

Intro

SP-BLF V

GP General Purpose Series

Spiral Fluted Taps, Deep Hole Use, Coated

SP

DIN

SL

PO

ST

ROLL

CARBIDE

LONG

HAND TAPS

EG (STI)

SPECIAL THREADS, GAUGES

THREAD MILLS

DIES

CENTER DRILLS

Technical info



FEATURES

General purpose for blind hole application.

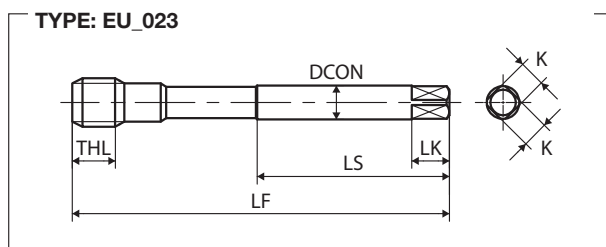
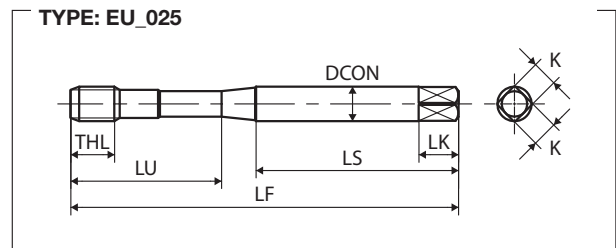
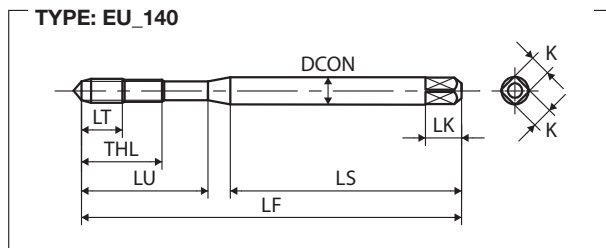
For tapping steel, also suitable for stainless steel and non-ferrous materials application.


BLF geometry reduces edge chipping trouble and improves chip ejection.

Recommended Tapping Speeds Depending On Materials

ISO	Vc (m/min)	★	ISO	Vc (m/min)	☆	ISO	Vc (m/min)	☆
P1	10÷20	★	M1	6÷12	☆	N1	10÷20	☆
P2	10÷20	★				N2	10÷20	☆
P3	10÷20	★				N3	10÷20	☆
P4	10÷15	★				N4	10÷20	☆
P7	6÷12	☆						

★ 1st choice ☆ suitable



M	TCTR (tolerance)	 Hole Ø (mm)	Hole Ø (mm)	Code	THCHT (chamfer)	LF (mm)	THL (mm)	LU (mm)	LS (mm)	DCON (mm)	K (mm)	LK (mm)	NOF	Type	Stock
DIN 371															
M3X0.5	IS02(6H)	2.5	2.56	96473.0TI	2.5P	56	9	18	34	3.5	2.7	6	3	140	●
M4X0.7	IS02(6H)	3.3	3.38	96474.0TI	2.5P	63	13	21	38	4.5	3.4	6	3	140	●
M5X0.8	IS02(6H)	4.2	4.28	96475.0TI	2.5P	70	14	25	39	6	4.9	8	3	140	●
M6X1	IS02(6H)	5	5.09	96476.0TI	2.5P	80	15	30	45	6	4.9	8	3	140	●
M8X1.25	IS02(6H)	6.8	6.85	96478.0TI	2.5P	90	19	35	47	8	6.2	9	3	025	●
M10X1.5	IS02(6H)	8.5	8.6	9647010TI	2.5P	100	23	39	52	10	8	11	3	025	●
DIN 376															
M12X1.75	IS02(6H)	10.3	10.36	9747012TI	2.5P	110	26	-	56	9	7	10	3	023	●
M14X2	IS02(6H)	12	12.12	9747014TI	2.5P	110	26	-	56	11	9	12	3	023	●
M16X2	IS02(6H)	14	14.12	9747016TI	2.5P	110	26	-	56	12	9	12	3	023	●
M18X2.5	IS02(6H)	15.5	15.63	9747018TI	2.5P	125	33	-	64	14	11	14	4	023	●
M20X2.5	IS02(6H)	17.5	17.63	9747020TI	2.5P	140	33	-	71	16	12	15	4	023	●
M22X2.5	IS02(6H)	19.5	19.63	9747022TI	2.5P	140	33	-	71	18	14.5	17	4	023	●
M24X3	IS02(6H)	21	21.13	9747024TI	2.5P	160	37	-	82	18	14.5	17	4	023	●

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