INTRODUCTION

The use of hardened materials in industrial processes is becoming increasingly common, creating a greater need for new and improved cutting tools capable of working in extreme conditions.
Dormer's new range of solid carbide taps is a high performing, comprehensive program designed specifically for machining various types of hardened steel and other difficult materials.

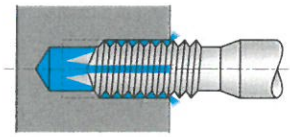
FEATURES AND BENEFITS

- High performance and productivity in a wide range of applications including hardened materials up to 63 HRC
- Ideal for mass production with cutting speeds up to 3 times higher when compared to HSS-E taps
- Fewer tool changes resulting in optimum machine output due to long tool life
- Highly stable tool design means less risk of tap breakage and optimum process security

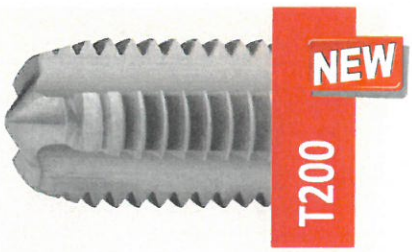
COOLING AND LUBRICATION

Internal coolant with axial coolant outlet:

- Thread depths up to 3xD
- Improved tool life
- Optimum chip evacuation when threading short chipping materials
- Horizontal and vertical blind hole machining



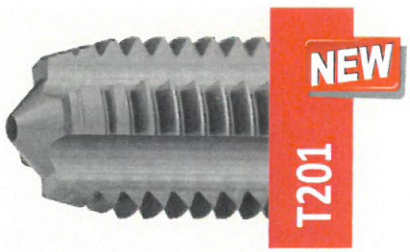
TAP STYLES



T200

First choice for **hardened steel** 49-55 HRC

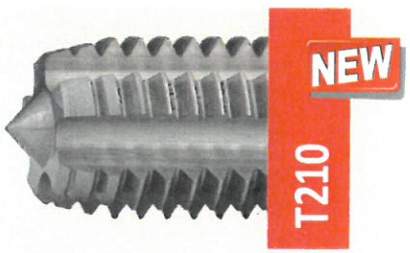
- For short-chipping materials
- TiCN coating for high strength and hardness to resist abrasive wear
- Threading depths up to 2xD
- Chamfer form C for blind and through holes



T201

First choice for **cast iron and aluminium alloys** with >10% silicon content and hardness up to 47 HRC

- For short-chipping materials
- Super-B TiAlN-WC/C coating for improved wear resistance and low friction in tough and abrasive materials
- Internal coolant with axial outlet
- Threading depths up to 2.5xD
- Chamfer form C for blind holes



T210

First choice for **hardened steel 55-63 HRC**

- For short-chipping materials
- TiCN coating for high strength and hardness to resist abrasive wear
- Threading depths up to 2xD
- Chamfer form C for blind and through holes

MATERIAL

Manufactured from premium grade micro grain Solid Carbide for:

- Long tool life and extremely high tapping speeds
- Threading in hardened material up to 63 HRC
- High wear resistance to abrasive materials

SURFACE TREATMENT

Titanium Carbon Nitride (TiCN) coating for:

- Alloyed and unalloyed steels
- Highly suited to solid carbide tools
- Wear resistant to abrasive materials

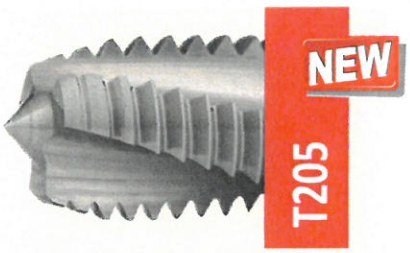
Super-B (TiAlN+WC/C) coating for:

- Cast iron and aluminium alloys with high silica content
- Ideal for higher speed and feeds
- Can be used for both wet and dry machining

GEOMETRY AND CHAMFER

The range features a variety of styles including straight flute, spiral flute and a forming tap in order to offer dependable options in numerous applications.

- Improved chamfer geometry for better running-in and even wear behaviour
- Special geometries for specific applications:
  - T205/T206 features a 15° helix angle suited for both short and long-chipping materials
  - T210 with increased number of flutes for better chip breaking and longer chamfer for increased tool life
  - T215 forming tap features a thread profile with optimized polygonal form which generates low torque



T205

First choice for **ductile iron and aluminium alloys** with >10% silicon content and hardness up to 47 HRC

- For long and short-chipping materials
- Bright finish for better chip flow
- Threading depths up to 2xD
- Chamfer form C for blind holes



T206

First choice for **ductile iron and aluminium alloys** with >10% silicon content and hardness up to 47 HRC

- For long and short-chipping materials
- Bright finish for better chip flow
- Internal coolant with axial outlet
- Threading depths up to 2.5xD
- Chamfer form C for blind holes



T215

Forming tap, first choice for **wide range of materials** with hardness up to 36 HRC

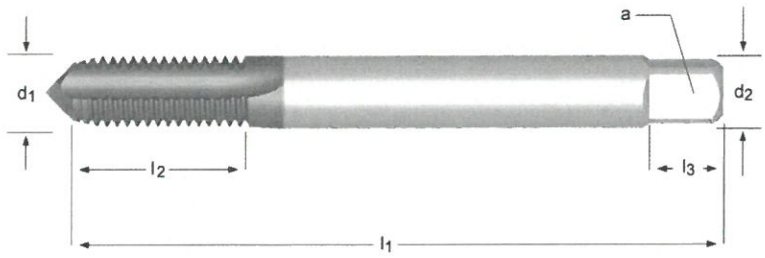
- **Extremely high productivity** and very long tool life in ductile materials
- TiCN coating for high strength and hardness to resist abrasive wear
- Threading depths up to 3xD
- Chamfer form C for blind and through holes

T200 • M Machine Tap Straight Flute

T200 ▪ 1.7

• 1.8 3.1 3.2 6.4 7.4 8.2 8.3 10.1

T200 | M | DIN 371≤10 376≥12 | 6H | 2XD | HM | C 2-3 | TiCN





M3 - M12

M	P mm	l_1 mm	l_2 mm	d_2 Ø mm	⊠ a mm	l_3 mm	z	↔	l_4 mm	T200
3	0.50	56	10	3.5	2.7	6	3	2.6	-	T200M3
4	0.70	63	13	4.5	3.4	6	3	3.4	-	T200M4
5	0.80	70	16	6.0	4.9	8	3	4.3	-	T200M5
6	1.00	80	19	6.0	4.9	8	3	5.1	30	T200M6
8	1.25	90	22	8.0	6.2	9	3	6.9	35	T200M8
10	1.50	100	24	10.0	8.0	11	3	8.7	39	T200M10
12	1.75	110	23	9.0	7.0	10	3	10.4	-	T200M12