SWISS+TECH HSS 'Purple Ring' Taps

HSS-PM | DIN 371/6

Suitable for the following Material Groups

Group	Materials	Brinell Hardness HB	Tensile Strength N/mm²	Tapping Speed M/min
4.1	Titanium alloy (also pure nickel)	-		3 - 9

Right Hand Cutting - Left Hand Spiral Flute - HSS-PM Nitride Finish
For through holes. Left hand spiral.
Taper lead to **DIN form D**
(3.5 x P to 5 x P). Tapping tolerance to **6HX**.

LEFT HAND SPIRAL FLUTE FOR THROUGH HOLES

METRIC COARSE



ISO Metric Coarse Helix angle 15°.

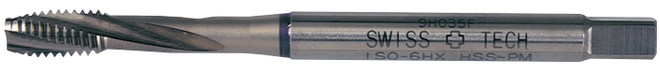
Size - Pitch (mm)	Overall Length	Thread Length	Shank Dia.	A/F Square	Weight each	Order Code SWT-185	Price/1 THB
M3.0 x 0.50	56.0	11.0	3.5	2.7	5g	**-4509P**	**1638.00**
M3.5 x 0.60	56.0	13.0	4.0	3.0	6g	**-4512P**	**1376.00**
M4.0 x 0.70	63.0	13.0	4.5	3.4	8g	**-4515P**	**1743.00**
M5.0 x 0.80	70.0	16.0	6.0	4.9	14g	**-4518P**	**1838.00**
M6.0 x 1.00	80.0	19.0	6.0	4.9	17g	**-4521P**	**1932.00**
M8.0 x 1.25	90.0	22.0	8.0	6.2	32g	**-4527P**	**2079.00**
M10.0 x 1.50	100.0	24.0	10.0	8.0	55g	**-4530P**	**2289.00**
M12.0 x 1.75	110.0	29.0	9.0	7.0	63g	**-4533P**	**3077.00**

Group	Materials	Brinell Hardness HB	Tensile Strength N/mm²	Tapping Speed M/min
4.2	Titanium alloy medium and hard to machine	-	up to 900	6 - 9
4.3	Titanium alloys of a hard and very hard to machine nature	-	up to 1200	6 - 9

Spiral Flute - HSS-PM Nitride Finish
For blind holes. Taper lead to **DIN form B**
(3 x P). Tapping tolerance to **6HX**.

SPIRAL FLUTE FOR BLIND HOLES

METRIC COARSE



ISO Metric Coarse Helix angle 15°. Tapping depth 2.5 x D.

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	5.0	3.5	2.7	5g	**-5009P**	**1334.00**
M3.5 x 0.60	56.0	7.0	4.0	3.0	6g	**-5012P**	**1680.00**
M4.0 x 0.70	63.0	7.0	4.5	3.4	8g	**-5015P**	**1491.00**
M5.0 x 0.80	70.0	9.0	6.0	4.9	14g	**-5018P**	**1586.00**
M6.0 x 1.00	80.0	11.0	6.0	4.9	17g	**-5021P**	**1691.00**
M8.0 x 1.25	90.0	12.0	8.0	6.2	32g	**-5027P**	**1785.00**
M10.0 x 1.50	100.0	13.0	10.0	8.0	55g	**-5030P**	**1890.00**
M12.0 x 1.75	110.0	15.0	9.0	7.0	63g	**-5033P**	**2510.00**

HSS 'Orange Ring' Taps

HSS-PM

Suitable for the following Material Groups

Group	Materials	Brinell Hardness HB	Tensile Strength N/mm²	Tapping Speed M/min
4.3	Titanium alloys of a hard and very hard to machine nature	-	up to 1250	3 - 6
5.1	Heat resistant super alloys including iron based high temperature alloys	-	up to 500	6 - 6

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

SPIRAL POINT FOR THROUGH HOLES

METRIC COARSE



ISO Metric Coarse

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	11.0	3.5	2.7	5g	**-5509N**	**1481.00**
M3.5 x 0.60	56.0	13.0	4.0	3.0	7g	**-5512N**	**1344.00**
M4.0 x 0.70	63.0	13.0	4.5	3.4	8g	**-5515N**	**1481.00**
M5.0 x 0.80	70.0	16.0	6.0	4.9	13g	**-5518N**	**1586.00**
M6.0 x 1.00	80.0	19.0	6.0	4.9	17g	**-5521N**	**1586.00**
M8.0 x 1.25	90.0	22.0	8.0	6.2	32g	**-5527N**	**1890.00**
M10.0 x 1.50	100.0	24.0	10.0	8.0	55g	**-5530N**	**2457.00**
M12.0 x 1.75	110.0	29.0	9.0	7.0	61g	**-5533N**	**2919.00**

Group	Materials	Brinell Hardness HB	Tensile Strength N/mm²	Tapping Speed M/min
5.2	Heat resistant super alloys, cobalt or nickel based medium to hard to machine	-	up to 900	3 - 6
5.3	Heat resistant super alloys, cobalt or nickel based hard to very hard to machine	-	up to 1200	3 - 6

Spiral Flute - HSS-PM Nitride & Oxide Finish
For blind holes. **Taper lead to DIN form C.**
This tap has the special chamfer lead of (3 x P).
Tapping tolerance: spiral flute to **6H.**

SPIRAL FLUTE FOR BLIND HOLES

METRIC COARSE



ISO Metric Coarse Helix angle 40°. Tapping depth 2.5 x D.

Size - Pitch (mm)	Overall Length	Thread Length	Shank Dia.	A/F Square	Weight each	Order Code SWT-185	Price/1 THB
M4.0 x 0.70	63.0	7.0	4.5	3.4	9g	**-6015N**	**1386.00**
M5.0 x 0.80	70.0	9.0	6.0	4.9	13g	**-6018N**	**1439.00**
M6.0 x 1.00	80.0	11.0	6.0	4.9	16g	**-6021N**	**1439.00**
M8.0 x 1.25	90.0	12.0	8.0	6.2	30g	**-6027N**	**NA**
M10.0 x 1.50	100.0	13.0	10.0	8.0	51g	**-6030N**	**2048.00**
M12.0 x 1.75	110.0	15.0	9.0	7.0	56g	**-6033N**	**2615.00**
M16.0 x 2.00	110.0	18.0	12.0	9.0	95g	**-6039N**	**3686.00**

© 2022

OS21_APAC_TH_0064.indd 1 07/12/2021 10:24