SWISS+TECH HSS 'Blue Ring' Taps

Manufactured to **DIN 371/376**

Suitable for the following Material Groups

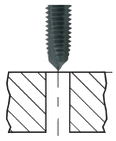
Group	Materials	Brinell Hardness HB	Tensile Strength N/mm²	Tapping Speed M/min
2.1	Soft and generally easy to machine ferritic & martensitic stainless steel and castings	up to 230	up to 800	4 - 6
2.2	Medium strength & reasonable to machine austenitic stainless steel and castings	up to 290	up to 1000	4 - 6
2.3	Hard & generally difficult to machine ferritic & austenitic stainless steel & castings	up to 340	up to 1200	3 - 6

Note: Fluteless taps may also be used on stainless steel. See 'Green Ring' **FLUTELESS** on page THB.

Spiral Point/Gun Nose - HSS-EV Oxidised Finish
For through holes.
Taper lead to **DIN form B** (3.5 x P to 5.5 x P).
Tapping tolerance to **6HX**.

HSS-EV

SPIRAL POINT FOR THROUGH HOLES





ISO Metric Coarse

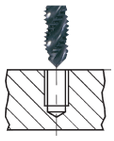
Size - Pitch (mm)	Overall Length	Thread Length	Shank Dia.	A/F Square	Weight each	Order Code SWT-185	Price/1 THB
M2.0 x 0.40	45.0	8.0	2.8	2.1	4g	-2003B	1082.00
M3.0 x 0.50	56.0	11.0	3.5	2.7	5g	-2009B	924.00
M4.0 x 0.70	63.0	13.0	4.5	3.4	8g	-2015B	924.00
M5.0 x 0.80	70.0	15.0	6.0	4.9	13g	-2018B	977.00
M6.0 x 1.00	80.0	17.0	6.0	4.9	17g	-2021B	1082.00
M8.0 x 1.25	90.0	20.0	8.0	6.0	32g	-2027B	1134.00
M10.0 x 1.50	100.0	22.0	10.0	8.0	55g	-2030B	1386.00
M12.0 x 1.75	110.0	24.0	9.0	7.0	61g	-2033B	1743.00
M16.0 x 2.00	110.0	27.0	12.0	9.0	108g	-2039B	2457.00

Spiral Flute (BLT) - HSS-EV Oxidised Finish
For deep blind holes.
Taper lead to **DIN form C** (2 x P to 3 x P).
Tapping tolerance to **6H**.

DIN 371/6

HSS-EV

SPIRAL FLUTE FOR BLIND HOLES





'Biteless Taper' ISO Metric Coarse

Helix angle 45°

Size - Pitch (mm)	Overall Length	Thread Length	Shank Dia.	A/F Square	Weight each	Order Code SWT-185	Price/1 THB
M2.0 x 0.40	45.0	8.0	2.8	2.1	5g	-2503B	2247.00
M3.0 x 0.50	56.0	6.0	3.5	2.7	5g	-2509B	977.00
M4.0 x 0.70	63.0	7.0	4.5	3.4	8g	-2515B	977.00
M5.0 x 0.80	70.0	8.0	6.0	4.9	13g	-2518B	1029.00
M6.0 x 1.00	80.0	11.0	6.0	4.9	16g	-2521B	1029.00
M8.0 x 1.25	90.0	13.0	8.0	6.2	30g	-2527B	1229.00
M10.0 x 1.50	100.0	15.0	10.0	8.0	45g	-2530B	1176.00
M12.0 x 1.75	110.0	18.0	9.0	7.0	56g	-2533B	1890.00
M16.0 x 2.00	110.0	20.0	12.0	9.0	95g	-2539B	2615.00

Spiral Flute (BLF) - HSS-EV Oxidised Finish
For shorter blind holes. Taper lead to **DIN form C** (3 x P).
Tapping tolerance to **6H**.

'Biteless Flat' ISO Metric Coarse

Helix angle 45°.

Size - Pitch (mm)	Overall Length	Thread Length	Shank Dia.	A/F Square	Weight each	Order Code SWT-185	Price/1 THB
M3.0 x 0.50	56.0	6.0	3.5	2.7	5g	-3009B	1985.00
M4.0 x 0.70	63.0	7.0	4.5	3.4	8g	-3015B	2079.00
M5.0 x 0.80	70.0	8.0	6.0	4.9	13g	-3018B	2184.00
M6.0 x 1.00	80.0	11.0	6.0	4.9	16g	-3021B	2289.00
M8.0 x 1.25	90.0	13.0	8.0	6.2	30g	-3027B	2394.00
M10.0 x 1.50	100.0	15.0	10.0	8.0	45g	-3030B	2730.00
M12.0 x 1.75	110.0	18.0	9.0	7.0	56g	-3033B	2835.00
M16.0 x 2.00	110.0	20.0	12.0	9.0	95g	-3039B	3224.00

SHERWOOD QUALITY CUTTING TOOLS Sherwood STD

400 ml

Fluid Spray
Non-soluble tapping and drilling aerosol spray that penetrates and clings to normally inaccessible areas and moving cutting edges.



Size	Weight per 12	Order Code SHR-732	Price/1 THB
400ml	5.1kg	-4000K	767.00

Sherwood STD Liquid (Poly Bottle)
Low odour liquid. Coats the cutting edge with a film of EP additives.

Sherwood STD Compound
Low melting point paste maintains a continual lubricant feed to the cutting edge. Hand applied. Suitable for the most severe cutting operations.



Lubricant Type	Size	Order Code SHR-732	Price/1 THB
Liquid	500ml	-4020K	893.00
Liquid	5ltr	-4060K	7308.00
Compound	500g	-4040K	735.00

STD Tapping & Drilling Non-Soluble Foam Lubricant

400 ml

Foam aerosol penetrates and is able to cling to normally inaccessible areas and moving cutting edges. Can be used on yellow metals without the risk of staining.



Size	Order Code SHR-732	Offer Price/1
400ml	-4210K	504.00

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