

2.36 M - ISO Metric Coarse Thread DIN 13

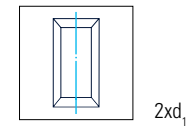
SCHUMACHER

Machine Taps Black Ring

DIN 371 HSS-E

Spiral point
for universal use

Group 3190
for through holes



31900/26	41900/25
High Volume 	High Volume 
Black Ring	Black Ring
B / 3,5-5 x P	B / 3,5-5 x P
VAP	TiN
ISO2 (6H) ISO1 (4H)	ISO2 (6H)
P1 general construction steel	M1 chemical resistant steel
N1 aluminium alloys	N3 copper alloys

[illegible]

Continuation »

■ available – intermediate size on request

2.37 M - ISO Metric Coarse Thread DIN 13

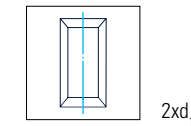
SCHUMACHER

Machine Taps Black Ring

DIN 371 HSS-E

Spiral point
for universal use

Group 3190
for through holes



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The technical drawing shows a side view of a turning tool holder. It has a long central section with diameter d_2 and length L . At one end, there is a shorter section with diameter d_1 and length L_2 .

	31900/26	41900/25
High Volume ⓘ		
Black Ring		
B / 3,5-5 x P		
VAP		TiN
ISO2 (6H)		
P1 general construction steel	M1 chemical resistant steel	N1 aluminium alloys N3 copper alloys

[illegible]

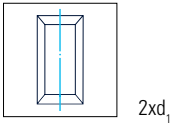
■ available – intermediate size on request

2.38 M - ISO Metric Coarse Thread DIN 13

Machine Taps Black Ring

DIN 376 HSS-E
Spiral point
for universal use

Group 4190
for through holes



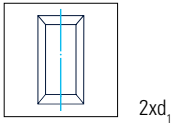
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41900/26 High Volume							31900/5760 PM-Line						
Black Ring							Black Ring						
B / 3,5-5 x P							B / 3,5-5 x P						
VAP							SG 4						
ISO2 (6H)							ISO2 (6H)						
P1 general construction steel							P1 general construction steel						
M1 chemical resistant steel							M1 chemical resistant steel						
N1 aluminium alloys							N1 Aluminium						
N3 copper alloys							N3 copper alloys						
Ø d ₁	P _{mm}	L ₁	L ₂	d ₂			Ø d ₁	P _{mm}	L ₁	L ₂	d ₂		
M 6	1	80	17	4.5	3.4	5.0	M 1.7	0.35	40	8	2.5	2.1	1.35
M 7	1	80	17	5.5	4.3	6.0	M 1.8	0.35	40	8	2.5	2.1	1.45
M 8	1.25	90	20	6	4.9	6.8	M 2	0.4	45	8	2.8	2.1	1.6
M 9	1.25	90	20	7	5.5	7.8	M 2.2	0.45	45	8	2.8	2.1	1.75
M 10	1.5	100	22	7	5.5	8.5	M 2.3	0.4	45	8	2.8	2.1	1.9
M 12	1.75	110	24	9	7	10.2	M 2.5	0.45	50	9	2.8	2.1	2.05
M 14	2	110	26	11	9	12.0	M 2.6	0.45	50	9	2.8	2.1	2.15
M 16	2	110	27	12	9	14.0	M 3	0.5	56	11	3.5	2.7	2.5
M 18	2.5	125	30	14	11	15.5	M 3.5	0.6	56	12	4	3	2.9
M 20	2.5	140	32	16	12	17.5	M 4	0.7	63	13	4.5	3.4	3.3
M 22	2.5	140	32	18	14.5	19.5	M 5	0.8	70	15	6	4.9	4.2
M 24	3	160	34	18	14.5	21.0	M 6	1	80	17	6	4.9	5.0
M 27	3	160	36	20	16	24.0	M 7	1	80	17	7	5.5	6.0
M 30	3.5	180	40	22	18	26.5	M 8	1.25	90	20	8	6.2	6.8
M 33	3.5	180	40	25	20	29.5	M 9	1.25	90	20	9	7	7.8
M 36	4	200	50	28	22	32.0	M 10	1.5	100	22	10	8	8.5

2.39 M - ISO Metric Coarse Thread DIN 13

Machine Taps Black Ring

DIN 371 HSS-E-PM
Spiral point
for universal use

Group 3190
for through holes

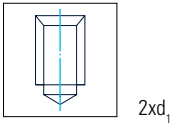


2.58 M - ISO Metric Coarse Thread DIN 13

Machine Taps - NUMERIC

DIN 376 HSS-E PM
RH spiral flutes 45°
for steel

Group 4303
for blind holes



High Speed Cutting
by Schumacher



NUMERIC
Supporting Digital Production
For use on CNC machines
with synchronized machining

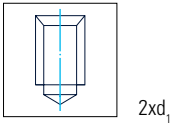
SCHUMACHER

2.59 M - ISO Metric Coarse Thread DIN 13

Machine Taps Black Ring

DIN 371 HSS-E
RH spiral flutes 40°
for universal use

Group 3330
for blind holes



SCHUMACHER

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43030/48 PM-Line							33300/26 High Volume						
C / 2-3 x P							Black Ring						
TiCN							C / 2-3 x P						
6HX							VAP						
P1 general construction steel P2 high strength steel M1 chemical resistant steeltant steel							TiN						
ISO01 (4H) ISO2 (6H)							ISO2 (6H)						
P1 general construction steel M1 chemical resistant steel N1 aluminium alloys N3 copper alloys													
Ø d ₁	P _{mm}	L ₁	L ₂	d ₂			Ø d ₁	P _{mm}	L ₁	L ₂	d ₂		
M 6	1	80	10	4.5	3.4	5.0	M 1	0.25	40	5.5	2.5	2.1	0.75
M 7	1	80	10	5.5	4.3	6.0	M 1.2	0.25	40	5.5	2.5	2.1	0.95
M 8	1.25	90	14	6	4.9	6.8	M 1.4	0.3	40	7	2.5	2.1	1.1
M 9	1.25	90	14	7	5.5	7.8	M 1.6	0.35	40	8	2.5	2.1	1.25
M 10	1.5	100	16	7	5.5	8.5	M 1.7	0.35	40	8	2.5	2.1	1.35
M 12	1.75	110	18	9	7	10.2	M 1.8	0.35	40	8	2.5	2.1	1.45
M 14	2	110	20	11	9	12.0	M 2	0.4	45	8	2.8	2.1	1.6
M 16	2	110	20	12	9	14.0	M 2.2	0.45	45	8	2.8	2.1	1.75
M 18	2.5	125	25	14	11	15.5	M 2.3	0.4	45	8	2.8	2.1	1.9
M 20	2.5	140	25	16	12	17.5	M 2.5	0.45	50	9	2.8	2.1	2.05
M 22	2.5	140	25	18	14.5	19.5	M 2.6	0.45	50	9	2.8	2.1	2.15
M 24	3	160	30	18	14.5	21.0							
M 27	3	160	30	20	16	24.0							
M 30	3.5	180	35	22	18	26.5							
M 33	3.5	180	35	25	20	29.5							
M 36	4	200	40	28	22	32.0							

■ available – intermediate size on request

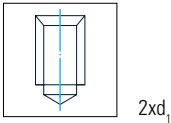
■ available – intermediate size on request

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Machine Taps Black Ring

DIN 371 HSS-E
RH spiral flutes 40°
for universal use

Group 3330
for blind holes



Art.-No.							Art.-No.						
Technology Page 8.1							Technology Page 8.1						
Chamfer Length Page 8.4							Chamfer Length Page 8.4						
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33300/26 High Volume							43300/26 High Volume						
Black Ring							Black Ring						
C / 2-3 x P							C / 2-3 x P						
VAP							TiN						
ISO2 (6H)							ISO2 (6H)						
P1 general construction steel							M1 chemical resistant steel						
							N1 aluminium alloys						
							N3 copper alloys						
Ø d ₁	P _{mm}	L ₁	L ₂	d ₂			Ø d ₁	P _{mm}	L ₁	L ₂	d ₂		
M 1.7	0.35	40	8	2.5	2.1	1.35	M 6	1	80	10	4.5	3.4	5.0
M 1.8	0.35	40	8	2.5	2.1	1.45	M 7	1	80	10	5.5	4.3	6.0
M 2	0.4	45	8	2.8	2.1	1.6	M 8	1.25	90	14	6	4.9	6.8
M 2.2	0.45	45	8	2.8	2.1	1.75	M 9	1.25	90	14	7	5.5	7.8
M 2.3	0.4	45	8	2.8	2.1	1.9	M 10	1.5	100	16	7	5.5	8.5
M 2.5	0.45	50	9	2.8	2.1	2.05	M 12	1.75	110	18	9	7	10.2
M 2.6	0.45	50	9	2.8	2.1	2.15	M 14	2	110	20	11	9	12.0
M 3	0.5	56	6	3.5	2.7	2.5	M 16	2	110	20	12	9	14.0
M 3.5	0.6	56	7	4	3	2.9	M 18	2.5	125	25	14	11	15.5
M 4	0.7	63	7	4.5	3.4	3.3	M 20	2.5	140	25	16	12	17.5
M 5	0.8	70	8	6	4.9	4.2	M 22	2.5	140	25	18	14.5	19.5
M 6	1	80	10	6	4.9	5.0	M 24	3	160	30	18	14.5	21.0
M 7	1	80	10	7	5.5	6.0	M 27	3	160	30	20	16	24.0
M 8	1.25	90	13	8	6.2	6.8	M 30	3.5	180	35	22	18	26.5
M 9	1.25	90	13	9	7	7.8	M 33	3.5	180	35	25	20	29.5
M 10	1.5	100	15	10	8	8.5	M 36	4	200	40	28	22	32.0

Machine Taps Black Ring

DIN 376 HSS-E
RH spiral flutes 40°
for universal use

Group 4330
for blind holes

