



Taps for steels from 25~45 HRC

# H-TAP

Volume 2



# KEY FEATURES: H-TAP

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1 For steels 25~45 HRC

2 Also for tool steels

3 Steam oxide treatment:  
improved lubricity

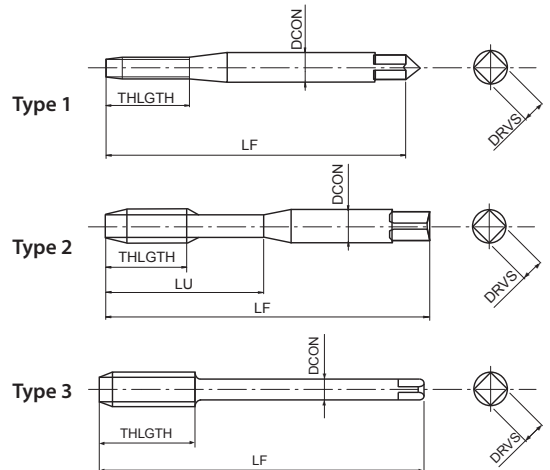
4 Powder metal:  
high wear resistance

# 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



<b>P</b> $C \geq 0,45\%$	<b>P</b> SCM	<b>K</b> GGG	<b>S</b> Ti	<b>S</b> Ni	<b>H</b> 25-35 HRC	<b>H</b> 35-45 HRC	m/min
7-12	7-12	7-12	3-5	1-3	4-8	4-8	

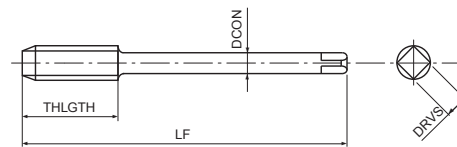
<b>M</b>	<b>PM</b>	<b>OX</b>	<b>15°</b>	<b>ISO 2 6H</b>	<b>C/3</b>		<b>DIN 371</b>	<b>DIN 376</b>
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EDP	TD	TP	LF	THLGTH	LU	DCON	DRVS	NOF	Type	DIN
83212560	2	0,4	45	-	8	2,8	2,1	2	1	371
83213360	2,5	0,45	50	-	9	2,8	2,1	2	1	371
83213860	3	0,5	56	-	18	3,5	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



# H-SFT

Threading | Cutting taps | Metric Fine



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

<b>P</b> ◉ C ≥ 0,45%	<b>P</b> ○ SCM	<b>K</b> ○ GGG	<b>S</b> ◉ Ti	<b>S</b> ◉ Ni	<b>H</b> ◉ 25-35 HRC	<b>H</b> ◉ 35-45 HRC	
7-12	7-12	7-12	3-5	1-3	4-8	4-8	m/min
<b>MF</b>	<b>PM</b>	<b>OX</b>	<b>15°</b>	<b>ISO 2 6H</b>	<b>C/3</b>	<b>DIN 374</b>	

EDP	TD	TP	LF	THLGTH	DCON	DRVS	NOF	DIN
83214060	3	0,35	56	4	2,2	-	3	374
83214560	4	0,5	63	6	2,8	2,1	3	374
83215160	5	0,5	70	7	3,5	2,7	3	374
83215760	6	0,5	80	8	4,5	3,4	3	374
83215660	6	0,75	80	8	4,5	3,4	3	374
83216360	8	0,75	80	10	6	4,9	3	374
83216260	8	1	90	10	6	4,9	3	374
83217160	10	1	90	12	7	5,5	4	374
83217060	10	1,25	100	12	7	5,5	4	374
83218260	12	1	100	14	9	7	4	374
83218160	12	1,25	100	14	9	7	4	374
83218060	12	1,5	100	14	9	7	4	374
83219260	14	1,5	100	16	11	9	5	374
83220360	16	1,5	100	16	12	9	5	374
83221660	18	1,5	110	20	14	11	5	374
83223060	20	1,5	125	20	16	12	5	374
83224060	22	1,5	125	20	18	14,5	5	374
83225060	24	1,5	140	24	18	14,5	5	374

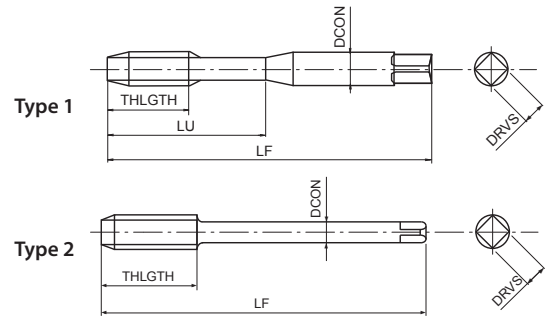
Threading | Cutting taps

Metric Fine










# H-SFT

Threading | Cutting taps | UNJF





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

Threading | Cutting taps

<b>P</b>  C ≥ 0,45%	<b>P</b>  SCM	<b>K</b>  GGG	<b>S</b>  Ti	<b>S</b>  Ni	<b>H</b>  25-35 HRC	<b>H</b>  35-45 HRC											m/min	
7-12	7-12	7-12	3-5	1-3	4-8	4-8												

<b>UNJF</b>	<b>PM</b>	<b>OX</b>	<b>15°</b>	<b>ANSI 3B</b>	 C/2,5		<b>DIN 2184-1</b>	<b>DIN 2184-1</b>
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EDP	TD	TP	LF	THLGTH	LU	DCON	DRVS	NOF	Type	DIN
48009467	10	32	70	-	25	6	4,9	3	1	2184-1
48009472	1/4	28	80	-	30	7	5,5	3	1	2184-1
48009476	5/16	24	90	-	35	8	6,2	3	1	2184-1
48009481	3/8	24	90	-	35	9	7	3	1	2184-1
48009486	7/16	20	100	15	-	8	6,2	3	2	2184-1
48009491	1/2	20	100	16	-	9	7	3	2	2184-1



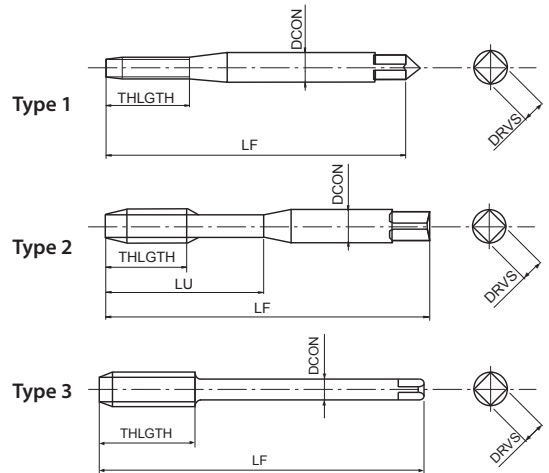
UNJF

# 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



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

<b>M</b>	<b>PM</b>	<b>OX</b>	<b>ISO 2 6H</b>	<b>B/5</b>	<b>DIN 371</b>	<b>DIN 376</b>
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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

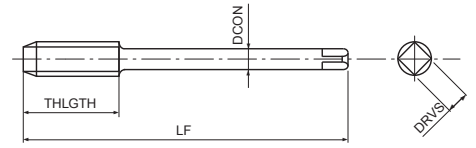
Threading | Cutting taps

Metric



# H-POT

Threading | Cutting taps | Metric Fine



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

Threading | Cutting taps

Metric Fine

<b>P</b> C ≥ 0,45%	<b>K</b> GGG	<b>S</b> Ti	<b>S</b> Ni	<b>H</b> 25-35 HRC	<b>H</b> 35-45 HRC	
8-13	10-15	4-6	2-4	6-10	6-10	m/min
<b>MF</b>	<b>PM</b>	<b>OX</b>	<b>ISO 2 6H</b>	<b>B/5</b>		<b>DIN 374</b>

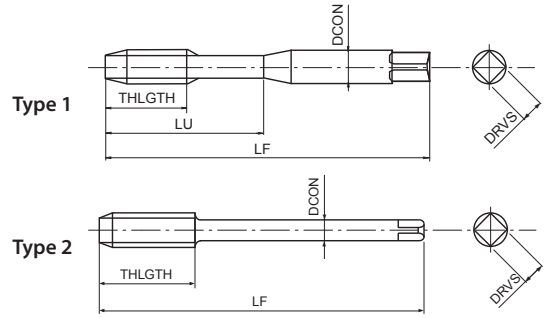
EDP	TD	TP	LF	THLGTH	DCON	DRVS	NOF	DIN
88414060	3	0,35	56	8	2,2	-	3	374
88414560	4	0,5	63	10	2,8	2,1	3	374
88415160	5	0,5	70	12	3,5	2,7	3	374
88415760	6	0,5	80	14	4,5	3,4	3	374
88415660	6	0,75	80	14	4,5	3,4	3	374
88416360	8	0,75	80	18	6	4,9	3	374
88416260	8	1	90	22	6	4,9	3	374
88417160	10	1	90	20	7	5,5	3	374
88417060	10	1,25	100	24	7	5,5	3	374
88418260	12	1	100	22	9	7	3	374
88418160	12	1,25	100	22	9	7	3	374
88418060	12	1,5	100	22	9	7	3	374
88419260	14	1,5	100	22	11	9	3	374
88420360	16	1,5	100	22	12	9	4	374
88421660	18	1,5	110	25	14	11	4	374
88423060	20	1,5	125	25	16	12	4	374
88424060	22	1,5	125	25	18	14,5	4	374
88425060	24	1,5	140	28	18	14,5	4	374





# 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

Threading | Cutting taps

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

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



UNJF

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