

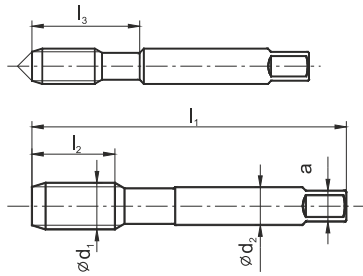
ISO Metric coarse thread DIN-13



HSSE
PM

TC

DIN
352



HRC40

KPL/3-P

F



Nr1-P

Nr2

F

F

Material groups



Hole type



Quality of material

HSSE-PM

HSSE-PM

Coating

TC

TC

Chamfer

~3P

M ød ₁	P	l ₁	l ₂	l ₃	ød ₂	a		Norm	~DIN-352	
								Tol.	6HX	6HX
								INDEX	A4-235D51	A4-203D51
M3	0,50	40	10	-	3,5	2,7	2,5	0030	●	●
M4	0,70	50	13	-	6,0	4,9	3,3	0040	●	●
M5	0,80	50	16	-	6,0	4,9	4,2	0050	●	●
M6	1,00	56	19	-	6,0	4,9	5,0	0060	●	●
M8	1,25	63	22	-	6,0	4,9	6,8	0080	●	●
M10	1,50	70	25	-	7,0	5,5	8,5	0100	●	●
M12	1,75	75	30	-	9,0	7,0	10,2	0120	●	●
M16	2,00	80	32	-	12,0	9,0	14,0	0160	●	●
M20	2,50	95	40	-	16,0	12,0	17,5	0200	○	○

Taps set HRC40 suitable for hardened steels up to 40HRC

Instruction of proper use HRC40 taps:

1. Maximum threading depth 1,5xD
2. Rigorously respect sequence of tapping procedure for hand taps sets using tap numbers in correct order
3. Please use only high quality cutting fluids (for example TEREBOR distributed by Fanar)
4. Carefully clear each tap from chips before next usage
5. Do not reverse the tap revolution before reach full depth of cut

Taps F suitable for thread shape correction after

hardening processor material galvanizing operations

Instruction of proper use F taps:

1. Please clean the threaded hole from mechanical impurities
2. Moisten both the tap and the hole with good quality tapping fluid (for example CIMTAP, TEREBOR or machine oil)
3. Enter tap into a hole by hand and make thread correction
4. Carefully clear each tap from chips before next usage