

STRAIGHT FLUTED TAPS



ST - DIN **266**
ST - JIS **290**
ST - ANSI **336**

Selection Chart

Intro

SP

SL

PO

ST

ROLL

CARBIDE

LONG

HAND TAPS

EG (STI)

SPECIAL THREADS, GAUGES

THREAD MILLS

DIES

CENTER DRILLS

Technical info

| | | Z-PRO | | | | | | GP General Purpose | | | | | | | | | |
|-------------------------|--|------------|---------|---------|---------|-----------------|---------|--------------------|-------|-------|-------|-------|-------|-------|----|------|----|
| | | GGST | | GGST CH | | GGST CH E(1.5P) | | HT | | HT LH | | PF LH | | NPT | | NPTF | |
| | | HSS-E | COATING | HSS-E | COATING | HSS-E | COATING | HSS-E | HSS-E | HSS-E | HSS-E | HSS-E | HSS-E | HSS-E | OX | | |
| | | | | | | | | | | | | | | | | | |
| | | | | | | | | | | | | | | | | | |
| | | | | | | | | | | | | | | | | | |
| | | DIN | DIN | DIN | DIN | JIS | ANSI | JIS | JIS | ANSI | ANSI | | | | | | |
| M | | 267 | 269 | 271 | 273 | 291 | | 317 | | | | | | | | | |
| MF | | 267 | 269 | 271 | 273 | 295 | | 318 | | | | | | | | | |
| UNC/UNF | | | | | 273 | 308 | 337 | 323 | | | | | | | | | |
| UNS, 8, 12, 20, 32UN | | | | | | | | 312 | | | | | | | | | |
| UNEF | | | | | | | | 313 | | | | | | | | | |
| G (BSP) | | 267 | | | | | | | 325 | | | | | | | | |
| Rp (BSPP) | | | | | | | | | | | | | | | | | |
| Rc (BSPT) | | | | | | | | | | | | | | | | | |
| NPT | | | | | | | | | | 342 | | | | | | | |
| NPTF | | | | | | | | | | | | 343 | | | | | |
| NPSC, NPSP, NPSF | | | | | | | | | | | | | | | | | |
| BSW | | | | | | | | 314 | 324 | | | | | | | | |
| EG(STI), M, MF, UNC/UNF | | | | | | | | | | | | | | | | | |
| Pg | | | | | | | | | | | | | | | | | |
| Tr | | | | | | | | | | | | | | | | | |
| S miniature | | | | | | | | | | | | | | | | | |
| Special threads | | | | | | | | | | | | | | | | | |
| | | Vc (m/min) | | | | | | | | | | | | | | | |
| P1 | | | | | | | | ☆ | 5÷10 | ☆ | 5÷10 | ☆ | 5÷10 | ★ | ≤5 | ★ | ≤5 |
| P2 | | | | | | | | ★ | 5÷10 | ★ | 5÷10 | ★ | 5÷10 | ★ | ≤5 | ★ | ≤5 |
| P3 | | | | | | | | ☆ | 5÷10 | ☆ | 5÷10 | ☆ | 5÷10 | ☆ | ≤5 | ☆ | ≤5 |
| P4 | | | | | | | | ☆ | 5÷10 | ☆ | 5÷10 | ☆ | 5÷10 | ☆ | ≤5 | ☆ | ≤5 |
| P5 | | | | | | | | | | | | | | | | | |
| P6 | | | | | | | | | | | | | | | | | |
| P7 | | | | | | | | | | | | | | | | | |
| P8 | | | | | | | | | | | | | | | | | |
| M1 | | | | | | | | | | | | | | | | | |
| M2 | | | | | | | | | | | | | | | | | |
| M3 | | | | | | | | | | | | | | | | | |
| K1 | | ★ | 5÷20 | ★ | 10÷30 | ★ | 10÷30 | ☆ | 5÷10 | ☆ | 5÷10 | ☆ | 5÷10 | ☆ | ≤5 | | |
| K2 | | ★ | 5÷20 | ★ | 10÷30 | ★ | 10÷30 | ☆ | 5÷10 | ☆ | 5÷10 | ☆ | 5÷10 | ☆ | ≤5 | | |
| K3 | | ★ | ≤10 | ★ | ≤15 | ★ | ≤15 | ☆ | 5÷10 | ☆ | 5÷10 | | | | | | |
| K4 | | ☆ | ≤10 | ☆ | ≤10 | ☆ | ≤10 | | | | | | | | | | |
| N1 | | | | | | | | | | | | | | | | | |
| N2 | | ☆ | 10÷20 | ☆ | 10÷30 | ☆ | 10÷30 | ☆ | 5÷10 | ☆ | 5÷10 | ☆ | 5÷10 | ☆ | ≤5 | | |
| N3 | | | | | | | | ☆ | 5÷10 | ☆ | 5÷10 | ☆ | 5÷10 | | | | |
| N4 | | ★ | 10÷20 | ★ | 10÷30 | ★ | 10÷30 | ☆ | 5÷10 | ☆ | 5÷10 | ☆ | 5÷10 | ☆ | ≤5 | | |
| N5 | | | | | | | | | | | | | | | | | |
| S1 (<25 HRC) | | | | | | | | | | | | | | | | | |
| S2 (<35 HRC) | | | | | | | | | | | | | | | | | |
| S3 (35 ÷ 45 HRC) | | | | | | | | | | | | | | | | | |
| S5 | | | | | | | | | | | | | | | | | |
| H (45 ÷ 55 HRC) | | | | | | | | | | | | | | | | | |
| H (55 ÷ 63 HRC) | | | | | | | | | | | | | | | | | |

★ 1st choice ☆ suitable

| GP General Purpose | | | | MS Material Specific | | | | | | | | | | |
|--------------------|------|-------|------|----------------------|-------|-----------|--------|-------------------------|------------|-------|-------|-------|---------|------------------|
| NPS | | NPSF | | EH-HT | PMST | ZELX MOLD | SU-HT | GG-HT | GG-HT TiCN | | | | | |
| HSS-E | OX | HSS-E | OX | HSS-Co | HSS-P | OX | HSS-Co | HSS-E | OX | HSS-E | NI | HSS-E | COATING | |
| | | | | | | | | | | | | | | |
| | | | | | | | | | | | | | | |
| ANSI | ANSI | DIN | DIN | ANSI | JIS | DIN | DIN | | | | | | | |
| | | 277 | | | | 281 | 283 | M | | | | | | |
| | | 277 | | | | 281 | 283 | MF | | | | | | |
| | | | | 347 | 328 | | | UNC/UNF | | | | | | |
| | | | | | | | | UNS, 8, 12, 20, 32UN | | | | | | |
| | | | | | | | | UNEF | | | | | | |
| | | 277 | | | | 281 | 283 | G (BSP) | | | | | | |
| | | | | | | | | Rp (BSPP) | | | | | | |
| | | | | | 279 | | | Rc (BSPT) | | | | | | |
| | | | | | | | | NPT | | | | | | |
| | | | | | | | | NPTF | | | | | | |
| 344 | 345 | | | | | | | NPSC, NPSM, NPSF | | | | | | |
| | | | | | | | | BSW | | | | | | |
| | | | | | | | | EG(STI), M, MF, UNC/UNF | | | | | | |
| | | | | | | | | Pg | | | | | | |
| | | | | | | | | Tr | | | | | | |
| | | | | | | | | S miniature | | | | | | |
| | | | | | | | | Special threads | | | | | | |
| Vc (m/min) | | | | | | | | | | | | | | |
| ☆ | 5÷10 | ☆ | 5÷10 | | | | | | | | | | | P1 |
| ★ | 5÷10 | ★ | 5÷10 | | | | | ☆ | ≤5 | | | | | P2 |
| ☆ | ≤5 | ☆ | ≤5 | | ★ | ≤5 | | ☆ | ≤5 | | | | | P3 |
| ☆ | ≤5 | ☆ | ≤5 | | ★ | ≤5 | | ☆ | ≤5 | | | | | P4 |
| | | ★ | ≤5 | ★ | ≤5 | ★ | ≤5 | | | | | | | P5 |
| | | ★ | ≤5 | ★ | ≤5 | ★ | ≤5 | | | | | | | P6 |
| | | | | | | | | ★ | ≤5 | | | | | P7 |
| | | | | | | | | | | | | | | P8 |
| | | | | | | | | ★ | ≤5 | | | | | M1 |
| | | | | | | | | | | | | | | M2 |
| | | | | | | | | | | | | | | M3 |
| | | | | | | | | ★ | 5÷10 | ★ | 5÷20 | | | K1 |
| | | ☆ | ≤5 | | ☆ | ≤5 | | ★ | 5÷10 | ★ | 5÷20 | | | K2 |
| | | ☆ | ≤5 | | ☆ | ≤5 | | ★ | ≤5 | ★ | ≤10 | | | K3 |
| | | | | | | | | ☆ | ≤5 | ☆ | ≤10 | | | K4 |
| | | | | | | | | | | | | | | N1 |
| | | | | | | | | ☆ | 5÷15 | ☆ | 10÷20 | | | N2 |
| | | | | | | | | | | | | | | N3 |
| | | | | | | | | ★ | 5÷15 | ★ | 10÷20 | | | N4 |
| | | | | | | | | | | | | | | N5 |
| | | | | | | | | | | | | | | S1 (<25 HRC) |
| | | | | | | | | | | | | | | S2 (<35 HRC) |
| | | | | | | | | | | | | | | S3 (35 ÷ 45 HRC) |
| | | | | | | | | | | | | | | S5 |
| | | | | | | | | | | | | | | H (45 ÷ 55 HRC) |
| | | | | | | | | | | | | | | H (55 ÷ 63 HRC) |

Intro

SP

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ROLL

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LONG

HAND TAPS

EG (STI)

SPECIAL THREADS, GAUGES

THREAD MILLS

DIES

CENTER DRILLS

Technical info

Selection Chart

Intro

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HAND TAPS

EG (STI)








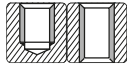
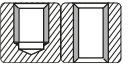
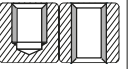

SPECIAL THREADS, GAUGES

THREAD MILLS

DIES

CENTER DRILLS

Technical info

| | | MS Material Specific | | | | | | | | | |
|-------------------------|---|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|------------------------------------------------------------------------------------|---------|-------|-------|------|--|
| | | GG-HT-OH TiCN | | LA-HT | | AXE-HT | | MG-HT | | PL1 | |
| | | HSS-E | COATING | HSS-E | NI | HSS-P | COATING | HSS-E | HSS-E | NI | |
| | |  |  |  |  |  | | | | | |
| | |  |  |  |  |  | | | | | |
| | |  | | | | | | | | | |
| | | DIN | DIN | JIS | DIN | JIS | JIS | | | | |
| M | | 285 | 287 | 331 | 289 | 333 | 335 | | | | |
| MF | | 285 | | 331 | 289 | | | | | | |
| UNC/UNF | | | | | | | | | | | |
| UNS, 8, 12, 20, 32UN | | | | | | | | | | | |
| UNEF | | | | | | | | | | | |
| G (BSP) | | | | | | | | | | | |
| Rp (BSPP) | | | | | | | | | | | |
| Rc (BSPT) | | | | | | | | | | | |
| NPT | | | | | | | | | | | |
| NPTF | | | | | | | | | | | |
| NPSC, NPSP, NPSF | | | | | | | | | | | |
| BSW | | | | | | | | | | | |
| EG(STI), M, MF, UNC/UNF | | | | | | | | | | | |
| Pg | | | | | | | | | | | |
| Tr | | | | | | | | | | | |
| S miniature | | | | | | | | | | | |
| Special threads | | | | | | | | | | | |
| | | Vc (m/min) | | | | | | | | | |
| P1 | | | | | | | | | | | |
| P2 | | | | | | | | | | | |
| P3 | | | | | | | | | | | |
| P4 | | | | | | | | | | | |
| P5 | | | | | | | | | | | |
| P6 | | | | | | | | | | | |
| P7 | | | | | | | | | | | |
| P8 | | | | | | | | | | | |
| M1 | | | | | | | | | | | |
| M2 | | | | | | | | | | | |
| M3 | | | | | | | | | | | |
| K1 | ★ | 10÷30 | | | ☆ | 10÷20 | | | | | |
| K2 | ★ | 10÷30 | | | | | | | | | |
| K3 | ★ | ≤15 | | | | | | | | | |
| K4 | ☆ | ≤10 | | | | | | | | | |
| N1 | | | ★ | 5÷15 | ☆ | 10÷20 | ★ | 5÷15 | | | |
| N2 | ☆ | 10÷30 | ★ | 5÷15 | ★ | 10÷20 | ★ | 5÷15 | | | |
| N3 | | | ★ | 5÷10 | | | | | | | |
| N4 | ★ | 10÷30 | ★ | 5÷10 | ★ | 10÷20 | | | | | |
| N5 | | | | | | | | | ★ | 5÷10 | |
| S1 (<25 HRC) | | | | | | | | | | | |
| S2 (<35 HRC) | | | | | | | | | | | |
| S3 (35 ÷ 45 HRC) | | | | | | | | | | | |
| S5 | | | | | | | | | | | |
| H (45 ÷ 55 HRC) | | | | | | | | | | | |
| H (55 ÷ 63 HRC) | | | | | | | | | | | |

★ 1st choice ☆ suitable

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TAPS

EG (STI)

SPECIAL
THREADS,
GAUGES

THREAD
MILLS

DIES

CENTER
DRILLS

Technical
info

Intro

GGST

Z-PRO Series

SP Straight Fluted Taps for Cast Iron, Coated

SL



PO

Recommended Tapping Speeds Depending On Materials

| ISO | Vc (m/min) | ISO | Vc (m/min) |
|-----|------------|-----|------------|
| K1 | 5÷20 ★ | N2 | 10÷20 ☆ |
| K2 | 5÷20 ★ | N4 | 10÷20 ★ |
| K3 | ≤10 ★ | | |
| K4 | ≤10 ☆ | | |

★ 1st choice ☆ suitable

ST

DIN

ROLL

CARBIDE

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HAND TAPS

EG (STI)

SPECIAL THREADS, GAUGES

THREAD MILLS

DIES

CENTER DRILLS

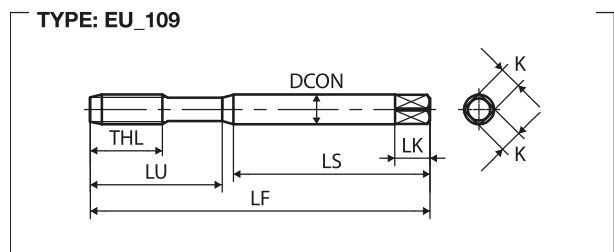
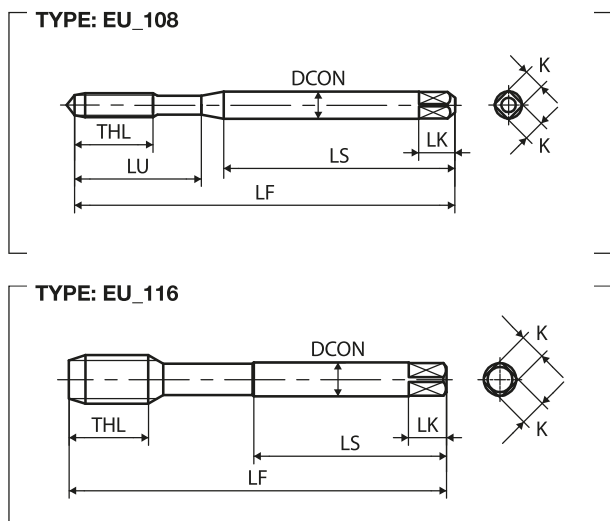
Technical info




FEATURES

Material specific for blind and through hole application.
 Specific design for best performance on cast iron application.
 Special coating allows stable and long life even at high speed.

Availability related to GG-HT TiCN stock exhaustion



| M | TCTR (tolerance) |  Hole Ø (mm) | Hole Ø (mm) | Code | THCHT (chamfer) | LF (mm) | THL (mm) | LU (mm) | LS (mm) | DCON (mm) | K (mm) | LK (mm) | NOF | Type | Stock |
|----------|---------------------|--------------------------------------------------------------------------------------------------|----------------|------------|--------------------|------------|-------------|------------|------------|--------------|-----------|------------|-----|------|-------|
| DIN 371 | | | | | | | | | | | | | | | |
| M3X0.5 | ISO2X(6HX) | 2.5 | 2.56 | 3104101035 | 2.5P | 56 | 9 | 18 | 34 | 3.5 | 2.7 | 6 | 3 | 108 | ○ |
| M4X0.7 | ISO2X(6HX) | 3.3 | 3.38 | 3104101042 | 2.5P | 63 | 13 | 21 | 38 | 4.5 | 3.4 | 6 | 4 | 108 | ● |
| M5X0.8 | ISO2X(6HX) | 4.2 | 4.28 | 3104101049 | 2.5P | 70 | 14 | 25 | 39 | 6 | 4.9 | 8 | 4 | 108 | ● |
| M6X1 | ISO2X(6HX) | 5 | 5.09 | 3104101055 | 2.5P | 80 | 15 | 30 | 45 | 6 | 4.9 | 8 | 4 | 108 | ● |
| M8X1.25 | ISO2X(6HX) | 6.8 | 6.85 | 3104101064 | 2.5P | 90 | 19 | 35 | 47 | 8 | 6.2 | 9 | 4 | 109 | ● |
| M10X1.5 | ISO2X(6HX) | 8.5 | 8.6 | 3104101078 | 2.5P | 100 | 23 | 39 | 52 | 10 | 8 | 11 | 4 | 109 | ● |
| DIN 376 | | | | | | | | | | | | | | | |
| M12X1.75 | ISO2X(6HX) | 10.3 | 10.36 | 3104101088 | 2.5P | 110 | 26 | - | 56 | 9 | 7 | 10 | 4 | 116 | ● |
| M14X2 | ISO2X(6HX) | 12 | 12.12 | 3104101100 | 2.5P | 110 | 26 | - | 56 | 11 | 9 | 12 | 4 | 116 | ● |
| M16X2 | ISO2X(6HX) | 14 | 14.12 | 3104101114 | 2.5P | 110 | 26 | - | 56 | 12 | 9 | 12 | 4 | 116 | ● |
| M18X2.5 | ISO2X(6HX) | 15.5 | 15.63 | 3104101128 | 2.5P | 125 | 33 | - | 64 | 14 | 11 | 14 | 4 | 116 | ● |
| M20X2.5 | ISO2X(6HX) | 17.5 | 17.63 | 3104101141 | 2.5P | 140 | 33 | - | 71 | 16 | 12 | 15 | 4 | 116 | ● |
| M22X2.5 | ISO2X(6HX) | 19.5 | 19.63 | 3104101156 | 2.5P | 140 | 33 | - | 71 | 18 | 14.5 | 17 | 4 | 116 | ● |
| M24X3 | ISO2X(6HX) | 21 | 21.13 | 3104101167 | 2.5P | 160 | 37 | - | 82 | 18 | 14.5 | 17 | 4 | 116 | ● |
| DIN 374 | | | | | | | | | | | | | | | |
| M8X1 | ISO2X(6HX) | 7 | 7.09 | 3104101065 | 2.5P | 90 | 19 | - | 46 | 6 | 4.9 | 8 | 4 | 116 | ● |
| M10X1.25 | ISO2X(6HX) | 8.8 | 8.85 | 3104101079 | 2.5P | 100 | 23 | - | 51 | 7 | 5.5 | 8 | 4 | 116 | ● |
| M10X1 | ISO2X(6HX) | 9 | 9.09 | 3104101080 | 2.5P | 90 | 19 | - | 46 | 7 | 5.5 | 8 | 4 | 116 | ● |
| M12X1.5 | ISO2X(6HX) | 10.5 | 10.6 | 3104101089 | 2.5P | 100 | 21 | - | 51 | 9 | 7 | 10 | 4 | 116 | ● |
| M12X1.25 | ISO2X(6HX) | 10.8 | 10.85 | 3104101090 | 2.5P | 100 | 21 | - | 51 | 9 | 7 | 10 | 4 | 116 | ● |
| M12X1 | ISO2X(6HX) | 11 | 11.09 | 3104101091 | 2.5P | 100 | 21 | - | 51 | 9 | 7 | 10 | 4 | 116 | ○ |
| M14X1.5 | ISO2X(6HX) | 12.5 | 12.6 | 3104101102 | 2.5P | 100 | 21 | - | 51 | 11 | 9 | 12 | 4 | 116 | ● |
| M16X1.5 | ISO2X(6HX) | 14.5 | 14.6 | 3104101116 | 2.5P | 100 | 21 | - | 51 | 12 | 9 | 12 | 4 | 116 | ● |
| M18X1.5 | ISO2X(6HX) | 16.5 | 16.6 | 3104101130 | 2.5P | 110 | 24 | - | 56 | 14 | 11 | 14 | 4 | 116 | ● |
| M20X1.5 | ISO2X(6HX) | 18.5 | 18.6 | 3104101144 | 2.5P | 125 | 24 | - | 64 | 16 | 12 | 15 | 4 | 116 | ● |
| M22X1.5 | ISO2X(6HX) | 20.5 | 20.6 | 3104101158 | 2.5P | 125 | 24 | - | 64 | 18 | 14.5 | 17 | 4 | 116 | ● |
| M24X1.5 | ISO2X(6HX) | 22.5 | 22.6 | 3104101170 | 2.5P | 140 | 27 | - | 71 | 18 | 14.5 | 17 | 4 | 116 | ● |
| DIN 5156 | | | | | | | | | | | | | | | |
| 1/8-28 | - | 8.75 | 8.78 | 3104130004 | 2.5P | 9.728 | 90 | 19 | 46 | 7 | 5.5 | 8 | 4 | 116 | ● |
| 1/4-19 | - | 11.75 | 11.78 | 3104130006 | 2.5P | 13.157 | 100 | 21 | 51 | 11 | 9 | 12 | 4 | 116 | ● |
| 3/8-19 | - | 15.25 | 15.28 | 3104130008 | 2.5P | 16.662 | 100 | 21 | 51 | 12 | 9 | 12 | 4 | 116 | ● |
| 1/2-14 | - | 19 | 19.04 | 3104130009 | 2.5P | 20.955 | 125 | 24 | 64 | 16 | 12 | 15 | 4 | 116 | ● |
| 3/4-14 | - | 24.5 | 24.52 | 3104130011 | 2.5P | 26.441 | 140 | 27 | 71 | 20 | 16 | 19 | 4 | 116 | ○ |
| 1-11 | - | 30.75 | 30.77 | 3104130013 | 2.5P | 33.249 | 160 | 29 | 82 | 25 | 20 | 23 | 4 | 116 | ○ |

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TAPS

EG (STI)

SPECIAL
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MILLS

DIES

CENTER
DRILLSTechnical
info

Intro

GGST CH



SP

Z-PRO Series

Straight Fluted Taps for Cast Iron with Axial Coolant Hole, Coated

SL



PO

Recommended Tapping Speeds Depending On Materials

| ISO | Vc (m/min) | ISO | Vc (m/min) |
|-----|------------|-----|------------|
| K1 | 10÷30 ★ | N2 | 10÷30 ☆ |
| K2 | 10÷30 ★ | N4 | 10÷30 ★ |
| K3 | ≤15 ★ | | |
| K4 | ≤10 ☆ | | |

★ 1st choice ☆ suitable

ST

DIN

ROLL

CARBIDE

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HAND TAPS

EG (STI)

SPECIAL THREADS, GAUGES

THREAD MILLS

DIES

CENTER DRILLS

Technical info

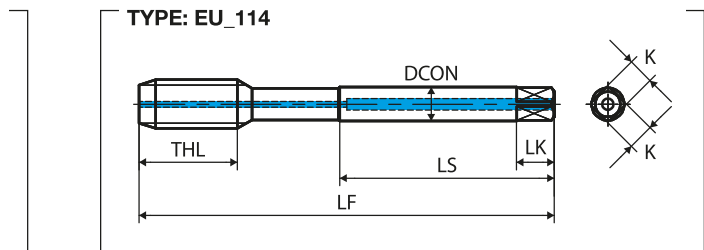
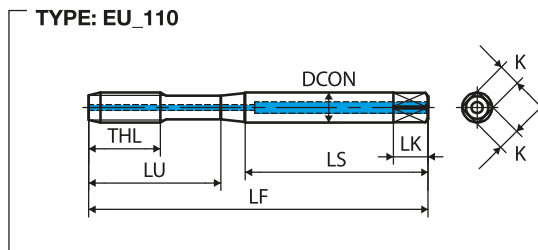
FEATURES


Material specific with axial oil hole for blind hole application.

Specific design for best performance on cast iron application.

Special coating allows stable and long life even at high speed.

Availability related to GG-HT-OH TiCN stock exhaustion



| M | TCTR (tolerance) |  Hole Ø (mm) | Hole Ø (mm) | Code | THCHT (chamfer) | LF (mm) | THL (mm) | LU (mm) | LS (mm) | DCON (mm) | K (mm) | LK (mm) | NOF | Type | Stock |
|----------|---------------------|--------------------------------------------------------------------------------------------------|----------------|------------|--------------------|------------|-------------|------------|------------|--------------|-----------|------------|-----|------|-------|
| DIN 371 | | | | | | | | | | | | | | | |
| M6X1 | ISO2X(6HX) | 5 | 5.09 | 3205101055 | 2.5P | 80 | 15 | 30 | 45 | 6 | 4.9 | 8 | 4 | 110 | ● |
| M8X1.25 | ISO2X(6HX) | 6.8 | 6.85 | 3205101064 | 2.5P | 90 | 19 | 35 | 47 | 8 | 6.2 | 9 | 4 | 110 | ● |
| M10X1.5 | ISO2X(6HX) | 8.5 | 8.6 | 3205101078 | 2.5P | 100 | 23 | 39 | 52 | 10 | 8 | 11 | 4 | 110 | ● |
| DIN 376 | | | | | | | | | | | | | | | |
| M12X1.75 | ISO2X(6HX) | 10.3 | 10.36 | 3205101088 | 2.5P | 110 | 26 | - | 56 | 9 | 7 | 10 | 4 | 114 | ● |
| M14X2 | ISO2X(6HX) | 12 | 12.12 | 3205101100 | 2.5P | 110 | 26 | - | 56 | 11 | 9 | 12 | 4 | 114 | ● |
| M16X2 | ISO2X(6HX) | 14 | 14.12 | 3205101114 | 2.5P | 110 | 26 | - | 56 | 12 | 9 | 12 | 4 | 114 | ● |
| M18X2.5 | ISO2X(6HX) | 15.5 | 15.63 | 3205101128 | 2.5P | 125 | 33 | - | 64 | 14 | 11 | 14 | 4 | 114 | ○ |
| M20X2.5 | ISO2X(6HX) | 17.5 | 17.63 | 3205101141 | 2.5P | 140 | 33 | - | 71 | 16 | 12 | 15 | 4 | 114 | ● |
| DIN 374 | | | | | | | | | | | | | | | |
| M8X1 | ISO2X(6HX) | 7 | 7.09 | 3205101065 | 2.5P | 90 | 19 | - | 46 | 6 | 4.9 | 8 | 4 | 114 | ● |
| M10X1.25 | ISO2X(6HX) | 8.8 | 8.85 | 3205101079 | 2.5P | 100 | 23 | - | 51 | 7 | 5.5 | 8 | 4 | 114 | ● |
| M10X1 | ISO2X(6HX) | 9 | 9.09 | 3205101080 | 2.5P | 90 | 19 | - | 46 | 7 | 5.5 | 8 | 4 | 114 | ● |
| M12X1.5 | ISO2X(6HX) | 10.5 | 10.6 | 3205101089 | 2.5P | 100 | 21 | - | 51 | 9 | 7 | 10 | 4 | 114 | ● |
| M12X1.25 | ISO2X(6HX) | 10.8 | 10.85 | 3205101090 | 2.5P | 100 | 21 | - | 51 | 9 | 7 | 10 | 4 | 114 | ● |
| M14X1.5 | ISO2X(6HX) | 12.5 | 12.6 | 3205101102 | 2.5P | 100 | 21 | - | 51 | 11 | 9 | 12 | 4 | 114 | ● |
| M16X1.5 | ISO2X(6HX) | 14.5 | 14.6 | 3205101116 | 2.5P | 100 | 21 | - | 51 | 12 | 9 | 12 | 4 | 114 | ● |
| M18X1.5 | ISO2X(6HX) | 16.5 | 16.6 | 3205101130 | 2.5P | 110 | 24 | - | 56 | 14 | 11 | 14 | 4 | 114 | ● |
| M20X1.5 | ISO2X(6HX) | 18.5 | 18.6 | 3205101144 | 2.5P | 125 | 24 | - | 64 | 16 | 12 | 15 | 4 | 114 | ● |

Intro

SP

SL

PO

ST

DIN

ROLL

CARBIDE

LONG

HAND
TAPS

EG (STI)

SPECIAL
THREADS,
GAUGESTHREAD
MILLS

DIES

CENTER
DRILLSTechnical
info

Intro

GGST CH E(1.5P)



Z-PRO Series

SP Straight Fluted Taps 1.5P, for Cast Iron with Axial Coolant Hole, Coated

SL



PO

Recommended Tapping Speeds Depending On Materials

| ISO | Vc (m/min) | ISO | Vc (m/min) |
|-----|------------|-----|------------|
| K1 | 10÷30 ★ | N2 | 10÷30 ☆ |
| K2 | 10÷30 ★ | N4 | 10÷30 ★ |
| K3 | ≤15 ★ | | |
| K4 | ≤10 ☆ | | |

ST

DIN

★ 1st choice ☆ suitable

ROLL

CARBIDE

LONG

HAND TAPS

EG (STI)

SPECIAL THREADS, GAUGES

THREAD MILLS

DIES

CENTER DRILLS

Technical info

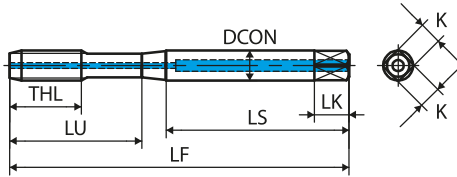
FEATURES

Material specific with axial oil hole and extra short chamfer (1.5P) for blind hole application.

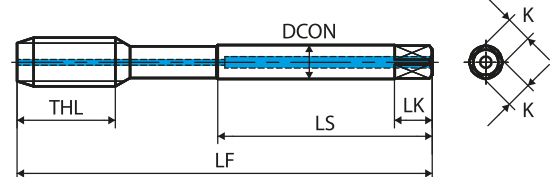
Specific design for best performance on cast iron application.


Special coating allows stable and long life even at higher speed.

TYPE: EU_110



TYPE: EU_114



| M | TCTR (tolerance) |  Hole Ø (mm) | Hole Ø (mm) | Code | THCHT (chamfer) | LF (mm) | THL (mm) | LU (mm) | LS (mm) | DCON (mm) | K (mm) | LK (mm) | NOF | Type | Stock |
|-----------------|---------------------|--------------------------------------------------------------------------------------------------|----------------|------------|--------------------|------------|-------------|------------|------------|--------------|-----------|------------|-----|------|-------|
| DIN 371 | | | | | | | | | | | | | | | |
| M6X1 | ISO2X(6HX) | 5 | 5.09 | 3206101055 | 1.5P | 80 | 15 | 30 | 45 | 6 | 4.9 | 8 | 4 | 110 | ● |
| M7x1 | ISO2X(6HX) | 6 | 6.09 | 3206101060 | 1.5P | 80 | 15 | 30 | 45 | 7 | 5.5 | 8 | 4 | 110 | ○ |
| M8X1.25 | ISO2X(6HX) | 6.8 | 6.85 | 3206101064 | 1.5P | 90 | 19 | 35 | 47 | 8 | 6.2 | 9 | 4 | 110 | ● |
| M10X1.5 | ISO2X(6HX) | 8.5 | 8.6 | 3206101078 | 1.5P | 100 | 23 | 39 | 52 | 10 | 8 | 11 | 4 | 110 | ● |
| DIN 376 | | | | | | | | | | | | | | | |
| M12X1.75 | ISO2X(6HX) | 10.3 | 10.36 | 3206101088 | 1.5P | 110 | 26 | - | 56 | 9 | 7 | 10 | 4 | 114 | ● |
| M14X2 | ISO2X(6HX) | 12 | 12.12 | 3206101100 | 1.5P | 110 | 26 | - | 56 | 11 | 9 | 12 | 4 | 114 | ○ |
| M16X2 | ISO2X(6HX) | 14 | 14.12 | 3206101114 | 1.5P | 110 | 26 | - | 56 | 12 | 9 | 12 | 4 | 114 | ○ |
| DIN 374 | | | | | | | | | | | | | | | |
| M10X1.25 | ISO2X(6HX) | 8.8 | 8.85 | 3206101079 | 1.5P | 100 | 23 | - | 51 | 7 | 5.5 | 8 | 4 | 114 | ○ |
| M10X1 | ISO2X(6HX) | 9 | 9.09 | 3206101080 | 1.5P | 90 | 19 | - | 46 | 7 | 5.5 | 8 | 4 | 114 | ○ |
| M12X1.5 | ISO2X(6HX) | 10.5 | 10.6 | 3206101089 | 1.5P | 100 | 21 | - | 51 | 9 | 7 | 10 | 4 | 114 | ● |
| M12X1.25 | ISO2X(6HX) | 10.8 | 10.85 | 3206101090 | 1.5P | 100 | 21 | - | 51 | 9 | 7 | 10 | 4 | 114 | ○ |
| M14X1.5 | ISO2X(6HX) | 12.5 | 12.6 | 3206101102 | 1.5P | 100 | 21 | - | 51 | 11 | 9 | 12 | 4 | 114 | ○ |
| M16X1.5 | ISO2X(6HX) | 14.5 | 14.6 | 3206101116 | 1.5P | 100 | 21 | - | 51 | 12 | 9 | 12 | 4 | 114 | ○ |

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