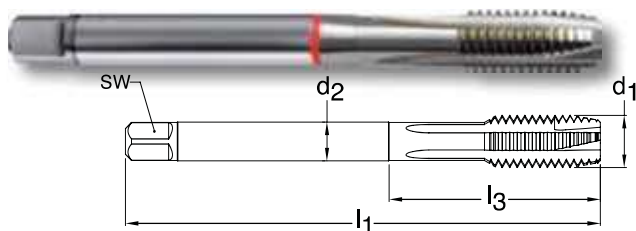


METRIC FINE



Through holes



bright finish



External cooling

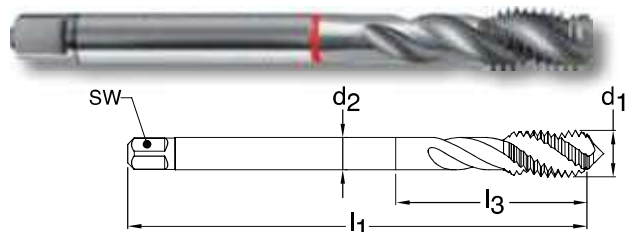
Series 828
Standard DIN 374
Tool Material HSS-E (Cobalt)
Spiral Point Straight flute
Chamfer Form B • 3.5 - 5



Class of Fit ISO 2(6H)

d1 - P	D Limits	Tap Drill Range mm	Number of Flutes	d2 mm	SW mm	l1 mm	l3 mm	Order Code	EDP Number	Stock
M3 X 0.35	D2/D3	2.621 - 2.721	3	2.20	N/A	56.00	N/A	3.002	9008280030020	○
M4 X 0.50	D3/D4	3.459 - 3.599	3	2.80	2.10	63.00	N/A	4.003	9008280040030	○
M5 X 0.50	D3/D4	4.459 - 4.599	3	3.50	2.70	70.00	N/A	5.003	9008280050030	○
M6 X 0.50	D3/D4	5.460 - 5.600	3	4.50	3.40	80.00	N/A	6.003	9008280060030	○
M6 X 0.75	D3/D4	5.188 - 5.378	3	4.50	3.40	80.00	N/A	6.004	9008280060040	●
M8 X 0.75	D3/D4	7.188 - 7.378	3	6.00	4.90	80.00	N/A	8.004	9008280080040	○
M8 X 1.00	D4/D5	6.917 - 7.153	3	6.00	4.90	90.00	N/A	8.005	9008280080050	○
M10 X 1.00	D4/D5	8.917 - 9.153	3	7.00	5.50	90.00	N/A	10.005	9008280100050	○
M12 X 1.00	D4/D5	10.917 - 11.153	4	9.00	7.00	100.00	N/A	12.005	9008280120050	○
M12 X 1.50	D4/D5	10.376 - 10.676	4	9.00	7.00	100.00	N/A	12.007	9008280120070	●
M14 X 1.50	D4/D5	12.376 - 12.676	4	11.00	9.00	100.00	N/A	14.007	9008280140070	●
M16 X 1.50	D4/D5	14.376 - 14.676	4	12.00	9.00	100.00	N/A	16.007	9008280160070	○
M18 X 1.50	D4/D5	16.376 - 16.676	4	14.00	11.00	110.00	N/A	18.007	9008280180070	○
M20 X 1.50	D6/D7	18.376 - 18.676	4	16.00	12.00	125.00	N/A	20.007	9008280200070	●
M22 X 1.50	D6/D7	20.376 - 20.676	4	18.00	14.50	125.00	N/A	22.007	9008280220070	○

METRIC FINE



Blind holes



bright finish



External cooling

Series 835
Standard DIN 374
Tool Material HSS-E (Cobalt)
Spiral Flute 40° Helix
Chamfer Form C • 2-3



Class of Fit ISO 2(6H)

d1 - P	D Limits	Tap Drill Range mm	Number of Flutes	d2 mm	SW mm	l1 mm	l3 mm	Order Code	EDP Number	Stock
M8 X 0.75	D3/D4	7.188 - 7.378	3	6.00	4.90	80.00	N/A	8.004	9008350080040	○
M8 X 1.00	D4/D5	6.917 - 7.153	3	6.00	4.90	90.00	N/A	8.005	9008350080050	●
M10 X 1.00	D4/D5	8.917 - 9.153	3	7.00	5.50	90.00	N/A	10.005	9008350100050	●
M12 X 1.50	D4/D5	10.376 - 10.676	3	9.00	7.00	100.00	N/A	12.007	9008350120070	●
M14 X 1.50	D4/D5	12.376 - 12.676	3	11.00	9.00	100.00	N/A	14.007	9008350140070	●
M16 X 1.50	D4/D5	14.376 - 14.676	4	12.00	9.00	100.00	N/A	16.007	9008350160070	○
M18 X 1.50	D4/D5	16.376 - 16.676	4	14.00	11.00	110.00	N/A	18.007	9008350180070	●
M20 X 1.50	D6/D7	18.376 - 18.676	4	16.00	12.00	125.00	N/A	20.007	9008350200070	●
M22 X 1.50	D6/D7	20.376 - 20.676	5	18.00	14.50	125.00	N/A	22.007	9008350220070	○
M24 X 1.50	D6/D7	22.376 - 22.676	5	18.00	14.50	140.00	N/A	24.007	9008350240070	●

Technical Information

Cutting rate recommendations for **CUT** taps

Material group		Approximate Rc	Approximate HB	Recommended SFM					
				HSS-E		HSS-E-PM		Solid carbide	
				bright finish	hard coated	bright finish	hard coated	bright finish	hard coated
	Structural steels, free-cutting steels		<180	30-50	40-70	50-70	55-95	-	-
	Unalloyed case hardened steels	<20	<230	20-40	30-70	40-65	40-80	-	-
	Unalloyed heat-treatable steels	<25	<250	15-35	25-50	30-60	35-75	-	-
	Structural steels, free-cutting steels	<20	<230	40-50	40-75	40-65	40-80	-	-
	Case hardened steels, heat-treatable steels	<25	<250	30-45	30-65	30-60	35-75	-	-
	Nitriding steels, spheroidal graphite iron	<30	<280	20-30	30-55	30-50	35-65	-	-
		<35	<320	15-25	20-35	25-45	30-60	-	-
		<38	<380	10-25	20-40	20-45	30-55	-	-
	Stainless- and acid-resistant steels, sulphured		<180	25-35	40-55	30-55	35-70	-	-
	austenitic	<25	<250	20-30	30-40	30-50	35-60	-	-
	martensitic	<30	<280	20-30	25-40	25-45	30-50	-	-
		<35	<320	10-20	20-30	20-35	25-50	-	-
	Alloyed case hardened steels	<25	<250	10-20	30-40	30-50	35-70	-	-
	Alloyed heat-treatable steels	<30	<280	25-35	30-50	25-45	35-65	-	-
	Alloyed tool steels	<35	<320	15-30	20-40	20-45	30-60	-	-
	High speed tool steels	<38	<380	8-15	10-30	15-35	25-55	-	-
		<44	<415	-	-	4-10	8-15	4-8	8-16
		<60		-	-	-	4-10	3-6	6-12
	Cast iron		<180	50-70	60-90	55-85	65-110	70-100	80-130
	Spheroidal graphite iron	<25	<250	30-50	45-85	40-70	60-100	70-100	80-130
	Malleable cast iron	<35	<320	15-35	20-40	25-45	35-55	60-110	70-120
	Aluminum and Al-alloys	SILICON CONTENT	WROUGHT ALUMINUM						
		< 6%	n/a	30-50	50-75	50-70	65-80	80-140	90-165
	Al cast alloys	6-10%	n/a	25-35	40-50	40-65	65-80	80-140	90-165
		>10%	n/a	-	25-35	40-65	65-80	60-130	80-140
	Al wrought alloys	n/a	30-80	50-65	65-100	-	-	-	-
		n/a	75-150	35-60	50-65	-	-	-	-
	Titanium and Ti-alloys		140-275	-	-	12-25	20-30	-	-
			300-380	-	-	6-12	10-18	-	-
	Nickel and Ni-alloys		200-300	-	-	6-12	10-18	-	-
			>300	-	-	3-6	6-12	-	-
	Plastics			15-30	-	20-40	-	30-60	-
	Magnesium-alloys			90-140	-	-	-	110-180	-
	Brass, short-chipping			30-45	-	45-60	-	80-100	-
	long-chipping			30-45	-	45-60	-	80-100	-

Technical Information

Tapping Formulas and Calculations

RPM for UNC/UNF Taps

$$\text{RPM} = (\text{revolution / minute}) = \frac{\text{cutting speed (SFM)} \times 3.82}{\text{tap diameter}}$$

Feed Rate for UNC/UNF Taps

$$\text{IPR} = (\text{inch / revolution}) = \frac{1 \text{ inch}}{\text{threads per inch (TPI)}}$$

$$\text{IPM} = (\text{inch / minute}) = \frac{\text{RPM}}{\text{threads per inch (TPI)}}$$

RPM for M/MF Taps

$$\text{RPM} = (\text{revolution / minute}) = \frac{\text{cutting speed (SFM)} \times 97.028}{\text{tap diameter (mm)}}$$

Feed Rate for M/MF Taps

$$\text{IPR} = (\text{inch / revolution}) = \text{pitch (mm)} \times 0.03937$$

$$\text{IPM} = (\text{inch / minute}) = \text{RPM} \times \text{pitch (mm)} \times 0.03937$$

To calculate Tap Drill Size

UNC/UNF and M/MF Cut Taps – General Requirements

$$\text{Tap Drill Size} = \text{Tap basic major diameter} - \text{pitch}$$

UNC/UNF Cut Taps – Special Percentage of Thread Requirements

$$\text{Drill Size} = \text{Basic major diameter} - \frac{0.01299 \times \text{desired percentage of thread}^*}{\text{threads per inch (TPI)}}$$

M/MF Cut Taps – Special Percentage of Thread Requirements

$$\text{Drill Size (mm)} = \text{Basic major diameter} - \frac{\text{desired percentage of thread}^* \times \text{pitch (mm)}}{76.98}$$

UNC/UNF and M/MF Form Taps – General Requirements

$$\text{Tap Drill Size} = \text{Basic major diameter} - \frac{\text{pitch}}{2}$$

UNC/UNF Form Taps – Special Percentage of Thread Requirements

$$\text{Drill Size} = \text{Basic major diameter} - \frac{0.0068 \times \text{desired percentage of thread}^*}{\text{threads per inch (TPI)}}$$

M/MF Form Taps – Special Percentage of Thread Requirements

$$\text{Drill Size (mm)} = \text{Basic major diameter} - \frac{\text{desired percentage of thread}^* \times \text{pitch (mm)}}{147.06}$$

* Actual percentage will vary from desired percentage due to runout of drilling operation.

Technical Information

Troubleshooting - Application problems with new taps

Problem

Possible causes

Solution

1 Thread produced is too large



- incorrect tap, tap geometry not suitable for the application
- tapping size hole too small
- alignment error of tapping size hole or position
- machine spindle axially restricted
- cold welding at the flank of the tap
- lead of tap unsatisfactory due to insufficient thread depth
- cutting speed too high
- insufficient lubrication or coolant supply
- tolerance specification on tap does not correspond to specifications on drawing and/or thread gauge

- apply correct tap for the material to be machined
- observe tapping size hole table in the technical section. Note different tapping size hole diameters for fluteless taps.
- - check for correct tool clamping
- - apply floating tap holder
- - check core drill
- - use mechanical feed
- - apply tension/compression tap chuck
- - apply new tap
- - apply coated tap
- - optimize lubrication
- - tap with forced feed
- - apply tap with modified lead
- - reduce cutting speed
- - improve lubrication
- ensure sufficient and suitable coolant supply and check concentration
- apply correct tap for required tolerances

2 Thread axially miscut



- spiral-fluted taps, corresponding to our design, are applied with too much pressure for initial tapping
- initial tapping pressure too low for taps with spiral point corresponding to our form "B"

- with spiral-fluted taps only light pressure required for initial tapping. The tap should immediately be applied within the tension/compression range
- taps with spiral point or left hand spiral require higher axial pressure. Ensure tap operates within the tension/compression range

3 Thread produced is too small



- tolerance specification on tap does not correspond to specifications on drawing and/or thread gauge
- incorrect tap
- tap does not cut accurately (thread plug gauge)
- machine spindle is axially too rigid

- apply correct tap for required tolerance
- apply correct tap for the material to be machined
- avoid strong axial forces during the cutting process
- apply tension/compression chuck

Troubleshooting - Application problems with new taps

Problem

Possible causes

Solution

4 Thread surface not according to requirements



- cutting edge geometry not suitable for the application
- cutting speed too high
- insufficient coolant (concentration and supply)
- chip congestion
- tapping size hole too small
- with tough, hard materials loading on tool too much or pitch too steep
- built-up edge
- cold welding

- apply "correct" tap for the material to be machined
- - reduce cutting speed
- - optimize lubrication
- ensure suitable coolant and sufficient volume
- apply suitable tap type
- observe tapping size hole diameter specifications to DIN 336 or respective standards. Observe table for fluteless taps
- apply hand tap sets
- apply coated tap
- improve coolant supply

5 Tool life insufficient

- surface hardening of tapping size hole
- reasons listed under: "thread surface not according to requirements"
- chip congestion

- - check drill (cutting edge) for wear
- - heat or surface treatment following thread production
- reasons listed under: thread surface "not according to requirements"
- apply correct tap

6 Tool breakage during advance or return



- tapping size hole too small
- teeth of chamfer lead overloaded
- tap hits bottom of tapping size hole
- - lack of or incorrect chamfer of tapping size hole
- - position or angle error of tapping size hole
- - tool hardness not suitable for the application
- - cutting edge geometry not suitable for the application

- observe tapping size hole dia. acc. to DIN 336 or respective standards
- - longer chamfer lead (blind or through hole)
- - increase no. of teeth of chamfer lead by increasing no. of flutes
- - apply tap sets
- - check hole depth
- - apply tension/compression tap chuck
- - correct chamfer angle of tapping size hole
- - ensure correct tool clamping
- - apply floating tap holder
- - check core drill
- apply suitable tap for the individual application

RED RING CUT TAPS

Alloyed case hardened steels

Alloyed heat-treatable steels

Alloyed tool steels

High speed tool steels

Material group	Approximate Rc	Approximate HB	Recommended SFM					
			HSS-E		HSS-E-PM		Solid carbide	
			bright finish	hard coated	bright finish	hard coated	bright finish	hard coated
Alloyed case hardened steels	<25	<250	25-35	30-50	30-50	35-70	—	—
Alloyed heat-treatable steels	<30	<280	15-30	30-40	25-45	35-65	—	—
Alloyed tool steels	<35	<320	10-20	20-40	20-45	30-60	—	—
High speed tool steels	<38	<380	8-15	10-30	15-35	25-55	—	—
	<44	<415	—	—	4-10	8-15	—	8-16
	<60	—	—	—	—	4-10	—	6-12