



OMEPHA ALEMANIA MÉXICO S.A. de C.V.
Fuente de la Lluvia 263
Colonia Balcones de Valle
78280 San Luis Potosí, S.L.P., México

Tel (444) 820 5465
Cel (444) 104 1350
info@omepha-alemania-mexico.com
www.omepha-alemania-mexico.com



Speedtap

D Hochleistungsgewindewerkzeuge

E High performance threading tools

I Maschi per alto rendimento

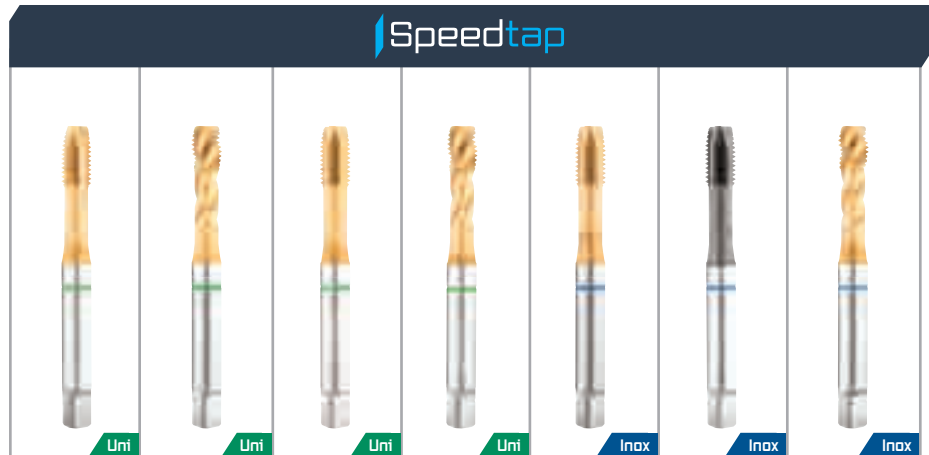


D **Übersicht**
Maschinengewindebohrer
Speedtap

E **Overview**
Machine taps
Speedtap

I **Sommario**
Maschi a macchina
Speedtap

D Anwendungsbereiche der Farbiring-Maschinengewindebohrer auf Seite 016.
E Application range of colour-ring machine taps on page 016.
I Impiego maschi a macchina funzione colore anello pagina 016.



Norm / Standard	DIN 371 / DIN 376						
Gewindeart / Type of thread / Tipo di maschio	M	M	M	M	M	M	M
Lochart / Hole type / Tipo di fore							
Toleranz / Tolerance / Tolleranza	ISO2 6H	ISO2 6H	ISO2 6H	ISO2 6H	ISO2 6H	ISO2 6H	ISO2 6H
Anschnitt / Chamfer / Imbocco	B	C	B	C	B	B	C
Drallwinkel / Spiral angle / Angolo elica		38°		38°			45°
Schneidstoff / Cutting material / Acciaie	HSS-Co5	HSS-Co5	HSS-Co5	HSS-Co5	HSS-Co5	HSS-Co5	HSS-Co5
Beschichtung / Coating / Rivestimento	TiN	TiN	TiN	TiN	TiN	ALLUNIT-S®	TiN
Ø mm	M 3 - M 16	M 3 - M 20	M 3 - M 24	M 3 - M 24	M 2 - M 16	M 2 - M 16	M 3 - M 16
Code / Codice	4724	4754	4734	4764	4814	4834	4844
Seite / Page / Pagina	270	271	272	273	274	274	275

Geeignet für / Suitable for / Adatte per							
	Stähle < 400 N/mm² Steels < 400 N/mm² Acciai < 400 N/mm²						
	Stähle < 850 N/mm² Steels < 850 N/mm² Acciai < 850 N/mm²						
	Stähle < 1.100 N/mm² Steels < 1.100 N/mm² Acciai < 1.100 N/mm²						
	Stähle < 1.300 N/mm² Steels < 1.300 N/mm² Acciai < 1.300 N/mm²						
	Stähle > 45 HRC Steels > 45 HRC Acciai > 45 HRC						
	Rostfreie Stähle < 850 N/mm² Stainless steels < 850 N/mm² Acciai inossidabili < 850 N/mm²						
	Rostfreie Stähle > 850 N/mm² Stainless steels > 850 N/mm² Acciai inossidabili > 850 N/mm²						
	Grauguss, Temperguss Cast iron, malleable cast iron Ghisa grigia, ghisa malleabile						
	Titan- und Titanlegierung Titanium and titanium alloys Titanio e leghe di Titanio						
	Kupfer, Messing Copper, brass Rame, ottone						
	Aluminium Aluminium Alluminio						
	Kunststoffe Plastics Materie plastiche						

D Übersicht





















































































Maschinengewindebohrer
Speedtap

E Overview

Machine taps
Speedtap

I Sommario

Maschi a macchina
Speedtap

Speedtap									
									
Inox	Inox	Inox	Inox	HRC	Cast iron	Alu	Alu	Uni	Inox
DIN 371 / DIN 376				DIN 2184-2	DIN 371 / DIN 376		DIN 371	DIN 2174	
M	M	M	M	M	M	M	M	M	M
									
IS02 6H	IS03 6G	IS03 6G	IS02 6H	6HX	6HX	IS02 6H	IS02 6H	6HX	6HX
C	B	C	E	C	C	B	C	C	C
45°		45°	45°				38°		
HSS-Co5	HSS-Co5	HSS-Co5	HSS-Co5	VHM / Carbide / MDI	HSS-E/PM	HSS-Co5	HSS-Co5	HSS-Co5	HSS-E/PM
ALUNIT-S*	TiN	TiN	ALUNIT-S*	TiCN	TiCN			TiN	TiN
M 3 - M 16	M 3 - M 10	M 3 - M 10	M 3 - M 16	M 4 - M 12	M 5 - M 16	M 3 - M 10	M 3 - M 10	M 3 - M 16	M 3 - M 16
4874	4824	4854	4864	5014	5114	4914	4924	4784	4884
275	276	277	278	279	280	281	282	283	284
									
									
									
									
									
				<63 HRC					
									
									
									
									
									



D Maschinengewindebohrer Speedtap-Universal, gerade genutet, für metrisches ISO-Gewinde DIN 13

Einsatzbereich:
HSS Cobalt Gewindebohrer für Durchgangsgewinde 3xd1. Besonders geeignet für unlegierten und legierten Stahl <900 N/mm² wie z.B. Baustahl, Einsatzstahl, Aluminium legiert Si>1%.

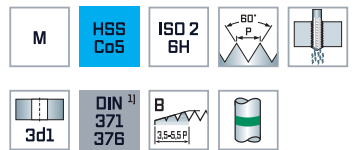
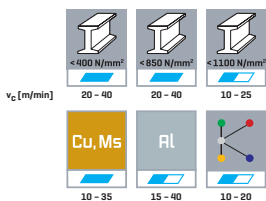
E Machine taps Speedtap-Universal, straight fluted, for metric ISO-threads DIN 13

Range of application:
HSS Cobalt tap for through hole threads 3xd1. Especially suitable for non-alloyed and alloyed steels <900 N/mm² e.g. structural steel, case-hardened steel, aluminium alloy Si >1%.

I Maschi a macchina Speedtap-Universal, scanalature diritte, per filettatura metrica ISO, DIN 13

Impiego:
Maschi al Cobalto HSS per fori passanti 3xd1. Particolarmente adatti per acciai legati e non legati <900 N/mm² come p.es. acciaio da costruzione, acciaio da cementazione, alluminio in lega con Si>1%.

Speedtap



TiN

d1 mm	P mm	l1 mm	l2 mm	l3 mm	d2 _{h9} mm	a _{h12} mm		Code 4724 Art.-Nr.
M 3	0,5	56	10	18	3,5	2,7	Ø 2,5 mm	0 4724003001 00
M 4	0,7	63	12	21	4,5	3,4	Ø 3,3 mm	0 4724004001 00
M 5	0,8	70	14	25	6	4,9	Ø 4,2 mm	0 4724005001 00
M 6	1	80	16	30	6	4,9	Ø 5,0 mm	0 4724006001 00
M 8	1,25	90	18	35	8	6,2	Ø 6,8 mm	0 4724008001 00
M 10	1,5	100	20	39	10	8	Ø 8,5 mm	0 4724010001 00
M 12	1,75	110	24	-	9	7	Ø 10,2 mm	0 4724012001 00
M 16	2	110	27	-	12	9	Ø 14,0 mm	0 4724016001 00

⁽¹⁾ DIN 371 ≤ M 10
DIN 376 ≥ M 12

D Maschinengewindebohrer Speedtap-Universal, spiral genutet, für metrisches ISO-Gewinde DIN 13

E Machine taps Speedtap-Universal, spiral fluted, for metric ISO-threads DIN 13

I Maschi a macchina Speedtap-Universal, scanalature elicoidali, per filettatura metrica ISO, DIN 13

Einsatzbereich:

HSS Cobalt Gewindebohrer für Grundgewinde 2,5xd1. Besonders geeignet für unlegierten und legierten Stahl <900 N/mm² wie z.B. Baustahl, Einsatzstahl, Aluminium legiert Si>1%.

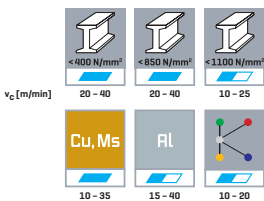
Range of application:

HSS Cobalt tap for blind hole threads 2,5xd1. Especially suitable for non-alloyed and alloyed steels <900 N/mm² e.g. structural steel, case-hardened steel, aluminium alloy Si >1%.

Impiego:

Maschi al Cobalto HSS per fori ciechi 2,5xd1. Particolarmente adatti per acciai legati e non legati <900 N/mm² come p.es. acciaio da costruzione, acciaio da cementazione, alluminio in lega con Si >1%.

Speedtap



Uni



TiN

d1 mm	P mm	l1 mm	l2 mm	l3 mm	d2 h9 mm	a h12 mm		Code 4754 Art.-Nr.
M 3	0,5	56	7	18	3,5	2,7	Ø 2,5 mm	0 4754003001 00
M 4	0,7	63	8	21	4,5	3,4	Ø 3,3 mm	0 4754004001 00
M 5	0,8	70	9	25	6	4,9	Ø 4,2 mm	0 4754005001 00
M 6	1	80	10	30	6	4,9	Ø 5,0 mm	0 4754006001 00
M 8	1,25	90	13	35	8	6,2	Ø 6,8 mm	0 4754008001 00
M 10	1,5	100	15	39	10	8	Ø 8,5 mm	0 4754010001 00
M 12	1,75	110	18	-	9	7	Ø 10,2 mm	0 4754012001 00
M 16	2	110	20	-	12	9	Ø 14,0 mm	0 4754016001 00
M 20	2,5	140	25	-	16	12	Ø 17,5 mm	0 4754020001 00

⁽¹⁾ DIN 371 ≤ M 10
DIN 376 ≥ M 12



Speedtap

D Maschinengewindebohrer Speedtap-Universal,
gerade genutet, für metri-
sches ISO-Gewinde DIN 13

E Machine taps Speedtap-Universal,
straight fluted, for metric
ISO-threads DIN 13

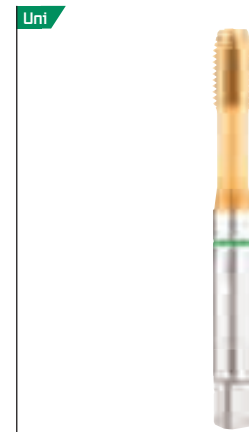
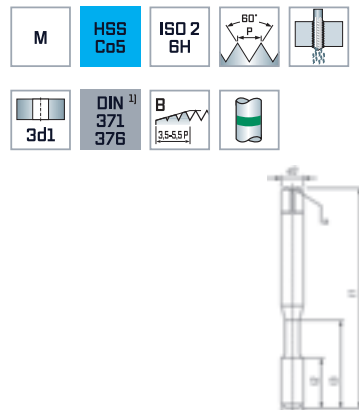
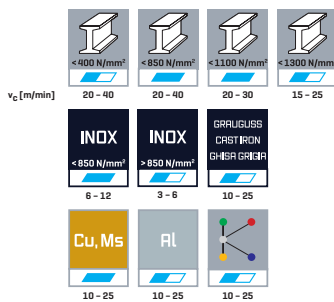
I Maschi a macchina Speedtap-Universal,
scanalature diritte, per
filettatura metrica ISO, DIN 13

Einsatzbereich:
HSS Cobalt Gewindebohrer für Durchgangs-
gewinde 3xd1. Besonders geeignet für legierten
Stahl 600 - 1100 N/mm² sowie für rostfreie
Cr-Ni-Stähle.

Range of application:
HSS Cobalt tap for through hole threads 3xd1.
Especially suitable for alloyed steels
600 - 1100 N/mm² and for stainless Cr-Ni steels.

Impiego:
Maschi al Cobalto HSS per fori passanti 3xd1. Par-
ticolarmenente adatti per acciai legati 600 - 1100 N/
mm² nonché acciai inossidabili Cr-Ni.

Speedtap



d1 mm	P mm	l1 mm	l2 mm	l3 mm	d2 _{h9} mm	a _{h12} mm		Code 4734 Art.-Nr.
M 3	0,5	56	10	18	3,5	2,7	Ø 2,5 mm	0 4734003001 00
M 4	0,7	63	12	21	4,5	3,4	Ø 3,3 mm	0 4734004001 00
M 5	0,8	70	14	25	6	4,9	Ø 4,2 mm	0 4734005001 00
M 6	1	80	16	30	6	4,9	Ø 5,0 mm	0 4734006001 00
M 8	1,25	90	18	35	8	6,2	Ø 6,8 mm	0 4734008001 00
M 10	1,5	100	20	39	10	8	Ø 8,5 mm	0 4734010001 00
M 12	1,75	110	24	-	9	7	Ø 10,2 mm	0 4734012001 00
M 14	2	110	25	-	11	9	Ø 12,0 mm	0 4734014001 00
M 16	2	110	27	-	12	9	Ø 14,0 mm	0 4734016001 00
M 20	2,5	140	32	-	16	12	Ø 17,5 mm	0 4734020001 00
M 24	3	160	36	-	18	14,5	Ø 21,0 mm	0 4734024001 00

⁽¹⁾ DIN 371 ≤ M 10
DIN 376 ≥ M 12

D Maschinengewindebohrer
Speedtap-Universal,
 spiral genutet, für metri-
 sches ISO-Gewinde DIN 13

E Machine taps
Speedtap-Universal,
 spiral fluted, for metric
 ISO-threads DIN 13

I Maschi a macchina
Speedtap-Universal,
 scanalature elicoidali, per
 filettatura metrica ISO, DIN 13

Einsatzbereich:

HSS Cobalt Gewindebohrer für Grundgewinde 2,5xd1. Besonders geeignet für legierten Stahl 600 - 1100 N/mm² sowie für rostfreie Cr-Ni-Stähle.

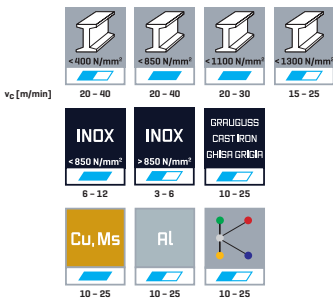
Range of application:

HSS Cobalt tap for blind hole threads 2,5xd1. Especially suitable for alloyed steels 600 - 1100 N/mm² and for stainless Cr-Ni steels.

Impiego:

Maschi al Cobalto HSS per fori ciechi 2,5xd1. Particolarmente adatti per acciai legati 600 - 1100 N/mm² nonché acciai inossidabili Cr-Ni.

Speedtap



TiN

d1 mm	P mm	l1 mm	l2 mm	l3 mm	d2 _{h9} mm	a _{h12} mm		Code 4764 Art.-Nr.
M 3	0,5	56	7	18	3,5	2,7	∅ 2,5 mm	0 4764003001.00
M 4	0,7	63	8	21	4,5	3,4	∅ 3,3 mm	0 4764004001.00
M 5	0,8	70	9	25	6	4,9	∅ 4,2 mm	0 4764005001.00
M 6	1	80	10	30	6	4,9	∅ 5,0 mm	0 4764006001.00
M 8	1,25	90	13	35	8	6,2	∅ 6,8 mm	0 4764008001.00
M 10	1,5	100	15	39	10	8	∅ 8,5 mm	0 4764010001.00
M 12	1,75	110	18	-	9	7	∅ 10,2 mm	0 4764012001.00
M 14	2	110	20	-	11	9	∅ 12,0 mm	0 4764014001.00
M 16	2	110	20	-	12	9	∅ 14,0 mm	0 4764016001.00
M 20	2,5	140	25	-	16	12	∅ 17,5 mm	0 4764020001.00
M 24	3	160	30	-	18	14,5	∅ 21,0 mm	0 4764024001.00

⁽¹⁾ DIN 371 ≤ M 10
 DIN 376 ≥ M 12



D Maschinengewindebohrer Speedtap-Inox,
gerade genutet, für metri-
sches ISO-Gewinde DIN 13

Einsatzbereich:
HSS Cobalt Gewindebohrer für Durchgangsgewinde 3xd1. Besonders geeignet für rostfreie Cr-Ni-Stähle, unlegierten und legierten Stahl <1200 N/mm², Kupfer und Kupferlegierungen kurzspanend <700 N/mm², Aluminium Si >6%.

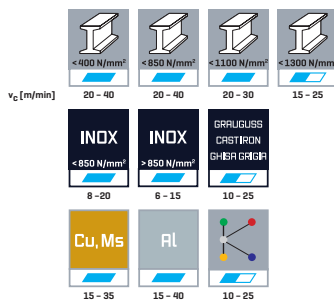
E Machine taps Speedtap-Inox,
straight fluted, for metric
ISO-threads DIN 13

Range of application:
HSS Cobalt tap for through hole threads 3xd1. Especially suitable for stainless Cr-Ni steels, non-alloyed and alloyed steels <1200 N/mm², copper and copper alloys short-chipping <700 N/mm², aluminium Si >6%.

I Maschi a macchina Speedtap-Inox,
scanalature dritte, per
filettatura metrica ISO, DIN 13

Impiego:
Maschi al Cobalto HSS per fori passanti 3xd1. Particolarmente adatti per acciai inossidabili Cr-Ni, acciai legati e non legati <1200N/mm², rame e leghe di rame a truciolo corto <700 N/mm², alluminio Si >6%.

Speedtap



d1 mm	P mm	l1 mm	l2 mm	l3 mm	d2 _{h9} mm	a _{h12} mm		Code 4814 Art.-Nr.	Code 4834 Art.-Nr.
M 2	0,4	45	9	-	2,8	2,1	Ø 1,6 mm	0 4814002001 00	0 4834002001 00
M 3	0,5	56	10	18	3,5	2,7	Ø 2,5 mm	0 4814003001 00	0 4834003001 00
M 4	0,7	63	12	21	4,5	3,4	Ø 3,3 mm	0 4814004001 00	0 4834004001 00
M 5	0,8	70	14	25	6	4,9	Ø 4,2 mm	0 4814005001 00	0 4834005001 00
M 6	1	80	16	30	6	4,9	Ø 5,0 mm	0 4814006001 00	0 4834006001 00
M 8	1,25	90	18	35	8	6,2	Ø 6,8 mm	0 4814008001 00	0 4834008001 00
M 10	1,5	100	20	39	10	8	Ø 8,5 mm	0 4814010001 00	0 4834010001 00
M 12	1,75	110	24	-	9	7	Ø 10,2 mm	0 4814012001 00	0 4834012001 00
M 16	2	110	27	-	12	9	Ø 14,0 mm	0 4814016001 00	0 4834016001 00

⁽¹⁾ DIN 371 ≤ M 10
DIN 376 ≥ M 12

D Maschinengewindebohrer Speedtap-Inox,
spiral genutet, für metrisches ISO-Gewinde DIN 13

E Machine taps Speedtap-Inox,
spiral fluted, for metric ISO-threads DIN 13

I Maschi a macchina Speedtap-Inox,
scanalature elicoidali, per filettatura metrica ISO, DIN 13

Einsatzbereich:

HSS Cobalt Gewindebohrer für Grundgewinde 3xd1. Besonders geeignet für rostfreie Cr-Ni-Stähle, unlegierten und legierten Stahl <1100N/mm², Kupfer und Kupferlegierungen kurzspanend <700 N/mm², Aluminium Si >6%.

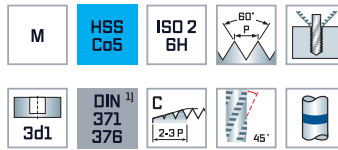
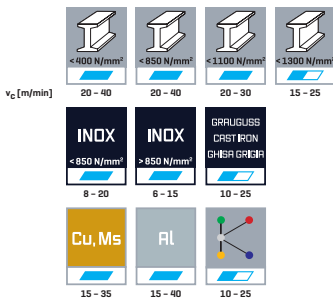
Range of application:

HSS Cobalt tap for blind hole threads 3xd1. Especially suitable for stainless Cr-Ni steels, non-alloyed or alloyed steels <1100 N/mm², copper and copper alloys short-chipping <700 N/mm², aluminium Si >6%.

Impiego:

Maschi al Cobalto HSS per fori ciechi 3xd1. Particolarmente adatti per acciai inossidabili Cr-Ni, acciai legati e non legati <1100N/mm², rame e leghe di rame a truciolo corto <700 N/mm², alluminio Si >6%.

Speedtap



d1 mm	P mm	l1 mm	l2 mm	l3 mm	d2 _{h9} mm	a _{h12} mm		Code 4844 Art.-Nr.	Code 4874 Art.-Nr.
M 3	0,5	56	7	18	3,5	2,7	∅ 2,5 mm	0 4844003001 00	0 4874003001 00
M 4	0,7	63	8	21	4,5	3,4	∅ 3,3 mm	0 4844004001 00	0 4874004001 00
M 5	0,8	70	9	25	6	4,9	∅ 4,2 mm	0 4844005001 00	0 4874005001 00
M 6	1	80	10	30	6	4,9	∅ 5,0 mm	0 4844006001 00	0 4874006001 00
M 8	1,25	90	13	35	8	6,2	∅ 6,8 mm	0 4844008001 00	0 4874008001 00
M 10	1,5	100	15	39	10	8	∅ 8,5 mm	0 4844010001 00	0 4874010001 00
M 12	1,75	110	18	-	9	7	∅ 10,2 mm	0 4844012001 00	0 4874012001 00
M 16	2	110	20	-	12	9	∅ 14,0 mm	0 4844016001 00	0 4874016001 00

⁽¹⁾ DIN 371 ≤ M 10
DIN 376 ≥ M 12



D **Maschinengewindebohrer Speedtap-Inox,**
gerade genutet, für metri-
sches ISO-Gewinde DIN 13

Einsatzbereich:

HSS Cobalt Gewindebohrer für Durchgangs-
gewinde 3xd1, ISO 3/6G Toleranz. Besonders
geeignet für rostfreie Cr-Ni-Stähle, unlegierten
und legierten Stahl <1100N/mm², Kupfer und
Kupferlegierungen kurzspanend <700 N/mm²,
Aluminium Si >6%.

E **Machine taps Speedtap-Inox,**
straight fluted, for metric
ISO-threads DIN 13

Range of application:

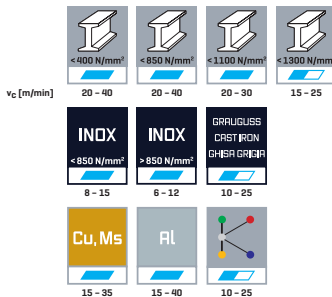
HSS Cobalt tap for through hole threads 3xd1,
ISO 3/6G tolerance. Especially suitable for
stainless Cr-Ni steels, non-alloyed and alloyed
steels <1100 N/mm², copper and copper alloys
short-chipping <700 N/mm², aluminium Si >6%.

I **Maschi a macchina Speedtap-Inox,**
scanalature dritte, per
filettatura metrica ISO, DIN 13

Impiego:

Maschi al Cobalto HSS per fori passanti 3xd1 con
tolleranza ISO 3/6G. Particolarmente adatti per
acciai inossidabili Cr-Ni, acciai legati e non legati
<1100N/mm², rame e leghe di rame a truciolo corto
<700 N/mm², alluminio Si >6%.

Speedtap



Inox



TiN

d1 mm	P mm	l1 mm	l2 mm	l3 mm	d2 _{h9} mm	a _{h12} mm		Code 4824 Art.-Nr.
M 3	0,5	56	10	18	3,5	2,7	∅ 2,5 mm	0 4824003001 00
M 4	0,7	63	12	21	4,5	3,4	∅ 3,3 mm	0 4824004001 00
M 5	0,8	70	14	25	6	4,9	∅ 4,2 mm	0 4824005001 00
M 6	1	80	16	30	6	4,9	∅ 5,0 mm	0 4824006001 00
M 8	1,25	90	18	35	8	6,2	∅ 6,8 mm	0 4824008001 00
M 10	1,5	100	20	39	10	8	∅ 8,5 mm	0 4824010001 00

D Maschinengewindebohrer Speedtap-Inox,
spiral genutet, für metri-
sches ISO-Gewinde DIN 13

E Machine taps Speedtap-Inox,
spiral fluted, for metric
ISO-threads DIN 13

I Maschi a macchina Speedtap-Inox,
scanalature elicoidali, per
filettatura metrica ISO, DIN 13

Einsatzbereich:

HSS Cobalt Gewindebohrer für Grundgewinde 3xd1, ISO 3/6G Toleranz. Besonders geeignet für rostfreie Cr-Ni-Stähle, unlegierten und legierten Stahl <1100N/mm², Kupfer und Kupferlegierungen kurzspanend <700 N/mm², Aluminium Si >6%.

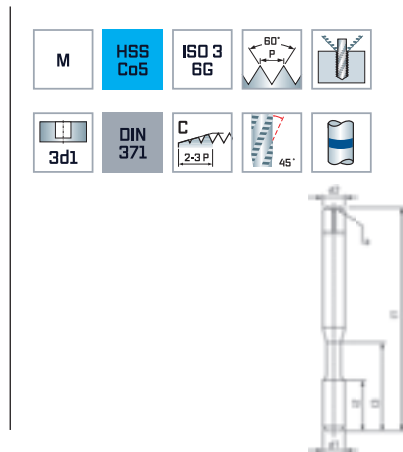
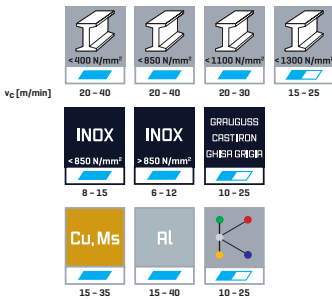
Range of application:

HSS Cobalt tap for blind hole threads 3xd1, ISO 3/6G tolerance. Especially suitable for stain-less Cr-Ni steels, non-alloyed and alloyed steels <1100 N/mm², copper and copper alloys short-chipping <700 N/mm², aluminium Si >6%.

Impiego:

Maschi al Cobalto HSS per fori ciechi 3xd1 con tolleranza ISO 3/6G. Particolarmente adatti per acciai inossidabili Cr-Ni, acciai legati e non legati <1100N/mm², rame e leghe di rame a truciolo corto <700 N/mm², alluminio Si >6%.

Speedtap



d1 mm	P mm	l1 mm	l2 mm	l3 mm	d2 _{h9} mm	a _{h12} mm		Code 4854 Art.-Nr.
M 3	0,5	56	7	18	3,5	2,7	∅ 2,5 mm	∅ 4854003001 00
M 4	0,7	63	8	21	4,5	3,4	∅ 3,3 mm	∅ 4854004001 00
M 5	0,8	70	9	25	6	4,9	∅ 4,2 mm	∅ 4854005001 00
M 6	1	80	10	30	6	4,9	∅ 5,0 mm	∅ 4854006001 00
M 8	1,25	90	13	35	8	6,2	∅ 6,8 mm	∅ 4854008001 00
M 10	1,5	100	15	39	10	8	∅ 8,5 mm	∅ 4854010001 00



D Maschinengewindebohrer Speedtap-Inox, kurz, spiral genutet, für metrisches ISO-Gewinde DIN 13

E Machine taps Speedtap-Inox, short series, spiral fluted, for metric ISO-threads DIN 13

I Maschi a macchina Speedtap-Inox, serie corta, scanalature elicoidali, per filettatura metrica ISO, DIN 13

Einsatzbereich:

HSS Cobalt Gewindebohrer mit kurzem Anschnitt für Grundgewinde 3xd1. Besonders geeignet für rostfreie Cr-Ni-Stähle, unlegierten und legierten Stahl <1100N/mm², Kupfer und Kupferlegierungen kurzspanend <700 N/mm², Aluminium Si >6%.

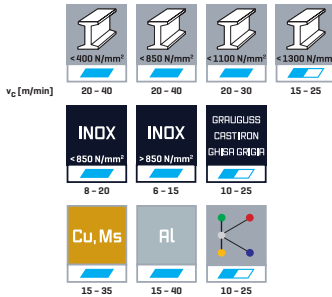
Range of application:

HSS Cobalt tap with short chamfer for blind hole threads 3xd1. Especially suitable for stainless Cr-Ni steels, non-alloyed and alloyed steels <1100 N/mm², copper and copper alloys short-chipping <700 N/mm², aluminium Si >6%.

Impiego:

Maschi al Cobalto HSS con imbocco corto per fori ciechi 3xd1. Particolarmente adatti per acciai inossidabili Cr-Ni, acciai legati e non legati <1100N/mm², rame e leghe di rame a truciolo corto <700 N/mm², alluminio Si >6%.

Speedtap



ALLUNIT-S®

d1 mm	P mm	l1 mm	l2 mm	l3 mm	d2 _{h9} mm	a _{h12} mm		Code 4864 Art.-Nr.
M 3	0,5	56	7	18	3,5	2,7	∅ 2,5 mm	0 4864003001 00
M 4	0,7	63	8	21	4,5	3,4	∅ 3,3 mm	0 4864004001 00
M 5	0,8	70	9	25	6	4,9	∅ 4,2 mm	0 4864005001 00
M 6	1	80	10	30	6	4,9	∅ 5,0 mm	0 4864006001 00
M 8	1,25	90	13	35	8	6,2	∅ 6,8 mm	0 4864008001 00
M 10	1,5	100	15	39	10	8	∅ 8,5 mm	0 4864010001 00
M 12	1,75	110	18	-	9	7	∅ 10,2 mm	0 4864012001 00
M 16	2	110	20	-	12	9	∅ 14,0 mm	0 4864016001 00

⁽¹⁾ DIN 371 ≤ M 10
DIN 376 ≥ M 12

D **VHM-Maschinengewindebohrer Speedtap-Ultra hard Steel 63 HRC,**
gerade genutet, für metrisches ISO-Gewinde DIN 13

E **Solid carbide machine taps Speedtap-Ultra hard steel 63 HRC,**
straight fluted, for metric ISO-threads DIN 13

I **Maschi a macchina MDI Speedtap-Ultra hard steel 63 HRC,**
scanalature diritte, per filettatura metrica ISO, DIN 13

Einsatzbereich:

VHM-Gewindebohrer für Durchgangs- und Grundgewinde 2xd1. Besonders geeignet für gehärteten Stahl bis 63 HRC, Sonderlegierungen (Wolfram-Kobaltlegierungen) und Titancarbid-Hartstoffe.

Range of application:

Solid carbide tap for through hole threads and blind hole threads 2xd1. Especially suitable for hardened steel up to 63 HRC, special alloys (tungsten-cobalt alloys) and hard titanium carbide materials.

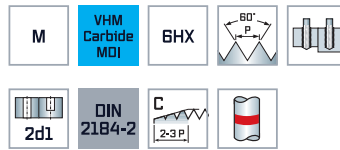
Impiego:

Maschi VHM per fori passanti e fori ciechi 2xd1. Particolarmente adatti per acciaio temprato fino a 63 HRC, leghe speciali (leghe wolframio-Cobalto) e carburo di titanio.

Speedtap



v_c [m/min] 1-4



HRC



TiCN

d1 mm	P mm	l1 mm	l2 mm	l3 mm	d2 _{H6} mm	a _{H12} mm		Code 5014 Art.-Nr.
M 4	0,7	45	13	-	4,5	3,4	Ø 3,3 mm	0 5014004001 00
M 5	0,8	50	16	-	6	4,9	Ø 4,2 mm	0 5014005001 00
M 6	1	56	19	-	6	4,9	Ø 5,0 mm	0 5014006001 00
M 8	1,25	63	25	-	8	6,2	Ø 6,8 mm	0 5014008001 00
M 10	1,5	70	30	-	10	8	Ø 8,5 mm	0 5014010001 00
M 12	1,75	75	24	-	9	7	Ø 10,2 mm	0 5014012001 00



D **Maschinengewindebohrer
Speedtap–Grauguss,**
gerade genutet, für metri-
sches ISO–Gewinde DIN 13

Einsatzbereich:

Gewindebohrer aus Pulverstahl für Durchgangs- und Grundgewinde 3xd1. Besonders geeignet für alle Gußeisen (Grauguß, Kugelgraphitguß, Temperguß, Vermikularguß, ADI, Hartguß) sowie für Magnesium und Magnesiumlegierungen, CFK und Graphit.

E **Machine taps
Speedtap–Cast iron,**
straight fluted, for metric
ISO–threads DIN 13

Range of application:

Tap made of powder steel for through hole threads and blind hole threads 3xd1. Especially suitable for all cast irons (grey cast iron, spheroidal graphite, malleable cast iron, vermicular, ADI, chilled iron) and for magnesium and magnesium alloys, CFRP and graphite.

I **Maschi a macchina
Speedtap–Ghisa grigia,**
scanalature diritte, per
filettatura metrica ISO, DIN 13

Impiego:

Maschi in acciaio da polveri per fori passanti e fori ciechi 3xd1. Particolarmente adatti per tutti i tipi di ghisa (ghisa grigia, ghisa sferoidale, ghisa temprata, ghisa vermiculare, ADI, ghisa temperata) nonché magnesio e leghe al magnesio, CFK e grafite.

Speedtap



v_c [m/min] 15 - 60



Cast iron



Grauguss
Cast iron
Ghisa grigia

TiCN

d1 mm	P mm	l1 mm	l2 mm	l3 mm	d2 _{h6} mm	a _{h12} mm		Code 5114 Art.-Nr.
M 5	0,8	70	14	25	6	4,9	∅ 4,2 mm	0 5114005001 00
M 6	1	80	16	30	6	4,9	∅ 5,0 mm	0 5114006001 00
M 8	1,25	90	18	35	8	6,2	∅ 6,8 mm	0 5114008001 00
M 10	1,5	100	20	39	10	8	∅ 8,5 mm	0 5114010001 00
M 12	1,75	110	24	-	9	7	∅ 10,2 mm	0 5114012001 00
M 16	2	110	27	-	12	9	∅ 14,0 mm	0 5114016001 00

⁽¹⁾ DIN 371 ≤ M 10
DIN 376 ≥ M 12

D Maschinengewindebohrer Speedtap-Aluminium,
gerade genutet, für metri-
sches ISO-Gewinde DIN 13

E Machine taps Speedtap-Aluminium,
straight fluted, for metric
ISO-threads DIN 13

I Maschi a macchina Speedtap-Aluminium,
scanalature diritte, per
filettatura metrica ISO, DIN 13

Einsatzbereich:

HSS Cobalt Gewindebohrer für Durchgangsge-
winde 3xd1. Besonders geeignet für Aluminium
Si ≤ 0,5%, Thermoplaste langspanend.

Range of application:

HSS Cobalt tap for through hole threads 3xd1.
Especially suitable for aluminium Si ≤ 0.5%,
thermoplastics long-chipping.

Impiego:

Maschi al Cobalto HSS per fori passanti
3xd1. Particolarmente adatti per alluminio
Si ≤ 0,5%, materiali termoplastici a truciolo lungo.

Speedtap




d1 mm	P mm	l1 mm	l2 mm	l3 mm	d2 _{h9} mm	a _{h12} mm		Code 4914 Art.-Nr.
M 3	0,5	56	10	18	3,5	2,7	Ø 2,5 mm	0 4914003001 00
M 4	0,7	63	12	21	4,5	3,4	Ø 3,3 mm	0 4914004001 00
M 5	0,8	70	14	25	6	4,9	Ø 4,2 mm	0 4914005001 00
M 6	1	80	16	30	6	4,9	Ø 5,0 mm	0 4914006001 00
M 8	1,25	90	18	35	8	6,2	Ø 6,8 mm	0 4914008001 00
M 10	1,5	100	20	39	10	8	Ø 8,5 mm	0 4914010001 00



D **Maschinengewindebohrer**
Speedtap–Aluminium,
spiral genutet, für metri-
sches ISO-Gewinde DIN 13

E **Machine taps**
Speedtap–Aluminium,
spiral fluted, for metric
ISO-threads DIN 13

I **Maschi a macchina**
Speedtap–Aluminium,
scanalature elicoidali, per
filettatura metrica ISO, DIN 13

Einsatzbereich:
HSS Cobalt Gewindebohrer für Grundgewinde
2,5xd1. Besonders geeignet für Aluminium
Si ≤ 0,5%, Thermoplaste langspanend.

Range of application:
HSS Cobalt tap for blind hole threads 2,5xd1.
Especially suitable for aluminium Si ≤ 0.5%,
thermoplastics long-chipping.

Impiego:
Maschi al Cobalto HSS per fori ciechi 2,5xd1.
Particolarmente adatti per alluminio Si ≤ 0,5%, mate-
riali termoplastici a truciolo lungo.

Speedtap




d1 mm	P mm	l1 mm	l2 mm	l3 mm	d2 _{h9} mm	a _{h12} mm		Code 4924 Art.-Nr.
M 3	0,5	56	7	18	3,5	2,7	∅ 2,5 mm	0 4924003001 00
M 4	0,7	63	8	21	4,5	3,4	∅ 3,3 mm	0 4924004001 00
M 5	0,8	70	9	25	6	4,9	∅ 4,2 mm	0 4924005001 00
M 6	1	80	10	30	6	4,9	∅ 5,0 mm	0 4924006001 00
M 8	1,25	90	13	35	8	6,2	∅ 6,8 mm	0 4924008001 00
M 10	1,5	100	15	39	10	8	∅ 8,5 mm	0 4924010001 00

D Maschinengewindeformer Speedtap-Universal, mit Ölnuten, für metrisches ISO-Gewinde DIN 13

Einsatzbereich:
HSS Cobalt Gewindeformer für Durchgangs- und Grundgewinde 3xd1. Besonders geeignet für Stähle < 900 N/mm², rostfreie Stähle und Aluminium Si >1%.

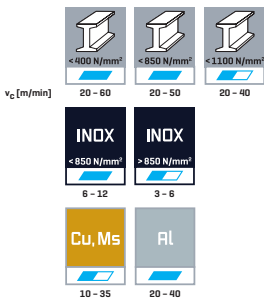
E Rolling taps Speedtap-Universal, with oil grooves, for metric ISO-threads DIN 13

Range of application:
HSS Cobalt rolling tap for through hole threads and blind hole threads 3xd1. Especially suitable for steels < 900 N/mm², stainless steels and aluminium Si >1

I Maschi a macchina a rulare Speedtap-Universal, con scanalature per lubrificazione, per filettatura metrica ISO, DIN 13

Impiego:
Maschi al Cobalto HSS per fori passanti e fori ciechi 3xd1. Particolarmente adatti per acciai < 900 N/mm², acciai inossidabili e alluminio Si >1%.

Speedtap



TiN

d1 mm	P mm	l1 mm	l2 mm	l3 mm	d2 _{h9} mm	a _{h12} mm		Code 4784 Art.-Nr.
M 3	0,5	56	10	18	3,5	2,7	∅ 2,80 mm	0 4784003001 00
M 4	0,7	63	12	21	4,5	3,4	∅ 3,70 mm	0 4784004001 00
M 5	0,8	70	14	25	6	4,9	∅ 4,65 mm	0 4784005001 00
M 6	1	80	16	30	6	4,9	∅ 5,55 mm	0 4784006001 00
M 8	1,25	90	18	35	8	6,2	∅ 7,45 mm	0 4784008001 00
M 10	1,5	100	20	39	10	8	∅ 9,35 mm	0 4784010001 00
M 12	1,75	110	24	-	9	7	∅ 11,20 mm	0 4784012001 00
M 16	2	110	27	-	12	9	∅ 15,10 mm	0 4784016001 00



D Maschinengewindeformer Speedtap-Inox,
mit Ölnuten, für metri-
sches ISO-Gewinde DIN 13

Einsatzbereich:

Gewindeformer aus Pulverstahl für Durchgangs- und Grundgewinde 3xd1. Besonders geeignet für rostfreie Cr-Ni-Stähle, unlegierten und legierten Stahl <1200N/mm² und Aluminium Si >1%.

E Rolling taps Speedtap-Inox,
with oil grooves, for metric
ISO-threads DIN 13

Range of application:

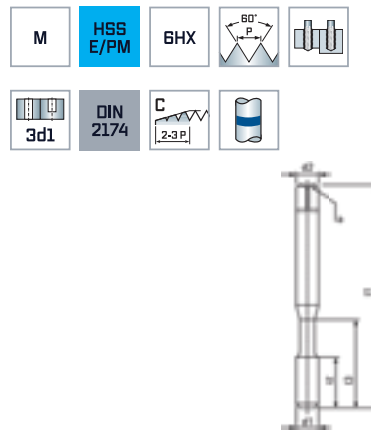
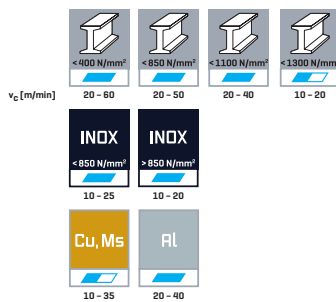
Rolling tap made of powder steel for through hole threads and blind hole threads 3xd1. Especially suitable for stainless Cr-Ni steels, non-alloyed and alloyed steels <1200 N/mm² and aluminium Si >1%.

I Maschi a macchina a rulare Speedtap-Inox,
con scanalature per
lubrificazione, per filettatura
metrica ISO, DIN 13

Impiego:

Maschi in acciaio da polveri per fori passanti e fori ciechi 3xd1. Particolarmente adatti per acciai inossidabili Cr-Ni, acciai legati e non legati <1200N/mm² e alluminio Si >1%.


Speedtap



Inox



TiN

d1 mm	P mm	l1 mm	l2 mm	l3 mm	d2 _{h9} mm	a _{h12} mm		Code 4884 Art.-Nr.
M 3	0,5	56	10	18	3,5	2,7	∅ 2,80 mm	∅ 4884003001 00
M 4	0,7	63	12	21	4,5	3,4	∅ 3,70 mm	∅ 4884004001 00
M 5	0,8	70	14	25	6	4,9	∅ 4,65 mm	∅ 4884005001 00
M 6	1	80	16	30	6	4,9	∅ 5,55 mm	∅ 4884006001 00
M 8	1,25	90	18	35	8	6,2	∅ 7,45 mm	∅ 4884008001 00
M 10	1,5	100	20	39	10	8	∅ 9,35 mm	∅ 4884010001 00
M 12	1,75	110	24	-	9	7	∅ 11,20 mm	∅ 4884012001 00
M 16	2	110	27	-	12	9	∅ 15,10 mm	∅ 4884016001 00

