



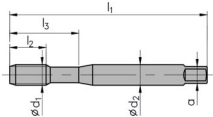
# Serie 61802

## IQ-UNI Maschinengewindebohrer HSSECo5

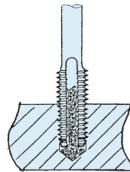
Metrische ISO-Regelgewinde nach DIN 13

**Type 61802 / 61804** - Universell einsetzbare Maschinengewindebohrer mit kurzem Anschnitt (2-3 Gänge) für Grund- und Durchgangslöcher in gut spanbare Werkstoffe bis 850N/mm<sup>2</sup>.

EN - Straight Flute machine taps with short chamfer (2-3 threads) for through and blind holes in free cutting materials up to 850N/mm<sup>2</sup>.

















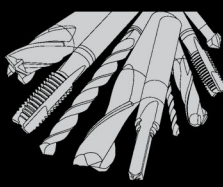
|                            |      |       |
|----------------------------|------|-------|
| TiN                        | TiCN | TiAlN |
| Beschichtungen auf Anfrage |      |       |
| DLC                        | ZrN  | nACo  |



### 61802 Dapprich-TechBox

- ▶ DIN 371 C
- ▶ HSSECo5 / M35
- ▶ für Grund- & Durchgangslöcher >1,5xd
- ▶ 2-3 Gang Anschnitt, verstärkter Schaft
- ▶ Toleranz ≤M1,4 ISO1/4H; ≥M1,6 ISO2/6H
- ▶ Beschichtungen auf Anfrage
- ▶ Commodity-Code 8207.4010

| P        |          | M   |   |   |   | K   |   |   |   | Ti  |   |   | Ni  |   |   | Cu  |   |   |   | N   |   |   |   | Syn   |   |   | ✓   | ++  |   |   |   |   |   |   |
|----------|----------|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 1.1      | 1.2      | 1.3   | 1.4   | 1.5   | 1.6   | 1.7   | 1.8   | 2.1   | 2.2   | 2.3   | 2.4   | 3.1   | 3.2   | 3.3   | 3.4   | 4.1   | 4.2   | 4.3   | 5.1   | 5.2   | 5.3   | 6.1   | 6.2   | 6.3   | 6.4   | 7.1   | 7.2   | 7.3   | 7.4   | 8.1   | 8.2   | 8.3   | ○ | + |
| BestNr A |          |   |   |   |   | 61 802  |   |   |   | 61 804  |   |   |   |   |   |   |   |   |   |   |   |   |   | ○   | +   |   |   |   |   |   |   |   |   |   |
| Gruppe   |          |   |   |   |   | 10  |   |   |   | 10  |   |   |   |   |   |   |   |   |   |   |   |   |   | ○   | +   |   |   |   |   |   |   |   |   |   |
| Qualität |          |   |   |   |   | HSSECo5   |   |   |   | HSSCo5  |   |   |   |   |   |   |   |   |   |   |   |   |   | ○   | +   |   |   |   |   |   |   |   |   |   |
| Schicht  |          |   |   |   |   | P0  |   |   |   | P0  |   |   |   |   |   |   |   |   |   |   |   |   |   | ○   | +   |   |   |   |   |   |   |   |   |   |
| Dreh ↔   |          |   |   |   |   | RH  |   |   |   | LH  |   |   |   |   |   |   |   |   |   |   |   |   |   | ○   | +   |   |   |   |   |   |   |   |   |   |
| Toleranz |          |   |   |   |   | ISO2/6H   |   |   |   | ISO2/6H   |   |   |   |   |   |   |   |   |   |   |   |   |   | ○   | +   |   |   |   |   |   |   |   |   |   |
| BestNr B | D1 mm    | Steigung P / mm   | d mm  |   |   |   |   | €   | €   |   |   | L1 mm   | L2 mm   | L3 mm   | D2 mm   | a mm  |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |
|          | <b>M</b> |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |   |   |
| .010     | M 1      | 0,25  | 0,75  |   |   |   |   | 65,12   |   |   |   | 40  | 5   |   | 2,5   | 2,1   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |
| .011     | M 1,1    | 0,25  | 0,85  |   |   |   |   | 65,12   |   |   |   | 40  | 5   |   | 2,5   | 2,1   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |
| .012     | M 1,2    | 0,25  | 0,95  |   |   |   |   | 46,60   |   |   |   | 40  | 5   |   | 2,5   | 2,1   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |
| .014     | M 1,4    | 0,30  | 1,10  |   |   |   |   | 46,60   |   |   |   | 40  | 7   |   | 2,5   | 2,1   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |
| .016     | M 1,6    | 0,35  | 1,25  |   |   |   |   | 45,76   |   |   |   | 40  | 8   |   | 2,5   | 2,1   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |
| .017     | M 1,7    | 0,35  | 1,35  |   |   |   |   | 41,82   |   |   |   | 40  | 8   |   | 2,5   | 2,1   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |
| .018     | M 1,8    | 0,35  | 1,45  |   |   |   |   | 43,00   |   |   |   | 40  | 8   |   | 2,5   | 2,1   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |
| .020     | M 2      | 0,40  | 1,60  |   |   |   |   | 10,22   | 17,40   |   |   | 45  | 8   |   | 2,8   | 2,1   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |
| .022     | M 2,2    | 0,45  | 1,75  |   |   |   |   | 20,65   |   |   |   | 45  | 9   |   | 2,8   | 2,1   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |
| .023     | M 2,3    | 0,40  | 1,90  |   |   |   |   | 13,93   | 23,17   |   |   | 45  | 9   |   | 2,8   | 2,1   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |
| .025     | M 2,5    | 0,45  | 2,05  |   |   |   |   | 10,22   | 17,40   |   |   | 50  | 9   |   | 2,8   | 2,1   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |
| .026     | M 2,6    | 0,45  | 2,15  |   |   |   |   | 13,93   |   |   |   | 50  | 9   |   | 2,8   | 2,1   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |
| .030     | M 3      | 0,50  | 2,50  |   |   |   |   | 7,81  | 14,81   |   |   | 56  | 9   | 8   | 3,5   | 2,7   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |
| .035     | M 3,5    | 0,60  | 2,90  |   |   |   |   | 8,30  | 19,74   |   |   | 56  | 11  | 9   | 4,0   | 3,0   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |
| .040     | M 4      | 0,70  | 3,30  |   |   |   |   | 7,95  | 15,72   |   |   | 63  | 12  | 9   | 4,5   | 3,4   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |
| .045     | M 4,5    | 0,75  | 3,75  |   |   |   |   | 15,75   | 26,25   |   |   | 70  | 13  | 11  | 6,0   | 4,9   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |
| .050     | M 5      | 0,80  | 4,20  |   |   |   |   | 8,33  | 14,46   |   |   | 70  | 13  | 11  | 6,0   | 4,9   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |
| .060     | M 6      | 1,00  | 5,00  |   |   |   |   | 8,51  | 14,70   |   |   | 80  | 15  | 14  | 6,0   | 4,9   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |
| .070     | M 7      | 1,00  | 6,00  |   |   |   |   | 13,34   | 22,75   |   |   | 80  | 15  | 13  | 7,0   | 5,5   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |
| .080     | M 8      | 1,25  | 6,75  |   |   |   |   | 9,52  | 18,76   |   |   | 90  | 18  | 17  | 8,0   | 6,2   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |
| .090     | M 9      | 1,25  | 7,75  |   |   |   |   | 21,95   | 27,48   |   |   | 90  | 18  | 17  | 9,0   | 7,0   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |
| .100     | M 10     | 1,50  | 8,50  |   |   |   |   | 11,41   | 23,87   |   |   | 100   | 20  | 19  | 10,0  | 8,0   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |   |



# Gewinden | Threading | Taraudage

## Gewindeschneidzeuge - M (metrisch)



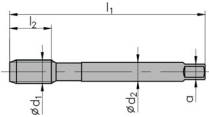
### Serie 61702

#### IQ-UNI Maschinengewindebohrer HSSECo5

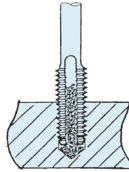
Metrisches ISO-Regelgewinde nach DIN 13

**Type 61702/ 61704** - Universell einsetzbare Maschinengewindebohrer mit kurzem Anschnitt (2-3 Gänge) für Grund- und Durchgangslöcher in gut spanbare Werkstoffe bis 850N/mm<sup>2</sup>.

EN - Straight Flute machine taps with short chamfer (2-3 threads) for through and blind holes in free cutting materials up to 850N/mm<sup>2</sup>.



|                            |      |       |
|----------------------------|------|-------|
| TiN                        | TiCN | TiAlN |
| Beschichtungen auf Anfrage |      |       |
| DLC                        | ZrN  | nACo  |



#### 61702 Dapprich-TechBox

- ▶ DIN 376 C - Überlaufschaft
- ▶ HSSECo5 / M35
- ▶ für Grund- & Durchgangslöcher <1,5xd
- ▶ 2-3 Gang Anschnitt; Überlaufschaft
- ▶ Toleranz ISO2/6H
- ▶ Beschichtungen auf Anfrage
- ▶ Commodity-Code 8207.4010

| P        |       | M               |       |        |        | K     |     |       |       | Ti    |      |     | Ni  |     |         | Cu      |     |     |     | N   |     |     |     | Syn |     |     | ✓   | ++  |     |     |     |     |   |   |
|----------|-------|-----------------|-------|--------|--------|-------|-----|-------|-------|-------|------|-----|-----|-----|---------|---------|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|---|---|
| 1.1      | 1.2   | 1.3             | 1.4   | 1.5    | 1.6    | 1.7   | 1.8 | 2.1   | 2.2   | 2.3   | 2.4  | 3.1 | 3.2 | 3.3 | 3.4     | 4.1     | 4.2 | 4.3 | 5.1 | 5.2 | 5.3 | 6.1 | 6.2 | 6.3 | 6.4 | 7.1 | 7.2 | 7.3 | 7.4 | 8.1 | 8.2 | 8.3 | ○ | + |
| BestNr A |       |                 |       |        |        |       |     |       |       |       |      |     |     |     | 61 702  | 61 704  |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |   |   |
| Gruppe   |       |                 |       |        |        |       |     |       |       |       |      |     |     |     | 10      | 10      |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |   |   |
| Qualität |       |                 |       |        |        |       |     |       |       |       |      |     |     |     | HSSECo5 | HSSECo5 |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |   |   |
| Schicht  |       |                 |       |        |        |       |     |       |       |       |      |     |     |     | P0      | P0      |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |   |   |
| Dreh ↔   |       |                 |       |        |        |       |     |       |       |       |      |     |     |     | RH      | LH      |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |   |   |
| Toleranz |       |                 |       |        |        |       |     |       |       |       |      |     |     |     | ISO2/6H | ISO2/6H |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |   |   |
| BestNr B | D1 mm | Steigung P / mm | d mm  | €      |        | €     |     | L1 mm | L2 mm | D2 mm | a mm |     |     |     |         |         |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |   |   |
|          | M     |                 |       |        | Stück  | Stück |     |       |       |       |      |     |     |     |         |         |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |   |   |
| .030     | M 3   | 0,50            | 2,50  | 11,06  | 22,68  | 56    | 9   | 2,2   | 1,8   |       |      |     |     |     |         |         |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |   |   |
| .035     | M 3,5 | 0,60            | 2,90  | 18,55  |        | 56    | 11  | 2,5   | 2,1   |       |      |     |     |     |         |         |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |   |   |
| .040     | M 4   | 0,70            | 3,30  | 11,41  | 23,59  | 63    | 12  | 2,8   | 2,1   |       |      |     |     |     |         |         |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |   |   |
| .045     | M 4,5 | 0,75            | 3,75  | 22,68  |        | 70    | 13  | 3,5   | 2,7   |       |      |     |     |     |         |         |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |   |   |
| .050     | M 5   | 0,80            | 4,20  | 11,52  | 21,60  | 70    | 13  | 3,5   | 2,7   |       |      |     |     |     |         |         |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |   |   |
| .060     | M 6   | 1,00            | 5,00  | 11,59  | 23,07  | 80    | 15  | 4,5   | 3,4   |       |      |     |     |     |         |         |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |   |   |
| .070     | M 7   | 1,00            | 6,00  | 13,72  | 33,60  | 80    | 15  | 5,5   | 4,3   |       |      |     |     |     |         |         |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |   |   |
| .080     | M 8   | 1,25            | 6,75  | 12,99  | 28,77  | 90    | 18  | 6,0   | 4,9   |       |      |     |     |     |         |         |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |   |   |
| .090     | M 9   | 1,25            | 7,75  | 24,54  | 40,88  | 90    | 18  | 7,0   | 5,5   |       |      |     |     |     |         |         |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |   |   |
| .100     | M 10  | 1,50            | 8,50  | 15,05  | 35,81  | 100   | 20  | 7,0   | 5,5   |       |      |     |     |     |         |         |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |   |   |
| .110     | M 11  | 1,50            | 9,50  | 42,14  | 52,64  | 100   | 20  | 8,0   | 6,2   |       |      |     |     |     |         |         |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |   |   |
| .120     | M 12  | 1,75            | 10,25 | 17,92  | 38,71  | 110   | 23  | 9,0   | 7,0   |       |      |     |     |     |         |         |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |   |   |
| .130     | M 13  | 1,75            | 11,25 | *      |        | 110   | 25  | 11,0  | 9,0   |       |      |     |     |     |         |         |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |   |   |
| .140     | M 14  | 2,00            | 12,00 | 22,19  | 70,21  | 110   | 25  | 11,0  | 9,0   |       |      |     |     |     |         |         |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |   |   |
| .160     | M 16  | 2,00            | 14,00 | 26,04  | 64,37  | 110   | 25  | 12,0  | 9,0   |       |      |     |     |     |         |         |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |   |   |
| .180     | M 18  | 2,50            | 15,50 | 37,38  | 85,26  | 125   | 30  | 14,0  | 11,0  |       |      |     |     |     |         |         |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |   |   |
| .200     | M 20  | 2,50            | 17,50 | 40,04  | 92,96  | 140   | 30  | 16,0  | 12,0  |       |      |     |     |     |         |         |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |   |   |
| .220     | M 22  | 2,50            | 19,50 | 53,55  | 101,43 | 140   | 30  | 18,0  | 14,5  |       |      |     |     |     |         |         |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |   |   |
| .240     | M 24  | 3,00            | 21,00 | 50,12  | 118,72 | 160   | 36  | 18,0  | 14,5  |       |      |     |     |     |         |         |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |   |   |
| .270     | M 27  | 3,00            | 24,00 | 65,56  | 114,24 | 160   | 36  | 20,0  | 16,0  |       |      |     |     |     |         |         |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |   |   |
| .300     | M 30  | 3,50            | 26,50 | 71,93  | 147,70 | 180   | 40  | 22,0  | 18,0  |       |      |     |     |     |         |         |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |   |   |
| .330     | M 33  | 3,50            | 29,50 | 103,50 | 179,52 | 180   | 42  | 25,0  | 20,0  |       |      |     |     |     |         |         |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |   |   |
| .360     | M 36  | 4,00            | 32,00 | 127,16 | 227,29 | 200   | 50  | 28,0  | 22,0  |       |      |     |     |     |         |         |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |   |   |
| .390     | M 39  | 4,00            | 35,00 | 164,29 | 200,31 | 200   | 50  | 32,0  | 24,0  |       |      |     |     |     |         |         |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |   |   |
| .420     | M 42  | 4,50            | 37,50 | 181,90 | 233,73 | 200   | 56  | 32,0  | 24,0  |       |      |     |     |     |         |         |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |   |   |
| .450     | M 45  | 4,50            | 40,50 | 207,45 | 283,19 | 200   | 56  | 36,0  | 29,0  |       |      |     |     |     |         |         |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |   |   |
| .480     | M 48  | 5,00            | 43,00 | 238,63 | 346,57 | 250   | 63  | 36,0  | 29,0  |       |      |     |     |     |         |         |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |   |   |
| .520     | M 52  | 5,00            | 47,00 | 289,10 | 388,36 | 250   | 63  | 40,0  | 32,0  |       |      |     |     |     |         |         |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |   |   |
| .560     | M 56  | 5,50            | 50,50 | *      | *      | 250   | 75  | 45,0  | 35,0  |       |      |     |     |     |         |         |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |   |   |
| .600     | M 60  | 6,00            | 54,00 | *      | *      | 250   | 75  | 45,0  | 35,0  |       |      |     |     |     |         |         |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |   |   |
| .640     | M 64  | 6,00            | 58,00 | *      | *      | 315   | 85  | 50,0  | 39,0  |       |      |     |     |     |         |         |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |   |   |
| .680     | M 68  | 6,00            | 62,00 | *      | *      | 315   | 85  | 50,0  | 39,0  |       |      |     |     |     |         |         |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |   |   |
| .720     | M 72  | 6,00            | 66,00 | *      | *      | 315   | 85  | 56,0  | 44,0  |       |      |     |     |     |         |         |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |   |   |
| .760     | M 76  | 6,00            | 70,00 | *      | *      | 315   | 85  | 56,0  | 44,0  |       |      |     |     |     |         |         |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |   |   |
| .800     | M 80  | 6,00            | 74,00 | *      | *      | 315   | 85  | 56,0  | 44,0  |       |      |     |     |     |         |         |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |   |   |
| .840     | M 84  | 6,00            | 78,00 | *      | *      | 315   | 85  | 56,0  | 44,0  |       |      |     |     |     |         |         |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |   |   |
| .880     | M 88  | 6,00            | 82,00 | *      | *      | 315   | 100 | 63,0  | 49,0  |       |      |     |     |     |         |         |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |   |   |
| .900     | M 90  | 6,00            | 84,00 | *      | *      | 315   | 100 | 63,0  | 49,0  |       |      |     |     |     |         |         |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |   |   |
| .920     | M 92  | 6,00            | 86,00 | *      | *      | 315   | 100 | 63,0  | 49,0  |       |      |     |     |     |         |         |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |   |   |
| .960     | M 96  | 6,00            | 90,00 | *      | *      | 315   | 100 | 63,0  | 49,0  |       |      |     |     |     |         |         |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |   |   |
| .999     | M 100 | 6,00            | 94,00 | *      | *      | 315   | 100 | 63,0  | 49,0  |       |      |     |     |     |         |         |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |   |   |