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# Solid Carbide Forming Tap for Aluminum

## Tapping by Forming Soft Materials

## NEW PORTFOLIO!

EXPANSION **Solid Carbide High-Performance Thread Forming Solution for Soft Aluminum and Cast Aluminum**

- Expanded Material Options: Solid Carbide.
  - The addition of Solid Carbide forming taps enables higher spindle speeds, longer tool life, and enhanced performance in demanding production environments.
- Radial Internal Coolant

YG
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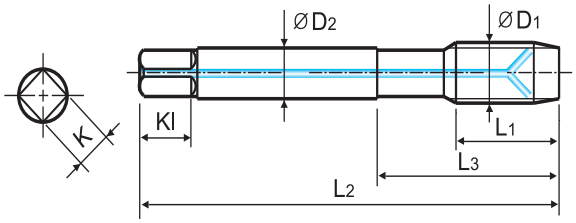
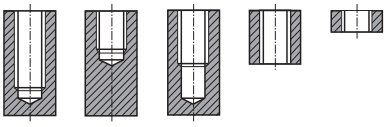
# Solid Carbide Forming Tap for Aluminum

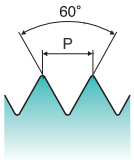
## Tapping by Forming Soft Materials

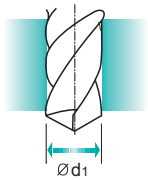



Short Chamfer

Hole type
3.0×D






Material groups **Al** | CARBIDE | DIN 371/376 | DIN 374 | 6HX | 60° | E | TiCN

**Machine Taps**

## M ISO Metric Coarse Threads - DIN 13 DIN 371/376

SERIES **T0Q01**

Unit : mm

| SIZE | Pitch | EDP No. | Thread Length | Overall Length | Neck Length | Shank Diameter | Square Size | Square Length | No. of Lobe | Tapping Drill Diameter |
|---|---|---|---|---|---|---|---|---|---|---|
| ØD1 | P | TiCN | L1 | L2 | L3 | ØD2 | K | Kl | Z | Ød1 |
| M4 x | 0.7 | **T0Q01246TICP** | 13 | 63 | 21 | 4.5 | 3.4 | 6 | 4 | 3.7 |
| M5 x | 0.8 | **T0Q01286TICP** | 15 | 70 | 25 | 6 | 4.9 | 8 | 4 | 4.65 |
| M6 x | 1.0 | **T0Q01316TICP** | 17 | 80 | 30 | 6 | 4.9 | 8 | 4 | 5.55 |
| M8 x | 1.25 | **T0Q01366TICP** | 20 | 90 | 35 | 8 | 6.2 | 9 | 6 | 7.4 |
| M10 x | 1.5 | **T0Q01426TICP** | 22 | 100 | 39 | 10 | 8 | 11 | 8 | 9.3 |
| M12 x | 1.75 | **T0Q01506TICP** | 24 | 110 | 44 | 9 | 7 | 10 | 8 | 11.2 |

▶ DIN 371(M4~M10) and DIN 376(M12)

## MF ISO Metric Fine Threads - DIN 13 DIN 374

SERIES **T0Q02**

Unit : mm

| SIZE | Pitch | EDP No. | Thread Length | Overall Length | Neck Length | Shank Diameter | Square Size | Square Length | No. of Lobe | Tapping Drill Diameter |
|---|---|---|---|---|---|---|---|---|---|---|
| ØD1 | P | TiAlN | L1 | L2 | L3 | ØD2 | K | Kl | Z | Ød1 |
| M6 x | 0.75 | **T0Q02326TICP** | 13 | 80 | 30 | 4.5 | 3.4 | 6 | 4 | 5.7 |
| M6 x | 0.5 | **T0Q02336TICP** | 13 | 80 | 30 | 4.5 | 3.4 | 6 | 4 | 5.8 |
| M8 x | 1.0 | **T0Q02376TICP** | 17 | 90 | 36 | 6 | 4.9 | 8 | 6 | 7.5 |
| M8 x | 0.75 | **T0Q02386TICP** | 14 | 80 | 30 | 6 | 4.9 | 8 | 6 | 7.7 |
| M10 x | 1.25 | **T0Q02436TICP** | 22 | 100 | 40 | 7 | 5.5 | 8 | 8 | 9.4 |
| M10 x | 1.0 | **T0Q02446TICP** | 18 | 90 | 36 | 7 | 5.5 | 8 | 8 | 9.5 |
| M12 x | 1.5 | **T0Q02516TICP** | 22 | 100 | 40 | 9 | 7 | 10 | 8 | 11.3 |
| M12 x | 1.25 | **T0Q02526TICP** | 22 | 100 | 40 | 9 | 7 | 10 | 8 | 11.4 |
| M12 x | 1.0 | **T0Q02536TICP** | 18 | 100 | 40 | 9 | 7 | 10 | 8 | 11.5 |

### RECOMMENDED CUTTING CONDITIONS

| Material Description | Aluminum-wrought alloy | | Aluminum-cast, alloyed | | | Copper and Copper Alloys (Bronze / Brass) | | |
|---|---|---|---|---|---|---|---|---|
| VDI 3323 | 21 | 22 | 23 | 24 | 25 | 26 | 27 | 28 |
| Vc (m/min.) | 20 - 60 | 20 - 60 | 20 - 50 | 20 - 50 | 20 - 50 | 20 - 60 | 20 - 60 | 20 - 60 |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