



Taps for steels from 25~45 HRC

H-TAP

Volume 2



KEY FEATURES: H-TAP



1 For steels 25~45 HRC

2 Also for tool steels

3 Steam oxide treatment:
improved lubricity

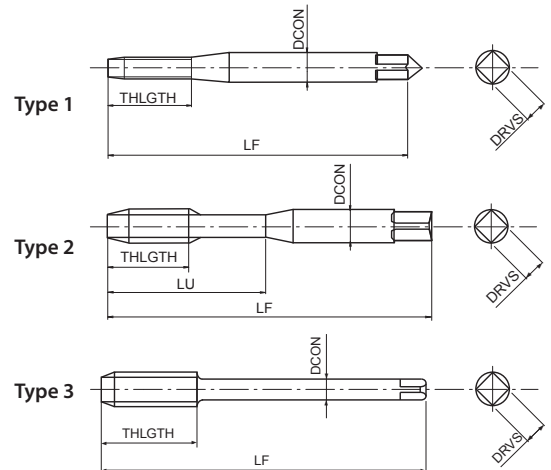
4 Powder metal:
high wear resistance

H-SFT

Threading | Cutting taps | Metric



- Powder metal low spiral-fluted cutting tap for blind holes
- Steam oxide treatment
- For hardened steels up to 45 HRC



| | | | | | | | |
|----------|----------|----------|----------|----------|----------|-----|-------|
| P | K | S | S | H | H | | |
| 7-12 | 7-12 | 7-12 | 3-5 | 1-3 | 4-8 | 4-8 | m/min |

| | | | | | | | |
|----------|-----------|-----------|------------|-----------------|------------|----------------|----------------|
| M | PM | OX | 15° | ISO 2 6H | C/3 | DIN 371 | DIN 376 |
|----------|-----------|-----------|------------|-----------------|------------|----------------|----------------|

| EDP | TD | TP | LF | THLGTH | LU | DCON | DRVS | NOF | Type | DIN |
|----------|-----|------|-----|--------|----|------|------|-----|------|-----|
| 83212560 | 2 | 0,4 | 45 | - | 8 | 2,8 | 2,1 | 2 | 1 | 371 |
| 83213360 | 2,5 | 0,45 | 50 | - | 9 | 2,8 | 2,1 | 2 | 1 | 371 |
| 83213860 | 3 | 0,5 | 56 | - | 18 | 3,5 | 2,7 | 3 | 2 | 371 |
| 83214460 | 4 | 0,7 | 63 | - | 21 | 4,5 | 3,4 | 3 | 2 | 371 |
| 83214960 | 5 | 0,8 | 70 | - | 25 | 6 | 4,9 | 3 | 2 | 371 |
| 83215560 | 6 | 1 | 80 | - | 30 | 6 | 4,9 | 3 | 2 | 371 |
| 83216160 | 8 | 1,25 | 90 | - | 35 | 8 | 6,2 | 3 | 2 | 371 |
| 83216960 | 10 | 1,5 | 100 | - | 39 | 10 | 8 | 3 | 2 | 371 |
| 83317960 | 12 | 1,75 | 110 | 18 | - | 9 | 7 | 3 | 3 | 376 |
| 83319160 | 14 | 2 | 110 | 20 | - | 11 | 9 | 3 | 3 | 376 |
| 83320260 | 16 | 2 | 110 | 20 | - | 12 | 9 | 3 | 3 | 376 |
| 83321460 | 18 | 2,5 | 125 | 25 | - | 14 | 11 | 4 | 3 | 376 |
| 83322860 | 20 | 2,5 | 140 | 25 | - | 16 | 12 | 4 | 3 | 376 |

Threading | Cutting taps

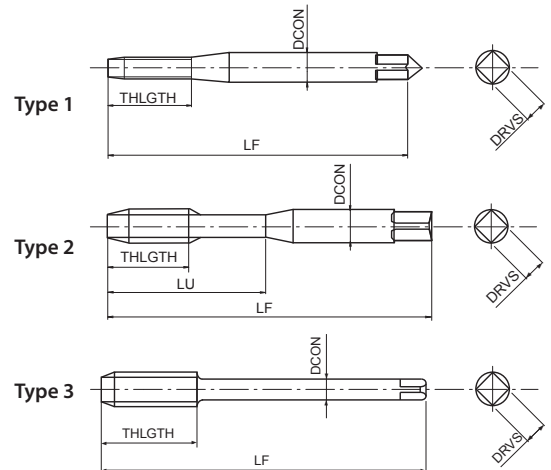
Metric

H-POT

Threading | Cutting taps | Metric



- Powder metal spiral-point cutting tap for through holes
- Steam oxide treatment
- For hardened steels up to 45 HRC



| | | | | | | |
|-----------------------|-----------------|----------------|----------------|-----------------------|-----------------------|-------|
| P C ≥ 0,45% | K GGG | S Ti | S Ni | H 25-35 HRC | H 35-45 HRC | |
| 8-13 | 10-15 | 4-6 | 2-4 | 6-10 | 6-10 | m/min |

| | | | | | | |
|----------|-----------|-----------|-----------------|------------|----------------|----------------|
| M | PM | OX | ISO 2 6H | B/5 | DIN 371 | DIN 376 |
|----------|-----------|-----------|-----------------|------------|----------------|----------------|

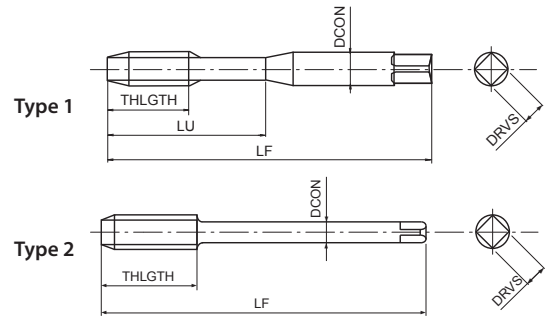
| EDP | TD | TP | LF | THLGTH | LU | DCON | DRVS | NOF | Type | DIN |
|----------|-----|------|-----|--------|----|------|------|-----|------|-----|
| 88412560 | 2 | 0,4 | 45 | 8 | - | 2,8 | 2,1 | 2 | 1 | 371 |
| 88413360 | 2,5 | 0,45 | 50 | 9 | - | 2,8 | 2,1 | 2 | 1 | 371 |
| 88413860 | 3 | 0,5 | 56 | - | 18 | 3,5 | 2,7 | 3 | 2 | 371 |
| 88414460 | 4 | 0,7 | 63 | - | 21 | 4,5 | 3,4 | 3 | 2 | 371 |
| 88414960 | 5 | 0,8 | 70 | - | 25 | 6 | 4,9 | 3 | 2 | 371 |
| 88415560 | 6 | 1 | 80 | - | 30 | 6 | 4,9 | 3 | 2 | 371 |
| 88416160 | 8 | 1,25 | 90 | - | 35 | 8 | 6,2 | 3 | 2 | 371 |
| 88416960 | 10 | 1,5 | 100 | - | 39 | 10 | 8 | 3 | 2 | 371 |
| 88517960 | 12 | 1,75 | 110 | 28 | - | 9 | 7 | 3 | 3 | 376 |
| 88519160 | 14 | 2 | 110 | 30 | - | 11 | 9 | 3 | 3 | 376 |
| 88520260 | 16 | 2 | 110 | 32 | - | 12 | 9 | 4 | 3 | 376 |
| 88521460 | 18 | 2,5 | 125 | 34 | - | 14 | 11 | 4 | 3 | 376 |
| 88522860 | 20 | 2,5 | 140 | 34 | - | 16 | 12 | 4 | 3 | 376 |

Threading | Cutting taps

Metric

H-POT

Threading | Cutting taps | UNJF



- Powder metal spiral-point cutting tap for through holes
- Steam oxide treatment
- For hardened steels up to 45 HRC

| | | | | | | |
|--------------------|--------------|-------------|-------------|--------------------|--------------------|-------|
| P C ≥ 0,45% | K GGG | S Ti | S Ni | H 25-35 HRC | H 35-45 HRC | |
| 8-13 | 10-15 | 4-6 | 2-4 | 6-10 | 6-10 | m/min |

| | | | | | | |
|-------------|-----------|-----------|----------------|-----|------------|------------|
| UNJF | PM | OX | ANSI 3B | B/5 | DIN 2184-1 | DIN 2184-1 |
|-------------|-----------|-----------|----------------|-----|------------|------------|

| EDP | TD | TP | LF | THLGTH | LU | DCON | DRVS | NOF | Type | DIN |
|----------|------|----|-----|--------|----|------|------|-----|------|--------|
| 48010467 | 10 | 32 | 70 | - | 25 | 6 | 4,9 | 3 | 1 | 2184-1 |
| 48010472 | 1/4 | 28 | 80 | - | 30 | 7 | 5,5 | 3 | 1 | 2184-1 |
| 48010476 | 5/16 | 24 | 90 | - | 35 | 8 | 6,2 | 3 | 1 | 2184-1 |
| 48010481 | 3/8 | 24 | 90 | - | 35 | 9 | 7 | 3 | 1 | 2184-1 |
| 48010486 | 7/16 | 20 | 100 | 20 | - | 8 | 6,2 | 3 | 2 | 2184-1 |
| 48010491 | 1/2 | 20 | 100 | 22 | - | 9 | 7 | 3 | 2 | 2184-1 |

Threading | Cutting taps

UNJF





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