

NORMEX[®] Machine taps

M	HSS	HSS-E	DIN 371	ISO 2-6H	ISO 6H	ISO 6HX
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ISO metric threading DIN 13			coarse pitch			Red ring			Green ring			ABC ^{TOOLS}			Vaporized			Blue ring			Futura coating (see below the chart)			Red ring		
Model			F 7842/3			F 7842/4			F 7842/7			F 7842/9			F 7843			F 7843/2			F 7843/22			F 7843/3		
4235 Rsp.Spez.-R			4255 Rsp.Spez.-G			—			4040/78 Grulo Vap			4040 Grulo			4045 Grulo Spez.			4340 Grulo TM			4245 Grulo Spez.-R					
DIN			371			371			371			371			371			371			371					
Version/Shape			C/right helix 15°			C/right helix 15°			C/right helix 35°			C/right helix 40°			C/right helix 40°			C/right helix 40°			C/right helix 40°			C/right helix 40°		
Steel			HSS-E			HSS-E			HSS			HSS-E			HSS-E			HSS-E			HSS-E			HSS-E		
Tolerance			ISO 2-6H			ISO 2-6H			ISO 6H			ISO 6H			ISO 2-6H			ISO 2-6H			ISO 6HX			ISO 2-6H		
For holes																										
For material group:			1.3.1 - 1.3.2			1.2 - 1.4 - 1.6 3.1 - 3.2.1			1.1			1.1			1.1			1.1 - 1.2 2.1 - 2.2			1.1 - 1.2 2.1 - 2.2			1.3.1 - 1.3.2		
M	Lead mm	Pilot hole Ø mm	Code F 7842	Each €	Code F 7842	Each €	Code F 7842	Each €	Code F 7842	Each €	Code F 7843	Each €	Code F 7843	Each €	Code F 7843	Each €	Code F 7843	Each €	Code F 7843	Each €	Code F 7843	Each €				
2	0,4	1,60	—		4002		—		—		0002		2002		—		—		—		—					
2,3	0,4	1,90	—		—		—		—		—		2023		—		—		—		—					
2,5	0,45	2,05	—		—		—		—		0025		2025		—		—		—		—					
3	0,5	2,50	3003		4003		7003		9003		0003		2003		2203		3003		—		—					
3,5	0,6	2,90	—		—		—		—		0035		—		—		—		—		—					
4	0,7	3,30	3004		4004		7004		9004		0004		2004		2204		3004		—		—					
5	0,8	4,20	3005		4005		7005		9005		0005		2005		2205		3005		—		—					
6	1	5,00	3006		4006		7006		9006		0006		2006		2206		3006		—		—					
8	1,25	6,80	3008		4008		7008		9008		0008		2008		2208		3008		—		—					
10	1,5	8,50	3010		4010		7010		9010		0010		2010		2210		3010		—		—					

Futura coating: high wear protection and excellent thermal and chemical stability, for using taps in dry and high-speed applications (violet-grey coating)

For larger diameters, see machine taps DIN 374 → F 4 pag. 546

To choose the right tap and coating indication, see tables from page 526