	0.040	0.044	0.047	0.053	–	0.056	0.068	–	0.071	–	–	–	–	–	–	–	–
B	0.022	0.029	0.031	0.032	–	0.032	–	0.038	0.048	–	–	0.053	0.059	0.063	0.070	–	0.075	0.090	–	0.095	–	–	–	–	–	–	–	–
C	0.028	0.036	0.039	0.040	–	0.040	–	0.048	0.060	–	–	0.066	0.074	0.079	0.088	–	0.094	0.113	–	0.119	–	–	–	–	–	–	–	–
				0.50		**0.75**	**1.00**				**1.00**				**1.00**	**1.50**		**1.00**	**1.50**		**1.00**	**1.50**	**1.50**	**2.00**	**2.50**	**3.00**	**2.00**	
D	–	–	–	0.044	–	0.041	0.036	–	–	–	0.057	–	–	–	0.075	0.067		0.079	0.071	–	0.083	0.071	0.092	0.081	0.073	0.067	0.096	–
E	–	–	–	0.058	–	0.055	0.048	–	–	–	0.076	–	–	–	0.100	0.089	–	0.105	0.094	–	0.110	0.095	0.122	0.108	0.097	0.089	0.128	–
F	–	–	–	0.073	–	0.069	0.060	–	–	–	0.095	–	–	–	0.125	0.111	–	0.131	0.118	–	0.138	0.119	0.153	0.135	0.121	0.111	0.160	–
				20	**18**				**16**		**14**				**13**	**12**		**11**			**10**							
G	–	–	–	0.019	0.023	–	–	–	0.030	–	0.034	–	–	–	0.053	0.051	–	0.055	–	–	0.066	–	–	–	–	–	–	–
H	–	–	–	0.025	0.030	–	–	–	0.040	–	0.045	–	–	–	0.071	0.068	–	0.073	–	–	0.088	–	–	–	–	–	–	–
I	–	–	–	0.031	0.038	–	–	–	0.050	–	0.056	–	–	–	0.089	0.085	–	0.091	–	–	0.110	–	–	–	–	–	–	–
				28		**24**					**20**				**18**						**16**							
J	–	–	–	0.023	–	0.026	–	–	–	–	0.041	–	–	–	0.062	–	–	–	–	–	0.083	–	–	–	–	–	–	–
K	–	–	–	0.030	–	0.035	–	–	–	–	0.054	–	–	–	0.083	–	–	–	–	–	0.110	–	–	–	–	–	–	–
L	–	–	–	0.038	–	0.044	–	–	–	–	0.068	–	–	–	0.104	–	–	–	–	–	0.138	–	–	–	–	–	–	–
						28									**19**						**19**		**14**				**14**	**11**
M	–	–	–	–	–	0.029	–	–	–	–	–	–	–	–	0.064	–	–	–	–	–	0.080	–	0.083	–	–	–	0.116	0.131
N	–	–	–	–	–	0.038	–	–	–	–	–	–	–	–	0.085	–	–	–	–	–	0.106	–	0.111	–	–	–	0.155	0.175
O	–	–	–	–	–	0.048	–	–	–	–	–	–	–	–	0.106	–	–	–	–	–	0.133	–	0.139	–	–	–	0.194	0.219
										27				**18**							**14**	**11.5**						
Q	–	–	–	–	–	–	–	–	–	0.039	–	–	–	0.044	–	–	–	–	–	–	0.079	0.115	–	–	–	–	–	–
R	–	–	–	–	–	–	–	–	–	0.052	–	–	–	0.059	–	–	–	–	–	–	0.105	0.153	–	–	–	–	–	–
S	–	–	–	–	–	–	–	–	–	0.065	–	–	–	0.074	–	–	–	–	–	–	0.131	0.191	–	–	–	–	–	–

THREAD MILLS – NUMBER OF PASSES TABLE



How to use the tables to find the depth increments per pass:

1. Select the table for your thread profile (example: "M12" is a metric thread).
2. Find the column matching your thread pitch in the top row of the table.
3. Find in that column below the recommended number of passes and for each pass the increment radial depth of cut. (example: for a pitch of 1.75 the recommended number of passes is 5 and radial depth of the 1st pass is 0.277 mm, the 2nd 0.228 mm etc.).
4. It is recommended to increase the number of passes for more difficult to machine materials.
5. For super-finishing result it is best practice to repeat the final pass.

Recommended number of passes and radial depth of cut per pass for female metric thread (60°).

		Radial depth of cut per pass [mm]										
		0.50	**0.70**	**0.75**	**0.80**	**1.00**	**1.25**	**1.50**	**1.75**	**2.00**	**2.50**	**3.00**
No. of passes	**1**	0.158	0.221	0.168	0.224	0.224	0.228	0.237	0.277	0.283	0.323	0.387
	2	0.131	0.183	0.138	0.185	0.185	0.188	0.196	0.228	0.234	0.267	0.320
	3	–	–	0.127	0.135	0.168	0.173	0.179	0.209	0.214	0.244	0.293
	4	–	–	–	–	–	0.133	0.138	0.161	0.164	0.187	0.225
	5	–	–	–	–	–	–	0.116	0.135	0.138	0.158	0.189
	6	–	–	–	–	–	–	–	–	0.122	0.139	0.167
	7	–	–	–	–	–	–	–	–	–	0.125	0.151
Acc. depth		0.289	0.404	0.433	0.544	0.577	0.722	0.866	1.010	1.155	1.443	1.732

Recommended number of passes and radial depth of cut per pass for female unified thread (60°).

		Radial depth of cut per pass [mm]									
	1 2 3 / 1"	**28**	**24**	**20**	**18**	**16**	**14**	**13**	**12**	**11**	**10**
No. of passes	**1**	0.203	0.237	0.232	0.258	0.251	0.287	0.309	0.299	0.327	0.328
	2	0.167	0.195	0.191	0.213	0.207	0.237	0.255	0.247	0.270	0.271
	3	0.154	0.179	0.175	0.195	0.190	0.217	0.234	0.226	0.247	0.248
	4	–	–	0.135	0.149	0.146	0.166	0.179	0.174	0.189	0.190
	5	–	–	–	–	0.123	0.140	0.151	0.146	0.160	0.160
	6	–	–	–	–	–	–	–	0.130	0.140	0.141
	7	–	–	–	–	–	–	–	–	–	0.128
Acc. Depth		0.524	0.611	0.733	0.815	0.917	1.047	1.128	1.222	1.333	1.466

THREAD MILLS – NUMBER OF PASSES TABLE

Recommended number of passes and radial depth of cut per pass for female BSP thread (55°).

1 2 3 / 1"		Radial depth of cut per pass [mm]			
		28	19	14	11
No. of passes	1	0.225	0.271	0.318	0.362
	2	0.186	0.224	0.263	0.299
	3	0.170	0.205	0.241	0.274
	4	–	0.156	0.185	0.210
	5	–	–	0.155	0.177
	6	–	–	–	0.157
	7	–	–	–	–
Acc. Depth		0.581	0.856	1.162	1.479

Recommended number of passes and radial depth of cut per pass for female NPT thread (60°).

1 2 3 / 1"		Radial depth of cut per pass [mm]			
		27	18	14	11.5
No. of passes	1	0.283	0.348	0.390	0.423
	2	0.233	0.287	0.322	0.349
	3	0.214	0.263	0.295	0.320
	4	–	0.202	0.226	0.246
	5	–	–	0.190	0.207
	6	–	–	–	0.183
	7	–	–	–	–
Acc. Depth		0.730	1.100	1.423	1.728

THREAD MILLS – GENERAL HINTS

General hints on thread milling

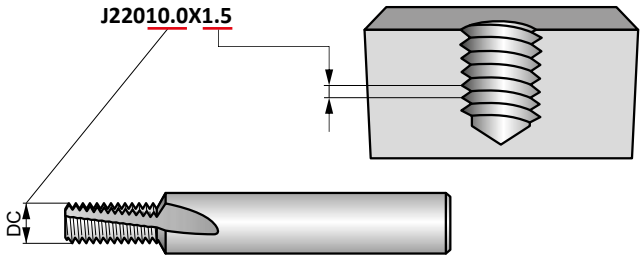
1. Thread milling is the process of generating a thread by the circular interpolation of a milling cutter with a specific thread geometry ground around it's periphery.
2. To be able to use a thread milling cutter it is necessary to have a CNC machine that can make circular paths.
3. Most modern CNC machines are equipped with machining cycles for thread milling.
4. Consult the manual or contact the machine supplier for information.

Features and benefits

1. Thread milling gives increased reliability and tool life.
2. Threadmills produce small chips resulting in problem free threading.
3. Tolerance adjustments can be made using exact co-ordinates.
4. You can generate a complete thread to the bottom of the hole.
5. Capable of machining a wide variety of materials.
6. The same cutter can produce different size threads provided the pitch is the same.
7. Both right and left hand threads can be created with the same tool.
8. Some thread mills can also machine the entry chamfer (J200 and J205).

Choosing your tool

Thread milling cutters have an item code based on the type, diameter (d_1) and pitch (P).
The item code is the number to use when ordering your tool.
Always consult the catalogue to ensure you have the correct thread dimensions.



This thread milling cutter can be used for threads ≥ M12×1.5 (M14×1.5, M18×1.5 etc.)

Programming with Rprg

- For easy adjustment of the thread tolerance always program with radius correction.
- The Rprg value is the start value for a new cutter and is printed on the cutter shank. This should be entered in the tool memory offset.
- Rprg is based on the theoretical zero-line of the thread meaning that when you program using Rprg the thread is never oversize, but normally tight.
- This means that with a small modification to the program co-ordinates you can create the thread to the required size.

Recommendations

- Always use the correct cutting data (refer to the cutting data chart in the Product section).
- Use the recommended drill size for the thread diameter, as for conventional taps.
- For easy adjustment of the thread tolerance always start with the Rprg value printed on the shank of the threadmill.
- Use a gauge to check the tolerance on the first thread to establish if the radius needs to be corrected. The radius can be corrected 2 or 3 times before the threadmill is worn out.
- When dry machining, compressed air is recommended to help with swarf removal.
- When threading more difficult materials, it is recommended to take multiple passes.

DIES



📖 6		WMG & ISO 13399
📖 12	TAPS	INSTRUCTIONS
📖 15	TAPS	SOLID CARBIDE TAPS
📖 25	TAPS	MATERIAL SPECIFIC SHARK TAPS
📖 62	TAPS	HSS HAND & MACHINE TAPS
📖 216	TAPS	TECHNICAL INFORMATION
📖 218		THREAD MILLS
📖 **238**		**DIES**
📖 270		CUTTING FLUIDS
📖 274		GENERAL TECHNICAL INFORMATION

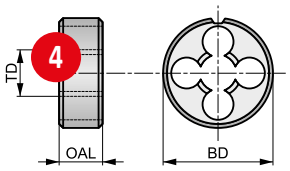
1 F201

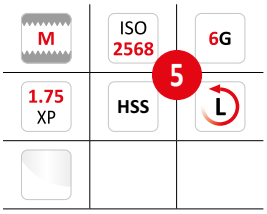
DORMER



HSS Gun Nosed Machine Die, Metric, Left Hand

Creates left handed, external screw threads with a me[2]se thread form. The bright finish ensures workpiece material will not stick to the cutting edges of the tool so you get a cleaner, more accurate thread and the gun nosed geometry directs chips away from the cutting edges for improved performance.





Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	M1.1	M1.2	M2.1	M2.2	K1.1
■12	■13	■14	■10	■9	◪8	■8	◪7	◪5	■7	■6	■6	◪5	■11

K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3
■8	◪6	■11	■9	◪7	■10	■8	◪6	■10	■8	◪6	◪20	◪15	◪10

N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	N4.1	N4.2	N4.3
◪10	◪9	◪6	■11	◪6	◪3	◪11	◪4	◪4

6

Product	TD [mm]	TP [mm]	BD [mm]	OAL [mm]
F201M3	3.000	0.50	20.00	5.0
F201M4	4.000	0.70	20.00	5.0
F201[7]	5.000	0.80	20.00	7.0
F201	6.000	1.00	20.00	7.0
F201M8	8.000	1.25	25.00	9.0
F201M10	10.000	1.50	30.00	11.0
F201M12	12.000	1.75	38.00	14.0
F201M14	14.000	2.00	38.00	14.0
F201M16	16.000	2.00	45.00	18.0
F201M18	18.000	2.50	45.00	18.0
F201M20	20.000	2.50	45.00	18.0

8

Pos.	Description
1	Designation of taps
2	Product description
3	Illustrative picture
4	Schematic drawing of tool

Pos.	Description
5	Product features
6	Material group recommendations incl. speed and feed guidance
7	Product code
8	Product dimensions

Typical page with tap holder displayed – specific page details will differ.

HSS DIES – ICONS OVERVIEW

General icons

■	Primary use
◪	Possible use

Basic standard group (BSG)

BS 1127:1950	BS 1127:1950 – Round Dies Stds.
DIN 382	DIN 382 – Hex Die Stds.
ISO 2568	ISO 2568 – Die Stds.

Material code (BMC)

HSS-E	High Speed Cobalt Steel Tool Material
HSS	High Speed Steel Tool Material

Coating

Bright	Bright (uncoated)

Die chamfer to pitch ratio (DCPR)

1.75 XP	Die Thread Chamfer to Pitch Ratio (1.75xP)
2.25 XP	Die Thread Chamfer to Pitch Ratio (2.25xP)

Hand (Cutting direction)

L	Left Hand Rotation / Cutting
R	Right Hand Rotation / Cutting

Thread form type (THFT)

NPT	Thread Form, American National Pipe Taper
BSW	Thread Form, British Standard Whitworth
PG	Thread Form, Steel Conduit DIN 40 430 (electrical)
BSF	Thread Form, British Standard Fine
M	Thread Form, Metric Coarse
UNC	Thread Form, Unified Coarse
G	Thread Form, British Standard Pipe
MF	Thread Form, Metric Fine
UNF	Thread Form, Unified Fine

Thread tolerance class (TCTR)

6g	Normal Fit "middle" Tolerance Class
Medium	Medium Inch Thread Class of Fit
Normal	Normal Fit Class for Pipe Thread
2A	External Inch Thread Medium Class of Fit
Class A	Medium Inch Thread Class of Fit

Tool materials

High Speed Steel	HSS	A medium-alloyed high speed steel that has good machinability and good performance. HSS exhibits hardness, toughness and wear resistance characteristics that make it attractive in a wide range of applications, for example in drills and taps.
Cobalt High Speed Steel	HSS-E	This high speed steel contains cobalt for increased hot hardness. The composition of HSCo provides a good combination of toughness and hardness. It has good machinability and good wear resistance, which makes it excellent for producing drills, taps, reamers and milling cutters.

Surface Coatings

Bright (uncoated)	Bright	Bright finish (uncoated surface) improves chip flow in soft or non-ferrous materials and maintains sharp cutting edges in abrasive materials.

DORMER PRAMET

HELP IS AT HAND

Our techincal support team are always at hand to help with any technical questions or queries you have about our technical apps. Use the contact us details to reach out to your local Dormer Pramet sales office. **Simply Reliable.**



Thread form (THFT)		M	M	M	MF	UNC	UNF
Basic standard group (BSG)		ISO 2568	ISO 2568	ISO 2568	ISO 2568	ISO 2568	ISO 2568
Thread tolerance class (TCTR)		6g	6g	6g	6g	2A	2A
Die chamfer to pitch ratio (DCPR)		1.75 XP	1.75 XP	2.25 XP	1.75 XP	1.75 XP	1.75 XP
Material code (BMC)		HSS	HSS	HSS-E	HSS	HSS	HSS
Hand (Cutting direction)		R	L	R	R	R	R
Coating		Bright	Bright	Bright	Bright	Bright	Bright
							
Product Family Code		F100	F201	F108	F110	F120	F130
		M2 - M42	M3 - M20	M2 - M20	M4 - M40	No.8 - 1"	No.10 - 1"
		248	249	250	251	252	253
P	P1	■	■	◪	■	■	■
	P2	■	■	◪	■	■	■
	P3	◪	◪	■	◪	◪	◪
	P4	◪	◪	■	◪	◪	◪
M	M1	■	■	◪	■	■	■
	M2	◪	◪	■	◪	◪	◪
	M3			■			
	M4			◪			
K	K1	■	■		■	■	■
	K2	■	■		■	■	■
	K3	■	■		■	■	■
	K4			■			
	K5	■	■		■	■	■
N	N1	◪	◪	◪	◪	◪	◪
	N2	◪	◪	◪	◪	◪	◪
	N3	◪	◪	◪	◪	◪	◪
	N4	◪	◪	◪	◪	◪	◪
	N5						
S	S1			◪			
	S2						
	S3						
	S4						
H	H1						
	H2						
	H3						
	H4						

■ Primary use ◪ Possible use

	BSW	BSF	G	NPT	PG	M	MF
	ISO 2568	ISO 2568	ISO 2568	ISO 2568	ISO 2568	BS 1127:1950	BS 1127:1950
	Medium	Medium	Class A	Normal	Normal		
	1.75 XP	1.75 XP	1.75 XP	1.75 XP	1.75 XP	1.75 XP	1.75 XP
	HSS	HSS	HSS	HSS	HSS	HSS	HSS
	R	R	R	R	R	R	R
	Bright	Bright	Bright	Bright	Bright	Bright	Bright
							
	F140	**F150**	**F170**	**F180**	**F190**	**F300**	**F310**
	1/8 - 1"	3/16 - 1/2	1/8 - 2"	1/8 - 1"	No.7 - No.36	M2 - M36	M3 - M30
	254	255	256	257	258	259	260
P1	■	■	■	■	■	■	■
P2	■	■	■	■	■	■	■
P3	◪	◪	◪	◪	◪	◪	◪
P4	◪	◪	◪	◪	◪	◪	◪
M1	■	■	■	■	■	■	■
M2	◪	◪	◪	◪	◪	◪	◪
M3							
M4							
K1	■	■	■	■	■	■	■
K2	■	■	■	■	■	■	■
K3	■	■	■	■	■	■	■
K4							
K5	■	■	■	■	■	■	■
N1	◪	◪	◪	◪	◪	◪	◪
N2	◪	◪	◪	◪	◪	◪	◪
N3	◪	◪	◪	◪	◪	◪	◪
N4	◪	◪	◪	◪	◪	◪	◪
N5							
S1							
S2							
S3							
S4							
H1							
H2							
H3							
H4							

■ Primary use ◪ Possible use

Thread form (THFT)		UNC	UNF	G	M	M	MF	
Basic standard group (BSG)		BS 1127:1950	BS 1127:1950	BS 1127:1950	DIN 382	BS 1127:1950	BS 1127:1950	
Thread tolerance class (TCTR)					6g	6g	6g	
Die chamfer to pitch ratio (DCPR)		1.75 XP	1.75 XP	1.75 XP	1.75 XP	1.75 XP	1.75 XP	
Material code (BMC)		HSS	HSS	HSS	HSS	HSS	HSS	
Hand (Cutting direction)		R	R	R	R	R	R	
Coating		Bright	Bright	Bright	Bright	Bright	Bright	
								
Product Family Code		F320	F330	F370	F202	F302	F312	
		No.4 - 1.1/4	No.4 - 1.1/2	1/8 - 1.1/2	M3 - M36	M3 - M36	M8 - M24	
		261	262	263	264	265	266	
P	P1	■	■	■	■	■	■	
	P2	■	■	■	■	■	■	
	P3	◪	◪	◪	◪	◪	◪	
	P4	◪	◪	◪	◪	◪	◪	
M	M1	■	■	■	■	■	■	
	M2	◪	◪	◪	◪	◪	◪	
	M3							
	M4							
K	K1	■	■	■	■	■	■	
	K2	■	■	■	■	■	■	
	K3	■	■	■	■	■	■	
	K4							
	K5	■	■	■	■	■	■	
N	N1	◪	◪	◪	◪	◪	◪	
	N2	◪	◪	◪	◪	◪	◪	
	N3	◪	◪	◪	◪	◪	◪	
	N4	◪	◪	◪	◪	◪	◪	
	N5							
S	S1							
	S2							
	S3							
	S4							
H	H1							
	H2							
	H3							
	H4							

■ Primary use ◪ Possible use

G

DIN 382

Class A

1.75 XP

HSS

R

Bright



	F272
	1/8 - 1.1/2
	267
P1	■
P2	■
P3	◪
P4	◪
M1	■
M2	◪
M3	
M4	
K1	■
K2	■
K3	■
K4	
K5	■
N1	◪
N2	◪
N3	◪
N4	◪
N5	
S1	
S2	
S3	
S4	
H1	
H2	
H3	
H4	

■ Primary use ◪ Possible use

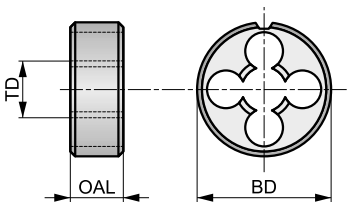
F100

DORMER



HSS Gun Nosed Machine Die, Metric, Right Hand

Solid die for external thread. Generally for use on lathes, small diameters can be produced by hand with a die stock holder. The gun-nose will drive the chip ahead of the cutting edge, increasing performance. Bright finish lapped surface prevents the workpiece material from sticking and improves the threading action.



M	ISO 2568	6g
1.75 XP	HSS	R
Bright		

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	M1.1	M1.2	M2.1	M2.2	K1.1
■12	■13	■14	■10	■9	◪8	■8	◪7	◪5	■7	■6	■6	◪5	■11

K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3
■8	◪6	■11	■9	◪7	■10	■8	◪6	■10	■8	◪6	◪20	◪15	◪10

N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	N4.1	N4.2	N4.3
◪10	◪9	◪6	■11	◪6	◪3	◪11	◪4	◪4

Products from this series are also available in set with taps. Please see L120.

Product	TD [mm]	TP [mm]	BD [mm]	OAL [mm]
F100M2 [1]	2.000	0.40	16.00	5.0
F100M2.5 [1]	2.500	0.45	16.00	5.0
F100M2.6 [1]	2.600	0.45	16.00	5.0
F100M3	3.000	0.50	20.00	5.0
F100M3.5	3.500	0.60	20.00	5.0
F100M4	4.000	0.70	20.00	5.0
F100M4.5	4.500	0.75	20.00	7.0
F100M5	5.000	0.80	20.00	7.0
F100M6	6.000	1.00	20.00	7.0
F100M7	7.000	1.00	25.00	9.0
F100M8	8.000	1.25	25.00	9.0
F100M9	9.000	1.25	25.00	9.0
F100M10	10.000	1.50	30.00	11.0
F100M11	11.000	1.50	30.00	11.0

Product	TD [mm]	TP [mm]	BD [mm]	OAL [mm]
F100M12	12.000	1.75	38.00	14.0
F100M14	14.000	2.00	38.00	14.0
F100M16	16.000	2.00	45.00	18.0
F100M18	18.000	2.50	45.00	18.0
F100M20	20.000	2.50	45.00	18.0
F100M22	22.000	2.50	55.00	22.0
F100M24	24.000	3.00	55.00	22.0
F100M27	27.000	3.00	65.00	25.0
F100M30	30.000	3.50	65.00	25.0
F100M33	33.000	3.50	65.00	25.0
F100M36	36.000	4.00	65.00	25.0
F100M39	39.000	4.00	75.00	30.0
F100M42	42.000	4.50	75.00	30.0

[1] Without gun-nose.

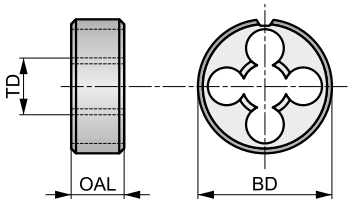
F201

DORMER



HSS Gun Nosed Machine Die, Metric, Left Hand

Solid die for external thread. Generally for use on lathes, small diameters can be produced by hand with a die stock holder. The gun-nose will drive the chip ahead of the cutting edge, increasing performance. Bright finish lapped surface prevents the workpiece material from sticking and improves the threading action.



M	ISO 2568	6g
1.75 XP	HSS	L
Bright		

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	M1.1	M1.2	M2.1	M2.2	K1.1
■12	■13	■14	■10	■9	◪8	■8	◪7	◪5	■7	■6	■6	◪5	■11
K1.2	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**K3.3**	**K5.1**	**K5.2**	**K5.3**	**N1.1**	**N1.2**	**N1.3**
■8	◪6	■11	■9	◪7	■10	■8	◪6	■10	■8	◪6	◪20	◪15	◪10
N2.1	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**N4.2**	**N4.3**					
◪10	◪9	◪6	■11	◪6	◪3	◪11	◪4	◪4					

Product	TD [mm]	TP [mm]	BD [mm]	OAL [mm]
F201M3	3.000	0.50	20.00	5.0
F201M4	4.000	0.70	20.00	5.0
F201M5	5.000	0.80	20.00	7.0
F201M6	6.000	1.00	20.00	7.0
F201M8	8.000	1.25	25.00	9.0
F201M10	10.000	1.50	30.00	11.0
F201M12	12.000	1.75	38.00	14.0
F201M14	14.000	2.00	38.00	14.0
F201M16	16.000	2.00	45.00	18.0
F201M18	18.000	2.50	45.00	18.0
F201M20	20.000	2.50	45.00	18.0

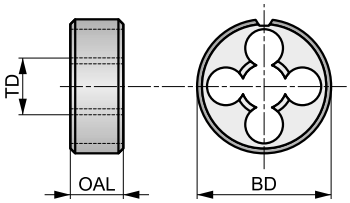
F108

DORMER



HSS-E Gun Nosed Machine Die, Metric, Right Hand

Solid die for producing external thread. The gun-nose will drive the chip ahead of the cutting edge, increasing performance. Bright finish lapped surface prevents the workpiece material from sticking and improves the threading action. Specific geometry to cut accurate threads in stainless steel.



M	ISO 2568	6g
2.25 XP	HSS-E	R
Bright		

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1
◪12	◪13	◪14	◪10	◪9	■8	◪8	■7	■6	■5	■4	◪7	◪6	■6
M2.2	**M2.3**	**M3.1**	**M3.2**	**M3.3**	**M4.1**	**K4.1**	**K4.2**	**K4.3**	**K4.4**	**K4.5**	**N1.1**	**N1.2**	**N1.3**
■5	◪5	■6	■5	■4	■5	■9	■7	■5	■4	◪4	◪20	◪15	■10
N2.1	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**N4.2**	**N4.3**	**S1.1**				
◪10	◪9	■6	■11	◪6	◪3	◪11	◪4	◪4	◪5				

Product	TD [mm]	TP [mm]	BD [mm]	OAL [mm]
F108M2 [1]	2.000	0.40	16.00	5.0
F108M2.5 [1]	2.500	0.45	16.00	5.0
F108M3	3.000	0.50	20.00	5.0
F108M4	4.000	0.70	20.00	5.0
F108M5	5.000	0.80	20.00	7.0
F108M6	6.000	1.00	20.00	7.0
F108M8	8.000	1.25	25.00	9.0
F108M10	10.000	1.50	30.00	11.0
F108M12	12.000	1.75	38.00	14.0
F108M14	14.000	2.00	38.00	14.0
F108M16	16.000	2.00	45.00	18.0
F108M18	18.000	2.50	45.00	18.0
F108M20	20.000	2.50	45.00	18.0

[1] Without gun-nose.

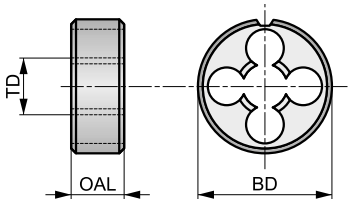
F110

DORMER



HSS Gun Nosed Machine Die, Metric Fine, Right Hand

Solid die for external thread. Generally for use on lathes, small diameters can be produced by hand with a die stock holder. The gun-nose will drive the chip ahead of the cutting edge increasing performance. Bright finish lapped surface prevents the workpiece material from sticking and improves the threading action.



MF	ISO 2568	6g
1.75 XP	HSS	R
Bright		

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	M1.1	M1.2	M2.1	M2.2	K1.1
■12	■13	■14	■10	■9	◪8	■8	◪7	◪5	■7	■6	■6	◪5	■11
K1.2	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**K3.3**	**K5.1**	**K5.2**	**K5.3**	**N1.1**	**N1.2**	**N1.3**
■8	◪6	■11	■9	◪7	■10	■8	◪6	■10	■8	◪6	◪20	◪15	◪10
N2.1	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**N4.2**	**N4.3**					
◪10	◪9	◪6	■11	◪6	◪3	◪11	◪4	◪4					

Product	TD [mm]	TP [mm]	BD [mm]	OAL [mm]
F110M4X.5	4.000	0.50	20.00	5.0
F110M5X.5	5.000	0.50	20.00	5.0
F110M6X.75	6.000	0.75	20.00	7.0
F110M7X.75	7.000	0.75	25.00	9.0
F110M8X.75	8.000	0.75	25.00	9.0
F110M8X1.0	8.000	1.00	25.00	9.0
F110M9X1.0	9.000	1.00	25.00	9.0
F110M10X.75	10.000	0.75	30.00	11.0
F110M10X1.0	10.000	1.00	30.00	11.0
F110M10X1.25	10.000	1.25	30.00	11.0
F110M11X1.0	11.000	1.00	30.00	11.0
F110M12X1.0	12.000	1.00	38.00	10.0
F110M12X1.25	12.000	1.25	38.00	10.0
F110M12X1.5	12.000	1.50	38.00	10.0
F110M13X1.0	13.000	1.00	38.00	10.0
F110M14X1.0	14.000	1.00	38.00	10.0
F110M14X1.25	14.000	1.25	38.00	10.0
F110M14X1.5	14.000	1.50	38.00	10.0
F110M15X1.0	15.000	1.00	38.00	10.0
F110M15X1.5	15.000	1.50	38.00	10.0
F110M16X1.0	16.000	1.00	45.00	14.0

Product	TD [mm]	TP [mm]	BD [mm]	OAL [mm]
F110M16X1.5	16.000	1.50	45.00	14.0
F110M18X1.0	18.000	1.00	45.00	14.0
F110M18X1.5	18.000	1.50	45.00	14.0
F110M20X1.0	20.000	1.00	45.00	14.0
F110M20X1.5	20.000	1.50	45.00	14.0
F110M22X1.0	22.000	1.00	55.00	16.0
F110M22X1.5	22.000	1.50	55.00	16.0
F110M24X1.0	24.000	1.00	55.00	16.0
F110M24X1.5	24.000	1.50	55.00	16.0
F110M24X2.0	24.000	2.00	55.00	16.0
F110M25X1.5	25.000	1.50	55.00	16.0
F110M26X1.5	26.000	1.50	55.00	16.0
F110M27X1.5	27.000	1.50	65.00	18.0
F110M27X2.0	27.000	2.00	65.00	18.0
F110M28X1.5	28.000	1.50	65.00	18.0
F110M30X1.5	30.000	1.50	65.00	18.0
F110M32X1.5	32.000	1.50	65.00	18.0
F110M35X1.5	35.000	1.50	65.00	18.0
F110M36X1.5	36.000	1.50	65.00	18.0
F110M40X1.5	40.000	1.50	75.00	20.0

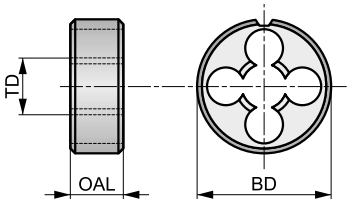
F120

DORMER



HSS Gun Nosed Machine Die, UNC, Right Hand

Solid die for external thread. Generally for use on lathes, small diameters can be produced by hand with a die stock holder. The gun-nose will drive the chip ahead of the cutting edge, increasing performance. Bright finish lapped surface prevents the workpiece material from sticking and improves the threading action.



UNC	ISO 2568	2A
1.75 XP	HSS	R
Bright		

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	M1.1	M1.2	M2.1	M2.2	K1.1
■12	■13	■14	■10	■9	◪8	■8	◪7	◪5	■7	■6	■6	◪5	■11
K1.2	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**K3.3**	**K5.1**	**K5.2**	**K5.3**	**N1.1**	**N1.2**	**N1.3**
■8	◪6	■11	■9	◪7	■10	■8	◪6	■10	■8	◪6	◪20	◪15	◪10
N2.1	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**N4.2**	**N4.3**					
◪10	◪9	◪6	■11	◪6	◪3	◪11	◪4	◪4					

Product	TDZ	TPI	TD [mm]	BD [mm]	OAL [mm]
F1208-32	8	32	4.170	20.00	7.0
F12010-24	10	24	4.830	20.00	7.0
F1201/4	1/4	20	6.350	20.00	7.0
F1205/16	5/16	18	7.940	25.00	9.0
F1203/8	3/8	16	9.530	30.00	11.0
F1207/16	7/16	14	11.110	30.00	11.0
F1201/2	1/2	13	12.700	38.00	14.0
F1209/16	9/16	12	14.290	38.00	14.0
F1205/8	5/8	11	15.880	45.00	18.0
F1203/4	3/4	10	19.050	45.00	18.0
F1207/8	7/8	9	22.230	55.00	22.0
F1201	1″	8	25.400	55.00	22.0

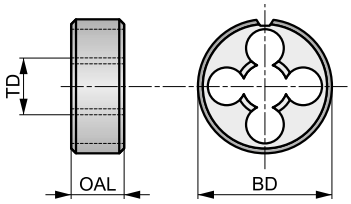
F130

DORMER



HSS Gun Nosed Machine Die, UNF, Right Hand

Solid die for external thread. Generally for use on lathes, small diameters can be produced by hand with a die stock holder. The gun-nose will drive the chip ahead of the cutting edge, increasing performance. Bright finish lapped surface prevents the workpiece material from sticking and improves the threading action.



UNF	ISO 2568	2A
1.75 XP	HSS	R
Bright		

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	M1.1	M1.2	M2.1	M2.2	K1.1
■12	■13	■14	■10	■9	◪8	■8	◪7	◪5	■7	■6	■6	◪5	■11
K1.2	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**K3.3**	**K5.1**	**K5.2**	**K5.3**	**N1.1**	**N1.2**	**N1.3**
■8	◪6	■11	■9	◪7	■10	■8	◪6	■10	■8	◪6	◪20	◪15	◪10
N2.1	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**N4.2**	**N4.3**					
◪10	◪9	◪6	■11	◪6	◪3	◪11	◪4	◪4					

Product	TDZ	TPI	TD [mm]	BD [mm]	OAL [mm]
F13010-32	10	32	4.830	20.00	7.0
F1301/4	1/4	28	6.350	20.00	7.0
F1305/16	5/16	24	7.940	25.00	9.0
F1303/8	3/8	24	9.530	30.00	11.0
F1307/16	7/16	20	11.110	30.00	11.0
F1301/2	1/2	20	12.700	38.00	10.0
F1309/16	9/16	18	14.290	38.00	10.0
F1305/8	5/8	18	15.880	45.00	14.0
F1303/4	3/4	16	19.050	45.00	14.0
F1307/8	7/8	14	22.230	55.00	16.0
F1301	1″	12	25.400	55.00	16.0

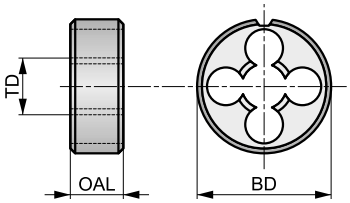
F140

DORMER



HSS Gun Nosed Machine Die, BSW, Right Hand

Solid die for external thread. Generally for use on lathes, small diameters can be produced by hand with a die stock holder. The gun-nose will drive the chip ahead of the cutting edge, increasing performance. Bright finish lapped surface prevents the workpiece material from sticking and improves the threading action.



BSW	ISO 2568	Medium
1.75 XP	HSS	R
Bright		

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	M1.1	M1.2	M2.1	M2.2	K1.1
■12	■13	■14	■10	■9	◪8	■8	◪7	◪5	■7	■6	■6	◪5	■11
K1.2	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**K3.3**	**K5.1**	**K5.2**	**K5.3**	**N1.1**	**N1.2**	**N1.3**
■8	◪6	■11	■9	◪7	■10	■8	◪6	■10	■8	◪6	◪20	◪15	◪10
N2.1	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**N4.2**	**N4.3**					
◪10	◪9	◪6	■11	◪6	◪3	◪11	◪4	◪4					

Product	TDZ	TPI	TD [mm]	BD [mm]	OAL [mm]
F1401/8	1/8	40	3.170	20.00	5.0
F1403/16	3/16	24	4.760	20.00	7.0
F1401/4	1/4	20	6.350	20.00	7.0
F1405/16	5/16	18	7.940	25.00	9.0
F1403/8	3/8	16	9.530	30.00	11.0
F1407/16	7/16	14	11.110	30.00	11.0
F1401/2	1/2	12	12.700	38.00	14.0
F1405/8	5/8	11	15.880	45.00	18.0
F1403/4	3/4	10	19.050	45.00	18.0
F1407/8	7/8	9	22.230	55.00	22.0
F1401	1″	8	25.400	55.00	22.0

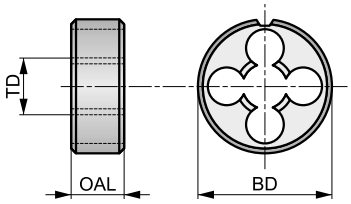
F150

DORMER



HSS Gun Nosed Machine Die, BSF, Right Hand

Solid die for external thread. Generally for use on lathes, yet small diameters can be produced by hand with a die stock holder. The gun-nose will drive the chip ahead of the cutting edge, increasing performance. Bright finish lapped surface prevents the workpiece material from sticking and improves the threading action.



BSF	ISO 2568	Medium
1.75 XP	HSS	R
Bright		

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	M1.1	M1.2	M2.1	M2.2	K1.1
■12	■13	■14	■10	■9	◪8	■8	◪7	◪5	■7	■6	■6	◪5	■11
K1.2	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**K3.3**	**K5.1**	**K5.2**	**K5.3**	**N1.1**	**N1.2**	**N1.3**
■8	◪6	■11	■9	◪7	■10	■8	◪6	■10	■8	◪6	◪20	◪15	◪10
N2.1	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**N4.2**	**N4.3**					
◪10	◪9	◪6	■11	◪6	◪3	◪11	◪4	◪4					

Product	TDZ	TPI	TD [mm]	BD [mm]	OAL [mm]
F1503/16	3/16	32	4.760	20.00	7.0
F1501/4	1/4	26	6.350	20.00	7.0
F1505/16	5/16	22	7.940	25.00	9.0
F1503/8	3/8	20	9.530	30.00	11.0
F1507/16	7/16	18	11.110	30.00	11.0
F1501/2	1/2	16	12.700	38.00	10.0

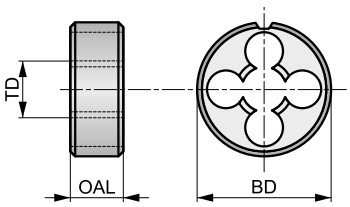
F170

DORMER



HSS Gun Nosed Machine Die, G(BSP) Right Hand

Solid die for external thread. Generally for use on lathes, small diameters can be produced by hand with a die stock holder. The gun-nose will drive the chip ahead of the cutting edge, increasing performance. Bright finish lapped surface prevents the workpiece material from sticking and improves the threading action.



G	ISO 2568	Class A
1.75 XP	HSS	R
Bright		

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	M1.1	M1.2	M2.1	M2.2	K1.1
■12	■13	■14	■10	■9	◪8	■8	◪7	◪5	■7	■6	■6	◪5	■11
K1.2	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**K3.3**	**K5.1**	**K5.2**	**K5.3**	**N1.1**	**N1.2**	**N1.3**
■8	◪6	■11	■9	◪7	■10	■8	◪6	■10	■8	◪6	◪20	◪15	◪10
N2.1	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**N4.2**	**N4.3**					
◪10	◪9	◪6	■11	◪6	◪3	◪11	◪4	◪4					

Product	TDZ	TPI	TD [mm]	BD [mm]	OAL [mm]
F1701/8	1/8	28	9.730	30.00	11.0
F1701/4	1/4	19	13.160	38.00	10.0
F1703/8	3/8	19	16.660	45.00	14.0
F1701/2	1/2	14	20.960	45.00	14.0
F1705/8	5/8	14	22.910	55.00	16.0
F1703/4	3/4	14	26.440	55.00	16.0
F1707/8	7/8	14	30.200	65.00	18.0
F1701	1″	11	33.250	65.00	18.0
F1701.1/8	1.1/8	11	37.890	75.00	20.0
F1701.1/4	1.1/4	11	41.910	75.00	20.0
F1701.1/2	1.1/2	11	47.800	90.00	22.0
F1702	2″	11	59.610	105.00	22.0

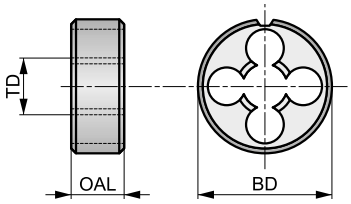
F180

DORMER



HSS Gun Nosed Machine Die, NPT, Right Hand

Solid die for external thread. Generally for use on lathes, small diameters can be produced by hand with a die stock holder. The gun-nose will drive the chip ahead of the cutting edge, increasing performance. Bright finish lapped surface prevents the workpiece material from sticking and improves the threading action.



NPT	ISO 2568	Normal
1.75 XP	HSS	R
Bright		

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	M1.1	M1.2	M2.1	M2.2	K1.1
■12	■13	■14	■10	■9	◪8	■8	◪7	◪5	■7	■6	■6	◪5	■11
K1.2	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**K3.3**	**K5.1**	**K5.2**	**K5.3**	**N1.1**	**N1.2**	**N1.3**
■8	◪6	■11	■9	◪7	■10	■8	◪6	■10	■8	◪6	◪20	◪15	◪10
N2.1	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**N4.2**	**N4.3**					
◪10	◪9	◪6	■11	◪6	◪3	◪11	◪4	◪4					

Product	TDZ	TPI	TD [mm]	BD [mm]	OAL [mm]
F1801/8	1/8	27	9.490	30.00	11.0
F1801/4	1/4	18	12.490	38.00	14.0
F1803/8	3/8	18	15.930	45.00	14.0
F1801/2	1/2	14	19.770	45.00	18.0
F1803/4	3/4	14	25.120	55.00	22.0
F1801	1"	11.5	31.460	65.00	25.0

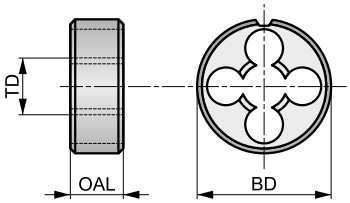
F190

DORMER



HSS Gun Nosed Machine Die, PG Conduit Thread, Right Hand

Solid die for external thread. Generally for use on lathes, small diameters can be produced by hand with a die stock holder. The gun-nose will drive the chip ahead of the cutting edge, increasing performance. Bright finish lapped surface prevents the workpiece material from sticking and improves the threading action.



PG	ISO 2568	Normal
1.75 XP	HSS	R
Bright		

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	M1.1	M1.2	M2.1	M2.2	K1.1
■12	■13	■14	■10	■9	◪8	■8	◪7	◪5	■7	■6	■6	◪5	■11
K1.2	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**K3.3**	**K5.1**	**K5.2**	**K5.3**	**N1.1**	**N1.2**	**N1.3**
■8	◪6	■11	■9	◪7	■10	■8	◪6	■10	■8	◪6	◪20	◪15	◪10
N2.1	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**N4.2**	**N4.3**					
◪10	◪9	◪6	■11	◪6	◪3	◪11	◪4	◪4					

Product	TDZ	TPI	TD [mm]	BD [mm]	OAL [mm]
F190PG7	7	20	12.500	38.00	10.0
F190PG9	9	18	15.200	38.00	10.0
F190PG11	11	18	18.600	45.00	14.0
F190PG13.5	13.5	18	20.400	45.00	14.0
F190PG16	16	18	22.500	55.00	16.0
F190PG21	21	16	28.300	65.00	18.0
F190PG29	29	16	37.000	65.00	18.0
F190PG36	36	16	47.000	90.00	22.0

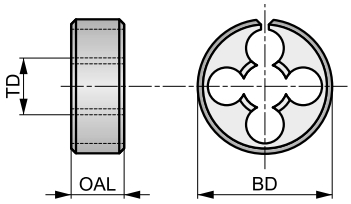
F300

DORMER



HSS Adjustable Split Hand Die, Metric, Right Hand

Split die to produce external thread by hand in multiple passes, adjusting each pass. By tightening the die stock holder, different classes of thread fit can be achieved - tight, regular or loose fit. Slightly tightened in the holder, it can be used to clean up or produce a partial thread.



M	BS 1127:1950	1.75 XP
HSS	R	Bright

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	M1.1	M1.2	M2.1	M2.2	K1.1
■12	■13	■14	■10	■9	◪8	■8	◪7	◪5	■7	■6	■6	◪5	■11
K1.2	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**K3.3**	**K5.1**	**K5.2**	**K5.3**	**N1.1**	**N1.2**	**N1.3**
■8	◪6	■11	■9	◪7	■10	■8	◪6	■10	■8	◪6	◪20	◪15	◪10
N2.1	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**N4.2**	**N4.3**					
◪10	◪9	◪6	■11	◪6	◪3	◪11	◪4	◪4					

Products from this series are also available in set with taps. Please see L120.

Product	TD [mm]	TP [mm]	BD [inch]	OAL [inch]
F300M2X13/16	2.000	0.40	13/16	1/4
F300M2.5X13/16	2.500	0.45	13/16	1/4
F300M3X13/16	3.000	0.50	13/16	1/4
F300M3.5X13/16	3.500	0.60	13/16	1/4
F300M4X13/16	4.000	0.70	13/16	1/4
F300M5X13/16	5.000	0.80	13/16	1/4
F300M5X1	5.000	0.80	1″	3/8
F300M6X13/16	6.000	1.00	13/16	1/4
F300M6X1	6.000	1.00	1″	3/8
F300M6X1.5/16	6.000	1.00	1.5/16	7/16
F300M7X13/16	7.000	1.00	13/16	1/4
F300M7X1	7.000	1.00	1″	3/8
F300M8X1	8.000	1.25	1″	3/8
F300M8X1.5/16	8.000	1.25	1.5/16	7/16
F300M9X1	9.000	1.25	1″	3/8
F300M9X1.5/16	9.000	1.25	1.5/16	7/16
F300M10X1	10.000	1.50	1″	3/8
F300M10X1.5/16	10.000	1.50	1.5/16	7/16

Product	TD [mm]	TP [mm]	BD [inch]	OAL [inch]
F300M10X1.1/2	10.000	1.50	1.1/2	1/2
F300M11X1.5/16	11.000	1.50	1.5/16	7/16
F300M12X1.5/16	12.000	1.75	1.5/16	7/16
F300M12X1.1/2	12.000	1.75	1.1/2	1/2
F300M14X1.5/16	14.000	2.00	1.5/16	7/16
F300M14X1.1/2	14.000	2.00	1.1/2	1/2
F300M16X1.1/2	16.000	2.00	1.1/2	1/2
F300M16X2	16.000	2.00	2″	5/8
F300M18X1.1/2	18.000	2.50	1.1/2	1/2
F300M18X2	18.000	2.50	2″	5/8
F300M20X1.1/2	20.000	2.50	1.1/2	1/2
F300M20X2	20.000	2.50	2″	5/8
F300M22X2	22.000	2.50	2″	5/8
F300M24X2	24.000	3.00	2″	5/8
F300M27X3	27.000	3.00	3″	7/8
F300M30X3	30.000	3.50	3″	7/8
F300M36X3	36.000	4.00	3″	7/8

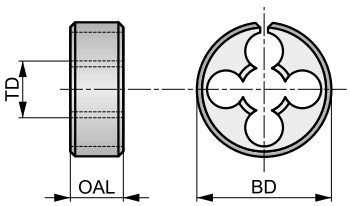
F310

DORMER



HSS Adjustable Split Hand Die, Metric Fine, Right Hand

Split die to produce external thread by hand in multiple passes, adjusting each pass. By tightening the die stock holder, different classes of thread fit can be achieved - tight, regular or loose fit. Slightly tightened in the holder, it can be used to clean up or produce a partial thread.



MF	BS 1127:1950	1.75 XP
HSS	R	Bright

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	M1.1	M1.2	M2.1	M2.2	K1.1
■12	■13	■14	■10	■9	◪8	■8	◪7	◪5	■7	■6	■6	◪5	■11
K1.2	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**K3.3**	**K5.1**	**K5.2**	**K5.3**	**N1.1**	**N1.2**	**N1.3**
■8	◪6	■11	■9	◪7	■10	■8	◪6	■10	■8	◪6	◪20	◪15	◪10
N2.1	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**N4.2**	**N4.3**					
◪10	◪9	◪6	■11	◪6	◪3	◪11	◪4	◪4					

Product	TD [mm]	TP [mm]	BD [inch]	OAL [inch]
F310M3X.35X13/16	3.000	0.35	13/16	1/4
F310M4X.5X13/16	4.000	0.50	13/16	1/4
F310M4X.75X13/16	4.000	0.75	13/16	1/4
F310M5X.5X13/16	5.000	0.50	13/16	1/4
F310M5X.9X13/16	5.000	0.90	13/16	1/4
F310M6X.75X13/16	6.000	0.75	13/16	1/4
F310M8X.75X1	8.000	0.75	1″	3/8
F310M8X1.0X1	8.000	1.00	1″	3/8
F310M9X1.0X1	9.000	1.00	1″	3/8
F310M10X.75X1	10.000	0.75	1″	3/8
F310M10X1.0X1	10.000	1.00	1″	3/8
F310M10X1.25X1	10.000	1.25	1″	3/8
F310M10X1.25X1.5/16	10.000	1.25	1.5/16	7/16
F310M12X1.0X1.5/16	12.000	1.00	1.5/16	7/16
F310M12X1.25X1.5/16	12.000	1.25	1.5/16	7/16

Product	TD [mm]	TP [mm]	BD [inch]	OAL [inch]
F310M12X1.5X1.5/16	12.000	1.50	1.5/16	7/16
F310M14X1.25X1.5/16	14.000	1.25	1.5/16	7/16
F310M14X1.5X1.5/16	14.000	1.50	1.5/16	7/16
F310M16X1.0X1.1/2	16.000	1.00	1.1/2	1/2
F310M16X1.5X1.1/2	16.000	1.50	1.1/2	1/2
F310M18X1.5X1.1/2	18.000	1.50	1.1/2	1/2
F310M20X1.0X1.1/2	20.000	1.00	1.1/2	1/2
F310M20X1.5X2	20.000	1.50	2″	5/8
F310M20X2.0X1.1/2	20.000	2.00	1.1/2	1/2
F310M22X1.5X2	22.000	1.50	2″	5/8
F310M24X1.5X2	24.000	1.50	2″	5/8
F310M24X2.0X2	24.000	2.00	2″	5/8
F310M25X1.5X2	25.000	1.50	2″	5/8
F310M27X2.0X2.1/4	27.000	2.00	2.1/4	11/16
F310M30X2.0X2.1/4	30.000	2.00	2.1/4	11/16

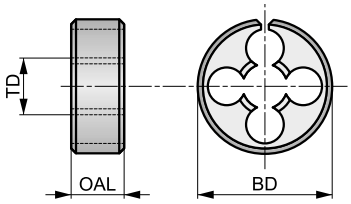
F320

DORMER



HSS Adjustable Split Hand Die, UNC, Right Hand

Split die to produce external thread by hand in multiple passes, adjusting each pass. By tightening the die stock holder, different classes of thread fit can be achieved - tight, regular or loose fit. Slightly tightened in the holder it can be used to clean up or produce a partial thread.



UNC	BS 1127:1950	1.75 XP
HSS	R	Bright

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	M1.1	M1.2	M2.1	M2.2	K1.1
■12	■13	■14	■10	■9	◪8	■8	◪7	◪5	■7	■6	■6	◪5	■11
K1.2	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**K3.3**	**K5.1**	**K5.2**	**K5.3**	**N1.1**	**N1.2**	**N1.3**
■8	◪6	■11	■9	◪7	■10	■8	◪6	■10	■8	◪6	◪20	◪15	◪10
N2.1	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**N4.2**	**N4.3**					
◪10	◪9	◪6	■11	◪6	◪3	◪11	◪4	◪4					

Products from this series are also available in set with taps. Please see L120.

Product	TDZ	TPI	TD [mm]	BD [inch]	OAL [inch]
F3204-40X13/16	4	40	2.850	13/16	1/4
F3205-40X13/16	5	40	3.180	13/16	1/4
F3206-32X13/16	6	32	3.510	13/16	1/4
F3208-32X13/16	8	32	4.170	13/16	1/4
F3208-32X1	8	32	4.170	1″	3/8
F32010-24X13/16	10	24	4.830	13/16	1/4
F32010-24X1	10	24	4.830	1″	3/8
F32012-24X13/16	12	24	5.490	13/16	1/4
F3201/4X13/16	1/4	20	6.350	13/16	1/4
F3201/4X1	1/4	20	6.350	1″	3/8
F3201/4X1.5/16	1/4	20	6.350	1.5/16	7/16
F3201/4X1.1/2	1/4	20	6.350	1.1/2	1/2
F3205/16X1	5/16	18	7.940	1″	3/8
F3205/16X1.1/2	5/16	18	7.940	1.1/2	1/2
F3203/8X1	3/8	16	9.530	1″	3/8
F3203/8X1.5/16	3/8	16	9.530	1.5/16	7/16

Product	TDZ	TPI	TD [mm]	BD [inch]	OAL [inch]
F3203/8X1.1/2	3/8	16	9.530	1.1/2	1/2
F3207/16X1.5/16	7/16	14	11.110	1.5/16	7/16
F3207/16X1.1/2	7/16	14	11.110	1.1/2	1/2
F3201/2X1.5/16	1/2	13	12.700	1.5/16	7/16
F3201/2X1.1/2	1/2	13	12.700	1.1/2	1/2
F3201/2X2	1/2	13	12.700	2″	5/8
F3209/16X1.1/2	9/16	12	14.290	1.1/2	1/2
F3205/8X1.1/2	5/8	11	15.880	1.1/2	1/2
F3205/8X2	5/8	11	15.880	2″	5/8
F3203/4X1.1/2	3/4	10	19.050	1.1/2	1/2
F3203/4X2	3/4	10	19.050	2″	5/8
F3207/8X2	7/8	9	22.230	2″	5/8
F3201X2	1″	8	25.400	2″	5/8
F3201.1/8X3	1.1/8	7	28.580	3″	7/8
F3201.1/4X3	1.1/4	7	31.750	3″	7/8

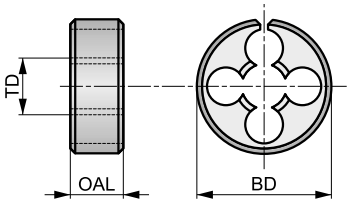
F330

DORMER



HSS Adjustable Split Hand Die, UNF, Right Hand

Split die to produce external thread by hand in multiple passes, adjusting each pass. By tightening the die stock holder, different classes of thread fit can be achieved - tight, regular or loose fit. Slightly tightened in the holder it can be used to clean up or produce a partial thread.



UNF	BS 1127:1950	1.75 XP
HSS	R	Bright

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	M1.1	M1.2	M2.2	M2.2	K1.1
■12	■13	■14	■10	■9	◪8	■8	◪7	◪5	■7	■6	■6	◪5	■11
K1.2	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**K3.3**	**K5.1**	**K5.2**	**K5.3**	**N1.1**	**N1.2**	**N1.3**
■8	◪6	■11	■9	◪7	■10	■8	◪6	■10	■8	◪6	◪20	◪15	◪10
N2.1	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**N4.2**	**N4.3**					
◪10	◪9	◪6	■11	◪6	◪3	◪11	◪4	◪4					

Products from this series are also available in set with taps. Please see L120.

Product	TDZ	TPI	TD [mm]	BD [inch]	OAL [inch]
F3304-48X13/16	4	48	2.850	13/16	1/4
F3305-44X13/16	5	44	3.180	13/16	1/4
F3306-40X13/16	6	40	3.510	13/16	1/4
F3308-36X13/16	8	36	4.170	13/16	1/4
F33010-32X13/16	10	32	4.830	13/16	1/4
F33010-32X1	10	32	4.830	1″	3/8
F33012-28X13/16	12	28	5.490	13/16	1/4
F3301/4X13/16	1/4	28	6.350	13/16	1/4
F3301/4X1	1/4	28	6.350	1″	3/8
F3301/4X1.1/2	1/4	28	6.350	1.1/2	1/2
F3305/16X1	5/16	24	7.940	1″	3/8
F3305/16X1.5/16	5/16	24	7.940	1.5/16	7/16
F3305/16X1.1/2	5/16	24	7.940	1.1/2	1/2
F3303/8X1	3/8	24	9.530	1″	3/8
F3303/8X1.5/16	3/8	24	9.530	1.5/16	7/16
F3303/8X1.1/2	3/8	24	9.530	1.1/2	1/2

Product	TDZ	TPI	TD [mm]	BD [inch]	OAL [inch]
F3307/16X1	7/16	20	11.110	1″	3/8
F3307/16X1.5/16	7/16	20	11.110	1.5/16	7/16
F3307/16X1.1/2	7/16	20	11.110	1.1/2	1/2
F3301/2X1.5/16	1/2	20	12.700	1.5/16	7/16
F3301/2X1.1/2	1/2	20	12.700	1.1/2	1/2
F3309/16X1.5/16	9/16	18	14.290	1.5/16	7/16
F3309/16X1.1/2	9/16	18	14.290	1.1/2	1/2
F3305/8X1.1/2	5/8	18	15.880	1.1/2	1/2
F3305/8X2	5/8	18	15.880	2″	5/8
F3303/4X1.1/2	3/4	16	19.050	1.1/2	1/2
F3303/4X2	3/4	16	19.050	2″	5/8
F3307/8X2	7/8	14	22.230	2″	5/8
F3301X2	1″	12	25.400	2″	5/8
F3301.1/8X3	1.1/8	12	28.580	3″	7/8
F3301.1/4X3	1.1/4	12	31.750	3″	7/8
F3301.1/2X3	1.1/2	12	38.100	3″	7/8

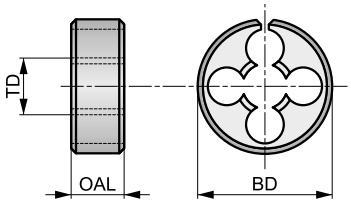
F370

DORMER



HSS Adjustable Split Hand Die, G(BSP) Right Hand

Split die to produce external thread by hand in multiple passes, adjusting each pass. By tightening the die stock holder, different classes of thread fit can be achieved - tight, regular or loose fit. Slightly tightened in the holder it can be used to clean up or produce a partial thread.



G	BS 1127:1950	1.75 XP
HSS	R	Bright

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	M1.1	M1.2	M2.1	M2.2	K1.1
■12	■13	■14	■10	■9	◪8	■8	◪7	◪5	■7	■6	■6	◪5	■11
K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3
■8	◪6	■11	■9	◪7	■10	■8	◪6	■10	■8	◪6	◪20	◪15	◪10
N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	N4.1	N4.2	N4.3					
◪10	◪9	◪6	■11	◪6	◪3	◪11	◪4	◪4					

Product	TDZ	TPI	TD [mm]	BD [inch]	OAL [inch]
F3701/8X1	1/8	28	9.730	1″	3/8
F3701/4X1.5/16	1/4	19	13.160	1.5/16	7/16
F3703/8X1.1/2	3/8	19	16.660	1.1/2	1/2
F3701/2X2	1/2	14	20.960	2″	5/8
F3705/8X2	5/8	14	22.910	2″	5/8
F3703/4X2	3/4	14	26.440	2″	5/8
F3707/8X2.1/4	7/8	14	30.200	2.1/4	11/16
F3701X2.1/4	1″	11	33.250	2.1/4	11/16
F3701.1/4X3	1.1/4	11	41.910	3″	7/8
F3701.1/2X4	1.1/2	11	47.800	4″	1″

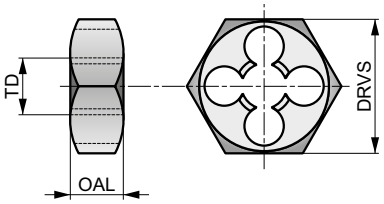
F202

DORMER



HSS Die Nut Metric, Right Hand

Hexagon die nut designed to repair or clean out damaged external threads by re-cutting the original thread form by hand. A wrench or spanner can be used to rotate the die nut around the outside of the bolt, thus it can be used in difficult to access locations.



M	DIN 382	6g
1.75 XP	HSS	R
Bright		

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	M1.1	M1.2	M2.1	M2.2	K1.1
■12	■13	■14	■10	■9	◪8	■8	◪7	◪5	■7	■6	■6	◪5	■11
K1.2	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**K3.3**	**K5.1**	**K5.2**	**K5.3**	**N1.1**	**N1.2**	**N1.3**
■8	◪6	■11	■9	◪7	■10	■8	◪6	■10	■8	◪6	◪20	◪15	◪10
N2.1	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**N4.2**	**N4.3**					
◪10	◪9	◪6	■11	◪6	◪3	◪11	◪4	◪4					

Product	TD [mm]	TP [mm]	DRVS [mm]	OAL [mm]
F202M3	3.000	0.50	19.00	5.0
F202M4	4.000	0.70	19.00	5.0
F202M5	5.000	0.80	19.00	7.0
F202M6	6.000	1.00	19.00	7.0
F202M7	7.000	1.00	22.00	9.0
F202M8	8.000	1.25	22.00	9.0
F202M10	10.000	1.50	27.00	11.0
F202M12	12.000	1.75	36.00	14.0
F202M14	14.000	2.00	36.00	14.0
F202M16	16.000	2.00	41.00	18.0
F202M18	18.000	2.50	41.00	18.0
F202M20	20.000	2.50	41.00	18.0
F202M22	22.000	2.50	50.00	22.0
F202M24	24.000	3.00	50.00	22.0
F202M27	27.000	3.00	60.00	25.0
F202M30	30.000	3.50	60.00	25.0
F202M36	36.000	4.00	60.00	25.0

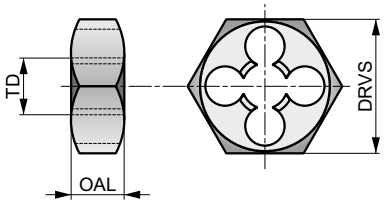
F302

DORMER



HSS Die Nut Metric, Right Hand

Hexagon die nut designed to repair or clean out damaged external threads by re-cutting the original thread form by hand. A wrench or spanner can be used to rotate the die nut around the outside of the bolt, thus it can be used in difficult to access locations.



M	BS 1127:1950	6g
1.75 XP	HSS	R
Bright		

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	M1.1	M1.2	M2.1	M2.2	K1.1
■12	■13	■14	■10	■9	◪8	■8	◪7	◪5	■7	■6	■6	◪5	■11
K1.2	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**K3.3**	**K5.1**	**K5.2**	**K5.3**	**N1.1**	**N1.2**	**N1.3**
■8	◪6	■11	■9	◪7	■10	■8	◪6	■10	■8	◪6	◪20	◪15	◪10
N2.1	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**N4.2**	**N4.3**					
◪10	◪9	◪6	■11	◪6	◪3	◪11	◪4	◪4					

Product	TD [mm]	TP [mm]	DRVS [inch]	OAL [inch]
F302M3	3.000	0.50	0.7100	1/4
F302M4	4.000	0.70	0.7100	1/4
F302M5	5.000	0.80	0.7100	1/4
F302M6	6.000	1.00	0.7100	1/4
F302M7	7.000	1.00	0.8200	5/16
F302M8	8.000	1.25	0.8200	5/16
F302M10	10.000	1.50	0.9200	3/8
F302M11	11.000	1.50	1.0100	7/16
F302M12	12.000	1.75	1.1000	1/2
F302M14	14.000	2.00	1.3000	5/8
F302M16	16.000	2.00	1.3000	5/8
F302M18	18.000	2.50	1.4800	11/16
F302M20	20.000	2.50	1.4800	11/16
F302M22	22.000	2.50	1.6700	13/16
F302M24	24.000	3.00	2.0500	15/16
F302M27	27.000	3.00	2.2200	1.1/16
F302M30	30.000	3.50	2.2200	1.1/16
F302M33	33.000	3.50	2.5800	1.1/8
F302M36	36.000	4.00	2.7600	1.1/4

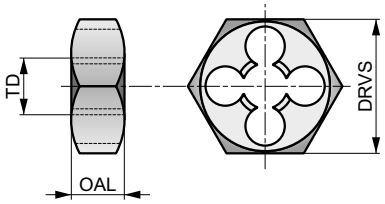
F312

DORMER



HSS Die Nut Metric Fine, Right Hand

Hexagon die nut designed to repair or clean out damaged external threads by re-cutting the original thread form by hand. A wrench or spanner can be used to rotate the die nut around the outside of the bolt, thus it can be used in difficult to access locations.



MF	BS 1127:1950	6g
1.75 XP	HSS	R
Bright		

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	M1.1	M1.2	M2.1	M2.2	K1.1
■12	■13	■14	■10	■9	◪8	■8	◪7	◪5	■7	■6	■6	◪5	■11

K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3
■8	◪6	■11	■9	◪7	■10	■8	◪6	■10	■8	◪6	◪20	◪15	◪10

N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	N4.1	N4.2	N4.3
◪10	◪9	◪6	■11	◪6	◪3	◪11	◪4	◪4

Product	TD [mm]	TP [mm]	DRVS [inch]	OAL [inch]
F312M8X.75	8.000	0.75	0.8200	5/16
F312M8X1.0	8.000	1.00	0.8200	5/16
F312M10X1.0	10.000	1.00	0.9200	3/8
F312M10X1.25	10.000	1.25	0.9200	3/8
F312M12X1.0	12.000	1.00	1.0100	7/16
F312M12X1.25	12.000	1.25	1.0100	7/16
F312M12X1.5	12.000	1.50	1.0100	7/16
F312M14X1.5	14.000	1.50	1.3000	5/8
F312M16X1.5	16.000	1.50	1.3000	5/8
F312M18X1.5	18.000	1.50	1.4800	11/16
F312M20X1.5	20.000	1.50	1.4800	11/16
F312M22X1.5	22.000	1.50	1.6700	13/16
F312M24X1.5	24.000	1.50	2.0500	15/16
F312M24X2.0	24.000	2.00	2.0500	15/16

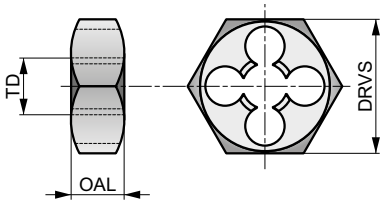
F272

DORMER



HSS Die Nut G(BSP) Right Hand

Hexagon die nut designed to repair or clean out damaged external threads by re-cutting the original thread form by hand. A wrench or spanner can be used to rotate the die nut around the outside of the bolt, thus it can be used in difficult to access locations.



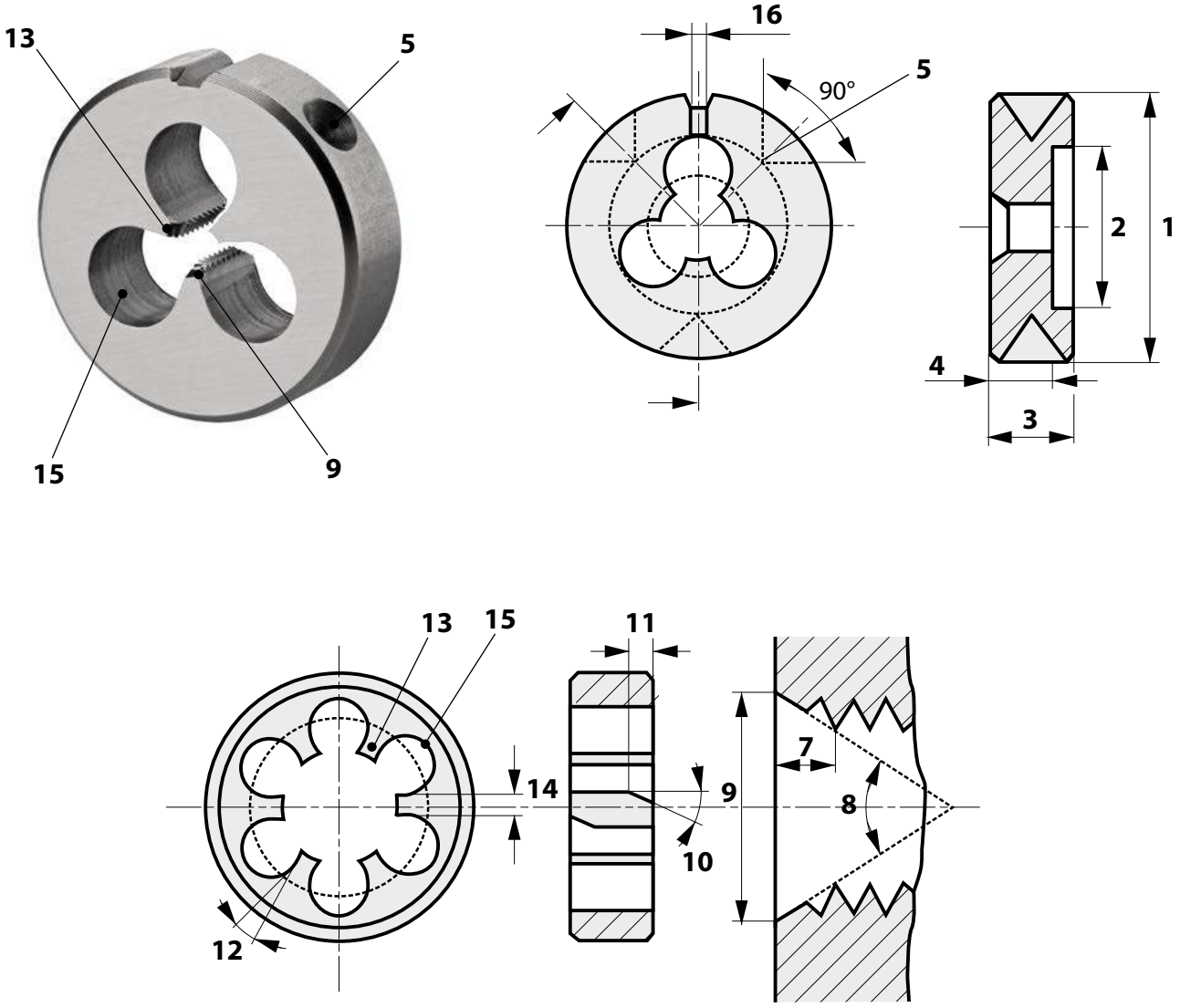
G	DIN 382	Class A
1.75 XP	HSS	R
Bright		

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	M1.1	M1.2	M2.1	M2.2	K1.1
■12	■13	■14	■10	■9	◪8	■8	◪7	◪5	■7	■6	■6	◪5	■11
K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3
■8	◪6	■11	■9	◪7	■10	■8	◪6	■10	■8	◪6	◪20	◪15	◪10
N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	N4.1	N4.2	N4.3					
◪10	◪9	◪6	■11	◪6	◪3	◪11	◪4	◪4					

Product	TDZ	TPI	TD [mm]	DRVS [mm]	OAL [mm]
F2721/8	1/8	28	9.730	27.00	11.0
F2721/4	1/4	19	13.160	36.00	10.0
F2723/8	3/8	19	16.660	41.00	14.0
F2721/2	1/2	14	20.960	41.00	14.0
F2723/4	3/4	14	26.440	60.00	18.0
F2721	1"	11	33.250	60.00	18.0
F2721.1/4	1.1/4	11	41.910	70.00	20.0
F2721.1/2	1.1/2	11	47.800	85.00	22.0

Nomenclature



1	Outside Diameter
2	Recess Diameter
3	Thickness
4	Thread Length
5	Conical Hole for Fixing Screw
6	Chamfer Angle
7	Chamfer Length
8	Chamfer Diameter

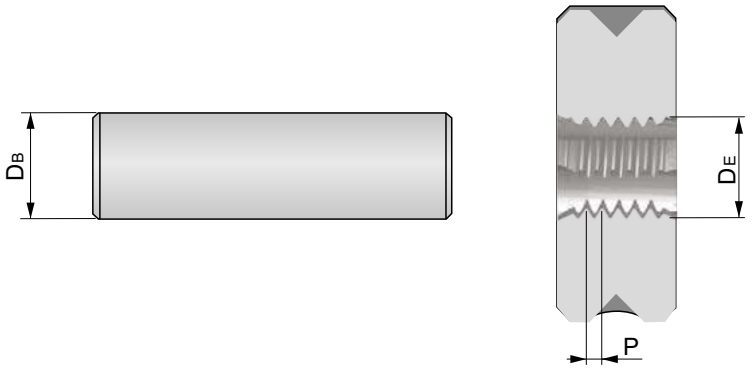
9	Gun-nose
10	Spiral Angle
11	Spiral Length
12	Rake Angle
13	Land
14	Width of Land
15	Clearance Hole
16	Split of Adjustment

Technical Tips on Threading with Dies

1. Before starting the die or dienut, chamfer the end of the bar at an angle of 45 degrees to eliminate sudden loading of the leading edges. Ensure the die or dienut is presented to the bolt squarely.
2. Make use of the large tolerances associated with the major diameter of the bolt, by reducing the diameter of the bar (see below). This will reduce the cutting force to a minimum.
3. Use the gun nose type of die, as this ensures the chips are directed away from the cutting area.
4. Ensure a good supply of the correct lubricant is aimed at the cutting area.
5. When adjusting split dies, avoid opening out as this will cause rubbing. Split dies may be closed down by approximately 0.15mm, by turning the adjustment screws equally. Pressure on one side of the die only may cause breakage.
6. Generally speaking, dienuts are used for reclaiming or cleaning out existing threads by hand. They tend to be of a more robust construction and should only be used in exceptional circumstances to cut a thread from solid.

Pre-machining Dimensions

The diameter of the bolt blank must be smaller than the max. external diameter of the screw thread.



$$D_B = D_E - (0.1 * P)$$

Trouble Shooting When Threading With Dies

Problem	Cause	Solution
Oversize / Undersize	Misalignment	Correct alignment, ensure cleanliness
	Incorrect axial feed rate	Ensure axial feed rate is controlled accurately
Poor finish	Incorrect rake angle for the material	Try alternative dies or special die
	Incorrect/lack of lubricant	See lubricants section
	Incorrect speed	Follow recommendations in Catalogue
	Bar diameter too large	Reduce to appropriate size
	Bar end not chamfered	Ensure bar end is chamfered
Chipping / Breakage	Wrong type of die	Follow recommendations in Catalogue
	Speed too high	Follow recommendations in Catalogue
	Bar diameter too large	Reduce to appropriate size
	Bar end not chamfered	Ensure bar end is chamfered
	Misalignment	Correct alignment, ensure cleanliness
Rapid wear	Incorrect/lack of lubricant	See lubricants section
	Speed too high	Follow recommendations in Catalogue
Built up edge	Incorrect/lack of lubricant	See section lubricants
	Bar diameter too large	Reduce to appropriate size
	Speed too low	Follow recommendations in Catalogue

CUTTING FLUIDS



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12	TAPS	INSTRUCTIONS
15	TAPS	SOLID CARBIDE TAPS
25	TAPS	MATERIAL SPECIFIC SHARK TAPS
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M200-1



M200 no. 1 Blue, Cutting Fluid for Heavy Machining

A high performance cutting oil for difficult operations, such as tapping, broaching and drilling by hand or with a pillar drill. For increased tool life and improved surface finishes. First choice recommendation for high strength steel, stainless steel and super alloys.

Product	Nr.
M2000.25NR.1BLUE	1/4 Ltr. 12x
M2001.0NR.1BLUE	1 Ltr.
M2005.0NR.1BLUE	5 Ltr.
M20020.0NR.1BLUE	20 Ltr.

M200-2



M200 no. 2 Red, Cutting Fluid for Non-Ferrous Metals

A neat oil for machining operations requiring chip removal in aluminium and its alloys. For lubrication and cooling to promote long tool life and ensure excellent surface finish. Low impact on the environment due to excellent anti-mist properties, high oxidation stability and low odours.

Product	Nr.
M2000.25NR.2RED	1/4 Ltr. 12x
M2001.0NR.2RED	1 Ltr.
M2005.0NR.2RED	5 Ltr.

M200-3



M200 no. 3 Green, Cutting Fluid for General Purpose Machining

A high performance cutting oil with extreme pressure (EP) additives to provide longer tool life. For general cutting or forming operations, such as tapping, broaching and drilling in steel or cast steel and stainless steel.

Product	Nr.
M2000.25NR.3GREEN	1/4 Ltr. 12x
M2001.0NR.3GREEN	1 Ltr.
M2005.0NR.3GREEN	5 Ltr.

GENERAL
TECHNICAL INFORMATION



📖 6		WMG & ISO 13399
📖 8	TAPS	INSTRUCTIONS
📖 16		SOLID CARBIDE TAPS
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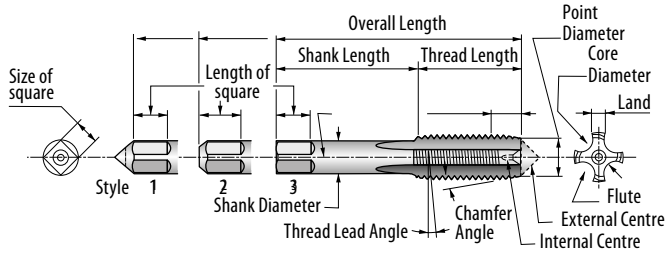
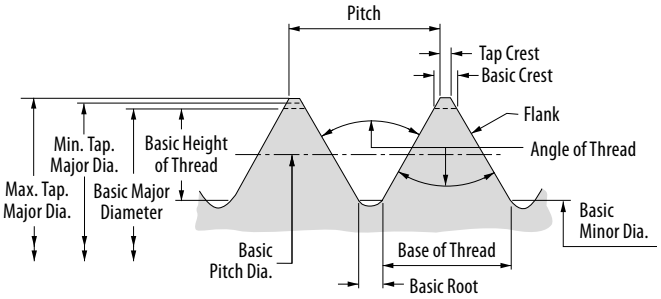
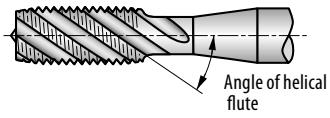
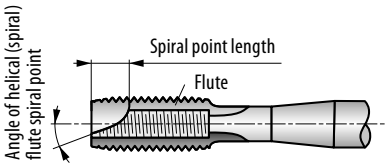
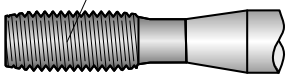
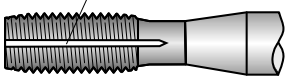












Allowance: The minimum clearance or maximum interference which is intended between mating parts.

Angle of Thread: The angle included between the flanks of a thread measured in an axial plane.

Back Taper: A slight taper on the threaded portion of the tap making the pitch diameter near the shank smaller than that at the chamfer.

Basic: The theoretical or nominal standard size from which all variations are made.

Chamfer: The tapered and relieved cutting teeth at the front end of the threaded section. Common types of chamfer are taper, 8 to 10 pitches long, plug, 3 to 5 pitches and bottoming, 1 to 2 pitches.

Crest: The top surface joining the two sides or flanks of a thread.

Cutting Face: The leading side of the land.

Flute: The longitudinal channels formed on a tap to create cutting edges on the thread profile.

Heel: The following side of the land.

Height of Thread: In profile, distance between crest and bottom section of thread measured normal to the axis.

Hook Face: A concave cutting face of the land. This may be varied for different materials and conditions.

Interrupted Thread: Alternate teeth are removed in the thread helix on a tap; usually restricted to those having an odd number of flutes.

Land: One of the threaded sections between the flutes of a tap.

Lead of Thread: The distance a screw thread advances axially in one turn.

Major Diameter: The largest diameter of the screw or nut on a straight screw thread.

Minor Diameter: The smallest diameter of the screw or nut on a straight screw thread.

Neck: The reduced diameter, on some taps, between the threaded portion and the shank.

Pitch: The distance from a point on one thread to a corresponding point on the next thread, measured parallel to the axis.

Pitch Diameter: On a straight screw thread, the diameter of an imaginary cylinder where the width of the thread and the width of the space between threads is equal.

Point Diameter: The diameter at the leading end of the chamfered portion.

Radial: The straight face of a land, the plane of which passes through the axis of the tap.

Rake: The angle of the cutting face of the land in relation to an axial plane intersecting the cutting face at the major diameter.

Relief: The removal of metal behind the cutting edge to provide clearance between the part being threaded and a portion of the threaded land. Also, see back taper.

CHAMFER RELIEF: The gradual decrease in land height from cutting edge to heel on the chamfered portion of the tap land to provide radial clearance for the cutting edge.

CONCENTRIC RELIEF: Radial relief in the thread form starting at the back of a concentric margin.

ECCENTRIC THREAD RELIEF: Radial relief in the thread form starting at the cutting edge and continuing to the heel.

Root: The bottom surface joining the flanks of two adjacent threads.

Side or flank of thread: The surface of the thread which connects the crest with the root.

Shank: The portion of the tap by which it is held and driven.

Spiral Point: An oblique cutting edge ground into the lands to provide a shear cutting action on the first few threads.

Square: The squared end of the tap shank.

Thread: The helical formed tooth of the tap which produces the thread in a tapped hole.

Thread Lead Angle: The angle made by the helix of the thread at the pitch diameter, with a plane perpendicular to the axis.

Threads Per Inch: The number of threads in one inch of length.

Thread: **SINGLE:** A thread in which lead is equal to pitch.

DOUBLE: A thread in which lead is equal to twice the pitch.

TRIPLE: A thread in which lead is equal to triple the pitch.

General hints on tapping

The success of any tapping operation depends on a number of factors, all of which affect the quality of the finished product.

1. Select the correct design of tap for the component material and type of hole, i.e. through or blind, from the Materials Classification chart.
2. Ensure the component is securely clamped – lateral movement may cause tap breakage or poor quality threads.
3. Select the correct size of drill from the relevant catalogue page. Always ensure that work hardening of the component material is kept to a minimum.
4. Select the correct cutting speed as shown on the catalogue product page.
5. Use appropriate cutting fluid for correct application.
6. In NC applications ensure that the feed value chosen for the program is correct. When using a tapping attachment, 95% to 97% of the pitch is recommended to allow the tap to generate its own pitch.
7. Where possible, hold the tap in a good quality torque limiting tapping attachment, which ensures free axial movement of the tap and presents it squarely to the hole. It also protects the tap from breakage if accidentally 'bottomed' in a blind hole.
8. Ensure smooth entry of the tap into the hole, as an uneven feed may cause 'bell mouthing'.

Tap tolerance vs tolerance on internal thread (nut)

Tolerance class, Tap			Tolerance, Internal thread (Nut)					Application
ISO	DIN	ANSI BS						
ISO 1	4 H	3 B	4 H	5 H	–	–	–	Fit without allowance
ISO 2	6 H	2 B	4 G	5 G	6 H	–	–	Normal fit
ISO 3	6 G	1 B	–	–	6 G	7 H	8 H	Fit with large allowance
–	7 G	–	–	–	–	7 G	8 G	Loose fit for following treatment or coating

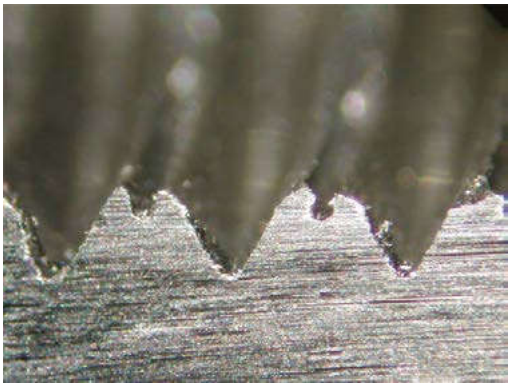
Tap Geometries & Applications

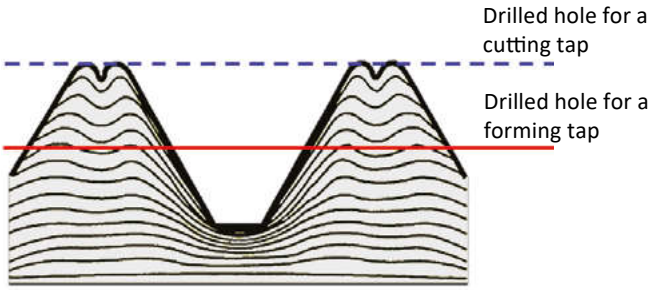
Description	Chips
Taps with straight flutes Straight flutes are the most commonly used type of tap. Suitable for use on most materials, mainly short chipping steel and cast iron, they form the basis of the program.	
Taps with interrupted thread The interrupted thread ensures less friction and therefore less resistance, which is particularly important when threading material which is resilient and difficult to machine (e.g. aluminium, bronze). It is also easier for lubricant to penetrate to the cutting edges, thus helping to minimize the torque generated	
Spiral point taps The tap has a straight fairly shallow flute and is often referred to as a gun nose or spiral point tap. The gun nose or spiral point is designed to drive the chips forward. The relatively shallow flutes ensure that the sectional strength is maximised. They also act to allow lubricant to reach the cutting edges. This type of tap is recommended for threading through holes.	
Nut taps These taps are generally used to thread nuts but can be used also on deep through holes. They have a shank diameter smaller than the nominal and a longer overall length, because their function is to accumulate nuts. They are used on special machines designed to thread huge amounts of nuts. They can work in steel and stainless steel. The first serial tap has a very long chamfer, in order to spread the cutting load on almost two thirds of the thread length.	

Description	Chips
Taps with flutes only on the chamfer lead The cutting part of the tap is formed by gun nosing in the same manner as for a spiral point tap, the function being to drive the chips forward ahead of the cutting edges. This design is extremely rigid which facilitates good machining results. However, the short length of the gun nosing limits its application to a depth of hole less than about 1.5 x Ø.	
Taps with spiral flutes Taps with spiral flutes are intended primarily for threading in blind holes. The helical flute transports the chips back away from the cutting edges and out of the hole, thus avoiding packing of chips in the flutes or at the bottom of the hole. In this way, danger of breaking the tap or damaging the thread is minimised.	
Cold forming taps Cold forming taps differ from cutting taps in that the thread is produced by plastic deformation of the component material rather than by the traditional cutting action. This means that no chips are produced by their action. The application range is materials with good formability. Tensile strength (Rm) should not exceed 1200 N/mm^2 and the elongation factor (A_5) should not be less than 10%. Cold forming taps without flutes are suitable for normal machining and are especially suitable when vertically tapping blind holes. They are also available with through coolant.	
Through coolant taps The performance of taps with through coolant holes is higher than the same taps used with external lubrication. These kinds of taps allow better evacuation of the chip, which is transported away from the cutting area itself. Wear on the cutting edge is reduced, since the cooling effect on the cutting zone is higher than the heat generation. Lubrication can be oil, emulsion or air pressurised with oil mist. Working pressure not less then 15 bar is required, but good results can be obtained with minimal lubrication.	

Flow Of Material When Forming A Thread

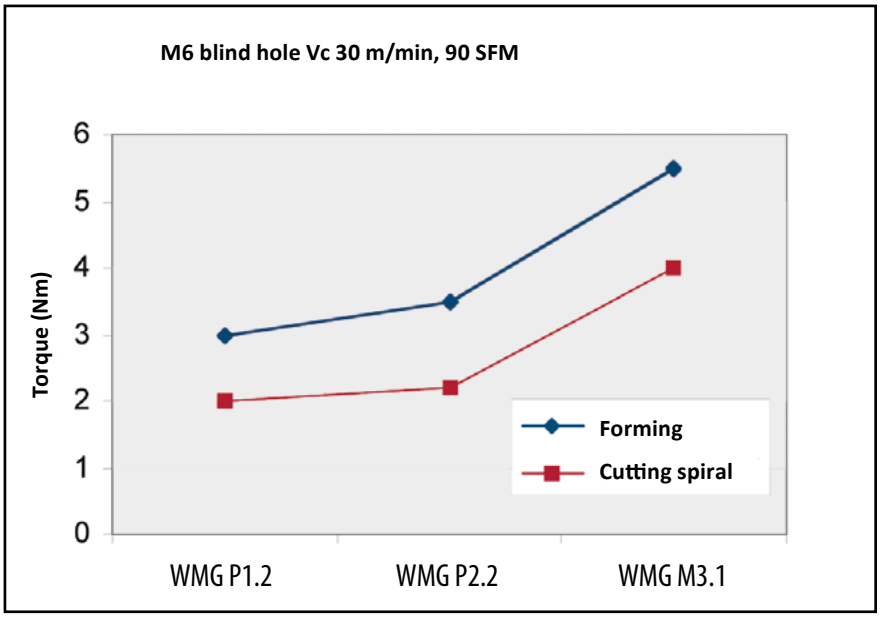
The tapping hole size depends upon the material being drilled, the cutting conditions selected and the condition of the equipment being used. If material is pushed up at the thread entry by the tap and/or the life of the tap is too short, select a slightly larger drill diameter. If on the other hand the profile of the thread formed is insufficient, then select a slightly smaller drill diameter.





Section of thread obtained by forming tap on steel C45

Cold forming taps require more power on the spindle, compared to a cutting tap of the same size, since it generates higher torque.



Torque comparison between forming and cutting taps in different material groups.

Trouble Shooting When Tapping

Problem	Cause	Remedy
Oversize	Incorrect tolerance	Choose a tap with lower thread tolerance
	Incorrect axial feed rate	Reduce feed rate by 5-10% or increase compression of tap holder
	Wrong type of tap for application	Use spiral point for through hole or spiral flute for blind hole. Use coated tool to prevent built up edge. Check Catalogue or Product Selector for correct tool alternative
	Tap not centered on the hole	Check tap holder and position tap centre on the hole
	Lack of lubrication	Use good lubrication in order to prevent built up edge. See lubricant section in technical handbook
	Tap speed too slow	Follow recommendation in Catalogue / Product Selector
Undersize	Wrong type of tap for application	Use spiral point for through hole or spiral flute for blind hole. Use coated tool to prevent built up edge. Use tap with higher rake angle. Check Catalogue or Product Selector for correct tool alternative
	Incorrect tolerance	Choose a tap with higher tolerance, especially on material with low oversize tendency, such as cast iron, stainless steel
	Incorrect or lack of lubricant	Use good lubrication in order to prevent chip blockage inside the hole. See lubricant section in technical handbook
	Tap drill hole too small	Increase drill diameter to the maximum value. Check tapping size drill
	Material closing in after tapping	See recommendation in Catalogue / Product Selector for correct tool alternative
Chipping	Wrong type of tap for application	Choose a tap with lower rake angle. Choose a tap with longer chamfer. Use spiral point taps for through hole and spiral flute for blind holes, in order to avoid chip blockage. Check Catalogue or Product Selector for correct tool alternative
	Incorrect or lack of lubricant	Use good lubrication in order to prevent built up edge. See lubricant section in technical handbook
	Taps hit bottom of hole	Increase depth of drilling or decrease depth of tapping
	Work hardening surface	Reduce speed, use coated tool, use good lubrication. See section for machining of stainless steel in technical handbook
	Swarf trapping on reversal	Avoid sudden return of tap on reversal motion
	Chamfer hits hole entrance	Check axial position and reduce axial error of tap point on hole centre
	Tap drill hole too small	Increase drill diameter to maximum value. Check tapping size drill

Trouble Shooting When Tapping

Problem	Cause	Remedy
Breakage	Tap worn out	Use a new tap or regrind the old one
	Lack of lubricant	Use good lubrication in order to prevent built up edge and chip blockage. See lubricant section in technical handbook
	Taps hit bottom of hole	Increase depth of drilling or decrease depth of tapping
	Tap speed too high	Reduce cutting speed. Follow recommendation in Catalogue / Product Selector
	Work hardening surface	Reduce speed. Use coated tool Use good lubrication. See section for machining of stainless steel in technical handbook
	Tap drill hole too small	Increase drill diameter up to maximum value. See tap drill tables
	Too high torque	Use tapping attachment with torque adjustment clutch
	Material closing in after tapping	See recommendation in Catalogue / Product Selector for correct tool alternative
Rapid wear	Wrong type of tap for application	Use tap with lower rake angle and/or higher relief and/or longer chamfer. Use coated tool. Check Catalogue or Product Selector for correct tool alternative
	Lack of lubricant	Use good lubrication in order to prevent built up edge and thermal stress on cutting edge. See lubricant section in technical handbook
	Tap speed too high	Reduce cutting speed. Follow recommendation in Catalogue / Product Selector
Built up edge	Wrong type of tap for application	Use tap with lower rake angle and/or higher relief. Check Catalogue or Product Selector for correct tool alternative
	Lack of lubricant	Use good lubrication in order to prevent built up edge. See lubricant section in technical handbook
	Surface treatment not suitable	Choose a tap with the recommended surface treatment
	Tap speed too low	Follow recommendation in Catalogue / Product Selector

NOTES

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SIMPLY RELIABLE

As a professional you can judge the quality of work by just looking at the chip. Our chip is a clean and uncomplicated shape that in itself tells a story. It is a clear and consistent signal and that's why we use it as a symbol for being **Simply Reliable**.

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