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ISO Metric fine thread DIN-13		HRC40													
		KPL/2	F												
  <div style="display: flex; flex-direction: column; gap: 5px;"> <div style="border: 1px solid black; padding: 2px; width: fit-content;">HSSE PM</div> <div style="border: 1px solid black; padding: 2px; width: fit-content;">TC</div> <div style="border: 1px solid black; padding: 2px; width: fit-content;">DIN 2181</div> </div>		   <p>Nr1-P      F      F</p>													
Material groups		<table border="1"> <tr><td>P</td><td>M</td><td>K</td></tr> <tr><td>N</td><td>S</td><td>H</td></tr> </table>	P	M	K	N	S	H	<table border="1"> <tr><td>P</td><td>M</td><td>K</td></tr> <tr><td>N</td><td>S</td><td>H</td></tr> </table>	P	M	K	N	S	H
P	M	K													
N	S	H													
P	M	K													
N	S	H													
Hole type															
Quality of material		HSSE-PM	HSSE-PM												
Coating		TC	TC												
Chamfer			~3P												
		Norm DIN-2181													
M	P	$l_1$	$l_2$	$l_3$	$\varnothing d_2$	a		Tol.	6HX						
$\varnothing d_1$								INDEX	A4-225D51	A4-202D51					
M8x1	1,0	63	18	-	6	4,9	7,0	0083	●	○					
M10x1	1,0	63	18	-	7	5,5	9,0	0103	●	●					
M12x1,5	1,5	70	20	-	9	7,0	10,5	0125	●	●					
M16x1,5	1,5	70	22	-	12	9,0	14,5	0165	●	●					

*i*

**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. Moistern bothe 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