

# HSS



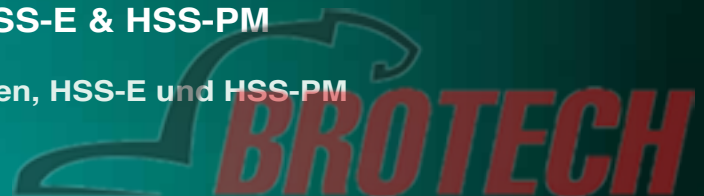
Leading Through Innovation



# COLD FORMING TAPS

## INNENGEWINDEFORMER

- Tapping by Forming Soft Materials, HSS-E & HSS-PM
- Zum Gewindedrücken in weichen Werkstoffen, HSS-E und HSS-PM

















# SELECTION GUIDE

## COLD FORMING TAPS

Tapping by Forming Soft Materials, HSS-E & HSS-PM

### COLD FORMING TAPS

◆ SYNCHRO TYPE

EDP No.	MODEL	Tool Material	Standard	Work Material	Dimensions	Tolerance	Chamfer	Thread Depth	Surface Treatment	PAGE
◆ TTS37		HSS-PM	M	GV	DIN 371/376	6HX	C	3.0D	TiN	615
TQ703		HSS-PM	M	GV	DIN 371/376	6HX	C	3.0D	Vap	616
TQ723		HSS-PM	M	GV	DIN 371/376	6HX	C	3.0D	Vap	617
TE703		HSS-E	M	GV	DIN 371/376	6HX	C	3.0D	NI	618
TE713		HSS-E	M	GV	DIN 371/376	6GX	C	3.0D	NI	619
TE723		HSS-E	M	GV	DIN 371/376	6HX	C	3.0D	NI	620
TD713		HSS-E	M	GV	DIN 371/376	6GX	C	3.0D	TiN	621
TD723		HSS-E	M	GV	DIN 371/376	6HX	C	3.0D	TiN	622
TD703		HSS-E	M	GV	DIN 371/376	6HX	C	3.0D	TiN	623
TY703		HSS-E	M	GV	DIN 371/376	6HX	C	3.0D	TiAlN	624
TE733		HSS-E	MF	GV	DIN 374	6HX	C	3.0D	NI	625
TD733		HSS-E	MF	GV	DIN 374	6HX	C	3.0D	TiN	626
TE704		HSS-E	UNC	GV	DIN 371/376	2BX	C	3.0D	NI	627
TD704		HSS-E	UNC	GV	DIN 371/376	2BX	C	3.0D	TiN	628

### M ISO metric coarse threads DIN 13

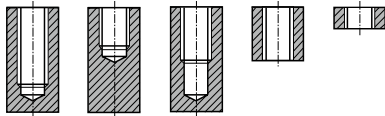
- Metrisches ISO-Gewinde DIN 13
- ISO MÉTRIQUE DIN13
- ISO Metrico passo grosso DIN 13

► Suitable for high speed machining and high precision threads

► Geeignet für die High-Speed-Bearbeitung (HSC) und hoher Gewinde-Präzision

Hole type

3.0×D



DIN 371/376

**Synchro Type**

Applicable to 2-3 times faster cutting speed than minimum general GS Taps cutting speeds

Material groups **GV**

HSS-PM

DIN 371/376

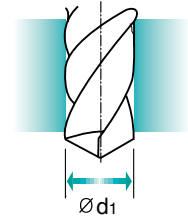
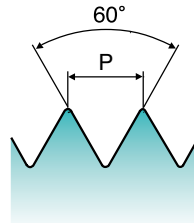
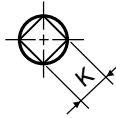
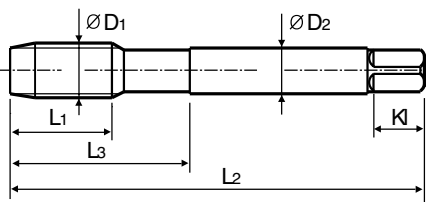
6HX

60°

C

TiN

Machine taps  
Maschinengewindebohrer



Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	Tapping Drill Diameter
∅D1	P	TiN	L1	L2	L3	∅D2	K	KI	∅d1
M3	× 0.5	<b>TTS37206</b>	5	56	18	3.5	2.7	6	2.8
M4	× 0.7	<b>TTS37246</b>	7	63	21	4.5	3.4	6	3.7
M5	× 0.8	<b>TTS37286</b>	8	70	25	6	4.9	8	4.65
M6	× 1	<b>TTS37316</b>	10	80	30	6	4.9	8	5.55
M8	× 1.25	<b>TTS37366</b>	13	90	35	8	6.2	9	7.4
M10	× 1.5	<b>TTS37426</b>	15	100	39	10	8	11	9.3
M12	× 1.75	<b>TTS37506</b>	18	110	44	9	7	10	11.2

► DIN371 (M3~M10) and DIN376 (M11~M12)

THREAD MILLS

CARBIDE TAPS

PRIME TAPS

COMBO TAPS

SPIRAL FLUTE TAPS

SPIRAL POINT TAPS

STRAIGHT FLUTE TAPS

COLD FORMING TAPS

NUT TAPS

STI TAPS

HAND TAPS

PIPE TAPS

TECHNICAL DATA

Unit : N/mm<sup>2</sup>

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
◎	◎	◎	◎			◎	◎							
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
				◎		○		◎	◎	◎	○			

# YG COLD FORMING TAPS

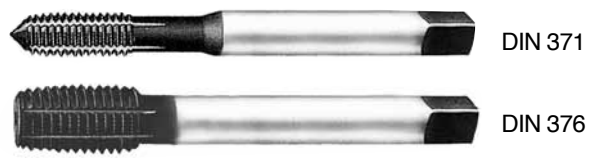
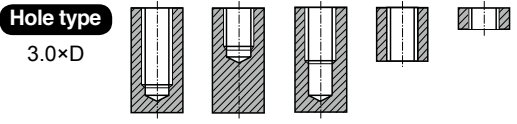
## TQ703 SERIES

### M ISO metric coarse threads DIN 13

- Metrisches ISO-Gewinde DIN 13
- ISO MÉTRIQUE DIN13
- ISO Metrico passo grosso DIN 13

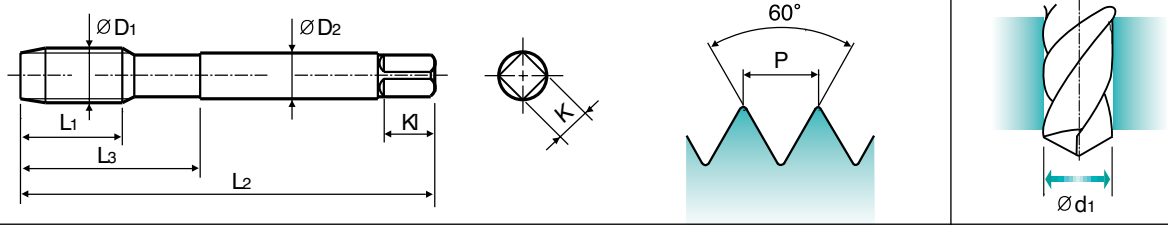
► Suitable for threading soft materials with at least 8-10% elongation in the best substrate.  
 ► The pre-drilling holes are bigger than normal sized holes.

► Aus bestem Werkstoff geeignet zum Gewindeformen weicher Werkstoffe mit mindestens 8-10% Dehnung.  
 ► Die Kernlochbohrungen sind größer als normale Kernlöcher.



**Material groups** **GV** **HSS-PM** **DIN 371/376** **6HX** **60°** **C** **Vap**

Cold forming taps with oil grooves  
 Gewindeformer mit Schmiernuten



Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	Tapping Drill Diameter
ØD1	P	Vap	L1	L2	L3	ØD2	K	Kl	Ød1
M2	× 0.4	<b>TQ703136</b>	8	45	13	2.8	2.1	5	1.83
M2.2	× 0.45	<b>TQ703156</b>	8	45	13	2.8	2.1	5	2
*M2.3	× 0.4	<b>TQ703196</b>	8	45	13	2.8	2.1	5	2.1
M2.5	× 0.45	<b>TQ703176</b>	9	50	15	2.8	2.1	5	2.3
*M2.6	× 0.45	<b>TQ703496</b>	9	50	15	2.8	2.1	5	2.4
M3	× 0.5	<b>TQ703206</b>	11	56	18	3.5	2.7	6	2.8
M3.5	× 0.6	<b>TQ703226</b>	12	56	20	4	3	6	3.25
M4	× 0.7	<b>TQ703246</b>	13	63	21	4.5	3.4	6	3.7
M4.5	× 0.75	<b>TQ703266</b>	14	70	25	6	4.9	8	4.15
M5	× 0.8	<b>TQ703286</b>	15	70	25	6	4.9	8	4.65
M6	× 1	<b>TQ703316</b>	17	80	30	6	4.9	8	5.55
M7	× 1	<b>TQ703346</b>	17	80	30	7	5.5	8	6.55
M8	× 1.25	<b>TQ703366</b>	20	90	35	8	6.2	9	7.4
M9	× 1.25	<b>TQ703396</b>	20	90	35	9	7	10	8.4
M10	× 1.5	<b>TQ703426</b>	22	100	39	10	8	11	9.3
M11	× 1.5	<b>TQ703466</b>	22	100	40	8	6.2	9	10.3
M12	× 1.75	<b>TQ703506</b>	24	110	44	9	7	10	11.2
M14	× 2	<b>TQ703546</b>	26	110	44	11	9	12	13
M16	× 2	<b>TQ703606</b>	27	110	44	12	9	12	15
M18	× 2.5	<b>TQ703656</b>	30	125	50	14	11	14	16.8
M20	× 2.5	<b>TQ703706</b>	32	140	54	16	12	15	18.8

► DIN 371(M2~M10) and DIN 376(M11~M20)  
 ► \* DIN profile not ISO

Unit : N/mm<sup>2</sup> ◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermoset	Plastic Thermoset	Plastic FRP
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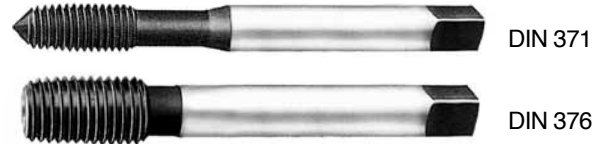
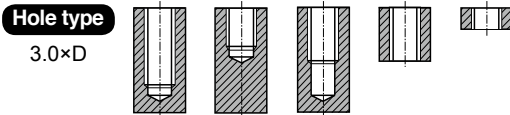


### M ISO metric coarse threads DIN 13

- Metrisches ISO-Gewinde DIN 13
- ISO MÉTRIQUE DIN13
- ISO Metrico passo grosso DIN 13

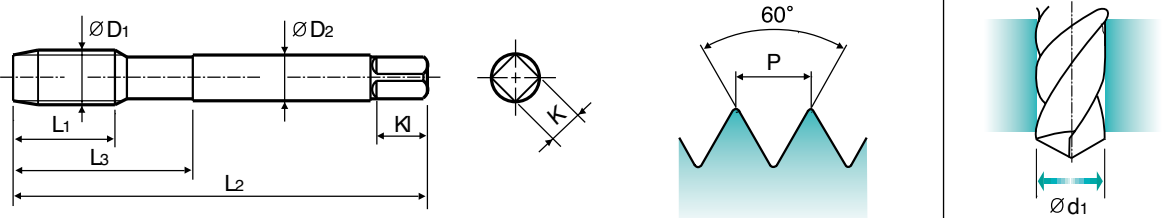
- ▶ Suitable for threading soft materials with at least 8-10% elongation in the best substrate.
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- ▶ Aus bestem Werkstoff geeignet zum Gewindeformen weicher Werkstoffe mit mindestens 8-10% Dehnung.
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**Material groups** **GV** **HSS-PM** **DIN 371/376** **6HX** **60°** **C** **Vap**

Cold forming taps  
Gewindeformer



Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	Tapping Drill Diameter
ØD1	P	Vap	L1	L2	L3	ØD2	K	KI	Ød1
M2	× 0.4	<b>TQ703136</b>	8	45	13	2.8	2.1	5	1.83
M2.2	× 0.45	<b>TQ703156</b>	8	45	13	2.8	2.1	5	2
*M2.3	× 0.4	<b>TQ703196</b>	8	45	13	2.8	2.1	5	2.1
M2.5	× 0.45	<b>TQ703176</b>	9	50	15	2.8	2.1	5	2.3
*M2.6	× 0.45	<b>TQ703496</b>	9	50	15	2.8	2.1	5	2.4
M3	× 0.5	<b>TQ703206</b>	11	56	18	3.5	2.7	6	2.8
M3.5	× 0.6	<b>TQ703226</b>	12	56	20	4	3	6	3.25
M4	× 0.7	<b>TQ703246</b>	13	63	21	4.5	3.4	6	3.7
M4.5	× 0.75	<b>TQ703266</b>	14	70	25	6	4.9	8	4.15
M5	× 0.8	<b>TQ703286</b>	15	70	25	6	4.9	8	4.65
M6	× 1	<b>TQ703316</b>	17	80	30	6	4.9	8	5.55
M7	× 1	<b>TQ703346</b>	17	80	30	7	5.5	8	6.55
M8	× 1.25	<b>TQ703366</b>	20	90	35	8	6.2	9	7.4
M9	× 1.25	<b>TQ703396</b>	20	90	35	9	7	10	8.4
M10	× 1.5	<b>TQ703426</b>	22	100	39	10	8	11	9.3
M11	× 1.5	<b>TQ703466</b>	22	100	40	8	6.2	9	10.3
M12	× 1.75	<b>TQ703506</b>	24	110	44	9	7	10	11.2
M14	× 2	<b>TQ703546</b>	26	110	44	11	9	12	13
M16	× 2	<b>TQ703606</b>	27	110	44	12	9	12	15
M18	× 2.5	<b>TQ703656</b>	30	125	50	14	11	14	16.8
M20	× 2.5	<b>TQ703706</b>	32	140	54	16	12	15	18.8

- ▶ DIN 371(M2~M10) and DIN 376(M11~M20)
- ▶ \* DIN profile not ISO

Unit : N/mm<sup>2</sup>

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
◎	◎	◎	◎										○	
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
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# Y/G COLD FORMING TAPS

## TE703 SERIES

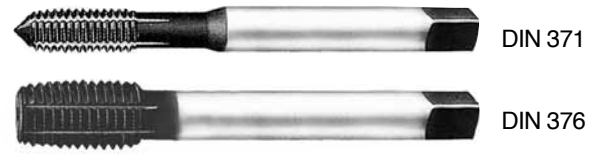
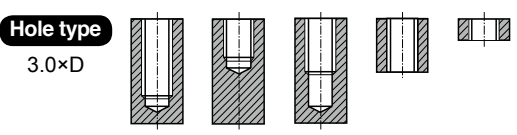
### M ISO metric coarse threads DIN 13



- Metrisches ISO-Gewinde DIN 13
- ISO MÉTRIQUE DIN13
- ISO Metrico passo grosso DIN 13

- Suitable for threading soft materials with at least 8-10% elongation.
- The pre-drilling holes are bigger than normal sized holes.

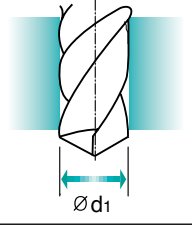
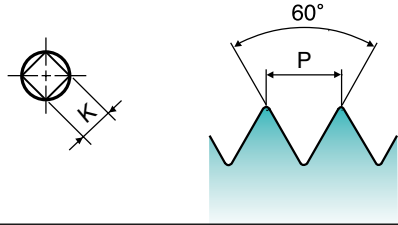
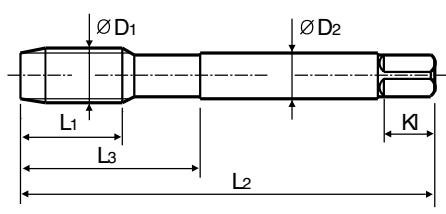
- Geeignet zum Gewindeformen weicher Werkstoffe mit mindestens 8-10% Dehnung.
- Die Kernlochbohrungen sind größer als normale Kernlöcher.



**Material groups**

**GV** HSS-E DIN 371/376 6HX 60° C NI

Cold forming taps with oil grooves  
Gewindeformer mit Schmiernuten



Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	Tapping Drill Diameter
ØD1	P	Ni	L1	L2	L3	ØD2	K	KI	Ød1
M2	× 0.4	TE703136	8	45	13	2.8	2.1	5	1.83
M2.2	× 0.45	TE703156	8	45	13	2.8	2.1	5	2
*M2.3	× 0.4	TE703196	8	45	13	2.8	2.1	5	2.1
M2.5	× 0.45	TE703176	9	50	15	2.8	2.1	5	2.3
*M2.6	× 0.45	TE703496	9	50	15	2.8	2.1	5	2.4
M3	× 0.5	TE703206	11	56	18	3.5	2.7	6	2.8
M3.5	× 0.6	TE703226	12	56	20	4	3	6	3.25
M4	× 0.7	TE703246	13	63	21	4.5	3.4	6	3.7
M4.5	× 0.75	TE703266	14	70	25	6	4.9	8	4.15
M5	× 0.8	TE703286	15	70	25	6	4.9	8	4.65
M6	× 1	TE703316	17	80	30	6	4.9	8	5.55
M7	× 1	TE703346	17	80	30	7	5.5	8	6.55
M8	× 1.25	TE703366	20	90	35	8	6.2	9	7.4
M9	× 1.25	TE703396	20	90	35	9	7	10	8.4
M10	× 1.5	TE703426	22	100	39	10	8	11	9.3
M11	× 1.5	TE703466	22	100	40	8	6.2	9	10.3
M12	× 1.75	TE703506	24	110	44	9	7	10	11.2
M14	× 2	TE703546	26	110	44	11	9	12	13
M16	× 2	TE703606	27	110	44	12	9	12	15
M18	× 2.5	TE703656	30	125	50	14	11	14	16.8
M20	× 2.5	TE703706	32	140	54	16	12	15	18.8

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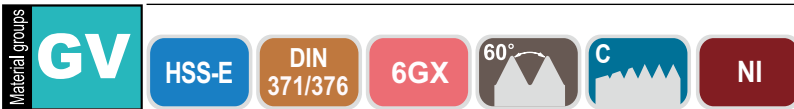
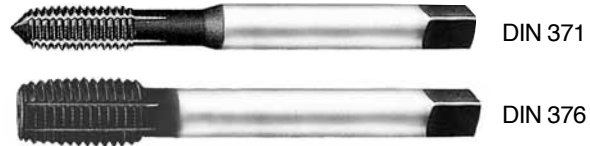
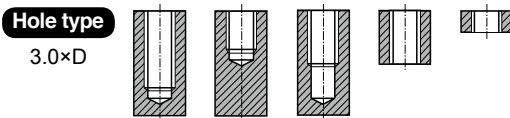
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○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermoset	Plastic Thermoset	Plastic FRP
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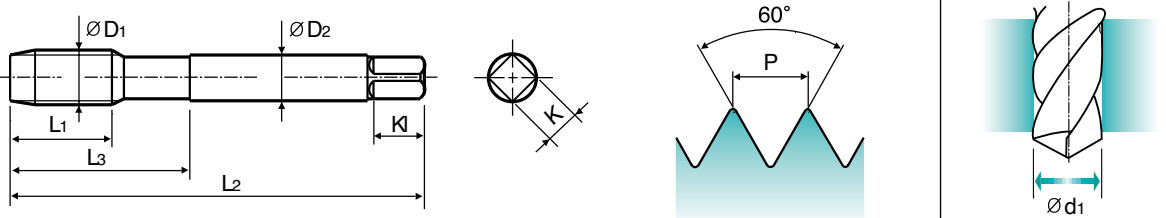
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- ▶ Suitable for threading soft materials with at least 8-10% elongation.
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Cold forming taps with oil grooves  
Gewindeformer mit Schmiernuten



Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	Tapping Drill Diameter
ØD1	P	Ni	L1	L2	L3	ØD2	K	KI	Ød1
M2 × 0.4		TE713136	8	45	13	2.8	2.1	5	1.83
M2.2 × 0.45		TE713156	8	45	13	2.8	2.1	5	2
*M2.3 × 0.4		TE713196	8	45	13	2.8	2.1	5	2.1
M2.5 × 0.45		TE713176	9	50	15	2.8	2.1	5	2.3
*M2.6 × 0.45		TE713496	9	50	15	2.8	2.1	5	2.4
M3 × 0.5		TE713206	11	56	18	3.5	2.7	6	2.8
M3.5 × 0.6		TE713226	12	56	20	4	3	6	3.25
M4 × 0.7		TE713246	13	63	21	4.5	3.4	6	3.7
M4.5 × 0.75		TE713266	14	70	25	6	4.9	8	4.15
M5 × 0.8		TE713286	15	70	25	6	4.9	8	4.65
M6 × 1		TE713316	17	80	30	6	4.9	8	5.55
M7 × 1		TE713346	17	80	30	7	5.5	8	6.55
M8 × 1.25		TE713366	20	90	35	8	6.2	9	7.4
M9 × 1.25		TE713396	20	90	35	9	7	10	8.4
M10 × 1.5		TE713426	22	100	39	10	8	11	9.3
M11 × 1.5		TE713466	22	100	40	8	6.2	9	10.3
M12 × 1.75		TE713506	24	110	44	9	7	10	11.2
M14 × 2		TE713546	26	110	44	11	9	12	13
M16 × 2		TE713606	27	110	44	12	9	12	15
M18 × 2.5		TE713656	30	125	50	14	11	14	16.8
M20 × 2.5		TE713706	32	140	54	16	12	15	18.8

- ▶ DIN 371(M2~M10) and DIN 376(M11~M20)
- ▶ \* DIN profile not ISO

Unit : N/mm<sup>2</sup>

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
◎	◎	◎	◎			○	○						○	
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
	◎			○		○		◎						

# Y/G COLD FORMING TAPS

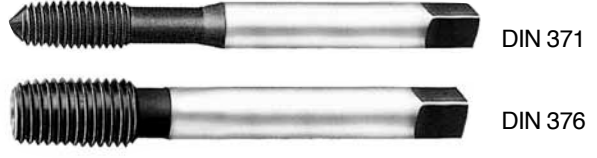
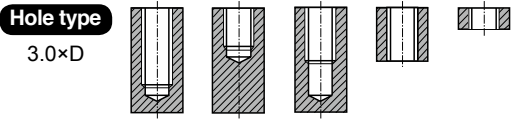
## TE723 SERIES

### M ISO metric coarse threads DIN 13

- Metrisches ISO-Gewinde DIN 13
- ISO MÉTRIQUE DIN13
- ISO Metrico passo grosso DIN 13

- Suitable for threading soft materials with at least 8-10% elongation.
- The pre-drilling holes are bigger than normal sized holes.

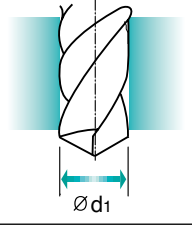
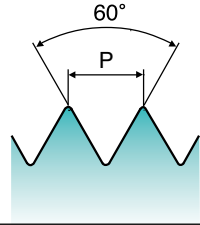
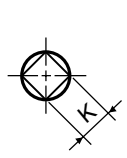
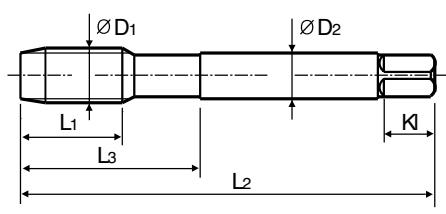
- Geeignet zum Gewindeformen weicher Werkstoffe mit mindestens 8-10% Dehnung.
- Die Kernlochbohrungen sind größer als normale Kernlöcher.



**Material groups**

- GV**
- HSS-E**
- DIN 371/376**
- 6HX**
- 60°**
- C**
- NI**

Cold forming taps  
Gewindeformer



Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	Tapping Drill Diameter
ØD1	P	Ni	L1	L2	L3	ØD2	K	KI	Ød1
M2	× 0.4	<b>TE723136</b>	8	45	13	2.8	2.1	5	1.83
M2.2	× 0.45	<b>TE723156</b>	8	45	13	2.8	2.1	5	2
*M2.3	× 0.4	<b>TE723196</b>	8	45	13	2.8	2.1	5	2.1
M2.5	× 0.45	<b>TE723176</b>	9	50	15	2.8	2.1	5	2.3
*M2.6	× 0.45	<b>TE723496</b>	9	50	15	2.8	2.1	5	2.4
M3	× 0.5	<b>TE723206</b>	11	56	18	3.5	2.7	6	2.8
M3.5	× 0.6	<b>TE723226</b>	12	56	20	4	3	6	3.25
M4	× 0.7	<b>TE723246</b>	13	63	21	4.5	3.4	6	3.7
M4.5	× 0.75	<b>TE723266</b>	14	70	25	6	4.9	8	4.15
M5	× 0.8	<b>TE723286</b>	15	70	25	6	4.9	8	4.65
M6	× 1	<b>TE723316</b>	17	80	30	6	4.9	8	5.55
M7	× 1	<b>TE723346</b>	17	80	30	7	5.5	8	6.55
M8	× 1.25	<b>TE723366</b>	20	90	35	8	6.2	9	7.4
M9	× 1.25	<b>TE723396</b>	20	90	35	9	7	10	8.4
M10	× 1.5	<b>TE723426</b>	22	100	39	10	8	11	9.3
M11	× 1.5	<b>TE723466</b>	22	100	40	8	6.2	9	10.3
M12	× 1.75	<b>TE723506</b>	24	110	44	9	7	10	11.2
M14	× 2	<b>TE723546</b>	26	110	44	11	9	12	13
M16	× 2	<b>TE723606</b>	27	110	44	12	9	12	15
M18	× 2.5	<b>TE723656</b>	30	125	50	14	11	14	16.8
M20	× 2.5	<b>TE723706</b>	32	140	54	16	12	15	18.8

- DIN 371(M2~M10) and DIN 376(M11~M20)
- \* DIN profile not ISO

Unit : N/mm<sup>2</sup>

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermoset	Plastic Thermoset	Plastic FRP
○	○	○	○	○	○	○	○	○	○	○	○	○	○	○





### M ISO metric coarse threads DIN 13

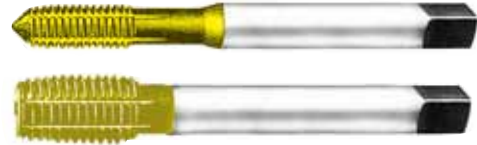
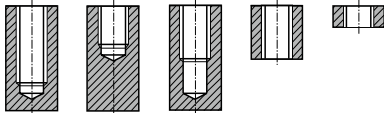
- Metrisches ISO-Gewinde DIN 13
- ISO MÉTRIQUE DIN13
- ISO Metrico passo grosso DIN 13

- ▶ Suitable for threading soft materials with at least 8-10% elongation.
- ▶ The pre-drilling holes are bigger than normal sized holes.

- ▶ Geeignet zum Gewindeformen weicher Werkstoffe mit mindestens 8-10% Dehnung.
- ▶ Die Kernlochbohrungen sind größer als normale Kernlöcher.

Hole type

3.0×D



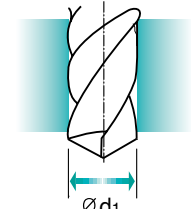
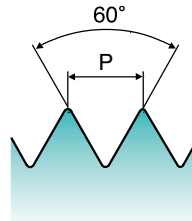
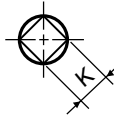
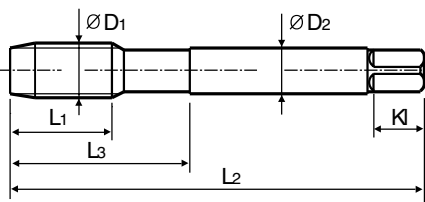
DIN 371

DIN 376

Material groups **GV**

HSS-E
DIN 371/376
6GX
60°
C
TiN

Cold forming taps with oil grooves  
Gewindeformer mit Schmiernuten



Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	Tapping Drill Diameter
ØD1	P	TiN	L1	L2	L3	ØD2	K	Kl	Ød1
M2 × 0.4		<b>TD713136</b>	8	45	13	2.8	2.1	5	1.83
M2.2 × 0.45		<b>TD713156</b>	8	45	13	2.8	2.1	5	2
*M2.3 × 0.4		<b>TD713196</b>	8	45	13	2.8	2.1	5	2.1
M2.5 × 0.45		<b>TD713176</b>	9	50	15	2.8	2.1	5	2.3
*M2.6 × 0.45		<b>TD713496</b>	9	50	15	2.8	2.1	5	2.4
M3 × 0.5		<b>TD713206</b>	11	56	18	3.5	2.7	6	2.8
M3.5 × 0.6		<b>TD713226</b>	12	56	20	4	3	6	3.25
M4 × 0.7		<b>TD713246</b>	13	63	21	4.5	3.4	6	3.7
M4.5 × 0.75		<b>TD713266</b>	14	70	25	6	4.9	8	4.15
M5 × 0.8		<b>TD713286</b>	15	70	25	6	4.9	8	4.65
M6 × 1		<b>TD713316</b>	17	80	30	6	4.9	8	5.55
M7 × 1		<b>TD713346</b>	17	80	30	7	5.5	8	6.55
M8 × 1.25		<b>TD713366</b>	20	90	35	8	6.2	9	7.4
M9 × 1.25		<b>TD713396</b>	20	90	35	9	7	10	8.4
M10 × 1.5		<b>TD713426</b>	22	100	39	10	8	11	9.3
M11 × 1.5		<b>TD713466</b>	22	100	40	8	6.2	9	10.3
M12 × 1.75		<b>TD713506</b>	24	110	44	9	7	10	11.2
M14 × 2		<b>TD713546</b>	26	110	44	11	9	12	13
M16 × 2		<b>TD713606</b>	27	110	44	12	9	12	15
M18 × 2.5		<b>TD713656</b>	30	125	50	14	11	14	16.8
M20 × 2.5		<b>TD713706</b>	32	140	54	16	12	15	18.8

- ▶ DIN 371(M2~M10) and DIN 376(M11~M20)
- ▶ \* DIN profile not ISO

Unit : N/mm<sup>2</sup>

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

# Y/G COLD FORMING TAPS

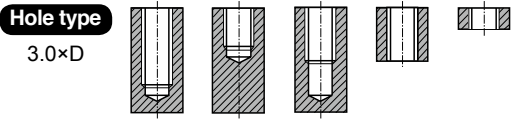
## TD723 SERIES

### M ISO metric coarse threads DIN 13

- Metrisches ISO-Gewinde DIN 13
- ISO MÉTRIQUE DIN13
- ISO Metrico passo grosso DIN 13

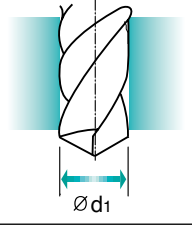
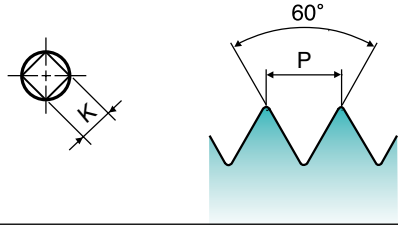
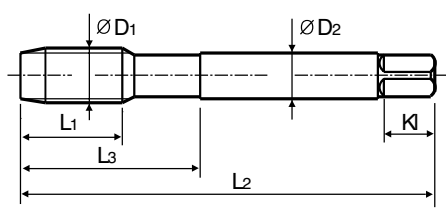
- Suitable for threading soft materials with at least 8-10% elongation.
- The pre-drilling holes are bigger than normal sized holes.

- Geeignet zum Gewindeformen weicher Werkstoffe mit mindestens 8-10% Dehnung.
- Die Kernlochbohrungen sind größer als normale Kernlöcher.



Material groups: **GV** HSS-E DIN 371/376 6HX 60° C TiN

Cold forming taps  
Gewindeformer



Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	Tapping Drill Diameter
ØD1	P	TiN	L1	L2	L3	ØD2	K	Kl	Ød1
M2	× 0.4	TD723136	8	45	13	2.8	2.1	5	1.83
M2.2	× 0.45	TD723156	8	45	13	2.8	2.1	5	2
*M2.3	× 0.4	TD723196	8	45	13	2.8	2.1	5	2.1
M2.5	× 0.45	TD723176	9	50	15	2.8	2.1	5	2.3
*M2.6	× 0.45	TD723496	9	50	15	2.8	2.1	5	2.4
M3	× 0.5	TD723206	11	56	18	3.5	2.7	6	2.8
M3.5	× 0.6	TD723226	12	56	20	4	3	6	3.25
M4	× 0.7	TD723246	13	63	21	4.5	3.4	6	3.7
M4.5	× 0.75	TD723266	14	70	25	6	4.9	8	4.15
M5	× 0.8	TD723286	15	70	25	6	4.9	8	4.65
M6	× 1	TD723316	17	80	30	6	4.9	8	5.55
M7	× 1	TD723346	17	80	30	7	5.5	8	6.55
M8	× 1.25	TD723366	20	90	35	8	6.2	9	7.4
M9	× 1.25	TD723396	20	90	35	9	7	10	8.4
M10	× 1.5	TD723426	22	100	39	10	8	11	9.3
M11	× 1.5	TD723466	22	100	40	8	6.2	9	10.3
M12	× 1.75	TD723506	24	110	44	9	7	10	11.2
M14	× 2	TD723546	26	110	44	11	9	12	13
M16	× 2	TD723606	27	110	44	12	9	12	15
M18	× 2.5	TD723656	30	125	50	14	11	14	16.8
M20	× 2.5	TD723706	32	140	54	16	12	15	18.8

- DIN 371(M2~M10) and DIN 376(M11~M20)
- \* DIN profile not ISO

Unit : N/mm<sup>2</sup>

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermoset	Plastic Thermoset	Plastic FRP
○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

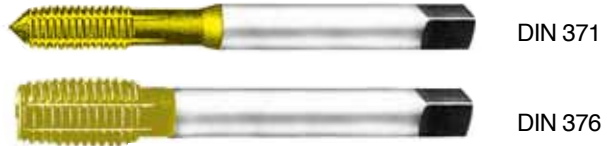
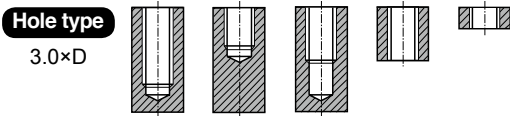


### M ISO metric coarse threads DIN 13

- Metrisches ISO-Gewinde DIN 13
- ISO MÉTRIQUE DIN13
- ISO Metrico passo grosso DIN 13

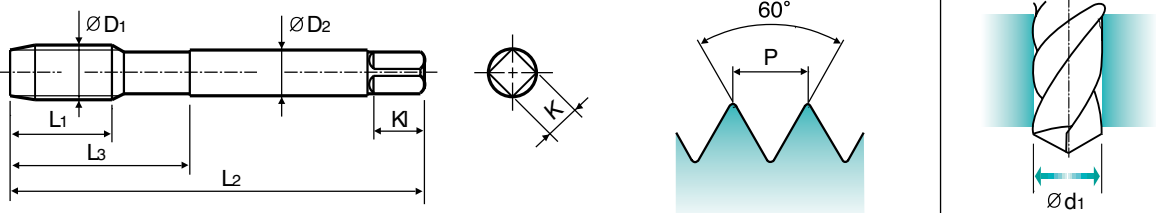
- ▶ Suitable for threading soft materials with at least 8-10% elongation.
- ▶ The pre-drilling holes are bigger than normal sized holes.

- ▶ Geeignet zum Gewindeformen weicher Werkstoffe mit mindestens 8-10% Dehnung.
- ▶ Die Kernlochbohrungen sind größer als normale Kernlöcher.



**Material groups** **GV** **HSS-E** **DIN 371/376** **6HX** **60°** **C** **TiN**

Cold forming taps with oil grooves  
Gewindeformer mit Schmiernuten



Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	Tapping Drill Diameter
ØD1	P	TiN	L1	L2	L3	ØD2	K	KI	Ød1
M2 × 0.4		<b>TD703136</b>	8	45	13	2.8	2.1	5	1.83
M2.2 × 0.45		<b>TD703156</b>	8	45	13	2.8	2.1	5	2
*M2.3 × 0.4		<b>TD703196</b>	8	45	13	2.8	2.1	5	2.1
M2.5 × 0.45		<b>TD703176</b>	9	50	15	2.8	2.1	5	2.3
*M2.6 × 0.45		<b>TD703496</b>	9	50	15	2.8	2.1	5	2.4
M3 × 0.5		<b>TD703206</b>	11	56	18	3.5	2.7	6	2.8
M3.5 × 0.6		<b>TD703226</b>	12	56	20	4	3	6	3.25
M4 × 0.7		<b>TD703246</b>	13	63	21	4.5	3.4	6	3.7
M4.5 × 0.75		<b>TD703266</b>	14	70	25	6	4.9	8	4.15
M5 × 0.8		<b>TD703286</b>	15	70	25	6	4.9	8	4.65
M6 × 1		<b>TD703316</b>	17	80	30	6	4.9	8	5.55
M7 × 1		<b>TD703346</b>	17	80	30	7	5.5	8	6.55
M8 × 1.25		<b>TD703366</b>	20	90	35	8	6.2	9	7.4
M9 × 1.25		<b>TD703396</b>	20	90	35	9	7	10	8.4
M10 × 1.5		<b>TD703426</b>	22	100	39	10	8	11	9.3
M11 × 1.5		<b>TD703466</b>	22	100	40	8	6.2	9	10.3
M12 × 1.75		<b>TD703506</b>	24	110	44	9	7	10	11.2
M14 × 2		<b>TD703546</b>	26	110	44	11	9	12	13
M16 × 2		<b>TD703606</b>	27	110	44	12	9	12	15
M18 × 2.5		<b>TD703656</b>	30	125	50	14	11	14	16.8
M20 × 2.5		<b>TD703706</b>	32	140	54	16	12	15	18.8

- ▶ DIN 371(M2~M10) and DIN 376(M11~M20)
- ▶ \* DIN profile not ISO

Unit : N/mm<sup>2</sup>

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

# TYG COLD FORMING TAPS

## TY703 SERIES

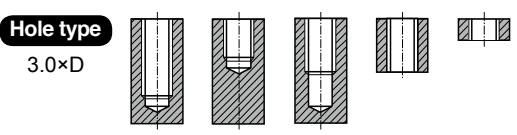
### M ISO metric coarse threads DIN 13



- Metrisches ISO-Gewinde DIN 13
- ISO MÉTRIQUE DIN13
- ISO Metrico passo grosso DIN 13

- Suitable for threading soft materials with at least 8-10% elongation.
- The pre-drilling holes are bigger than normal sized holes.

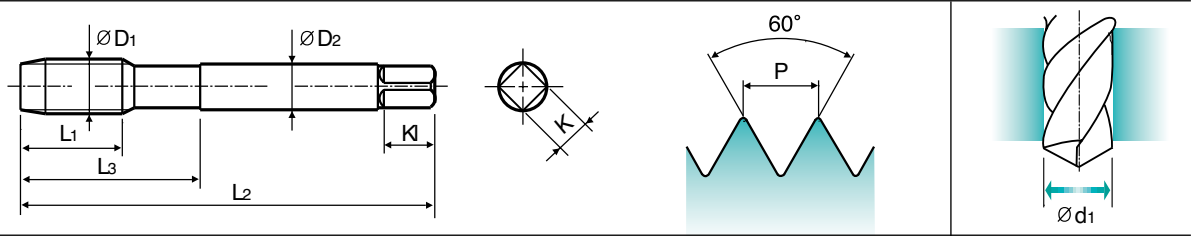
- Geeignet zum Gewindeformen weicher Werkstoffe mit mindestens 8-10% Dehnung.
- Die Kernlochbohrungen sind größer als normale Kernlöcher.



**Material groups**

**GV** HSS-E DIN 371/376 6HX 60° C TiAlN

Cold forming taps with oil grooves  
Gewindeformer mit Schmiernuten



SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	Tapping Drill Diameter
ØD1	P	TiAlN	L1	L2	L3	ØD2	K	Kl	Ød1
M2 × 0.4		TY703136	8	45	13	2.8	2.1	5	1.83
M2.2 × 0.45		TY703156	8	45	13	2.8	2.1	5	2
*M2.3 × 0.4		TY703196	8	45	13	2.8	2.1	5	2.1
M2.5 × 0.45		TY703176	9	50	15	2.8	2.1	5	2.3
*M2.6 × 0.45		TY703496	9	50	15	2.8	2.1	5	2.4
M3 × 0.5		TY703206	11	56	18	3.5	2.7	6	2.8
M3.5 × 0.6		TY703226	12	56	20	4	3	6	3.25
M4 × 0.7		TY703246	13	63	21	4.5	3.4	6	3.7
M4.5 × 0.75		TY703266	14	70	25	6	4.9	8	4.15
M5 × 0.8		TY703286	15	70	25	6	4.9	8	4.65
M6 × 1		TY703316	17	80	30	6	4.9	8	5.55
M7 × 1		TY703346	17	80	30	7	5.5	8	6.55
M8 × 1.25		TY703366	20	90	35	8	6.2	9	7.4
M9 × 1.25		TY703396	20	90	35	9	7	10	8.4
M10 × 1.5		TY703426	22	100	39	10	8	11	9.3
M11 × 1.5		TY703466	22	100	40	8	6.2	9	10.3
M12 × 1.75		TY703506	24	110	44	9	7	10	11.2
M14 × 2		TY703546	26	110	44	11	9	12	13
M16 × 2		TY703606	27	110	44	12	9	12	15
M18 × 2.5		TY703656	30	125	50	14	11	14	16.8
M20 × 2.5		TY703706	32	140	54	16	12	15	18.8

- DIN 371(M2~M10) and DIN 376(M11~M20)
- \* DIN profile not ISO

Unit : N/mm<sup>2</sup>      ◎ : Excellent      ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermoset	Plastic Thermoset	Plastic FRP
○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

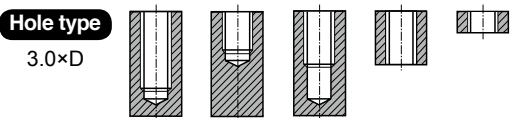


### MF ISO metric fine threads DIN 13

■ **Metrisches ISO-Feingewinde DIN 13**  
■ **ISO MÉTRIQUE PAS FINS DIN13**  
■ **ISO Metrico passo fine DIN 13**

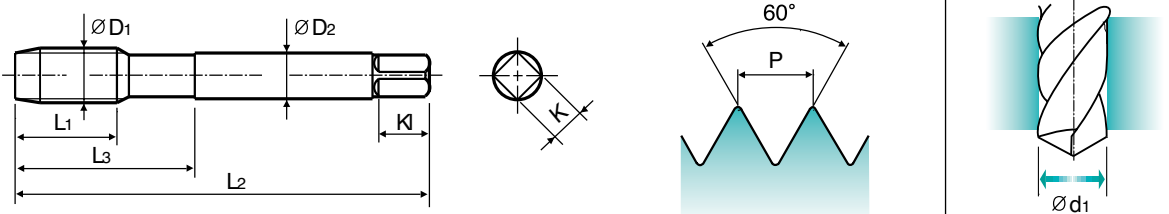
- Suitable for threading soft materials with at least 8-10% elongation.
- The pre-drilling holes are bigger than normal sized holes.

- Geeignet zum Gewindeformen weicher Werkstoffe mit mindestens 8-10% Dehnung.
- Die Kernlochbohrungen sind größer als normale Kernlöcher.



**Material groups** **GV** **HSS-E** **DIN 374** **6HX** **60°** **C** **NI**

Cold forming taps with oil grooves  
Gewindeformer mit Schmiernuten

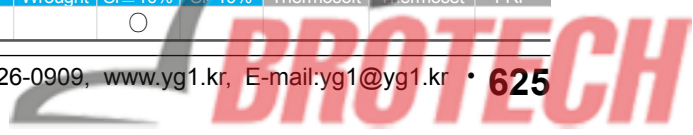


Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	Tapping Drill Diameter
ØD1	P	Ni	L1	L2	L3	ØD2	K	KI	Ød1
M4	× 0.5	TE733256	10	63	21	2.8	2.1	5	3.75
M5	× 0.5	TE733296	11	70	25	3.5	2.7	6	4.75
M6	× 0.75	TE733326	13	80	30	4.5	3.4	6	5.65
M6	× 0.5	TE733336	13	80	30	4.5	3.4	6	5.75
M7	× 0.75	TE733356	14	80	30	5.5	4.3	7	6.65
M8	× 1	TE733376	17	90	36	6	4.9	8	7.5
M8	× 0.75	TE733386	14	80	30	6	4.9	8	7.65
M10	× 1.25	TE733436	22	100	40	7	5.5	8	9.4
M10	× 1	TE733446	18	90	36	7	5.5	8	9.5
M10	× 0.75	TE733456	18	90	36	7	5.5	8	9.65
M12	× 1.5	TE733516	22	100	40	9	7	10	11.25
M12	× 1.25	TE733526	22	100	40	9	7	10	11.4
M12	× 1	TE733536	18	100	40	9	7	10	11.5
M14	× 1.5	TE733556	22	100	40	11	9	12	13.25
M14	× 1.25	TE733566	22	100	40	11	9	12	13.4
M16	× 1.5	TE733616	22	100	40	12	9	12	15.25
M18	× 1.5	TE733676	25	110	44	14	11	14	17.25
M20	× 1.5	TE733726	25	125	50	16	12	15	19.25

Unit : N/mm<sup>2</sup> ◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
◎	◎	◎	◎			○	○						○	
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
	◎			○		○		◎						



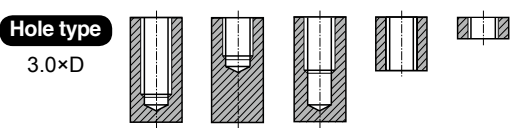
- CARBIDE
- HSS
- THREAD MILLS
- CARBIDE TAPS
- PRIME TAPS
- COMBO TAPS
- SPIRAL FLUTE TAPS
- SPIRAL POINT TAPS
- STRAIGHT FLUTE TAPS
- COLD FORMING TAPS
- NUT TAPS
- STI TAPS
- HAND TAPS
- PIPE TAPS
- TECHNICAL DATA

**YG COLD FORMING TAPS**

**TD733 SERIES**

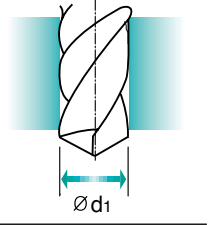
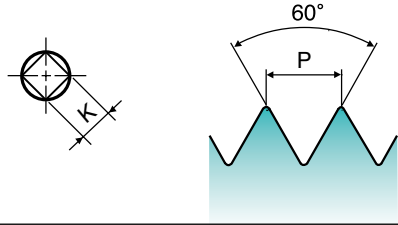
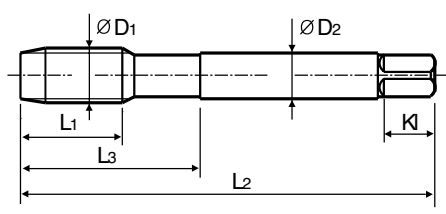
**MF ISO metric fine threads DIN 13**  
 Metrisches ISO-Feingewinde DIN 13  
 ISO MÉTRIQUE PAS FINS DIN13  
 ISO Metrica passo fine DIN 13

- Suitable for threading soft materials with at least 8-10% elongation.
- The pre-drilling holes are bigger than normal sized holes.
- Geeignet zum Gewindeformen weicher Werkstoffe mit mindestens 8-10% Dehnung.
- Die Kernlochbohrungen sind größer als normale Kernlöcher.



**Material groups**  
**GV** HSS-E DIN 374 6HX 60° C TiN

Cold forming taps with oil grooves  
 Gewindeformer mit Schmiernuten



Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	Tapping Drill Diameter
ØD1	P	TiN	L1	L2	L3	ØD2	K	Kl	Ød1
M4	× 0.5	TD733256	10	63	21	2.8	2.1	5	3.75
M5	× 0.5	TD733296	11	70	25	3.5	2.7	6	4.75
M6	× 0.75	TD733326	13	80	30	4.5	3.4	6	5.65
M6	× 0.5	TD733336	13	80	30	4.5	3.4	6	5.75
M7	× 0.75	TD733356	14	80	30	5.5	4.3	7	6.65
M8	× 1	TD733376	17	90	36	6	4.9	8	7.5
M8	× 0.75	TD733386	14	80	30	6	4.9	8	7.65
M10	× 1.25	TD733436	22	100	40	7	5.5	8	9.4
M10	× 1	TD733446	18	90	36	7	5.5	8	9.5
M10	× 0.75	TD733456	18	90	36	7	5.5	8	9.65
M12	× 1.5	TD733516	22	100	40	9	7	10	11.25
M12	× 1.25	TD733526	22	100	40	9	7	10	11.4
M12	× 1	TD733536	18	100	40	9	7	10	11.5
M14	× 1.5	TD733556	22	100	40	11	9	12	13.25
M14	× 1.25	TD733566	22	100	40	11	9	12	13.4
M16	× 1.5	TD733616	22	100	40	12	9	12	15.25
M18	× 1.5	TD733676	25	110	44	14	11	14	17.25
M20	× 1.5	TD733726	25	125	50	16	12	15	19.25

Unit : N/mm<sup>2</sup>

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermoset	Plastic Thermoset	Plastic FRP
○	○	○	○	○	○	○	○	○	○	○	○	○	○	○



### UNC Unified coarse threads

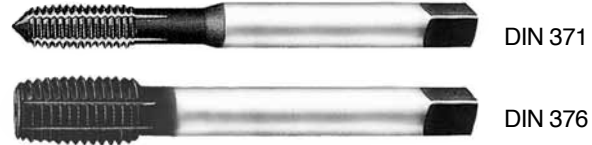
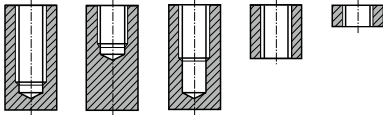
Unified Grobgewinde  
 UNC  
 Unificato passo grosso

- Suitable for threading soft materials with at least 8-10% elongation.
- The pre-drilling holes are bigger than normal sized holes.

- Geeignet zum Gewindeformen weicher Werkstoffe mit mindestens 8-10% Dehnung.
- Die Kernlochbohrungen sind größer als normale Kernlöcher.

Hole type

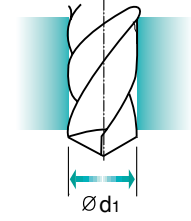
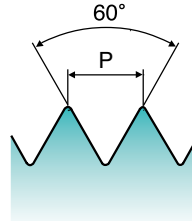
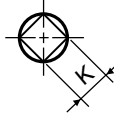
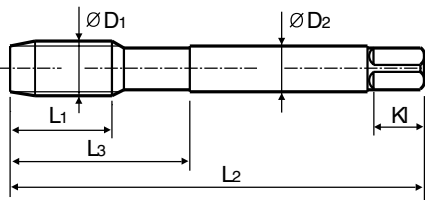
3.0×D



Material groups **GV**

HSS-E
DIN 371/376
2BX
60°
C
NI

Cold forming taps with oil grooves  
 Gewindeformer mit Schmiernuten



Unit : mm

SIZE	TPI	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	Tapping Drill Diameter
ØD1		Ni	L1	L2	L3	ØD2	K	KI	Ød1
#5	- 40 UNC	TE704202	11	56	18	3.5	2.7	6	2.87
#6	- 32 UNC	TE704242	12	56	20	4	3	6	3.1
#8	- 32 UNC	TE704282	13	63	21	4.5	3.4	6	3.8
#10	- 24 UNC	TE704322	15	70	25	6	4.9	8	4.3
#12	- 24 UNC	TE704362	16	80	30	6	4.9	8	4.95
1/4	- 20 UNC	TE704402	17	80	30	7	5.5	8	5.75
5/16	- 18 UNC	TE704442	20	90	35	8	6.2	9	7.25
3/8	- 16 UNC	TE704482	22	100	39	9	7	10	8.75
7/16	- 14 UNC	TE704522	22	100	40	8	6.2	9	10.2
1/2	- 13 UNC	TE704562	25	110	44	9	7	10	11.7
9/16	- 12 UNC	TE704602	26	110	40	11	9	12	13.2
5/8	- 11 UNC	TE704642	27	110	44	12	9	12	14.7
3/4	- 10 UNC	TE704702	30	125	50	14	11	14	17.8

► DIN 371(#4~3/8) and DIN 376(7/16~3/4)

Unit : N/mm<sup>2</sup>

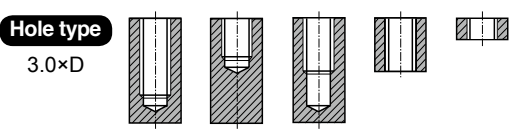
◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
◎	◎	◎	◎			○	○						○	
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
	◎			○		○		◎						

**UNC** Unified coarse threads  
 Unified Grobgewinde  
 UNC  
 Unificato passo grosso

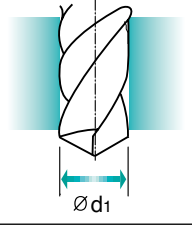
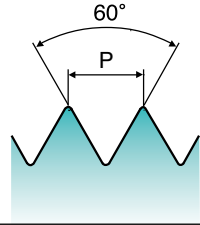
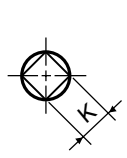
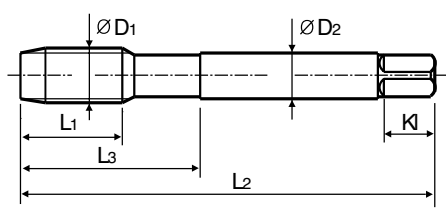
► Suitable for threading soft materials with at least 8-10% elongation.  
 ► The pre-drilling holes are bigger than normal sized holes.

► Geeignet zum Gewindeformen weicher Werkstoffe mit mindestens 8-10% Dehnung.  
 ► Die Kernlochbohrungen sind größer als normale Kernlöcher.



**Material groups**  
**GV** HSS-E DIN 371/376 2BX 60° C TiN

Cold forming taps with oil grooves  
 Gewindeformer mit Schmiernuten



Unit : mm

SIZE	TPI	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	Tapping Drill Diameter
∅D1		TiN	L1	L2	L3	∅D2	K	KI	∅d1
#5	- 40 UNC	<b>TD704202</b>	11	56	18	3.5	2.7	6	2.87
#6	- 32 UNC	<b>TD704242</b>	12	56	20	4	3	6	3.1
#8	- 32 UNC	<b>TD704282</b>	13	63	21	4.5	3.4	6	3.8
#10	- 24 UNC	<b>TD704322</b>	15	70	25	6	4.9	8	4.3
#12	- 24 UNC	<b>TD704362</b>	16	80	30	6	4.9	8	4.95
1/4	- 20 UNC	<b>TD704402</b>	17	80	30	7	5.5	8	5.75
5/16	- 18 UNC	<b>TD704442</b>	20	90	35	8	6.2	9	7.25
3/8	- 16 UNC	<b>TD704482</b>	22	100	39	9	7	10	8.75
7/16	- 14 UNC	<b>TD704522</b>	22	100	40	8	6.2	9	10.2
1/2	- 13 UNC	<b>TD704562</b>	25	110	44	9	7	10	11.7
9/16	- 12 UNC	<b>TD704602</b>	26	110	40	11	9	12	13.2
5/8	- 11 UNC	<b>TD704642</b>	27	110	44	12	9	12	14.7
3/4	- 10 UNC	<b>TD704702</b>	30	125	50	14	11	14	17.8

► DIN 371(#4~3/8) and DIN 376(7/16~3/4)

Unit : N/mm<sup>2</sup>      ◎ : Excellent      ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermoset	Plastic Thermoset	Plastic FRP
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎