

THREAD-CUTTING TOOLS

HAND TAPS

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Type and applications overview

	Material	DIN	Type	Cutting direction	Thread	Tenacity classes	Nominal dimension	Item no.	Page/s
	HSS	DIN 352			M	800 N/mm ²	M 2 – M 52	230 xxx	130
	HSSE Co5	DIN 352			M		M 2 – M 24	230 xxx E	
	HSS	DIN 352			M	800 N/mm ²	M 3 – M 20	230 xxx Li	132
	HSS	DIN 2181			MF	800 N/mm ²	MF 3 – MF 52	235 xxx	133
	HSS	DIN 5157			G (BSP)	800 N/mm ²	G 1/8 – G 2"	236 xxx	135
	HSS	DIN 352			Ww (BSW)	800 N/mm ²	1/16 – 2"	246 xxx	136
	HSS	DIN 352			UNC	800 N/mm ²	Nr. 2 – 12 1/4 – 2"	246 xxx UNC	137
	HSS	DIN 2181			UNF	800 N/mm ²	Nr. 2 – 12 1/4 – 1 1/2"	246 xxx UNF	138
	HSS	DIN 352	B		M	800 N/mm ²	M 3 – M 12	231 xxx	142
	HSSE Co5	DIN 352	B		M	1000 N/mm ²		231 xxx E	
	HSS		C		NPT	800 N/mm ²	1/16 – 2"	231 xxx NPT	143
	HSS	DIN 5157	B		G (BSP)	800 N/mm ²	G 1/8 – G 1"	236 2xx	144
	HSS	DIN 22568	B		M	800 N/mm ²	M 2 – M 52	237 xxx	131
	HSSE Co5	DIN 22568	B		M	1000 N/mm ²	M 3 – M 12	238 xxx	
							M 2 – M 24	237 xxx E	
	HSS	DIN 22568	B		M	800 N/mm ²	M 3 – M 20	237 xxx Li	132
	HSS	DIN 22568	B		MF	800 N/mm ²	MF 3 – MF 52	239 xxx	134
	HSS	DIN 24231	B		G (BSP)	800 N/mm ²	G 1/8 – G 2"	240 xxx	135
	HSS	DIN 22568	B		Ww (BSW)	800 N/mm ²	1/16 – 2"	247 xxx	136
	HSS	DIN 22568	B		UNC	800 N/mm ²	Nr. 2 – 12 1/4 – 2"	240 xxx UNC	137
	HSS	DIN 22568	B		UNF	800 N/mm ²	Nr. 2 – 12 1/4 – 1 1/2"	240 xxx UNF	138
	HSS	DIN 382			M	800 N/mm ²	M 3 – M 30	267 xxx	143
	HSS	DIN 382	B		G (BSP)	800 N/mm ²	G 1/8 – G 1"	267 6xx	144



Hand tap M DIN 352

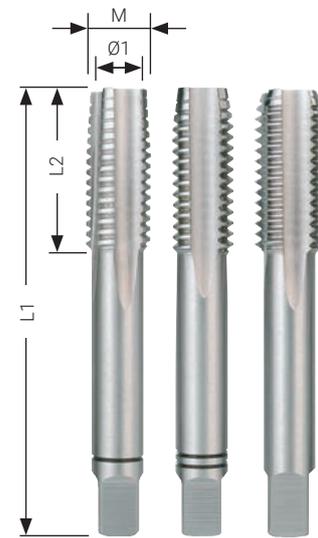


The hand tap consists of high speed steel (HSS). For through threads and bottoming threads in unalloyed and low-alloyed steels, malleable cast iron and non-ferrous metals. The thread is cut in three operation.

Also available individually

Taper tap: 6 - 8-thread chamfer Item no. 230 -1
 Second tap: 4 - 5-thread chamfer Item no. 230 -2
 Final tap: 2 - 3-thread chamfer Item no. 230 -3

Thread: metric, DIN ISO 13
 Flanks: relief-ground



06

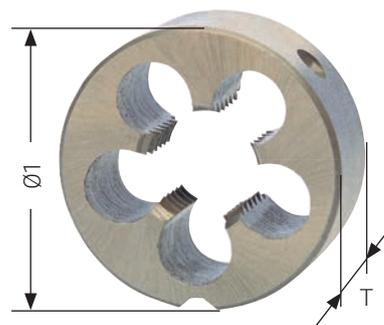
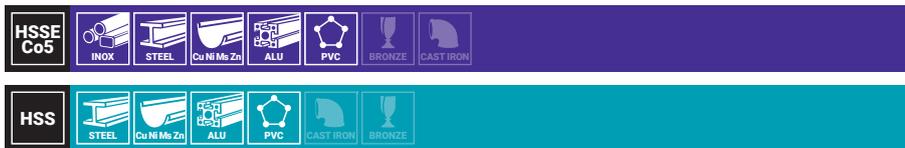
Packaging: plastic

Set consists of 1x taper tap, 1x second tap and 1x final tap

Nominal thread size M	Pitch mm	Thread core hole Ø1 mm	L1 mm	L2 mm	HSSE-Co 5	HSS	
M 2	0.40	1.60	36.0	8.0	230 020 E	230 020	1
M 2.5	0.45	2.10	40.0	8.0	—	230 025	1
M 3	0.50	2.50	40.0	10.0	230 030 E	230 030	1
M 3.5	0.60	2.90	45.0	12.0	—	230 035	1
M 4	0.70	3.30	45.0	12.0	230 040 E	230 040	1
M 4.5	0.75	3.70	50.0	16.0	—	230 045	1
M 5	0.80	4.20	50.0	13.0	230 050 E	230 050	1
M 6	1.00	5.00	56.0	15.0	230 060 E	230 060	1
M 7	1.00	6.00	56.0	16.0	—	230 070	1
M 8	1.25	6.80	56.0	18.0	230 080 E	230 080	1
M 9	1.25	7.80	63.0	22.0	—	230 090	1
M 10	1.50	8.50	70.0	24.0	230 100 E	230 100	1
M 11	1.50	9.50	70.0	24.0	—	230 110	1
M 12	1.75	10.20	75.0	29.0	230 120 E	230 120	1
M 14	2.00	12.00	80.0	30.0	230 140 E	230 140	1
M 15	2.00	13.00	80.0	32.0	—	230 150	1
M 16	2.00	14.00	80.0	32.0	230 160 E	230 160	1
M 18	2.50	15.50	95.0	40.0	230 180 E	230 180	1
M 20	2.50	17.50	95.0	40.0	230 200 E	230 200	1
M 22	2.50	19.50	100.0	40.0	230 220 E	230 220	1
M 24	3.00	21.00	110.0	45.0	230 240 E	230 240	1
M 27	3.00	24.00	110.0	50.0	—	230 270	1
M 30	3.50	26.50	125.0	56.0	—	230 300	1
M 33	3.50	29.50	125.0	56.0	—	230 330	1
M 36	4.00	32.00	150.0	63.0	—	230 360	1
M 39	4.00	35.00	150.0	63.0	—	230 390	1
M 42	4.50	37.50	150.0	63.0	—	230 420	1
M 45	4.50	40.50	160.0	70.0	—	230 450	1
M 48	5.00	43.00	180.0	75.0	—	230 480	1
M 52	5.00	47.00	180.0	75.0	—	230 520	1



Round die M DIN EN 22568



The round die consists of high speed steel in unalloyed and low-alloyed steels up to a strength of 800 N/mm². The round die consists of 5 % cobalt alloyed high speed steel (HSSE-Co 5) in unalloyed and alloyed steels up to a strength of 1000 N/mm² and non-ferrous metals. The thread is cut in one operation.

Thread: metric, DIN ISO 13

Packaging: plastic

Nominal thread size M	Pitch mm	Outside Ø1 mm	Thickness T mm	HSSE-Co 5	HSS	HSS	
M 2	0.40	16.0	5.0	237 020 E	237 020	—	1
M 2.5	0.45	16.0	5.0	—	237 025	—	1
M 3	0.50	20.0	5.0	237 030 E	237 030	—	1
M 3	0.50	25.0	9.0	—	—	238 030	1
M 3.5	0.60	20.0	5.0	—	237 035	—	1
M 4	0.70	20.0	5.0	237 040 E	237 040	—	1
M 4	0.70	25.0	9.0	—	—	238 040	1
M 4.5	0.75	20.0	7.0	—	237 045	—	1
M 5	0.80	20.0	7.0	237 050 E	237 050	—	1
M 5	0.80	25.0	9.0	—	—	238 050	1
M 6	1.00	20.0	7.0	237 060 E	237 060	—	1
M 6	1.00	25.0	9.0	—	—	238 060	1
M 7	1.00	25.0	9.0	—	237 070	—	1
M 8	1.25	25.0	9.0	237 080 E	237 080	238 080	1
M 9	1.25	25.0	9.0	—	237 090	—	1
M 10	1.50	30.0	11.0	237 100 E	237 100	—	1
M 10	1.50	25.0	9.0	—	—	238 100	1
M 11	1.50	30.0	11.0	—	237 110	—	1
M 12	1.75	38.0	14.0	237 120 E	237 120	—	1
M 12	1.75	25.0	9.0	—	—	238 120	1
M 14	2.00	38.0	14.0	237 140 E	237 140	—	1
M 16	2.00	45.0	18.0	237 160 E	237 160	—	1
M 18	2.50	45.0	18.0	237 180 E	237 180	—	1
M 20	2.50	45.0	18.0	237 200 E	237 200	—	1
M 22	2.50	55.0	22.0	237 220 E	237 220	—	1
M 24	3.00	55.0	22.0	237 240 E	237 240	—	1
M 27	3.00	65.0	25.0	—	237 270	—	1
M 30	3.50	65.0	25.0	—	237 300	—	1
M 33	3.50	65.0	25.0	—	237 330	—	1
M 36	4.00	65.0	25.0	—	237 360	—	1
M 39	4.00	75.0	30.0	—	237 390	—	1
M 42	4.50	75.0	30.0	—	237 420	—	1
M 45	4.50	90.0	36.0	—	237 450	—	1
M 48	5.00	90.0	36.0	—	237 480	—	1
M 52	5.00	90.0	36.0	—	237 520	—	1





Hand tap M DIN 352 – left-hand thread



Also available individually

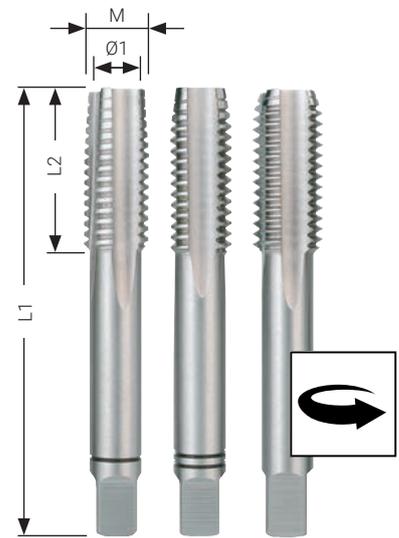
Taper tap: 6 - 8-thread chamfer Item no. 230Li -1

Second tap: 4 - 5-thread chamfer Item no. 230Li -2

Final tap: 2 - 3-thread chamfer Item no. 230Li -3

Thread: metric, DIN ISO 13

Flanks: relief-ground



Packaging: plastic

Set consists of 1x taper tap, 1x second tap and 1x final tap

Nominal thread size M	Pitch mm	Thread core hole Ø1 mm	L1 mm	L2 mm	HSS	
M 3	0.50	2.50	40.0	10.0	230 030 Li	1
M 4	0.70	3.30	45.0	12.0	230 040 Li	1
M 5	0.80	4.20	50.0	13.0	230 050 Li	1
M 6	1.00	5.00	56.0	15.0	230 060 Li	1
M 8	1.25	6.80	56.0	18.0	230 080 Li	1
M 10	1.50	8.50	70.0	24.0	230 100 Li	1
M 12	1.75	10.20	75.0	29.0	230 120 Li	1
M 14	2.00	12.00	80.0	30.0	230 140 Li	1
M 16	2.00	14.00	80.0	32.0	230 160 Li	1
M 18	2.50	15.50	95.0	40.0	230 180 Li	1
M 20	2.50	17.50	95.0	40.0	230 200 Li	1

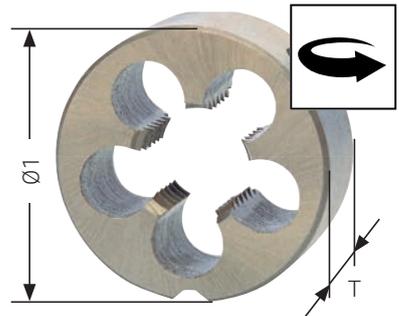


Round die M DIN EN 22568 – left-hand thread



Thread: metric, DIN ISO 13

Packaging: plastic



Nominal thread size M	Pitch mm	Outside Ø1 mm	Thickness T mm	HSS	
M 3	0.50	20.0	5.0	237 030 Li	1
M 4	0.70	20.0	5.0	237 040 Li	1
M 5	0.80	20.0	7.0	237 050 Li	1
M 6	1.00	20.0	7.0	237 060 Li	1
M 7	1.00	25.0	9.0	237 070 Li	1
M 8	1.25	25.0	9.0	237 080 Li	1
M 10	1.50	30.0	11.0	237 100 Li	1
M 12	1.75	38.0	14.0	237 120 Li	1
M 14	2.00	38.0	14.0	237 140 Li	1
M 16	2.00	45.0	18.0	237 160 Li	1
M 18	2.50	45.0	18.0	237 180 Li	1
M 20	2.50	45.0	18.0	237 200 Li	1



Hand tap MF DIN 2181



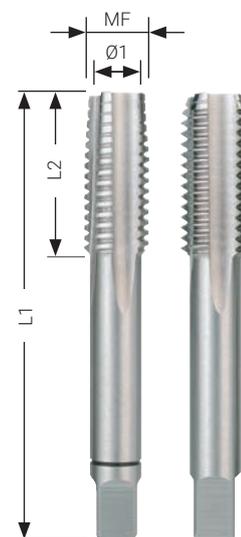
Also available individually

Taper tap: 5 - 6-thread chamfer Item no. 235-1

Final tap: 2 - 3-thread chamfer Item no. 235.....-2

Thread: metric fine, DIN ISO 13

Flanks: relief-ground



Packaging: plastic

Set consists of 1x taper tap and 1x final tap

Nominal thread size MF	Pitch mm	Thread core hole Ø1 mm	L1 mm	L2 mm	HSS	
MF 3	0.35	2.60	40.0	10.0	235 030	1
MF 4	0.35	3.10	45.0	10.0	235 040	1
MF 4	0.50	3.50	45.0	12.0	235 041	1
MF 5	0.50	4.50	50.0	13.0	235 050	1
MF 5	0.75	4.25	50.0	13.0	235 051	1
MF 6	0.50	5.50	50.0	14.0	235 061	1
MF 6	0.75	5.20	50.0	15.0	235 060	1
MF 7	0.75	6.20	50.0	14.0	235 070	1
MF 8	0.50	7.50	50.0	19.0	235 082	1
MF 8	0.75	7.20	56.0	18.0	235 080	1
MF 8	1.00	7.00	56.0	18.0	235 081	1
MF 9	0.75	8.20	56.0	19.0	235 092	1
MF 9	1.00	8.00	63.0	20.0	235 090	1
MF 10	0.75	9.20	63.0	20.0	235 102	1
MF 10	1.00	9.00	63.0	18.0	235 100	1
MF 10	1.25	8.70	70.0	24.0	235 101	1
MF 11	1.00	9.20	63.0	20.0	235 110	1
MF 11	1.25	9.80	63.0	22.0	235 111	1
MF 12	1.00	11.00	70.0	20.0	235 122	1
MF 12	1.25	10.70	70.0	20.0	235 121	1
MF 12	1.50	10.50	70.0	20.0	235 120	1
MF 13	1.00	12.00	70.0	22.0	235 130	1
MF 13	1.50	11.50	70.0	22.0	235 131	1
MF 14	1.00	13.00	70.0	20.0	235 142	1
MF 14	1.25	12.70	70.0	20.0	235 140	1
MF 14	1.50	12.50	70.0	20.0	235 141	1
MF 15	1.50	13.50	70.0	22.0	235 150	1
MF 16	1.00	15.00	70.0	20.0	235 161	1
MF 16	1.25	14.75	70.0	20.0	235 162	1
MF 16	1.50	14.50	70.0	20.0	235 160	1
MF 18	1.00	17.00	80.0	22.0	235 181	1
MF 18	1.25	16.80	80.0	22.0	235 183	1

Nominal thread size MF	Pitch mm	Thread core hole Ø1 mm	L1 mm	L2 mm	HSS	
MF 18	1.50	16.50	80.0	22.0	235 180	1
MF 18	2.00	16.00	80.0	22.0	235 182	1
MF 20	1.00	19.00	80.0	22.0	235 201	1
MF 20	1.25	18.80	80.0	22.0	235 203	1
MF 20	1.50	18.50	80.0	22.0	235 200	1
MF 20	2.00	18.00	80.0	22.0	235 202	1
MF 22	1.00	21.00	80.0	22.0	235 221	1
MF 22	1.50	20.50	80.0	22.0	235 220	1
MF 22	2.00	20.00	80.0	22.0	235 222	1
MF 24	1.00	23.00	90.0	22.0	235 242	1
MF 24	1.50	22.50	90.0	22.0	235 240	1
MF 24	2.00	22.00	90.0	22.0	235 241	1
MF 25	1.50	23.50	90.0	22.0	235 250	1
MF 26	1.50	24.50	90.0	22.0	235 261	1
MF 26	2.00	24.00	90.0	22.0	235 260	1
MF 27	1.50	25.50	90.0	22.0	235 270	1
MF 27	2.00	25.00	90.0	22.0	235 271	1
MF 28	1.50	26.50	90.0	22.0	235 280	1
MF 28	2.00	26.00	90.0	22.0	235 281	1
MF 30	1.00	29.00	90.0	22.0	235 300	1
MF 30	1.50	28.50	90.0	22.0	235 301	1
MF 30	2.00	28.00	90.0	22.0	235 302	1
MF 32	1.50	30.50	90.0	22.0	235 320	1
MF 35	1.50	33.50	100.0	25.0	235 350	1
MF 38	1.50	36.50	110.0	25.0	235 380	1
MF 40	1.50	38.50	110.0	25.0	235 400	1
MF 42	1.50	40.50	110.0	25.0	235 420	1
MF 45	1.50	43.50	110.0	25.0	235 450	1
MF 48	1.50	46.50	125.0	40.0	235 480	1
MF 50	1.50	48.50	125.0	40.0	235 500	1
MF 52	1.50	50.50	125.0	40.0	235 520	1



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Application tip

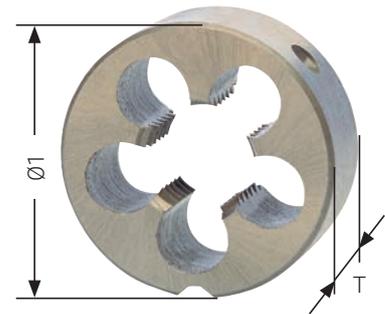
After two rotations of the drill turn back 1/3 rotation to break the chip. Thus the strain on the screw tap decreases. Lubrication with RUKO cutting oil is recommended.



Round die MF DIN EN 22568



Thread: metric fine, DIN ISO 13



Packaging: plastic

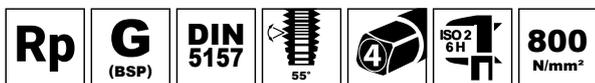
Nominal thread size MF	Pitch mm	Outside Ø1 mm	Thickness T mm	HSS	
MF 3	0.35	20.0	5.0	239 030	1
MF 4	0.35	20.0	5.0	239 040	1
MF 4	0.50	20.0	5.0	239 041	1
MF 5	0.50	20.0	5.0	239 050	1
MF 5	0.75	20.0	7.0	239 051	1
MF 6	0.50	20.0	5.0	239 061	1
MF 6	0.75	20.0	7.0	239 060	1
MF 7	0.75	25.0	9.0	239 070	1
MF 8	0.50	25.0	9.0	239 082	1
MF 8	0.75	25.0	9.0	239 080	1
MF 8	1.00	25.0	9.0	239 081	1
MF 9	0.75	25.0	9.0	239 090	1
MF 9	1.00	25.0	9.0	239 091	1
MF 10	0.75	30.0	11.0	239 102	1
MF 10	1.00	30.0	11.0	239 100	1
MF 10	1.25	30.0	11.0	239 101	1
MF 11	1.00	30.0	11.0	239 110	1
MF 11	1.25	30.0	11.0	239 111	1
MF 12	1.00	38.0	10.0	239 121	1
MF 12	1.25	38.0	10.0	239 122	1
MF 12	1.50	38.0	10.0	239 120	1
MF 13	1.00	38.0	10.0	239 131	1
MF 13	1.50	38.0	10.0	239 130	1
MF 14	1.00	38.0	10.0	239 142	1
MF 14	1.25	38.0	10.0	239 140	1
MF 14	1.50	38.0	10.0	239 141	1
MF 15	1.50	38.0	10.0	239 150	1
MF 16	1.00	45.0	14.0	239 161	1
MF 16	1.25	45.0	14.0	239 162	1
MF 16	1.50	45.0	14.0	239 160	1
MF 18	1.00	45.0	14.0	239 181	1
MF 18	1.25	45.0	14.0	239 183	1

Nominal thread size MF	Pitch mm	Outside Ø1 mm	Thickness T mm	HSS	
MF 18	1.50	45.0	14.0	239 180	1
MF 18	2.00	45.0	14.0	239 182	1
MF 20	1.00	45.0	14.0	239 201	1
MF 20	1.25	45.0	14.0	239 203	1
MF 20	1.50	45.0	14.0	239 200	1
MF 20	2.00	45.0	14.0	239 202	1
MF 22	1.00	55.0	16.0	239 221	1
MF 22	1.50	55.0	16.0	239 220	1
MF 22	2.00	55.0	16.0	239 222	1
MF 24	1.00	55.0	16.0	239 242	1
MF 24	1.50	55.0	16.0	239 240	1
MF 24	2.00	55.0	16.0	239 241	1
MF 25	1.50	55.0	16.0	239 250	1
MF 26	1.50	55.0	16.0	239 261	1
MF 26	2.00	55.0	16.0	239 262	1
MF 27	1.50	65.0	18.0	239 270	1
MF 27	2.00	65.0	18.0	239 271	1
MF 28	1.50	65.0	18.0	239 281	1
MF 28	2.00	65.0	18.0	239 282	1
MF 30	1.00	65.0	18.0	239 300	1
MF 30	1.50	65.0	18.0	239 301	1
MF 30	2.00	65.0	18.0	239 302	1
MF 32	1.50	65.0	18.0	239 320	1
MF 35	1.50	65.0	18.0	239 350	1
MF 38	1.50	75.0	20.0	239 380	1
MF 40	1.50	75.0	20.0	239 400	1
MF 42	1.50	75.0	20.0	239 420	1
MF 45	1.50	90.0	22.0	239 450	1
MF 48	1.50	90.0	22.0	239 480	1
MF 50	1.50	90.0	22.0	239 500	1
MF 52	1.50	90.0	22.0	239 520	1



Application tip

It is recommended that the threading dies are turned back briefly now and then so that the chips break and do not clog the threads. Lubrication with RUKO cutting oil is recommended.



Hand tap G DIN 5157



Also available individually

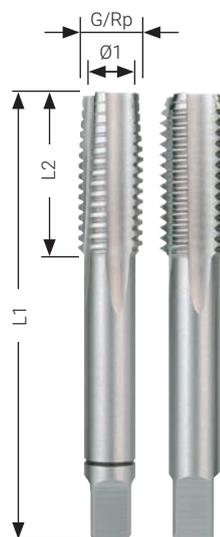
Taper tap: 5 - 6-thread chamfer Item no. 236-1

Final tap: 2 - 3-thread chamfer Item no. 236.....-2

Thread: DIN ISO 228 "G" (cylindrical pipe thread)

DIN 2999 "Rp" (Whitworth pipe thread)

Flanks: relief-ground



Packaging: plastic

Set consists of 1x taper tap and 1x final tap

Nominal thread size G	Nominal thread size Rp	Threads per inch	Thread core hole Ø1 mm	L1 mm	L2 mm	HSS	
G 1/8"	Rp 1/8"	28	8.80	63.0	18.0	236 018	1
G 1/4"	Rp 1/4"	19	11.80	70.0	20.0	236 014	1
G 3/8"	Rp 3/8"	19	15.25	70.0	20.0	236 038	1
G 1/2"	Rp 1/2"	14	19.00	80.0	22.0	236 012	1
G 5/8"	Rp 5/8"	14	21.00	80.0	22.0	236 058	1
G 3/4"	Rp 3/4"	14	24.50	90.0	22.0	236 034	1
G 7/8"	Rp 7/8"	14	28.25	90.0	22.0	236 078	1
G 1"	Rp 1"	11	30.75	100.0	25.0	236 010	1
G 1 1/8"	Rp 1 1/8"	11	35.30	125.0	40.0	236 118	1
G 1 1/4"	Rp 1 1/4"	11	39.25	125.0	40.0	236 114	1
G 1 3/8"	Rp 1 3/8"	11	41.70	140.0	40.0	236 138	1
G 1 1/2"	Rp 1 1/2"	11	45.25	140.0	40.0	236 112	1
G 1 3/4"	Rp 1 3/4"	11	51.10	140.0	40.0	236 134	1
G 2"	Rp 2"	11	57.00	160.0	40.0	236 020	1

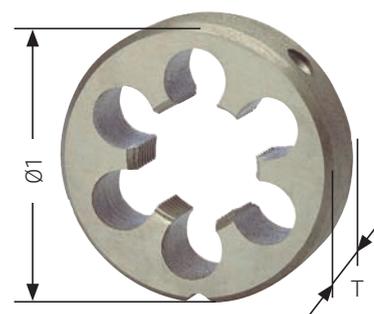


Round die G DIN EN 24231



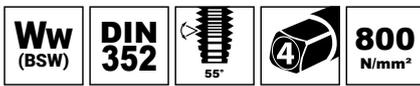
Thread: DIN ISO 228 "G" (cylindrical pipe thread)

Packaging: plastic



Nominal thread size G	Threads per inch	Outside Ø1 mm	Thickness T mm	HSS	
G 1/8"	28	30.0	11.0	240 018	1
G 1/4"	19	38.0	10.0	240 014	1
G 3/8"	19	45.0	14.0	240 038	1
G 1/2"	14	45.0	14.0	240 012	1
G 5/8"	14	55.0	16.0	240 058	1
G 3/4"	14	55.0	16.0	240 034	1
G 7/8"	14	65.0	18.0	240 078	1
G 1"	11	65.0	18.0	240 010	1

Nominal thread size G	Threads per inch	Outside Ø1 mm	Thickness T mm	HSS	
G 1 1/8"	11	75.0	20.0	240 118	1
G 1 1/4"	11	75.0	20.0	240 114	1
G 1 3/8"	11	90.0	22.0	240 138	1
G 1 1/2"	11	90.0	22.0	240 112	1
G 1 5/8"	11	90.0	22.0	240 158	1
G 1 3/4"	11	105.0	22.0	240 134	1
G 2"	11	105.0	22.0	240 020	1



Hand tap BSW ≈ DIN 352



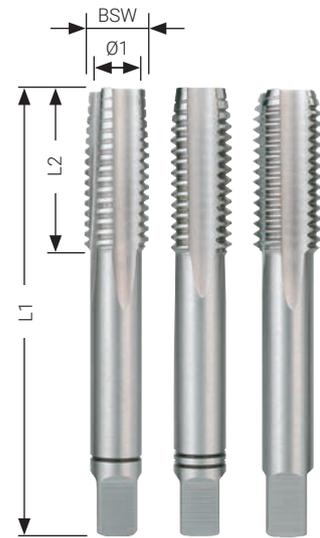
Also available individually

Taper tap: 5 - 6-thread chamfer Item no. 246-1
 Second tap: 4 - 5-thread chamfer Item no. 246-2
 Final tap: 2 - 3-thread chamfer Item no. 246-3

Thread: BSW, formerly DIN 11
 Flanks: relief-ground

Packaging: plastic

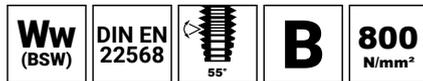
Set consists of 1x taper tap, 1x second tap and 1x final tap



Nominal thread size BSW	Threads per inch	Thread core hole Ø1 mm	L1 mm	L2 mm	HSS	
1/16"	60	1.15	32.0	7.0	246 116	1
3/32"	48	1.80	40.0	8.0	246 332	1
1/8"	40	2.50	40.0	10.0	246 018	1
5/32"	32	3.10	45.0	12.0	246 532	1
3/16"	24	3.60	50.0	13.0	246 316	1
7/32"	24	4.40	50.0	15.0	246 732	1
1/4"	20	5.10	50.0	16.0	246 014	1
5/16"	18	6.50	56.0	18.0	246 516	1
3/8"	16	7.90	70.0	24.0	246 038	1
7/16"	14	9.30	70.0	24.0	246 716	1
1/2"	12	10.50	80.0	30.0	246 012	1
9/16"	12	12.00	80.0	30.0	246 916	1

Nominal thread size BSW	Threads per inch	Thread core hole Ø1 mm	L1 mm	L2 mm	HSS	
5/8"	11	13.50	80.0	32.0	246 058	1
3/4"	10	16.50	95.0	40.0	246 034	1
7/8"	9	19.25	100.0	40.0	246 078	1
1"	8	22.00	110.0	50.0	246 010	1
1 1/8"	7	24.75	125.0	50.0	246 118	1
1 1/4"	7	27.75	125.0	50.0	246 114	1
1 3/8"	6	30.20	150.0	63.0	246 138	1
1 1/2"	6	33.50	150.0	63.0	246 112	1
1 5/8"	5	35.50	150.0	63.0	246 158	1
1 3/4"	5	38.50	160.0	70.0	246 134	1
1 7/8"	4 1/2	41.50	180.0	75.0	246 178	1
2"	4 1/2	44.50	180.0	75.0	246 020	1

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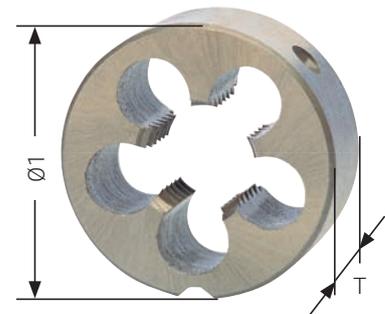


Round die BSW ≈ DIN EN 22568



Thread: BSW, formerly DIN 11

Packaging: plastic



Nominal thread size BSW	Threads per inch	Outside Ø1 mm	Thickness T mm	HSS	
1/16"	60	16.0	5.0	247 116	1
3/32"	48	16.0	5.0	247 332	1
1/8"	40	20.0	5.0	247 018	1
5/32"	32	20.0	5.0	247 532	1
3/16"	24	20.0	7.0	247 316	1
7/32"	24	20.0	7.0	247 732	1
1/4"	20	25.0	9.0	247 014	1
5/16"	18	25.0	9.0	247 516	1
3/8"	16	30.0	11.0	247 038	1
7/16"	14	30.0	11.0	247 716	1
1/2"	12	38.0	14.0	247 012	1
9/16"	12	38.0	14.0	247 916	1

Nominal thread size BSW	Threads per inch	Outside Ø1 mm	Thickness T mm	HSS	
5/8"	11	45.0	18.0	247 058	1
3/4"	10	45.0	18.0	247 034	1
7/8"	9	55.0	22.0	247 078	1
1"	8	55.0	22.0	247 010	1
1 1/8"	7	65.0	25.0	247 118	1
1 1/4"	7	65.0	25.0	247 114	1
1 3/8"	6	65.0	25.0	247 138	1
1 1/2"	6	75.0	30.0	247 112	1
1 5/8"	5	75.0	30.0	247 158	1
1 3/4"	5	90.0	36.0	247 134	1
1 7/8"	4 1/2	90.0	36.0	247 178	1
2"	4 1/2	90.0	36.0	247 020	1



Hand tap UNC ≈ DIN 352

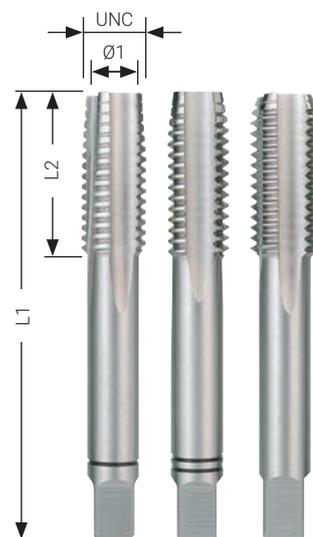


Also available individually

Taper tap: 5 - 6-thread chamfer Item no. 246**UNC1**
 Second tap: 4 - 5-thread chamfer Item no. 246.....**UNC2**
 Final tap: 2 - 3-thread chamfer Item no. 246.....**UNC3**

Thread: American UNC coarse thread
 Flanks: relief-ground

Packaging: plastic
 Set consists of 1x taper tap, 1x second tap and 1x final tap



Nominal thread size UNC	Threads per inch	Thread core hole Ø1 mm	L1 mm	L2 mm	HSS	
Nr. 2	56	1.8	36.0	11.0	246 020 UNC	1
Nr. 3	48	2.1	36.0	11.0	246 030 UNC	1
Nr. 4	40	2.3	40.0	12.0	246 040 UNC	1
Nr. 5	40	2.6	40.0	12.0	246 050 UNC	1
Nr. 6	32	2.8	45.0	14.0	246 060 UNC	1
Nr. 8	32	3.5	45.0	14.0	246 080 UNC	1
Nr. 10	24	3.9	50.0	16.0	246 100 UNC	1
Nr. 12	24	4.5	50.0	18.0	246 120 UNC	1
1/4"	20	5.1	50.0	19.0	246 014 UNC	1
5/16"	18	6.6	56.0	22.0	246 516 UNC	1
3/8"	16	8.0	70.0	24.0	246 038 UNC	1
7/16"	14	9.4	70.0	24.0	246 716 UNC	1

Nominal thread size UNC	Threads per inch	Thread core hole Ø1 mm	L1 mm	L2 mm	HSS	
1/2"	13	10.8	75.0	29.0	246 012 UNC	1
9/16"	12	12.2	80.0	30.0	246 916 UNC	1
5/8"	11	13.5	80.0	32.0	246 058 UNC	1
3/4"	10	16.5	95.0	40.0	246 034 UNC	1
7/8"	9	19.5	100.0	40.0	246 078 UNC	1
1"	8	22.2	110.0	50.0	246 010 UNC	1
1 1/8"	7	25.0	132.0	56.0	246 118 UNC	1
1 1/4"	7	28.0	132.0	56.0	246 114 UNC	1
1 3/8"	6	30.7	150.0	63.0	246 138 UNC	1
1 1/2"	6	34.0	150.0	63.0	246 112 UNC	1
1 3/4"	5	39.5	160.0	70.0	246 134 UNC	1
2"	4 1/2	45.0	190.0	80.0	246 200 UNC	1

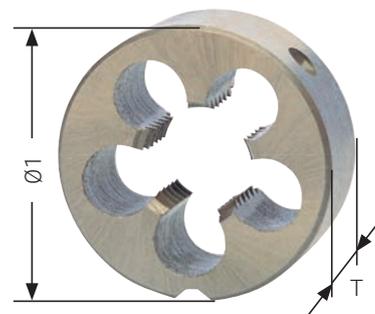


Round die UNC ≈ DIN EN 22568



Thread: American UNC coarse thread

Packaging: plastic



Nominal thread size UNC	Threads per inch	Outside Ø1 mm	Thickness T mm	HSS	
Nr. 2	56	16.0	5.0	240 020 UNC	1
Nr. 3	48	16.0	5.0	240 030 UNC	1
Nr. 4	40	20.0	5.0	240 040 UNC	1
Nr. 5	40	20.0	5.0	240 050 UNC	1
Nr. 6	32	20.0	7.0	240 060 UNC	1
Nr. 8	32	20.0	7.0	240 080 UNC	1
Nr. 10	24	20.0	7.0	240 100 UNC	1
Nr. 12	24	20.0	7.0	240 120 UNC	1
1/4"	20	20.0	7.0	240 014 UNC	1
5/16"	18	25.0	9.0	240 516 UNC	1
3/8"	16	30.0	11.0	240 038 UNC	1
7/16"	14	30.0	11.0	240 716 UNC	1

Nominal thread size UNC	Threads per inch	Outside Ø1 mm	Thickness T mm	HSS	
1/2"	13	38.0	14.0	240 012 UNC	1
9/16"	12	38.0	14.0	240 916 UNC	1
5/8"	11	45.0	18.0	240 058 UNC	1
3/4"	10	45.0	18.0	240 034 UNC	1
7/8"	9	55.0	22.0	240 078 UNC	1
1"	8	55.0	22.0	240 010 UNC	1
1 1/8"	7	65.0	25.0	240 118 UNC	1
1 1/4"	7	65.0	25.0	240 114 UNC	1
1 3/8"	6	65.0	25.0	240 138 UNC	1
1 1/2"	6	75.0	30.0	240 112 UNC	1
1 3/4"	5	90.0	36.0	240 134 UNC	1
2"	4.5	90.0	36.0	240 200 UNC	1



Hand tap UNF ≈ DIN 2181



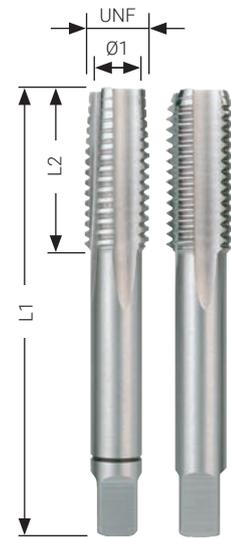
Also available individually

Taper tap: 5 - 6-thread chamfer Item no. 246**UNF1**

Final tap: 2 - 3-thread chamfer Item no. 246.....**UNF2**

Thread: American UNF coarse thread

Flanks: relief-ground



Packaging: plastic

Set consists of 1x taper tap and 1x final tap

Nominal thread size UNF	Threads per inch	Thread core hole Ø1 mm	L1 mm	L2 mm	HSS	
Nr. 2	64	1.85	32.0	10.0	246 020 UNF	1
Nr. 3	56	2.15	32.0	10.0	246 030 UNF	1
Nr. 4	48	2.40	36.0	11.0	246 040 UNF	1
Nr. 5	44	2.70	36.0	11.0	246 050 UNF	1
Nr. 6	40	2.95	40.0	12.0	246 060 UNF	1
Nr. 8	36	3.50	40.0	12.0	246 080 UNF	1
Nr. 10	32	4.10	45.0	14.0	246 100 UNF	1
Nr. 12	28	4.60	50.0	14.0	246 120 UNF	1
1/4"	28	5.50	50.0	18.0	246 014 UNF	1
5/16"	24	6.90	56.0	22.0	246 516 UNF	1
3/8"	24	8.50	63.0	22.0	246 038 UNF	1

Nominal thread size UNF	Threads per inch	Thread core hole Ø1 mm	L1 mm	L2 mm	HSS	
7/16"	20	9.90	63.0	22.0	246 716 UNF	1
1/2"	20	11.50	75.0	24.0	246 012 UNF	1
9/16"	18	12.90	80.0	28.0	246 916 UNF	1
5/8"	18	14.50	80.0	28.0	246 058 UNF	1
3/4"	16	17.50	95.0	32.0	246 034 UNF	1
7/8"	14	20.50	100.0	36.0	246 078 UNF	1
1"	12	23.25	110.0	40.0	246 010 UNF	1
1 1/8"	12	22.00	110.0	50.0	246 118 UNF	1
1 1/4"	12	22.00	132.0	56.0	246 114 UNF	1
1 3/8"	12	28.00	132.0	56.0	246 138 UNF	1
1 1/2"	12	32.00	150.0	63.0	246 112 UNF	1

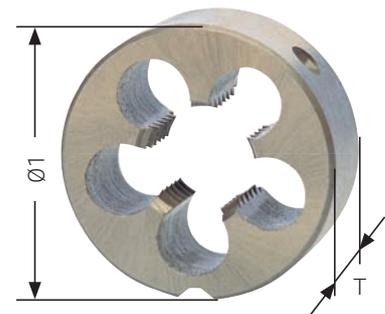


Round die UNF ≈ DIN EN 22568



Thread: American UNF coarse thread

Packaging: plastic



Nominal thread size UNF	Threads per inch	Outside Ø1 mm	Thickness T mm	HSS	
Nr. 2	64	16.0	5.0	240 020 UNF	1
Nr. 3	56	16.0	5.0	240 030 UNF	1
Nr. 4	48	16.0	5.0	240 040 UNF	1
Nr. 5	44	20.0	5.0	240 050 UNF	1
Nr. 6	40	20.0	5.0	240 060 UNF	1
Nr. 8	36	20.0	7.0	240 080 UNF	1
Nr. 10	32	20.0	7.0	240 100 UNF	1
Nr. 12	28	20.0	7.0	240 120 UNF	1
1/4"	28	20.0	7.0	240 014 UNF	1
5/16"	24	25.0	9.0	240 516 UNF	1
3/8"	24	30.0	11.0	240 038 UNF	1

Nominal thread size UNF	Threads per inch	Outside Ø1 mm	Thickness T mm	HSS	
7/16"	20	30.0	11.0	240 716 UNF	1
1/2"	20	38.0	10.0	240 012 UNF	1
9/16"	18	38.0	10.0	240 916 UNF	1
5/8"	18	45.0	14.0	240 058 UNF	1
3/4"	16	45.0	14.0	240 034 UNF	1
7/8"	14	55.0	16.0	240 078 UNF	1
1"	12	55.0	16.0	240 010 UNF	1
1 1/8"	12	65.0	18.0	240 118 UNF	1
1 1/4"	12	65.0	18.0	240 114 UNF	1
1 3/8"	12	65.0	18.0	240 138 UNF	1
1 1/2"	12	75.0	20.0	240 112 UNF	1

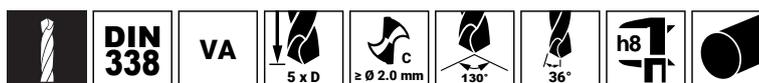


Hand tap sets HSS and HSSE-Co 5



245 001 RO

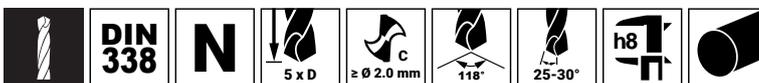
		HSSE-Co 5	HSS
21 tfg./pcs.	Hand tap set M DIN 352 one three-piece set each of M 3 M 4 M 5 M 6 M 8 M 10 M 12 in plastic case	245 001 ERO	245 001 RO
22 tfg./pcs.	Hand tap set M DIN 352 one three-piece set each of M 3 M 4 M 5 M 6 M 8 M 10 M 12 1 tap wrench DIN 1814 size 11/2 in steel case	245 002 E	245 002



Hand tap and twist drill sets



		HSSE-Co 5
29 tfg./pcs.	Hand tap and twist drill set in steel case Hand taps M DIN 352 one three-piece set each of M 3 M 4 M 5 M 6 M 8 M 10 M 12 7 twist drills DIN 338 type VA Ø 2.5 3.3 4.2 5.0 6.8 8.5 10.2 mm 1 tap wrench DIN 1814 size 11/2	245 003 E
28 tfg./pcs.	Hand tap and twist drill set in plastic case Hand taps M DIN 352 one three-piece set each of M 3 M 4 M 5 M 6 M 8 M 10 M 12 7 twist drills DIN 338 type VA Ø 2.5 3.3 4.2 5.0 6.8 8.5 10.2 mm	245 003 ERO
44 tfg./pcs.	Hand tap and twist drill set in tool magazine Hand taps M DIN 352 one three-piece set each of M 3 M 4 M 5 M 6 M 8 M 10 M 12 7 twist drills DIN 338 type VA Ø 2.5 3.3 4.2 5.0 6.8 8.5 10.2 mm 7 dies M DIN EN 22568 - M 3 M 4 M 5 M 6 M 8 M 10 M 12 5 die stocks DIN 225 - 20.0 x 5.0 20.0 x 7.0 25.0 x 9.0 30.0 x 11.0 38.0 x 14.0 mm 2 tap wrenches DIN 1814 size 1 and size 2 1 screwdriver 1 screw-pitch gauge	245 030 E



Hand tap and twist drill sets



		HSS
29 fig./pcs.	Hand tap and twist drill set in steel case Hand taps M DIN 352 one three-piece set each of M 3 M 4 M 5 M 6 M 8 M 10 M 12 7 twist drills DIN 338 type N Ø 2.5 3.3 4.2 5.0 6.8 8.5 10.2 mm 1 tap wrench DIN 1814 size 11/2	245 003
28 fig./pcs.	Hand tap and twist drill set in plastic case Hand taps M DIN 352 one three-piece set each of M 3 M 4 M 5 M 6 M 8 M 10 M 12 7 twist drills DIN 338 type N Ø 2.5 3.3 4.2 5.0 6.8 8.5 10.2 mm	245 003 RO
44 fig./pcs.	Hand tap and twist drill set in tool magazine Hand taps M DIN 352 one three-piece set each of M 3 M 4 M 5 M 6 M 8 M 10 M 12 7 twist drills DIN 338 type N Ø 2.5 3.3 4.2 5.0 6.8 8.5 10.2 mm 7 dies M DIN EN 22568 - M 3 M 4 M 5 M 6 M 8 M 10 M 12 5 die stocks DIN 225 - 20.0 x 5.0 20.0 x 7.0 25.0 x 9.0 30.0 x 11.0 38.0 x 14.0 mm 2 tap wrenches DIN 1814 size 1 and size 2 1 screwdriver 1 screw-pitch gauge	245 030



245 003



245 003 RO



245 030



Thread-cutting sets



		HSSE-Co 5	HSS
31 tfg./pcs.	DIY thread-cutting toolsset one three-piece set each of hand taps M DIN 352 M 3 M 4 M 5 M 6 M 8 M 10 M 12 + 7 dies Ø 25.0 mm ≈ DIN EN 22568 M 3 M 4 M 5 M 6 M 8 M 10 M 12 + 1 die stock DIN 225 - 25.0 x 9.0 mm + 1 tap wrench, size 1½ DIN 1814 + 1 screwdriver	245 010 E	245 010
37 tfg./pcs.	Thread-cutting tool set one three-piece set each of hand taps M DIN 352 M 3 M 4 M 5 M 6 M 8 M 10 M 12 + 7 dies M DIN EN 22568 M 3 M 4 M 5 M 6 M 8 M 10 M 12 + 5 die stocks DIN 225 20.0 x 5.0 20.0 x 7.0 25.0 x 9.0 30.0 x 11.0 38.0 x 14.0 mm + 2 tap wrenches DIN 1814 size 1 and size 2 + 1 screwdriver + 1 screw-pitch gauge	245 020 E	245 020
54 tfg./pcs.	Thread-cutting tool set one three-piece set each of hand taps M DIN 352 M 3 M 4 M 5 M 6 M 8 M 10 M 12 M 14 M 16 M 18 M 20 + 11 dies M DIN EN 22568 M 3 M 4 M 5 M 6 M 8 M 10 M 12 M 14 M 16 M 18 M 20 + 6 die stocks DIN 225 20.0 x 5.0 20.0 x 7.0 25.0 x 9.0 30.0 x 11.0 38.0 x 14.0 45.0 x 18.0 mm + 2 tap wrenches DIN 1814 size 1 and size 3 + 1 screwdriver + 1 screw-pitch gauge	245 040 E	245 040
43 tfg./pcs.	Thread-cutting tool set MF (metric fine) one two-piece set each of hand taps MF DIN 2181 MF 3 MF 4 MF 5 MF 6 MF 8 MF 10 MF 12 MF 14 MF 16 MF 18 MF 20 + 11 dies MF DIN 22568 MF 3 MF 4 MF 5 MF 6 MF 8 MF 10 MF 12 MF 14 MF 16 MF 18 MF 20 + 6 die stocks DIN 225 20.0 x 5.0 20.0 x 7.0 25.0 x 9.0 30.0 x 11.0 38.0 x 10.0 45.0 x 14.0 mm + 2 tap wrenches DIN 1814 size 1 and size 3 + 1 screwdriver + 1 screw-pitch gauge	—	245 041



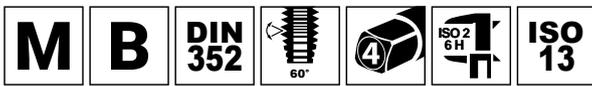
245 010 E



245 020



245 040



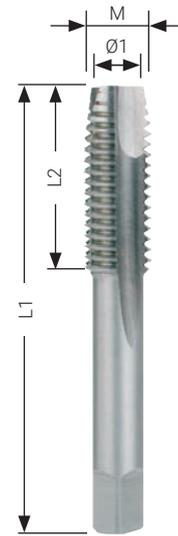
Single-cut tap M ≈ DIN 352



The single-cut tap HSS for through threads in unalloyed and low-alloyed steels up to a strength of 800 N/mm². The single-cut tap HSSE-Co 5 for through threads in unalloyed and alloyed steels up to a strength of 1000 N/mm², malleable cast iron and non-ferrous metals. The thread can be cut in one operation by hand or machine.

Thread: metric, DIN ISO 13
Flanks: relief-ground

Packaging: plastic
Set consists of 1x Taper tap, 1x Second tap and 1x Final tap



06

Nominal thread size M	Pitch mm	Thread core hole Ø1 mm	L1 mm	L2 mm	HSSE-Co 5	HSS	
M 3	0.50	2.50	40.0	10.0	231 030 E	231 030	1
M 4	0.70	3.30	45.0	12.0	231 040 E	231 040	1
M 5	0.80	4.20	50.0	13.0	231 050 E	231 050	1
M 6	1.00	5.00	50.0	15.0	231 060 E	231 060	1
M 8	1.25	6.80	56.0	18.0	231 080 E	231 080	1
M 9	1.25	7.80	67.0	22.0	—	231 090	1
M 10	1.50	8.50	70.0	24.0	231 100 E	231 100	1
M 12	1.75	10.20	75.0	29.0	231 120 E	231 120	1

Single-cut tap + ULTIMATECUT twist drill type FLOWSTEP® set



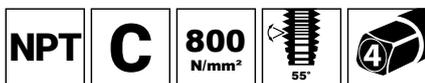
		HSS
15 fig./pcs.	Single-cut tap set 7 single-cut taps ≈ DIN 352 HSS, ground M 3 M 4 M 5 M 6 M 8 M 10 M 12 + 7 ULTIMATECUT twist drills DIN 338 type FLOWSTEP® HSS Ø 2.5 3.3 4.2 5.0 6.8 8.5 10.2 mm + 1 tap wrench, size 1 1/2 DIN 1814	259 004 RO



Single-cut tap + twist drill set DIN 338 type N set

		HSS
15 fig./pcs.	Single-cut tap set 7 single-cut taps ≈ DIN 352 HSS, ground M 3 M 4 M 5 M 6 M 8 M 10 M 12 + 7 twist drills DIN 338 type N HSS, ground Ø 2.5 3.3 4.2 5.0 6.8 8.5 10.2 mm + 1 tap wrench, size 1 1/2 DIN 1814	245 004 RO





Single-cut tap NPT

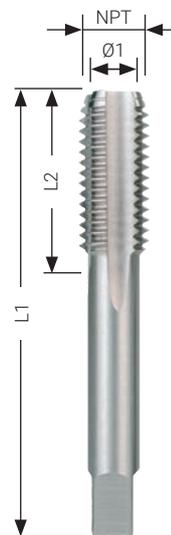


For through threads in unalloyed or low-alloyed steels up to 800 N/mm² strength, malleable cast iron and non-ferrous metals. The thread can be cut in one operation by hand or machine.

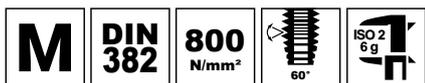
Note: pilot drill cylindrically

Thread: American conical pipe thread to ANSI B.1.20.1
 Flanks: relief-ground
 Cone: 1:16

Packaging: plastic



Nominal thread size NPT	Threads per inch	Thread core hole Ø1 mm	Cutting depth mm	L1 mm	L2 mm	HSS	
1/16"	27.0	6.00	12.00	65.0	19.0	231 116 NPT	1
1/8"	27.0	8.25	12.00	65.0	19.0	231 018 NPT	1
1/4"	18.0	10.70	17.50	70.0	25.0	231 014 NPT	1
3/8"	18.0	14.10	17.50	75.0	26.0	231 038 NPT	1
1/2"	14.0	17.40	22.90	80.0	31.0	231 012 NPT	1
3/4"	14.0	22.60	23.00	100.0	33.0	231 034 NPT	1
1"	11.5	28.50	27.40	110.0	38.0	231 010 NPT	1
1 1/4"	11.5	37.00	28.10	125.0	41.0	231 114 NPT	1
1 1/2"	11.5	43.50	28.40	140.0	42.0	231 112 NPT	1
2"	11.5	55.00	28.40	160.0	44.0	231 020 NPT	1

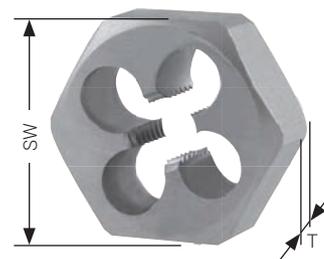


Hexagonal die nut M DIN 382



Thread: metric, DIN ISO 13

Packaging: plastic



Nominal thread size M	Pitch mm	Outside Ø SW mm	Thickness T mm	HSS	
M 3	0.50	18.0	5.0	267 030	1
M 4	0.70	18.0	5.0	267 040	1
M 5	0.80	18.0	7.0	267 050	1
M 6	1.00	18.0	7.0	267 060	1
M 8	1.25	21.0	9.0	267 080	1
M 10	1.50	27.0	11.0	267 100	1
M 12	1.75	36.0	14.0	267 120	1
M 14	2.00	36.0	14.0	267 140	1

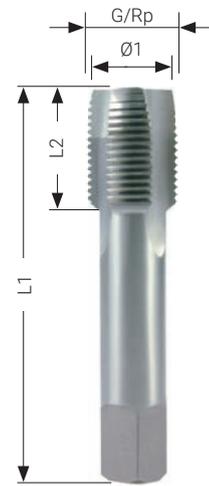
Nominal thread size M	Pitch mm	Outside Ø SW mm	Thickness T mm	HSS	
M 16	2.00	41.0	18.0	267 160	1
M 18	2.50	41.0	18.0	267 180	1
M 20	2.50	41.0	18.0	267 200	1
M 22	2.50	50.0	22.0	267 220	1
M 24	3.00	50.0	22.0	267 240	1
M 27	3.00	60.0	25.0	267 270	1
M 30	3.50	60.0	25.0	267 300	1



Single-cut tap G ≈ DIN 5157 HSS, ground



Thread: DIN ISO 228 "G" (cylindrical pipe thread)
 DIN 2999 "Rp" (Whitworth pipe thread)
 Flanks: relief-ground



Packaging: plastic

Nominal thread size G	Nominal thread size Rp	Threads per inch	Thread core hole Ø1 mm	L1 mm	L2 mm	HSS	
G 1/8"	Rp 1/8"	28	8.6	63.0	20.0	236 218	1
G 1/4"	Rp 1/4"	19	11.5	70.0	22.0	236 214	1
G 3/8"	Rp 3/8"	19	15.0	70.0	22.0	236 238	1
G 1/2"	Rp 1/2"	14	19.0	80.0	22.0	236 212	1
G 3/4"	Rp 3/4"	14	24.5	90.0	22.0	236 234	1
G 1"	Rp 1"	11	30.5	100.0	25.0	236 210	1

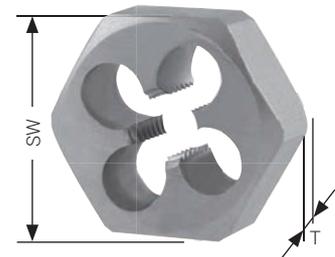
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Hexagonal die nut G DIN 382 HSS, ground



Thread: DIN ISO 228 "G" (cylindrical pipe thread)



Packaging: plastic

Nominal thread size G	Threads per inch	Outside Ø SW mm	Thickness T mm	HSS	
G 1/8"	28	27.0	11.0	267 618	1
G 1/4"	19	36.0	10.0	267 614	1
G 3/8"	19	41.0	14.0	267 638	1
G 1/2"	14	41.0	14.0	267 612	1
G 3/4"	14	50.0	16.0	267 634	1
G 1"	11	60.0	18.0	267 610	1



Sanitary repair thread-cutting set HSS for cylindrical pipe thread



		HSS
13 tfg./pcs.	<p>Sanitary repair thread-cutting tool set 6 single-cut taps G/Rp ≈ DIN 5157 HSS, ground G/Rp 1/8" x 28 G/Rp 1/4" x 19 G/Rp 3/8" x 19 G/Rp 1/2" x 14 G/Rp 3/4" x 14 G/Rp 1" x 11</p> <p>+ 6 hexagonal dies G DIN 382 HSS, ground G 1/8" x 28 G 1/4" x 19 G 3/8" x 19 G 1/2" x 14 G 3/4" x 14 G 1" x 11</p> <p>+ 1 cutting paste, 40 ml</p>	245 059

06

Thread-cutting tool sets in wooden case



245 004 RO



		HSS
28 tfg./pcs.	<p>Thread-cutting tool set one two-piece set each of hand taps G DIN 5157 1/8" 1/4" 3/8" 1/2" 5/8" 3/4" 1"</p> <p>+ 7 dies G DIN EN 24231 1/8" 1/4" 3/8" 1/2" 5/8" 3/4" 1"</p> <p>+ 5 die stocks DIN 225 30.0 x 11.0 38.0 x 10.0 45.0 x 14.0 55.0 x 16.0 65.0 x 18.0 mm</p> <p>+ 2 tap wrenches, size 3 and size 5 DIN 1814</p>	245 074
35 tfg./pcs.	<p>Thread-cutting tool set one two-piece set each of hand taps UNF ≈ DIN 2181 1/4" 5/16" 3/8" 7/16" 1/2" 5/8" 3/4" 7/8" 1"</p> <p>+ 9 dies UNF ≈ DIN EN 22568 1/4" 5/16" 3/8" 7/16" 1/2" 5/8" 3/4" 7/8" 1"</p> <p>+ 6 die stocks DIN 225 20.0 x 7.0 25.0 x 9.0 30.0 x 11.0 38.0 x 10.0 45.0 x 14.0 55.0 x 16.0 mm</p> <p>+ 2 tap wrenches, size 2 and size 4 DIN 1814</p>	245 073
44 tfg./pcs.	<p>Thread-cutting tool set one three-piece set each of hand taps UNC ≈ DIN 352 1/4" 5/16" 3/8" 7/16" 1/2" 5/8" 3/4" 7/8" 1"</p> <p>+ 9 dies UNC ≈ DIN EN 22568 1/4" 5/16" 3/8" 7/16" 1/2" 5/8" 3/4" 7/8" 1"</p> <p>+ 6 die stocks DIN 225 20.0 x 7.0 25.0 x 9.0 30.0 x 11.0 38.0 x 10.0 45.0 x 18.0 55.0 x 22.0 mm</p> <p>+ 2 tap wrenches, size 2 and size 4 DIN 1814</p>	245 072

Die stock DIN 225

For closed and slotted taps as per DIN EN 24231.

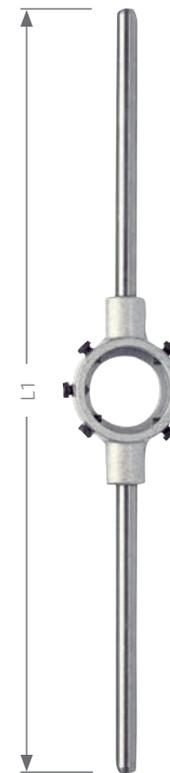
With steel handles one of which can be unscrewed and five screws for clamping the tap.

Version: die-cast zinc housing

Packaging: plastic

Size	Thickness mm	L1 mm	for tap size			HSS	
			M + MF	Ww	G		
16	5.0	160.0	M 1 - M 2.6	1/16 - 3/32	—	242 165	1
20	5.0	175.0	M 3 - M 4	1/8 - 5/32	—	242 205	1
20	7.0	175.0	M 4.5 - M 6	3/16 - 1/4	—	242 207	1
25	9.0	210.0	M 7 - M 9	5/16	1/16	242 259	1
30	11.0	260.0	M 10 - M 11	3/8 - 7/16	1/8	242 3011	1
38	14.0	310.0	M 12 - M 14	1/2 - 9/16	—	242 3814	1
45	18.0	440.0	M 16 - M 20	5/8 - 3/4	—	242 4518	1
55	22.0	495.0	M 22 - M 24	7/8 - 1	—	242 5522	1
65	25.0	630.0	M 27 - M 36	1 1/8 - 1 3/8	—	242 6525	1
75	30.0	700.0	M 38 - M 42	1 1/2 - 1 5/8	—	242 7530	1
90	36.0	900.0	M 45 - M 52	1 3/4 - 2	—	242 9036	1
105	36.0	930.0	M 54 - M 63	2 1/4 - 2 3/4	—	242 10536	1

38	10.0	310.0	MF 12 - MF 14	—	1/4	242 3810	1
45	14.0	440.0	MF 16 - MF 20	—	3/8 - 1/2	242 4514	1
55	16.0	495.0	MF 22 - MF 24	—	5/8 - 3/4	242 5516	1
65	18.0	630.0	MF 27 - MF 36	—	7/8 - 1	242 6518	1
75	20.0	750.0	MF 38 - MF 42	—	1 1/8 - 1 1/4	242 7520	1
90	22.0	900.0	MF 45 - MF 52	—	1 3/8 - 1 5/8	242 9022	1
105	22.0	930.0	MF 54 - MF 63	—	1 3/4 - 2	242 10522	1



Extension sleeve DIN 377

As extension for hand thread-cutting tools.

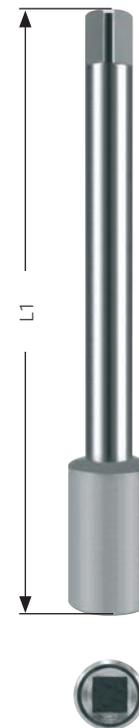
Inside and outside square of identical size.

Version: hardened and ground

Shank: square as per DIN 10

Packaging: plastic

Square mm	Length mm	for hand tap size			HSS	
		M	Ww	G		
2.1	60.0	M 1 - M 2.6	1/16 - 3/32	—	241 021	1
2.7	80.0	M 3	—	—	241 027	1
3.4	95.0	M 4	5/32	—	241 034	1
4.9	110.0	M 5 - M 8	7/32 - 5/16	—	241 049	1
5.5	115.0	M 9 - M 10	3/8	1/8	241 055	1
7.0	125.0	M 12	1/2	—	241 070	1
9.0	135.0	M 13 - M 16	9/16 - 5/8	1/4	241 090	1
11.0	150.0	M 18	11/16 - 3/4	—	241 110	1
12.0	155.0	M 20	13/16	1/2	241 120	1
14.5	174.0	M 22 - M 24	7/8 - 15/16	5/8	241 145	1
16.0	185.0	M 27 - M 28	1	3/4	241 160	1
18.0	195.0	M 30 - M 32	1 1/8	7/8	241 180	1



Adjustable tap wrench DIN 1814

Ideal for thread-cutting in inaccessible places.
With two-jaw chuck for tensioning square shanks.
With steel handles one of which can be unscrewed.

Version: die-cast zinc housing
Chuck jaws: hardened

Packaging: plastic

Size	L1 mm	for hand tape size				
		M	Ww	G		
0	125.0	M 1 - M 8	1/16 - 5/16	—	241 100	1
1	175.0	M 1 - M 10	1/8 - 3/8	—	241 101	1
1 1/2	175.0	M 1 - M 12	1/8 - 1/2	1/8	241 112	1
2	265.0	M 4 - M 12	3/16 - 5/8	1/8 - 3/8	241 102	1
3	370.0	M 5 - M 20	1/4 - 3/4	1/8 - 1/2	241 103	1
4	480.0	M 11 - M 27	1/2 - 1	1/8 - 3/4	241 104	1
5	700.0	M 13 - M 32	5/8 - 1 1/4	1/4 - 1	241 105	1
6	1000.0	M 18 - M 42	3/4 - 1 1/2	1/4 - 1 1/4	241 106	1
7	1250.0	M 25 - M 52	7/8 - 2	5/8 - 2 1/4	241 107	1

Ball tap wrench

Ideal for rapid fitting of taps.

Version: die-cast zinc housing
Shank: square as per DIN 10

Packaging: plastic

Size	L1 mm	for hand tape size				
		M	Ww	G		
0	200.0	M 1 - M 4	1/16 - 5/32	—	241 200	1
1	200.0	M 3.5 - M 8	5/32 - 5/16	—	241 201	1
2	240.0	M 4 - M 10	5/32 - 3/8	—	241 202	1
3	300.0	M 5 - M 12	7/32 - 1/2	—	241 203	1
4	340.0	M 9 - M 16	3/8 - 5/8	—	241 204	1
5	450.0	M 12 - M 20	1/2 - 13/16	—	241 205	1
6	650.0	M 18 - M 27	11/16 - 1	—	241 206	1

Tap wrench with ratchet

Ideal for thread-cutting in inaccessible places.
With two-jaw chuck for tensioning square shanks.

Version: adjustable left, right, fixed
Shank: sliding cross-handle with grooves at both ends
Surface: chromium-plated

Packaging: plastic

Size	L1 mm	for hand tape size				
		M	Ww	G		
1	85.0	M 3 - M 10	1/8 - 3/8	—	241 001	1
2	100.0	M 5 - M 12	7/32 - 1/2	1/8	241 002	1
10	250.0	M 3 - M 10	1/8 - 3/8	—	241 010	1
20	300.0	M 5 - M 12	7/32 - 1/2	1/8	241 020	1

