SWISS+TECH HSS 'Green Ring' Taps

DIN 371/6

HSS-EV

Manufactured to **DIN 371/376**

Suitable for the following Material Groups

Group	Materials	Brinell Hardness HB	Tensile Strength N/mm²	Tapping Speed M/min
7.1	Unalloyed aluminium, magnesium and zinc	-	up to 150	20 - 30
7.2	Aluminium alloy less than 5% silicon magnesium & zinc alloys (long chip)	-	up to 1200	20 - 30

Group	Materials	Brinell Hardness HB	Tensile Strength N/mm²	Tapping Speed M/min
7.3	Aluminium alloy 5% to 10% silicon	-	up to 500	15 - 20
7.4	Aluminium alloy 5% to 10% silicon	-	up to 500	15 - 20

Spiral Point/Gun Nose - HSS-EV Nitride 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



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

SPIRAL FLUTE FOR BLIND 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
M2.0 x 0.40	45.0	8.0	2.8	2.1	4g	**-6503G**	**1061.00**
M3.0 x 0.50	56.0	11.0	3.5	2.7	5g	**-6509G**	**714.00**
M4.0 x 0.70	63.0	13.0	4.5	3.4	8g	**-6515G**	**714.00**
M5.0 x 0.80	70.0	16.0	6.0	4.9	13g	**-6518G**	**777.00**
M6.0 x 1.00	80.0	19.0	6.0	4.9	17g	**-6521G**	**777.00**
M8.0 x 1.25	90.0	22.0	8.0	6.2	32g	**-6527G**	**1061.00**
M10.0 x 1.50	100.0	24.0	10.0	8.0	58g	**-6530G**	**1208.00**
M12.0 x 1.75	110.0	29.0	9.0	7.0	61g	**-6533G**	**2079.00**
M16.0 x 2.00	110.0	32.0	12.0	9.0	108g	**-6539G**	**2321.00**

ISO Metric Coarse Helix angle 45°. 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
M2.0 x 0.40	45.0	8.0	2.8	2.1	5g	**-7003G**	**1061.00**
M2.5 x 0.45	50.0	9.0	2.8	2.1	5g	**-7006G**	**956.00**
M3.0 x 0.50	56.0	11.0	3.5	2.7	5g	**-7009G**	**777.00**
M4.0 x 0.70	63.0	13.0	4.5	3.4	8g	**-7015G**	**777.00**
M5.0 x 0.80	70.0	16.0	6.0	4.9	13g	**-7018G**	**819.00**
M6.0 x 1.00	80.0	19.0	6.0	4.9	16g	**-7021G**	**872.00**
M7.0 x 1.00	80.0	19.0	7.0	5.5	19	**-7024G**	**NA**
M8.0 x 1.25	90.0	22.0	8.0	6.2	30g	**-7027G**	**1040.00**
M10.0 x 1.50	100.0	24.0	10.0	8.0	45g	**-7030G**	**1218.00**
M12.0 x 1.75	110.0	29.0	9.0	7.0	56g	**-7033G**	**1575.00**

HSS 'Green Ring' Fluteless Taps

HSS-EV FLUTELESS

Lubrication grooves are a feature of all taps of M3.0 and over. Manufactured to **DIN 371/376**.

Suitable for the following Material Groups

Group	Materials	Brinell Hardness HB	Tensile Strength N/mm²	Tapping Speed M/min
6.1	Copper	-	up to 500	8 - 12
6.2	Brass (alpha - long chip)	-	up to 800	15 - 20

Group	Materials	Brinell Hardness HB	Tensile Strength N/mm²	Tapping Speed M/min
7.1	Unalloyed aluminium, magnesium and zinc	-	up to 150	20 - 30
7.2	Aluminium alloy less than 5% silicon magnesium & zinc alloys (long chip)	-	up to 1200	20 - 30

Fluteless - HSS-EV Bright Finish
For through and blind holes.
Taper lead to **DIN form B**
(3.5 x P to 5.5 x P).
Tapping tolerance to **6H**.

FLUTELESS FOR THROUGH AND BLIND HOLES

METRIC COARSE



Fluteless - HSS-EV (TiN Coated)
For through and blind holes.
Taper lead to **DIN form B**
(3.5 x P to 5.5 x P).
Tapping tolerance to **6H**.

FLUTELESS FOR THROUGH AND BLIND 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
M2.0 x 0.40	45.0	8.0	2.8	2.1	4g	**-7503G**	**1292.00**
M3.0 x 0.50	56.0	11.0	3.5	2.7	5g	**-7509G**	**1523.00**
M3.5 x 0.60	56.0	12.0	4.0	3.0	7g	**-7512G**	**1197.00**
M4.0 x 0.70	63.0	13.0	4.5	3.4	8g	**-7515G**	**1680.00**
M5.0 x 0.80	70.0	15.0	6.0	4.9	13g	**-7518G**	**998.00**
M6.0 x 1.00	80.0	17.0	6.0	4.9	17g	**-7521G**	**1019.00**
M8.0 x 1.25	90.0	20.0	8.0	6.2	32g	**-7527G**	**1281.00**

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	**-8003G**	**2993.00**
M3.0 x 0.50	56.0	11.0	3.5	2.7	5g	**-8009G**	**1344.00**
M4.0 x 0.70	63.0	13.0	4.5	3.4	8g	**-8015G**	**1470.00**
M5.0 x 0.80	70.0	15.0	6.0	4.9	13g	**-8018G**	**1922.00**
M6.0 x 1.00	80.0	17.0	6.0	4.9	17g	**-8021G**	**1943.00**
M8.0 x 1.25	90.0	20.0	8.0	6.2	32g	**-8027G**	**2562.00**
M10.0 x 1.50	100.0	22.0	10.0	8.0	58g	**-8030G**	**3045.00**

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