

D **Maschinengewindebohrer**
Speedtap 4.0–Uni/Inox,
 gerade genutet, für metrisches
 ISO-Gewinde DIN 13

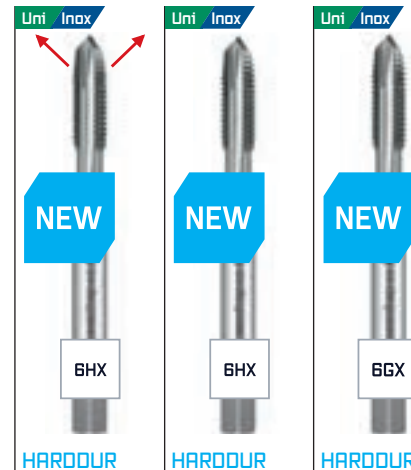
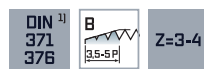
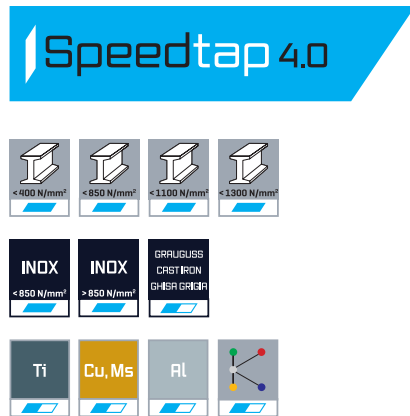
E **Machine taps**
Speedtap 4.0–Uni/Inox,
 straight fluted, for metric
 ISO-threads DIN 13

I **Maschi a macchina**
Speedtap 4.0–Uni/Inox,
 scanalature diritte, per
 filettatura metrica ISO, DIN 13

Einsatzbereich:
 HSSE-PM Gewindebohrer für Durchgangsgewinde.
 Besonders geeignet für rostfreie Cr-Ni-Stähle,
 unlegierten und legierten Stahl ≤ 1300 N/mm².
 Die Generation 4.0 setzt neue Maßstäbe beim
 Gewinden.

Range of application:
 Tap made of powder steel for through hole
 threads. Especially suitable for stainless
 Cr-Ni steels, non-alloyed and alloyed steels
 ≤ 1300 N/mm². The generation 4.0 sets new
 standards in threading.

Impiego:
 Maschi in acciaio sinterizzato HSSE-PM per fori
 passanti. Particolarmente adatti per acciai inossidabili
 Cr-Ni, acciai legati e non legati ≤ 1300 N/mm². La
 nuova generazione 4.0 stabilisce nuovi standard per
 realizzare maschiature.



d1 mm	P mm	l1 mm	l2 mm	l3 mm	d2 _{h9} mm	a _{h12} mm	Z		Code 4618 Art.-Nr.	Code 4608 Art.-Nr.	Code 4628 Art.-Nr.
M 2	0,4	45	8	-	2,8	2,1	3	Ø 1,6		0 4608002001 00	
M 2,5	0,45	50	9	-	2,8	2,1	3	Ø 2,05		0 4608002501 00	
M 3	0,5	56	11	18	3,5	2,7	3	Ø 2,5		0 4608003001 00	0 4628003001 00
M 4	0,7	63	13	21	4,5	3,4	3	Ø 3,3		0 4608004001 00	0 4628004001 00
M 5	0,8	70	16	25	6	4,9	3	Ø 4,2		0 4608005001 00	0 4628005001 00
M 6	1	80	19	30	6	4,9	3	Ø 5	0 4618006001 00	0 4608006001 00	0 4628006001 00
M 8	1,25	90	22	35	8	6,2	3	Ø 6,8	0 4618008001 00	0 4608008001 00	0 4628008001 00
M 10	1,5	100	24	39	10	8	3	Ø 8,5	0 4618010001 00	0 4608010001 00	0 4628010001 00
M 12	1,75	110	28	-	9	7	3	Ø 10,2	0 4618012001 00	0 4608012001 00	0 4628012001 00
M 14	2	110	30	-	11	9	3	Ø 12		0 4608014001 00	
M 16	2	110	32	-	12	9	3	Ø 14	0 4618016001 00	0 4608016001 00	0 4628016001 00
M 20	2,5	140	34	-	16	12	3	Ø 17,5		0 4608020001 00	0 4628020001 00
M 20	2,5	140	34	-	16	12	4	Ø 17,5	0 4618020001 00		
M 24	3	160	38	-	18	14,5	3	Ø 21		0 4608024001 00	
M 27	3	160	38	-	20	16	4	Ø 24		0 4608027001 00	
M 30	3,5	180	45	-	22	18	4	Ø 26,5		0 4608030001 00	

⁽¹⁾ DIN 371 ≤ M 10
 DIN 376 ≥ M 12

D Maschinengewindebohrer
Speedtap 4.0-Uni/Inox,
 spiral-genutet, für metrisches
 ISO-Gewinde DIN 13

E Machine taps
Speedtap 4.0-Uni/Inox,
 spiral fluted, for metric
 ISO-threads DIN 13

I Maschi a macchina
Speedtap 4.0-Uni/Inox,
 scanalature elicoidali, per
 filettatura metrica ISO, DIN 13

Einsatzbereich:

HSSE-PM Gewindebohrer für Grundgewinde.
 Besonders geeignet für rostfreie Cr-Ni-Stähle,
 unlegierten und legierten Stahl ≤1300 N/mm².
 Die Generation 4.0 setzt neue Maßstäbe beim
 Gewinden.

Range of application:

Tap made of powder steel for blind hole
 threads. Especially suitable for stainless
 Cr-Ni steels, non-alloyed and alloyed steels
 ≤1300 N/mm². The generation 4.0 sets new
 standards in threading.

Impiego:

Maschi in acciaio sinterizzato HSSE-PM per fori
 ciechi. Particolarmente adatti per acciai inossidabili
 Cr-Ni, acciai legati e non legati ≤1300 N/mm². La
 nuova generazione 4.0 stabilisce nuovi standard per
 realizzare maschiature.

d1 mm	P mm	l1 mm	l2 mm	l3 mm	d2 _{h9} mm	a _{h12} mm	Z		Code 4648 Art.-Nr.	Code 4638 Art.-Nr.	Code 4658 Art.-Nr.	Code 4668 Art.-Nr.
M 2	0,4	45	8	-	2,8	2,1	3	0 1,6		0 4638002001 00		
M 2,5	0,45	50	9	-	2,8	2,1	3	0 2,05		0 4638002501 00		
M 3	0,5	56	5	18	3,5	2,7	3	0 2,5		0 4638003001 00	0 4658003001 00	0 4668003001 00
M 4	0,7	63	7	21	4,5	3,4	3	0 3,3		0 4638004001 00	0 4658004001 00	0 4668004001 00
M 5	0,8	70	8	25	6	4,9	3	0 4,2		0 4638005001 00	0 4658005001 00	0 4668005001 00
M 6	1	80	10	30	6	4,9	3	0 5	0 4648006001 00	0 4638006001 00	0 4658006001 00	0 4668006001 00
M 8	1,25	90	13	35	8	6,2	3	0 6,8	0 4648008001 00	0 4638008001 00	0 4658008001 00	0 4668008001 00
M 10	1,5	100	15	39	10	8	3	0 8,5	0 4648010001 00	0 4638010001 00	0 4658010001 00	0 4668010001 00
M 12	1,75	110	18	-	9	7	4	0 10,2	0 4648012001 00	0 4638012001 00	0 4658012001 00	0 4668012001 00
M 14	2	110	20	-	11	9	4	0 12		0 4638014001 00		
M 16	2	110	20	-	12	9	4	0 14	0 4648016001 00	0 4638016001 00	0 4658016001 00	0 4668016001 00
M 20	2,5	140	25	-	16	12	4	0 17,5	0 4648020001 00	0 4638020001 00	0 4658020001 00	0 4668020001 00
M 24	3	160	30	-	18	14,5	4	0 21		0 4638024001 00		
M 27	3	160	30	-	20	16	4	0 24		0 4638027001 00		
M 30	3,5	180	35	-	22	18	4	0 26,5		0 4638030001 00		

⁽¹⁾ DIN 371 ≤ M 10
 DIN 376 ≥ M 12



D **Maschinengewindebohrer**
Speedtap 4.0-Titanium,
gerade genutet, für metrisches
ISO-Gewinde DIN 13

E **Machine taps**
Speedtap 4.0-Titanium,
straight fluted, for metric
ISO-threads DIN 13

I **Maschi a macchina**
Speedtap 4.0-Titanium,
scanalature diritte, per
filettatura metrica ISO, DIN 13

Einsatzbereich:
HSSE-PM Gewindebohrer für Durchgangsgewinde.
Besonders geeignet für Titan und Titanlegierungen
≤1500 N/mm². Die Generation 4.0 setzt neue
Maßstäbe beim Gewinden.

Range of application:
Tap made of powder steel for through hole threads.
Especially suitable for titanium and titanium
alloys ≤1500 N/mm². The generation 4.0 sets
new standards in threading.

Impiego:
Maschi in acciaio sinterizzato HSSE-PM per fori
passanti. Particolarmente adatti per titanio e leghe
di titanio ≤1500 N/mm². La nuova generazione 4.0
stabilisce nuovi standard per realizzare maschiature.

Speedtap 4.0



Titan



VAPD

d1 mm	P mm	l1 mm	l2 mm	l3 mm	d2 _{h9} mm	a _{h12} mm	Z		Code 4667 Art.-Nr.
M 3	0,5	56	11	18	3,5	2,7	3	∅ 2,5	0 4667003001 00
M 4	0,7	63	13	21	4,5	3,4	3	∅ 3,3	0 4667004001 00
M 5	0,8	70	16	25	6	4,9	3	∅ 4,2	0 4667005001 00
M 6	1	80	19	30	6	4,9	3	∅ 5	0 4667006001 00
M 8	1,25	90	22	35	8	6,2	3	∅ 6,8	0 4667008001 00
M 10	1,5	100	24	39	10	8	3	∅ 8,5	0 4667010001 00

D **Maschinengewindebohrer**
Speedtap 4.0-Titanium,
spiral-genutet, für metrisches
ISO-Gewinde DIN 13

E **Machine taps**
Speedtap 4.0-Titanium,
spiral fluted, for metric
ISO-threads DIN 13

I **Maschi a macchina**
Speedtap 4.0-Titanium,
scanalature elicoidali, per
filettatura metrica ISO, DIN 13

Einsatzbereich:

HSSE-PM Gewindebohrer für Grundgewinde.
Besonders geeignet für Titan und Titanlegierungen
≤1500 N/mm². Die Generation 4.0 setzt neue
Maßstäbe beim Gewinden.

Range of application:

Tap made of powder steel for blind hole threads.
Especially suitable for titanium and titanium
alloys ≤1500 N/mm². The generation 4.0 sets
new standards in threading.

Impiego:

Maschi in acciaio sinterizzato HSSE-PM per fori
ciechi. Particolarmente adatti per titanio e leghe
di titanio ≤1500 N/mm². La nuova generazione 4.0
stabilisce nuovi standard per realizzare maschiature.

Speedtap 4.0



Titan



VAPD

d1 mm	P mm	l1 mm	l2 mm	l3 mm	d2 _{h9} mm	a _{h12} mm	Z		Code 4677 Art.-Nr.
M 3	0,5	56	5	18	3,5	2,7	3	∅ 2,5	0 4677003001 00
M 4	0,7	63	7	21	4,5	3,4	3	∅ 3,3	0 4677004001 00
M 5	0,8	70	8	25	6	4,9	3	∅ 4,2	0 4677005001 00
M 6	1	80	10	30	6	4,9	3	∅ 5	0 4677006001 00
M 8	1,25	90	13	35	8	6,2	3	∅ 6,8	0 4677008001 00
M 10	1,5	100	15	39	10	8	3	∅ 8,5	0 4677010001 00

D **Maschinengewindebohrer**
Speedtap 4.0–Nickel,
gerade genutet, für metrisches
ISO-Gewinde DIN 13

E **Machine taps**
Speedtap 4.0–Nickel,
straight fluted, for metric
ISO-threads DIN 13

I **Maschi a macchina**
Speedtap 4.0–Nickel,
scanalature diritte, per
filettatura metrica ISO, DIN 13

Einsatzbereich:

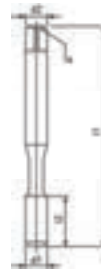
HSSE-PM Gewindebohrer für Durchgangsgewinde. Besonders geeignet für Nickel und Nickellegierungen ≤ 1500 N/mm². Die Generation 4.0 setzt neue Maßstäbe beim Gewinden.

Range of application:

Tap made of powder steel for through hole threads. Especially suitable for nickel and nickel alloys ≤ 1500 N/mm². The generation 4.0 sets new standards in threading.

Impiego:

Maschi in acciaio sinterizzato HSSE-PM per fori passanti. Particolarmente adatti per nichel e leghe di nichel ≤ 1500 N/mm². La nuova generazione 4.0 stabilisce nuovi standard per realizzare maschiature.



Nickel



d1 mm	P mm	l1 mm	l2 mm	d2 _{h9} mm	a _{h12} mm	Z		Code 4704 Art.-Nr.
M 3	0,5	56	12	3,5	2,7	3	Ø 2,5	0 4704003001 00
M 4	0,7	63	16	4,5	3,4	3	Ø 3,3	0 4704004001 00
M 5	0,8	70	19	6	4,9	3	Ø 4,2	0 4704005001 00
M 6	1	80	23	6	4,9	3	Ø 5	0 4704006001 00
M 8	1,25	90	30	8	6,2	3	Ø 6,8	0 4704008001 00
M 10	1,5	100	38	10	8	3	Ø 8,5	0 4704010001 00

D **Maschinengewindebohrer**
Speedtap 4.0-Nickel,
spiral-genutet, für metrisches
ISO-Gewinde DIN 13

Einsatzbereich:

HSSE-PM Gewindebohrer für Grundgewinde.
Besonders geeignet für Nickel und Nickellegie-
rungen ≤ 1500 N/mm². Die Generation 4.0 setzt
neue Maßstäbe beim Gewinden.

E **Machine taps**
Speedtap 4.0-Nickel,
spiral fluted, for metric
ISO-threads DIN 13

Range of application:

Tap made of powder steel for blind hole threads.
Especially suitable for nickel and nickel alloys
 ≤ 1500 N/mm². The generation 4.0 sets new
standards in threading.

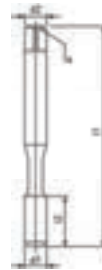
I **Maschi a macchina**
Speedtap 4.0-Nickel,
scanalature elicoidali, per
filettatura metrica ISO, DIN 13

Impiego:

Maschi in acciaio sinterizzato HSSE-PM per fori
ciechi. Particolarmente adatti per nichel e leghe
di nichel ≤ 1500 N/mm². La nuova generazione 4.0
stabilisce nuovi standard per realizzare maschiature.

Speedtap 4.0

Ni



Nickel

NEW



d1 mm	P mm	l1 mm	l2 mm	d2 _{h9} mm	a _{h12} mm	Z		Code 4705 Art.-Nr.
M 3	0,5	56	11	3,5	2,7	3		0 4705003001 00
M 4	0,7	63	14	4,5	3,4	3		0 4705004001 00
M 5	0,8	70	17	6	4,9	3		0 4705005001 00
M 6	1	80	21	6	4,9	3		0 4705006001 00
M 8	1,25	90	28	8	6,2	3		0 4705008001 00
M 10	1,5	100	35	10	8	3		0 4705010001 00

D **Maschinengewindebohrer**
Speedtap 4.0-Ultra Hard
Steel 53 HRC,
gerade genutet, für metrisches
ISO-Gewinde DIN 13

Einsatzbereich:

HSSE-PM Gewindebohrer für Durchgangs- und Grundgewinde. Besonders geeignet für zähe und schwer zerspanbare Werkstoffe ≤53HRC. Die Generation 4.0 setzt neue Maßstäbe beim Gewinden.

E **Machine taps**
Speedtap 4.0-Ultra Hard
steel 53 HRC,
straight fluted, for metric
ISO-threads DIN 13

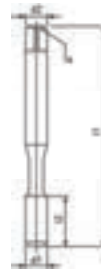
Range of application:

Tap made of powder steel for through hole threads and blind hole threads. Especially suitable for tough and difficult to machine materials ≤53HRC. The generation 4.0 sets new standards in threading.

I **Maschi a macchina**
Speedtap 4.0-Ultra Hard
steel 53 HRC,
scanalature diritte, per
filettatura metrica ISO, DIN 13

Impiego:

Maschi in acciaio sinterizzato HSSE-PM per fori passanti e fori ciechi. Particolarmente adatti per materiali duri e tenaci difficili da lavorare ≤53HRC. La nuova generazione 4.0 stabilisce nuovi standard per realizzare maschiature.



TiCN

Code 4607
Art.-Nr.



TiCN

Code 4617
Art.-Nr.

d1 mm	P mm	l1 mm	l2 mm	d2 _{h9} mm	a _{h12} mm	Z			
M 3	0,5	46	11	3,5	2,7	4	Ø 2,55	0 4607003001 00	0 4617003001 00
M 4	0,7	52	13	4,5	3,4	4	Ø 3,4	0 4607004001 00	0 4617004001 00
M 5	0,8	60	16	6	4,9	4	Ø 4,3	0 4607005001 00	0 4617005001 00
M 6	1	62	19	6	4,9	4	Ø 5,1	0 4607006001 00	0 4617006001 00
M 8	1,25	70	22	6	4,9	5	Ø 6,9	0 4607008001 00	0 4617008001 00
M 10	1,5	75	24	7	5,5	5	Ø 8,6	0 4607010001 00	0 4617010001 00
M 12	1,75	82	29	9	7	5	Ø 10,4	0 4607012001 00	0 4617012001 00
M 14	2	88	30	11	9	5	Ø 12,1		0 4617014001 00
M 16	2	95	32	12	9	5	Ø 14,1	0 4607016001 00	0 4617016001 00
M 20	2,5	105	37	16	12	5	Ø 17,7	0 4607020001 00	0 4617020001 00
M 24	3	160	38	18	14,5	5	Ø 21,2	0 4607024001 00	0 4617024001 00

Schneidöl / Cutting oil / Olio da taglio

Menge/Quantity/Quantità ml	Code 4601 Art.-Nr.
50	0 4601000011 00
125	0 4601000021 00
500	0 4601000031 00

D **Maschinengewindebohrer**
Speedtap 4.0-Ultra Hard
Steel 63 HRC,
gerade genutet, für metrisches
ISO-Gewinde DIN 13

Einsatzbereich:

VHM Gewindebohrer für Durchgangs- und Grundgewinde. Besonders geeignet für zähe und schwer zerspanbare Werkstoffe sowie Hartbearbeitung ≤63HRC. Die Generation 4.0 setzt neue Maßstäbe beim Gewinden.

E **Machine taps**
Speedtap 4.0-Ultra Hard
steel 63 HRC,
straight fluted, for metric
ISO-threads DIN 13

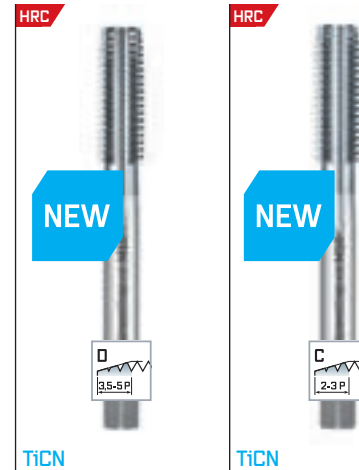
Range of application:

Solid carbide tap for through hole threads and blind hole threads. Especially suitable for tough and difficult to machine materials as well as hard machining ≤63HRC. The generation 4.0 sets new standards in threading.

I **Maschi a macchina**
Speedtap 4.0-Ultra Hard
steel 63 HRC,
scanalature diritte, per
filettatura metrica ISO, DIN 13

Impiego:

Maschi in metallo duro per fori passanti e fori ciechi. Particolarmente adatti per materiali duri e tenaci difficili da lavorare oltre che per materiali temprati ≤63HRC. La nuova generazione 4.0 stabilisce nuovi standard per realizzare maschiature.

d1 mm	P mm	l1 mm	l2 mm	d2 _{h9} mm	a _{h12} mm	Z		Code 4645 Art.-Nr.	Code 4655 Art.-Nr.
M 3	0,5	46	11	3,5	2,7	4	Ø 2,55	0 4645003001 00	0 4655003001 00
M 3,5	0,6	46	13	4	3	4	Ø 3	0 4645003501 00	0 4655003501 00
M 4	0,7	52	13	4,5	3,4	4	Ø 3,4	0 4645004001 00	0 4655004001 00
M 5	0,8	60	16	6	4,9	4	Ø 4,3	0 4645005001 00	0 4655005001 00
M 6	1	62	19	6	4,9	5	Ø 5,1	0 4645006001 00	0 4655006001 00
M 8	1,25	70	22	6	4,9	5	Ø 6,9	0 4645008001 00	0 4655008001 00
M 10	1,5	75	24	7	5,5	5	Ø 8,6	0 4645010001 00	0 4655010001 00
M 12	1,75	82	29	9	7	5	Ø 10,4	0 4645012001 00	0 4655012001 00
M 14	2	88	30	11	9	6	Ø 12,1	0 4645014001 00	0 4655014001 00
M 16	2	95	32	12	9	6	Ø 14,1	0 4645016001 00	0 4655016001 00
M 20	2,5	105	37	16	12	6	Ø 17,7	0 4645020001 00	0 4655020001 00

Schneidöl / Cutting oil / Olio da taglio

Menge / Quantity / Quantità ml	Code 4601 Art.-Nr.
50	0 4601000011 00
125	0 4601000021 00
500	0 4601000031 00

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

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

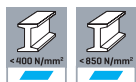
I **Maschi a macchina**
Speedtap-Universal,
scanalature diritte, per
filettatura metrica ISO, DIN 13

Einsatzbereich:
HSSE Gewindebohrer für Durchgangsgewinde.
Besonders geeignet für unlegierten und legierten
Stahl ≤850 N/mm².

Range of application:
HSS Cobalt tap for through hole threads.
Especially suitable for non-alloyed and alloyed
steels ≤850 N/mm².

Impiego:
Maschi in acciaio super rapido al Cobalto HSSE per
fori passanti. Particolarmente adatti per acciai legati
e non legati ≤850 N/mm².

Speedtap



TiN

d1 mm	P mm	l1 mm	l2 mm	l3 mm	d2 _{h9} mm	a _{h12} mm	Z		Code 4621 Art.-Nr.	Code 4641 Art.-Nr.
M 1,4 ^(*)	0,3	40	7	-	2,5	2,1	2	Ø 1,1	0 4621001401 00	
M 1,6	0,35	40	8	-	2,5	2,1	2	Ø 1,25	0 4621001601 00	
M 1,7	0,35	40	8	-	2,5	2,1	2	Ø 1,3	0 4621001701 00	
M 1,8	0,35	40	8	-	2,5	2,1	2	Ø 1,45	0 4621001801 00	
M 2	0,4	45	8	-	2,8	2,1	2	Ø 1,6	0 4621002001 00	
M 2,3	0,4	45	9	-	2,8	2,1	2	Ø 1,9	0 4621002301 00	
M 2,5	0,45	50	9	-	2,8	2,1	2	Ø 2,05	0 4621002501 00	
M 2,6	0,45	50	9	-	2,8	2,1	2	Ø 2,1	0 4621002601 00	
M 3	0,5	56	11	18	3,5	2,7	3	Ø 2,5	0 4621003001 00	0 4641003001 00
M 4	0,7	63	13	21	4,5	3,4	3	Ø 3,3	0 4621004001 00	0 4641004001 00
M 5	0,8	70	16	25	6	4,9	3	Ø 4,2	0 4621005001 00	0 4641005001 00
M 6	1	80	19	30	6	4,9	3	Ø 5	0 4621006001 00	0 4641006001 00
M 8	1,25	90	22	35	8	6,2	3	Ø 6,8	0 4621008001 00	0 4641008001 00
M 10	1,5	100	24	39	10	8	3	Ø 8,5	0 4621010001 00	0 4641010001 00
M 12	1,75	110	28	45	12	9	3	Ø 10,2	0 4621012001 00	

(*) M 1,4 = ISO 1 5H

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

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

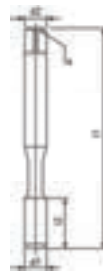
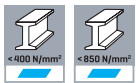
I Maschi a macchina
Speedtap-Universal,
 scanalature diritte, per
 filettatura metrica ISO, DIN 13

Einsatzbereich:
 HSSE Gewindebohrer für Durchgangsgewinde.
 Besonders geeignet für unlegierten und legierten
 Stahl ≤850 N/mm².

Range of application:
 HSS Cobalt tap for through hole threads.
 Especially suitable for non-alloyed and alloyed
 steels ≤850 N/mm².

Impiego:
 Maschi in acciaio super rapido al Cobalto HSSE per
 fori passanti. Particolarmente adatti per acciai legati
 e non legati ≤850 N/mm².

Speedtap



d1 mm	P mm	l1 mm	l2 mm	d2 _{h9} mm	a _{h12} mm	Z		Code 4631 Art.-Nr.	Code 4651 Art.-Nr.
M 2	0,4	45	8	1,4	-	2	Ø 1,6	0 4631002001 00	
M 2,5	0,45	50	9	1,8	-	2	Ø 2,05	0 4631002501 00	
M 3	0,5	56	11	2,2	-	3	Ø 2,5	0 4631003001 00	0 4651003001 00
M 4	0,7	63	13	2,8	2,1	3	Ø 3,3	0 4631004001 00	0 4651004001 00
M 5	0,8	70	16	3,5	2,7	3	Ø 4,2	0 4631005001 00	0 4651005001 00
M 6	1	80	19	4,5	3,4	3	Ø 5	0 4631006001 00	0 4651006001 00
M 8	1,25	90	22	6	4,9	3	Ø 6,8	0 4631008001 00	0 4651008001 00
M 10	1,5	100	24	7	5,5	3	Ø 8,5	0 4631010001 00	0 4651010001 00
M 12	1,75	110	28	9	7	3	Ø 10,2	0 4631012001 00	0 4651012001 00
M 14	2	110	30	11	9	3	Ø 12	0 4631014001 00	0 4651014001 00
M 16	2	110	32	12	9	3	Ø 14	0 4631016001 00	0 4651016001 00
M 18	2,5	125	34	14	11	3	Ø 15,5	0 4631018001 00	0 4651018001 00
M 20	2,5	140	34	16	12	3	Ø 17,5	0 4631020001 00	0 4651020001 00
M 22	2,5	140	34	18	14,5	3	Ø 19,5	0 4631022001 00	0 4651022001 00
M 24	3	160	38	18	14,5	3	Ø 21	0 4631024001 00	0 4651024001 00
M 27	3	160	38	20	16	4	Ø 24	0 4631027001 00	0 4651027001 00
M 30	3,5	180	45	22	18	4	Ø 26,5	0 4631030001 00	0 4651030001 00
M 33	3,5	180	50	25	20	4	Ø 29,5	0 4631033001 00	0 4651033001 00
M 36	4	200	56	28	22	4	Ø 32	0 4631036001 00	0 4651036001 00
M 39	4	200	60	32	24	4	Ø 35	0 4631039001 00	
M 42	4,5	200	60	32	24	4	Ø 37,5	0 4631042001 00	
M 45	4,5	220	65	36	29	4	Ø 40,5	0 4631045001 00	
M 48	5	250	70	36	29	4	Ø 43	0 4631048001 00	
M 52	5	250	70	40	32	4	Ø 47	0 4631052001 00	



D **Maschinengewindebohrer**
Speedtap-Uni/Inox,
gerade genutet, für metrisches
ISO-Gewinde DIN 13

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

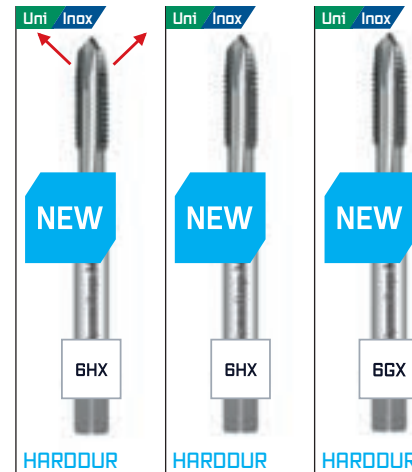
I **Maschi a macchina**
Speedtap-Uni/Inox,
scanalature diritte, per
filettatura metrica ISO, DIN 13

Einsatzbereich:
HSSE-PM Gewindebohrer für Durchgangsgewinde.
Besonders geeignet für unlegierte, legierte sowie
rostfreie Cr-Ni-Stähle ≤ 1300 N/mm².

Range of application:
Tap made of powder steel for through hole
threads. Especially suitable for non-alloyed
and alloyed steels and for stainless Cr-Ni-
steels ≤ 1300 N/mm².

Impiego:
Maschi in acciaio sinterizzato HSSE-PM per fori
passanti. Particolarmente adatti per acciai legati
e non legati e per acciai inossidabili Cr-Ni ≤ 1300
N/mm².

Speedtap



d1 mm	P mm	l1 mm	l2 mm	l3 mm	d2 _{h9} mm	ø _{h12} mm	Z		Code 4625/4635 Art.-Nr.	Code 4605/4615 Art.-Nr.	Code 4629/4639 Art.-Nr.
M 2	0,4	45	8	-	2,8	2,1	3	Ø 1,6		0 4605002001 00	
M 2,5	0,45	50	9	-	2,8	2,1	3	Ø 2,05		0 4605002501 00	
M 3	0,5	56	11	18	3,5	2,7	3	Ø 2,5		0 4605003001 00	0 4629003001 00
M 4	0,7	63	13	21	4,5	3,4	3	Ø 3,3		0 4605004001 00	0 4629004001 00
M 5	0,8	70	16	25	6	4,9	3	Ø 4,2		0 4605005001 00	0 4629005001 00
M 6	1	80	19	30	6	4,9	3	Ø 5	0 4625006001 00	0 4605006001 00	0 4629006001 00
M 8	1,25	90	22	35	8	6,2	3	Ø 6,8	0 4625008001 00	0 4605008001 00	0 4629008001 00
M 10	1,5	100	24	39	10	8	3	Ø 8,5	0 4625010001 00	0 4605010001 00	0 4629010001 00
M 12	1,75	110	28	-	9	7	3	Ø 10,2	0 4635012001 00	0 4615012001 00	0 4639012001 00
M 14	2	110	30	-	11	9	3	Ø 12		0 4615014001 00	
M 16	2	110	32	-	12	9	3	Ø 14	0 4635016001 00	0 4615016001 00	0 4639016001 00
M 20	2,5	140	34	-	16	12	3	Ø 17,5		0 4615020001 00	0 4639020001 00
M 20	2,5	140	34	-	16	12	4	Ø 17,5	0 4635020001 00		
M 24	3	160	38	-	18	14,5	3	Ø 21		0 4615024001 00	
M 27	3	160	38	-	20	16	4	Ø 24		0 4615027001 00	
M 30	3,5	180	45	-	22	18	4	Ø 26,5		0 4615030001 00	

⁽¹⁾ DIN 371 \leq M 10
DIN 376 \geq M 12

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

Einsatzbereich:
HSSE Gewindebohrer für Grundgewinde. Besonders geeignet für unlegierten und legierten Stahl ≤850 N/mm².

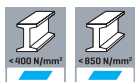
E Machine taps Speedtap-Universal, spiral fluted, for metric ISO-threads DIN 13

Range of application:
HSS Cobalt tap for blind hole threads. Especially suitable for non-alloyed and alloyed steels ≤850 N/mm².

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

Impiego:
Maschi in acciaio super rapido HSSE per fori ciechi. Particolarmente adatti per acciai legati e non legati ≤850 N/mm².

Speedtap



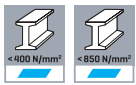
d1 mm	P mm	l1 mm	l2 mm	l3 mm	d2 _{h9} mm	a _{h12} mm	Z		Code 4661 Art.-Nr.	Code 4601 Art.-Nr.
M 2	0,4	45	8	-	2,8	2,1	2	∅ 1,6	0 4661002001 00	
M 2,3	0,4	45	9	-	2,8	2,1	2	∅ 1,9	0 4661002301 00	
M 2,5	0,45	50	9	-	2,8	2,1	2	∅ 2,05	0 4661002501 00	
M 2,6	0,45	50	9	-	2,8	2,1	2	∅ 2,1	0 4661002601 00	
M 3	0,5	56	5	18	3,5	2,7	3	∅ 2,5	0 4661003001 00	0 4601003001 00
M 3,5	0,6	56	6	20	4	3	3	∅ 2,9	0 4661003501 00	
M 4	0,7	63	7	21	4,5	3,4	3	∅ 3,3	0 4661004001 00	0 4601004001 00
M 5	0,8	70	8	25	6	4,9	3	∅ 4,2	0 4661005001 00	0 4601005001 00
M 6	1	80	10	30	6	4,9	3	∅ 5	0 4661006001 00	0 4601006001 00
M 8	1,25	90	13	35	8	6,2	3	∅ 6,8	0 4661008001 00	0 4601008001 00
M 10	1,5	100	15	39	10	8	3	∅ 8,5	0 4661010001 00	0 4601010001 00
M 12	1,75	110	18	45	12	9	3	∅ 10,2	0 4661012001 00	

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

Einsatzbereich:

HSSE Gewindebohrer für Grundgewinde.
Besonders geeignet für unlegierten und
legierten Stahl ≤ 850 N/mm².

Speedtap



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

Range of application:

HSS Cobalt tap for blind hole threads. Especially
suitable for non-alloyed and alloyed steels ≤ 850
N/mm².



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

Impiego:

Maschi in acciaio super rapido al Cobalto HSSE per
fori ciechi. Particolarmente adatti per acciai legati e
non legati ≤ 850 N/mm².



VAPD

d1 mm	P mm	l1 mm	l2 mm	d2 _{h9} mm	a _{h12} mm	Z		Code 4671 Art.-Nr.	Code 4611 Art.-Nr.
M 3	0,5	56	5	2,2	0	3	Ø 2,5	0 4671003001 00	0 4611003001 00
M 4	0,7	63	7	2,8	2,1	3	Ø 3,3	0 4671004001 00	0 4611004001 00
M 5	0,8	70	8	3,5	2,7	3	Ø 4,2	0 4671005001 00	0 4611005001 00
M 6	1	80	10	4,5	3,4	3	Ø 5	0 4671006001 00	0 4611006001 00
M 8	1,25	90	13	6	4,9	3	Ø 6,8	0 4671008001 00	0 4611008001 00
M 10	1,5	100	15	7	5,5	3	Ø 8,5	0 4671010001 00	0 4611010001 00
M 12	1,75	110	18	9	7	3	Ø 10,2	0 4671012001 00	0 4611012001 00
M 14	2	110	20	11	9	3	Ø 12	0 4671014001 00	0 4611014001 00
M 16	2	110	20	12	9	3	Ø 14	0 4671016001 00	0 4611016001 00
M 18	2,5	125	25	14	11	4	Ø 15,5	0 4671018001 00	0 4611018001 00
M 20	2,5	140	25	16	12	4	Ø 17,5	0 4671020001 00	0 4611020001 00
M 22	2,5	140	25	18	14,5	4	Ø 19,5	0 4671022001 00	0 4611022001 00
M 24	3	160	30	18	14,5	4	Ø 21	0 4671024001 00	0 4611024001 00
M 27	3	160	30	20	16	4	Ø 24	0 4671027001 00	0 4611027001 00
M 30	3,5	180	35	22	18	4	Ø 26,5	0 4671030001 00	0 4611030001 00
M 33	3,5	180	35	25	20	4	Ø 29,5	0 4671033001 00	0 4611033001 00
M 36	4	200	40	28	22	4	Ø 32	0 4671036001 00	0 4611036001 00



Speedtap 4.0

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

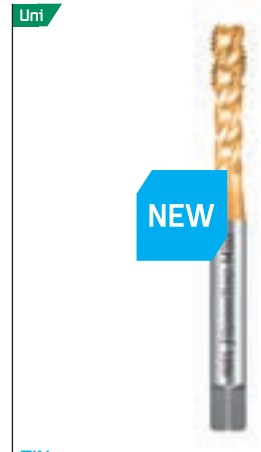
I **Maschi a macchina**
Speedtap-Universal,
scanalature elicoidali, per
filettatura metrica ISO, DIN 13

Einsatzbereich:
HSSE Gewindebohrer für Grundgewinde.
Besonders geeignet für unlegierten und
legierten Stahl ≤ 850 N/mm².

Range of application:
HSS Cobalt tap for blind hole threads. Especially
suitable for non-alloyed and alloyed steels ≤ 850
N/mm².

Impiego:
Maschi in acciaio super rapido al Cobalto HSSE per
fori ciechi. Particolarmente adatti per acciai legati e
non legati ≤ 850 N/mm.

Speedtap



d1 mm	P mm	l1 mm	l2 mm	l3 mm	d2 _{h9} mm	a _{h12} mm	Z		Code 4681 Art.-Nr.
M 3	0,5	56	5	18	3,5	2,7	3	∅ 2,5	0 4681003001 00
M 4	0,7	63	7	21	4,5	3,4	3	∅ 3,3	0 4681004001 00
M 5	0,8	70	8	25	6	4,9	3	∅ 4,2	0 4681005001 00
M 6	1	80	10	30	6	4,9	3	∅ 5	0 4681006001 00
M 8	1,25	90	13	35	8	6,2	3	∅ 6,8	0 4681008001 00
M 10	1,5	100	15	39	10	8	3	∅ 8,5	0 4681010001 00

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:

HSSE Gewindebohrer für Grundgewinde.
Besonders geeignet für unlegierten und
legierten Stahl ≤ 850 N/mm².

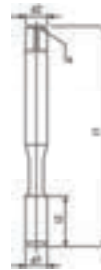
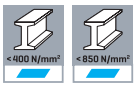
Range of application:

HSS Cobalt tap for blind hole threads. Especially
suitable for non-alloyed and alloyed steels ≤ 850
N/mm².

Impiego:

Maschi in acciaio super rapido al Cobalto HSSE per
fori ciechi. Particolarmente adatti per acciai legati e
non legati ≤ 850 N/mm².

Speedtap



d1 mm	P mm	l1 mm	l2 mm	d2 _{h9} mm	a _{h12} mm	Z		Code 4691 Art.-Nr.
M 3	0,5	56	5	2,2	-	3	Ø 2,5	0 4691003001 00
M 4	0,7	63	7	2,8	2,1	3	Ø 3,3	0 4691004001 00
M 5	0,8	70	8	3,5	2,7	3	Ø 4,2	0 4691005001 00
M 6	1	80	10	4,5	3,4	3	Ø 5	0 4691006001 00
M 8	1,25	90	13	6	4,9	3	Ø 6,8	0 4691008001 00
M 10	1,5	100	15	7	5,5	3	Ø 8,5	0 4691010001 00
M 12	1,75	110	18	9	7	3	Ø 10,2	0 4691012001 00
M 14	2	110	20	11	9	3	Ø 12	0 4691014001 00
M 16	2	110	20	12	9	3	Ø 14	0 4691016001 00
M 18	2,5	125	25	14	11	4	Ø 15,5	0 4691018001 00
M 20	2,5	140	25	16	12	4	Ø 17,5	0 4691020001 00
M 22	2,5	140	25	18	14,5	4	Ø 19,5	0 4691022001 00
M 24	3	160	30	18	14,5	4	Ø 21	0 4691024001 00



Speedtap 4.0

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

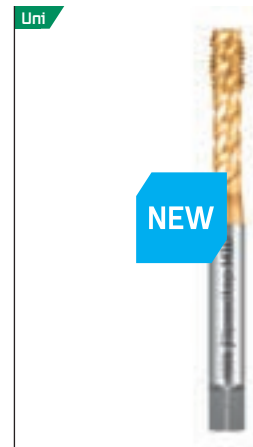
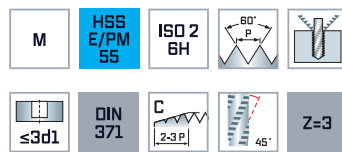
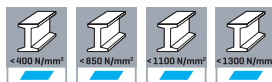
I **Maschi a macchina**
Speedtap-Universal,
scanalature elicoidali, per
filettatura metrica ISO, DIN 13

Einsatzbereich:
HSSE-PM Gewindebohrer für Grundgewinde.
Besonders geeignet für unlegierte, legierte Stähle
≤1300 N/mm².

Range of application:
Tap made of powder steel for blind hole threads.
Especially suitable for non-alloyed and alloyed
steels ≤1300 N/mm².

Impiego:
Maschi in acciaio sinterizzato HSSE-PM per fori ciechi.
Particolarmente adatti per acciai legati e non legati
≤1300 N/mm².

Speedtap



d1 mm	P mm	l1 mm	l2 mm	l3 mm	d2 _{h9} mm	a _{h12} mm	Z		Code 4666 Art.-Nr.
M 3	0,5	56	5	18	3,5	2,7	3	∅ 2,5	0 4666003001 00
M 4	0,7	63	7	21	4,5	3,4	3	∅ 3,3	0 4666004001 00
M 5	0,8	70	8	25	6	4,9	3	∅ 4,2	0 4666005001 00
M 6	1	80	10	30	6	4,9	3	∅ 5	0 4666006001 00
M 8	1,25	90	13	35	8	6,2	3	∅ 6,8	0 4666008001 00
M 10	1,5	100	15	39	10	8	3	∅ 8,5	0 4666010001 00

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

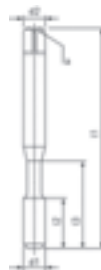
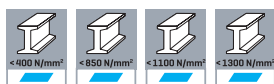
E Machine taps
Speedtap-Uni/Inox,
 spiral fluted, for metric
 ISO-threads DIN 13

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

Einsatzbereich:
 HSSE-PM Gewindebohrer für Grundgewinde.
 Besonders geeignet für unlegierte, legierte sowie
 rostfreie Cr-Ni-Stähle ≤1300 N/mm².

Range of application:
 Tap made of powder steel for blind hole threads.
 Especially suitable for non-alloyed and alloyed
 steels and for stainless Cr-Ni-steels ≤1300 N/mm².

Impiego:
 Maschi in acciaio sinterizzato HSSE-PM per fori
 ciechi. Particolarmente adatti per acciai legati e non
 legati e per acciai inossidabili Cr-Ni ≤1300 N/mm².



d1 mm	P mm	l1 mm	l2 mm	l3 mm	d2 _{h9} mm	a _{h12} mm	Z		Code 4685/4695 Art.-Nr.	Code 4665/4675 Art.-Nr.
M 2	0,4	45	8	-	2,8	2,1	3	Ø 1,6		0 4665002001 00
M 2,5	0,45	50	9	-	2,8	2,1	3	Ø 2,05		0 4665002501 00
M 3	0,5	56	5	18	3,5	2,7	3	Ø 2,5		0 4665003001 00
M 4	0,7	63	7	21	4,5	3,4	3	Ø 3,3		0 4665004001 00
M 5	0,8	70	8	25	6	4,9	3	Ø 4,2		0 4665005001 00
M 6	1	80	10	30	6	4,9	3	Ø 5	0 4685006001 00	0 4665006001 00
M 8	1,25	90	13	35	8	6,2	3	Ø 6,8	0 4685008001 00	0 4665008001 00
M 10	1,5	100	15	39	10	8	3	Ø 8,5	0 4685010001 00	0 4665010001 00
M 12	1,75	110	18	-	9	7	4	Ø 10,2	0 4695012001 00	0 4675012001 00
M 14	2	110	20	-	11	9	4	Ø 12		0 4675014001 00
M 16	2	110	20	-	12	9	4	Ø 14	0 4695016001 00	0 4675016001 00
M 20	2,5	140	25	-	16	12	4	Ø 17,5	0 4695020001 00	0 4675020001 00
M 24	3	160	30	-	18	14,5	4	Ø 21		0 4675024001 00
M 27	3	160	30	-	20	16	4	Ø 24		0 4675027001 00
M 30	3,5	180	35	-	22	18	4	Ø 26,5		0 4675030001 00

⁽¹⁾ DIN 371 ≤ M 10
 DIN 376 ≥ M 12



D **Maschinengewindebohrer**
Speedtap–Uni/Inox,
spiral-genutet, für metrisches
ISO-Gewinde DIN 13

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

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

Einsatzbereich:
HSSE-PM Gewindebohrer für Grundgewinde.
Besonders geeignet für unlegierte, legierte sowie
rostfreie Cr-Ni-Stähle ≤1300 N/mm².

Range of application:
Tap made of powder steel for blind hole threads.
Especially suitable for non-alloyed and alloyed
steels and for stainless Cr-Ni-steels ≤1300 N/mm².

Impiego:
Maschi in acciaio sinterizzato HSSE-PM per fori
ciechi. Particolarmente adatti per acciai legati e non
legati e per acciai inossidabili Cr-Ni ≤1300 N/mm².

Speedtap



HARDOUR

d1 mm	P mm	l1 mm	l2 mm	l3 mm	d2 _{h9} mm	a _{h12} mm	Z		Code 4606/4616 Art.-Nr.
M 3	0,5	56	5	18	3,5	2,7	3	∅ 2,5	0 4606003001 00
M 4	0,7	63	7	21	4,5	3,4	3	∅ 3,3	0 4606004001 00
M 5	0,8	70	8	25	6	4,9	3	∅ 4,2	0 4606005001 00
M 6	1	80	10	30	6	4,9	3	∅ 5	0 4606006001 00
M 8	1,25	90	13	35	8	6,2	3	∅ 6,8	0 4606008001 00
M 10	1,5	100	15	39	10	8	3	∅ 8,5	0 4606010001 00
M 12	1,75	110	18	-	9	7	4	∅ 10,2	0 4616012001 00
M 16	2	110	20	-	12	9	4	∅ 14	0 4616016001 00
M 20	2,5	140	25	-	16	12	4	∅ 17,5	0 4616020001 00

⁽¹⁾ DIN 371 ≤ M 10
DIN 376 ≥ M 12

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

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

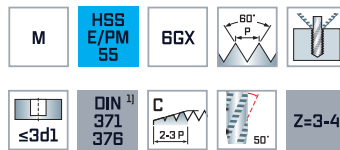
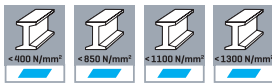
I Maschi a macchina
Speedtap-uni/Inox,
 scanalature elicoidali, per
 filettatura metrica ISO, DIN 13

Einsatzbereich:
 HSSE-PM Gewindebohrer für Grundgewinde.
 Besonders geeignet für unlegierte, legierte sowie
 rostfreie Cr-Ni-Stähle ≤1300 N/mm².

Range of application:
 Tap made of powder steel for blind hole threads.
 Especially suitable for non-alloyed and alloyed
 steels and for stainless Cr-Ni-steels ≤1300 N/mm².

Impiego:
 Maschi in acciaio sinterizzato HSSE-PM per fori
 ciechi. Particolarmente adatti per acciai legati e non
 legati e per acciai inossidabili Cr-Ni ≤1300 N/mm².

Speedtap



HARDOUR

d1 mm	P mm	l1 mm	l2 mm	l3 mm	d2 _{h9} mm	a _{h12} mm	Z		Code 4626/4636 Art.-Nr.
M 3	0,5	56	5	18	3,5	2,7	3	∅ 2,5	0 4626003001 00
M 4	0,7	63	7	21	4,5	3,4	3	∅ 3,3	0 4626004001 00
M 5	0,8	70	8	25	6	4,9	3	∅ 4,2	0 4626005001 00
M 6	1	80	10	30	6	4,9	3	∅ 5	0 4626006001 00
M 8	1,25	90	13	35	8	6,2	3	∅ 6,8	0 4626008001 00
M 10	1,5	100	15	39	10	8	3	∅ 8,5	0 4626010001 00
M 12	1,75	110	18	-	9	7	4	∅ 10,2	0 4636012001 00
M 16	2	110	20	-	12	9	4	∅ 14	0 4636016001 00
M 20	2,5	140	25	-	16	12	4	∅ 17,5	0 4636020001 00

⁽¹⁾ DIN 371 ≤ M 10
 DIN 376 ≥ M 12



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

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

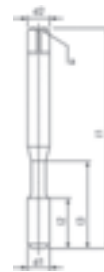
I Maschi a macchina Speedtap-Inox,
scanalature diritte, per filettatura metrica ISO, DIN 13

Einsatzbereich:
HSSE Gewindebohrer für Durchgangsgewinde.
Besonders geeignet für unlegierte, legierte sowie rostfreie Cr-Ni-Stähle $\leq 1200 \text{ N/mm}^2$.

Range of application:
HSS Cobalt tap for through hole threads.
Especially suitable for non-alloyed and alloyed steels and for stainless Cr-Ni-steels $\leq 1200 \text{ N/mm}^2$.

Impiego:
Maschi in acciaio super rapido al Cobalto HSSE per fori passanti. Particolarmente adatti per acciai legati e non legati e per acciai inossidabili Cr-Ni $\leq 1200 \text{ N/mm}^2$.

Speedtap



d1 mm	P mm	l1 mm	l2 mm	l3 mm	d2 _{h9} mm	a _{h12} mm	Z		Code 4602 Art.-Nr.	Code 4622 Art.-Nr.	Code 4642 Art.-Nr.
M 2	0,4	45	8	-	2,8	2,1	2	Ø 1,6	0 4602002001 00		
M 2,5	0,45	50	9	-	2,8	2,1	2	Ø 2,05	0 4602002501 00		
M 3	0,5	56	11	18	3,5	2,7	3	Ø 2,5	0 4602003001 00	0 4622003001 00	0 4642003001 00
M 3,5	0,6	56	12	20	4	3	3	Ø 2,9	0 4602003501 00		
M 4	0,7	63	13	21	4,5	3,4	3	Ø 3,3	0 4602004001 00	0 4622004001 00	0 4642004001 00
M 5	0,8	70	16	25	6	4,9	3	Ø 4,2	0 4602005001 00	0 4622005001 00	0 4642005001 00
M 6	1	80	19	30	6	4,9	3	Ø 5	0 4602006001 00	0 4622006001 00	0 4642006001 00
M 8	1,25	90	22	35	8	6,2	3	Ø 6,8	0 4602008001 00	0 4622008001 00	0 4642008001 00
M 10	1,5	100	24	39	10	8	3	Ø 8,5	0 4602010001 00	0 4622010001 00	0 4642010001 00
M 12	1,75	110	28	45	12	9	3	Ø 10,2	0 4602012001 00		

(*) Gültig für Code 4622 + 4642 / Valid for Code 4622 + 4642 / Valido per il codice 4622 + 4642

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

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

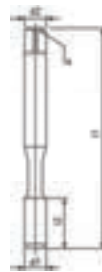
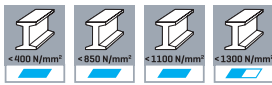
I Maschi a macchina
Speedtap-Inox,
 scanalature diritte, per
 filettatura metrica ISO, DIN 13

Einsatzbereich:
 HSSE Gewindebohrer für Durchgangsgewinde.
 Besonders geeignet für unlegierte, legierte sowie
 rostfreie Cr-Ni-Stähle ≤1200 N/mm².

Range of application:
 HSS Cobalt tap for through hole threads.
 Especially suitable for non-alloyed and alloyed
 steels and for stainless Cr-Ni-steels ≤1200 N/mm².

Impiego:
 Maschi in acciaio super rapido al Cobalto HSSE per fori
 passanti. Particolarmente adatti per acciai legati e non
 legati e per acciai inossidabili Cr-Ni ≤1200 N/mm².

Speedtap



d1 mm	P mm	l1 mm	l2 mm	d2 _{h9} mm	a _{h12} mm	Z		Code 4612 Art.-Nr.	Code 4632 Art.-Nr.	Code 4652 Art.-Nr.
M 3	0,5	56	11	2,2	0	3	∅ 2,5	0 4612003001 00		
M 4	0,7	63	13	2,8	2,1	3	∅ 3,3	0 4612004001 00	0 4632004001 00	
M 5	0,8	70	16	3,5	2,7	3	∅ 4,2	0 4612005001 00	0 4632005001 00	
M 6	1	80	19	4,5	3,4	3	∅ 5	0 4612006001 00	0 4632006001 00	
M 8	1,25	90	22	6	4,9	3	∅ 6,8	0 4612008001 00	0 4632008001 00	
M 10	1,5	100	24	7	5,5	3	∅ 8,5	0 4612010001 00	0 4632010001 00	
M 12	1,75	110	28	9	7	3	∅ 10,2	0 4612012001 00	0 4632012001 00	0 4652012001 00
M 14	2	110	30	11	9	3	∅ 12	0 4612014001 00	0 4632014001 00	0 4652014001 00
M 16	2	110	32	12	9	3	∅ 14	0 4612016001 00	0 4632016001 00	0 4652016001 00
M 18	2,5	125	34	14	11	3	∅ 15,5	0 4612018001 00		
M 20	2,5	140	34	16	12	3	∅ 17,5	0 4612020001 00	0 4632020001 00	0 4652020001 00
M 22	2,5	140	34	18	14,5	3	∅ 19,5	0 4612022001 00	0 4632022001 00	0 4652022001 00
M 24	3	160	38	18	14,5	3	∅ 21	0 4612024001 00	0 4632024001 00	0 4652024001 00
M 27	3	160	38	20	16	4	∅ 24	0 4612027001 00		0 4652027001 00
M 30	3,5	180	45	22	18	4	∅ 26,5	0 4612030001 00	0 4632030001 00	0 4652030001 00
M 33	3,5	180	50	25	20	4	∅ 29,5	0 4612033001 00		0 4652033001 00
M 36	4	200	56	28	22	4	∅ 32	0 4612036001 00		0 4652036001 00

⁽¹⁾ Gültig für Code 4632 + 4652 / Valid for Code 4632 + 4652 / Valido per il codice 4632 + 4652



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

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

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

Einsatzbereich:
 HSSE Gewindebohrer für Durchgangsgewinde.
 Besonders geeignet für unlegierte, legierte sowie
 rostfreie Cr-Ni-Stähle $\leq 1200 \text{ N/mm}^2$.

Range of application:
 HSS Cobalt tap for through hole threads.
 Especially suitable for non-alloyed and alloyed
 steels and for stainless Cr-Ni-steels $\leq 1200 \text{ N/mm}^2$.

Impiego:
 Maschi in acciaio super rapido al Cobalto HSSE per fori
 passanti. Particolarmente adatti per acciai legati e non
 legati e per acciai inossidabili Cr-Ni $\leq 1200 \text{ N/mm}^2$.

Speedtap



Inox



VAPD

d1 mm	P mm	l1 mm	l2 mm	l3 mm	d2 _{h9} mm	a _{h12} mm	Z		Code 4662/4672 Art.-Nr.
M 2	0,4	45	8	-	2,8	2,1	2	∅ 1,6	0 4662002001 00
M 2,5	0,45	50	9	-	2,8	2,1	2	∅ 2,05	0 4662002501 00
M 3	0,5	56	11	18	3,5	2,7	3	∅ 2,5	0 4662003001 00
M 3,5	0,6	56	12	20	4	3	3	∅ 2,9	0 4662003501 00
M 4	0,7	63	13	21	4,5	3,4	3	∅ 3,3	0 4662004001 00
M 5	0,8	70	16	25	6	4,9	3	∅ 4,2	0 4662005001 00
M 6	1	80	19	30	6	4,9	3	∅ 5	0 4662006001 00
M 8	1,25	90	22	35	8	6,2	3	∅ 6,8	0 4662008001 00
M 10	1,5	100	24	39	10	8	3	∅ 8,5	0 4662010001 00
M 12	1,75	110	28	-	9	7	3	∅ 10,2	0 4672012001 00
M 14	2	110	30	-	11	9	3	∅ 12	0 4672014001 00
M 16	2	110	32	-	12	9	3	∅ 14	0 4672016001 00
M 18	2,5	125	34	-	14	11	3	∅ 15,5	0 4672018001 00
M 20	2,5	140	34	-	16	12	3	∅ 17,5	0 4672020001 00

⁽¹⁾ DIN 371 \leq M 10
 DIN 376 \geq M 12

D Maschinengewindebohrer
Speedtap-Uni/Inox,
 gerade genutet, für metrisches
 ISO-Gewinde DIN 13

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

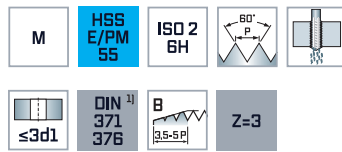
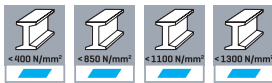
I Maschi a macchina
Speedtap-Uni/Inox,
 scanalature diritte, per
 filettatura metrica ISO, DIN 13

Einsatzbereich:
 HSSE-PM Gewindebohrer für Durchgangsgewinde.
 Besonders geeignet für unlegierte, legierte sowie
 rostfreie Cr-Ni-Stähle ≤1300 N/mm².

Range of application:
 Tap made of powder steel for through hole threads.
 Especially suitable for non-alloyed and alloyed
 steels and for stainless Cr-Ni-steels ≤1300 N/mm².

Impiego:
 Maschi in acciaio sinterizzato HSSE-PM per fori pas-
 santi. Particolarmente adatti per acciai legati e non
 legati e per acciai inossidabili Cr-Ni ≤1300 N/mm².

Speedtap



TiCN

d1 mm	P mm	l1 mm	l2 mm	l3 mm	d2 _{h9} mm	a _{h12} mm	Z		Code 4686/4696 Art.-Nr.
M 3	0,5	56	11	18	3,5	2,7	3	∅ 2,5	0 4686003001 00
M 4	0,7	63	13	21	4,5	3,4	3	∅ 3,3	0 4686004001 00
M 5	0,8	70	16	25	6	4,9	3	∅ 4,2	0 4686005001 00
M 6	1	80	19	30	6	4,9	3	∅ 5	0 4686006001 00
M 8	1,25	90	22	35	8	6,2	3	∅ 6,8	0 4686008001 00
M 10	1,5	100	24	39	10	8	3	∅ 8,5	0 4686010001 00
M 12	1,75	110	28	-	9	7	3	∅ 10,2	0 4696012001 00
M 16	2	110	32	-	12	9	3	∅ 14	0 4696016001 00
M 20	2,5	140	34	-	16	12	3	∅ 17,5	0 4696020001 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:
HSSE Gewindebohrer für Grundgewinde.
Besonders geeignet für unlegierte, legierte
sowie rostfreie Cr-Ni-Stähle ≤1200 N/mm².

Range of application:
HSS Cobalt tap for blind hole threads. Especially
suitable for non-alloyed and alloyed steels and
for stainless Cr-Ni-steels ≤1200 N/mm².

Impiego:
Maschi in acciaio super rapido al Cobalto HSSE per fori
ciechi. Particolarmente adatti per acciai legati e non
legati e per acciai inossidabili Cr-Ni ≤1200 N/mm².

Speedtap



d1 mm	P mm	l1 mm	l2 mm	l3 mm	d2 _{h9} mm	a _{h12} mm	Z		Code 4647 Art.-Nr.	Code 4604 Art.-Nr.	Code 4624 Art.-Nr.
M 2	0,4	45	8	-	2,8	2,1	2	∅ 1,6	0 4647002001 00		
M 2,5	0,45	50	9	-	2,8	2,1	2	∅ 2,05	0 4647002501 00		
M 3	0,5	56	5	18	3,5	2,7	3	∅ 2,5	0 4647003001 00	0 4604003001 00	0 4624003001 00
M 3,5	0,6	56	6	20	4	3	3	∅ 2,9	0 4647003501 00		
M 4	0,7	63	7	21	4,5	3,4	3	∅ 3,3	0 4647004001 00	0 4604004001 00	0 4624004001 00
M 5	0,8	70	8	25	6	4,9	3	∅ 4,2	0 4647005001 00	0 4604005001 00	0 4624005001 00
M 6	1	80	10	30	6	4,9	3	∅ 5	0 4647006001 00	0 4604006001 00	0 4624006001 00
M 8	1,25	90	13	35	8	6,2	3	∅ 6,8	0 4647008001 00	0 4604008001 00	0 4624008001 00
M 10	1,5	100	15	39	10	8	3	∅ 8,5	0 4647010001 00	0 4604010001 00	0 4624010001 00
M 12	1,75	110	18	45	12	9	4	∅ 10,2	0 4647012001 00		

^(*) Gültig für Code 4604 + 4624 / Valid for Code 4604 + 4624 / Valido per il codice 4604 + 4624

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

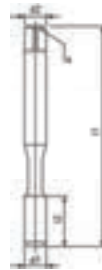
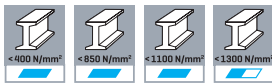
I Maschi a macchina
Speedtap-Inox,
 scanalature elicoidali, per
 filettatura metrica ISO, DIN 13

Einsatzbereich:
 HSSE Gewindebohrer für Grundgewinde.
 Besonders geeignet für unlegierte, legierte
 sowie rostfreie Cr-Ni-Stähle ≤1200 N/mm².

Range of application:
 HSS Cobalt tap for blind hole threads. Especially
 suitable for non-alloyed and alloyed steels and
 for stainless Cr-Ni-steels ≤1200 N/mm².

Impiego:
 Maschi in acciaio super rapido al Cobalto HSSE per fori
 ciechi. Particolarmente adatti per acciai legati e non
 legati e per acciai inossidabili Cr-Ni ≤1200 N/mm².

Speedtap



d1 mm	P mm	l1 mm	l2 mm	d2 _{h9} mm	a _{h12} mm	Z		Code 4657 Art.-Nr.	Code 4614 Art.-Nr.	Code 4634 Art.-Nr.
M 3	0,5	56	5	2,2	-	3	Ø 2,5	0 4657003001 00	0 4614003001 00	
M 4	0,7	63	7	2,8	2,1	3	Ø 3,3	0 4657004001 00	0 4614004001 00	
M 5	0,8	70	8	3,5	2,7	3	Ø 4,2	0 4657005001 00	0 4614005001 00	
M 6	1	80	10	4,5	3,4	3	Ø 5	0 4657006001 00	0 4614006001 00	
M 8	1,25	90	13	6	4,9	3	Ø 6,8	0 4657008001 00	0 4614008001 00	
M 10	1,5	100	15	7	5,5	3	Ø 8,5	0 4657010001 00	0 4614010001 00	
M 12	1,75	110	18	9	7	4	Ø 10,2	0 4657012001 00	0 4614012001 00	0 4634012001 00
M 14	2	110	20	11	9	4	Ø 12	0 4657014001 00		
M 16	2	110	20	12	9	4	Ø 14	0 4657016001 00	0 4614016001 00	0 4634016001 00
M 18	2,5	125	25	14	11	4	Ø 15,5	0 4657018001 00		
M 20	2,5	140	25	16	12	4	Ø 17,5	0 4657020001 00	0 4614020001 00	0 4634020001 00
M 22	2,5	140	25	18	14,5	4	Ø 19,5	0 4657022001 00		0 4634022001 00
M 24	3	160	30	18	14,5	4	Ø 21	0 4657024001 00		0 4634024001 00
M 27	3	160	30	20	16	4	Ø 24	0 4657027001 00		0 4634027001 00
M 30	3,5	180	35	22	18	5	Ø 26,5	0 4657030001 00		0 4634030001 00
M 33	3,5	180	35	25	20	5	Ø 29,5	0 4657033001 00		0 4634033001 00
M 36	4	200	40	28	22	5	Ø 32	0 4657036001 00		0 4634036001 00

^(*) Gültig für Code 4614 + 4634 / Valid for Code 4614 + 4634 / Valido per il codice 4614 + 4634



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

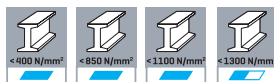
I **Maschi a macchina**
Speedtap-Inox,
scanalature elicoidali, per
filettatura metrica ISO, DIN 13

Einsatzbereich:
HSSE Gewindebohrer für Grundgewinde.
Besonders geeignet für unlegierte, legierte
sowie rostfreie Cr-Ni-Stähle ≤ 1200 N/mm².

Range of application:
HSS Cobalt tap for blind hole threads. Especially
suitable for non-alloyed and alloyed steels and for
stainless Cr-Ni-steels ≤ 1200 N/mm².

Impiego:
Maschi al Cobalto HSS per fori ciechi. Particolarmente
adatti per acciai legati e non legati e per acciai inossi-
dabili Cr-Ni ≤ 1200 N/mm².

Speedtap



d1 mm	P mm	l1 mm	l2 mm	l3 mm	d2 _{h9} mm	a _{h12} mm	Z		Code 4687/4697 Art.-Nr.
M 2	0,4	45	8	-	2,8	2,1	2	∅ 1,6	0 4687002001 00
M 2,5	0,45	50	9	-	2,8	2,1	2	∅ 2,05	0 4687002501 00
M 3	0,5	56	5	18	3,5	2,7	3	∅ 2,5	0 4687003001 00
M 4	0,7	63	7	21	4,5	3,4	3	∅ 3,3	0 4687004001 00
M 5	0,8	70	8	25	6	4,9	3	∅ 4,2	0 4687005001 00
M 6	1	80	10	30	6	4,9	3	∅ 5	0 4687006001 00
M 8	1,25	90	13	35	8	6,2	3	∅ 6,8	0 4687008001 00
M 10	1,5	100	15	39	10	8	3	∅ 8,5	0 4687010001 00
M 12	1,75	110	18	-	9	7	4	∅ 10,2	0 4697012001 00
M 14	2	110	20	-	11	9	4	∅ 12	0 4697014001 00
M 16	2	110	20	-	12	9	4	∅ 14	0 4697016001 00
M 18	2,5	125	25	-	14	11	4	∅ 15,5	0 4697018001 00
M 20	2,5	140	25	-	16	12	4	∅ 17,5	0 4697020001 00
M 24	3	160	30	-	18	14,5	4	∅ 21	0 4697024001 00
M 27	3	160	30	-	20	16	4	∅ 24	0 4697027001 00
M 30	3,5	180	35	-	22	18	5	∅ 26,5	0 4697030001 00

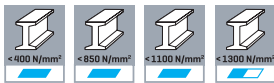
⁽¹⁾ DIN 371 \leq M 10
DIN 376 \geq M 12

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

Einsatzbereich:

HSSE Gewindebohrer für Grundgewinde.
Besonders geeignet für unlegierte, legierte
sowie rostfreie Cr-Ni-Stähle ≤ 1200 N/mm².

Speedtap



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

Range of application:

HSS Cobalt tap for blind hole threads. Especially
suitable for non-alloyed and alloyed steels and for
stainless Cr-Ni-steels ≤ 1200 N/mm².



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

Impiego:

Maschi in acciaio super rapido al Cobalto HSSE per fori
ciechi. Particolarmente adatti per acciai legati e non
legati e per acciai inossidabili Cr-Ni ≤ 1200 N/mm².

Inox



VAPD

d1 mm	P mm	l1 mm	l2 mm	l3 mm	d2 _{h9} mm	a _{h12} mm	Z		Code 4646/4656 Art.-Nr.
M 4	0,7	63	7	21	4,5	3,4	3	Ø 3,3	0 4646004001 00
M 5	0,8	70	8	25	6	4,9	3	Ø 4,2	0 4646005001 00
M 6	1	80	10	30	6	4,9	3	Ø 5	0 4646006001 00
M 8	1,25	90	13	35	8	6,2	3	Ø 6,8	0 4646008001 00
M 10	1,5	100	15	39	10	8	3	Ø 8,5	0 4646010001 00
M 12	1,75	110	18	-	9	7	4	Ø 10,2	0 4656012001 00
M 16	2	110	20	-	12	9	4	Ø 14	0 4656016001 00
M 20	2,5	140	25	-	16	12	4	Ø 17,5	0 4656020001 00

⁽¹⁾ DIN 371 \leq M 10
DIN 376 \geq M 12

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

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

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

Einsatzbereich:
HSSE-PM Gewindebohrer für Grundgewinde.
Besonders geeignet für unlegierte, legierte
sowie rostfreie Cr-Ni-Stähle ≤1300 N/mm².

Range of application:
Tap made of powder steel for blind hole threads.
Especially suitable for non-alloyed and alloyed
steels and for stainless Cr-Ni-steels ≤1300 N/mm².

Impiego:
Maschi in acciaio sinterizzato HSSE-PM per fori ciechi.
Particolarmente adatti per acciai legati e non legati e
per acciai inossidabili Cr-Ni ≤1300 N/mm².

Speedtap



TiCN



TiCN

d1 mm	P mm	l1 mm	l2 mm	l3 mm	d2 _{h9} mm	a _{h12} mm	Z		Code 4627/4637 Art.-Nr.	Code 4649/4659 Art.-Nr.
M 3	0,5	56	5	18	3,5	2,7	3	Ø 2,5		0 4649003001 00
M 4	0,7	63	7	21	4,5	3,4	3	Ø 3,3		0 4649004001 00
M 5	0,8	70	8	25	6	4,9	3	Ø 4,2		0 4649005001 00
M 6	1	80	10	30	6	4,9	3	Ø 5	0 4627006001 00	0 4649006001 00
M 8	1,25	90	13	35	8	6,2	3	Ø 6,8	0 4627008001 00	0 4649008001 00
M 10	1,5	100	15	39	10	8	3	Ø 8,5	0 4627010001 00	0 4649010001 00
M 12	1,75	110	18	-	9	7	4	Ø 10,2	0 4637012001 00	0 4659012001 00
M 14	2	110	20	-	11	9	4	Ø 12	0 4637014001 00	0 4659014001 00
M 16	2	110	20	-	12	9	4	Ø 14	0 4637016001 00	0 4659016001 00
M 18	2,5	125	25	-	14	11	4	Ø 15,5	0 4637018001 00	0 4659018001 00
M 20	2,5	140	25	-	16	12	4	Ø 17,5	0 4637020001 00	0 4659020001 00
M 22	2,5	140	25	-	18	14,5	4	Ø 19,5	0 4637022001 00	0 4659022001 00
M 24	3	160	30	-	18	14,5	4	Ø 21	0 4637024001 00	0 4659024001 00
M 27	3	160	30	-	20	16	4	Ø 24	0 4637027001 00	0 4659027001 00
M 30	3,5	180	35	-	22	18	4	Ø 26,5	0 4637030001 00	0 4659030001 00

⁽¹⁾ DIN 371 ≤ M 10
DIN 376 ≥ M 12

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

Einsatzbereich:

HSSE Gewindebohrer für Durchgangsgewinde.
Besonders geeignet für Aluminium Si ≤ 0,5%,
Kupfer, Thermoplaste.

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

Range of application:

HSS Cobalt tap for through hole threads.
Especially suitable for aluminium Si ≤ 0,5%,
copper, thermoplastics.

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

Impiego:

Maschi in acciaio super rapido al Cobalto HSSE per
fori passanti. Particolarmente adatti per alluminio
Si ≤ 0,5%, rame, materiali termoplastici.

Speedtap



d1 mm	P mm	l1 mm	l2 mm	l3 mm	d2 _{h9} mm	a _{h12} mm	Z		Code 4664/4674 Art.-Nr.
M 3	0,5	56	11	18	3,5	2,7	3	∅ 2,5	0 4664003001 00
M 4	0,7	63	13	21	4,5	3,4	3	∅ 3,3	0 4664004001 00
M 5	0,8	70	16	25	6	4,9	3	∅ 4,2	0 4664005001 00
M 6	1	80	19	30	6	4,9	3	∅ 5	0 4664006001 00
M 8	1,25	90	22	35	8	6,2	3	∅ 6,8	0 4664008001 00
M 10	1,5	100	24	39	10	8	3	∅ 8,5	0 4664010001 00
M 12	1,75	110	28	-	9	7	3	∅ 10,2	0 4674012001 00
M 16	2	110	32	-	12	9	3	∅ 14	0 4674016001 00
M 20	2,5	140	34	-	16	12	3	∅ 17,5	0 4674020001 00

⁽¹⁾ DIN 371 ≤ M 10
DIN 376 ≥ M 12

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

Einsatzbereich:
HSSE Gewindebohrer für Grundgewinde.
Besonders geeignet für Aluminium
Si ≤ 0,5%, Kupfer, Thermoplaste.

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

Range of application:
HSS Cobalt tap for blind hole threads. Especially
suitable for aluminium Si ≤ 0,5%, copper, thermo-
plastics.

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

Impiego:
Maschi in acciaio super rapido al Cobalto HSSE
per fori ciechi. Particolarmente adatti per alluminio
Si ≤ 0,5%, rame, materiali termoplastici.

Speedtap



d1 mm	P mm	l1 mm	l2 mm	l3 mm	d2 _{h9} mm	a _{h12} mm	Z		Code 4676 Art.-Nr.
M 2	0,4	45	8	-	2,8	2,1	2	Ø 1,6	0 4676002001 00
M 2,5	0,45	50	9	-	2,8	2,1	2	Ø 2,05	0 4676002501 00
M 3	0,5	56	5	18	3,5	2,7	3	Ø 2,5	0 4676003001 00
M 3,5	0,6	56	6	20	4	3	3	Ø 2,9	0 4676003501 00
M 4	0,7	63	7	21	4,5	3,4	3	Ø 3,3	0 4676004001 00
M 5	0,8	70	8	25	6	4,9	3	Ø 4,2	0 4676005001 00
M 6	1	80	10	30	6	4,9	3	Ø 5	0 4676006001 00
M 8	1,25	90	13	35	8	6,2	3	Ø 6,8	0 4676008001 00
M 10	1,5	100	15	39	10	8	3	Ø 8,5	0 4676010001 00

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

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

I Maschi a macchina
Speedtap–Grauguss,
 scanalature diritte, per
 filettatura metrica ISO, DIN 13

Einsatzbereich:

HSSE Gewindebohrer für Durchgangs- und Grundgewinde. Besonders geeignet für alle Gußeisen [Grauguß, Kugelgraphitguß, Temperguß, Vermikularguß, ADI, Hartguß].

Range of application:

HSS Cobalt tap for through hole threads and blind hole threads. Especially suitable for all cast iron [grey cast iron, spheroidal graphite, malleable cast iron, vermicular, ADI, chilled iron].

Impiego:

Maschi in acciaio super rapido al Cobalto HSSE per fori passanti e fori ciechi. Particolarmente adatti per tutti i tipi di ghisa [ghisa grigia, ghisa sferoidale, ghisa temprata, ghisa vermiculare, ADI, ghisa temperata].

Speedtap



M HSS E/V3 6HX 60° P.P. 3-3 P. Z=3-4

≤2,5d1 DIN 371 376 C 2-3 P. Z=3-4



d1 mm	P mm	l1 mm	l2 mm	l3 mm	d2 _{h9} mm	a _{h12} mm	Z		Code 4684 Art.-Nr.	Code 4694 Art.-Nr.
M 4	0,7	63	13	21	4,5	3,4	3	∅ 3,3	0 4684004001 00	
M 5	0,8	70	16	-	3,5	2,7	3	∅ 4,2		0 4694005001 00
M 5	0,8	70	16	25	6	4,9	3	∅ 4,2	0 4684005001 00	
M 6	1	80	19	-	4,5	3,4	3	∅ 5		0 4694006001 00
M 6	1	80	19	30	6	4,9	3	∅ 5	0 4684006001 00	
M 8	1,25	90	22	-	6	4,9	4	∅ 6,8		0 4694008001 00
M 8	1,25	90	22	35	8	6,2	4	∅ 6,8	0 4684008001 00	
M 10	1,5	100	24	-	7	5,5	4	∅ 8,5		0 4694010001 00
M 10	1,5	100	24	39	10	8	4	∅ 8,5	0 4684010001 00	
M 12	1,75	110	28	-	9	7	4	∅ 10,2		0 4694012001 00
M 16	2	110	32	-	12	9	4	∅ 14		0 4694016001 00

⁽¹⁾ DIN 371 ≤ M 10
 DIN 376 ≥ M 12



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

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

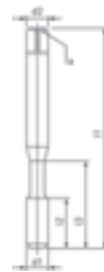
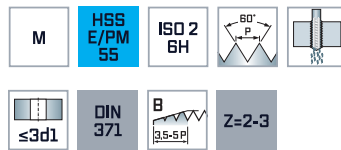
I Maschi a macchina Speedtap–Grauguss, scanalature diritte, per filettatura metrica ISO, DIN 13

Einsatzbereich:
HSSE-PM Gewindebohrer für Durchgangsgewinde. Besonders geeignet für alle Gußeisen (Grauguß, Kugelgraphitguß, Temperguß, Vermikularguß, ADI, Hartguß).

Range of application:
Tap made of powder steel for through hole threads and blind hole threads. Especially suitable for all cast iron [grey cast iron, spheroidal graphite, malleable cast iron, vermicular, ADI, chilled iron].

Impiego:
Maschi in acciaio sinterizzato HSSE-PM per fori passanti. Particolarmente adatti per tutti i tipi di ghisa [ghisa grigia, ghisa sferoidale, ghisa temprata, ghisa vermiculare, ADI, ghisa temperata].

Speedtap



Cast Iron



TiCN

d1 mm	P mm	l1 mm	l2 mm	l3 mm	d2 _{h9} mm	a _{h12} mm	Z			Code 4682 Art.-Nr.
M 2,5	0,45	50	9	-	2,8	2,1	2	0	2,05	0 4682002501 00
M 3	0,5	56	11	18	3,5	2,7	3	0	2,5	0 4682003001 00
M 3,5	0,6	56	12	20	4	3	3	0	2,9	0 4682003501 00
M 4	0,7	63	13	21	4,5	3,4	3	0	3,3	0 4682004001 00
M 5	0,8	70	16	25	6	4,9	3	0	4,2	0 4682005001 00
M 6	1	80	19	30	6	4,9	3	0	5	0 4682006001 00
M 8	1,25	90	22	35	8	6,2	3	0	6,8	0 4682008001 00
M 10	1,5	100	24	39	10	8	3	0	8,5	0 4682010001 00

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

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

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

Einsatzbereich:

HSSE-PM Gewindebohrer für Grundgewinde.
 Besonders geeignet für alle Gußeisen (Grauguß,
 Kugelgraphitguß, Temperguß, Vermikularguß,
 ADI, Hartguß).

Range of application:

Tap made of powder steel for blind hole threads.
 Especially suitable for all cast iron (grey cast iron,
 spheroidal graphite, malleable cast iron, vermicu-
 lar, ADI, chilled iron).

Impiego:

Maschi in acciaio sinterizzato HSSE-PM per fori
 ciechi. Particolarmente adatti per tutti i tipi di ghisa
 (ghisa grigia, ghisa sferoidale, ghisa temprata, ghisa
 vermiculare, ADI, ghisa temperata).

Speedtap



M HSS E/PM 55 ISO 2 6H 60° P_{max} 15°

≤1,5d1 DIN 371 C 2-3 P 15° Z=2-3



Cast Iron



TiCN

d1 mm	P mm	l1 mm	l2 mm	l3 mm	d2 _{h9} mm	a _{h12} mm	Z		Code 4698 Art.-Nr.
M 2,5	0,45	50	9	-	2,8	2,1	2	Ø 2,05	0 4698002501 00
M 3	0,5	56	5	18	3,5	2,7	3	Ø 2,5	0 4698003001 00
M 3,5	0,6	56	6	20	4	3	3	Ø 2,9	0 4698003501 00
M 4	0,7	63	7	21	4,5	3,4	3	Ø 3,3	0 4698004001 00
M 5	0,8	70	8	25	6	4,9	3	Ø 4,2	0 4698005001 00
M 6	1	80	10	30	6	4,9	3	Ø 5	0 4698006001 00
M 8	1,25	90	13	35	8	6,2	3	Ø 6,8	0 4698008001 00
M 10	1,5	100	15	39	10	8	3	Ø 8,5	0 4698010001 00



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

Einsatzbereich:
HSSE Gewindeformer für Durchgangs- und Grundgewinde. Besonders geeignet für unlegierte, und legierte Stähle ≤1300 N/mm², Aluminium Si ≤ 10%.

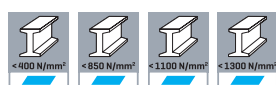
E Rolling taps Speedtap-Universal, with oil grooves, for metric ISO-threads DIN 13

Range of application:
HSS Cobalt rolling tap for through hole threads and blind hole threads. Especially suitable for non-alloyed and alloyed steels ≤1300 N/mm², aluminium Si ≤10%.

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

Impiego:
Maschi a rulare in acciaio super rapido al Cobalto HSSE per fori passanti e fori ciechi. Particolarmente adatti per acciai legati e non legati ≤1300 N/mm², alluminio Si ≤ 10%.

Speedtap



d1 mm	P mm	l1 mm	l2 mm	l3 mm	d2 _{h9} mm	a _{h12} mm	Z		Code 4689/4699 Art.-Nr.	Code 4669/4679 Art.-Nr.
M 1	0,25	40	5,5	-	2,5	2,1	-	Ø 0,9		0 4669001001 00
M 1,2	0,25	40	5,5	-	2,5	2,1	-	Ø 1,1		0 4669001201 00
M 1,4	0,3	40	7	-	2,5	2,1	-	Ø 1,27		0 4669001401 00
M 1,6	0,35	40	8	-	2,5	2,1	-	Ø 1,45		0 4669001601 00
M 2	0,4	45	8	-	2,8	2,1	-	Ø 1,85		0 4669002001 00
M 2,5	0,45	50	9	-	2,8	2,1	-	Ø 2,33		0 4669002501 00
M 3	0,5	56	8	18	3,5	2,7	4	Ø 2,8		0 4669003001 00
M 4	0,7	63	11	21	4,5	3,4	4	Ø 3,7		0 4669004001 00
M 5	0,8	70	12	25	6	4,9	5	Ø 4,65		0 4669005001 00
M 6	1	80	10	30	6	4,9	5	Ø 5,55	0 4689006001 00	0 4669006001 00
M 8	1,25	90	12	35	8	6,2	5	Ø 7,4	0 4689008001 00	0 4669008001 00
M 10	1,5	100	15	39	10	8	8	Ø 9,3	0 4689010001 00	0 4669010001 00
M 12	1,75	110	17	-	9	7	8	Ø 11,2	0 4699012001 00	0 4679012001 00
M 14	2	110	20	-	11	9	8	Ø 13	0 4699014001 00	0 4679014001 00
M 16	2	110	20	-	12	9	8	Ø 15	0 4699016001 00	0 4679016001 00
M 18	2,5	125	20	-	14	11	8	Ø 16,8	0 4699018001 00	0 4679018001 00
M 20	2,5	140	20	-	16	12	8	Ø 18,8	0 4699020001 00	0 4679020001 00
M 22	2,5	140	20	-	18	14,5	8	Ø 20,8	0 4699022001 00	0 4679022001 00
M 24	3	160	24	-	18	14,5	8	Ø 22,5	0 4699024001 00	0 4679024001 00
M 27	3	160	18	-	20	16	8	Ø 25,5	0 4699027001 00	0 4679027001 00
M 30	3,5	180	21	-	22	18	8	Ø 28,2	0 4699030001 00	0 4679030001 00
M 33	3,5	180	21	-	25	20	8	Ø 31,2	0 4699033001 00	
M 36	4	200	24	-	28	22	8	Ø 33,9	0 4699036001 00	
M 39	4	200	24	-	32	24	9	Ø 36,9	0 4699039001 00	
M 42	4,5	200	27	-	32	24	9	Ø 39,6	0 4699042001 00	
M 45	4,5	220	27	-	36	29	9	Ø 42,6	0 4699045001 00	

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

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

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

Einsatzbereich:
HSSE Gewindeformer für Durchgangs- und Grundgewinde. Besonders geeignet für rostfreie Cr-Ni-Stähle ≤1200 N/mm², Aluminium Si ≤ 10%.

Range of application:
HSS Cobalt rolling tap for through hole threads and blind hole threads. Especially suitable for stainless Cr-Ni-steels ≤1200 N/mm², aluminium Si ≤10%.

Impiego:
Maschi a rullare in acciaio super rapido al Cobalto HSSE per fori passanti e fori ciechi. Particolarmente adatti per acciai inossidabili Cr-Ni ≤1200 N/mm², alluminio Si ≤ 10%.



d1 mm	P mm	l1 mm	l2 mm	l3 mm	d2 _{h9} mm	a _{h12} mm	Z		Code 4678/4688 Art.-Nr.	Code 4644/4654 Art.-Nr.
M 2	0,4	45	8	-	2,8	2,1	3	Ø 1,83		0 4644002001 00
M 2,5	0,45	50	9	-	2,8	2,1	3	Ø 2,33		0 4644002501 00
M 3	0,5	56	11	18	3,5	2,7	4	Ø 2,8		0 4644003001 00
M 3,5	0,6	56	11	18	4	3	4	Ø 3,25		0 4644003501 00
M 4	0,7	63	13	21	4,5	3,4	5	Ø 3,7		0 4644004001 00
M 5	0,8	70	16	25	6	4,9	5	Ø 4,65		0 4644005001 00
M 6	1	80	19	30	6	4,9	5	Ø 5,55	0 4678006001 00	0 4644006001 00
M 8	1,25	90	22	35	8	6,2	6	Ø 7,4	0 4678008001 00	0 4644008001 00
M 10	1,5	100	24	39	10	8	6	Ø 9,3	0 4678010001 00	0 4644010001 00
M 12	1,75	110	28	-	9	7	6	Ø 11,2	0 4688012001 00	0 4654012001 00
M 14	2	110	30	-	11	9	5	Ø 13	0 4688014001 00	0 4654014001 00
M 16	2	110	32	-	12	9	7	Ø 15	0 4688016001 00	0 4654016001 00

