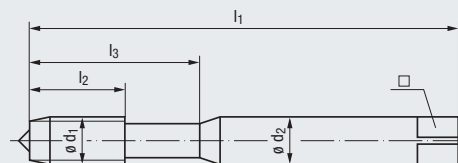
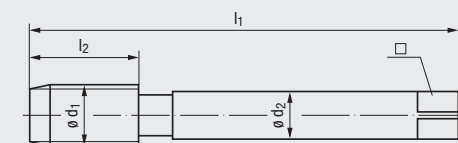


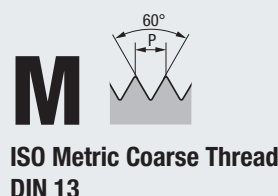
DIN Length • DIN Shank



Reinforced Shank
(M2 - M10)



Reduced Shank
(M12 - M20)



Class of Fit
Coating
Cutting Material
Technical Characteristics

Thread Depth
and Hole Shape

Applications – Material

STEEL
Steel
Materials



6HX

6HX

6HX

6HX

6HX

NT

TIN

NT

TIN

Carbide

HSS Extra

HSS Extra

HSS Extra

HSS Extra

Carbide

C / 2-3

C / 2-3

C / 2-3

C / 2-3

C / 2-3

O / P

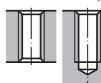
E / O / P

O / P

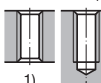
E / O / P

E / O

max. 3 x d₁



max. 3 x d₁



P 1.1-3.1

P 1.1-3.1

P 1.1-3.1

P 1.1-3.1

P 2.1-4.1

M 1.1-2.1²⁾

N 1.4-5, 2.1-2

M 1.1-2.1²⁾

N 1.4-5, 2.1-2

N 1.4-5

Reinforced Shank

Nominal Size ø d ₁	P	l ₁	l ₂	l ₃	ø d ₂	□
M 2	0.4	45	7	12	2.8	2.1
M 2.5	0.45	50	9	14	2.8	2.1
M 3	0.5	56	11	18	3.5	2.7
M 3.5	0.6	56	12	20	4	3
M 4	0.7	63	13	21	4.5	3.4
M 4.5	0.75	70	14	25	6	4.9
M 5	0.8	70	15	25	6	4.9
M 6	1	80	17	30	6	4.9
M 8	1.25	90	20	35	8	6.2
M 10	1.5	100	22	39	10	8

Tool Identification

Dimens. ID	B0911000	B0911400	B0921000	B0921400	B1970100
	Druck 1-STEEL NT	Druck 1-STEEL TIN	Druck 1-STEEL-SN NT	Druck 1-STEEL-SN TIN	VHM Druck 1-STEEL SN-IKZ

Reduced Shank

Nominal Size ø d ₁	P	l ₁	l ₂	l ₃	ø d ₂	□
M 12	1.75	110	24	—	9	7
M 14	2	110	26	—	11	9
M 16	2	110	27	—	12	9
M 18	2.5	125	30	—	14	11
M 20	2.5	140	32	—	16	12

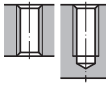
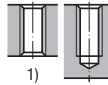
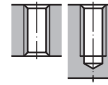
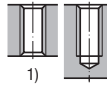
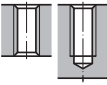
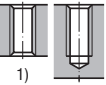
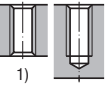
Tool Identification

Dimens. ID	C0911400	C0921400
	Druck 2-STEEL TIN	Druck 2-STEEL-SN TIN

- ¹⁾ Cold-forming in through holes is possible only with external cooling/lubrication
- ²⁾ Restricted application possibilities with emulsion



We recommend a smaller preparatory diameter by 0.05 mm for difficult to form materials (such as aluminum cast alloys) for P ≥ 1 mm.
For further information regarding the recommended preparatory diameters, see page 208 - 209.

STEEL Steel Materials					VA Stainless steel materials				
									
new	new	new	new	new	new	new			
6HX	6HX	6HX	6HX	6HX	6HX	6HX			
TIN-66	TIN-66	TIN-66	TIN	TICN-67	TIN-T26	TIN-T26			
HSSE-PM	HSSE-PM	HSSE-PM	HSSE-PM	HSSE-PM	HSSE-PM	HSSE-PM			
C / 2-3	C / 2-3	E / 1.5-2	C / 2-3	C / 2-3	E / 1.5-2	E / 1.5-2			
E / O / P	E / O	E / O	E / O / P	E / O	E / O / P	E / O			
max. 3 x d ₁ 	max. 3 x d ₁ 	max. 3 x d ₁ 	max. 3 x d ₁ 	max. 3 x d ₁ 	max. 3 x d ₁ 	max. 3 x d ₁ 			
P 1.1-4.1 K 2.1	P 1.1-4.1 K 2.1	P 1.1-4.1 K 2.1	P 3.1-5.1 K 2.1	P 3.1-5.1 K 2.1	P 1.1-4.1 M 1.1-3.1 2)	P 1.1-4.1 M 1.1-3.1 2)			
B5217F00	B5237F00	B5317F00	B5216F00	B5236F00	B5296A00	B5316A00	Tool Identification		
InnoForm 1-STEEL-M SN-PM TIN-66	InnoForm 1-STEEL-M SN-PM TIN-66	InnoForm 1-STEEL-M/E SN-PM TIN-66	InnoForm 1-STEEL-H SN-PM TICN-67	InnoForm 1-STEEL-H SN-PM TICN-67	InnoForm 1-VA/E-SN PM-TIN-T26	InnoForm 1-VA/E-SN IKZ-PM TIN-T26	Dimens. ID	Nominal Size ø d ₁	P
							.0020	M 2	0.4
★					★		.0025	M 2.5	0.45
							.0030	M 3	0.5
★	★	★	★	★	★	★	.0035	M 3.5	0.6
							.0040	M 4	0.7
★	★	★	★	★	★	★	.0045	M 4.5	0.75
★	★	★	★	★	★	★	.0050	M 5	0.8
★	★	★	★	★	★	★	.0060	M 6	1
★	★	★	★	★	★	★	.0080	M 8	1.25
★	★	★	★	★	★	★	.0100	M 10	1.5
C5217F00	C5237F00	C5317F00	C5216F00	C5236F00			Tool Identification		
InnoForm 2-STEEL-M SN-PM TIN-66	InnoForm 2-STEEL-M SN-PM TIN-66	InnoForm 2-STEEL-M/E SN-PM TIN-66	InnoForm 2-STEEL-H SN-PM TICN-67	InnoForm 2-STEEL-H SN-PM TICN-67			Dimens. ID	Nominal Size ø d ₁	P
★	★	★	★	★			.0112	M 12	1.75
							.0114	M 14	2
★	★	★	★	★			.0116	M 16	2
							.0118	M 18	2.5
							.0120	M 20	2.5

1) Cold-forming in through holes is possible only with external cooling/lubrication

2) Restricted application possibilities with emulsion

3) Patent pending

