



# SCREW THREAD INSERT TAPS

## T2197 SERIES

### M SCREW THREAD INSERT SPIRAL FLUTE TAPS 嵌套螺纹用螺旋槽丝锥

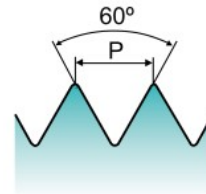
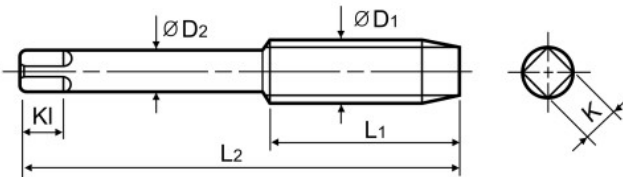
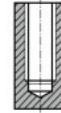
► Suitable for tapping deep Blind holes when a standard Straight Fluted tap is inadequate.

► 适用于标准直槽丝锥加工能力不足时的深盲孔加工。



up to M5 : Male Center

Hole type  
孔类型  
2.5×D



Material groups  
**AI**

HSS-E

STI

JIS 1b

60°

2.5P

R40

Bright



p. B194

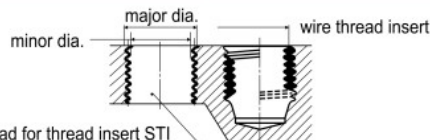


Plain Shank Page  
TAPPING ER CHUCK D215-220  
TAPPING CHUCK D221-228  
ONE STEP TAPPING CHUCK D211-213

Unit(单位) : mm

SIZE	Pitch	EDP No.	Limit	Overall Length	Thread Length	Shank Diameter	Square Size	Square Length	No. of Flute
尺寸	牙距	型号	精度	全长	螺纹长	柄径	方块尺寸	方块长度	槽数
ØD1	P			L2	L1	ØD2	K	KI	
M3 × 0.5		T2197201	JIS 1b	48	18	4	3.2	6	3
M4 × 0.7		T2197241	JIS 1b	60	22	5.5	4.5	7	3
M5 × 0.8		T2197281	JIS 1b	62	24	6	4.5	7	3
M6 × 1		T2197311	JIS 1b	65	26	6.2	5	8	3
M8 × 1.25		T2197361	JIS 1b	75	32	7	5.5	8	3
M10 × 1.5		T2197421	JIS 1b	82	38	8.5	6.5	9	3
M10 × 1.25		T2197431	JIS 1b	82	38	8.5	6.5	9	3
M12 × 1.75		T2197501	JIS 1b	90	42	10.5	8	11	3
M12 × 1.5		T2197511	JIS 1b	88	42	10.5	8	11	3
M12 × 1.25		T2197521	JIS 1b	88	42	10.5	8	11	3
M14 × 2		T2197541	JIS 1b	95	45	13	10	13	3
M14 × 1.5		T2197551	JIS 1b	95	45	12.5	10	13	3
M16 × 2		T2197601	JIS 1b	95	45	14	11	14	4
M16 × 1.5		T2197611	JIS 1b	95	45	14	11	14	4
M18 × 2.5		T2197651	JIS 1b	115	55	17	13	16	4
M18 × 1.5		T2197671	JIS 1b	95	45	15	12	15	4
M20 × 2.5		T2197701	JIS 1b	120	58	19	15	18	4
M20 × 1.5		T2197721	JIS 1b	95	45	17	13	16	4
M22 × 2.5		T2197741	JIS 1b	130	62	20	15	18	4
M22 × 1.5		T2197761	JIS 1b	95	45	19	15	18	4
M24 × 3		T2197781	JIS 1b	135	65	21	17	20	4
M24 × 1.5		T2197801	JIS 1b	95	45	20	15	18	4

► Refer to p.B233-B238 for recommended tap drill sizes.  
参考p.B233-B238 底孔尺寸。



◎ : Excellent (优秀) ○ : Good (良好)

ISO Material Description	P										M				K						
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel				Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25	42	21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended	○	○	○																		

ISO Material Description	N										S						H				
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys						Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended	◎	◎	◎	◎	◎																