

Aluminum and Aluminum Alloys



DIN length - DIN shank

Series 978 - Carbide, Metric Fine, 15° helix, bright finish, DIN 374, axial coolant



Size	No. Flutes	Shank dia. mm	Square Size mm	Overall Length mm	ISO2 (6H) Approx. Limits	DIN 374 Series	Order No.
M12 X 1.50	3	9.000	7.000	100.000	D5/D6	● 978	12.007
M14 X 1.50	3	11.000	9.000	100.000	D4/D5	○	14.007
M18 X 1.50	4	14.000	11.000	110.000	D4/D5	○	18.007

METRIC FINE

ISO2 (6H)
Class of Fit



Blind Hole

15° Helix
0° Helix

Semi-bottoming
Chamfer Lead



C · 2-3



C · 2-3

DIN length - DIN shank

Series 972 - Carbide, Metric Fine, straight flute, bright finish, DIN 371, axial coolant



Size	No. Flutes	Shank dia. mm	Square Size mm	Overall Length mm	ISO2 (6H) Approx. Limits	DIN 371 Series	Order No.
*M4 X 0.50	3	4.500	3.400	63.000	D3/D4	○	4.003
M5 X 0.50	4	6.000	4.900	70.000	D3/D4	○	5.003
M8 X 1.00	4	8.000	6.200	90.000	D4/D5	○	8.005
M10 X 1.00	4	10.000	8.000	90.000	D4/D5	○	10.005

* Sizes <M5 do not have coolant ducts through the tap

DIN length - DIN shank

Series 977 - Carbide, Metric Fine, 15° helix, bright finish, DIN 371, axial coolant



Size	No. Flutes	Shank dia. mm	Square Size mm	Overall Length mm	ISO2 (6H) Approx. Limits	DIN 371 Series	Order No.
*M4 X 0.50	3	4.500	3.400	63.000	D3/D4	○	4.003
M5 X 0.50	3	6.000	4.900	70.00	D3/D4	○	5.003
M6 X 0.50	3	6.000	4.900	80.000	D3/D4	○	6.003
M8 X 1.00	3	8.000	6.200	90.000	D4/D5	○	8.005
M10 X 1.00	3	10.000	8.000	90.000	D4/D5	○	10.005

* Sizes <M5 do not have coolant ducts through the tap

Refer to pages 142-145 for additional dimensional information

● USA Stock

○ International Stock (0-2 wks)

When ordering: EDP no. = Series + Order no. (i.e. 3912 21840)