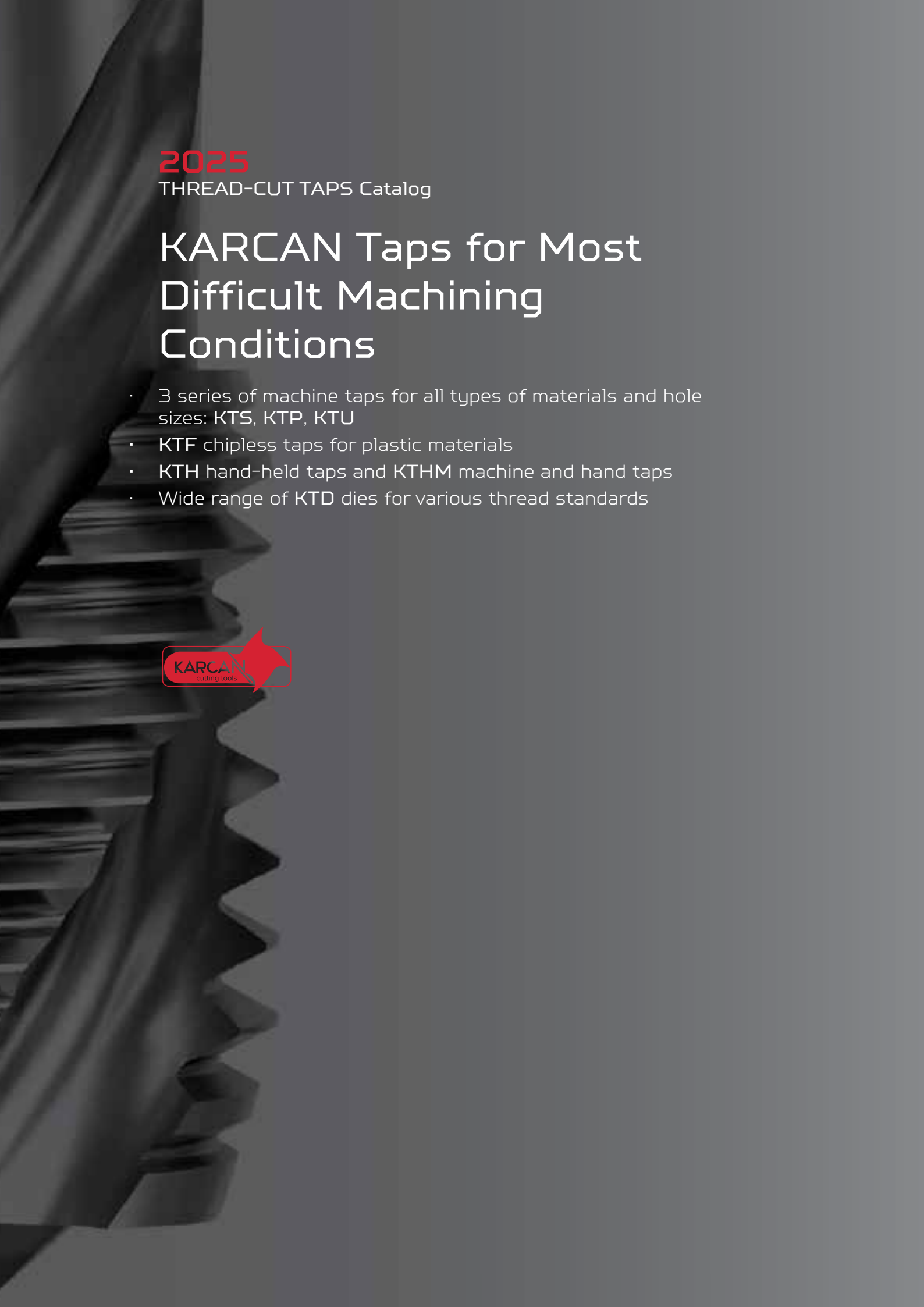


2025

THREAD-CUT
TAPS CATALOG

EN

BEYOND THE MACHINING



2025

THREAD-CUT TAPS Catalog

KARCAN Taps for Most Difficult Machining Conditions

- 3 series of machine taps for all types of materials and hole sizes: KTS, KTP, KTU
- KTF chipless taps for plastic materials
- KTH hand-held taps and KTHM machine and hand taps
- Wide range of KTD dies for various thread standards





*Thread-cut
Taps*



Tap series

KARCAN THREAD-CUT TAPS

KTS

- KTS series machine taps are designed for machining materials of groups P, K, N. First choice for single and small-scale production.
- Range of thread standards: M, MF, BSW, BSP, UNC, UNF, UN, UNS, Pg.
- Tap materials: HSS, HSS-E.

KTP

- KTP series machine taps are high-performance tools with a narrow application profile. All taps have a ring with a specific color to indicate the materials to be machined.
Blue ring – materials of Group M; **Red ring** – improved tool steels of Group P; **Yellow ring** – wrought alloys of Group N; White ring – machining of gray cast irons of Group K.
- Range of thread standards: M.
- Tap materials: HSSE-PM, HSS-E, HSSE-V3.

KTU

- KTU Premium series taps are Hi-class tools for maximum productivity. First choice for difficult-to-machine materials of groups S, H, as well as for serial and mass production where maximum productivity and durability are required.
- Range of thread standards: M, MF, BSW, BSP G, UNC, UNF, UN, Rp, Pg, Rc, NPT, NPTF.
- Tap materials: HSSE-PM, HSS-E, HSSE-V3, VHM.

KTF

- KTF thread formers are universal tools for machining a wide range of materials that are subject to plastic deformation.
- Series available with and without coolant grooves.
- Size range: from M1 to M16.
- Thread former materials: HSSE-PM, HSS-E.

KTH, KTHM, KTN

- These series are used for manual thread machining. KTHM short machine and hand taps are suitable for both manual and machine tapping.
- Range of thread standards: M, MF, BSW, BSP, BSF, UN, UNC, UNF, UNEF, UNS, Pg, NPT, NPTF, Tr.
- Tap materials: HSS, HSS-E.

KTD

- KTD series dies with a wide range of thread standards and sizes. Right and left hand threads are available.
- Range of thread standards: M, MF, BSW, BSP, BSF, UNC, UNF, UNS, Pg, NPT, Tr.
- Tap materials: HSS, HSS-E.



Thread-cut taps



THREAD-CUT THREAD TAP

KTS SERIES

Tool Selection Guide



Thread type	Series	Model	Form	Helix angle	Min. size	Max. size	Material	Coating	Standard	Tolerance		Hole type	Steel	Stainless Steel	Hardened Steel	Hardened Steel	Cast Iron	Non-Ferrous Metals	Heat-Resistant Alloys (HPSA)	Titanium
															≤54 HRC	>54 HRC				
KTS	KTS0301		A		3	10	HSS	Blank ⁺	DIN 371	6H	R		●	○	○	○	●	●	○	○
	KTS0307		A		12	-	HSS	Blank ⁺	DIN 376	6H	R		●	○	○	○	●	●	○	○
	KTS1001		A		3	10	HSSE	Blank ⁺	DIN 371	6H	R		●	●	○	○	●	●	○	○
	KTS2001		A		12	-	HSSE	Blank ⁺	DIN 376	6H	R		●	●	○	○	●	●	○	○
	KTS0302		B		2	10	HSS	Blank ⁺	DIN 371	6H	R		●	○	○	○	●	●	○	○
	KTS0309		B		3	30	HSS	Blank ⁺	DIN 376	6H	R		●	○	○	○	●	●	○	○
	KTS1004		B		2	10	HSSE	Blank ⁺	DIN 371	6H	R		●	●	○	○	●	●	○	○
	Σ KTS2004		B		3	52	HSSE	Blank ⁺ *	DIN 376	6H	R		●	●	○	○	●	●	○	○
	KTS1105		B		2	10	HSSE	TiN	DIN 371	6H	R		●	●	○	○	●	●	○	○
	KTS2105		B		12	36	HSSE	TiN	DIN 376	6H	R		●	●	○	○	●	●	○	○
	KTS1005		B		2	10	HSSE	VAP	DIN 371	6H	R		●	●	○	○	●	●	○	○
	KTS2005		B		12	36	HSSE	VAP	DIN 376	6H	R		●	●	○	○	●	●	○	○
	KTS1102		B/ AZ		3	10	HSSE	Blank ⁺	DIN 371	6H	R		●	●	○	○	●	●	○	○
	KTS2102		B/ AZ		12	20	HSSE	Blank ⁺	DIN 376	6H	R		●	●	○	○	●	●	○	○
	KTS0306		C	35°	2	10	HSS	Blank ⁺	DIN 371	6H	R		●	○	○	○	●	●	○	○

* Optionally available coating



KTS SERIES

													Steel	Stainless Steel	Hardened Steel	Hardened Steel	Cast Iron	Non-Ferrous Metals	Heat-Resistant Alloys (HRSA)	Titanium		
Thread type	Series	Model	Form	Helix angle	Min. size	Max. size	Material	Coating	Standard	Tolerance		Hole type			≤54 HRC	>54 HRC						
KTS	Σ	KTS0311		C	35°	3	24	HSS	Blank ⁺	DIN 376	6H	R		●	○	○	○	●	●	○	○	
		KTS1015		C	35°	2	10	HSSE	Blank ⁺	DIN 371	6H	R		●	●	○	○	●	●	○	○	
		KTS2015		C	35°	3	52	HSSE	Blank ⁺ *	DIN 376	6H	R		●	●	○	○	●	●	○	○	
		KTS1107		C	35°	2	10	HSSE	TiN	DIN 371	6H	R		●	●	○	○	●	●	○	○	
		KTS2109		C	35°	12	36	HSSE	TiN	DIN 376	6H	R		●	●	○	○	●	●	○	○	
		KTS1016		C	35°	2	10	HSSE	VAP	DIN 371	6H	R		●	●	○	○	●	●	○	○	
		KTS2016		C	35°	12	36	HSSE	VAP	DIN 376	6H	R		●	●	○	○	●	●	○	○	
		KTS1061		B		3	10	HSSE	Blank ⁺	DIN 371	6HX	R		●	●	○	○	●	●	○	○	
		KTS1062		B		12	–	HSSE	Blank ⁺	DIN 376	6HX	R		●	●	○	○	●	●	○	○	
		KTS1063		C	35°	3	10	HSSE	Blank ⁺	DIN 371	6HX	R		●	●	○	○	●	●	○	○	
		KTS1064		C	35°	12	–	HSSE	Blank ⁺	DIN 376	6HX	R		●	●	○	○	●	●	○	○	
		KTS1065		B		3	10	HSSE	TiN	DIN 371	6HX	R		●	●	○	○	●	●	○	○	
		KTS1066		B		12	–	HSSE	TiN	DIN 376	6HX	R		●	●	○	○	●	●	○	○	
		KTS1067		C	35°	3	10	HSSE	TiN	DIN 371	6HX	R		●	●	○	○	●	●	○	○	
		KTS1068		C	35°	12	–	HSSE	TiN	DIN 376	6HX	R		●	●	○	○	●	●	○	○	

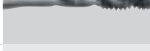
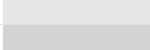
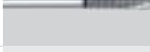
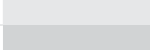
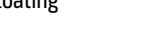
* Optionally available coating

THREAD-CUT THREAD TAP

KTS SERIES

Tool Selection Guide

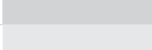
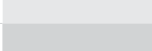
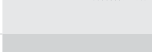
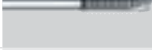
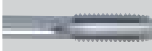


Thread type	Series	Model	Form	Helix angle	Min. size	Max. size	Material	Coating	Standard	Tolerance		Hole type	Steel	Stainless Steel	Hardened Steel	Hardened Steel	Cast Iron	Non-Ferrous Metals	Heat-Resistant Alloys (HRA)	Titanium
													≤54 HRC	>54 HRC						
Σ	KTS1069		B		3	10	HSSE	TiAlN	DIN 371	6HX	R									
	KTS1070		B		12	-	HSSE	TiAlN	DIN 376	6HX	R									
	KTS1071		C	35°	3	10	HSSE	TiAlN	DIN 371	6HX	R									
	KTS1072		C	35°	12	-	HSSE	TiAlN	DIN 376	6HX	R									
	KTS1023		B		3	12	HSSE	Blank ⁺	DIN 371 (100 mm)	6H	R									
	KTS1025		B		4	12	HSSE	Blank ⁺	DIN 371 (120 mm)	6H	R									
	KTS1027		B		4	12	HSSE	Blank ⁺	DIN 371 (150 mm)	6H	R									
	KTS2107		B		3	10	HSSE	Blank ⁺	DIN 371	6H	L									
	KTS2108		B		12	24	HSSE	Blank ⁺	DIN 376	6H	L									
	KTS1028		C		3	10	HSSE	Blank ⁺	DIN 371	6H	L									
	KTS2028		C		12	24	HSSE	Blank ⁺	DIN 376	6H	L									
MF	KTS2204		B		3x0.35	21x1.5	HSSE	Blank ⁺ *	DIN 374	6H	R									
	KTS2206		B		22x1	52x4	HSSE	Blank ⁺ *	DIN374	6H	R									
	KTS2226		C	35°	3x0.35	21x1.5	HSSE	Blank ⁺ *	DIN 374	6H	R									

* Optionally available coating



KTS SERIES

Thread type	Series	Model	Form	Helix angle	Min. size	Max. size	Material	Coating	Standard	Tolerance		Hole type		Steel	Stainless Steel	Hardened Steel ≤54 HRC	Hardened Steel >54 HRC	Cast Iron	Non-Ferrous Metals	Heat-Resistant Alloys (HRSA)	Titanium	
KTS	MF	KTS2228		C	35°	22x0.75	52x4	HSSE	Blank ⁺ *	DIN 374	6H	R										
	BSW	KTS1304		B		1/8	1.1/2	HSSE	Blank ⁺	DIN 2184-1			R									
		KTS1315		C	35°	1/8	1.1/2	HSSE	Blank ⁺	DIN 2184-1			R									
	BSP	KTS2504		B		1/8	2	HSSE	Blank ⁺ *	DIN 5156	6H		R									
		KTS2521		C		1/8	2	HSSE	Blank ⁺	DIN 5156	6H		R									
		KTS2516		C	35°	1/8	2	HSSE	Blank ⁺ *	DIN 5156	6H		R									
	UNC	KTS1604		B		Nr.4	1.1/2	HSSE	Blank ⁺ *	DIN 2184-1	2B		R									
		KTS1615		C	35°	Nr.4	1.1/2	HSSE	Blank ⁺ *	DIN 2184-1	2B		R									
	UNF	KTS1704		B		Nr.4	1.1/2	HSSE	Blank ⁺ *	DIN 2184-1	2B		R									
		KTS1715		C	35°	Nr.4	1.1/2	HSSE	Blank ⁺ *	DIN 2184-1	2B		R									
	UN	KTS2804		B		1.1/8	2	HSSE	Blank ⁺	DIN 2184-1	2B		R									
		KTS2815		C	35°	1.1/8	2	HSSE	Blank ⁺	DIN 2184-1	2B		R									
	UNS	KTS2821		C		1/4	3	HSSE	Blank ⁺	DIN 2184-1	2B		R									
	Pg	KTS2901		C		7	48	HSSE	Blank ⁺	DIN 2184-1	6H		R									

* Optionally available coating

THREAD-CUT THREAD TAP

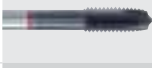
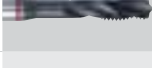
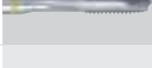
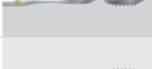
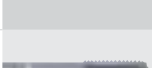
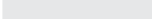
KTP SERIES

Tool Selection Guide



Thread type	Series	Model	Form	Helix angle	Min. size	Max. size	Material	Coating	Standard	Tolerance		Hole type	Steel	Stainless Steel	Hardened Steel	Hardened Steel	Cast Iron	Non-Ferrous Metals	Heat-Resistant Alloys (HPSA)	Titanium
															≤54 HRC	>54 HRC				
KTP	M	KTP1029		B	3	10	HSSE	Blank ⁺	DIN 371	6H	R		●	●	○	○	○	○	○	○
		KTP1030		B	12	36	HSSE	Blank ⁺	DIN 376	6H	R		○	●	○	○	○	○	○	○
		KTP1031		B	3	10	HSSE	TiN	DIN 371	6H	R		●	●	○	○	○	○	○	○
		KTP1032		B	12	36	HSSE	TiN	DIN 376	6H	R		●	●	○	○	○	○	○	○
		KTP1033		B	3	10	HSSE	VAP	DIN 371	6H	R		●	●	○	○	○	○	○	○
		KTP1034		B	12	36	HSSE	VAP	DIN 376	6H	R		●	●	○	○	○	○	○	○
		KTP1035		B	3	10	HSSE-PM	TiAlN	DIN 371	6H	R		●	●	○	○	○	○	○	○
		KTP1036		B	12	-	HSSE-PM	TiAlN	DIN 376	6H	R		●	●	○	○	○	○	○	○
		KTP1037		C	35°	3	HSSE	Blank ⁺	DIN 371	6H	R		○	●	○	○	○	○	○	○
		KTP1038		C	35°	12	HSSE	Blank ⁺	DIN 376	6H	R		○	●	○	○	○	○	○	○
		KTP1039		C	35°	3	HSSE	TiN	DIN 371	6H	R		●	●	○	○	○	○	○	○
		KTP1040		C	35°	12	HSSE	TiN	DIN 376	6H	R		●	●	○	○	○	○	○	○
		KTP1041		C	35°	3	HSSE	VAP	DIN 371	6H	R		●	●	○	○	○	○	○	○
		KTP1042		C	35°	12	HSSE	VAP	DIN 376	6H	R		●	●	○	○	○	○	○	○
		KTP1043		C	35°	3	HSSE-PM	TiAlN	DIN 371	6H	R		●	●	○	○	○	○	○	○
		KTP1044		C	35°	12	HSSE-PM	TiAlN	DIN 376	6H	R		●	●	○	○	○	○	○	○



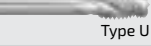
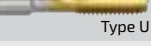
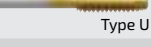
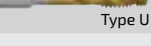
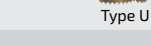
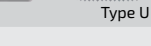
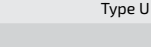
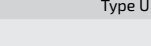
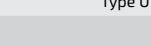
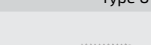
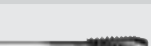
													Steel	Stainless Steel	Hardened Steel	Hardened Steel	Cast Iron	Non-Ferrous Metals	Heat-Resistant Alloys (HRSA)	Titanium
Thread type	Series	Model	Form	Helix angle	Min. size	Max. size	Material	Coating	Standard	Tolerance		Hole type			≤54 HRC	>54 HRC				
KTP	KTP1045		B		3	10	HSSE-V3	Blank ⁺	DIN 371	6H	R									
	KTP1046		B		12	36	HSSE-V3	Blank ⁺	DIN 376	6H	R									
	KTP1047		B		3	10	HSSE-V3	TiCN	DIN 371	6H	R									
	KTP1048		B		12	30	HSSE-V3	TiCN	DIN 376	6H	R									
	KTP1049		C	40°	3	10	HSSE-V3	Blank ⁺	DIN 371	6H	R									
	KTP1050		C	40°	12	36	HSSE-V3	Blank ⁺	DIN 376	6H	R									
	KTP1051		C	40°	3	10	HSSE-V3	TiCN	DIN 371	6H	R									
	KTP1052		C	40°	12	30	HSSE-V3	TiCN	DIN 376	6H	R									
	KTP1053		B		3	10	HSSE	Blank ⁺	DIN 371	6H	R									
	KTP1054		B		12	30	HSSE	Blank ⁺	DIN 376	6H	R									
	KTP1055		C	45°	3	10	HSSE	Blank ⁺	DIN 371	6H	R									
	KTP1056		C	45°	12	30	HSSE	Blank ⁺	DIN 376	6H	R									
	KTP1057		C		3	10	HSSE	Blank ⁺	DIN 371	6HX	R									
	KTP1058		C		12	20	HSSE	Blank ⁺	DIN 376	6HX	R									
	KTP1059		C		3	10	HSSE	TiCN	DIN 371	6HX	R									
	KTP1060		C		12	20	HSSE	TiCN	DIN 376	6HX	R									

THREAD-CUT THREAD TAP

Tool Selection Guide

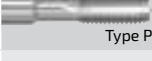
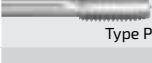
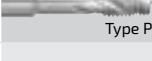
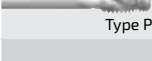
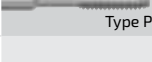
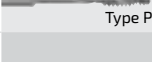
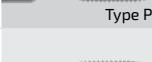
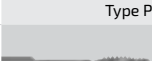
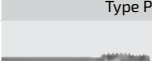
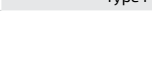


KTU SERIES

Thread type	Series	Model	Form	Helix angle	Min. size	Max. size	Material	Coating	Standard	Tolerance		Hole type	Steel	Stainless Steel	Hardened Steel	Hardened Steel	Cast Iron	Non-Ferrous Metals	Heat-Resistant Alloys (HPSA)	Titanium
															≤54 HRC	>54 HRC				
KTU	KTU9000	 Type U	B		1	10	HSSE	Blank ⁺	DIN 371	6H	R		●	○	○	○	●	●	○	○
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	KTU9002	 Type U	C	35°	1	10	HSSE	Blank ⁺	DIN 371	6H	R		●	○	○	○	●	●	○	○
	KTU9003	 Type U	C	35°	12	36	HSSE	Blank ⁺	DIN 376	6H	R		●	○	○	○	●	●	○	○
	KTU9004	 Type U	B		2	10	HSSE	TiN	DIN 371	6H	R		●	●	○	○	●	●	○	○
	KTU9005	 Type U	B		12	36	HSSE	TiN	DIN 376	6H	R		●	●	○	○	●	●	○	○
	KTU9006	 Type U	C	35°	2	10	HSSE	TiN	DIN 371	6H	R		●	●	○	○	●	●	○	○
	KTU9007	 Type U	C	35°	12	36	HSSE	TiN	DIN 376	6H	R		●	●	○	○	●	●	○	○
	KTU9008	 Type U	B		2	10	HSSE	TiAlN	DIN 371	6H	R		●	●	○	○	●	●	○	○
	KTU9009	 Type U	B		12	36	HSSE	TiAlN	DIN 376	6H	R		●	●	○	○	●	●	○	○
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	KTU9012	 Type U	B		2	10	HSSE	AlCro	DIN 371	6H	R		●	●	○	○	●	●	○	○
	KTU9013	 Type U	B		12	36	HSSE	AlCro	DIN 376	6H	R		●	●	○	○	●	●	○	○
	KTU9014	 Type U	C	35°	2	10	HSSE	AlCro	DIN 371	6H	R		●	●	○	○	●	●	○	○
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KTU SERIES

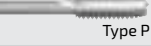
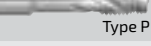
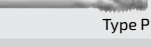
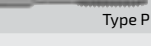
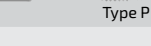
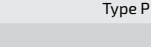
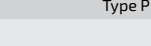
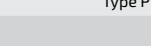
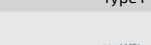
Thread type	Series	Model	Form	Helix angle	Min. size	Max. size	Material	Coating	Standard	Tolerance		Hole type	Steel	Stainless Steel	Hardened Steel	Hardened Steel	Cast Iron	Non-Ferrous Metals	Heat-Resistant Alloys (HRSA)	Titanium
															≤54 HRC	>54 HRC				
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	KTU9038	 Type P	C	38°	2	10	HSSE	Blank ⁺	DIN 371	6H	R		●	○	○	○	●	●	○	○
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	KTU9040	 Type P	B		2.5	10	HSSE	Blank ⁺	DIN 371	6G	R		●	○	○	○	●	●	○	○
	KTU9041	 Type P	B		12	24	HSSE	Blank ⁺	DIN 376	6G	R		●	○	○	○	●	●	○	○
	KTU9042	 Type P	C	38°	2	10	HSSE	Blank ⁺	DIN 371	6G	R		●	○	○	○	●	●	○	○
	KTU9043	 Type P	C	38°	12	45	HSSE	Blank ⁺	DIN 376	6G	R		●	○	○	○	●	●	○	○
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	KTU9049	 Type P	B		12	24	HSSE	Blank ⁺	DIN 376	6H	L		●	○	○	○	●	●	○	○
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	KTU9053	 Type P	B		12	20	HSSE	Blank ⁺	DIN 376	6H ⁺ 0.1	R		●	○	○	○	●	●	○	○

THREAD-CUT THREAD TAP

Tool Selection Guide

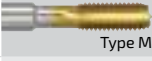
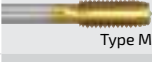
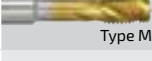
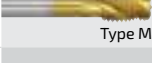
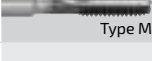
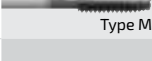
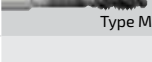
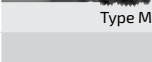
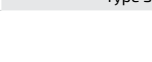


KTU SERIES

Thread type	Series	Model	Form	Helix angle	Min. size	Max. size	Material	Coating	Standard	Tolerance		Hole type	Steel	Stainless Steel	Hardened Steel	Hardened Steel	Cast Iron	Non-Ferrous Metals	Heat-Resistant Alloys (HPSA)	Titanium
															≤54 HRC	>54 HRC				
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	KTU9021	 Type P	B		12	24	HSSE-PM	Blank ⁺	DIN 376	6H	R		●	●	○	○	○	○	○	○
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	KTU9060	 Type P	B		3	10	HSSE-PM	TiCN	DIN 371	6H	R		●	●	○	○	○	○	○	○
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	KTU9063	 Type P	C	38°	12	36	HSSE-PM	TiCN	DIN 376	6H	R		●	●	○	○	○	○	○	○
	KTU9102	 Type M	B		2	10	HSSE	VAP	DIN 371	6H	R		○	●	○	○	○	○	○	○
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KTU SERIES

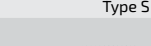
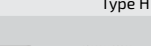
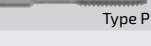
Thread type	Series	Model	Form	Helix angle	Min. size	Max. size	Material	Coating	Standard	Tolerance		Hole type	Steel	Stainless Steel	Hardened Steel	Hardened Steel	Cast Iron	Non-Ferrous Metals	Heat-Resistant Alloys (HPSA)	Titanium
															≤54 HRC	>54 HRC				
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	KTU9132	 Type M	B		3	10	HSSE	TiN	DIN 371	6H	R		○	●	○	○	○	○	○	○
	KTU9133	 Type M	B		12	36	HSSE	TiN	DIN 376	6H	R		○	●	○	○	○	○	○	○
	KTU9134	 Type M	C	38°	3	10	HSSE	TiN	DIN 371	6H	R		○	●	○	○	○	○	○	○
	KTU9135	 Type M	C	38°	12	36	HSSE	TiN	DIN 376	6H	R		○	●	○	○	○	○	○	○
	KTU9106	 Type M	B		2	10	HSSE-PM	KSWC	DIN 371	6HX	R		○	●	○	○	○	○	○	○
	KTU9107	 Type M	B		12	24	HSSE-PM	KSWC	DIN 376	6HX	R		○	●	○	○	○	○	○	○
	KTU9108	 Type M	C	50°	2	10	HSSE-PM	KSWC	DIN 371	6HX	R		○	●	○	○	○	○	○	○
	KTU9109	 Type M	C	50°	12	24	HSSE-PM	KSWC	DIN 376	6HX	R		○	●	○	○	○	○	○	○
	KTU9138	 Type K	C	15°	3	10	HSSE-PM	TiCN	DIN 371	6HX	R		○	○	○	○	○	○	○	○
	KTU9139	 Type K	C	15°	12	20	HSSE-PM	TiCN	DIN 376	6HX	R		○	○	○	○	○	○	○	○
	KTU9140	 Type S	B		2	10	HSSE-PM	Ni	DIN 371	6H	R		○	○	○	○	○	○	○	○
	KTU9141	 Type S	B		12	20	HSSE-PM	Ni	DIN 376	6H	R		○	○	○	○	○	○	○	○
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THREAD-CUT THREAD TAP

Tool Selection Guide

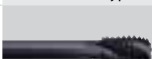
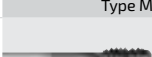
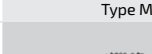
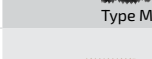
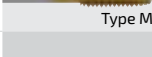
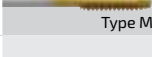
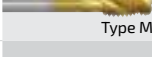
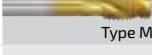
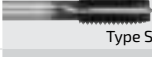


KTU SERIES

Thread type	Series	Model	Form	Helix angle	Min. size	Max. size	Material	Coating	Standard	Tolerance		Hole type	Steel	Stainless Steel	Hardened Steel	Hardened Steel	Cast Iron	Non-Ferrous Metals	Heat-Resistant Alloys (HRA)	Titanium
															≤54 HRC	>54 HRC				
KTU	KTU9144	 Type S	B		2	10	HSSE-PM	NT	DIN 371	6H	R		○	○	○	○	○	○	○	●
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	KTU9146	 Type S	C	25°	2	10	HSSE-PM	NT	DIN 371	6H	R		○	○	○	○	○	○	○	●
	KTU9147	 Type S	C	25°	12	20	HSSE-PM	NT	DIN 376	6H	R		○	○	○	○	○	○	○	●
	KTU9168	 Type H	D		4	10	HSSE-PM	TiAlN	DIN 371	6HX	R		○	○	●	○	○	○	○	○
	KTU9169	 Type H	D		12	20	HSSE-PM	TiAlN	DIN 376	6HX	R		○	○	●	○	○	○	○	○
	KTU9170	 Type H	D		2	10	VHM	TiAlN	DIN 371	6HX	R		○	○	○	●	○	○	○	○
	KTU9171	 Type H	D		12	16	VHM	TiAlN	DIN 376	6HX	R		○	○	○	●	○	○	○	○
	KTU9407	 Type S	A		2	24	HSSE-V3	Blank ⁺	DIN 352	6H	R		○	○	○	○	○	○	●	●
	KTU9413	 Type H	A		3	24	HSSE-PM	Blank ⁺	DIN 352	6H	R		○	○	●	○	○	○	○	○
MF	KTU9064	 Type P	B		3x0.35	5x0.5	HSSE	Blank ⁺	DIN 371	6H	R		●	○	○	○	○	○	○	○
	KTU9064	 Type P	B		6x0.5	20x2	HSSE	Blank ⁺	DIN 374	6H	R		●	○	○	○	○	○	○	○
	KTU9065	 Type P	B		22x1	52x3	HSSE	Blank ⁺	DIN 374	6H	R		●	○	○	○	○	○	○	○
	KTU9066	 Type P	C	38°	3x0.35	6x0.5	HSSE	Blank ⁺	DIN 371	6H	R		●	○	○	○	○	○	○	○
	KTU9066	 Type P	C	38°	6x0.75	20x2	HSSE	Blank ⁺	DIN 374	6H	R		●	○	○	○	○	○	○	○
	KTU9067	 Type P	C	38°	22x1.5	52x1.5	HSSE	Blank ⁺	DIN 374	6H	R		●	○	○	○	○	○	○	○



KTU SERIES

Thread type	Series	Model	Form	Helix angle	Min. size	Max. size	Material	Coating	Standard	Tolerance		Hole type	Steel	Stainless Steel	Hardened Steel	Hardened Steel	Cast Iron	Non-Ferrous Metals	Heat-Resistant Alloys (HRSA)	Titanium
													≤54 HRC	>54 HRC						
KTU	MF	 Type P	B		8x1	20x1.5	HSSE	Blank ⁺	DIN 374	6G	R		●	○	○	○	●	●	○	○
		 Type P	B		8x1	20x1.5	HSSE-PM	TiCN	DIN 374	6H	R		●	●	○	○	○	○	○	○
		 Type P	C	38°	8x1	20x1.5	HSSE-PM	TiCN	DIN 374	6H	R		●	●	○	○	○	○	○	○
		 Type M	B		8x0.75	20x1.5	HSSE	VAP	DIN 374	6H	R		○	●	○	○	○	○	○	○
		 Type M	B		22x1.5	30x1.5	HSSE	VAP	DIN 374	6H	R		○	●	○	○	○	○	○	○
		 Type M	C	38°	8x0.75	20x1.5	HSSE	VAP	DIN 374	6H	R		○	●	○	○	○	○	○	○
		 Type M	C	38°	22x1.5	30x1.5	HSSE	VAP	DIN 374	6H	R		○	●	○	○	○	○	○	○
		 Type M	B		8x1	20x1.5	HSSE-PM	KSWC	DIN 374	6HX	R		●	●	○	○	●	○	○	○
		 Type M	B		22x1.5	24x1.5	HSSE-PM	KSWC	DIN 374	6HX	R		●	●	○	○	●	○	○	○
		 Type M	C	38°	8x1	20x1.5	HSSE-PM	KSWC	DIN 374	6HX	R		●	●	○	○	●	○	○	○
		 Type M	C	38°	22x1.5	24x1.5	HSSE-PM	KSWC	DIN 374	6HX	R		●	●	○	○	●	○	○	○
		 Type M	B		8x0.75	20x1.5	HSSE	TiN	DIN 374	6H	R		●	●	○	○	●	○	○	○
		 Type M	B		22x1.5	30x1.5	HSSE	TiN	DIN 374	6H	R		●	●	○	○	●	○	○	○
		 Type M	C	38°	8x0.75	20x1.5	HSSE	TiN	DIN 374	6H	R		●	●	○	○	●	○	○	○
		 Type M	C	38°	22x1.5	30x1.5	HSSE	TiN	DIN 374	6H	R		●	●	○	○	●	○	○	○
		 Type S	B		8x1	20x1.5	HSSE-PM	Ni	DIN 374	6H	R		○	○	○	○	○	○	●	○
		 Type S	C	25°	8x1	20x1.5	HSSE-PM	Ni	DIN 374	6H	R		○	○	○	○	○	○	●	○

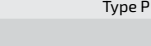
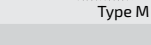
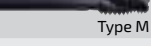
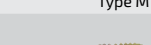
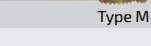
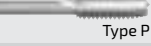
THREAD-CUT THREAD TAP

Tool Selection Guide



KTU SERIES

Thread type	Series	Model	Form	Helix angle	Min. size	Max. size	Material	Coating	Standard	Tolerance		Hole type	Steel	Stainless Steel	Hardened Steel	Hardened Steel	Cast Iron	Non-Ferrous Metals	Heat-Resistant Alloys (HRS)	Titanium

KTU	BSW	KTU9088		Type P	B		1/8	2	HSSE	Blank+	DIN 2184-1		R		●	○	○	○	○	○	○
		KTU9089		Type P	C	38°	1/8	1.1/2	HSSE	Blank+	DIN 2184-1		R		●	○	○	○	○	○	○
		KTU9076		Type P	B		1/8	2	HSSE	Blank+	DIN 5156	6H	R		●	○	○	○	○	○	○
		KTU9077		Type P	C	38°	1/8	2	HSSE	Blank+	DIN 5156	6H	R		●	○	○	○	○	○	○
		KTU9078		Type P	B		1/8	1/2	HSSE-PM	TiCN	DIN 5156	6H	R		●	●	○	○	○	○	○
		KTU9079		Type P	C	38°	1/8	1/2	HSSE-PM	TiCN	DIN 5156	6H	R		●	●	○	○	○	○	○
	BSP G	KTU9118		Type M	B		1/8	1	HSSE	VAP	DIN 5156	6H	R		○	●	○	○	○	○	○
		KTU9119		Type M	C	38°	1/8	1	HSSE	VAP	DIN 5156	6H	R		○	●	○	○	○	○	○
		KTU9120		Type M	B		1/8	3/4	HSSE-PM	KSWC	DIN 5156	6H	R		○	●	○	○	○	○	○
		KTU9121		Type M	C	50°	1/8	3/4	HSSE-PM	KSWC	DIN 5156	6H	R		○	●	○	○	○	○	○
		KTU9182		Type M	B		1/8	1	HSSE	TiN	DIN 5156	6H	R		○	●	○	○	○	○	○
		KTU9183		Type M	C	38°	1/8	1	HSSE	TiN	DIN 5156	6H	R		○	●	○	○	○	○	○
	UNC	KTU9080		Type P	B		Nr.2	1.1/2	HSSE	Blank+	DIN 2184-1	2B	R		●	○	○	○	○	○	○
		KTU9081		Type P	C	38°	Nr.2	1.3/4	HSSE	Blank+	DIN 2184-1	2B	R		●	○	○	○	○	○	○
		KTU9082		Type P			Nr.4	3/4	HSSE-PM	TiCN	DIN 2184-1	2BX	R		●	●	○	○	○	○	○
		KTU9083		Type P		38°	Nr.4	3/4	HSSE-PM	TiCN	DIN 2184-1	2BX	R		●	●	○	○	○	○	○
		KTU9122		Type M	B		Nr.4	1	HSSE	VAP	DIN 2184-1	2B	R		○	●	○	○	○	○	○



KTU SERIES

Thread type	Series	Model	Form	Helix angle	Min. size	Max. size	Material	Coating	Standard	Tolerance		Hole type	Steel	Stainless Steel	Hardened Steel	Hardened Steel	Cast Iron	Non-Ferrous Metals	Heat-Resistant Alloys (HRS)	Titanium
															≤54 HRC	>54 HRC				
KTU	UNC	KTU9123	Type M	C	38°	Nr.4	1	HSSE	VAP	DIN 2184-1	2B	R		○	●	○	○	○	○	○
		KTU9184	Type M	B		Nr.4	1	HSSE	TiN	DIN 2184-1	2B	R		○	●	○	○	○	○	○
		KTU9185	Type M	C	38°	Nr.4	1	HSSE	TiN	DIN 2184-1	2B	R		○	●	○	○	○	○	○
		KTU9124	Type M	B		Nr.4	3/4	HSSE-PM	KSWC	DIN 2184-1	2BX	R		○	●	○	○	○	○	○
		KTU9125	Type M	C	50°	Nr.4	3/4	HSSE-PM	KSWC	DIN 2184-1	2BX	R		○	●	○	○	○	○	○
		KTU9156	Type S	B		Nr.4	1/2	HSSE-PM	Ni	DIN 2184-1	2B	R		○	○	○	○	○	○	○
		KTU9157	Type S	C	25°	Nr.4	1/2	HSSE-PM	Ni	DIN 2184-1	2B	R		○	○	○	○	○	○	○
		KTU9158	Type S	B		Nr.4	3/8	HSSE-PM	NT	DIN 2184-1	2B	R		○	○	○	○	○	○	○
		KTU9159	Type S	C	25°	Nr.4	3/8	HSSE-PM	NT	DIN 2184-1	2B	R		○	○	○	○	○	○	○
	UNF	KTU9084	Type P	B		Nr.2	1.1/2	HSSE	Blank+	DIN 2184-1	2B	R		●	○	○	○	○	○	○
		KTU9085	Type P	C	38°	Nr.2	1.1/2	HSSE	Blank+	DIN 2184-1	2B	R		●	○	○	○	○	○	○
		KTU9086	Type P	B		Nr.6	1/2	HSSE-PM	TiCN	DIN 2184-1	2BX	R		●	●	○	○	○	○	○
		KTU9087	Type P	C	38°	Nr.4	1/2	HSSE-PM	TiCN	DIN 2184-1	2BX	R		●	●	○	○	○	○	○
		KTU9126	Type M	B		Nr.6	1	HSSE	VAP	DIN 2184-1	2B	R		○	●	○	○	○	○	○
		KTU9127	Type M	C	38°	Nr.6	1	HSSE	VAP	DIN 2184-1	2B	R		○	●	○	○	○	○	○
		KTU9186	Type M	B		Nr.6	1	HSSE	TiN	DIN 2184-1	2B	R		○	●	○	○	○	○	○
		KTU9187	Type M	C	38°	Nr.8	1	HSSE	TiN	DIN 2184-1	2B	R		○	●	○	○	○	○	○

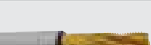
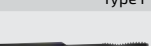
THREAD-CUT THREAD TAP

Tool Selection Guide



KTU SERIES

Thread type	Series	Model	Form	Helix angle	Min. size	Max. size	Material	Coating	Standard	Tolerance		Hole type	Steel	Stainless Steel	Hardened Steel	Hardened Steel	Cast Iron	Non-Ferrous Metals	Heat-Resistant Alloys (HPSA)	Titanium
															≤54 HRC	>54 HRC				

KTU	UNF	KTU9128		Type M	B		Nr.10	3/4	HSSE-PM	KSWC	DIN 2184-1	2BX	R									
		KTU9129		Type M	C	50°	Nr.10	3/4	HSSE-PM	KSWC	DIN 2184-1	2BX	R									
		KTU9160		Type S	B		Nr.6	1/2	HSSE-PM	Ni	DIN 2184-1	2B	R									
		KTU9161		Type S	C	25°	Nr.6	1/2	HSSE-PM	Ni	DIN 2184-1	2B	R									
		KTU9162		Type S	B		Nr.6	3/8	HSSE-PM	NT	DIN 2184-1	2B	R									
		KTU9163		Type S	C	25°	Nr.6	3/8	HSSE-PM	NT	DIN 2184-1	2B	R									
	Pg	KTU9090		Type P	C		7	48	HSSE	Blank+	DIN 40430		R									
	Rp	KTU9092		Type P	B		1/8	1	HSSE	Blank+	DIN 5156		R									
		KTU9093		Type P	C	38°	1/8	1	HSSE	Blank+	DIN 5156		R									
		KTU9130		Type M	B		1/8	1	HSSE	VAP	DIN 5156		R									
		KTU9131		Type M	C	38°	1/8	1	HSSE	VAP	DIN 5156		R									
	Rc	KTU9094		Type P	C		1/8	1	HSSE	Blank+	DIN 5156		R									
		KTU9136		Type M	C	38°	1/8	1	HSSE	TiN	DIN 5156		R									
	NPT	KTU9095		Type P	C		1/16	2	HSSE	Blank+	DIN 5156		R									
		KTU9137		Type M	C	38°	1/16	1	HSSE	VAP	DIN 5156		R									
	NPTF	KTU9096		Type P	C		1/16	2	HSSE	Blank+	DIN 5156		R									



KTF SERIES

Thread type	Series	Model	Form	Helix angle	Min. size	Max. size	Material	Coating	Standard	Tolerance		Hole type	Steel	Stainless Steel	Hardened Steel	Hardened Steel	Cast Iron	Non-Ferrous Metals	Heat-Resistant Alloys (HPSA)	Titanium
															≤54 HRC	>54 HRC				
KTF	M	 KTF1900	C		1	1.4	HSSE-PM	TiN	DIN 371	4HX	R		●	●	○	○	○	●	○	○
		 KTF1900	C		1.6	2.5	HSSE-PM	TiN	DIN 371	6HX	R		●	●	○	○	○	●	○	○
		 KTF1900	C		3	10	HSSE	TiN	DIN 371	6HX	R		●	●	○	○	○	●	○	○
		 KTF1900	C		12	16	HSSE	TiN	DIN 376	6HX	R		●	●	○	○	○	●	○	○
		 KTF1902	C		1	1.4	HSSE-PM	Blank+	DIN 371	4HX	R		●	●	○	○	○	●	○	○
		 KTF1902	C		1.6	2.5	HSSE-PM	Blank+	DIN 371	6HX	R		●	●	○	○	○	●	○	○
		 KTF1902	C		3	10	HSSE	Blank+	DIN 371	6HX	R		●	●	○	○	○	●	○	○
		 KTF1902	C		12	16	HSSE	Blank+	DIN 376	6HX	R		●	●	○	○	○	●	○	○
		 KTF1903 With flutes	C		3	10	HSSE	TiN	DIN 371	6HX	R		●	●	○	○	○	●	○	○
		 KTF1903 With flutes	C		12	16	HSSE	TiN	DIN 376	6HX	R		●	●	○	○	○	●	○	○
		 KTF1905 With flutes	C		3	10	HSSE	Blank+	DIN 371	6HX	R		●	●	○	○	○	●	○	○
		 KTF1905 With flutes	C		12	16	HSSE	Blank+	DIN 376	6HX	R		●	●	○	○	○	●	○	○

THREAD-CUT THREAD TAP

KTH SERIES

Tool Selection Guide



Thread type	Series	Model	Form	Helix angle	Min. size	Max. size	Material	Coating	Standard	Tolerance		Hole type	Steel	Stainless Steel	Hardened Steel	Hardened Steel	Cast Iron	Non-Ferrous Metals	Heat-Resistant Alloys (HPSA)	Titanium
															≤54 HRC	>54 HRC				
KTH	Σ	KTH0105		A	1	60	HSS	Blank+ *	DIN 352	6H	R		●	○	○	○	●	●	○	○
		KTH0107		A	2	30	HSSE	Blank+ *	DIN 352	6H	R		●	●	○	○	●	●	○	○
		KTH0813		A	2	24	HSSE	VAP	DIN 352	6H	R		●	●	○	○	●	●	●	●
		KTH0109		A	3	30	HSS	Blank+ *	DIN 352	6H	L		●	○	○	○	●	●	○	○
	MF	KTH0115		B	2.5x0.35	21x1	HSS	Blank+ *	DIN 2181	6H	R		●	○	○	○	●	●	○	○
		KTH0122		B	21x1.5	52x4	HSS	Blank+ *	DIN 2181	6H	R		●	○	○	○	●	●	○	○
		KTH0142		B	6x0.75	20x2	HSSE	Blank+ *	DIN 2181	6H	R		●	●	○	○	●	●	○	○
		KTH0143		B	22x1.5	24x1.5	HSSE	Blank+ *	DIN 2181	6H	R		●	●	○	○	●	●	○	○
	BSW	KTH0135		A	1/16	2	HSS	Blank+	DIN 2184-2	stand. BS84	R		●	○	○	○	●	●	○	○
		KTH0155		B	1/8	4	HSS	Blank+ *	DIN 5157	6H	R		●	○	○	○	●	●	○	○
	BSP	KTH0159		B	1/8	3	HSSE	Blank+ *	DIN 5157	6H	R		●	●	○	○	●	●	○	○

* Optionally available coating



KTH SERIES

Thread type	Series	Model	Form	Helix angle	Min. size	Max. size	Material	Coating	Standard	Tolerance		Hole type	Steel	Stainless Steel	Hardened Steel	Hardened Steel	Cast Iron	Non-Ferrous Metals	Heat-Resistant Alloys (HPSA)	Titanium
															≤54 HRC	>54 HRC				
KTH	BSP	KTH0157		B	1/8	3	HSS	Blank ⁺	DIN 5157	6H	L		●	○	○	○	●	●	○	○
	BSF	KTH0145		B	3/16	1	HSS	Blank ⁺	DIN 2184-2		R		●	○	○	○	●	●	○	○
	UNC	KTH0165		A	N°1	1.1/2	HSS	Blank ⁺ *	DIN 2184-2	2B	R		●	○	○	○	●	●	○	○
	UNF	KTH0175		B	N°0	1.1/2	HSS	Blank ⁺ *	DIN 2184-2	2B	R		●	○	○	○	●	●	○	○
	UNEF	KTH0177		B	N°12	1.11/16	HSS	Blank ⁺	DIN 2184-2	2B	R		●	○	○	○	●	●	○	○
	UNS	KTH0167		B	1/4	3	HSS	Blank ⁺	DIN 2184-2	2B	R		●	○	○	○	●	●	○	○
	Pg	KTH0191		B	7	48	HSS	Blank ⁺	DIN 2184-2	2B	R		●	○	○	○	●	●	○	○
	NPT	KTH0181			1/16	4	HSS	Blank ⁺	DIN 2184-2		R		●	○	○	○	●	●	○	○
		KTH0193		B	10	32	HSS	Blank ⁺		7H	R		●	○	○	○	●	●	○	○
	Tr	KTH0183		B	10	40	HSSE	Blank ⁺ *		7H	R		●	●	○	○	●	●	○	○
		KTH0189		B	10	40	HSSE	Blank ⁺		7H	L		●	●	○	○	●	●	○	○

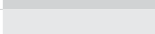
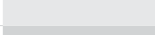
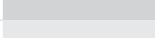
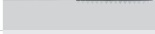
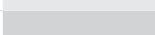
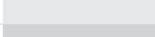
* Optionally available coating

THREAD-CUT THREAD TAP

KTHM, KTN SERIES

Tool Selection Guide



													Steel	Stainless Steel	Hardened Steel	Hardened Steel	Cast Iron	Non-Ferrous Metals	Heat-Resistant Alloys (HPSA)	Titanium	
Thread type	Series	Model	Form	Helix angle	Min. size	Max. size	Material	Coating	Standard	Tolerance		Hole type			≤54 HRC	>54 HRC					
KTHM	Σ	KTHM0202		A		3	12	HSS	Blank ⁺	DIN 352	6H	R									
		KTHM0204		B		3	24	HSS	Blank ⁺	DIN 352	6H	R									
		KTHM0206		B		3	24	HSSE	Blank ⁺	DIN 352	6H	R									
		KTHM0205		C		1	56	HSS	Blank ⁺	DIN 352	6H	R									
		KTHM0219		C	35°	3	24	HSS	Blank ⁺	DIN 352	6H	R									
	MF	KTHM0220		C		3x0.35	21x1	HSS	Blank ⁺	DIN 2184	6H	R									
		KTHM0221		C		21x1.5	52x4	HSS	Blank ⁺	DIN 2181	6H	R									
	BSW	KTHM0235		C		1/16	2	HSS	Blank ⁺	DIN 2184-2	6H	R									
	BSP	KTHM0258		C		1/8	2	HSS	Blank ⁺	DIN 5157	6H	R									
	UNC	KTHM0260		C		1/4	1	HSS	Blank ⁺	DIN 2184-2	2B	R									
	UNF	KTHM0270		C		1/4	1	HSS	Blank ⁺	DIN 2184-2	2B	R									
	NPT	KTHM0280		C		1/16	2	HSS	Blank ⁺			R									
	NPTF	KTHM0282		C		1/16	2	HSS	Blank ⁺			R									
KTN	Σ	KTN3399		2/3x L2		3	24	HSSE	Blank ⁺		6H	R									
	Tr	KTN0831		2/3x L2		10	36	HSS	Blank ⁺		7H	R									
		KTN0292		2/3x L2		10	40	HSSE	Blank ⁺		7H	R									
		KTN0293		2/3 xL2		10	40	HSSE	Blank ⁺		7H	L									



Thread type	Series	Model	Form	Helix angle	Min. size	Max. size	Material	Coating	Standard	Tolerance		Hole type	Steel	Stainless Steel	Hardened Steel	Hardened Steel	Cast Iron	Non-Ferrous Metals	Heat-Resistant Alloys (HRA)	Titanium
															≤54 HRC	>54 HRC				
KTD	Σ	KTD0402		B	1	60	HSS	Blank+	DIN 223	6g	R		●	○	○	○	●	●	○	○
		KTD0404		B	3	52	HSS	Blank+	DIN 223	6g	L		●	○	○	○	●	●	○	○
		KTD0406		B	3	52	HSSE	Blank+	DIN 223	6g	R		●	●	○	○	●	●	○	○
		KTD0409		B	2	52	HSSE	VAP	DIN 223	6g	R		●	●	○	○	●	●	○	○
		KTD0403		B	3	12	HSS	Blank+	D25x9	6g	R		●	○	○	○	●	●	○	○
		KTD0502		B	3	68	HSS	Blank+	DIN 382	6g	R		●	○	○	○	●	●	○	○
	MF	KTD0414		B	2x0.25	20x2	HSS	Blank+	DIN 223	6g	R		●	○	○	○	●	●	○	○
		KTD0415		B	21x1.5	56x4	HSS	Blank+	DIN 223	6g	R		●	○	○	○	●	●	○	○
		KTD0417		B	4x0.5	20x1.5	HSS	Blank+	DIN 223	6g	L		●	○	○	○	●	●	○	○
		KTD0514		B	3x0.35	20x2	HSS	Blank+	DIN 382	6g	R		●	○	○	○	●	●	○	○
		KTD0515		B	21x1.5	52x3	HSS	Blank+	DIN 382	6g	R		●	○	○	○	●	●	○	○
	BSW	KTD0436		B	1/16	2	HSS	Blank+	DIN 223	6g	R		●	○	○	○	●	●	○	○
	BSP	KTD0452		B	1/8	3	HSS	Blank+	DIN 223	6g	R		●	○	○	○	●	●	○	○

THREAD-CUT THREAD TAP

Tool Selection Guide



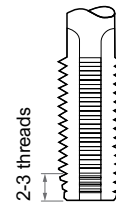
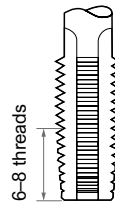
KTD SERIES

Thread type	Series	Model	Form	Helix angle	Min. size	Max. size	Material	Coating	Standard	Tolerance	Hole type	Hole type	Steel	Stainless Steel	Hardened Steel	Hardened Steel	Cast Iron	Non-Ferrous Metals	Heat-Resistant Alloys (HPSA)	Titanium
															≤54 HRC	>54 HRC				
KTD	BSP	KTD0458		B	1/8	2	HSSE	Blank+	DIN 223	6g	R		●	●	○	○	●	●	○	○
	BSF	KTD0444		B	3/16	1.1/2	HSS	Blank+	DIN 223	6g	R		●	○	○	○	●	●	○	○
	UNC	KTD0462		B	N°1	2	HSS	Blank+	DIN 223	2a	R		●	○	○	○	●	●	○	○
	UNF	KTD0472		B	N°0	1.1/2	HSS	Blank+	DIN 223	2a	R		●	○	○	○	●	●	○	○
	UNS	KTD0466		B	1/4	1.3/4	HSS	Blank+	DIN 223	2a	R		●	○	○	○	●	●	○	○
	Pg	KTD490		B	7	48	HSS	Blank+	DIN 223		R		●	○	○	○	●	●	○	○
	NPT	KTD0480		B	1/16	2	HSS	Blank+	DIN 223		R		●	○	○	○	●	●	○	○
	Tr	KTD0492		B	10	36	HSS	Blank+	DIN 223	7e	R		●	○	○	○	●	●	○	○





Taper Lead Selection Guide



	Form A	Form B	Form C
Chip flute type	straight flutes	straight flutes, negative helix angle of taper lead	straight or helical flutes
Main use	for through holes in materials that produce medium-length chips or continuous chips	for through holes in materials producing medium-length chips or continuous chips	for blind holes in materials producing continuous and medium-length chips, and for through holes in materials producing segmented chips

Guide for Tool Material Selection

Material type	Description
HSS	High quality high speed steel taps. High-speed steel (HSS) refers to a group of alloy tool steels with a carbon content of up to 2.06 %, as well as up to 30 % content of alloying elements such as tungsten, molybdenum, vanadium, cobalt, nickel and titanium. HSS class materials are characterized by high hardness, wear resistance and heat resistance up to 600 °C. HSS are less sensitive to shock and vibration, which sometimes lead to very rapid breakage of cutting tools made of harder materials.
HSSE	Taps made of high-quality high-speed steel with 5 % cobalt. Maintaining hardness at high temperatures ensures a longer service life. HSSE is used for machining high strength materials and for machining deep threads with corresponding high heat. The 5 % cobalt content provides higher heat resistance and load capacity.
HSSE-PM	The PM abbreviation for HSSE-PM does not refer to the alloy components of high performance high speed steel, but to the production method. The powder is pressed at ultra-high temperatures, then sintered in a special furnace. The steel advantages arise from a more uniform and dense distribution of carbide (carbide = hard substances in steel). This allows for better material machining. But in use it is still wear-resistant and with high heat resistance of the material. Suitable for machining high-strength and hard-to-machine materials such as titanium alloys or heat-resistant alloys.
HSSE-V3	The abbreviation V3 stands for the vanadium content in the tap alloy structure. HSSE-V3 steel is superior in mechanical strength to other high-speed steels and is used for the production of high-strength taps.
VHM	Carbide taps for machining hardened materials up to 63 HRC. Taps are designed for use exclusively in CNC equipment. Manual operation is prohibited.



Coating Selection Guide

Coating type	Description
VAP	Steam thermal treatment or steam oxidation enhances the lubricating effect of the coolant and thus prevents the chip pickup. Well suited for machining stainless steels.
TiN	Titanium nitride is currently the most common and versatile coating. Compared to other coatings, it does not always provide maximum durability. Due to chemical affinity, TiN coating is generally not recommended for machining titanium.
TiAlN	Gray-purple coating with a steel friction coefficient of 0.4. Titanium nitride, but alloyed with aluminum, is used for spraying. Due to the use of an alloying component, the cutting edge hardness increases by 3000 HV. The tool is suitable for cutting threads in heat resistant, alloy and carbon steels.
TiCN	Titanium carbonitride has a higher hardness than TiN coating (approx. 3000 HV vs. 2300 HV), but a slightly lower heat resistance (approx. 400 °C vs. 600 °C). It is used primarily in the machining of abrasive materials. The TiCN coating is particularly well suited for machining gray cast iron and AlSi alloys with Si content greater than 5 %.
AlCr	Blue-gray coating with the lowest steel friction coefficient of 0.35 and the highest heat resistance of over 1100 °C.
KSWC	The unique KSWC coating developed together with Oerlikon specifically for the machining Group M materials.
Ni	Taps with a nitrided coating are recommended for use in machining materials that cause severe abrasive wear, in particular: gray cast iron, aluminum alloys with a high silicon content (more than 10 %). Nitriding increases the hardness of the cutting edge of the tool and reduces friction and, therefore, heating. The surface layer is more resistant to tempering.

KTU Series Tap Selection Guide

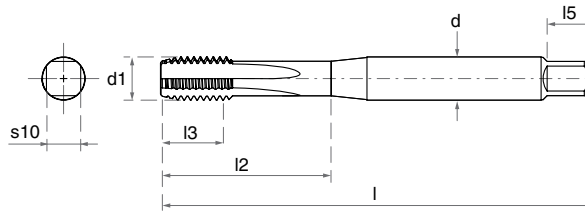
Material	P							M			K	S		H	
Coating type	U	P	PPM	PTiCN	PVAP	PTiN	PKSWC	MVAP	MTiN	MSTC	KTiCN	SNi	STiNT	HALTiN	H H M ALTiN

THREAD-CUT THREAD TAP

Nominal dimensions of M and MF machine taps



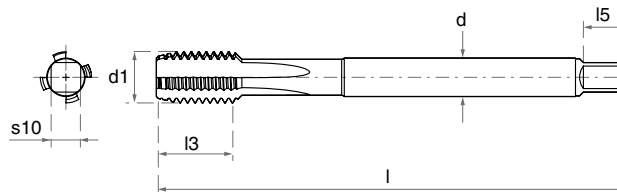
DIN
371



d1	increment	d	l	l3*	l2	l5	s10
M3	0.5	3.5	56	11	18	6	2.7
M3.5	0.6	4	56	12	20	6	3
M4	0.7	4.5	63	13	21	6	3.4
M4.5	0.75	6	70	16	25	8	4.9
M5	0.8	6	70	16	25	8	4.9
M6	1	6	80	19	30	8	4.9
M7	1	7	80	19	30	8	5.5
M8	0.75	8	80	18	30	9	6.2
M8	1.25	8	90	22	35	9	6.2
M9	0.75	9	80	18	30	10	7
M9	1.25	9	90	22	35	10	7
M10	1	10	90	20	35	11	8
M10	1.5	10	100	24	39	11	8

* Maximum

DIN
376

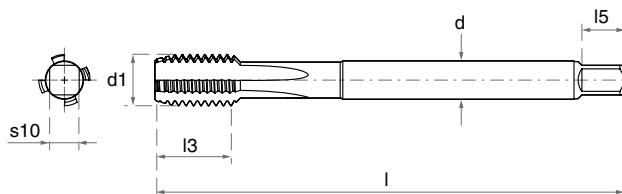


d1	increment	d	l	l3*	l5	s10
M8	1.25	6	90	22	8	4.9
M9	1.25	7	90	22	8	5.5
M10	1.5	7	100	24	8	5.5
M11	1.5	8	100	24	9	6.2
M12	1.75	9	110	28	10	7
M14	2	11	110	30	12	9
M16	2	12	110	32	12	9
M18	2.5	14	125	34	14	11
M20	2.5	16	140	34	15	12
M22	2.5	18	140	34	17	14.5
M24	3	18	160	38	17	14.5
M27	3	20	160	38	19	16
M30	3.5	22	180	45	21	18
M33	3.5	25	180	50	23	20
M36	4	28	200	56	25	22
M39	4	32	200	60	27	24
M42	4.5	32	200	60	27	24
M45	4.5	36	220	65	32	29

* Maximum



DIN
374



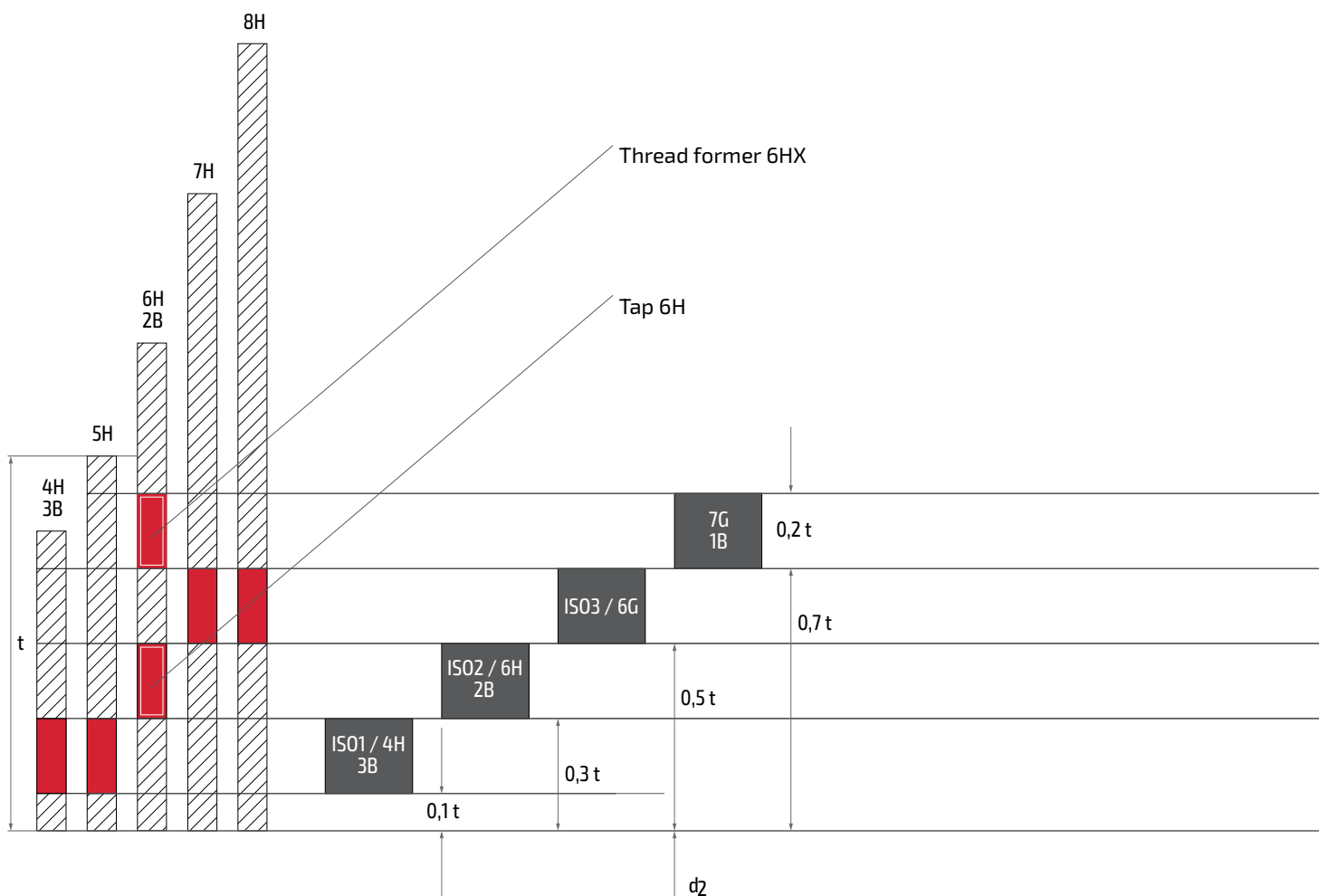
d1	increment		d	l	l3*	l5	s10
	min	max					
M8	0.2	0.75	6	80	18	8	4.9
M8	-	1	6	90	22	8	4.9
M9	0.2	0.75	7	80	18	8	5.5
M9	-	1	7	90	22	8	5.5
M10	0.2	1	7	90	20	8	5.5
M10	-	1.25	7	100	24	8	5.5
M11	0.35	1	8	90	20	9	6.2
M12	0.35	1.5	9	100	22	10	7
M14	0.35	1.5	11	100	22	12	9
M16	0.35	1.5	12	100	22	12	9
M16	-	2	12	110	32	12	9
M18	0.35	1.5	14	110	25	14	11
M18	-	2	14	125	34	14	11
M20	0.35	1.5	16	125	25	15	12
M20	-	2	16	140	34	15	12
M22	0.35	1.5	18	125	25	17	14.5
M22	-	2	18	140	34	17	14.5
M24	0.35	2	18	140	28	17	14.5
M27	0.35	2	20	140	28	19	16
M30	0.35	2	22	150	28	21	18
M30	-	3	22	180	45	21	18

* Maximum

Thread tolerances

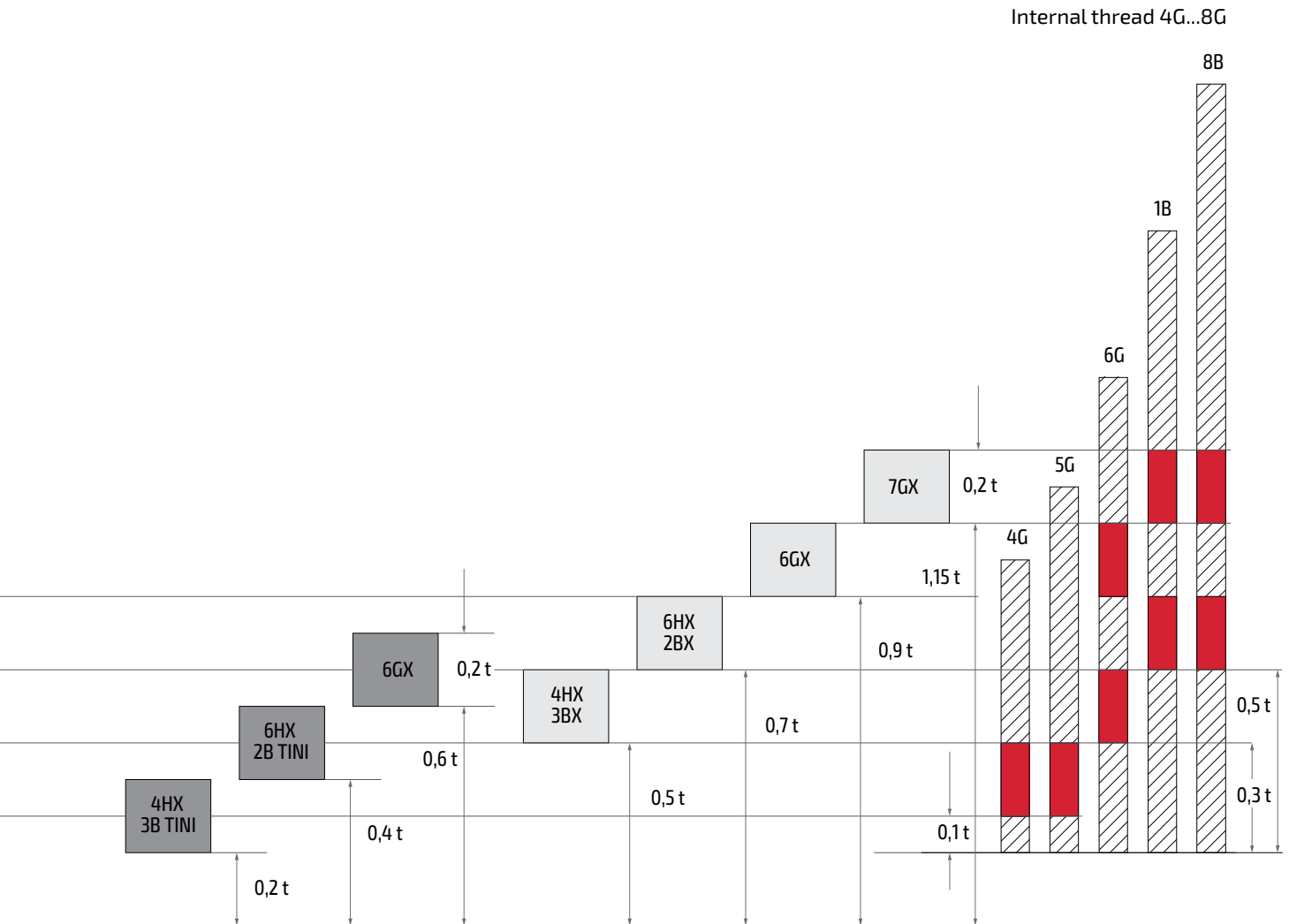
0114 13, part 15

Internal thread 4H...8H



d_2 = average diameter

t = tolerance limits according to DIN13, part 15 ANSI/ASME B1.1



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