

M ISO METRIC COARSE DIN 13 TOP-LINE TAP

High Performance Machine Taps for Stainless Steels, Soft Steels & Structural Steels & Copper

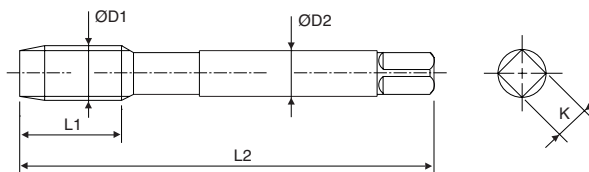
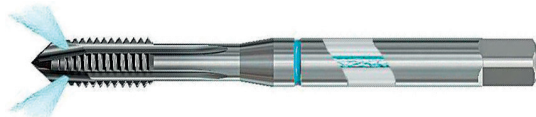
K24/25M-TXC

- ▶ Powder Metal substrate for maximum tool life
- ▶ TiAlN +C coating offers exceptional wear resistance
- ▶ Through coolant enables excellent chip evacuation & provides increased tool life

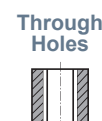
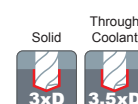
Solid



Through Coolant



FOR KEY SEE PAGE 869



SPIRAL POINT • 6HX TOLERANCE

ØD1	Pitch	L1	L2	ØD2 h9	K h12	No. Flute	Drill Dia.	ORDER CODE	PRICE
SOLID									
M3	0.5	10	56	3.5	2.7	3	2.5	K24M3X-TXC	£18.81
M4	0.7	13	63	4.5	3.4	3	3.3	K24M4X-TXC	£18.81
M5	0.8	13	70	6	4.9	3	4.2	K24M5X-TXC	£18.81
M6	1	16	80	6	4.9	3	5	K24M6X-TXC	£18.81
M8	1.25	18	90	8	6.2	3	6.8	K24M8X-TXC	£24.06
M10	1.5	20	100	10	8	3	8.5	K24M10X-TXC	£28.30
M12	1.75	25	110	9	7	4	10.3	K25M12X-TXC	£33.62
M14	2	28	110	11	9	4	12	K25M14X-TXC	£44.65
M16	2	28	110	12	9	4	14	K25M16X-TXC	£52.94
THROUGH COOLANT									
M6	1	16	80	6	4.9	3	5	K24M6XFORY-TXC	£47.00
M8	1.25	18	90	8	6.2	3	6.8	K24M8XFORY-TXC	£50.07
M10	1.5	20	100	10	8	3	8.5	K24M10XFORY-TXC	£54.51
M12	1.75	25	110	9	7	4	10.3	K25M12XFORY-TXC	£63.97
M14	2	28	110	11	9	4	12	K25M14XFORY-TXC	£76.59
M16	2	28	110	12	9	4	14	K25M16XFORY-TXC	£85.60

ACCESSORIES ER TAP COLLETS WITH SQUARE DRIVE & QUICK CHANGE TAP ADAPTERS

For taps ≥M30, See page 1085 for size 3 tap adapters



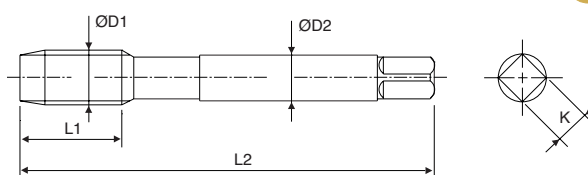
Tap Dia. ØD1	Shank ØD2	Square K	ER TAP COLLETS WITH SQUARE					QC TAP ADAPTER FIXED		QC TAP ADAPTER CLUTCH	
			ER16	ER20	ER25	ER32	ER40	SIZE 1	SIZE 2	SIZE 1	SIZE 2
M3	3.5	2.7	ER16MD03.5	ER20MD03.5	ER25MD03.5	ER32MD03.5	-	IBC1-3.5X2.7	-	IBS1-3.5X2.7	-
M4	4.5	3.4	ER16MD04.5	ER20MD04.5	ER25MD04.5	ER32MD04.5	-	IBC1-4.5X3.4	-	IBS1-4.5X3.4	-
M5/M6	6	4.9	ER16MD06	ER20MD06	ER25MD06	ER32MD06	ER40MD06	IBC1-6X4.9	IBC2-6X4.9	IBS1-6X4.9	IBS2-6X4.9
M8	8	6.2	ER16MD08	ER20MD08	ER25MD08	ER32MD08	ER40MD08	IBC1-8X6.2	IBC2-8X6.2	IBS1-8X6.2	IBS2-8X6.2
M10	10	8	-	ER20MD10	ER25MD10	ER32MD10	ER40MD10	IBC1-10X8	IBC2-10X8	IBS1-10X8	IBS2-10X8
M12	9	7	-	ER20MD09	ER25MD09	ER32MD09	ER40MD09	IBC1-9X7	IBC2-9X7	IBS1-9X7	IBS2-9X7
M14	11	9	-	-	ER25MD11	ER32MD11	ER40MD11	IBC1-11X9	IBC2-11X9	IBS1-11X9	IBS2-11X9
M16	12	9	-	-	ER25MD12	ER32MD12	ER40MD12	-	IBC2-12X9	-	IBS2-12X9

M ISO METRIC COARSE DIN 13 TOP-LINE TAP

Ultra High Performance Machine Taps for Stainless Steels, Soft Steels & Carbon Steels

K82M-TXC
K82M-FOR-TXC

- ▶ Powder Metal substrate for maximum tool life
- ▶ TiAIN +C coating offers exceptional wear resistance
- ▶ Through coolant enables excellent chip evacuation & provides increased tool life
- ▶ Inox taper prevents oversized threads and premature tap failure

Solid**Through Coolant****SPIRAL FLUTE • 6HX TOLERANCE**

ØD1	Pitch	L1	L2	ØD2 h9	K h12	No. Flute	Drill Dia.	ORDER CODE	PRICE
SOLID									
M3	0.5	10	56	3.5	2.7	3	2.5	K82M3X-TXC	£19.14
M4	0.7	13	63	4.5	3.4	3	3.3	K82M4X-TXC	£19.14
M5	0.8	13	70	6	4.9	3	4.2	K82M5X-TXC	£19.14
M6	1	16	80	6	4.9	3	5	K82M6X-TXC	£19.14
M8	1.25	18	90	8	6.2	3	6.8	K82M8X-TXC	£22.78
M10	1.5	20	100	10	8	3	8.5	K82M10X-TXC	£26.41
M12	1.75	25	110	9	7	3	10.3	K83M12X-TXC	£38.29
M14	2	28	110	11	9	3	12	K83M14X-TXC	£50.17
M16	2	28	110	12	9	4	14	K83M16X-TXC	£58.40
THROUGH COOLANT									
M6	1	16	80	6	4.9	3	5	K82M6XFOR-TXC	£36.34
M8	1.25	18	90	8	6.2	3	6.8	K82M8XFOR-TXC	£39.24
M10	1.5	20	100	10	8	3	8.5	K82M10XFOR-TXC	£43.09
M12	1.75	25	110	9	7	3	10.3	K83M12XFOR-TXC	£47.37
M14	2	28	110	11	9	3	12	K83M14XFOR-TXC	£56.83
M16	2	28	110	12	9	4	14	K83M16XFOR-TXC	£64.03

MATERIAL APPLICATIONS N/mm² CUTTING SPEED m/min

● Excellent ○ Good

STEELS				HARDENED STEELS		STAINLESS STEELS			CAST IRON				TITANIUM	
Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite			Ti	Ti Alloy
<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
		● 20-25	● 15-20	○ 5-12		● 10-15	● 8-10	● 6-8						
TITANIUM				COPPER, BRASS, BRONZE				ALUMINIUM				PLASTICS / COMPOSITES		
Ti Alloy	Nickel	Nickel Alloy	Nickel Alloy	Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al		Thermo	Thermoset	CFRP/GFRP
≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%			