

Chart for choosing the right tap

Type of hole		2-4	2	2-3	2-3	2-5	2-3	2	2	2-4	
1	Through hole, thread depth up to 2 x d ₁	Lead-in		C 2-3 thr.	C 2-3 thr.	Correct lead-in	A 5-6 thr.	B 4-5 thr. Correct lead-in	B 4-5 thr. Correct lead-in	C 2-3 thr.	
		M	F 7800 F 7801 F 7802	F 7809 F 7809/3 F 7809/5		F 7823 fino a F 7827	F 7829/9	F 7830	F 7833 F 7856	F 7833/1 F 7856/1	F 7838 F 7839 F 7861
2	Through hole, thread depth up to 3 x d ₁	BSW				F 7829/7					
		G	F 7816 F 7817			F 7829/5 F 7829/6		F 7916		F 7918	
3	Blind hole, thread depth up to 2 x d ₁	BSPT			F 7819/2						
		NPT			F 7819/1						
4	Blind hole, thread depth up to 3 x d ₁	UNC	F 7820/1 F 7821/1					F 7926 F 7929			
		UNF	F 7822/1 F 7822/5					F 7933 F 7936			
Mod. BOSS		2000 2000 LH	4659	2700	—	—	4050	7010 7011	7010/78 7011/78	4052 / 4052 LH 6002 / 6002 LH	
5		Blind hole, thread depth up to 3 x d ₁ with deep pilot hole for chip removal									
Cooling liquid legend		O = cutting oil E = emulsion D = dry S = special cutting oil MKS = minimal lubrication		Special notes Cooling Lubricant		0 - (E)		0 - E		Vaporised 0 - E	
Material group		Material sub-group		0 - (E)		0 - E		0 - E		0 - E	
1. Steel	1.1 Non-alloy steel ≤ 800 N/mm ²	●	15-20	●	●	15-20	15-20	15-20	15-20	15-20	
	1.2 Non-alloy steel ≤ 1000 N/mm ²							15-20			
	1.3.1 Non-alloy and alloy steel ≤ 1200 mm ²										
	1.3.2 Non-alloy and alloy steel > 1200 N/mm ²										
	1.3.3 Hardened steel – 42÷46 HRc										
	1.4 Stainless steel (V2A)										
2. Cast iron	2.1 Grey cast iron										
	2.2 Spheroidal cast iron, ductile cast iron										
3. Non-ferrous materials	3.1 Aluminium, copper and copper alloys										
	3.2.1 Aluminium alloys, copper alloys										
	3.2.2 Special aluminium alloys										
4. Special alloys	4.1 Nickel alloys										
	4.2 Titanium alloys										
5. Plastic	5.1 Thermoplastic										
	5.2 Plastic, reinforced plastic with fiber										

Application: 00-00 Recommended – 00-00 Suggested