Cold forming taps M

Tolerance ISO 2 (6H)

N° EF10060 / EF10061

N° EH6100 / EH6101 duroform

N° EH10070 / EH10071

N° EH10072 / EH10073

Al	HSS PM/F		Al Aluminium Alloy	Cu Copper	349
U	HM MG10		Rm <850-1100	Al Aluminium Alloy	353
St	HSS PM/F		Rm <850		355
St	HSS PM/F		Rm <850		359

Tolerance ISO 3 (6G)

N° EF10064 / EF10065

N° EH10074 / EH10075

Al	HSS PM/F		Al Aluminium Alloy	Cu Copper	361
St	HSS PM/F		Rm <850		363

Tolerance 7G

N° EF10068

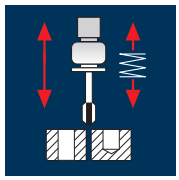
N° EH10078

Al	HSS PM/F		Al Aluminium Alloy	Cu Copper	365
St	HSS PM/F		Rm <850		367

passion
for precision

fraisa

Application



Material	M	ø [mm]	P [mm]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]	v_c 3.0 x d	n [min⁻¹]	v_f [100%]
Unalloyed aluminium	M 1	1.0	0.25	25	7960	1990	20	6365	1591	15	4775	1194
	M 1.2	1.2	0.25	25	6630	1658	20	5305	1326	15	3980	995
	M 1.4	1.4	0.30	25	5685	1706	20	4545	1364	15	3410	1023
	M 1.6	1.6	0.35	25	4975	1741	20	3980	1393	15	2985	1045
	M 1.8	1.8	0.35	25	4420	1547	20	3535	1237	15	2655	929
	M 2	2.0	0.40	25	3980	1592	20	3185	1274	15	2385	954
	M 2.2	2.2	0.45	25	3615	1627	20	2895	1303	15	2170	977
	M 2.5	2.5	0.45	25	3185	1433	20	2545	1145	15	1910	860
	M 3	3.0	0.50	25	2655	1328	20	2120	1060	15	1590	795
Unalloyed aluminium	M 4	4.0	0.70	25	1990	1393	20	1590	1113	15	1195	837
	M 5	5.0	0.80	25	1590	1272	20	1275	1020	15	955	764
	M 6	6.0	1.00	25	1325	1325	20	1060	1060	15	795	795
	M 8	8.0	1.25	25	995	1244	20	795	994	15	595	744
	M10	10.0	1.50	25	795	1193	20	635	953	15	475	713
Wrought aluminium alloys Si < 6% not hardened	M 1	1.0	0.25	30	9550	2388	25	7960	1990	20	6365	1591
	M 1.2	1.2	0.25	30	7960	1990	25	6630	1658	20	5305	1326
	M 1.4	1.4	0.30	30	6820	2046	25	5685	1706	20	4545	1364
	M 1.6	1.6	0.35	30	5970	2090	25	4975	1741	20	3980	1393
	M 1.8	1.8	0.35	30	5305	1857	25	4420	1547	20	3535	1237
	M 2	2.0	0.40	30	4775	1910	25	3980	1592	20	3185	1274
	M 2.2	2.2	0.45	30	4340	1953	25	3615	1627	20	2895	1303
	M 2.5	2.5	0.45	30	3820	1719	25	3185	1433	20	2545	1145
	M 3	3.0	0.50	30	3185	1593	25	2655	1328	20	2120	1060
Wrought aluminium alloys Si < 6% not hardened	M 4	4.0	0.70	30	2385	1670	25	1990	1393	20	1590	1113
	M 5	5.0	0.80	30	1910	1528	25	1590	1272	20	1275	1020
	M 6	6.0	1.00	30	1590	1590	25	1325	1325	20	1060	1060
	M 8	8.0	1.25	30	1195	1494	25	995	1244	20	795	994
	M10	10.0	1.50	30	955	1433	25	795	1193	20	635	953

Material	M	ø [mm]	P [mm]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]	v_c 3.0 x d	n [min⁻¹]	v_f [100%]
Unalloyed copper	M 1	1.0	0.25	15	4775	1194	10	3185	796	10	3185	796
	M 1.2	1.2	0.25	15	3980	995	10	2655	664	10	2655	664
	M 1.4	1.4	0.30	15	3410	1023	10	2275	683	10	2275	683
	M 1.6	1.6	0.35	15	2985	1045	10	1990	697	10	1990	697
	M 1.8	1.8	0.35	15	2655	929	10	1770	620	10	1770	620
	M 2	2.0	0.40	15	2385	954	10	1590	636	10	1590	636
	M 2.2	2.2	0.45	15	2170	977	10	1445	650	10	1445	650
	M 2.5	2.5	0.45	15	1910	860	10	1275	574	10	1275	574
	M 3	3.0	0.50	15	1590	795	10	1060	530	10	1060	530
Unalloyed copper	M 4	4.0	0.70	15	1195	837	10	795	557	10	795	557
	M 5	5.0	0.80	15	955	764	10	635	508	10	635	508
	M 6	6.0	1.00	15	795	795	10	530	530	10	530	530
	M 8	8.0	1.25	15	595	744	10	400	500	10	400	500
	M10	10.0	1.50	15	475	713	10	320	480	10	320	480
Non ferrous metal A_5 > 15%	M 1	1.0	0.25	15	4775	1194	10	3185	796	10	3185	796
	M 1.2	1.2	0.25	15	3980	995	10	2655	664	10	2655	664
	M 1.4	1.4	0.30	15	3410	1023	10	2275	683	10	2275	683
	M 1.6	1.6	0.35	15	2985	1045	10	1990	697	10	1990	697
	M 1.8	1.8	0.35	15	2655	929	10	1770	620	10	1770	620
	M 2	2.0	0.40	15	2385	954	10	1590	636	10	1590	636
	M 2.2	2.2	0.45	15	2170	977	10	1445	650	10	1445	650
	M 2.5	2.5	0.45	15	1910	860	10	1275	574	10	1275	574
	M 3	3.0	0.50	15	1590	795	10	1060	530	10	1060	530
Non ferrous metal A_5 > 15%	M 4	4.0	0.70	15	1195	837	10	795	557	10	795	557
	M 5	5.0	0.80	15	955	764	10	635	508	10	635	508
	M 6	6.0	1.00	15	795	795	10	530	530	10	530	530
	M 8	8.0	1.25	15	595	744	10	400	500	10	400	500
	M10	10.0	1.50	15	475	713	10	320	480	10	320	480

Cold forming taps

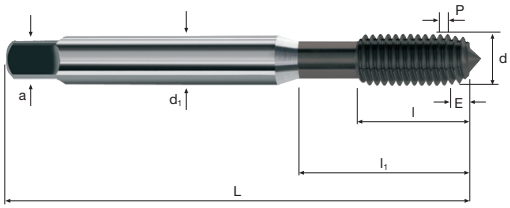
Al

M | ISO 2 (6H)

60° | HSS PM/F

DIN 371

X · P
Form E



			Al Aluminium > 99%	Al Aluminium Alloy			Cu Copper		CuZn Brass

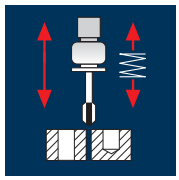
Example:
Order-N°. Article-N°. **EF10060** ø-Code **.010**

Ø Code	d	P	L	l	l1	d1	a			F-DLC EF10060
.010	M 1	0.25	40	5.5	–	2.5	2.1	3	0.87	●
.012	M 1.2	0.25	40	5.5	–	2.5	2.1	3	1.07	●
.020	M 1.4	0.30	40	7.0	–	2.5	2.1	3	1.25	●
.022	M 1.6	0.35	40	8.0	–	2.5	2.1	3	1.42	●
.026	M 1.8	0.35	40	8.0	–	2.5	2.1	3	1.62	●
.034	M 2	0.40	45	8.0	–	2.8	2.1	3	1.80	●
.036	M 2.2	0.45	45	9.0	–	2.8	2.1	3	2.00	●
.040	M 2.5	0.45	50	9.0	–	2.8	2.1	3	2.30	●
.044	M 3	0.50	56	12.0	18.0	3.5	2.7	3	2.80	●
.058	M 4	0.70	63	13.0	21.0	4.5	3.4	3	3.70	●
.084	M 5	0.80	70	15.0	25.0	6.0	4.9	4	4.60	●
.088	M 6	1.00	80	17.0	30.0	6.0	4.9	4	5.50	●
.160	M 8	1.25	90	20.0	35.0	8.0	6.2	4	7.40	●
.174	M10	1.50	100	22.0	39.0	10.0	8.0	4	9.30	●

≤ M 1.4 Tolerance ISO1 (4H)

For larger dimensions see article no. EF10061, page 351

Application

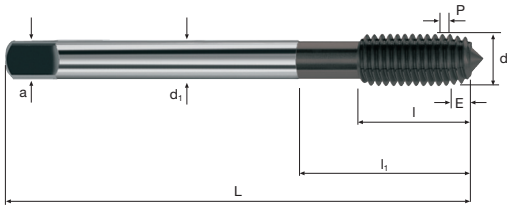


Material	M	ø [mm]	P [mm]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]	v_c 3.0 x d	n [min⁻¹]	v_f [100%]
Unalloyed aluminium	M12	12.0	1.75	25	665	1164	20	530	928	15	400	700
	M14	14.0	2.00	25	570	1140	20	455	910	15	340	680
	M16	16.0	2.00	25	495	990	20	400	800	15	300	600
Wrought aluminium alloys Si < 6% not hardened	M12	12.0	1.75	30	795	1391	25	665	1164	20	530	928
	M14	14.0	2.00	30	680	1360	25	570	1140	20	455	910
	M16	16.0	2.00	30	595	1190	25	495	990	20	400	800
Unalloyed copper	M12	12.0	1.75	15	400	700	10	265	464	10	265	464
	M14	14.0	2.00	15	340	680	10	225	450	10	225	450
	M16	16.0	2.00	15	300	600	10	200	400	10	200	400
Non ferrous metal A_5 > 15%	M12	12.0	1.75	15	400	700	10	265	464	10	265	464
	M14	14.0	2.00	15	340	680	10	225	450	10	225	450
	M16	16.0	2.00	15	300	600	10	200	400	10	200	400

Cold forming taps

Al

M	ISO 2 (6H)
60°	HSS PM/F
DIN 376	
	X · P Form E



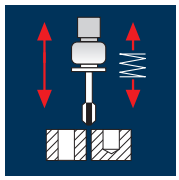
			Al Aluminium > 99%	Al Aluminium Alloy			Cu Copper		CuZn Brass

Example:
Order-N°. Article-N°. **EF10061** ø-Code **.240**

Ø Code	d	P	L	l	l1	d1	a			F-DLC EF10061
.240	M12	1.75	110	24	40	9	7	5	11.20	●
.244	M14	2.00	110	26	40	11	9	5	13.10	●
.246	M16	2.00	110	27	40	12	9	5	15.10	●

VII

Application



Material

M	ø [mm]	P [mm]	v_c 1.0 x d	n [min⁻¹]	v_f [100%]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]
Steel < 850 N/mm² A_5 > 10%											
M 3	3.0	0.50	35	3715	1858	30	3185	1593	25	2655	1328
M 4	4.0	0.70	35	2785	1949	30	2385	1670	25	1990	1393
M 5	5.0	0.80	35	2230	1784	30	1910	1528	25	1590	1272
M 6	6.0	1.00	35	1855	1855	30	1590	1590	25	1325	1325
M 8	8.0	1.25	35	1395	1744	30	1195	1494	25	995	1244
M10	10.0	1.50	35	1115	1673	30	955	1433	25	795	1193
M12	12.0	1.75	35	930	1628	30	795	1391	25	665	1164
Steel 850 - 1100 N/mm² A_5 > 10%											
M 3	3.0	0.50	30	3185	1593	25	2655	1328	20	2120	1060
M 4	4.0	0.70	30	2385	1670	25	1990	1393	20	1590	1113
M 5	5.0	0.80	30	1910	1528	25	1590	1272	20	1275	1020
M 6	6.0	1.00	30	1590	1590	25	1325	1325	20	1060	1060
M 8	8.0	1.25	30	1195	1494	25	995	1244	20	795	994
M10	10.0	1.50	30	955	1433	25	795	1193	20	635	953
M12	12.0	1.75	30	795	1391	25	665	1164	20	530	928
Unalloyed aluminium											
M 3	3.0	0.50	50	5305	2653	40	4245	2123	30	3185	1593
M 4	4.0	0.70	50	3980	2786	40	3185	2230	30	2385	1670
M 5	5.0	0.80	50	3185	2548	40	2545	2036	30	1910	1528
M 6	6.0	1.00	50	2655	2655	40	2120	2120	30	1590	1590
M 8	8.0	1.25	50	1990	2488	40	1590	1988	30	1195	1494
M10	10.0	1.50	50	1590	2385	40	1275	1913	30	955	1433
M12	12.0	1.75	50	1325	2319	40	1060	1855	30	795	1391
Wrought aluminium alloys Si < 6% not hardened											
M 3	3.0	0.50	80	8490	4245	60	6365	3183	40	4245	2123
M 4	4.0	0.70	80	6365	4456	60	4775	3343	40	3185	2230
M 5	5.0	0.80	80	5095	4076	60	3820	3056	40	2545	2036
M 6	6.0	1.00	80	4245	4245	60	3185	3185	40	2120	2120
M 8	8.0	1.25	80	3185	3981	60	2385	2981	40	1590	1988
M10	10.0	1.50	80	2545	3818	60	1910	2865	40	1275	1913
M12	12.0	1.75	80	2120	3710	60	1590	2783	40	1060	1855

Material

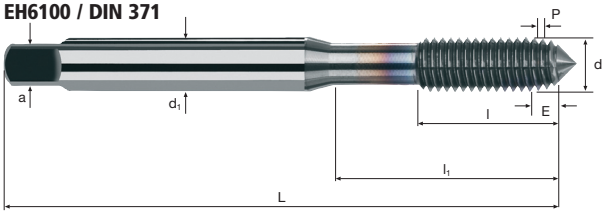
M	ø [mm]	P [mm]	v_c 1.0 x d	n [min⁻¹]	v_f [100%]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]
Unalloyed copper											
M 3	3.0	0.50	60	6365	3183	40	4245	2123	30	3185	1593
M 4	4.0	0.70	60	4775	3343	40	3185	2230	30	2385	1670
M 5	5.0	0.80	60	3820	3056	40	2545	2036	30	1910	1528
M 6	6.0	1.00	60	3185	3185	40	2120	2120	30	1590	1590
M 8	8.0	1.25	60	2385	2981	40	1590	1988	30	1195	1494
M10	10.0	1.50	60	1910	2865	40	1275	1913	30	955	1433
M12	12.0	1.75	60	1590	2783	40	1060	1855	30	795	1391
Non ferrous metal A_5 > 15%											
M 3	3.0	0.50	50	5305	2653	30	3185	1593	25	2655	1328
M 4	4.0	0.70	50	3980	2786	30	2385	1670	25	1990	1393
M 5	5.0	0.80	50	3185	2548	30	1910	1528	25	1590	1272
M 6	6.0	1.00	50	2655	2655	30	1590	1590	25	1325	1325
M 8	8.0	1.25	50	1990	2488	30	1195	1494	25	995	1244
M10	10.0	1.50	50	1590	2385	30	955	1433	25	795	1193
M12	12.0	1.75	50	1325	2319	30	795	1391	25	665	1164
Stainless steel ferritc/martensitic A_5 > 10%											
M 3	3.0	0.50	30	3185	1593	25	2655	1328	20	2120	1060
M 4	4.0	0.70	30	2385	1670	25	1990	1393	20	1590	1113
M 5	5.0	0.80	30	1910	1528	25	1590	1272	20	1275	1020
M 6	6.0	1.00	30	1590	1590	25	1325	1325	20	1060	1060
M 8	8.0	1.25	30	1195	1494	25	995	1244	20	795	994
M10	10.0	1.50	30	955	1433	25	795	1193	20	635	953
M12	12.0	1.75	30	795	1391	25	665	1164	20	530	928
Stainless steel [Cr-Ni/1.4301]											
M 3	3.0	0.50	30	3185	1593	25	2655	1328	20	2120	1060
M 4	4.0	0.70	30	2385	1670	25	1990	1393	20	1590	1113
M 5	5.0	0.80	30	1910	1528	25	1590	1272	20	1275	1020
M 6	6.0	1.00	30	1590	1590	25	1325	1325	20	1060	1060
M 8	8.0	1.25	30	1195	1494	25	995	1244	20	795	994
M10	10.0	1.50	30	955	1433	25	795	1193	20	635	953
M12	12.0	1.75	30	795	1391	25	665	1164	20	530	928

Cold forming taps duroform

U

M	ISO 2 (6H)
60°	HM MG10
DIN 371/376	
X · P Form E	

EH6100 / DIN 371



EH6101 / DIN 376

Rm < 850	Rm 850-1100						Inox Stainless		Aluminium Copper

Example: Order-N°. Article-N°. **EH6100** ø-Code **.044**

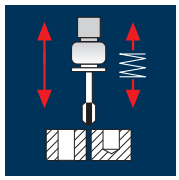
Ø Code	d	P	L	l	l1	d1	a			TiCN EH6100
.044	M 3	0.50	56	12	18	3.5	2.7	3	2.80	●
.058	M 4	0.70	63	13	21	4.5	3.4	4	3.70	●
.084	M 5	0.80	70	15	25	6.0	4.9	4	4.60	●
.088	M 6	1.00	80	17	30	6.0	4.9	4	5.50	●
.160	M 8	1.25	90	20	35	8.0	6.2	5	7.40	●
.174	M10	1.50	100	22	39	10.0	8.0	5	9.30	●

Example: Order-N°. Article-N°. **EH6101** ø-Code **.240**

Ø Code	d	P	L	l	l1	d1	a			TiCN EH6101
.240	M12	1.75	110	24	50	9.0	7.0	7	11.20	●

VII

Application



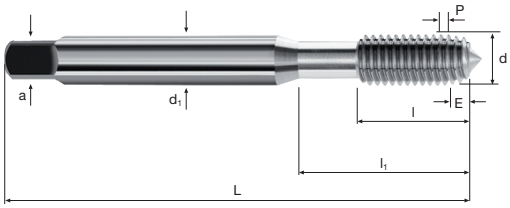
Material	M	ø [mm]	P [mm]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]	v_c 3.0 x d	n [min⁻¹]	v_f [100%]
Steel < 850 N/mm² A_5 > 10%	M 1	1.0	0.25	20	6365	1591	15	4775	1194	10	3185	796
	M 1.2	1.2	0.25	20	5305	1326	15	3980	995	10	2655	664
	M 1.4	1.4	0.30	20	4545	1364	15	3410	1023	10	2275	683
	M 1.6	1.6	0.35	20	3980	1393	15	2985	1045	10	1990	697
	M 1.8	1.8	0.35	20	3535	1237	15	2655	929	10	1770	620
	M 2	2.0	0.40	20	3185	1274	15	2385	954	10	1590	636
	M 2.2	2.2	0.45	20	2895	1303	15	2170	977	10	1445	650
	M 2.5	2.5	0.45	20	2545	1145	15	1910	860	10	1275	574
	M 3	3.0	0.50	20	2120	1060	15	1590	795	10	1060	530
Steel < 850 N/mm² A_5 > 10%	M 4	4.0	0.70	20	1590	1113	15	1195	837	10	795	557
	M 5	5.0	0.80	20	1275	1020	15	955	764	10	635	508
	M 6	6.0	1.00	20	1060	1060	15	795	795	10	530	530
	M 8	8.0	1.25	20	795	994	15	595	744	10	400	500
	M10	10.0	1.50	20	635	953	15	475	713	10	320	480
Steel 850 - 1100 N/mm² A_5 > 10%	M 1	1.0	0.25	15	4775	1194	10	3185	796			
	M 1.2	1.2	0.25	15	3980	995	10	2655	664			
	M 1.4	1.4	0.30	15	3410	1023	10	2275	683			
	M 1.6	1.6	0.35	15	2985	1045	10	1990	697			
	M 1.8	1.8	0.35	15	2655	929	10	1770	620			
	M 2	2.0	0.40	15	2385	954	10	1590	636			
	M 2.2	2.2	0.45	15	2170	977	10	1445	650			
	M 2.5	2.5	0.45	15	1910	860	10	1275	574			
	M 3	3.0	0.50	15	1590	795	10	1060	530			
Steel 850 - 1100 N/mm² A_5 > 10%	M 4	4.0	0.70	15	1195	837	10	795	557			
	M 5	5.0	0.80	15	955	764	10	635	508			
	M6	6.0	1.00	15	795	795	10	530	530			
	M8	8.0	1.25	15	595	744	10	400	500			
	M10	10.0	1.50	15	475	713	10	320	480			

Material	M	ø [mm]	P [mm]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]
Stainless steel ferritc/martensitic A_5 > 10%	M 1	1.0	0.25	15	4775	1194	10	3185	796
	M 1.2	1.2	0.25	15	3980	995	10	2655	664
	M 1.4	1.4	0.30	15	3410	1023	10	2275	683
	M 1.6	1.6	0.35	15	2985	1045	10	1990	697
	M 1.8	1.8	0.35	15	2655	929	10	1770	620
	M 2	2.0	0.40	15	2385	954	10	1590	636
	M 2.2	2.2	0.45	15	2170	977	10	1445	650
	M 2.5	2.5	0.45	15	1910	860	10	1275	574
	M 3	3.0	0.50	15	1590	795	10	1060	530
Stainless steel ferritc/martensitic A_5 > 10%	M 4	4.0	0.70	15	1195	837	10	795	557
	M 5	5.0	0.80	15	955	764	10	635	508
	M 6	6.0	1.00	15	795	795	10	530	530
	M 8	8.0	1.25	15	595	744	10	400	500
	M10	10.0	1.50	15	475	713	10	320	480
Stainless steel [Cr-Ni/1.4301]	M 1	1.0	0.25	15	4775	1194	10	3185	796
	M 1.2	1.2	0.25	15	3980	995	10	2655	664
	M 1.4	1.4	0.30	15	3410	1023	10	2275	683
	M 1.6	1.6	0.35	15	2985	1045	10	1990	697
	M 1.8	1.8	0.35	15	2655	929	10	1770	620
	M 2	2.0	0.40	15	2385	954	10	1590	636
	M 2.2	2.2	0.45	15	2170	977	10	1445	650
	M 2.5	2.5	0.45	15	1910	860	10	1275	574
	M 3	3.0	0.50	15	1590	795	10	1060	530
Stainless steel [Cr-Ni/1.4301]	M 4	4.0	0.70	15	1195	837	10	795	557
	M 5	5.0	0.80	15	955	764	10	635	508
	M 6	6.0	1.00	15	795	795	10	530	530
	M 8	8.0	1.25	15	595	744	10	400	500
	M10	10.0	1.50	15	475	713	10	320	480

Cold forming taps

St

M	ISO 2 (6H)
60°	HSS PM/F
DIN 371	
	Form E



Rm < 850	Rm 850-1100						Inox Stainless		

Example: **Order-N°.** Article-N°. **EH10070** ø-Code **.010**

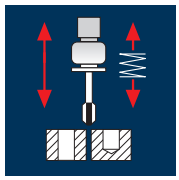
Ø Code	d	P	L	l	l1	d1	a			TiCN EH10070
.010 *	M 1	0.25	40	5.5	–	2.5	2.1	3	0.87	●
.012 *	M 1.2	0.25	40	5.5	–	2.5	2.1	3	1.07	●
.020 *	M 1.4	0.30	40	7.0	–	2.5	2.1	3	1.25	●
.022 *	M 1.6	0.35	40	8.0	–	2.5	2.1	3	1.42	●
.026 *	M 1.8	0.35	40	8.0	–	2.5	2.1	3	1.62	●
.034	M 2	0.40	45	8.0	–	2.8	2.1	3	1.80	●
.036	M 2.2	0.45	45	9.0	–	2.8	2.1	3	2.00	●
.040	M 2.5	0.45	50	9.0	–	2.8	2.1	3	2.30	●
.044	M 3	0.50	56	12.0	18.0	3.5	2.7	3	2.80	●
.058	M 4	0.70	63	13.0	21.0	4.5	3.4	4	3.70	●
.084	M 5	0.80	70	15.0	25.0	6.0	4.9	4	4.60	●
.088	M 6	1.00	80	17.0	30.0	6.0	4.9	4	5.50	●
.160	M 8	1.25	90	20.0	35.0	8.0	6.2	5	7.40	●
.174	M10	1.50	100	22.0	39.0	10.0	8.0	5	9.30	●

≤ M 1.4 Tolerance ISO1 (4H)

* without oil grooves

For larger dimensions see article no. EH10071, page 357

Application



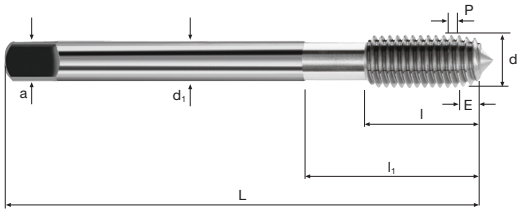
Material

M	ø [mm]	P [mm]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]	v_c 3.0 x d	n [min⁻¹]	v_f [100%]
Steel < 850 N/mm² A_5 > 10%											
M12	12.0	1.75	20	530	928	15	400	700	10	265	464
M14	14.0	2.00	20	455	910	15	340	680	10	225	450
M16	16.0	2.00	20	400	800	15	300	600	10	200	400
Steel 850 - 1100 N/mm² A_5 > 10%											
M12	12.0	1.75	15	400	700	10	265	464			
M14	14.0	2.00	15	340	680	10	225	450			
M16	16.0	2.00	15	300	600	10	200	400			
Stainless steel ferritc/martensitic A_5 > 10%											
M12	12.0	1.75	15	400	700	10	265	464			
M14	14.0	2.00	15	340	680	10	225	450			
M16	16.0	2.00	15	300	600	10	200	400			
Stainless steel [Cr-Ni/1.4301]											
M12	12.0	1.75	15	400	700	10	265	464			
M14	14.0	2.00	15	340	680	10	225	450			
M16	16.0	2.00	15	300	600	10	200	400			

Cold forming taps

St

M	ISO 2 (6H)
60°	HSS PM/F
DIN 376	
	Form E (X · P)



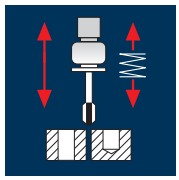
Rm < 850	Rm 850-1100						Inox Stainless		

Example:
Order-N°. **EH10071** (Article-N°.) **.240** (ø-Code)

ø Code	d	P	L	l	l1	d1	a			TiCN EH10071
.240	M12	1.75	110	24	40	9	7	7	11.20	●
.244	M14	2.00	110	26	40	11	9	7	13.10	●
.246	M16	2.00	110	27	40	12	9	7	15.10	●

VII

Application



Material

M	ø [mm]	P [mm]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]	v_c 3.0 x d	n [min⁻¹]	v_f [100%]
Steel < 850 N/mm² A_5 > 10%											
M 6	6.0	1.00	25	1325	1325	20	1060	1060	15	795	795
M 8	8.0	1.25	25	995	1244	20	795	994	15	595	744
M10	10.0	1.50	25	795	1193	20	635	953	15	475	713
M12	12.0	1.75	25	665	1164	20	530	928	15	400	700
M14	14.0	2.00	25	570	1140	20	455	910	15	340	680
M16	16.0	2.00	25	495	990	20	400	800	15	300	600
Steel 850 - 1100 N/mm² A_5 > 10%											
M 6	6.0	1.00	15	795	795	10	530	530			
M 8	8.0	1.25	15	595	744	10	400	500			
M10	10.0	1.50	15	475	713	10	320	480			
M12	12.0	1.75	15	400	700	10	265	464			
M14	14.0	2.00	15	340	680	10	225	450			
M16	16.0	2.00	15	300	600	10	200	400			
Stainless steel ferritc/martensitic A_5 > 10%											
M 6	6.0	1.00	15	795	795	10	530	530			
M 8	8.0	1.25	15	595	744	10	400	500			
M10	10.0	1.50	15	475	713	10	320	480			
M12	12.0	1.75	15	400	700	10	265	464			
M14	14.0	2.00	15	340	680	10	225	450			
M16	16.0	2.00	15	300	600	10	200	400			
Stainless steel [Cr-Ni/1.4301]											
M 6	6.0	1.00	15	795	795	10	530	530			
M 8	8.0	1.25	15	595	744	10	400	500			
M10	10.0	1.50	15	475	713	10	320	480			
M12	12.0	1.75	15	400	700	10	265	464			
M14	14.0	2.00	15	340	680	10	225	450			
M16	16.0	2.00	15	300	600	10	200	400			

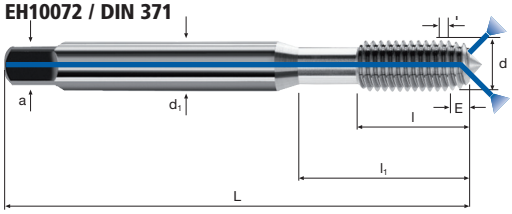
Cold forming taps

Incool

St

M	ISO 2 (6H)
60°	HSS PM/F
DIN 371/376	
	X · P Form E

EH10072 / DIN 371



EH10073 / DIN 376

Rm < 850	Rm 850-1100						Inox Stainless		

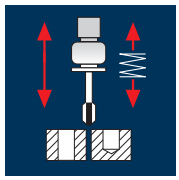
Example: Order-N°. EH10072 (Article-N°.) .088 (ø-Code)

Ø Code	d	P	L	l	l1	d1	a			TiCN EH10072
.088	M 6	1.00	80	17	30	6	4.9	4	5.50	●
.160	M 8	1.25	90	20	35	8	6.2	5	7.40	●
.174	M10	1.50	100	22	39	10	8.0	5	9.30	●

Example: Order-N°. EH10073 (Article-N°.) .240 (ø-Code)

Ø Code	d	P	L	l	l1	d1	a			TiCN EH10073
.240	M12	1.75	110	24	50	9	7.0	7	11.20	●
.244	M14	2.00	110	26	58	11	9.0	7	13.10	●
.246	M16	2.00	110	27	58	12	9.0	7	15.10	●

Application



Material

M	ø [mm]	P [mm]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]	v_c 3.0 x d	n [min⁻¹]	v_f [100%]
Unalloyed aluminium											
M 2	2.0	0.40	25	3980	1592	20	3185	1274	15	2385	954
M 2.2	2.2	0.45	25	3615	1627	20	2895	1303	15	2170	977
M 2.5	2.5	0.45	25	3185	1433	20	2545	1145	15	1910	860
M 3	3.0	0.50	25	2655	1328	20	2120	1060	15	1590	795
M 4	4.0	0.70	25	1990	1393	20	1590	1113	15	1195	837
M 5	5.0	0.80	25	1590	1272	20	1275	1020	15	955	764
M 6	6.0	1.00	25	1325	1325	20	1060	1060	15	795	795
M 8	8.0	1.25	25	995	1244	20	795	994	15	595	744
M10	10.0	1.50	25	795	1193	20	635	953	15	475	713
Unalloyed aluminium											
M12	12.0	1.75	25	665	1164	20	530	928	15	400	700
M14	14.0	2.00	25	570	1140	20	455	910	15	340	680
M16	16.0	2.00	25	495	990	20	400	800	15	300	600
Wrought aluminium alloys Si < 6% not hardened											
M 2	2.0	0.40	30	4775	1910	25	3980	1592	20	3185	1274
M 2.2	2.2	0.45	30	4340	1953	25	3615	1627	20	2895	1303
M 2.5	2.5	0.45	30	3820	1719	25	3185	1433	20	2545	1145
M 3	3.0	0.50	30	3185	1593	25	2655	1328	20	2120	1060
M 4	4.0	0.70	30	2385	1670	25	1990	1393	20	1590	1113
M 5	5.0	0.80	30	1910	1528	25	1590	1272	20	1275	1020
M 6	6.0	1.00	30	1590	1590	25	1325	1325	20	1060	1060
M 8	8.0	1.25	30	1195	1494	25	995	1244	20	795	994
M10	10.0	1.50	30	955	1433	25	795	1193	20	635	953
Wrought aluminium alloys Si < 6% not hardened											
M12	12.0	1.75	30	795	1391	25	665	1164	20	530	928
M14	14.0	2.00	30	680	1360	25	570	1140	20	455	910
M16	16.0	2.00	30	595	1190	25	495	990	20	400	800

Material

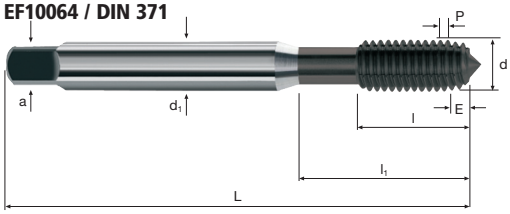
M	ø [mm]	P [mm]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]	v_c 3.0 x d	n [min⁻¹]	v_f [100%]
Unalloyed copper											
M 2	2.0	0.40	15	2385	954	10	1590	636	10	1590	636
M 2.2	2.2	0.45	15	2170	977	10	1445	650	10	1445	650
M 2.5	2.5	0.45	15	1910	860	10	1275	574	10	1275	574
M 3	3.0	0.50	15	1590	795	10	1060	530	10	1060	530
M 4	4.0	0.70	15	1195	837	10	795	557	10	795	557
M 5	5.0	0.80	15	955	764	10	635	508	10	635	508
M 6	6.0	1.00	15	795	795	10	530	530	10	530	530
M 8	8.0	1.25	15	595	744	10	400	500	10	400	500
M10	10.0	1.50	15	475	713	10	320	480	10	320	480
Unalloyed copper											
M12	12.0	1.75	15	400	700	10	265	464	10	265	464
M14	14.0	2.00	15	340	680	10	225	450	10	225	450
M16	16.0	2.00	15	300	600	10	200	400	10	200	400
Non ferrous metal A_5 > 15%											
M 2	2.0	0.40	15	2385	954	10	1590	636	10	1590	636
M 2.2	2.2	0.45	15	2170	977	10	1445	650	10	1445	650
M 2.5	2.5	0.45	15	1910	860	10	1275	574	10	1275	574
M 3	3.0	0.50	15	1590	795	10	1060	530	10	1060	530
M 4	4.0	0.70	15	1195	837	10	795	557	10	795	557
M 5	5.0	0.80	15	955	764	10	635	508	10	635	508
M 6	6.0	1.00	15	795	795	10	530	530	10	530	530
M 8	8.0	1.25	15	595	744	10	400	500	10	400	500
M10	10.0	1.50	15	475	713	10	320	480	10	320	480
Non ferrous metal A_5 > 15%											
M12	12.0	1.75	15	400	700	10	265	464	10	265	464
M14	14.0	2.00	15	340	680	10	225	450	10	225	450
M16	16.0	2.00	15	300	600	10	200	400	10	200	400

Cold forming taps

Al

M	ISO 3 (6G)
60°	HSS PM/F
DIN 371/376	
	Form E (X · P)

EF10064 / DIN 371



EF10065 / DIN 376

			Al Aluminium > 99%	Al Aluminium Alloy			Cu Copper		CuZn Brass

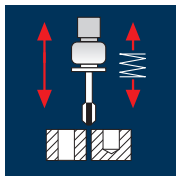
Example: Order-N°. Article-N°. **EF10064** ø-Code **.034**

Ø Code	d	P	L	l	l1	d1	a				F-DLC EF10064
.034	M 2	0.40	45	8	–	2.8	2.1	3	1.80		●
.036	M 2.2	0.45	45	9	–	2.8	2.1	3	2.00		●
.040	M 2.5	0.45	50	9	–	2.8	2.1	3	2.30		●
.044	M 3	0.50	56	12	18.0	3.5	2.7	3	2.80		●
.058	M 4	0.70	63	13	21.0	4.5	3.4	3	3.70		●
.084	M 5	0.80	70	15	25.0	6.0	4.9	4	4.60		●
.088	M 6	1.00	80	17	30.0	6.0	4.9	4	5.50		●
.160	M 8	1.25	90	20	35.0	8.0	6.2	4	7.40		●
.174	M10	1.50	100	22	39.0	10.0	8.0	4	9.30		●

Example: Order-N°. Article-N°. **EF10065** ø-Code **.240**

Ø Code	d	P	L	l	l1	d1	a				F-DLC EF10065
.240	M12	1.75	110	24	40.0	9.0	7.0	5	11.20		●
.244	M14	2.00	110	26	40.0	11.0	9.0	5	13.10		●
.246	M16	2.00	110	27	40.0	12.0	9.0	5	15.10		●

Application



Material	M	ø [mm]	P [mm]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]	v_c 3.0 x d	n [min⁻¹]	v_f [100%]
Steel < 850 N/mm² A_5 > 10%	M 2	2.0	0.40	20	3185	1274	15	2385	954	10	1590	636
	M 2.2	2.2	0.45	20	2895	1303	15	2170	977	10	1445	650
	M 2.5	2.5	0.45	20	2545	1145	15	1910	860	10	1275	574
	M 3	3.0	0.50	20	2120	1060	15	1590	795	10	1060	530
	M 4	4.0	0.70	20	1590	1113	15	1195	837	10	795	557
	M 5	5.0	0.80	20	1275	1020	15	955	764	10	635	508
	M 6	6.0	1.00	20	1060	1060	15	795	795	10	530	530
	M 8	8.0	1.25	20	795	994	15	595	744	10	400	500
	M10	10.0	1.50	20	635	953	15	475	713	10	320	480
Steel < 850 N/mm² A_5 > 10%	M12	12.0	1.75	20	530	928	15	400	700	10	265	464
	M14	14.0	2.00	20	455	910	15	340	680	10	225	450
	M16	16.0	2.00	20	400	800	15	300	600	10	200	400
Steel 850 - 1100 N/mm² A_5 > 10%	M 2	2.0	0.40	15	2385	954	10	1590	636			
	M 2.2	2.2	0.45	15	2170	977	10	1445	650			
	M 2.5	2.5	0.45	15	1910	860	10	1275	574			
	M 3	3.0	0.50	15	1590	795	10	1060	530			
	M 4	4.0	0.70	15	1195	837	10	795	557			
	M 5	5.0	0.80	15	955	764	10	635	508			
	M 6	6.0	1.00	15	795	795	10	530	530			
	M 8	8.0	1.25	15	595	744	10	400	500			
	M10	10.0	1.50	15	475	713	10	320	480			
Steel 850 - 1100 N/mm² A_5 > 10%	M12	12.0	1.75	15	400	700	10	265	464			
	M14	14.0	2.00	15	340	680	10	225	450			
	M16	16.0	2.00	15	300	600	10	200	400			

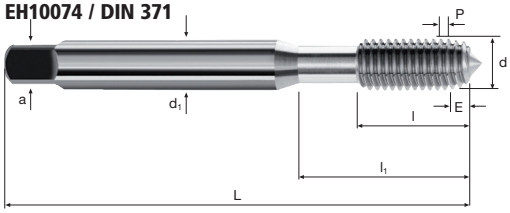
Material	M	ø [mm]	P [mm]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]
Stainless steel ferritc/martensitic A_5 > 10%	M 2	2.0	0.40	15	2385	954	10	1590	636
	M 2.2	2.2	0.45	15	2170	977	10	1445	650
	M 2.5	2.5	0.45	15	1910	860	10	1275	574
	M 3	3.0	0.50	15	1590	795	10	1060	530
	M 4	4.0	0.70	15	1195	837	10	795	557
	M 5	5.0	0.80	15	955	764	10	635	508
	M 6	6.0	1.00	15	795	795	10	530	530
	M 8	8.0	1.25	15	595	744	10	400	500
	M10	10.0	1.50	15	475	713	10	320	480
Stainless steel ferritc/martensitic A_5 > 10%	M12	12.0	1.75	15	400	700	10	265	464
	M14	14.0	2.00	15	340	680	10	225	450
	M16	16.0	2.00	15	300	600	10	200	400
Stainless steel [Cr-Ni/1.4301]	M 2	2.0	0.40	15	2385	954	10	1590	636
	M 2.2	2.2	0.45	15	2170	977	10	1445	650
	M 2.5	2.5	0.45	15	1910	860	10	1275	574
	M 3	3.0	0.50	15	1590	795	10	1060	530
	M 4	4.0	0.70	15	1195	837	10	795	557
	M 5	5.0	0.80	15	955	764	10	635	508
	M 6	6.0	1.00	15	795	795	10	530	530
	M 8	8.0	1.25	15	595	744	10	400	500
	M10	10.0	1.50	15	475	713	10	320	480
Stainless steel [Cr-Ni/1.4301]	M12	12.0	1.75	15	400	700	10	265	464
	M14	14.0	2.00	15	340	680	10	225	450
	M16	16.0	2.00	15	300	600	10	200	400

Cold forming taps

St

M	ISO 3 (6G)
60°	HSS PM/F
DIN 371/376	
	Form E (X · P)

EH10074 / DIN 371



EH10075 / DIN 376

Rm < 850	Rm 850-1100						Inox Stainless		

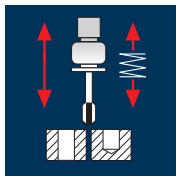
Example: Order-N°. EH10074 (Article-N°.) .034 (ø-Code)

Ø Code	d	P	L	l	l1	d1	a				TiCN EH10074
.034	M 2	0.40	45	8	–	2.8	2.1	3	1.80		●
.036	M 2.2	0.45	45	9	–	2.8	2.1	3	2.00		●
.040	M 2.5	0.45	50	9	–	2.8	2.1	3	2.30		●
.044	M 3	0.50	56	12	18.0	3.5	2.7	3	2.80		●
.058	M 4	0.70	63	13	21.0	4.5	3.4	3	3.70		●
.084	M 5	0.80	70	15	25.0	6.0	4.9	4	4.60		●
.088	M 6	1.00	80	17	30.0	6.0	4.9	4	5.50		●
.160	M 8	1.25	90	20	35.0	8.0	6.2	5	7.40		●
.174	M10	1.50	100	22	39.0	10.0	8.0	5	9.30		●

Example: Order-N°. EH10075 (Article-N°.) .240 (ø-Code)

Ø Code	d	P	L	l	l1	d1	a				TiCN EH10075
.240	M12	1.75	110	24	40	9.0	7.0	7	11.20		●
.244	M14	2.00	110	26	40	11.0	9.0	7	13.10		●
.246	M16	2.00	110	27	40	12.0	9.0	7	15.10		●

Application



Material

Material	M	ø [mm]	P [mm]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]	v_c 3.0 x d	n [min⁻¹]	v_f [100%]
Unalloyed aluminium	M 2	2.0	0.40	25	3980	1592	20	3185	1274	15	2385	954
	M 2.2	2.2	0.45	25	3615	1627	20	2895	1303	15	2170	977
	M 2.5	2.5	0.45	25	3185	1433	20	2545	1145	15	1910	860
	M 3	3.0	0.50	25	2655	1328	20	2120	1060	15	1590	795
	M 4	4.0	0.70	25	1990	1393	20	1590	1113	15	1195	837
	M 5	5.0	0.80	25	1590	1272	20	1275	1020	15	955	764
	M 6	6.0	1.00	25	1325	1325	20	1060	1060	15	795	795
	M 8	8.0	1.25	25	995	1244	20	795	994	15	595	744
	M10	10.0	1.50	25	795	1193	20	635	953	15	475	713
Wrought aluminium alloys Si < 6% not hardened	M 2	2.0	0.40	30	4775	1910	25	3980	1592	20	3185	1274
	M 2.2	2.2	0.45	30	4340	1953	25	3615	1627	20	2895	1303
	M 2.5	2.5	0.45	30	3820	1719	25	3185	1433	20	2545	1145
	M 3	3.0	0.50	30	3185	1593	25	2655	1328	20	2120	1060
	M 4	4.0	0.70	30	2385	1670	25	1990	1393	20	1590	1113
	M 5	5.0	0.80	30	1910	1528	25	1590	1272	20	1275	1020
	M 6	6.0	1.00	30	1590	1590	25	1325	1325	20	1060	1060
	M 8	8.0	1.25	30	1195	1494	25	995	1244	20	795	994
	M10	10.0	1.50	30	955	1433	25	795	1193	20	635	953
Unalloyed copper	M 2	2.0	0.40	15	2385	954	10	1590	636	10	1590	636
	M 2.2	2.2	0.45	15	2170	977	10	1445	650	10	1445	650
	M 2.5	2.5	0.45	15	1910	860	10	1275	574	10	1275	574
	M 3	3.0	0.50	15	1590	795	10	1060	530	10	1060	530
	M 4	4.0	0.70	15	1195	837	10	795	557	10	795	557
	M 5	5.0	0.80	15	955	764	10	635	508	10	635	508
	M 6	6.0	1.00	15	795	795	10	530	530	10	530	530
	M 8	8.0	1.25	15	595	744	10	400	500	10	400	500
	M10	10.0	1.50	15	475	713	10	320	480	10	320	480
Non ferrous metal A_5 > 15%	M 2	2.0	0.40	15	2385	954	10	1590	636	10	1590	636
	M 2.2	2.2	0.45	15	2170	977	10	1445	650	10	1445	650
	M 2.5	2.5	0.45	15	1910	860	10	1275	574	10	1275	574
	M 3	3.0	0.50	15	1590	795	10	1060	530	10	1060	530
	M 4	4.0	0.70	15	1195	837	10	795	557	10	795	557
	M 5	5.0	0.80	15	955	764	10	635	508	10	635	508
	M 6	6.0	1.00	15	795	795	10	530	530	10	530	530
	M 8	8.0	1.25	15	595	744	10	400	500	10	400	500
	M10	10.0	1.50	15	475	713	10	320	480	10	320	480

Cold forming taps

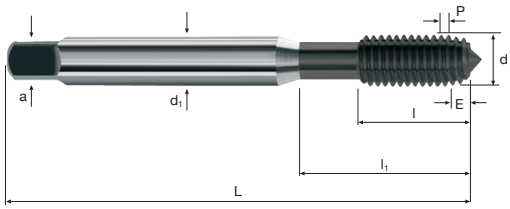
Al

M | 7G

60° | HSS PM/F

DIN 371

X · P
Form E

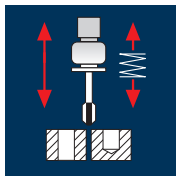


			Al Aluminium > 99%	Al Aluminium Alloy			Cu Copper		CuZn Brass

Example:
Order-N°. Article-N°. **EF10068** ø-Code **.034**

Ø Code	d	P	L	l	l1	d1	a			F-DLC EF10068
.034	M 2	0.40	45	8	–	2.8	2.1	3	1.80	●
.036	M 2.2	0.45	45	9	–	2.8	2.1	3	2.00	●
.040	M 2.5	0.45	50	9	–	2.8	2.1	3	2.30	●
.044	M 3	0.50	56	12	18.0	3.5	2.7	3	2.80	●
.058	M 4	0.70	63	13	21.0	4.5	3.4	3	3.70	●
.084	M 5	0.80	70	15	25.0	6.0	4.9	4	4.60	●
.088	M 6	1.00	80	17	30.0	6.0	4.9	4	5.50	●
.160	M 8	1.25	90	20	35.0	8.0	6.2	4	7.40	●
.174	M10	1.50	100	22	39.0	10.0	8.0	4	9.30	●

Application



Material

M	ø [mm]	P [mm]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]	v_c 3.0 x d	n [min⁻¹]	v_f [100%]
Steel < 850 N/mm² A_5 > 10%											
M 2	2.0	0.40	20	3185	1274	15	2385	954	10	1590	636
M 2.2	2.2	0.45	20	2895	1303	15	2170	977	10	1445	650
M 2.5	2.5	0.45	20	2545	1145	15	1910	860	10	1275	574
M 3	3.0	0.50	20	2120	1060	15	1590	795	10	1060	530
M 4	4.0	0.70	20	1590	1113	15	1195	837	10	795	557
M 5	5.0	0.80	20	1275	1020	15	955	764	10	635	508
M 6	6.0	1.00	20	1060	1060	15	795	795	10	530	530
M 8	8.0	1.25	20	795	994	15	595	744	10	400	500
M10	10.0	1.50	20	635	953	15	475	713	10	320	480
Steel 850 - 1100 N/mm² A_5 > 10%											
M 2	2.0	0.40	15	2385	954	10	1590	636			
M 2.2	2.2	0.45	15	2170	977	10	1445	650			
M 2.5	2.5	0.45	15	1910	860	10	1275	574			
M 3	3.0	0.50	15	1590	795	10	1060	530			
M 4	4.0	0.70	15	1195	837	10	795	557			
M 5	5.0	0.80	15	955	764	10	635	508			
M 6	6.0	1.00	15	795	795	10	530	530			
M 8	8.0	1.25	15	595	744	10	400	500			
M10	10.0	1.50	15	475	713	10	320	480			
Stainless steel ferritc/martensitic A_5 > 10%											
M 2	2.0	0.40	15	2385	954	10	1590	636			
M 2.2	2.2	0.45	15	2170	977	10	1445	650			
M 2.5	2.5	0.45	15	1910	860	10	1275	574			
M 3	3.0	0.50	15	1590	795	10	1060	530			
M 4	4.0	0.70	15	1195	837	10	795	557			
M 5	5.0	0.80	15	955	764	10	635	508			
M 6	6.0	1.00	15	795	795	10	530	530			
M 8	8.0	1.25	15	595	744	10	400	500			
M10	10.0	1.50	15	475	713	10	320	480			
Stainless steel [Cr-Ni/1.4301]											
M 2	2.0	0.40	15	2385	954	10	1590	636			
M 2.2	2.2	0.45	15	2170	977	10	1445	650			
M 2.5	2.5	0.45	15	1910	860	10	1275	574			
M 3	3.0	0.50	15	1590	795	10	1060	530			
M 4	4.0	0.70	15	1195	837	10	795	557			
M 5	5.0	0.80	15	955	764	10	635	508			
M 6	6.0	1.00	15	795	795	10	530	530			
M 8	8.0	1.25	15	595	744	10	400	500			
M10	10.0	1.50	15	475	713	10	320	480			

Cold forming taps

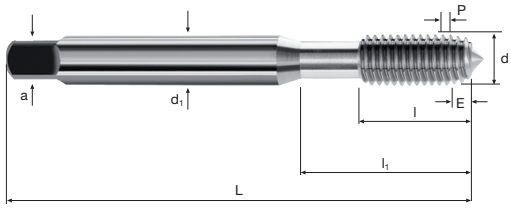
St

M | 7G

60° | HSS PM/F

DIN 371

X · P
Form E



Rm < 850	Rm 850-1100						Inox Stainless		

Example:
Order-N°. **EH10078** **.034**
(Article-N°. / ø-Code)

Ø Code	d	P	L	l	l1	d1	a			TiCN EH10078
.034	M 2	0.40	45	8	–	2.8	2.1	3	1.80	●
.036	M 2.2	0.45	45	9	–	2.8	2.1	3	2.00	●
.040	M 2.5	0.45	50	9	–	2.8	2.1	3	2.30	●
.044	M 3	0.50	56	12	18.0	3.5	2.7	3	2.80	●
.058	M 4	0.70	63	13	21.0	4.5	3.4	4	3.70	●
.084	M 5	0.80	70	15	25.0	6.0	4.9	4	4.60	●
.088	M 6	1.00	80	17	30.0	6.0	4.9	4	5.50	●
.160	M 8	1.25	90	20	35.0	8.0	6.2	5	7.40	●
.174	M10	1.50	100	22	39.0	10.0	8.0	5	9.30	●