DORMER PRAMET

DIN ANSI SHARK LINE

MATERIAL SPECIFIC APPLICATION TAPS

2020

DORMER

SHARK LINE

SHARK

MATERIAL SPECIFIC APPLICATION TAPS

Our material specific application-based range of DIN ANSI Shark Taps offer high performance and process security. This range has been expanded with two new tap designs for high strength steels above 1200 N/mm² and titanium alloys.

FEATURES AND BENEFITS

COLOR RING CODING

- The color ring on the tool shank identifies suitability for specific materials and enables **quick and easy tool selection**.

NEW

ROBUST GEOMETRY (Black Shark)

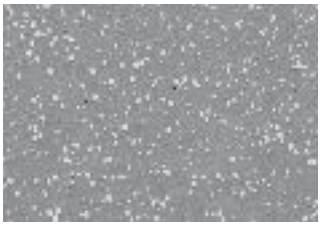
- Significant increase of cutting edge strength. This ensures **problem-free threading** of up to 2.5×D through holes (1.5×D blind holes) in high strength and heat resistant work-materials with hardness up to 45 HRC.

EDGE TREATMENT (Black, Red, Yellow, Blue Shark)

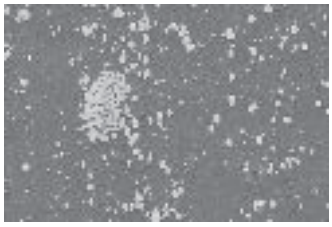
- Spiral flute taps incorporate a special edge treatment to increase strength and reduce the chance of micro-chipping on the cutting edges. This considerably improves **performance and tool life**.

MATERIAL

Shark taps are manufactured from a unique powder metallurgy tool steel different from any other HSS-E-PM. This provides an unbeatable combination of toughness and edge strength, allowing the taps to perform at higher cutting temperatures while offering excellent performance and longer tool life.



Unique HSS-E-PM material used for **SHARK TAPS** (note the evenly dispersed grain structure)



Traditional HSS-E (M35) material

GEOMETRY AND CHAMFER

The **E816, E817, E916, E917** taps feature a spiral point.
This supports:

- Process security
- Superior surface finish
- Highly accurate threads
- Through hole threading up to **2.5×D**

NEW

The **E805, E806, E905, E906** taps feature a spiral flute with constant rake angle. It has a balanced higher relief on the chamfer (cutting threads) and lower relief on the guidance threads. This supports:

- Process security
- Superior surface finish
- Highly accurate threads
- Blind hole threading up to **1.5×D**

NEW

SHARK LINE

SHARK

MATERIAL SPECIFIC APPLICATION TAPS

STRUCTURAL, PLAIN CARBON & LOW ALLOW STEELS

YELLOW SHARK

- **SURFACE TREATMENT**
  TiAlN-Top coating with an additional edge treatment.
- **FLUTE GEOMETRY**
  Available in spiral point for through holes and spiral flute (40° angle) for blind holes. Special flute geometry on Yellow Shark spiral flute taps prevents nest formation of chips, reducing the risk of re-cutting chips on reversal.
- **THREAD FORMS**
  UNC, UNF, Metric and Metric Fine
- **PRODUCT CODES**
  E624, E625, E764, E765, E808, E809, E908, E909

STAINLESS STEELS

BLUE SHARK

- **SURFACE TREATMENT**
  Super-B (TiAlN + WC/C) coated with an additional edge treatment.
- **FLUTE GEOMETRY**
  Available in spiral point for through holes and spiral flute (40° angle) for blind holes.
- **BACK TAPERED**
  Back taper on spiral flute taps further facilitates chip evacuation, reducing chipping on the last threads of the taps and also reducing torque when the tap reverses.
- **THREAD FORMS**
  UNC, UNF, Metric and Metric Fine
- **PRODUCT CODES**
  E628, E629, E768, E769, E812, E813, E912, E913

SHARK

MATERIAL SPECIFIC APPLICATION TAPS

ALLOY STEELS

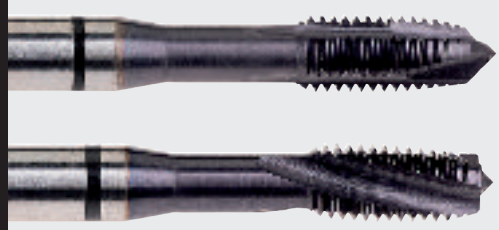
RED SHARK

- **SURFACE TREATMENT**
  TiAlN-Top coated with an additional edge treatment.
- **FLUTE GEOMETRY**
  Available in spiral point for through holes and spiral flute (45° angle) for blind holes.
- **BACK TAPERED**
  Back taper on spiral flute taps further facilitates chip evacuation, reducing chipping on the last threads of the taps and also reducing torque when the tap reverses.
- **CUTTING GEOMETRY (SPIRAL FLUTE TAPS)**
  The special three-radii profile with a constant rake angle along the flute length leads to better control of cutting properties and prevents nest formation of chips.
- **TAPPING ATTACHMENT (RECOMMENDATION)**
  When using spiral flute Red Shark taps, it is recommended to use a tool holder with minimal float or soft start.
- **THREAD FORMS**
  UNC, UNF, Metric and Metric Fine
- **PRODUCT CODES**
  E626, E627, E766, E767, E810, E811, E910, E911

HIGH STRENGTH STEELS

NEW

BLACK SHARK



- **SURFACE TREATMENT**
  TiAlN-Top coating with an additional edge treatment.
- **FLUTE GEOMETRY**
  Spiral point or low helix spiral flute geometries with low rake angle for good chip control and edge strength.
- **CUTTING GEOMETRY (SPIRAL FLUTE TAPS)**
  The special three-radii profile with a constant rake angle along the flute length leads to better control of cutting properties and prevents nest formation of chips.
- **TAPPING ATTACHMENT (RECOMMENDATION)**
  When using Black Shark taps, it is recommended to use synchronized (rigid) tapping.
- **THREAD FORMS**
  UNC, UNF, Metric and Metric Fine
- **PRODUCT CODES**
  E805, E806, E816, E817, E905, E906, E916, E917

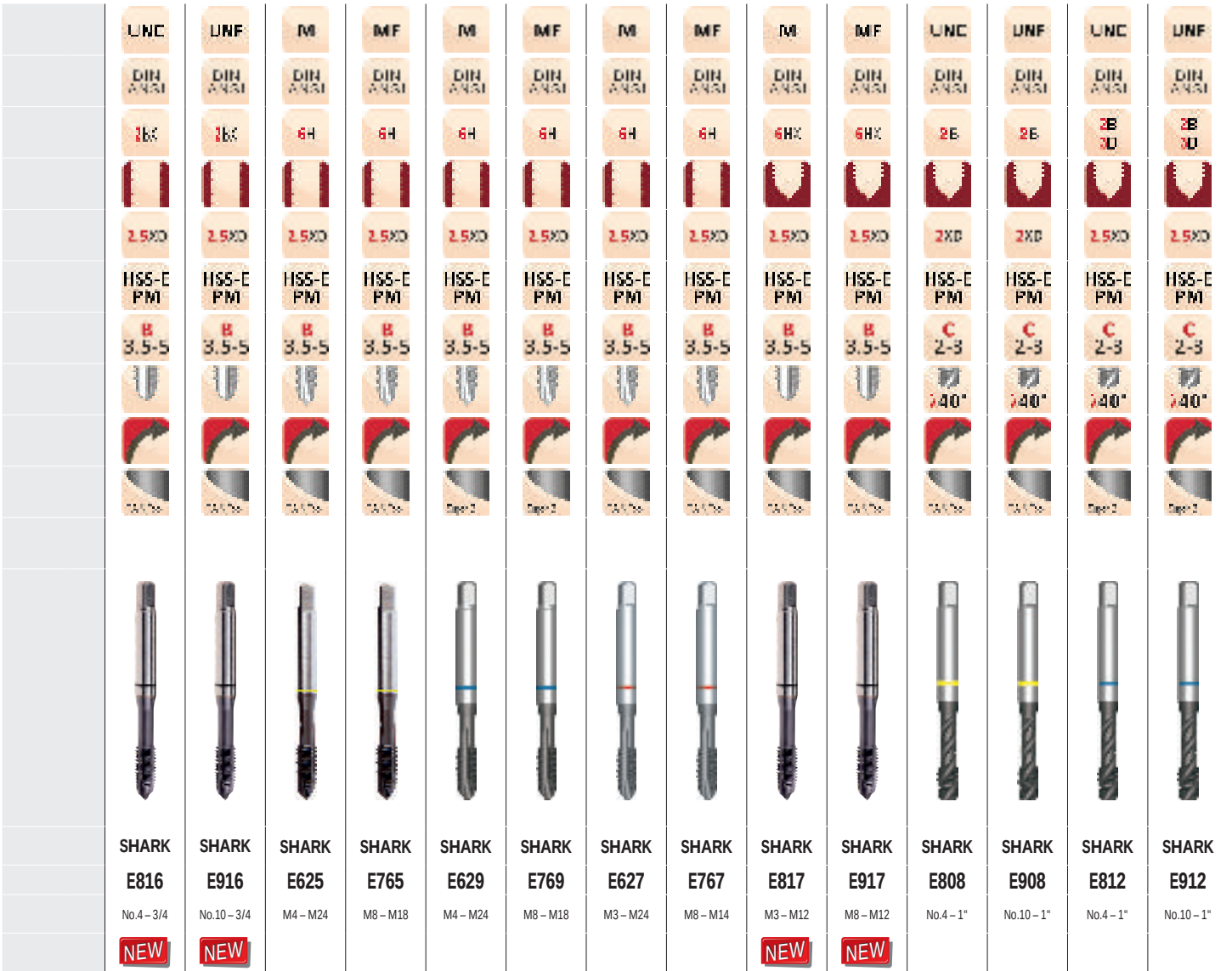
CAST IRONS

WHITE SHARK

- **SURFACE TREATMENT**
  TiAlN-Top coated.
- **FLUTE GEOMETRY**
  Straight flute design gives excellent performance when threading both through and blind holes in short chipping materials.
- **INTERNAL COOLANT WITH AXIAL OUTLET**
  Reduces interruptions of the production process by providing optimum chip evacuation in both horizontal and vertical blind hole machining.
- **THREAD FORMS**
  UNC, UNF, Metric and Metric Fine
- **PRODUCT CODES**
  E630, E631, E770, E771, E814, E815, E914, E915

		UNC	UNC	UNF	UNF	M	M	MF	MF	UNC	UNF	UNC	UNF	UNC	UNF
		DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI
		2bS	2bS	2bS	2bS	6HX	6HX	6HX	6HX	2B	2B	3B 3U	3B 3U	2B	2B
		2XD	2.5XD	2XD	2.5XD	2XD	2.5XD	2XD	2.5XD	2.5XD	2.5XD	2.5XD	2.5XD	2.5XD	2.5XD
		HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM
		C 2-3	E 1.5-2	C 2-3	E 1.5-2	C 2-3	E 1.5-2	C 2-3	E 1.5-2	B 3.5-5	B 3.5-5	B 3.5-5	B 3.5-5	B 3.5-5	B 3.5-5
		SHARK E814	SHARK E815	SHARK E914	SHARK E915	SHARK E630	SHARK E631	SHARK E770	SHARK E771	SHARK E809	SHARK E909	SHARK E813	SHARK E913	SHARK E811	SHARK E911
		1/4 – 1"	1/4 – 1"	No.10 – 7/8	1/4 – 1"	M5 – M24	M6 – M24	M8 – M14	M10 – M14	No.4 – 1"	No.10 – 1"	No.4 – 1"	No.10 – 1"	No.4 – 1"	no.10 – 1"
ISO 513		12	12	12	12	13	13	13	13	14	14	15	15	17	17
P	P1									■	■	◪	◪		
	P2									■	■	◪	◪	■	■
	P3									◪	◪	◪	◪	■	■
	P4									◪	◪	◪	◪	■	■
M	M1											■	■		
	M2											■	■		
	M3											■	■		
	M4											■	■		
K	K1	■	■	■	■	■	■	■	■						
	K2														
	K3														
	K4														
	K5														
N	N1														
	N2														
	N3	◪	◪	◪	◪	◪	◪	◪	◪						
	N4	■	■	■	■	■	■	■	■						
S	S1													◪	◪
	S2													◪	◪
	S3													◪	◪
	S4													◪	◪
H	H1														
	H2														
	H3														
	H4														

■ Main application ◪ Secondary application



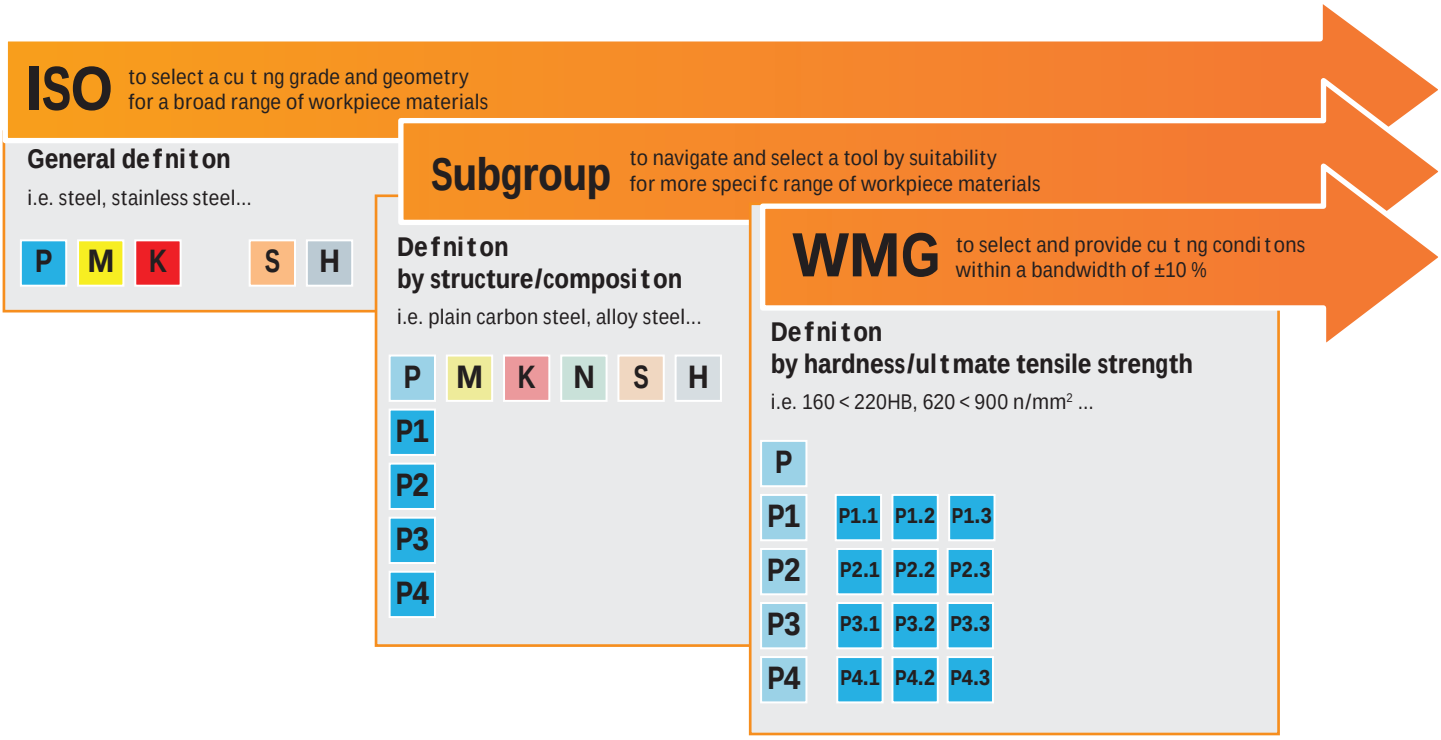
		SHARK E816	SHARK E916	SHARK E625	SHARK E765	SHARK E629	SHARK E769	SHARK E627	SHARK E767	SHARK E817	SHARK E917	SHARK E808	SHARK E908	SHARK E812	SHARK E912
		No.4 – 3/4	No.10 – 3/4	M4 – M24	M8 – M18	M4 – M24	M8 – M18	M3 – M24	M8 – M14	M3 – M12	M8 – M12	No.4 – 1"	No.10 – 1"	No.4 – 1"	No.10 – 1"
		NEW	NEW							NEW	NEW				
ISO 513		18	18	19	19	20	20	21	21	22	22	23	23	24	24
P	P1			■	■	◪	◪					■	■	◪	◪
	P2			■	■	◪	◪	■	■			■	■	◪	◪
	P3	◪	◪	◪	◪	◪	◪	■	■	◪	◪	◪	◪	◪	◪
	P4	■	■	◪	◪	◪	◪	■	■	■	■	◪	◪	◪	◪
M	M1					■	■							■	■
	M2					■	■							■	■
	M3					■	■							■	■
	M4					■	■							■	■
K	K1														
	K2														
	K3														
	K4														
	K5														
N	N1														
	N2														
	N3														
	N4														
S	S1	■	■					◪	◪	■	■				
	S2							◪	◪						
	S3	■	■					◪	◪	■	■				
	S4							◪	◪						
H	H1														
	H2														
	H3	◪	◪							◪	◪				
	H4														

■ Main application ◪ Secondary application

		UNC	UNF	UNC	UNF	M	MF	M	MF	M	MF	M	MF
		DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI
		2B	2B	2bX	2bX	6H	6H	6H	6H	6H	6H	6HX	6HX
		2.5xD	2.5xD	1.5xD	1.5xD	2xD	2xD	2.5xD	2.5xD	2.5xD	2.5xD	1.5xD	1.5xD
		HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM
		C 2-3	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3
		10°	10°	15°	15°	40°	40°	40°	40°	10°	10°	15°	15°
		SHARK E810 No.4 – 1"	SHARK E910 No.10 – 1"	SHARK E805 No.4 – 3/4 NEW	SHARK E905 No.10 – 3/4 NEW	SHARK E624 M4 – M24	SHARK E764 M8 – M18	SHARK E628 M4 – M24	SHARK E768 M8 – M18	SHARK E626 M3 – M24	SHARK E766 M8 – M14	SHARK E806 M3 – M12 NEW	SHARK E906 M8 – M12 NEW
ISO 513		26	26	27	27	28	28	29	29	30	30	31	31
P	P1					■	■	◪	◪				
	P2	■	■			■	■	◪	◪	■	■		
	P3	■	■	◪	◪	◪	◪	◪	◪	■	■	◪	◪
	P4	■	■	■	■	◪	◪	◪	◪	■	■	■	■
M	M1							■	■				
	M2							■	■				
	M3							■	■				
	M4							■	■				
K	K1												
	K2												
	K3												
	K4												
	K5												
N	N1												
	N2												
	N3												
	N4												
S	S1	◪	◪	■	■					◪	◪	■	■
	S2	◪	◪							◪	◪		
	S3	◪	◪	■	■					◪	◪	■	■
	S4	◪	◪							◪	◪		
H	H1												
	H2												
	H3			◪	◪							◪	◪
	H4												

■ Main application ◪ Secondary application

WORKPIECE MATERIAL GROUPS (WMG)



ABOUT DORMER PRAMET'S WORKPIECE MATERIAL CLASSIFICATION

Workpiece material groups ("WMG") are used to support easy and reliable selec ton of the right cu t ng tool and star t ng values for machining condi tons in par t cular applica t ons.

Dormer Pramet classi fes workpiece materials into six di f erently colored groups;

- **Blue**: Steel and cast steel (P-group)
- **Yellow**: Stainless steel (M-group)
- **Red**: Cast iron (K-group)
- **Green**: Non-ferrous metals (N-group)
- **Orange**: High-temperature alloys (S-group)
- **Grey**: Hardened materials (H-group)

Each of these are divided into subgroups on the basis of their structure and/or composi t on. For example, P-group steel and cast steel is split into four subgroups, namely;

- P1 – **Free machining steel**
- P2 – **Plain carbon steel**
- P3 – **Alloy steel**
- P4 – **Tool steel**

A f nal division includes material proper t es, such as hardness and ul t mate tensile strength. This is to provide our customers with a complete tool recommenda t on, including star t ng values for cu t ng speed and feed.

The table on the next page includes a descrip t on of each workpiece material group, as well as examples of commonly used designa t ons

ISO			WMG (Workpiece Material Groups)	Ultimate tensile strength Mpa [N/mm²]	Old Dormer AMG	Old Pramet ISO
P	P1	P1.1	Free machining sulfurized carbon steel with a hardness of < 220 HB	≤ 760	1.1	P1
		P1.2	Free machining sulfurized and phosphorized carbon steel with a hardness of < 180 HB	≤ 620	1.1	P1
		P1.3	Free machining sulfurized/phosphorized and leaded carbon steel with a hardness of < 160 HB	≤ 550	1.1	P1
	P2	P2.1	Plain low carbon steel containing < 0.25%C with a hardness of < 180 HB	≤ 620	1.2	P2
		P2.2	Plain medium carbon steel containing < 0.55%C with a hardness of < 240 HB	≤ 830	1.3	P2
		P2.3	Plain high carbon steel containing > 0.55%C, with a hardness of < 300 HB	≤ 1030	1.5	P3
	P3	P3.1	Alloy steel with a hardness of < 180 HB	≤ 620	1.4	P3
		P3.2	Alloy steel with a hardness of 180 – 260 HB	> 620 ≤ 900	1.4	P3
		P3.3	Alloy steel with a hardness of 260 – 360 HB	> 900 ≤ 1240	1.5	P4
	P4	P4.1	Tool steel with a hardness of < 26 HRC	≤ 900	1.4	P3
		P4.2	Tool steel with a hardness of 26 – 39 RC	> 900 ≤ 1240	1.5	P4
		P4.3	Tool steel with a hardness of 39 – 45 HRC	> 1250 ≤ 1450	1.6	H1
M	M1	M1.1	Stainless steel, ferritic with a hardness of < 160 HB	≤ 520	2.1	M1
		M1.2	Stainless steel, ferritic with a hardness of 160 – 220 HB	> 520 ≤ 700	2.1	M1
	M2	M2.1	Stainless steel, martensitic with a hardness of < 200 HB	≤ 670	2.3	M2
		M2.2	Stainless steel, martensitic with a hardness of 200 – 280 HB	> 670 ≤ 950	2.3	M2
		M2.3	Stainless steel, martensitic with a hardness of 280 – 380 HB	> 950 ≤ 1300	2.4	M2
	M3	M3.1	Stainless steel, austenitic with a hardness of < 200 HB	≤ 750	2.2	M3
		M3.2	Stainless steel, austenitic with a hardness of 200 – 260 HB	>750 ≤ 870	2.2	M3
		M3.3	Stainless steel, austenitic with a hardness of 260 – 300 HB	> 870 ≤ 1040	2.2	M3
	M4	M4.1	Stainless steel, austenitic-ferritic or super-austenitic with a hardness of < 300 HB	≤ 990	2.3	M4
		M4.2	Stainless steel, precipitation hardening austenitic with a hardness of 300 – 380 HB	≤ 1320	2.4	M4
K	K1	K1.1	Gray iron, ferritic or ferritic-pearlitic with a hardness of < 180 HB	≤ 190	3.1	K1
		K1.2	Gray iron, ferritic-pearlitic or pearlitic with a hardness of 180 – 240 HB	> 190 ≤ 310	3.2	K1
		K1.3	Gray iron, pearlitic with a hardness of 240 – 280 HB	>310 ≤ 390	3.2	K1
	K2	K2.1	Malleable iron, ferritic with a hardness of < 160 HB	≤ 400	3.3	K2
		K2.2	Malleable iron, ferritic or pearlitic with a hardness of 160 – 200 HB	> 400 ≤ 550	3.3	K2
		K2.3	Malleable iron, pearlitic with a hardness of 200 – 240 HB	> 550 ≤ 660	3.4	K2
	K3	K3.1	Ductile (nodular/spheriodal) iron, ferritic with a hardness of < 180 HB	≤ 560	3.3	K3
		K3.2	Ductile (nodular/spheriodal) iron, ferritic or pearlitic with a hardness of 180 – 220 HB	> 560 ≤ 680	3.3	K4
		K3.3	Ductile (nodular/spheriodal) iron, pearlitic with a hardness of 220 – 260 HB	> 680 ≤ 800	3.4	K4
	K4	K4.1	Austenitic cast iron with a hardness of < 180 HB	≤ 610		
		K4.2	Austenitic cast iron with a hardness of 180 – 240HB	> 610 ≤ 840		
		K4.3	Austempered ductile iron with a hardness of 240 – 280 HB	> 840 ≤ 980		
		K4.4	Austempered ductile iron with a hardness of 280 – 320 HB	> 980 ≤ 1130		
		K4.5	Austempered ductile iron with a hardness of 320 – 360 HB	> 1130 ≤ 1280		
	K5	K5.1	Vermicular, compacted graphite iron with a hardness of < 180 HB			
		K5.2	Vermicular, compacted graphite iron with a hardness of 180 – 220 HB			
		K5.3	Vermicular, compacted graphite iron with a hardness of 220 – 260 HB			
N	N1	N1.1	Pure aluminum and wrought aluminum alloys with a hardness of < 60 HB	≤ 240	7.1	N1
		N1.2	Wrought aluminum alloys with a hardness of 60 – 100 HB	> 240 ≤ 400	7.1	N1
		N1.3	Wrought aluminum alloys with a hardness of 100 – 150 HB	> 400 ≤ 590	7.2	N2
	N2	N2.1	Cast aluminum alloys with a hardness of < 75 HB	≤ 240	7.3	N1
		N2.2	Cast aluminum alloys with a hardness of 75 – 90 HB	> 240 ≤ 270	7.3	N1
		N2.3	Cast aluminum alloys with a hardness of 90 < 140 HB	> 270 ≤ 440	7.3	N2
	N3	N3.1	Free-cutting copper-alloys materials with excellent machining properties		6.3	N3
		N3.2	Short-chip copper-alloys with good to moderate machining properties		6.2	N3
		N3.3	Electrolytic copper and long-chip copper-alloys with moderate to poor machining properties		6.1	N4
	N4	N4.1	Thermoplastic polymers		8.1	
		N4.2	Thermosetting polymers		8.2	
		N4.3	Reinforced polymers or composites		8.3	
S	S1	S1.1	Titanium or titanium alloys, with a hardness of < 200 HB	≤ 660	4.1	S1
		S1.2	Titanium alloys, with a hardness of 200 – 280 HB	> 660 ≤ 950	4.2	S1
		S1.3	Titanium alloys, a hardness of 280 – 360 HB	> 950 ≤ 1200	4.3	S1
	S2	S2.1	High-temperature Fe-based alloys with a hardness of < 200 HB	≤ 690		S2
		S2.2	High-temperature Fe-based alloys with a hardness of 200 – 280 HB	> 690 ≤ 970		S2
	S3	S3.1	High-temperature Ni-based alloys with a hardness of < 280 HB	≤ 940	5.2	S3
		S3.2	High-temperature Ni-based alloys with a hardness of 280 – 360 HB	> 940 ≤ 1200	5.3	S3
	S4	S4.1	High-temperature Co-based alloys with a hardness of < 240HB	≤ 800		S4
		S4.2	High-temperature Co-based alloys with a hardness of 240 – 320 HB	> 800 ≤ 1070		S4
H	H1	H1.1	Chilled cast iron with a hardness of < 400 HB			
	H2	H2.1	Hardened cast iron with a hardness < 55 HRC			H2
		H2.2	Hardened cast iron with a hardness > 55 HRC			H2
	H3	H3.1	Hardened steel with a hardness of < 51 HRC		1.7	H3
		H3.2	Hardened steel with a hardness of 51 – 55 HRC		1.7	H3
	H4	H4.1	Hardened steel with a hardness of 55 – 59 HRC		1.8	H4
		H4.2	Hardened steel with a hardness of > 59 HRC		1.8	H4

DIN ANSI Machine Tap, White Shark for Cast Iron

E814	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K4.1	K4.2	K4.3
E914	■98	■72	■56	■141	■115	◪92	■125	■95	◪79	■115	■89	◪66
E815	K4.4	K4.5	K5.1	K5.2	K5.3	N3.2	N4.2					
E915	◪56	◪46	■131	■98	◪75	◪98	■49					

E814 / E914

Designed for semi-bo t oming or through hole tapping in Cast Iron applica t ons. Premium HSCo Powder Metal substrate with TiAlN-Top Coa t ng combine to o f er superior abrasion resistance, higher opera t ng speeds, improved thread quality, reduced cycle t mes and longer tool life.

E815 / E915

Coolant through design allows for higher tapping speeds and be t er tool life. This design eliminates the problems associated with inadequate coolant supply in some applica t ons. Full Bo t oming.

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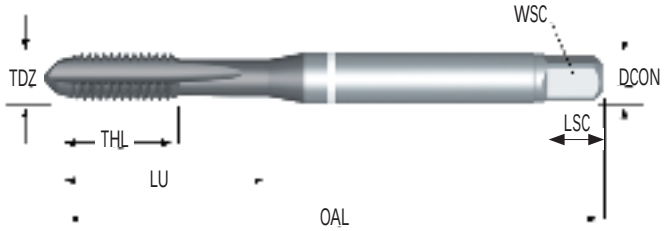
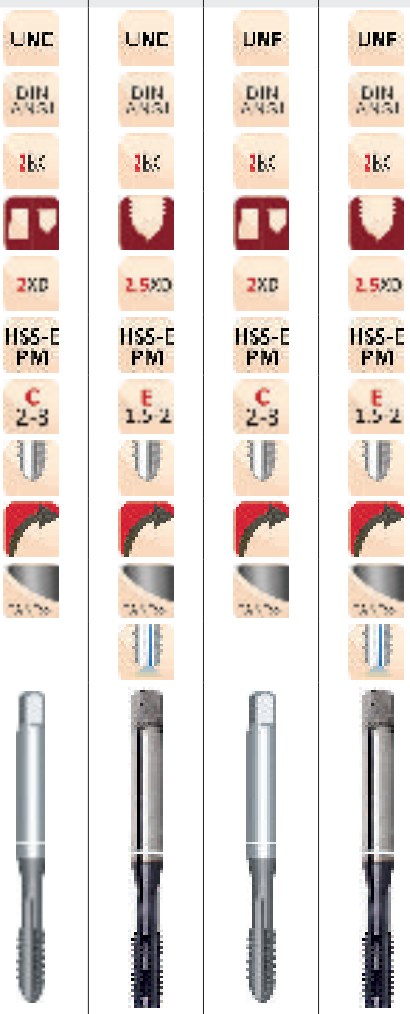




Pack Qty = 1 pc

TDZ UNC	TDZ UNF	TPI	OAL [inch]	THL [inch]	LU [inch]	DCON [inch]	WSC [inch]	LSC [inch]	NOF [-]	[mm]	[inch]	Limits	E814	E815	E914	E915
	10	32	2.756	0.551	1.102	0.194	0.150	0.250	4	4.10	N21	H4	—	—	7350222	—
1/4		20	3.150	0.591	0.984	0.255	0.189	0.310	4	5.10	N7	H5	7350203	7350231	—	—
	1/4	28	3.150	0.591	0.984	0.255	0.189	0.310	4	5.50	N3	H5	—	—	7350223	—
	1/4	28	3.150	0.591	0.984	0.255	0.189	0.310	4	5.50	N3	H4	—	—	—	7350240
5/16		18	3.543	0.709	1.339	0.318	0.236	0.380	4	6.60	F	H5	7350204	—	—	—
5/16		18	3.543	0.787	1.339	0.318	0.236	0.380	4	6.60	F	H5	—	7350232	—	—
	5/16	24	3.543	0.709	1.339	0.318	0.236	0.380	4	6.90	I	H5	—	—	7350224	—
	5/16	24	3.543	0.787	1.339	0.318	0.236	0.380	4	6.90	I	H5	—	—	—	7350241
3/8		16	3.937	0.787	1.535	0.381	0.284	0.440	4	8.00	5/16	H5	7350205	7350233	—	—
	3/8	24	3.543	0.787	1.476	0.381	0.284	0.440	4	8.50	Q	H5	—	—	7350225	7350242
7/16		14	3.937	0.787	–	0.323	0.240	0.410	4	9.40	U	H5	7350206	7350234	—	—
	7/16	20	3.937	0.787	–	0.323	0.240	0.410	4	9.90	25/64	H5	—	—	7350226	7350243
1/2		13	4.331	0.906	–	0.367	0.273	0.440	4	10.80	27/64	H5	7350207	7350235	—	—
	1/2	20	3.937	0.827	–	0.367	0.273	0.440	4	11.50	29/64	H5	—	—	7350227	7350244
5/8		11	4.331	0.906	–	0.480	0.358	0.560	4	13.50	17/32	H5	7350208	7350236	—	—
	5/8	18	3.937	0.827	–	0.480	0.358	0.560	4	14.50	37/64	H5	—	—	7350228	7350245
3/4		10	4.921	1.181	–	0.590	0.439	0.690	4	16.50	21/32	H5	7350209	7350237	—	—
	3/4	16	4.331	0.906	–	0.590	0.439	0.690	4	17.50	11/16	H6	—	—	7350229	—
	3/4	16	4.331	0.906	–	0.590	0.439	0.690	4	17.50	11/16	H5	—	—	—	7350246
7/8		9	5.512	1.339	–	0.697	0.520	0.750	4	19.50	49/64	H6	7350220	7350238	—	—
	7/8	14	4.921	0.906	–	0.697	0.520	0.750	4	20.40	13/16	H6	—	—	7350230	7350247
1“		8	6.299	1.417	–	0.800	0.597	0.810	4	22.25	7/8	H6	7350221	7350239	—	—
	1“	12	5.512	1.063	–	0.800	0.597	0.810	4	23.25	59/64	H6	—	—	—	7350248

Note: Sizes up to 3/8” have male centers on both ends • Sizes over 3/8” have female centers on both ends.

DIN ANSI Machine Tap, White Shark for Cast Iron

E630	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K4.1	K4.2	K4.3
E770	■98	■72	■56	■141	■115	◪92	■125	■95	◪79	■115	■89	◪66
E631	K4.4	K4.5	K5.1	K5.2	K5.3	N3.2	N4.2					
E771	◪56	◪46	■131	■98	◪75	◪98	■49					

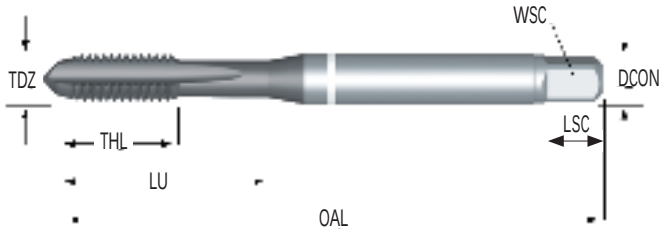
E630 / E770

Designed for semi-bo t oming or through hole tapping in Cast Iron applica t ons. Premium HSCo Powder Metal substrate with TiAlN-Top Coa t ng combine to o f er superior abrasion resistance, higher opera t ng speeds, improved thread quality, reduced cycle t mes and longer tool life.

E631 / E771

Coolant through design allows for higher tapping speeds and be t er tool life. This design eliminates the problems associated with inadequate coolant supply in some applica t ons. Full Bo t oming.

DORMER



Pack Qty = 1 pc

TDZ M	TDZ MF	P [mm]	OAL [mm]	THL [mm]	LU [mm]	DCON [inch]	WSC [inch]	LSC [mm]	NOF [-]	[mm]	[inch]	Limits	E630	E631	E770	E771
5		0.80	70	13	25	0.194	0.150	6	4	4.20	N19	D4	**7350249**	—	—	—
6		1.00	80	15	25	0.255	0.189	8	4	5.00	N9	D5	—	**7350265**	—	—
6		1.00	80	15	30	0.255	0.189	8	4	5.00	N9	D5	**7350250**	—	—	—
	8	1.00	90	18	35	0.318	0.236	10	4	7.00	J	D5	—	—	**7350259**	—
8		1.25	90	18	35	0.318	0.236	10	4	6.80	H	D5	**7350251**	—	—	—
8		1.25	90	20	34	0.318	0.236	10	4	6.80	H	D5	—	**7350266**	—	—
	10	1.00	90	20	35	0.381	0.284	11	4	9.00	T	D6	—	—	**7350260**	—
	10	1.25	100	20	39	0.381	0.284	11	4	8.80	11/32	D6	—	—	**7350261**	**7350274**
10		1.50	100	20	39	0.381	0.284	11	4	8.50	Q	D6	**7350252**	**7350267**	—	—
	12	1.25	100	21	–	0.367	0.273	11	4	10.80	27/64	D6	—	—	**7350262**	**7350275**
	12	1.50	100	21	–	0.367	0.273	11	4	10.50	Z	D6	—	—	**7350263**	**7350276**
12		1.75	110	23	–	0.367	0.273	11	4	10.30	Y	D6	**7350253**	**7350268**	—	—
	14	1.50	100	21	–	0.429	0.320	13	4	12.50	31/64	D7	—	—	**7350264**	**7350277**
14		2.00	110	23	–	0.429	0.320	13	4	12.00	15/32	D7	**7350254**	**7350269**	—	—
16		2.00	110	23	–	0.480	0.358	14	4	14.00	35/64	D7	**7350255**	**7350270**	—	—
18		2.50	125	30	–	0.542	0.404	16	4	15.50	39/64	D7	**7350256**	**7350271**	—	—
20		2.50	140	30	–	0.652	0.487	18	4	17.50	11/16	D7	**7350257**	**7350272**	—	—
24		3.00	160	38	–	0.760	0.567	19	4	21.00	53/64	D8	**7350258**	**7350273**	—	—

Note: Sizes up to M10 have male centers on both ends • Sizes over M10 have female centers on both ends.

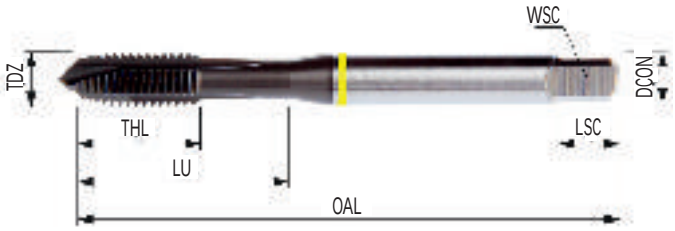
DIN ANSI Machine Tap, Yellow Shark for Low Alloy Steels

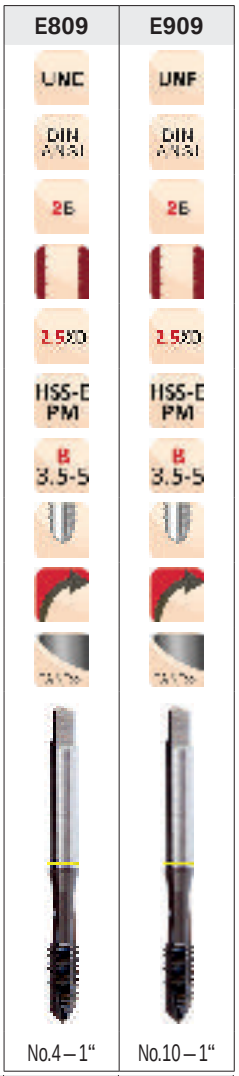
	P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	N3.1	N3.2	N3.3
E809 E909	■102	◪112	■115	■85	■75	◪66	◪62	◪49	◪43	◪36	◪33	■167	◪98	■49

E809 / E909

Designed for through hole tapping in low Alloy Steel applicat ons. Premium HSCo Powder Metal substrate with TiAlN-Top Coat ng combine to o f er superior abrasion resistance, higher opera t ng speeds, improved thread quality, reduced cycle t mes and longer tool life.

DORMER





Pack Qty = 1 pc

TDZ UNC	TDZ UNF	TPI	OAL	THL	LU	DCON	WSC	LSC	NOF			Limits	E809	E909
		[inch]	[inch]	[inch]	[inch]	[inch]	[inch]	[inch]	[-]	[mm]	[inch]			
4		40	2.205	0.354	0.709	0.141	0.108	0.190	3	2.35	N43	H2	**7350469**	**—**
6		32	2.205	0.433	0.787	0.141	0.108	0.190	3	2.85	N36	H2	**7350470**	**—**
8		32	2.480	0.512	0.827	0.168	0.129	0.250	3	3.50	N29	H3	**7350471**	**—**
10		24	2.756	0.551	1.102	0.194	0.150	0.250	3	3.90	N25	H3	**7350472**	**—**
	10	32	2.756	0.551	1.102	0.194	0.150	0.250	3	4.10	N21	H3	—	**7350482**
1/4		20	3.150	0.591	0.984	0.255	0.189	0.310	3	5.10	N7	H5	**7350473**	—
	1/4	28	3.150	0.591	0.984	0.255	0.189	0.310	3	5.50	N3	H4	—	**7350483**
5/16		18	3.543	0.709	1.339	0.318	0.236	0.380	3	6.60	F	H5	**7350474**	—
	5/16	24	3.543	0.709	1.339	0.318	0.236	0.380	3	6.90	I	H4	—	**7350484**
3/8		16	3.937	0.787	1.535	0.381	0.284	0.440	3	8.00	5/16	H4	**7350475**	—
	3/8	24	3.543	0.787	1.476	0.381	0.284	0.440	3	8.50	Q	H4	—	**7350485**
7/16		14	3.937	0.787	–	0.323	0.240	0.410	3	9.40	U	H5	**7350476**	—
	7/16	20	3.937	0.787	–	0.323	0.240	0.410	3	9.90	25/64	H5	—	**7350486**
1/2		13	4.331	0.906	–	0.367	0.273	0.440	3	10.80	27/64	H5	**7350477**	—
	1/2	20	3.937	0.827	–	0.367	0.273	0.440	3	11.50	29/64	H5	—	**7350487**
5/8		11	4.331	0.906	–	0.480	0.358	0.560	3	13.50	17/32	H5	**7350478**	—
	5/8	18	3.937	0.827	–	0.480	0.358	0.560	3	14.50	37/64	H5	—	**7350488**
3/4		10	4.921	1.181	–	0.590	0.439	0.690	3	16.50	21(32	H5	**7350479**	—
	3/4	16	4.331	0.906	–	0.590	0.439	0.690	3	17.50	11/16	H5	—	**7350489**
7/8		9	5.512	1.339	–	0.697	0.520	0.750	4	19.50	49/64	H6	**7350480**	
	7/8	14	4.921	0.906	–	0.697	0.520	0.750	4	20.40	13/16	H6		**7350490**
1“		8	6.299	1.417	–	0.800	0.597	0.810	4	22.25	7/8	H6	**7350481**	
	1“	12	5.512	1.063	–	0.800	0.597	0.810	4	23.25	59/64	H6		**7350491**

Note: Sizes up to 3/8” have male centers on both ends • Sizes over 3/8” have female centers on both ends.

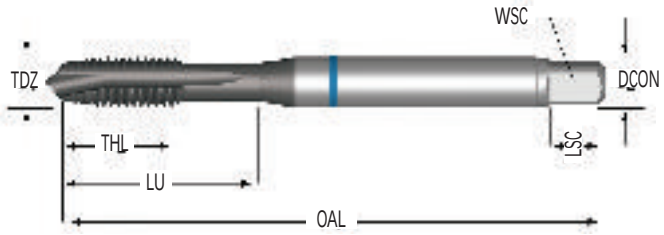
DIN ANSI Machine Tap, Blue Shark for Stainless Steel

	P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1	M2.2
E813 E913	◪79	◪89	◪92	◪66	◪59	◪52	◪49	◪39	◪33	◪30	◪23	■62	■52	■56	■46
	M3.1	M3.2	M3.3	M4.1											
	■39	■33	■30	■20											

E813 / E913

Designed for superior performance through hole tapping in a wide range of Stainless Steel types. Premium HSCo Powder Metal substrate with Super-B (TiAlN+WC/C) Coating combined with an additional edge treatment to offer improved thread quality and longer tool life. Available in both 2B and 3B Class of Fit to cover a wide range of applications.

DORMER



E813	E913
UNC	UNF
DIN ANSI	DIN ANSI
2B 3D	2B 3D
2.5xD	2.5xD
HSS-E PM	HSS-E PM
B 3.5-5	B 3.5-5
	
No.4 – 1“	No.10 – 1“

Pack Qty = 1 pc

TDZ UNC	TDZ UNF	TPI [inch]	OAL [inch]	THL [inch]	LU [inch]	DCON [inch]	◪ WSC [inch]	LSC [inch]	NOF [-]	[mm]	[inch]	Limits	E813	E913
4		40	2.205	0.354	0.709	0.141	0.108	0.190	3	2.35	N43	H2	**7350278**	—
6		32	2.205	0.433	0.787	0.141	0.108	0.190	3	2.85	N36	H3	**7350279**	—
8		32	2.480	0.512	0.827	0.168	0.129	0.250	3	3.50	N29	H3	**7350280**	—
10		24	2.756	0.551	1.102	0.194	0.150	0.250	3	3.90	N25	H3	**7350281**	—
	10	32	2.756	0.551	1.102	0.194	0.150	0.250	3	4.10	N21	H3	—	**7350299**
1/4		20	3.150	0.591	0.984	0.255	0.189	0.310	3	5.10	N7	H5	**7350282**	—
1/4		20	3.150	0.591	0.984	0.255	0.189	0.310	3	5.10	N7	H3	**7350283**	—
	1/4	28	3.150	0.591	0.984	0.255	0.189	0.310	3	5.50	N3	H5	—	**7350300**
	1/4	28	3.150	0.591	0.984	0.255	0.189	0.310	3	5.50	N3	H3	—	**7350301**
5/16		18	3.543	0.709	1.339	0.318	0.236	0.380	3	6.60	F	H5	**7350284**	—
5/16		18	3.543	0.709	1.339	0.318	0.236	0.380	3	6.60	F	H3	**7350285**	—
	5/16	24	3.543	0.709	1.339	0.318	0.236	0.380	3	6.90	I	H4	—	**7350302**
	5/16	24	3.543	0.709	1.339	0.318	0.236	0.380	3	6.90	I	H3	—	**7350303**
3/8		16	3.937	0.787	1.535	0.381	0.284	0.440	3	8.00	5/16	H3	**7350287**	—
3/8		16	3.937	0.787	1.535	0.381	0.284	0.440	3	8.00	5/16	H5	**7350286**	—
	3/8	24	3.543	0.787	1.476	0.381	0.284	0.440	3	8.50	Q	H4	—	**7350304**
	3/8	24	3.543	0.787	1.476	0.381	0.284	0.440	3	8.50	Q	H3	—	**7350305**
7/16		14	3.937	0.787	–	0.323	0.240	0.410	4	9.40	U	H5	**7350288**	—
	7/16	20	3.937	0.787	–	0.323	0.240	0.410	4	9.90	25/64	H5	—	**7350306**
1/2		13	4.331	0.906	–	0.367	0.273	0.440	4	10.80	27/64	H5	**7350289**	—
1/2		13	4.331	0.906	–	0.367	0.273	0.440	4	10.80	27/64	H3	**7350290**	—
	1/2	20	3.937	0.827	–	0.367	0.273	0.440	4	11.50	29/64	H5	—	**7350307**
	1/2	20	3.937	0.827	–	0.367	0.273	0.440	4	11.50	29/64	H3	—	**7350308**
5/8		11	4.331	0.906	–	0.480	0.358	0.560	4	13.50	17/32	H5	**7350291**	—
5/8		11	4.331	0.906	–	0.480	0.358	0.560	4	13.50	17/32	H3	**7350292**	—
	5/8	18	3.937	0.827	–	0.480	0.358	0.560	4	14.50	37/64	H5	—	**7350309**

Note: Sizes up to 3/8” have male centers on both ends • Sizes over 3/8” have female centers on both ends.

TDZ UNC	TDZ UNF	TPI	OAL	THL	LU	DCON	WSC	LSC	NOF			Limits	E813	E913
		[inch]	[inch]	[inch]	[inch]	[inch]	[inch]	[inch]	[-]	[mm]	[inch]			
	5/8	18	3.937	0.827	–	0.480	0.358	0.560	4	14.50	37/64	H3	—	**7350310**
3/4		10	4.921	1.181	–	0.590	0.439	0.690	4	16.50	21/32	H5	**7350293**	—
3/4		10	4.921	1.181	–	0.590	0.439	0.690	4	16.50	21/32	H3	**7350294**	—
	3/4	16	4.331	0.906	–	0.590	0.439	0.690	4	17.50	11/16	H5	—	**7350311**
	3/4	16	4.331	0.906	–	0.590	0.439	0.690	4	17.50	11/16	H3	—	**7350312**
7/8		9	5.512	1.339	–	0.697	0.520	0.750	4	19.50	49/64	H6	**7350295**	—
7/8		9	5.512	1.339	–	0.697	0.520	0.750	4	19.50	49/64	H4	**7350296**	—
	7/8	14	4.921	0.906	–	0.697	0.520	0.750	4	20.40	13/16	H6	—	**7350313**
	7/8	14	4.921	0.906	–	0.697	0.520	0.750	4	20.40	13/16	H4	—	**7350314**
1“		8	6.299	1.417	–	0.800	0.597	0.810	4	22.25	7/8	H6	**7350297**	—
1“		8	6.299	1.417	–	0.800	0.597	0.810	4	22.25	7/8	H4	**7350298**	—
	1“	12	5.512	1.063	–	0.800	0.597	0.810	4	23.25	59/64	H6	—	**7350315**
	1“	12	5.512	1.063	–	0.800	0.597	0.810	4	23.25	59/64	H4	—	**7350316**

Note: Sizes up to 3/8” have male centers on both ends • Sizes over 3/8” have female centers on both ends.

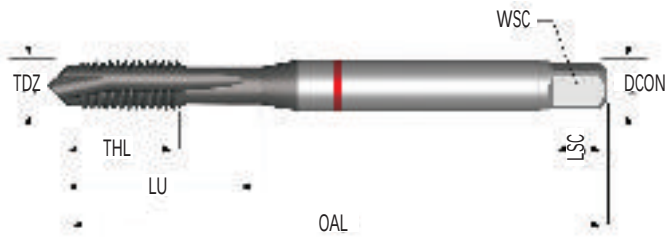
DIN ANSI Machine Tap, Red Shark for Alloy Steels

	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	S1.2	S2.1	S3.1	S4.1				
E811 **E911**	■79	■82	■66	■56	■49	■43	◪33	◪10	◪13	◪10	◪7				

E811 / E911

Designed for high performance through hole tapping in most medium Alloy Steels. The TiAlN-Top Coat ng combined with an addi t onal edge treatment provides excellent performance and consistency in high produc t on applica t ons.

DORMER



E811	E911
UNC	UNF
DIN ANSI	DIN ANSI
2B	2B
2.5xD	2.5xD
HSS-E PM	HSS-E PM
3.5-5	3.5-5
	
No.4 – 1“	No.10 – 1“

Pack Qty = 1 pc

TDZ UNC	TDZ UNF	TPI	OAL	THL	LU	DCON	WSC	LSC	NOF			Limits	E811	E911
		[inch]	[inch]	[inch]	[inch]	[inch]	[inch]	[inch]	[-]	[mm]	[inch]			
4		40	2.205	0.354	0.709	0.141	0.108	0.190	3	2.35	N43	H2	**7350391**	—
6		32	2.205	0.433	0.787	0.141	0.108	0.190	3	2.85	N36	H2	**7350392**	—
8		32	2.480	0.512	0.827	0.168	0.129	0.250	3	3.50	N29	H3	**7350393**	—
10		24	2.756	0.551	1.102	0.194	0.150	0.250	3	3.90	N25	H3	**7350394**	—
	10	32	2.756	0.551	1.102	0.194	0.150	0.250	3	4.10	N21	H3	—	**7350404**
1/4		20	3.150	0.591	0.984	0.255	0.189	0.310	3	5.10	N7	H5	**7350395**	—
	1/4	28	3.150	0.591	0.984	0.255	0.189	0.310	3	5.50	N3	H4	—	**7350405**
5/16		18	3.543	0.709	1.339	0.318	0.236	0.380	3	6.60	F	H5	**7350396**	—
	5/16	24	3.543	0.709	1.339	0.318	0.236	0.380	3	6.90	I	H4	—	**7350406**
3/8		16	3.543	0.787	1.535	0.381	0.284	0.440	3	8.00	5/16	H4	**7350397**	—
	3/8	24	3.543	0.787	1.476	0.318	0.284	0.440	3	8.50	Q	H4	—	**7350407**
7/16		14	3.937	0.787	–	0.323	0.240	0.410	3	9.40	U	H5	**7350398**	—
	7/16	20	3.937	0.787	–	0.323	0.240	0.410	3	9.90	25/64	H5	—	**7350408**
1/2		13	4.331	0.906	–	0.367	0.273	0.440	3	10.80	27/64	H5	**7350399**	—
	1/2	20	3.937	0.827	–	0.367	0.273	0.440	3	11.50	29/64	H5	—	**7350409**
5/8		11	4.331	0.906	–	0.480	0.358	0.560	3	13.50	17/32	H5	**7350400**	—
	5/8	18	3.937	0.827	–	0.480	0.358	0.560	3	14.50	37/64	H5	—	**7350410**
3/4		10	4.921	1.181	–	0.590	0.439	0.690	4	16.50	21/32	H5	**7350401**	—
	3/4	16	4.331	0.906	–	0.590	0.439	0.690	4	17.50	11/16	H5	—	**7350411**
7/8		9	5.512	1.339	–	0.697	0.520	0.750	4	19.50	49/64	H6	**7350402**	—
	7/8	14	4.921	0.906	–	0.697	0.520	0.750	4	20.40	13/16	H6	—	**7350412**
1“		8	6.299	1.417	–	0.800	0.597	0.810	4	22.25	7/8	H6	**7350403**	—
	1“	12	5.512	1.063	–	0.800	0.597	0.810	4	23.25	59/64	H6	—	**7350413**

Note: Sizes up to 3/8” have male centers on both ends • Sizes over 3/8” have female centers on both ends.

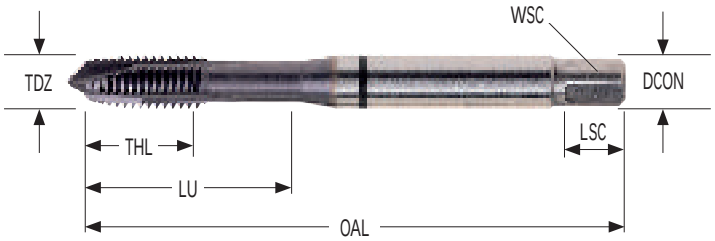
DIN-ANSI Machine Tap Black Shark for Hard Alloys, Plug Style

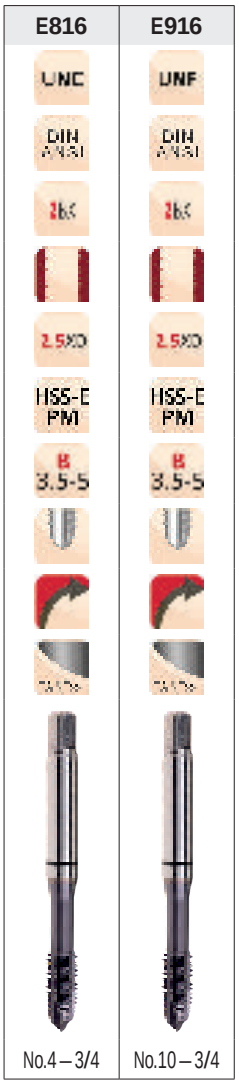
E816	P3.2	P3.3	P4.3	S1.2	S1.3	S3.1	S3.2	H3.1						
E916	■55	■42	■32	■42	■26	■16	■10	◪22						

E816 / E916

Designed for high performance through hole tapping in high strength and heat resistant work-materials with hardness up to 45HRC. The TiAlN-Top coating combined with geometry that significantly increases cutting edge strength, provides excellent performance and consistency in hard and difficult to machine materials.

DORMER





No.4 – 3/4 | No.10 – 3/4

Pack Qty = 1 pc

TDZ UNC	TDZ UNF	TPI	OAL	THL	LU	DCON	◪ WSC	LSC	NOF			Limits	E816	E916
		[inch]	[inch]	[inch]	[inch]	[inch]	[inch]	[inch]	[-]	[mm]	[inch]			
4		40	2.205	0.472	0.827	0.141	0.108	0.190	3	2.35	N43	H2	**7812046**	—
6		32	2.480	0.551	0.866	0.168	0.129	0.250	3	2.85	N36	H3	**7812047**	—
8		32	2.756	0.610	1.102	0.194	0.150	0.250	3	3.50	N29	H3	**7812048**	—
10		24	3.150	0.669	1.024	0.255	0.189	0.310	3	3.90	N25	H3	**7812049**	—
	10	32	3.150	0.669	1.024	0.255	0.189	0.310	3	4.10	N21	H3	—	**7812107**
1/4		20	3.543	0.807	1.378	0.318	0.236	0.380	3	5.10	N7	H5	**7812100**	—
	1/4	28	3.543	0.807	1.339	0.318	0.236	0.380	3	5.50	N3	H4	—	**7812108**
5/16		18	3.937	0.906	1.535	0.381	0.236	0.440	3	6.60	F	H5	**7812101**	—
	5/16	24	3.937	0.906	1.535	0.381	0.284	0.440	3	6.90	I	H4	—	**7812109**
3/8		16	3.937	0.787	1.535	0.381	0.236	0.440	3	8.00	5/16	H5	**7812102**	—
	3/8	24	3.937	0.787	1.535	0.381	0.284	0.440	3	8.50	Q	H4	—	**7812110**
7/16		14	3.937	0.787	–	0.323	0.240	0.410	4	9.40	U	H5	**7812103**	—
	7/16	20	3.937	0.787	–	0.323	0.240	0.440	4	9.90	25/64	H5	—	**7812111**
1/2		13	4.331	0.906	–	0.367	0.273	0.440	4	10.80	27/64	H5	**7812104**	—
	1/2	20	4.331	0.906	–	0.367	0.273	0.440	4	11.50	29/64	H5	—	**7812112**
5/8		11	4.331	0.906	–	0.480	0.358	0.560	4	13.50	17/32	H5	**7812105**	—
	5/8	18	4.331	0.906	–	0.480	0.358	0.560	4	14.50	37/64	H5	—	**7812113**
3/4		10	4.921	1.181	–	0.590	0.440	0.690	4	16.50	21/32	H5	**7812106**	—
	3/4	16	4.921	1.181	–	0.590	0.440	0.690	4	17.50	11/16	H5	—	**7812114**

Note: Sizes up to 3/8" have male centers on both ends • Sizes over 3/8" have female centers on both ends.

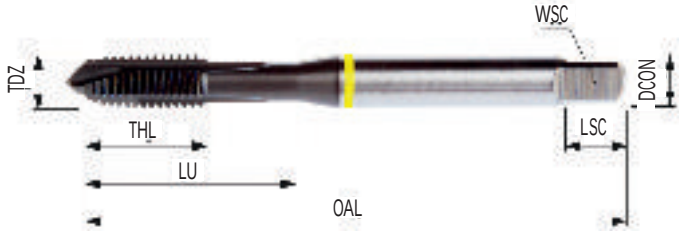
DIN ANSI Machine Tap, Yellow Shark for Low Alloy Steels

	P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	N3.1	N3.2	N3.3
E625 / E765	■102	◪112	■115	■85	■75	◪66	◪62	◪49	◪43	◪36	◪33	■167	◪98	■49

E625 / E765

Designed for high performance through hole tapping in most medium Alloy Steels. The TiAlN-Top Coating combined with an additional edge treatment provides excellent performance and consistency in high production applications.

DORMER



E625	E765
M	MF
DIN ANSI	DIN ANSI
6H	6H
2.5XD	2.5XD
HSS-E PM	HSS-E PM
3.5-5	3.5-5
M4 – M24	M8 – M18

Pack Qty = 1 pc

TDZ M	TDZ MF	P [mm]	OAL [mm]	THL [mm]	LU [mm]	DCON [inch]	◪ WSC [inch]	LSC [inch]	NOF [-]	[mm]	[inch]	Limits	E625	E765
4		0.70	63	12	21	0.168	0.129	6	3	3.30	N30	D4	**7350492**	—
5		0.80	70	13	25	0.194	0.150	6	3	4.20	N19	D4	**7350493**	—
6		1.00	80	15	30	0.255	0.189	8	3	5.00	N9	D5	**7350494**	—
	8	1.00	90	18	35	0.318	0.236	10	3	7.00	J	D5	—	**7350503**
8		1.25	90	18	35	0.318	0.236	10	3	6.80	H	D5	**7350495**	—
	10	1.25	100	20	39	0.381	0.284	11	3	8.80	11/32	D6	—	**7350504**
10		1.50	100	20	39	0.381	0.284	11	3	8.50	Q	D6	**7350496**	—
	12	1.25	100	21	–	0.367	0.273	11	3	10.80	27/64	D6	—	**7350505**
	12	1.50	100	21	–	0.367	0.273	11	3	10.50	Z	D6	—	**7350506**
12		1.75	110	23	–	0.367	0.273	11	3	10.30	Y	D6	**7350497**	—
	14	1.50	100	21	–	0.429	0.320	13	3	12.50	31/64	D7	—	**7350507**
14		2.00	110	23	–	0.429	0.320	13	3	12.00	15/32	D7	**7350498**	—
	16	1.50	100	21	–	0.480	0.358	14	3	14.50	9/16	D7	—	**7350508**
16		2.00	110	23	–	0.480	0.358	14	3	14.00	35/64	D7	**7350499**	—
	18	1.50	110	24	–	0.542	0.404	16	3	16.50	41/64	D7	—	**7350509**
18		2.50	125	30	–	0.542	0.404	16	3	15.50	39/64	D7	**7350500**	—
20		2.50	140	30	–	0.652	0.487	18	3	17.50	11/16	D7	**7350501**	—
24		3.00	160	38	–	0.760	0.567	19	4	21.00	53/64	D8	**7350502**	—

Note: Sizes up to M10 have male centers on both ends • Sizes over M10 have female centers on both ends.

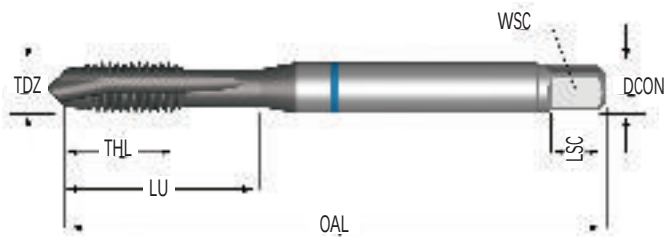
DIN ANSI Machine Tap, Blue Shark for Stainless Steel

	P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1	M2.2
E629 E769	◩79	◩89	◩92	◩66	◩59	◩52	◩49	◩39	◩33	◩30	◩23	■62	■52	■56	■46
	M3.1	M3.2	M3.3	M4.1											
	■39	■33	■30	■20											

E629 / E769

Designed for superior performance through hole tapping in a wide range of Stainless Steel types. Premium HSCo Powder Metal substrate with Super-B (TiAlN+WC/C) Coating combined with an additional edge treatment to offer improved thread quality and longer tool life. Available in both 2B and 3B Class of Fit to cover a wide range of applications.

DORMER



E629	E769
M	MF
DIN ANSI	DIN ANSI
6H	6H
2.5xD	2.5xD
HSS-E PM	HSS-E PM
3.5-5	3.5-5
	
M4 – M24	M8 – M18

Pack Qty = 1 pc

TDZ M	TDZ MF	P [mm]	OAL [mm]	THL [mm]	LU [mm]	DCON [inch]	WSC [inch]	LSC [inch]	NOF [-]	[mm]	[inch]	Limits	E629	E769
4		0.70	63	12	21	0.168	0.129	6	3	3.30	N30	D4	**7350317**	—
5		0.80	70	13	25	0.194	0.150	6	3	4.20	N19	D4	**7350318**	—
6		1.00	80	15	30	0.255	0.189	8	3	5.00	N9	D5	**7350319**	—
	8	1.00	90	18	35	0.318	0.236	10	3	7.00	J	D5	—	**7350328**
8		1.25	90	18	35	0.318	0.236	10	3	6.80	H	D5	**7350320**	—
	10	1.25	100	20	39	0.381	0.284	11	3	8.80	11/32	D6	—	**7350329**
10		1.50	100	20	39	0.381	0.284	11	3	8.50	Q	D6	**7350321**	—
	12	1.25	100	21	–	0.367	0.273	11	4	10.80	27/64	D6	—	**7350330**
	12	1.50	100	21	–	0.367	0.273	11	4	10.50	Z	D6	—	**7350331**
12		1.75	110	23	–	0.367	0.273	11	4	10.30	Y	D6	**7350322**	—
	14	1.50	100	21	–	0.429	0.320	13	4	12.50	31/64	D7	—	**7350332**
14		2.00	110	23	–	0.429	0.320	13	4	12.00	15/32	D7	**7350323**	—
	16	1.50	100	21	–	0.480	0.358	14	4	14.50	9/16	D7	—	**7350333**
16		2.00	110	23	–	0.480	0.358	14	4	14.00	35/64	D7	**7350324**	—
	18	1.50	110	24	–	0.542	0.404	16	4	16.50	41/64	D7	—	**7350334**
18		2.50	125	30	–	0.542	0.404	16	4	15.50	39/64	D7	**7350325**	—
20		2.50	140	30	–	0.652	0.487	18	4	17.50	11/16	D7	**7350326**	—
24		3.00	160	38	–	0.760	0.567	19	4	21.00	53/64	D8	**7350327**	—

Note: Sizes up to M10 have male centers on both ends • Sizes over M10 have female centers on both ends.

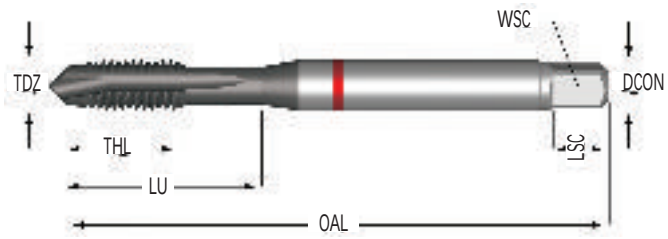
DIN ANSI Machine Tap, Red Shark for Alloy Steels

	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	S1.2	S2.1	S3.1	S4.1				
E627															
E767	■79	■82	■66	■56	■49	■43	◪33	◪10	◪13	◪10	◪7				

E627 / E767

Designed for high performance through hole tapping in most medium Alloy Steels. The TiAlN-Top Coat ng combined with an addi t onal edge treatment provides excellent performance and consistency in high produc t on applica t ons.

DORMER



E627	E767
M	MF
DIN ANSI	DIN ANSI
6H	6H
2.5xD	2.5xD
HSS-E PM	HSS-E PM
3.5-5	3.5-5
	
M3 – M24	M8 – M14

Pack Qty = 1 pc

TDZ M	TDZ MF	P [mm]	OAL [mm]	THL [mm]	LU [mm]	DCON [inch]	◪ WSC [inch]	LSC [inch]	3 NOF [-]	[mm]	[inch]	Limits	E627	E767
3		0.50	56	9	18	0.141	0.108	5	3	2.50	N40	D3	**7350414**	—
4		0.70	63	12	21	0.168	0.129	6	3	3.30	N30	D4	**7350415**	—
5		0.80	70	13	25	0.194	0.150	6	3	4.20	N19	D4	**7350416**	—
6		1.00	80	15	30	0.255	0.189	8	3	5.00	N9	D5	**7350417**	—
	8	1.00	90	18	35	0.318	0.236	10	3	7.00	J	D5	—	**7350426**
8		1.25	90	18	35	0.318	0.236	10	3	6.80	H	D5	**7350418**	—
	10	1.25	100	20	39	0.381	0.284	11	3	8.80	11/32	D6	—	**7350427**
10		1.50	100	20	39	0.381	0.284	11	3	8.50	Q	D6	**7350419**	—
	12	1.50	100	21	–	0.367	0.273	11	3	10.50	Z	D6	—	**7350428**
12		1.75	110	23	–	0.367	0.273	11	3	10.30	Y	D6	**7350420**	—
	14	1.50	100	21	–	0.429	0.320	13	3	12.50	31/64	D7	—	**7350429**
14		2.00	110	23	–	0.429	0.320	13	3	12.00	15/32	D7	**7350421**	—
16		2.00	110	23	–	0.480	0.358	14	3	14.00	35/64	D7	**7350422**	—
18		2.50	125	30	–	0.542	0.404	16	4	15.50	39/64	D7	**7350423**	—
20		2.50	140	30	–	0.652	0.487	18	4	17.50	11/16	D7	**7350424**	—
24		3.00	160	38	–	0.760	0.567	19	4	21.00	53/64	D8	**7350425**	—

Note: Sizes up to M10 have male centers on both ends • Sizes over M10 have female centers on both ends.

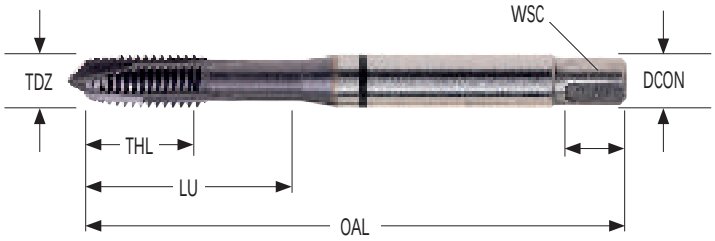
DIN-ANSI Machine Tap Black Shark for Hard Alloys, Plug Style

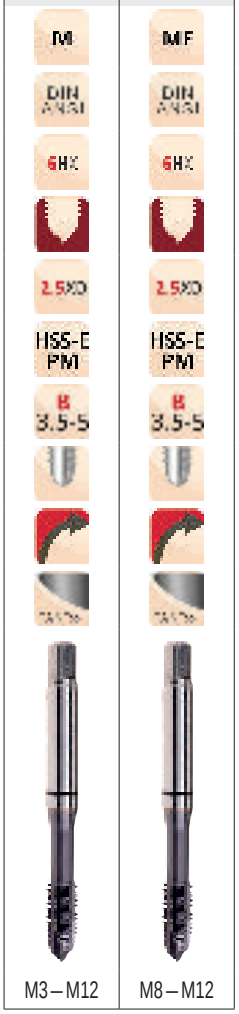
	P3.2	P3.3	P4.3	S1.2	S1.3	S3.1	S3.2	H3.1							
E817															
E917	■55	■42	■32	■42	■26	■16	■10	◪22							

E817 / E917

Designed for high performance through hole tapping in high strength and heat resistant work-materials with hardness up to 45HRC. The TiAlN-Top coating combined with geometry that significantly increases cutting edge strength, provides excellent performance and consistency in hard and difficult to machine materials.

DORMER





Pack Qty = 1 pc

TDZ M	TDZ MF	P	OAL	THL	LU	DCON	◪ WSC	LSC	NOF			Limits	E817	E917
		[mm]	[mm]	[mm]	[mm]	[inch]	[inch]	[inch]	[-]	[mm]	[inch]			
3		0.50	63	15	22	0.168	0.129	6	3	2.50	N40	D3	**7812115**	—
4		0.70	70	16	28	0.194	0.150	6	3	3.30	N30	D4	**7812116**	—
5		0.80	80	17	26	0.255	0.189	8	3	4.20	N19	D4	**7812117**	—
6		1.00	90	21	35	0.318	0.236	10	3	5.00	N9	D5	**7812118**	—
8		1.25	100	23	39	0.381	0.284	11	3	6.80	H	D5	**7812119**	—
	8	1.00	100	23	39	0.381	0.284	11	3	7.00	J	D5	—	**7812122**
10		1.50	100	20	38	0.381	0.284	11	3	8.50	Q	D6	**7812120**	—
	10	1.25	100	20	38	0.381	0.284	11	3	8.80	11/32	D5		**7812123**
12		1.75	110	23	-	0.367	0.273	11	4	10.30	Y	D6	**7812121**	—
	12	1.25	110	23	-	0.367	0.273	11	4	10.80	27/64	D5	—	**7812124**
	12	1.50	110	23	-	0.367	0.273	11	4	10.50	Z	D5	—	**7812125**

Note: Sizes up to M10 have male centers on both ends • Sizes over M10 have female centers on both ends.

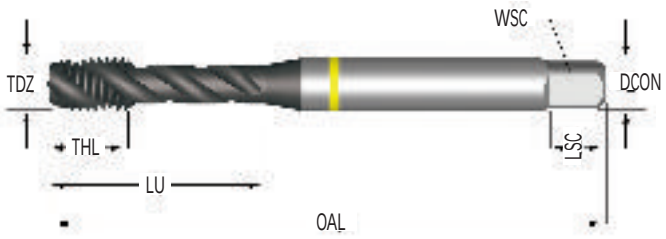
DIN ANSI Machine Tap, Yellow for Low Alloy Steels

	P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	N3.1	N3.2	N3.3
E808 **E908**	■102	◪112	■115	■85	■75	◪66	◪62	◪49	◪43	◪36	◪33	■167	◪98	■49

E808 / E908

Designed for blind hole tapping in low Alloy Steel applica t ons. Premium HSCo Powder Metal substrate with TiAlN-Top Coa t ng combined with a special 40° Spiral Flute geometry prevents nes t ng and reduces the risk of re-cu t ng chips on reversal allowing taps to operate at higher speeds while providing improved thread quality.

DORMER



E808	E908
UNC	UNF
DIN ANSI	DIN ANSI
2B	2B
2XD	2XD
HSS-E PM	HSS-E PM
C 2-3	C 2-3
40°	40°
	
No.4 – 1“	No.10 – 1“

Pack Qty = 1 pc

TDZ UNC	TDZ UNF	TPI	OAL	THL	LU	DCON	WSC	LSC	NOF			Limits	E808	E908
		[inch]	[inch]	[inch]	[inch]	[inch]	[inch]	[inch]	[-]	[mm]	[inch]			
4		40	2.205	0.256	0.709	0.141	0.108	0.236	3	2.35	N43	H2	**7350510**	—
6		32	2.205	0.256	0.787	0.141	0.108	0.190	3	2.85	N36	H2	**7350511**	—
8		32	2.480	0.276	0.827	0.168	0.129	0.250	3	3.50	N29	H3	**7350512**	—
10		24	2.756	0.315	1.102	0.194	0.150	0.250	3	3.90	N25	H3	**7350513**	—
	10	32	2.756	0.315	1.102	0.194	0.150	0.250	3	4.10	N21	H3	—	**7350523**
1/4		20	3.150	0.394	0.984	0.255	0.189	0.310	3	5.10	N7	H5	**7350514**	—
	1/4	28	3.150	0.394	0.984	0.255	0.189	0.310	3	5.50	N3	H4	—	**7350524**
5/16		18	3.543	0.472	1.339	0.318	0.236	0.380	3	6.60	F	H5	**7350515**	—
	5/16	24	3.543	0.472	1.339	0.318	0.236	0.380	3	6.90	I	H4	—	**7350525**
3/8		16	3.937	0.591	1.535	0.381	0.284	0.440	3	8.00	5/16	H4	**7350516**	—
	3/8	24	3.543	0.591	1.476	0.381	0.284	0.440	3	8.50	Q	H4	—	**7350526**
7/16		14	3.937	0.591	–	0.323	0.240	0.410	3	9.40	U	H5	**7350517**	—
	7/16	20	3.937	0.591	–	0.323	0.240	0.410	3	9.90	25/64	H5	—	**7350527**
1/2		13	4.331	0.709	–	0.367	0.273	0.440	3	10.80	27/64	H5	**7350518**	—
	1/2	20	3.937	0.709	–	0.367	0.273	0.440	3	11.50	29/64	H5	—	**7350528**
5/8		11	4.331	0.787	–	0.480	0.358	0.560	4	13.50	17/32	H5	**7350519**	—
	5/8	18	3.937	0.591	–	0.480	0.358	0.560	4	14.50	37/64	H5	—	**7350529**
3/4		10	4.921	0.984	–	0.590	0.439	0.690	4	16.50	21/32	H5	**7350520**	—
	3/4	16	4.331	0.984	–	0.590	0.439	0.690	4	17.50	11/16	H5	—	**7350530**
7/8		9	5.512	0.984	–	0.697	0.520	0.750	4	19.50	49/64	H6	**7350521**	—
	7/8	14	4.921	0.984	–	0.697	0.520	0.750	4	20.40	13/16	H6	—	**7350531**
1“		8	6.299	1.181	–	0.800	0.597	0.810	4	22.25	7/8	H6	**7350522**	—
	1“	12	5.512	1.063	–	0.800	0.597	0.810	4	23.25	59/64	H6	—	**7350532**

Note: Sizes up to 3/8” have male centers on both ends • Sizes over 3/8” have female centers on both ends.

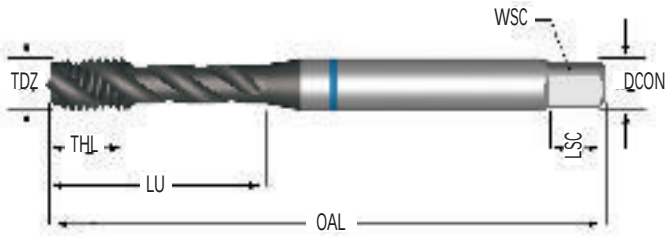
DIN ANSI Machine Tap, Blue Shark for Stainless Steel

	P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1	M2.2
E812	◩79	◩89	◩92	◩66	◩59	◩52	◩49	◩39	◩33	◩30	◩23	■62	■52	■56	■46
E912	M3.1	M3.2	M3.3	M4.1											
	■39	■33	■30	■20											

E812 / E912

Designed for superior performance blind hole tapping in a wide range of Stainless Steel types. Premium HSCo Powder Metal substrate with Super-B (TiAlN+WC/C) Coat ng combined with an addi t onal edge treatment and a 40° Flute angle facilitates be t er chip evacua t on o f ering improved thread quality and longer tool life. Available in both 2B and 3B Class of Fit to cover a wide range of applica t ons.

DORMER



E812	E912
UNC	UNF
DIN ANSI	DIN ANSI
3B 3D	3B 3D
2.5xD	2.5xD
HSS-E PM	HSS-E PM
C 2-3	C 2-3
40°	40°
	
No.4 – 1“	No.10 – 1“

Pack Qty = 1 pc

TDZ UNC	TDZ UNF	TPI	OAL	THL	LU	DCON	WSC	LSC	NOF			Limits	E812	E912
		[inch]	[inch]	[inch]	[inch]	[inch]	[inch]	[inch]	[-]	[mm]	[inch]			
4		40	2.205	0.256	0.709	0.141	0.108	0.236	3	2.35	N43	H2	—	—
6		32	2.205	0.256	0.787	0.141	0.108	0.190	3	2.80	N36	H3	**7350336**	—
8		32	2.480	0.276	0.827	0.168	0.129	0.250	3	3.50	N29	H3	**7350337**	—
10		24	2.756	0.315	1.102	0.194	0.150	0.250	3	3.90	N25	H3	**7350338**	—
	10	32	2.756	0.315	1.102	0.194	0.150	0.250	3	4.10	N21	H3	—	**7350356**
1/4		20	3.150	0.394	0.984	0.255	0.189	0.310	3	5.10	N7	H5	**7350339**	—
1/4		20	3.150	0.394	0.984	0.255	0.189	0.310	3	5.10	N7	H3	**7350340**	—
	1/4	28	3.150	0.394	0.984	0.255	0.189	0.310	3	5.50	N3	H5	—	**7350357**
	1/4	28	3.150	0.394	0.984	0.255	0.189	0.310	3	5.50	N3	H3	—	**7350358**
5/16		18	3.543	0.472	1.339	0.318	0.236	0.380	3	6.60	F	H5	**7350341**	—
5/16		18	3.543	0.472	1.339	0.318	0.236	0.380	3	6.60	F	H3	**7350342**	—
	5/16	24	3.543	0.472	1.339	0.318	0.236	0.380	3	6.90	I	H4	—	**7350359**
	5/16	24	3.543	0.472	1.339	0.318	0.236	0.380	3	6.90	I	H3	—	**7350360**
3/8		16	3.937	0.591	1.535	0.381	0.284	0.440	3	8.00	5/16	H5	**7350343**	—
3/8		16	3.937	0.591	1.535	0.381	0.284	0.440	3	8.00	5/16	H3	**7350344**	—
	3/8	24	3.543	0.591	1.476	0.318	0.284	0.440	3	8.50	Q	H4	—	**7350361**
	3/8	24	3.543	0.591	1.476	0.318	0.284	0.440	3	8.50	Q	H3	—	**7350362**
7/16		14	3.937	0.591	–	0.323	0.240	0.410	4	9.40	U	H5	**7350345**	—
	7/16	20	3.937	0.591	–	0.323	0.240	0.410	4	9.90	25/64	H5	—	**7350363**

TDZ UNC	TDZ UNF	TPI	OAL	THL	LU	DCON	WSC	LSC	NOF			Limits	E812	E912
		[inch]	[inch]	[inch]	[inch]	[inch]	[inch]	[inch]	[-]	[mm]	[inch]			
1/2		13	4.331	0.709	–	0.367	0.273	0.440	4	10.70	27/64	H5	**7350346**	—
1/2		13	4.331	0.709	–	0.367	0.273	0.440	4	10.70	27/64	H3	**7350347**	—
	1/2	20	3.937	0.709	–	0.367	0.273	0.440	4	11.50	29/64	H5	—	**7350364**
	1/2	20	3.937	0.709	–	0.367	0.273	0.440	4	11.50	29/64	H3	—	**7350365**
5/8		11	4.331	0.787	–	0.480	0.358	0.560	4	13.50	17/32	H5	**7350348**	—
5/8		11	4.331	0.787	–	0.480	0.358	0.560	4	13.50	17/32	H3	**7350349**	—
	5/8	18	3.937	0.591	–	0.480	0.358	0.560	4	14.50	37/64	H5	—	**7350366**
	5/8	18	3.937	0.591	–	0.480	0.358	0.560	4	14.50	37/64	H3	—	**7350367**
3/4		10	4.921	0.984	–	0.590	0.439	0.690	4	16.50	21/32	H5	**7350350**	—
3/4		10	4.921	0.984	–	0.590	0.439	0.690	4	16.50	21/32	H3	**7350351**	—
	3/4	16	4.331	0.984	–	0.590	0.439	0.690	4	17.50	11/16	H5	—	**7350368**
	3/4	16	4.331	0.984	–	0.590	0.439	0.690	4	17.50	11/16	H3	—	**7350369**
7/8		9	5.512	0.984	–	0.697	0.520	0.750	4	19.50	49/64	H6	**7350352**	—
7/8		9	5.512	0.984	–	0.697	0.520	0.750	4	19.50	49/64	H4	**7350353**	—
	7/8	14	4.921	0.984	–	0.697	0.520	0.750	4	20.40	13/16	H6	—	**7350370**
	7/8	14	4.921	0.984	–	0.697	0.520	0.750	4	20.40	13/16	H4	—	**7350371**
1“		8	6.299	1.181	–	0.800	0.597	0.810	4	22.25	7/8	H6	**7350354**	—
1“		8	6.299	1.181	–	0.800	0.597	0.810	4	22.25	7/8	H4	**7350355**	—
	1“	12	5.512	1.063	–	0.800	0.597	0.810	4	23.25	59/64	H6	—	**7350372**
	1“	12	5.512	1.063	–	0.800	0.597	0.810	4	23.25	59/64	H4	—	**7350373**

Note: Sizes up to 3/8” have male centers on both ends • Sizes over 3/8” have female centers on both ends.

DIN ANSI Machine Tap, Red Shark for Alloy Steels

	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	S1.2	S2.1	S3.1	S4.1				
E810															
E910	■79	■82	■66	■56	■49	■43	◪33	◪10	◪13	◪10	◪7				

E810 / E910

Designed for high performance blind hole tapping in most medium Alloy Steels. The TiAlN-Top Coating combined with a special 45° Flute Geometry and an additional edge treatment provides excellent performance and consistency in high production applications. The back taper built into this design further facilitates chip evacuation and reduces torque when the tap reverses. It is recommended to use a toolholder with minimal float or soft start.

DORMER

E810	E910
UNC	UNF
DIN ANSI	DIN ANSI
2B	2B
2.5xD	2.5xD
HSS-E PM	HSS-E PM
C 2-3	C 2-3
45°	45°
	
No.4 – 1“	No.10 – 1“

Pack Qty = 1 pc

TDZ UNC	TDZ UNF	TPI	OAL	THL	LU	DCON	WSC	LSC	NOF			Limits	E810	E910
		[inch]	[inch]	[inch]	[inch]	[inch]	[inch]	[inch]	[-]	[mm]	[inch]			
4		40	2.205	0.256	0.709	0.141	0.108	0.236	3	2.35	N43	H2	**7350430**	—
6		32	2.205	0.256	0.787	0.141	0.108	0.190	3	2.85	N36	H2	**7350431**	—
8		32	2.480	0.276	0.827	0.168	0.129	0.250	3	3.50	N29	H3	**7350432**	—
10		24	2.756	0.315	1.102	0.194	0.150	0.250	3	3.90	N25	H3	**7350433**	—
	10	32	2.756	0.315	1.102	0.194	0.150	0.250	3	4.10	N21	H3	—	**7350443**
1/4		20	3.150	0.394	0.984	0.255	0.189	0.310	3	5.10	N7	H5	**7350434**	—
	1/4	28	3.150	0.394	0.984	0.255	0.189	0.310	3	5.50	N3	H4	—	**7350444**
5/16		18	3.543	0.472	1.339	0.318	0.236	0.380	3	6.60	F	H5	**7350435**	—
	5/16	24	3.543	0.472	1.339	0.318	0.236	0.380	3	6.9	I	H4	—	**7350445**
3/8		16	3.937	0.591	1.535	0.381	0.284	0.440	3	8.00	5/16	H4	**7350436**	—
	3/8	24	3.543	0.591	1.476	0.381	0.284	0.440	3	8.50	Q	H4	—	**7350446**
7/16		14	3.937	0.591	–	0.323	0.240	0.410	3	9.40	U	H5	**7350437**	—
	7/16	20	3.937	0.591	–	0.323	0.240	0.410	3	9.90	25/64	H5	—	**7350447**
1/2		13	4.331	0.709	–	0.367	0.273	0.440	3	10.80	27/64	H5	**7350438**	—
	1/2	20	3.937	0.709	–	0.367	0.273	0.440	3	11.50	29/64	H5	—	**7350448**
5/8		11	4.331	0.787	–	0.480	0.358	0.560	4	13.50	17/32	H5	**7350439**	—
	5/8	18	3.937	0.591	–	0.480	0.358	0.560	4	14.50	37/64	H5	—	**7350449**
3/4		10	4.921	0.984	–	0.590	0.439	0.690	4	16.50	21/32	H5	**7350440**	—
	3/4	16	4.331	0.984	–	0.590	0.439	0.690	4	17.50	11/16	H5	—	**7350450**
7/8		9	5.512	0.984	–	0.697	0.520	0.750	4	19.50	49/64	H6	**7350441**	—
	7/8	14	4.921	0.984	–	0.697	0.520	0.750	4	20.40	13/16	H6	—	**7350451**
1“		8	6.299	1.181	–	0.800	0.597	0.810	4	22.25	7/8	H6	**7350442**	
	1“	12	5.512	1.063	–	0.800	0.597	0.810	4	23.25	59/64	H6	—	**7350452**

Note: Sizes up to 3/8” have male centers on both ends • Sizes over 3/8” have female centers on both ends.

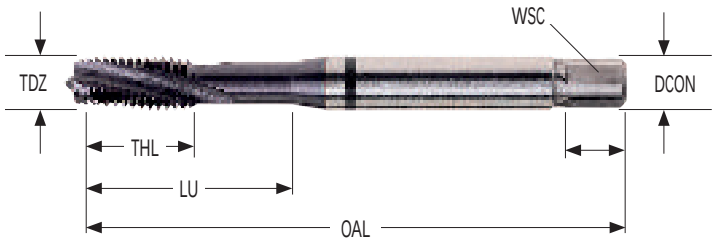
DIN-ANSI Machine Tap Black Shark for Hard Alloys, Spiral Flute

	P3.2	P3.3	P4.3	S1.2	S1.3	S3.1	S3.2	H3.1							
E805 E905	■55	■42	■32	■42	■26	■16	■10	◪22							

E805 / E905

Designed for high performance blind hole tapping in high strength and heat-resistant work-materials with hardness up to 45HRC. The TiAlN-Top coating combined with geometry what significantly increases cutting edge strength, provides excellent performance and consistency in hard and difficult to machine materials.

DORMER



E805	E905
UNC	UNF
DIN ANSI	DIN ANSI
2b/6	2b/6
1.5xD	1.5xD
HSS-E PM	HSS-E PM
2-3	2-3
15°	15°
	
No.4 – 3/4	No.10 – 3/4

Pack Qty = 1 pc

TDZ UNC	TDZ UNF	TPI	OAL	THL	LU	DCON	WSC	LSC	NOF			Limits	E805	E905
		[inch]	[inch]	[inch]	[inch]	[inch]	[inch]	[inch]	[-]	[mm]	[inch]			
4		40	2.205	0.472	0.827	0.141	0.108	0.190	3	2.35	N43	H2	**7812126**	—
6		32	2.480	0.551	0.866	0.168	0.129	0.250	3	2.85	N36	H2	**7812127**	—
8		32	2.756	0.610	1.102	0.194	0.150	0.250	3	3.50	N29	H3	**7812128**	—
10		24	3.150	0.669	1.024	0.255	0.189	0.310	3	3.90	N25	H3	**7812129**	—
	10	32	3.150	0.669	1.024	0.255	0.189	0.310	3	4.10	N21	H3	—	**7812137**
1/4		20	3.543	0.807	1.378	0.318	0.236	0.380	3	5.10	N7	H5	**7812130**	—
	1/4	28	3.543	0.807	1.339	0.318	0.236	0.380	3	5.50	N3	H4	—	**7812138**
5/16		18	3.937	0.906	1.535	0.381	0.236	0.440	3	6.60	F	H5	**7812131**	—
	5/16	24	3.937	0.906	1.535	0.381	0.284	0.440	3	6.90	I	H4	—	**7812139**
3/8		16	3.937	0.787	1.535	0.381	0.236	0.440	3	8.00	5/16	H5	**7812132**	—
	3/8	24	3.937	0.787	1.535	0.381	0.284	0.440	3	8.50	Q	H4	—	**7812140**
7/16		14	3.937	0.787	-	0.323	0.240	0.410	4	9.40	U	H5	**7812133**	—
	7/16	20	3.937	0.787	-	0.325	0.240	0.440	4	9.90	25/64	H5	—	**7812140**
1/2		13	4.331	0.906	-	0.367	0.273	0.440	4	10.80	27/64	H5	**7812134**	—
	1/2	20	4.331	0.906	-	0.367	0.273	0.440	4	11.50	29/64	H5	—	**7812142**
5/8		11	4.331	0.906	-	0.480	0.358	0.560	4	13.50	17/32	H5	**7812135**	—
	5/8	18	4.331	0.906	-	0.480	0.358	0.560	4	14.50	37/64	H5	—	**7812143**
3/4		10	4.921	1.181	-	0.590	0.440	0.690	4	16.50	21/32	H5	**7812136**	—
	3/4	16	4.921	1.181	-	0.590	0.440	0.690	4	17.50	11/16	H5	—	**7812144**

Note: Sizes up to 3/8" have male centers on both ends • Sizes over 3/8" have female centers on both ends.

DIN ANSI Machine Tap, Yellow for Low Alloy Steels

	P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	N3.1	N3.2	N3.3
E624 / E764	■102	◪112	■115	■85	■75	◪66	◪62	◪49	◪43	◪36	◪33	■167	◪98	■49

E624 / E764

Designed for blind hole tapping in low Alloy Steel applica t ons. Premium HSCo Powder Metal substrate with TiAlN-Top Coa t ng combined with a special 40° Spiral Flute geometry prevents nes t ng and reduces the risk of re-cu t ng chips on reversal allowing taps to operate at higher speeds while providing improved thread quality.

DORMER

E624	E764
M	MF
DIN ANSI	DIN ANSI
6H	6H
2XD	2XD
HSS-E PM	HSS-E PM
C 2-3	C 2-3
40°	40°
	
M4 – M24	M8 – M18

Pack Qty = 1 pc

TDZ M	TDZ MF	P [mm]	OAL [mm]	THL [mm]	LU [mm]	DCON [inch]	WSC [inch]	LSC [inch]	NOF [-]	[mm]	[inch]	Limits	E624	E764
4		0.70	63	7	21	0.168	0.129	6	3	3.30	N30	D4	**7350533**	—
5		0.80	70	8	25	0.194	0.150	6	3	4.20	N19	D4	**7350534**	—
6		1.00	80	10	30	0.255	0.189	8	3	5.00	N9	D5	**7350535**	—
	8	1.00	90	13	35	0.318	0.236	10	3	7.00	J	D5	—	**7350544**
8		1.25	90	13	35	0.318	0.236	10	3	6.80	H	D5	**7350536**	
	10	1.25	100	15	39	0.381	0.284	11	3	8.80	11/32	D6	—	**7350545**
10		1.50	100	15	39	0.381	0.284	11	3	8.50	Q	D6	**7350537**	—
	12	1.25	100	15	–	0.367	0.273	11	3	10.80	27/64	D6	—	**7350546**
	12	1.50	100	15	–	0.367	0.273	11	3	10.50	Z	D6	—	**7350547**
12		1.75	110	18	–	0.367	0.273	11	3	10.30	Y	D6	**7350538**	—
	14	1.50	100	15	–	0.429	0.320	13	3	12.50	31/64	D7	—	**7350548**
14		2.00	110	20	–	0.429	0.320	13	3	12.00	15/32	D7	**7350539**	—
	16	1.50	100	15	–	0.480	0.358	14	4	14.50	9/16	D7	—	**7350549**
16		2.00	110	20	–	0.480	0.358	14	4	14.00	35/64	D7	**7350540**	—
	18	1.50	110	17	–	0.542	0.404	16	4	16.50	41/64	D7	—	**7350550**
18		2.50	125	25	–	0.542	0.404	16	4	15.50	39/64	D7	**7350541**	—
20		2.50	140	25	–	0.652	0.487	18	4	17.50	11/16	D7	**7350542**	—
24		3.00	160	30	–	0.760	0.567	19	4	21.00	53/64	D8	**7350543**	—

Note: Sizes up to M10 have male centers on both ends • Sizes over M10 have female centers on both ends.

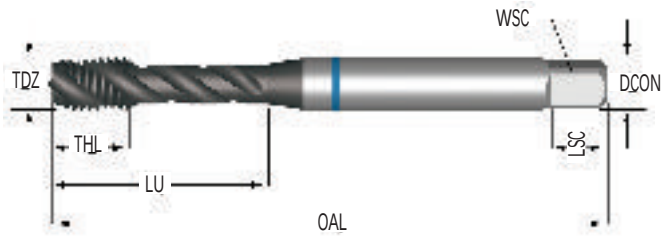
DIN ANSI Machine Tap, Blue Shark for Stainless Steel

	P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1	M2.2
E628 E768	◪79	◪89	◪92	◪66	◪59	◪52	◪49	◪39	◪33	◪30	◪23	■62	■52	■56	■46
	M3.1	M3.2	M3.3	M4.1											
	■39	■33	■30	■20											

E628 / E768

Designed for superior performance blind hole tapping in a wide range of Stainless Steel types. Premium HSCo Powder Metal substrate with Super-B (TiAlN+WC/C) Coat ng combined with an addi t onal edge treatment and a 40° Flute angle facilitates be t er chip evacua t on o f ering improved thread quality and longer tool life. Available in both 2B and 3B Class of Fit to cover a wide range of applica t ons.

DORMER



E628	E768
M	MF
DIN ANSI	DIN ANSI
6H	6H
2.5xD	2.5xD
HSS-E PM	HSS-E PM
2-3	2-3
40°	40°
M4 – M24	M8 – M18

Pack Qty = 1 pc

TDZ M	TDZ MF	P	OAL	THL	LU	DCON	WSC	LSC	NOF			Limits	E628	E768
		[mm]	[mm]	[mm]	[mm]	[inch]	[inch]	[inch]	[-]	[mm]	[inch]			
4		0.70	63	7	21	0.168	0.129	6	3	3.30	N30	D4	**7350374**	—
5		0.80	70	8	25	0.194	0.150	6	3	4.20	N19	D4	**7350375**	—
6		1.00	80	10	30	0.255	0.189	8	3	5.00	N9	D5	**7350376**	—
	8	1.00	90	13	35	0.318	0.236	10	3	7.00	J	D5	—	**7350385**
8		1.25	90	13	35	0.318	0.236	10	3	6.80	H	D5	**7350377**	
	10	1.25	100	15	39	0.381	0.284	11	3	8.80	11/32	D6	—	**7350386**
10		1.50	100	15	39	0.381	0.284	11	3	8.50	Q	D6	**7350378**	—
	12	1.50	100	15	–	0.367	0.273	11	4	10.50	Z	D6	—	**7350387**
12		1.75	110	18	–	0.367	0.273	11	4	10.30	Y	D6	**7350379**	—
	14	1.50	100	15	–	0.429	0.320	13	4	12.50	31/64	D7	—	**7350388**
14		2.00	110	20	–	0.429	0.320	13	4	12.00	15/32	D7	**7350380**	—
	16	1.50	100	15	–	0.480	0.358	14	4	14.50	9/16	D7	—	**7350389**
16		2.00	110	20	–	0.480	0.358	14	4	14.00	35/64	D7	**7350381**	—
	18	1.50	110	17	–	0.542	0.404	16	4	16.50	41/64	D7	—	**7350390**
18		2.50	125	25	–	0.542	0.404	16	4	15.50	39/64	D7	**7350382**	—
20		2.50	140	25	–	0.652	0.487	18	4	17.50	11/16	D7	**7350383**	—
24		3.00	160	30	–	0.760	0.567	19	4	21.00	53/64	D8	**7350384**	—

Note: Sizes up to M10 have male centers on both ends • Sizes over M10 have female centers on both ends.

DIN ANSI Machine Tap, Red Shark for Alloy Steels

	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	S1.2	S2.1	S3.1	S4.1				
E626															
E766	■94	■95	■79	■66	■59	■49	◪39	◪10	◪13	◪10	◪7				

E626 / E766

Designed for high performance blind hole tapping in most medium Alloy Steels. The TiAlN-Top Coating combined with a special 45° Flute Geometry and an additional edge treatment provides excellent performance and consistency in high production applications. The back taper built into this design further facilitates chip evacuation and reduces torque when the tap reverses. It is recommended to use a toolholder with minimal float or soft start.

DORMER

E626	E766
M	MF
DIN ANSI	DIN ANSI
6H	6H
2.5xD	2.5xD
HSS-E PM	HSS-E PM
C 2-3	C 2-3
45°	45°
TiAlN	TiAlN
M3 – M24	M8 – M14

Pack Qty = 1 pc

TDZ M	TDZ MF	P	OAL	THL	LU	DCON	WSC	LSC	NOF			Limits	E626	E766
		[mm]	[mm]	[mm]	[mm]	[inch]	[inch]	[inch]	[-]	[mm]	[inch]			
3		0.50	56	6	18	0.141	0.108	5	3	2.50	N40	D3	**7350453**	—
4		0.70	63	7	21	0.168	0.129	6	3	3.30	N30	D4	**7350454**	—
5		0.80	70	8	25	0.194	0.150	6	3	4.20	N19	D4	**7350455**	—
6		1.00	80	10	30	0.255	0.189	8	3	5.00	N9	D5	**7350456**	—
	8	1.00	90	13	35	0.318	0.236	10	3	7.00	J	D5	—	**7350465**
8		1.25	90	13	35	0.318	0.236	10	3	6.80	H	D5	**7350457**	—
	10	1.25	100	15	39	0.381	0.284	11	3	8.80	11/32	D6	—	**7350466**
10		1.50	100	15	39	0.381	0.284	11	3	8.50	Q	D6	**7350458**	—
	12	1.25	100	15	–	0.367	0.273	11	3	10.80	27/64	D6	—	**7350467**
12		1.75	110	18	–	0.367	0.273	11	3	10.30	Y	D6	**7350459**	—
	14	1.50	100	15	–	0.429	0.320	13	3	12.50	31/64	D7	—	**7350468**
14		2.00	110	20	–	0.429	0.320	13	3	12.00	15/32	D7	**7350460**	—
16		2.00	110	20	–	0.480	0.358	14	4	14.00	35/64	D7	**7350461**	—
18		2.50	125	25	–	0.542	0.404	16	4	15.50	39/64	D7	**7350462**	—
20		2.50	140	25	–	0.652	0.487	18	4	17.50	11/16	D7	**7350463**	—
24		3.00	160	30	–	0.760	0.567	19	4	21.00	53/64	D8	**7350464**	—

Note: Sizes up to M10 have male centers on both ends • Sizes over M10 have female centers on both ends.

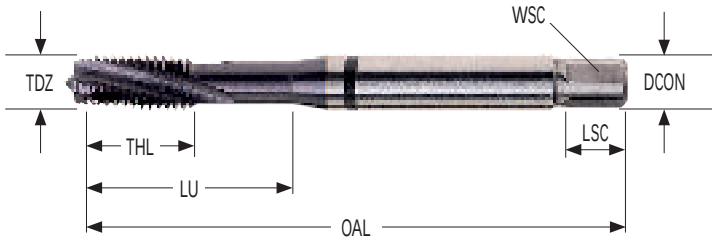
DIN-ANSI Machine Tap Black Shark for Hard Alloys, Spiral Flute

	P3.2	P3.3	P4.3	S1.2	S1.3	S3.1	S3.2	H3.1							
E805 / E905	■55	■42	■32	■42	■26	■16	■10	◪22							

E806 / E906

Designed for high performance blind hole tapping in high strength and heat-resistant work-materials with hardness up to 45HRC. The TiAlN-Top coating combined with geometry what significantly increases cutting edge strength, provides excellent performance and consistency in hard and difficult to machine materials.

DORMER



Pack Qty = 1 pc

TDZ M	TDZ MF	P [mm]	OAL [mm]	THL [mm]	LU [mm]	DCON [inch]	WSC [inch]	LSC [inch]	NOF [-]	[mm]	[inch]	Limits	E806	E906
3		0.50	63	15	22	0.168	0.129	6	3	2.50	N40	D3	**7812145**	—
4		0.70	70	16	28	0.194	0.150	6	3	3.30	N30	D4	**7812146**	—
5		0.80	80	17	26	0.255	0.189	8	3	4.20	N19	D4	**7812147**	—
6		1.00	90	21	35	0.318	0.236	10	3	5.00	N9	D5	**7812148**	—
8		1.25	100	23	39	0.381	0.284	11	3	6.80	H	D5	**7812149**	—
	8	1.00	100	23	39	0.381	0.284	11	3	7.00	J	D5	—	**7812152**
10		1.50	100	20	38	0.381	0.284	11	3	8.50	Q	D6	**7812150**	—
12		1.75	110	23	-	0.367	0.273	11	4	10.30	Y	D6	**7812151**	—
	10	1.25	100	20	38	0.381	0.284	11	3	8.80	11/32	D5	—	**7812153**
	12	1.25	110	23	-	0.367	0.273	11	4	10.80	27/64	D5	—	**7812155**
	12	1.50	110	23	-	0.367	0.273	11	4	10.50	Z	D5	—	**7812154**

Note: Sizes up to M10 have male centers on both ends • Sizes over M10 have female centers on both ends.

Icon descriptions

Thread form	 Unified Coarse	 Unified Fine	 Metric coarse	 Metric fine	
Standard					
Tolerance					
Hole Type	 Through hole	 Blind hole	 Through or blind hole		
Depth					
Material	 High Speed Cobalt Powder Metallurgy Steel				
Chamfer	 Plug chamfer	 Semi - bottoming	 Full - bottoming		
Flute Geometry	 Straight Flute	 Spiral Point	 15°	 40º	 45º
Direction	 Right				
Coating	 Titanium Aluminium Nitride - Top	 Titanium Aluminium Nitride + Tungsten Carbide Carbon			
Coolant	 Internal Coolant (Axial)				
Rating	■ Main application	◪ Secondary application			

SIMPLY RELIABLE

As a professional you can judge the quality of work by just looking at the chip. Our chip is a clean and uncomplicated shape that in itself tells a story. It is a clear and consistent signal and that's why we use it as a symbol for being **Simply Reliable**.

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