



FLUTELESS MACHINE TAPS 挤压丝锥

	blank 白身	VAP	TIN
6H ISO2	167	168	169
6G ISO3	170		

Application:

bright:

- for nonferrous metal of good ductility

VAP (Steam Tempered):

- for steel up to approx. 700 N/mm²

TIN (Titanium Nitride Coating):

- for steel up to approx. 900 N/mm²
and to increase endurance and cutting speed

应用:

白身:

用于有良好延展性的有色金属

VAP(蒸汽处理):

- 用于抗拉强度小于700N/mm²的钢材

TIN(氮化钛涂层):

- 用于抗拉强度小于900N/mm²的钢材
提高耐磨度和切削速度

because available ■ because reliable ■ because you ■



RECOMMENDED APPLICATION OF FLUTELESS MACHINE TAPS

挤压丝锥使用建议

Material 材料	bright 白身	VAP	TIN
unalloyed and low alloyed Steel 非合金钢和低合金钢			x
heat resistant Steel 耐热钢			x
Stainless Steel 不锈钢		x	x
Constructional Steel 结构钢		x	x
Brass, long-chipping 黄铜, 长屑	x		
Bronzes, long-chipping 青铜, 长屑	x		
Copper 紫铜	x		
Al-alloys, long-chipping 铝合金, 长屑	x		
Zinc Alloyes 锌合金	x		

Oil Groove:

Use Fluteless Taps with Oil Groove for thread depth over 1,5 x D to optimize lubrication.

油槽:

螺纹深度超过 1.5 x D 时, 使用带油槽的挤压丝锥可充分润滑。

Lubrication:

Good lubrication is very important when forming threads.
Use graphitic lubrication/oil with lubricity or add suitable additives.

润滑:

好的润滑对挤压螺纹非常重要。
使用石墨润滑/润滑油或增加合适的添加剂。

RECOMMENDED CORE HOLE DIAMETER

建议底孔直径

M 1	M 1,1	M 1,2	M 1,4	M 1,6	M 1,7	M 1,8	M 2	M 2,5	M 3	M 4	M 5	M 6	M 8	M 10	M 12	M 14	M 16
0,90	1,00	1,10	1,25	1,45	1,55	1,65	1,80	2,30	2,80	3,70	4,65	5,55	7,45	9,30	11,20	13,00	15,10



Fluteless Machine Taps (Forming Taps)

metric ISO-thread DIN 13

挤压丝锥

公制ISO螺纹 DIN 13



DIN 371/376

2.1/2 Thread Start

HSS-E

ToI. ISO2X/6HX

Nominal Diameter D	L 1	L 2	D 2	∅	Art.-No.
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without Oil Groove / 无油槽

DIN 371

M 1 x 0.25	40	5	2.5	2.1	35500
M 1.1 x 0.25	40	5	2.5	2.1	35501
M 1.2 x 0.25	40	5	2.5	2.1	35502
M 1.4 x 0.3	40	7	2.5	2.1	35503
M 1.6 x 0.35	40	8	2.5	2.1	35504
M 1.7 x 0.35	40	8	2.5	2.1	35505
M 1.8 x 0.35	40	8	2.5	2.1	35506
M 2 x 0.4	45	8	2.8	2.1	35507
M 2.5 x 0.45	50	9	2.8	2.1	35508
M 3 x 0.5	56	11	3.5	2.7	35510
M 4 x 0.7	63	13	4.5	3.4	35512
M 5 x 0.8	70	16	6.0	4.9	35513
M 6 x 1.0	80	19	6.0	4.9	35514
M 8 x 1.25	90	22	8.0	6.2	35515
M 10 x 1.5	100	24	10.0	8.0	35516

DIN 376

M 12 x 1.75	110	29	9.0	7.0	35517
M 14 x 2.0	110	30	11.0	9.0	35518
M 16 x 2.0	110	32	12.0	9.0	35519

with Oil Groove / 带油槽

DIN 371

M 3 x 0.5	56	11	3.5	2.7	35610
M 4 x 0.7	63	13	4.5	3.4	35612
M 5 x 0.8	70	16	6.0	4.9	35613
M 6 x 1.0	80	19	6.0	4.9	35614
M 8 x 1.25	90	22	8.0	6.2	35615
M 10 x 1.5	100	24	10.0	8.0	35616

DIN 376

M 12 x 1.75	110	29	9.0	7.0	35617
M 14 x 2.0	110	30	11.0	9.0	35618
M 16 x 2.0	110	32	12.0	9.0	35619

Application:

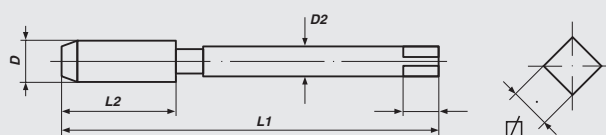
bright:

- for nonferrous metal of good ductility

应用:

白身:

- 用于有良好延展性的有色金属





Fluteless Machine Taps

metric ISO-thread DIN 13

挤压丝锥

公制ISO螺纹 DIN 13



DIN 371/376

2.1/2 Thread Start

HSSE-VAP

Tol. ISO2X/6HX

Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
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without Oil Groove / 无油槽

DIN 371

M 3 x 0.5	56	11	3.5	2.7	35550
M 4 x 0.7	63	13	4.5	3.4	35552
M 5 x 0.8	70	16	6.0	4.9	35553
M 6 x 1.0	80	19	6.0	4.9	35554
M 8 x 1.25	90	22	8.0	6.2	35555
M 10 x 1.5	100	24	10.0	8.0	35556

DIN 376

M 12 x 1.75	110	29	9.0	7.0	35557
M 14 x 2.0	110	30	11.0	9.0	35558
M 16 x 2.0	110	32	12.0	9.0	35559

with Oil Groove / 带油槽

DIN 371

M 3 x 0.5	56	11	3.5	2.7	35650
M 4 x 0.7	63	13	4.5	3.4	35652
M 5 x 0.8	70	16	6.0	4.9	35653
M 6 x 1.0	80	19	6.0	4.9	35654
M 8 x 1.25	90	22	8.0	6.2	35655
M 10 x 1.5	100	24	10.0	8.0	35656

DIN 376

M 12 x 1.75	110	29	9.0	7.0	35657
M 14 x 2.0	110	30	11.0	9.0	35658
M 16 x 2.0	110	32	12.0	9.0	35659

Application:

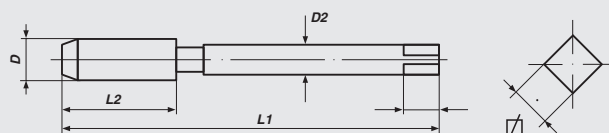
VAP (Steam Tempered):

- for steel up to approx. 700 N/mm²

应用:

VAP(蒸汽处理):

- 用于抗拉强度小于700N/mm²的钢材



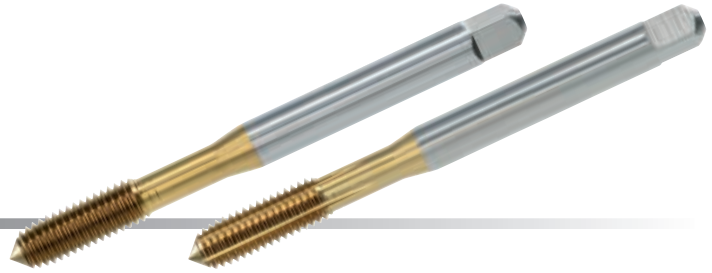


Fluteless Machine Taps

metric ISO-thread DIN 13

挤压丝锥, 带油槽

公制ISO螺纹 DIN 13



DIN 371/376

2.1/2 Thread Start

HSSE-TIN

ToI. ISO2X/6HX

Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
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without Oil Groove / 无油槽

DIN 371					
M 1 x 0.25	40	5	2.5	2.1	35520
M 1.1 x 0.25	40	5	2.5	2.1	35521
M 1.2 x 0.25	40	5	2.5	2.1	35522
M 1.4 x 0.3	40	7	2.5	2.1	35523
M 1.6 x 0.35	40	8	2.5	2.1	35524
M 1.7 x 0.35	40	8	2.5	2.1	35525
M 1.8 x 0.35	40	8	2.5	2.1	35526
M 2 x 0.4	45	8	2.8	2.1	35527
M 2.5 x 0.45	50	9	2.8	2.1	35528
M 3 x 0.5	56	11	3.5	2.7	35530
M 4 x 0.7	63	13	4.5	3.4	35532
M 5 x 0.8	70	16	6.0	4.9	35533
M 6 x 1.0	80	19	6.0	4.9	35534
M 8 x 1.25	90	22	8.0	6.2	35535
M 10 x 1.5	100	24	10.0	8.0	35536
DIN 376					
M 12 x 1.75	110	29	9.0	7.0	35537
M 14 x 2.0	110	30	11.0	9.0	35538
M 16 x 2.0	110	32	12.0	9.0	35539

with Oil Groove / 带油槽

DIN 371					
M 3 x 0.5	56	11	3.5	2.7	35630
M 4 x 0.7	63	13	4.5	3.4	35632
M 5 x 0.8	70	16	6.0	4.9	35633
M 6 x 1.0	80	19	6.0	4.9	35634
M 8 x 1.25	90	22	8.0	6.2	35635
M 10 x 1.5	100	24	10.0	8.0	35636
DIN 376					
M 12 x 1.75	110	29	9.0	7.0	35637
M 14 x 2.0	110	30	11.0	9.0	35638
M 16 x 2.0	110	32	12.0	9.0	35639

Application:

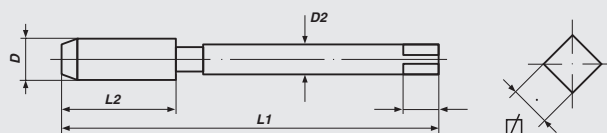
TIN (Titanium Nitride Coating):

- for steel up to approx. 900 N/mm²
and to increase endurance and cutting speed

应用:

TIN(氮化钛涂层)

- 用于抗拉强度小于900N/mm²的钢材
提高耐磨度和切削速度





Fluteless Machine Taps (Forming Taps), *with oversize*

metric ISO-thread DIN 13

挤压丝锥， 中径加大

公制ISO螺纹 DIN 13



DIN 371/376 2.1/2 Thread Start HSS-E Tol. ISO3X/6GX

Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
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without Oil Groove / 无油槽

DIN 371

M 3 x 0.5	56	11	3.5	2.7	35510-6G
M 4 x 0.7	63	13	4.5	3.4	35512-6G
M 5 x 0.8	70	16	6.0	4.9	35513-6G
M 6 x 1.0	80	19	6.0	4.9	35514-6G
M 8 x 1.25	90	22	8.0	6.2	35515-6G
M 10 x 1.5	100	24	10.0	8.0	35516-6G

DIN 376

M 12 x 1.75	110	29	9.0	7.0	35517-6G
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with Oil Groove / 带油槽

DIN 371

M 3 x 0.5	56	11	3.5	2.7	35610-6G
M 4 x 0.7	63	13	4.5	3.4	35612-6G
M 5 x 0.8	70	16	6.0	4.9	35613-6G
M 6 x 1.0	80	19	6.0	4.9	35614-6G
M 8 x 1.25	90	22	8.0	6.2	35615-6G
M 10 x 1.5	100	24	10.0	8.0	35616-6G

DIN 376

M 12 x 1.75	110	29	9.0	7.0	35617-6G
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Application:

tolerance ISO 3 (6G) =
oversize of 0,02 - 0,4 mm
pre plate material for
galvanising

应用:

公差 ISO 3 (6G) =
加大0.02 - 0.4mm
电镀前板材