

UNIMASTER TAPS

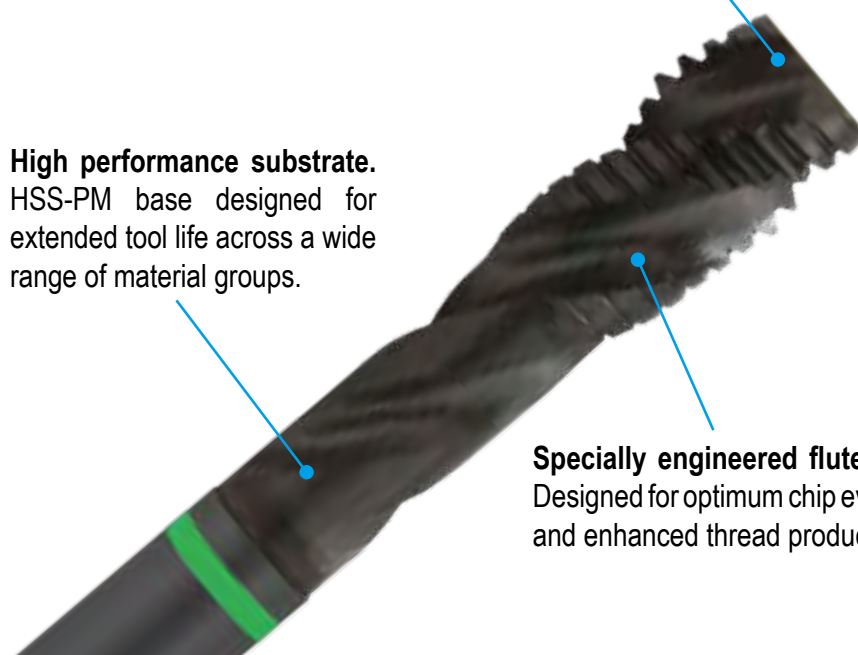


- Unique patented geometry designed for optimum chip evacuation and enhanced thread production.
- Made on specially designed, purpose built tap grinding machines.
- Excellent performance in a wide range of materials across all ISO material groups.
- Advanced base material gives excellent toughness and abrasion resistance.

Unique patented geometry.
Prevents over-feeding and oversize pitch diameter.

High performance substrate.
HSS-PM base designed for extended tool life across a wide range of material groups.

Specially engineered flute design.
Designed for optimum chip evacuation and enhanced thread production.

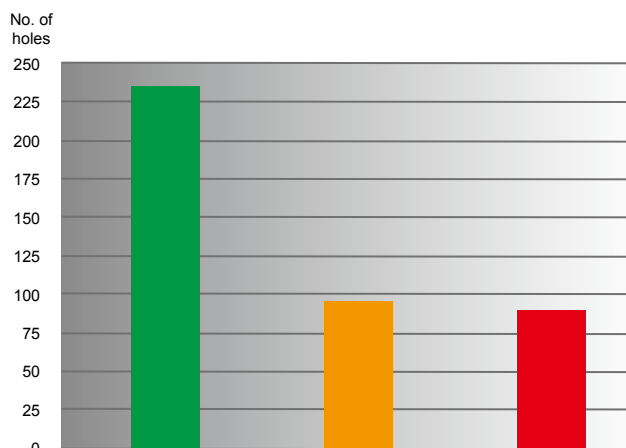


Test results

Test Condition

Tool: **TM83130600 Spiral flute**
 Size: **M6 x 1.0**
 Material: **SUS304 Stainless steel**
 v_c : **8 m/min**
 n : **425 rev/min**
 f_n : **1.0 mm/rev**
 Depth: **25.0 mm**
 Coolant: **Flood applied**
 Machine: **Vertical Machining Centre**
 Toolholder: **Tension and compression**

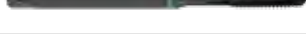
Result



Tool	TM83130600	COMPETITOR A	COMPETITOR B
No. of holes	230	98	92
Edge Condition	Wear	Broken	Broken

APPLICATION GUIDE

INDEX

P			M		K		N					S		H	SPIRAL POINT TAPS											
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●	●	●	○	○	●	●	○	○				○	○			TM8130	UV		Unimaster Blue Vap DIN371/376 M2 - M20	P.36						
●	●	●	○	○	●	●	●	●				○	○			TM8117	UV		Unimaster Gold TiN DIN371/376 M2 - M16	P.38						
●	●	●	●	●	●	●	●	●				○	○			TM8940	UV		Unimaster Bright Through Coolant DIN371/376 M6 - M20	P.40						
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●	●	●	○	○	●	●	○	○				○	○			TM8340	UV		Unimaster Bright DIN371/376 UNC #4 - 1"	P.44						
●	●	●	○	○	●	●	○	○				○	○			TM8740	UV		Unimaster Bright DIN371/374 UNF #4 - 1"	P.46						
○	○		●	●				○								TM8413	UV		Unimaster PM Vap DIN371/376 M2 - M16	P.48						
○	○		●	●				○								TM8913	UV		Unimaster PM Vap DIN374 MF4 - MF12	P.50						
																					SPIRAL FLUTE TAPS					
●	●	●	○	○	●	●	○	○				○	○			TM8030	UV		Unimaster Blue Vap DIN371/376 M2 - M20	P.37						
●	●	●	○	○	●	●	●	●				○	○			TM8017	UV		Unimaster Gold TiN DIN371/376 M2 - M16	P.39						
●	●	●	●	●	●	●	●	●				○	○			TM8840	UV		Unimaster Bright Through Coolant DIN371/376 M6 - M20	P.41						
●	●	●	○	○	●	●	○	○				○	○			TM8040	UV		Unimaster Bright DIN371/376 M2 - M30	P.43						
●	●	●	○	○	●	●	○	○				○	○			TM8240	UV		Unimaster Bright DIN371/376 UNC #4 - 1"	P.45						
●	●	●	○	○	●	●	○	○				○	○			TM8640	UV		Unimaster Bright DIN371/374 UNF #4 - 1"	P.47						
○	○		●	●				○								TM8313	UV		Unimaster PM Vap DIN371/376 M2 - M16	P.49						
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																						Cutting Data		P.125		

▶ For material group examples, refer to page 2

► For material group examples, refer to page 2
► For full material group tables, refer to pages 140 - 153

M METRIC COARSE THREADS



HSS-E

TCT
6H

THCHT
B

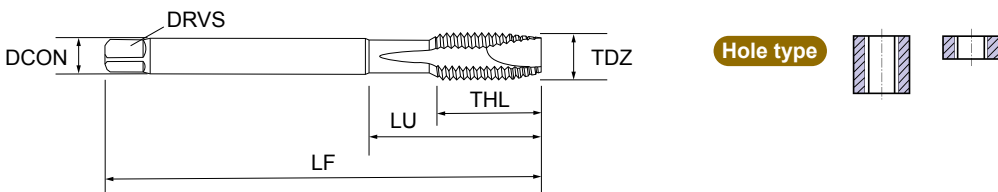
THFT
M60

VAP

Series No. TM8130

▶ cutting conditions : p.125

Spiral point.
Unimaster Blue.
Patented universal geometry.



EUROPA CODE ORDCODE	SIZE TDZ	PITCH TP	THREAD LENGTH THL	O/ALL LENGTH LF	NECK LENGTH LU	CZC _{MS}		NO. OF FLUTES NOF	STD. BSG	TAPPING DRILL PHD
						DCON	DRVS			
TM81300200	M2	0.4	8	45	13	2.8	2.1	3	DIN371	1.6
TM81300300	M3	0.5	11	56	18	3.5	2.7	3	DIN371	2.5
TM81300400	M4	0.7	13	63	21	4.5	3.4	3	DIN371	3.3
TM81300500	M5	0.8	15	70	25	6.0	4.9	3	DIN371	4.2
TM81300600	M6	1.0	17	80	30	6.0	4.9	3	DIN371	5.0
TM81300800	M8	1.25	20	90	35	8.0	6.2	3	DIN371	6.8
TM81301000	M10	1.5	22	100	39	10.0	8.0	3	DIN371	8.5
TM81301200	M12	1.75	24	110	44	9.0	7.0	3	DIN376	10.2
TM81301400	M14	2.0	26	110	44	11.0	9.0	3	DIN376	12.0
TM81301600	M16	2.0	27	110	44	12.0	9.0	3	DIN376	14.0
TM81302000	M20	2.5	32	140	54	16.0	12.0	4	DIN376	17.5

M METRIC COARSE THREADS



HSS-E

TCT
6H

THCHT
C

THFT
M60

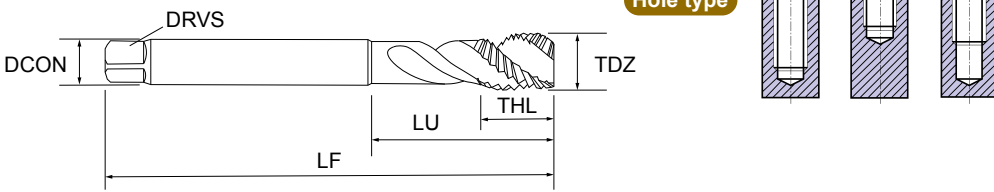
VAP

FHA 40°

Series No. TM8030

▶ cutting conditions : p.125

Spiral flute.
Unimaster Blue.
Patented universal geometry.



EUROPA CODE ORDCODE	SIZE TDZ	PITCH TP	THREAD LENGTH THL	O/ALL LENGTH LF	NECK LENGTH LU	CZC _{MS}		NO. OF FLUTES NOF	STD. BSG	TAPPING DRILL PHD
						DCON	DRVS			
TM80300200	M2	0.4	8	45	13	2.8	2.1	3	DIN371	1.6
TM80300300	M3	0.5	6	56	18	3.5	2.7	3	DIN371	2.5
TM80300400	M4	0.7	7	63	21	4.5	3.4	3	DIN371	3.3
TM80300500	M5	0.8	8	70	25	6.0	4.9	3	DIN371	4.2
TM80300600	M6	1.0	10	80	30	6.0	4.9	3	DIN371	5.0
TM80300800	M8	1.25	13	90	35	8.0	6.2	3	DIN371	6.8
TM80301000	M10	1.5	15	100	39	10.0	8.0	3	DIN371	8.5
TM80301200	M12	1.75	18	110	44	9.0	7.0	3	DIN376	10.2
TM80301400	M14	2.0	20	110	44	11.0	9.0	3	DIN376	12.0
TM80301600	M16	2.0	20	110	44	12.0	9.0	3	DIN376	14.0
TM80302000	M20	2.5	25	140	54	16.0	12.0	4	DIN376	17.5

ISO	P			M		K		N						S		H
VDI	1-5	6-9	10-11	12, 13	14	15-16	17-20	21-25	26-28	29.1	29.2	30	31-35	36-37	38-41	
EMG	11-12	13-14	15	21-22	23	31-32	33-34	71-74	61-64	81-82	83	84	51-53	41-43	16	
● Excellent	○ Good	●	●	●	○	○	●	●	○	○			○	○		

ISO	P			M		K		N						S		H
VDI	1-5	6-9	10-11	12, 13	14	15-16	17-20	21-25	26-28	29.1	29.2	30	31-35	36-37	38-41	
EMG	11-12	13-14	15	21-22	23	31-32	33-34	71-74	61-64	81-82	83	84	51-53	41-43	16	
● Excellent	○ Good	●	●	●	○	○	●	●	○	○			○	○		

M METRIC COARSE THREADS



HSS-E

TCT
6H

THCHT
B

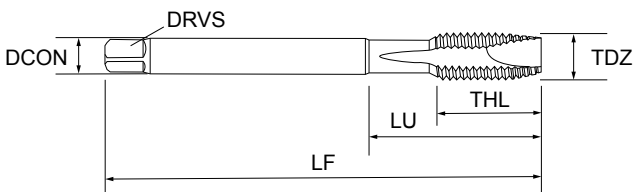
THFT
M60

TIN
COATED

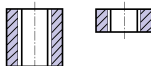
Series No. TM8117

▶ cutting conditions : p.125

Spiral point.
Unimaster Gold.
Patented universal geometry.



Hole type



EUROPA CODE ORDCODE	SIZE TDZ	PITCH TP	THREAD LENGTH THL	O/ALL LENGTH LF	NECK LENGTH LU	CZC _{MS}		NO. OF FLUTES NOF	STD. BSG	TAPPING DRILL PHD
						DCON	DRVS			
TM81170200	M2	0.4	8	45	13	2.8	2.1	3	DIN371	1.6
TM81170250	M2.5	0.45	9	50	15	2.8	2.1	3	DIN371	2.05
TM81170300	M3	0.5	11	56	18	3.5	2.7	3	DIN371	2.5
TM81170400	M4	0.7	13	63	21	4.5	3.4	3	DIN371	3.3
TM81170500	M5	0.8	15	70	25	6.0	4.9	3	DIN371	4.2
TM81170600	M6	1.0	17	80	30	6.0	4.9	3	DIN371	5.0
TM81170800	M8	1.25	20	90	35	8.0	6.2	3	DIN371	6.8
TM81171000	M10	1.5	22	100	39	10.0	8.0	3	DIN371	8.5
TM81171200	M12	1.75	24	110	44	9.0	7.0	3	DIN376	10.2
TM81171400	M14	2.0	26	110	44	11.0	9.0	3	DIN376	12.0
TM81171600	M16	2.0	27	110	44	12.0	9.0	3	DIN376	14.0

ISO	P			M		K		N						S	H
VDI	1-5	6-9	10-11	12, 13	14	15-16	17-20	21-25	26-28	29.1	29.2	30	31-35	36-37	38-41
EMG	11-12	13-14	15	21-22	23	31-32	33-34	71-74	61-64	81-82	83	84	51-53	41-43	16
● Excellent	○ Good	●	●	●	○	○	●	●	●	●			○	○	

M METRIC COARSE THREADS



HSS-E

TCT
6H

THCHT
C

THFT
M60

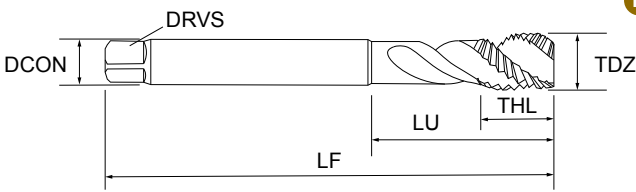
TIN
COATED

FHA 40°

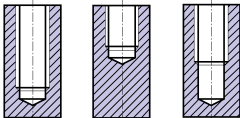
Series No. TM8017

▶ cutting conditions : p.125

Spiral flute.
Unimaster Gold.
Patented universal geometry.



Hole type



EUROPA CODE ORDCODE	SIZE TDZ	PITCH TP	THREAD LENGTH THL	O/ALL LENGTH LF	NECK LENGTH LU	CZC _{MS}		NO. OF FLUTES NOF	STD. BSG	TAPPING DRILL PHD
						DCON	DRVS			
TM80170200	M2	0.4	8	45	13	2.8	2.1	3	DIN371	1.6
TM80170250	M2.5	0.45	9	50	15	2.8	2.1	3	DIN371	2.05
TM80170300	M3	0.5	6	56	18	3.5	2.7	3	DIN371	2.5
TM80170400	M4	0.7	7	63	21	4.5	3.4	3	DIN371	3.3
TM80170500	M5	0.8	8	70	25	6.0	4.9	3	DIN371	4.2
TM80170600	M6	1.0	10	80	30	6.0	4.9	3	DIN371	5.0
TM80170800	M8	1.25	13	90	35	8.0	6.2	3	DIN371	6.8
TM80171000	M10	1.5	15	100	39	10.0	8.0	3	DIN371	8.5
TM80171200	M12	1.75	18	110	44	9.0	7.0	3	DIN376	10.2
TM80171400	M14	2.0	20	110	44	11.0	9.0	3	DIN376	12.0
TM80171600	M16	2.0	20	110	44	12.0	9.0	3	DIN376	14.0

ISO	P			M		K		N						S	H
VDI	1-5	6-9	10-11	12, 13	14	15-16	17-20	21-25	26-28	29.1	29.2	30	31-35	36-37	38-41
EMG	11-12	13-14	15	21-22	23	31-32	33-34	71-74	61-64	81-82	83	84	51-53	41-43	16
● Excellent	○ Good	●	●	●	○	○	●	●	●	●			○	○	

M METRIC COARSE THREADS



HSS-E

TCT
6H

CNSC 1

THCHT
B

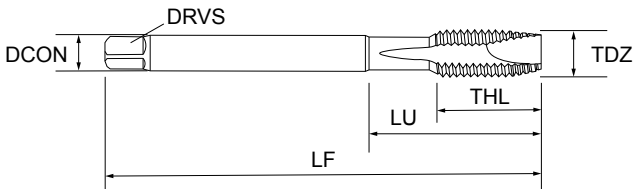
THFT
M60

BRIGHT
FINISH

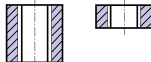
Series No. TM8940

▶ cutting conditions : p.125

Spiral point, through coolant
Unimaster Bright.
Patented universal geometry.



Hole type



EUROPA CODE ORDCODE	SIZE TDZ	PITCH TP	THREAD LENGTH THL	O/ALL LENGTH LF	NECK LENGTH LU	CZC _{MS}		NO. OF FLUTES NOF	STD. BSG	TAPPING DRILL PHD
						DCON	DRVS			
TM89400600	M6	1.0	17	80	30	6.0	4.9	3	DIN371	5.0
TM89400800	M8	1.25	20	90	35	8.0	6.2	3	DIN371	6.8
TM89401000	M10	1.5	22	100	39	10.0	8.0	3	DIN371	8.5
TM89401200	M12	1.75	24	110	44	9.0	7.0	3	DIN376	10.2
TM89401400	M14	2.0	26	110	44	11.0	9.0	3	DIN376	12.0
TM89401600	M16	2.0	27	110	44	12.0	9.0	3	DIN376	14.0
TM89401800	M18	2.5	30	125	50	14.0	11.0	4	DIN376	15.5
TM89402000	M20	2.5	32	140	54	16.0	12.0	4	DIN376	17.5

M METRIC COARSE THREADS



HSS-E

TCT
6H

CNSC 1

THCHT
C

THFT
M60

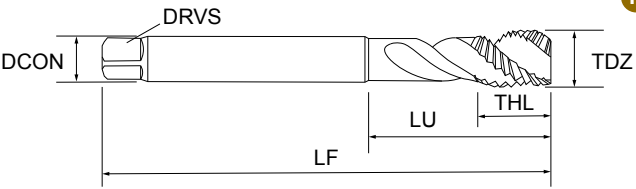
BRIGHT
FINISH

FHA 40°

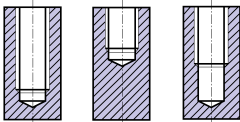
Series No. TM8840

▶ cutting conditions : p.125

Spiral flute, through coolant
Unimaster Bright.
Patented universal geometry.



Hole type

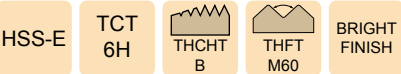


EUROPA CODE ORDCODE	SIZE TDZ	PITCH TP	THREAD LENGTH THL	O/ALL LENGTH LF	NECK LENGTH LU	CZC _{MS}		NO. OF FLUTES NOF	STD. BSG	TAPPING DRILL PHD
						DCON	DRVS			
TM88400600	M6	1.0	10	80	30	6.0	4.9	3	DIN371	5.0
TM88400800	M8	1.25	13	90	35	8.0	6.2	3	DIN371	6.8
TM88401000	M10	1.5	15	100	39	10.0	8.0	3	DIN371	8.5
TM88401200	M12	1.75	18	110	44	9.0	7.0	3	DIN376	10.2
TM88401400	M14	2.0	20	110	44	11.0	9.0	3	DIN376	12.0
TM88401600	M16	2.0	20	110	44	12.0	9.0	3	DIN376	14.0
TM88401800	M18	2.5	25	125	50	14.0	11.0	4	DIN376	15.5
TM88402000	M20	2.5	25	140	54	16.0	12.0	4	DIN376	17.5

ISO		P			M		K		N					S		H
VDI		1-5	6-9	10-11	12, 13	14	15-16	17-20	21-25	26-28	29.1	29.2	30	31-35	36-37	38-41
EMG		11-12	13-14	15	21-22	23	31-32	33-34	71-74	61-64	81-82	83	84	51-53	41-43	16
● Excellent	○ Good	●	●	●	●	●	●	●	●	●				○	○	

ISO		P			M		K		N					S		H
VDI		1-5	6-9	10-11	12, 13	14	15-16	17-20	21-25	26-28	29.1	29.2	30	31-35	36-37	38-41
EMG		11-12	13-14	15	21-22	23	31-32	33-34	71-74	61-64	81-82	83	84	51-53	41-43	16
● Excellent	○ Good	●	●	●	●	●	●	●	●	●				○	○	

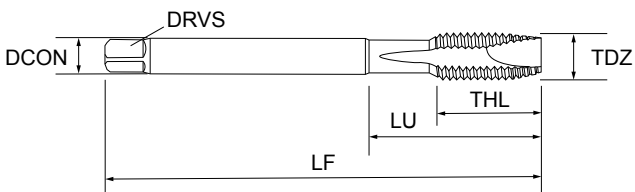
M METRIC COARSE THREADS



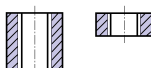
Series No. TM8140

▶ cutting conditions : p.125

Spiral point.
Unimaster Bright.
Patented universal geometry.



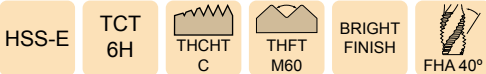
Hole type



EUROPA CODE ORDCODE	SIZE TDZ	PITCH TP	THREAD LENGTH THL	O/ALL LENGTH LF	NECK LENGTH LU	CZC _{MS}		NO. OF FLUTES NOF	STD. BSG	TAPPING DRILL PHD
						DCON	DRVS			
TM81400200	M2	0.4	8	45	13	2.8	2.1	3	DIN371	1.6
TM81400250	M2.5	0.45	9	50	15	2.8	2.1	3	DIN371	2.05
TM81400300	M3	0.5	11	56	18	3.5	2.7	3	DIN371	2.5
TM81400400	M4	0.7	13	63	21	4.5	3.4	3	DIN371	3.3
TM81400500	M5	0.8	15	70	25	6.0	4.9	3	DIN371	4.2
TM81400600	M6	1.0	17	80	30	6.0	4.9	3	DIN371	5.0
TM81400800	M8	1.25	20	90	35	8.0	6.2	3	DIN371	6.8
TM81401000	M10	1.5	22	100	39	10.0	8.0	3	DIN371	8.5
TM81401200	M12	1.75	24	110	44	9.0	7.0	3	DIN376	10.2
TM81401400	M14	2.0	26	110	44	11.0	9.0	3	DIN376	12.0
TM81401600	M16	2.0	27	110	44	12.0	9.0	3	DIN376	14.0
TM81402000	M20	2.5	32	140	54	16.0	12.0	4	DIN376	17.5
TM81402200	M22	2.5	32	140	54	18.0	14.5	4	DIN376	19.5
TM81402400	M24	3.0	34	160	60	18.0	14.5	4	DIN376	21.0
TM81402700	M27	3.0	36	160	60	20.0	16.0	4	DIN376	24.0
TM81403000	M30	3.5	40	160	70	22.0	18.0	4	DIN376	26.5

ISO	P			M		K		N						S	H
VDI	1-5	6-9	10-11	12, 13	14	15-16	17-20	21-25	26-28	29.1	29.2	30	31-35	36-37	38-41
EMG	11-12	13-14	15	21-22	23	31-32	33-34	71-74	61-64	81-82	83	84	51-53	41-43	16
● Excellent	○ Good	●	●	●	○	○	●	●	○	○			○	○	

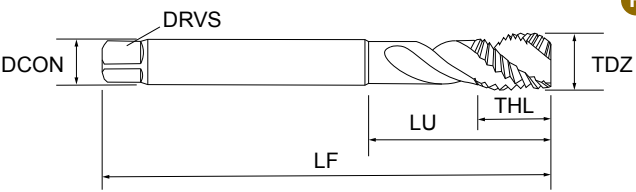
M METRIC COARSE THREADS



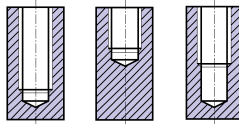
Series No. TM8040

▶ cutting conditions : p.125

Spiral flute.
Unimaster Bright.
Patented universal geometry.



Hole type



EUROPA CODE ORDCODE	SIZE TDZ	PITCH TP	THREAD LENGTH THL	O/ALL LENGTH LF	NECK LENGTH LU	CZC _{MS}		NO. OF FLUTES NOF	STD. BSG	TAPPING DRILL PHD
						DCON	DRVS			
TM80400200	M2	0.4	8	45	13	2.8	2.1	3	DIN371	1.6
TM80400250	M2.5	0.45	9	50	15	2.8	2.1	3	DIN371	2.05
TM80400300	M3	0.5	6	56	18	3.5	2.7	3	DIN371	2.5
TM80400400	M4	0.7	7	63	21	4.5	3.4	3	DIN371	3.3
TM80400500	M5	0.8	8	70	25	6.0	4.9	3	DIN371	4.2
TM80400600	M6	1.0	10	80	30	6.0	4.9	3	DIN371	5.0
TM80400800	M8	1.25	13	90	35	8.0	6.2	3	DIN371	6.8
TM80401000	M10	1.5	15	100	39	10.0	8.0	3	DIN371	8.5
TM80401200	M12	1.75	18	110	44	9.0	7.0	3	DIN376	10.2
TM80401400	M14	2.0	20	110	44	11.0	9.0	3	DIN376	12.0
TM80401600	M16	2.0	20	110	44	12.0	9.0	3	DIN376	14.0
TM80402000	M20	2.5	25	140	54	16.0	12.0	4	DIN376	17.5
TM80402200	M22	2.5	25	140	54	18.0	14.5	4	DIN376	19.5
TM80402400	M24	3.0	30	160	60	18.0	14.5	4	DIN376	21.0
TM80402700	M27	3.0	30	160	60	20.0	16.0	4	DIN376	24.0
TM80403000	M30	3.5	35	160	70	22.0	18.0	4	DIN376	26.5

ISO	P			M		K		N						S	H
VDI	1-5	6-9	10-11	12, 13	14	15-16	17-20	21-25	26-28	29.1	29.2	30	31-35	36-37	38-41
EMG	11-12	13-14	15	21-22	23	31-32	33-34	71-74	61-64	81-82	83	84	51-53	41-43	16
● Excellent	○ Good	●	●	●	○	○	●	●	○	○			○	○	



HSS-E

TCT
2B

THCHT
B

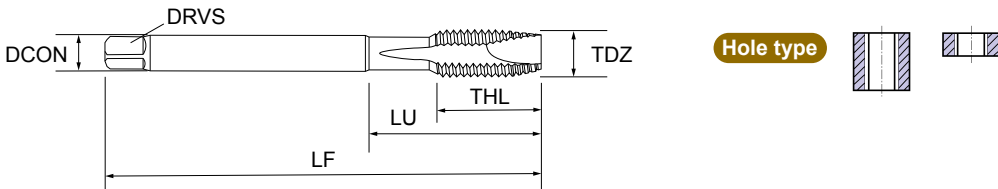
THFT
UN60

BRIGHT
FINISH

Series No. TM8340

▶ cutting conditions : p.125

Spiral point.
Unimaster Bright.
Patented universal geometry.



EUROPA CODE ORDCODE	SIZE TDZ	PITCH TP	THREAD LENGTH THL	O/ALL LENGTH LF	NECK LENGTH LU	CZC _{MS}		NO. OF FLUTES NOF	STD. BSG	TAPPING DRILL PHD
						DCON	DRVS			
TM83400400	#4	40	11	56	18	3.5	2.7	3	DIN371	2.3
TM83400600	#6	32	12	56	20	4.0	3.0	3	DIN371	2.85
TM83400800	#8	32	13	63	21	4.5	3.4	3	DIN371	3.5
TM83401000	#10	24	15	70	25	6.0	4.9	3	DIN371	3.9
TM83401200	#12	24	16	80	30	6.0	49	3	DIN371	4.5
TM83409160	1/4	20	17	80	30	7.0	5.5	3	DIN371	5.2
TM83409200	5/16	18	20	90	35	8.0	6.2	3	DIN371	6.6
TM83409240	3/8	16	22	100	39	9.0	7.0	3	DIN371	8.0
TM83409320	1/2	13	25	110	44	9.0	7.0	3	DIN376	10.75
TM83409400	5/8	11	27	110	44	12.0	9.0	3	DIN376	13.5
TM83409480	3/4	10	30	125	50	14.0	11.0	4	DIN376	16.5
TM83409640	1"	8	36	160	60	20.0	16.0	4	DIN376	22.25



HSS-E

TCT
2B

THCHT
C

THFT
UN60

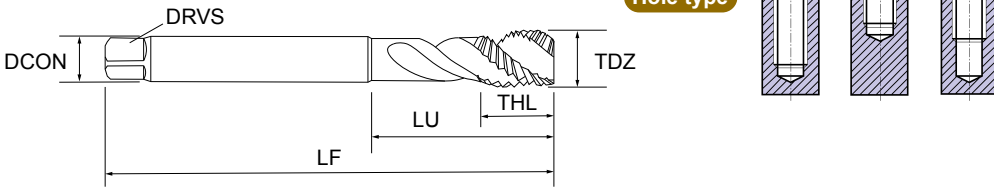
BRIGHT
FINISH

FHA 40°

Series No. TM8240

▶ cutting conditions : p.125

Spiral flute.
Unimaster Bright.
Patented universal geometry.



EUROPA CODE ORDCODE	SIZE TDZ	PITCH TP	THREAD LENGTH THL	O/ALL LENGTH LF	NECK LENGTH LU	CZC _{MS}		NO. OF FLUTES NOF	STD. BSG	TAPPING DRILL PHD
						DCON	DRVS			
TM82400400	#4	40	6	56	18	3.5	2.7	3	DIN371	2.3
TM82400600	#6	32	7	56	20	4.0	3.0	3	DIN371	2.85
TM82400800	#8	32	8	63	21	4.5	3.4	3	DIN371	3.5
TM82401000	#10	24	10	70	25	6.0	4.9	3	DIN371	3.9
TM82401200	#12	24	10	80	30	6.0	49	3	DIN371	4.5
TM82409160	1/4	20	13	80	30	7.0	5.5	3	DIN371	5.2
TM82409200	5/16	18	14	90	35	8.0	6.2	3	DIN371	6.6
TM82409240	3/8	16	16	100	39	9.0	7.0	3	DIN371	8.0
TM82409320	1/2	13	20	110	44	9.0	7.0	3	DIN376	10.75
TM82409400	5/8	11	22	110	44	12.0	9.0	3	DIN376	13.5
TM82409480	3/4	10	25	125	50	14.0	11.0	4	DIN376	16.5
TM82409640	1"	8	30	160	60	20.0	16.0	4	DIN376	22.25

ISO	P			M		K		N						S		H
VDI	1-5	6-9	10-11	12, 13	14	15-16	17-20	21-25	26-28	29.1	29.2	30	31-35	36-37	38-41	
EMG	11-12	13-14	15	21-22	23	31-32	33-34	71-74	61-64	81-82	83	84	51-53	41-43	16	
● Excellent	○ Good	●	●	●	○	○	●	●	○	○			○	○		

ISO	P			M		K		N						S		H
VDI	1-5	6-9	10-11	12, 13	14	15-16	17-20	21-25	26-28	29.1	29.2	30	31-35	36-37	38-41	
EMG	11-12	13-14	15	21-22	23	31-32	33-34	71-74	61-64	81-82	83	84	51-53	41-43	16	
● Excellent	○ Good	●	●	●	○	○	●	●	○	○			○	○		

UNF UNIFIED FINE THREADS



HSS-E

TCT 2B

THCHT B

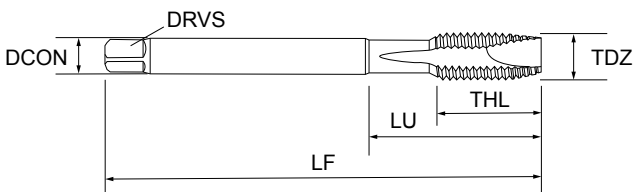
THFT UN60

BRIGHT FINISH

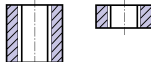
Series No. TM8740

▶ cutting conditions : p.125

Spiral point.
Unimaster Bright.
Patented universal geometry.



Hole type



EUROPA CODE ORDCODE	SIZE TDZ	PITCH TP	THREAD LENGTH THL	O/ALL LENGTH LF	NECK LENGTH LU	CZC _{MS}		NO. OF FLUTES NOF	STD. BSG	TAPPING DRILL PHD
						DCON	DRVS			
TM87400400	#4	48	11	56	18	3.5	2.7	3	DIN371	2.4
TM87400600	#6	40	12	56	20	4.0	3.0	3	DIN371	3.0
TM87400800	#8	36	13	63	21	4.5	3.4	3	DIN371	3.5
TM87401000	#10	32	15	70	25	6.0	4.9	3	DIN371	4.1
TM87409160	1/4	28	17	80	30	7.0	5.5	3	DIN371	5.5
TM87409200	5/16	24	20	90	35	8.0	6.2	3	DIN371	6.9
TM87409240	3/8	24	22	100	39	9.0	7.0	3	DIN371	8.5
TM87409320	1/2	20	25	110	44	9.0	7.0	3	DIN374	11.5
TM87409400	5/8	18	27	110	44	12.0	9.0	3	DIN374	14.5
TM87409480	3/4	16	30	125	50	14.0	11.0	4	DIN374	17.5
TM87409640	1"	12	36	160	60	20.0	16.0	4	DIN374	23.3

UNF UNIFIED FINE THREADS



HSS-E

TCT 2B

THCHT C

THFT UN60

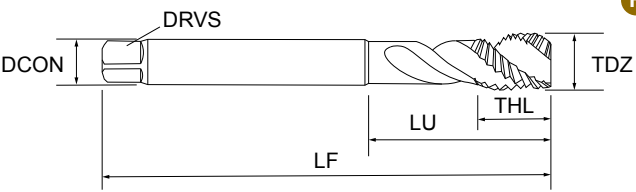
BRIGHT FINISH

FHA 40°

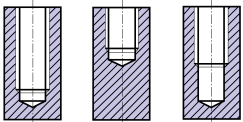
Series No. TM8640

▶ cutting conditions : p.125

Spiral flute.
Unimaster Bright.
Patented universal geometry.



Hole type



EUROPA CODE ORDCODE	SIZE TDZ	PITCH TP	THREAD LENGTH THL	O/ALL LENGTH LF	NECK LENGTH LU	CZC _{MS}		NO. OF FLUTES NOF	STD. BSG	TAPPING DRILL PHD
						DCON	DRVS			
TM86400400	#4	48	6	56	18	3.5	2.7	3	DIN371	2.4
TM86400600	#6	40	7	56	20	4.0	3.0	3	DIN371	3.0
TM86400800	#8	36	8	63	21	4.5	3.4	3	DIN371	3.5
TM86401000	#10	32	10	70	25	6.0	4.9	3	DIN371	4.1
TM86409160	1/4	28	13	80	30	7.0	5.5	3	DIN371	5.5
TM86409200	5/16	24	14	90	35	8.0	6.2	3	DIN371	6.9
TM86409240	3/8	24	16	100	39	9.0	7.0	3	DIN371	8.5
TM86409320	1/2	20	20	110	44	9.0	7.0	3	DIN374	11.5
TM86409400	5/8	18	22	110	44	12.0	9.0	3	DIN374	14.5
TM86409480	3/4	16	25	125	50	14.0	11.0	4	DIN374	17.5
TM86409640	1"	12	30	160	60	20.0	16.0	4	DIN374	23.3

ISO	P			M		K		N					S		H
VDI	1-5	6-9	10-11	12, 13	14	15-16	17-20	21-25	26-28	29.1	29.2	30	31-35	36-37	38-41
EMG	11-12	13-14	15	21-22	23	31-32	33-34	71-74	61-64	81-82	83	84	51-53	41-43	16
● Excellent	○ Good	●	●	●	○	○	●	●	○	○			○	○	

ISO	P			M		K		N					S		H
VDI	1-5	6-9	10-11	12, 13	14	15-16	17-20	21-25	26-28	29.1	29.2	30	31-35	36-37	38-41
EMG	11-12	13-14	15	21-22	23	31-32	33-34	71-74	61-64	81-82	83	84	51-53	41-43	16
● Excellent	○ Good	●	●	●	○	○	●	●	○	○			○	○	

M METRIC COARSE THREADS



HSS PM

HSS-E

TCT 6H

THCHT B

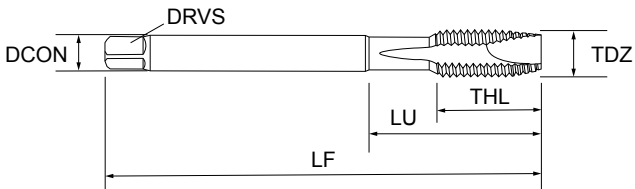
THFT M60

VAP

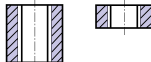
Series No. TM8413

▶ cutting conditions : p.125

Spiral point.
Unimaster PM.
HSS-PM up to M12, HSS-E above.
Patented universal geometry.



Hole type



DIN 371



DIN 376

EUROPA CODE ORDCODE	SIZE TDZ	PITCH TP	THREAD LENGTH THL	O/ALL LENGTH LF	NECK LENGTH LU	CZC _{MS}		NO. OF FLUTES NOF	STD. BSG	TAPPING DRILL PHD
						DCON	DRVS			
TM84130200	M2	0.4	8	45	13	2.8	2.1	3	DIN371	1.6
TM84130300	M3	0.5	11	56	18	3.5	2.7	3	DIN371	2.5
TM84130400	M4	0.7	13	63	21	4.5	3.4	3	DIN371	3.3
TM84130500	M5	0.8	15	70	25	6.0	4.9	3	DIN371	4.2
TM84130600	M6	1.0	17	80	30	6.0	4.9	3	DIN371	5.0
TM84130800	M8	1.25	20	90	35	8.0	6.2	3	DIN371	6.8
TM84131000	M10	1.5	22	100	39	10.0	8.0	3	DIN371	8.5
TM84131200	M12	1.75	24	110	44	9.0	7.0	3	DIN376	10.2
TM84131400	M14	2.0	26	110	44	11.0	9.0	3	DIN376	12.0
TM84131600	M16	2.0	27	110	44	12.0	9.0	3	DIN376	14.0

M METRIC COARSE THREADS



HSS PM

HSS-E

TCT 6H

THCHT C

THFT M60

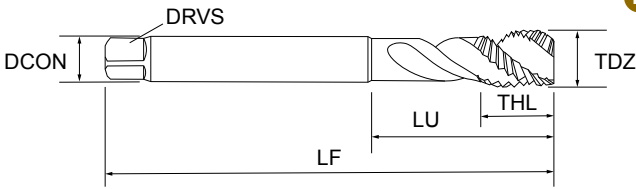
VAP

FHA 40°

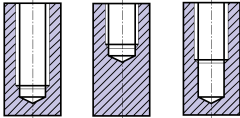
Series No. TM8313

▶ cutting conditions : p.125

Spiral flute.
Unimaster PM.
HSS-PM up to M12, HSS-E above.
Patented universal geometry.



Hole type



DIN 371



DIN 376

EUROPA CODE ORDCODE	SIZE TDZ	PITCH TP	THREAD LENGTH THL	O/ALL LENGTH LF	NECK LENGTH LU	CZC _{MS}		NO. OF FLUTES NOF	STD. BSG	TAPPING DRILL PHD
						DCON	DRVS			
TM83130200	M2	0.4	8	45	13	2.8	2.1	3	DIN371	1.6
TM83130300	M3	0.5	6	56	18	3.5	2.7	3	DIN371	2.5
TM83130400	M4	0.7	7	63	21	4.5	3.4	3	DIN371	3.3
TM83130500	M5	0.8	8	70	25	6.0	4.9	3	DIN371	4.2
TM83130600	M6	1.0	10	80	30	6.0	4.9	3	DIN371	5.0
TM83130800	M8	1.25	13	90	35	8.0	6.2	3	DIN371	6.8
TM83131000	M10	1.5	15	100	39	10.0	8.0	3	DIN371	8.5
TM83131200	M12	1.75	18	110	44	9.0	7.0	3	DIN376	10.2
TM83131400	M14	2.0	20	110	44	11.0	9.0	3	DIN376	12.0
TM83131600	M16	2.0	20	110	44	12.0	9.0	3	DIN376	14.0

ISO	P			M		K		N						S	H
VDI	1-5	6-9	10-11	12, 13	14	15-16	17-20	21-25	26-28	29.1	29.2	30	31-35	36-37	38-41
EMG	11-12	13-14	15	21-22	23	31-32	33-34	71-74	61-64	81-82	83	84	51-53	41-43	16
● Excellent	○ Good	○	○	●	●				○						

ISO	P			M		K		N						S	H
VDI	1-5	6-9	10-11	12, 13	14	15-16	17-20	21-25	26-28	29.1	29.2	30	31-35	36-37	38-41
EMG	11-12	13-14	15	21-22	23	31-32	33-34	71-74	61-64	81-82	83	84	51-53	41-43	16
● Excellent	○ Good	○	○	●	●				○						

MF METRIC FINE THREADS



HSS PM

TCT 6H

THCHT B

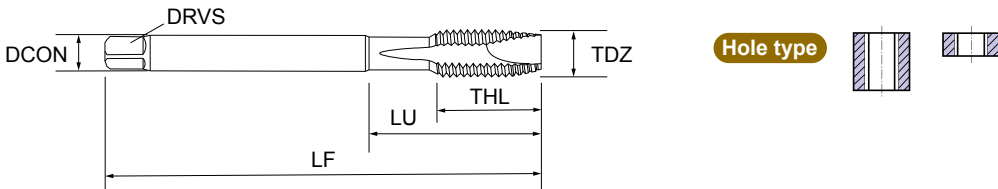
THFT M60

VAP

Series No. TM8913

▶ cutting conditions : p.125

Spiral point.
Unimaster PM.
Patented universal geometry.



EUROPA CODE ORDCODE	SIZE TDZ	PITCH TP	THREAD LENGTH THL	O/ALL LENGTH LF	NECK LENGTH LU	CZC _{MS}		NO. OF FLUTES NOF	STD. BSG	TAPPING DRILL PHD
						DCON	DRVS			
TM89130400	M4	0.5	10	63	21	2.8	2.1	3	DIN374	3.5
TM89130500	M5	0.5	11	70	25	3.5	2.7	3	DIN374	4.5
TM89130600	M6	0.5	13	80	30	4.5	3.4	3	DIN374	5.5
TM89130601	M6	0.75	13	80	30	4.5	3.4	3	DIN374	5.2
TM89130800	M8	0.75	14	80	30	6.0	4.9	3	DIN374	7.2
TM89130801	M8	1.0	17	90	36	6.0	4.9	3	DIN374	7.0
TM89131000	M10	0.75	18	90	36	7.0	5.5	3	DIN374	9.2
TM89131001	M10	1.0	18	90	36	7.0	5.5	3	DIN374	9.0
TM89131002	M10	1.25	22	100	40	7.0	5.5	3	DIN374	8.8
TM89131200	M12	1.0	18	100	40	9.0	7.0	3	DIN374	11.0
TM89131201	M12	1.25	22	100	40	9.0	7.0	3	DIN374	10.8
TM89131202	M12	1.5	22	100	40	9.0	7.0	3	DIN374	10.5

ISO	P			M		K		N						S	H
VDI	1-5	6-9	10-11	12, 13	14	15-16	17-20	21-25	26-28	29.1	29.2	30	31-35	36-37	38-41
EMG	11-12	13-14	15	21-22	23	31-32	33-34	71-74	61-64	81-82	83	84	51-53	41-43	16
● Excellent	○ Good	○	○	●	●				○						

MF METRIC FINE THREADS



HSS PM

TCT 6H

THCHT C

THFT M60

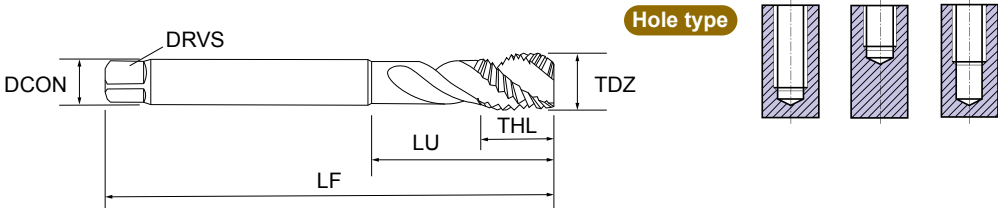
VAP

FHA 40°

Series No. TM8813

▶ cutting conditions : p.125

Spiral flute.
Unimaster PM.
Patented universal geometry.



EUROPA CODE ORDCODE	SIZE TDZ	PITCH TP	THREAD LENGTH THL	O/ALL LENGTH LF	NECK LENGTH LU	CZC _{MS}		NO. OF FLUTES NOF	STD. BSG	TAPPING DRILL PHD
						DCON	DRVS			
TM88130400	M4	0.5	5	63	21	2.8	2.1	3	DIN374	3.5
TM88130500	M5	0.5	5	70	25	3.5	2.7	3	DIN374	4.5
TM88130600	M6	0.5	5	80	30	4.5	3.4	3	DIN374	5.5
TM88130601	M6	0.75	8	80	30	4.5	3.4	3	DIN374	5.2
TM88130800	M8	0.75	8	80	30	6.0	4.9	3	DIN374	7.2
TM88130801	M8	1.0	10	90	36	6.0	4.9	3	DIN374	7.0
TM88131000	M10	0.75	10	90	36	7.0	5.5	3	DIN374	9.2
TM88131001	M10	1.0	10	90	36	7.0	5.5	3	DIN374	9.0
TM88131002	M10	1.25	16	100	40	7.0	5.5	3	DIN374	8.8
TM88131200	M12	1.0	11	100	40	9.0	7.0	3	DIN374	11.0
TM88131201	M12	1.25	15	100	40	9.0	7.0	3	DIN374	10.8
TM88131202	M12	1.5	15	100	40	9.0	7.0	3	DIN374	10.5

ISO	P			M		K		N						S	H
VDI	1-5	6-9	10-11	12, 13	14	15-16	17-20	21-25	26-28	29.1	29.2	30	31-35	36-37	38-41
EMG	11-12	13-14	15	21-22	23	31-32	33-34	71-74	61-64	81-82	83	84	51-53	41-43	16
● Excellent	○ Good	○	○	●	●				○						

Series No. UNI...SF/SP

Universal tap and drill sets

Metric coarse.

Unigold sets include Goldex HSS drills to suit tapping sizes.

Uniblue sets are taps only.



EUROPA CODE ORDCODE	SIZE RANGE	TAPPING DRILLS	TAP TYPE	TAP STYLE
UNIBLUESF1	M3, M4, M5, M6, M8, M10, M12	TAPS ONLY	UNIMASTER BLUE	SP/FLUTE
UNIBLUESP1	M3, M4, M5, M6, M8, M10, M12	TAPS ONLY	UNIMASTER BLUE	SP/POINT
UNIGOLDSF1	M3, M4, M5, M6, M8, M10, M12	2.5, 3.3, 4.2, 5.0, 6.8, 8.5, 10.2	UNIMASTER BRIGHT	SP/FLUTE
UNIGOLDSP1	M3, M4, M5, M6, M8, M10, M12	2.5, 3.3, 4.2, 5.0, 6.8, 8.5, 10.2	UNIMASTER BRIGHT	SP/POINT
UNIGOLDSF2	M3, M4, M5, M6, M8, M10, M12	2.5, 3.3, 4.2, 5.0, 6.8, 8.5, 10.2	UNIMASTER BLUE	SP/FLUTE
UNIGOLDSP2	M3, M4, M5, M6, M8, M10, M12	2.5, 3.3, 4.2, 5.0, 6.8, 8.5, 10.2	UNIMASTER BLUE	SP/POINT