SYNCHRO TAP

TTS32 SERIES

MF ISO Metric Fine Threads DIN 13

Metrisches ISO-Feingewinde DIN 13
ISO MÉTRIQUE PAS FINS DIN13
ISO Metrico passo fine DIN 13

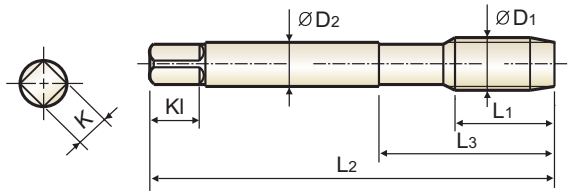
Machine taps
Maschinengewindebohrer

- Coated HSS-PM (Powder Metallurgy) Taps for high-speed tapping on rigid CNC machines or equivalent machines
- Up to 3 times faster in tapping compared to conventional taps
- For high-speed synchro tapping, synchro holder for increasing tool life and thread quality is recommended
- High precision threads

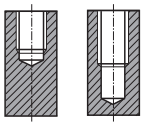
- Beschichtete HSS-PM-Gewindebohrer zum Hochgeschwindigkeitsgewindebohren auf starren CNC-Maschinen oder gleichwertige Maschinen
- Bis zu dreimal schnelleres Gewindeschneiden als bei herkömmlichen Gewindebohrern
- Beim Hochgeschwindigkeits-Gewindebohren wird die Verwendung eines Synchrofutters zur Erhöhung der Werkzeugstandzeit und der Gewindequalität empfohlen
- Hoch präzise Gewinde

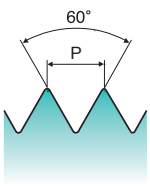
DIN 374

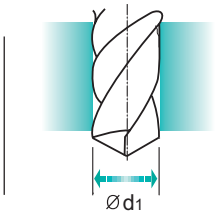




Hole type
2.5×D







Material groups **GS** | HSS PM | DIN 374 | 6HX | 60° | C | R45 | TiN

p.B74

Recommended ToolHolder: Plain Shank, SYNCHRO TAPPING CHUCK

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	TiN	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M8	× 1.0	**TTS32376**	10	90	36	6	4.9	8	3	7.0
M10	× 1.25	**TTS32436**	13	100	40	7	5.5	8	3	8.75
M10	× 1.0	**TTS32446**	10	90	40	7	5.5	8	3	9.0
M12	× 1.25	**TTS32526**	13	100	40	9	7	10	3	10.75
M12	× 1.5	**TTS32516**	15	100	40	9	7	10	3	10.5
M14	× 1.5	**TTS32556**	15	100	40	11	9	12	3	12.5
M16	× 1.5	**TTS32616**	15	100	40	12	9	12	3	14.5
M18	× 1.5	**TTS32676**	17	110	44	14	11	14	4	16.5
M20	× 1.5	**TTS32726**	17	125	50	16	12	15	4	18.5

- Coating (TiAlN) is available on your request.

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎		◎	◎					◎	◎	○	○		◎			

ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended			◎	◎	◎	◎		○													