

TAPPING - RECOMMENDED VALUES (TOLERANCE ACCORDING TO ISO 2 6H)

Recommended values for use of machine tap drills with tapping attachments on magnetic drills

Tapping: The tap drill to be used must be matched to the core hole prepared in the work piece. Please refer to the enclosed borehole table for metric ISO threads.

Borehole table metric ISO threads

Dimensions	Stg.	Drill Ø
M3	0.5	2.5
M4	0.7	3.3
M5	0.8	4.2
M6	1	5
M8	1.25	6.8
M10	1.5	8.5
M12	1.75	10.2
M14	2	12
M16	2	14
M18	2.5	15.5
M20	2.5	17.5

Fine thread

Dimensions	Stg.	Drill Ø
M8x1	1	7
M10x1	1	9
M12x1	1	11
M12x1.5	1.5	10.5
M14x1	1	13
M14x1.5	1.5	12.5
M16x1	1	15
M16x1.5	1.5	14.5
M20x1	1	19
M20x1.5	1.5	18.5

Tips for the production of threads

1. Clearance hole

We recommend adjacent tap drills for the clearance holes which convey the chips out of the borehole in the cutting direction. The special polished section also allows a reliable re-threading when the tap drill is withdrawn from the tapped hole and moves back in an anticlockwise direction.

2. Blind holes

We recommend adjacent tap drills for blind holes. The chips are guided out of the borehole against the direction of the cutting. It is particularly important to ensure that the tap drill does not run aground, because otherwise the automatic return can no longer be activated. A correspondingly large pre-borehole depth must be planned.

If this is not done, the tap drill must be loosened manually.

3. Blind holes up to 1.5 x D

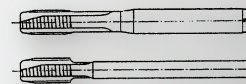
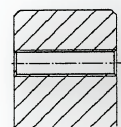
For this, our tap drills are suited to according to the adjacent figure. Also here, the chips are conveyed away out of the borehole against the cutting direction. Also here, it must be ensured that the tap drill does not run aground. A correspondingly large pre-borehole depth must be taken into account.

If this is not done, the tap drill must be loosened manually.

Beside our tap drills with a reinforced shank, tap drills with a reduced shaft according to DIN 376 can, of course, also be used.

Please work with sufficient coolant that is recommended by the manufacturer for tapping.

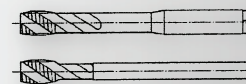
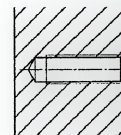
Chip ejection downward through the hole



DIN 371 with a reinforced shank form B, with spiral point, 3.5 to 5 pitches

DIN 376 with a reduced shaft, thread depth 3 x D

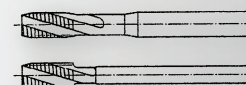
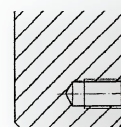
Chip ejection along the tool



DIN 371 with reinforced shank with a spiral groove, approx. 35° right-hand twist bevel C, approx. 3 pitches

DIN 376 with reduced shaft Thread depth 2.5 x D

Chip ejection along the tool



DIN 371 with reinforced shank with a spiral groove, approx. 17° right-hand twist, bevel C, approx. 2 to 3 pitches

DIN 376 with reduced shaft Thread depth 1.5 x D