

Solid Carbide Forming Tap for Aluminum

Tapping by Forming Soft Materials

NEW PORTFOLIO!

EXPANSION Solid Carbide High-Performance
Thread Forming Solution
for Soft Aluminum and Cast Aluminum

- Expanded Material Options: Solid Carbide.
- The addition of Solid Carbide forming taps enables higher spindle speeds, longer tool life, and enhanced performance in demanding production environments.
- Radial Internal Coolant

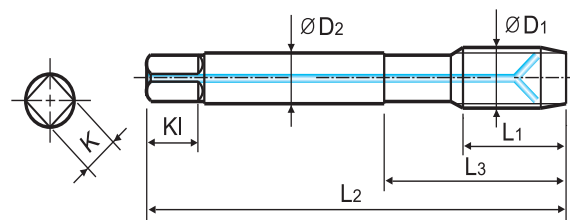


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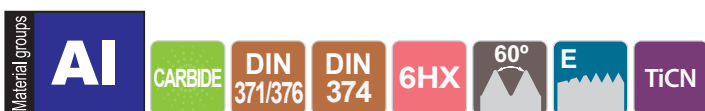
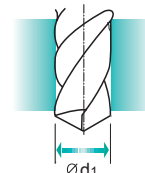
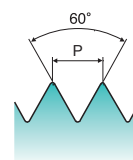
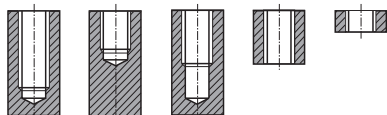
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Tapping by Forming Soft Materials



Short Chamfer

Hole type
3.0×D



Machine Taps

M ISO Metric Coarse Threads - DIN 13

DIN 371/376

SERIES

TOQ01

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Lobe	Tapping Drill Diameter
ØD ₁	P	TiCN	L ₁	L ₂	L ₃	ØD ₂	K	KI	Z	Ød ₁
M4	x 0.7	TOQ01246TICP	13	63	21	4.5	3.4	6	4	3.7
M5	x 0.8	TOQ01286TICP	15	70	25	6	4.9	8	4	4.65
M6	x 1.0	TOQ01316TICP	17	80	30	6	4.9	8	4	5.55
M8	x 1.25	TOQ01366TICP	20	90	35	8	6.2	9	6	7.4
M10	x 1.5	TOQ01426TICP	22	100	39	10	8	11	8	9.3
M12	x 1.75	TOQ01506TICP	24	110	44	9	7	10	8	11.2

► DIN 371(M4~M10) and DIN 376(M12)

MF ISO Metric Fine Threads - DIN 13

DIN 374

SERIES

TOQ02

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Lobe	Tapping Drill Diameter
ØD ₁	P	TiAlN	L ₁	L ₂	L ₃	ØD ₂	K	KI	Z	Ød ₁
M6	x 0.75	TOQ02326TICP	13	80	30	4.5	3.4	6	4	5.7
M6	x 0.5	TOQ02336TICP	13	80	30	4.5	3.4	6	4	5.8
M8	x 1.0	TOQ02376TICP	17	90	36	6	4.9	8	6	7.5
M8	x 0.75	TOQ02386TICP	14	80	30	6	4.9	8	6	7.7
M10	x 1.25	TOQ02436TICP	22	100	40	7	5.5	8	8	9.4
M10	x 1.0	TOQ02446TICP	18	90	36	7	5.5	8	8	9.5
M12	x 1.5	TOQ02516TICP	22	100	40	9	7	10	8	11.3
M12	x 1.25	TOQ02526TICP	22	100	40	9	7	10	8	11.4
M12	x 1.0	TOQ02536TICP	18	100	40	9	7	10	8	11.5

RECOMMENDED CUTTING CONDITIONS

Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)		
	21	22	23	24	25	26	27	28
VDI 3323	21	22	23	24	25	26	27	28
Vc (m/min.)	20 - 60	20 - 60	20 - 50	20 - 50	20 - 50	20 - 60	20 - 60	20 - 60