

Roll Form Taps



Compared to tapping, no chips are produced when doing roll form tapping.

Materials with an elongation of $>5\%$ and a tensile strength of $<1000\text{N/m}^2$ are suitable for thread forming.

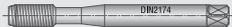
Formed threads have a smoother surface and are stronger under dynamic stress than those that are cut.

Solid carbide roll form taps achieve a tool life up to 20 times longer than those in HSS-E.



Patented thread forming tools in HSS-E with brazed carbide strips are particularly suited to use on transfer lines. The flexible tool body compensates for small alignment errors while the carbide produces maximum durability in the working area.

Restrictions: thin-walled components with a wall thickness $<2 \times$ pitch are not suitable for thread forming.

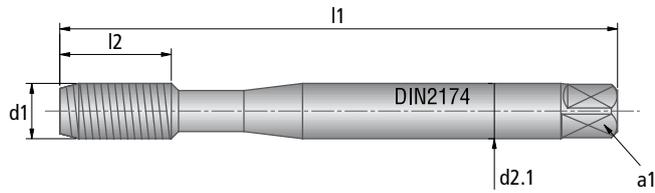
M	HSS-E Roll Form Taps	MOREX TiN, MOREX IK TiN, MOREX N TiN, MOREX N IKS TiN		116
MF	HSS-E Roll Form Taps	MOREX TiN, MOREX IK TiN MOREX N TiN, MOREX N IKS TiN		117
M	Solid Carbide Roll Form Taps	MOREX IK, MOREX IK TiN, MOREX N IK, MOREX N IK TiN		118
M	Solid Carbide Roll Form Taps	MOREX N IKS, MOREX N IKS TiN		119
M	HSS-E Roll Form Taps with carbide strips	MOREX HML IK, MOREX HML IK TiN MOREX N HML IK, MOREX N HML IKS TiN		120
MF	HSS-E Roll Form Taps with carbide strips	MOREX HML IK		121



M HSS-E Roll Form Taps

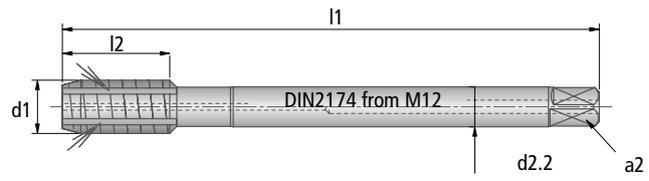
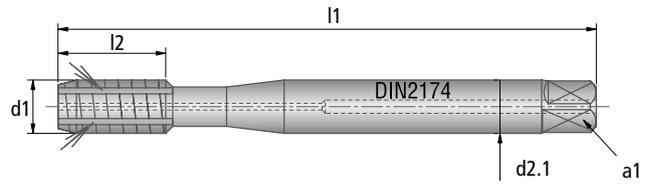
MOREX TiN, MOREX N TiN

For metric ISO thread DIN 13
Cutting material: HSS-E



MOREX IK TiN, MOREX N IKS TiN

For metric ISO thread DIN 13
Cutting material: HSS-E



Type		MOREX TiN		MOREX IK TiN		MOREX N TiN		MOREX N IKS TiN			
Tolerance field		ISO 2X		ISO 2X		ISO 2X		ISO 2X			
Dimensions (DIN)		2174		2174		2174		2174			
Material		HSS-E		HSS-E		HSS-E		HSS-E			
Chamfer form		C		C		C		C			
Version		TiN		TiN		TiN		TiN			
Nom. Ø d1	P	l1	l2	d2.1	a1	d2.2	a2				
								Order No.	Order No.	Order No.	Order No.
M 1	0,25	40	5,5	2,5	2,1						
M 1,1	0,25	40	5,5	2,5	2,1						
M 1,2	0,25	40	5,5	2,5	2,1						
M 1,4	0,30	40	7,0	2,5	2,1						
M 1,6	0,35	40	8,0	2,5	2,1						
M 1,7	0,35	40	8,0	2,5	2,1						
M 1,8	0,35	40	8,0	2,5	2,1						
M 2	0,40	45	8,0	2,8	2,1			20374001000008			
M 2,2	0,45	45	9,0	2,8	2,1						
M 2,3	0,40	45	9,0	2,8	2,1						
M 2,5	0,45	50	9,0	2,8	2,1			20374001000011			
M 2,6	0,45	50	9,0	2,8	2,1						
M 3	0,50	56	11,0	3,5	2,7			20374001000013		20376001000013	
M 3,5	0,60	56	13,0	4,0	3,0						
M 4	0,70	63	13,0	4,5	3,4			20374001000015		20376001000015	
M 4,5	0,75	70	15,0	6,0	4,9						
M 5	0,80	70	16,0	6,0	4,9			20374001000017		20376001000017	
M 6	1,00	80	18,0	6,0	4,9			20374001000018	20574001000018	20376001000018	20598001000018
M 7	1,00	80	18,0	7,0	5,5						
M 8	1,25	90	18,0	8,0	6,2			20374001000020	20574001000020	20376001000020	20598001000020
M 9	1,25	90	18,0	9,0	7,0						
M10	1,50	100	21,0	10,0	8,0			20374001000022	20574001000022	20376001000022	20598001000022
M11	1,50	100	21,0			8,0	6,2				
M12	1,75	110	24,0			9,0	7,0	20375001000024	20575001000024	20377001000024	20599001000024
M14	2,00	110	24,0			11,0	9,0	20375001000025	20575001000025	20377001000025	
M16	2,00	110	27,0			12,0	9,0		20575001000026		
M18	2,50	125	32,0			14,0	11,0				
M20	2,50	140	32,0			16,0	12,0				

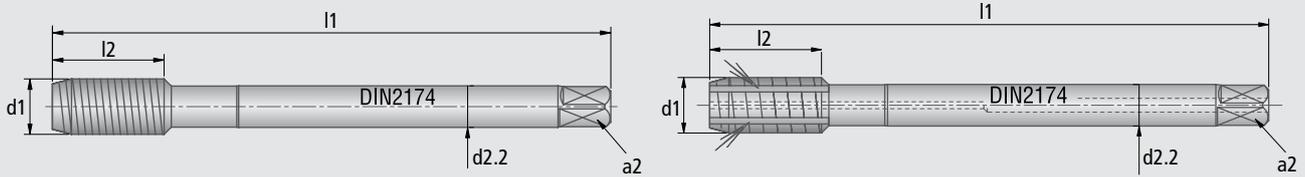
MF HSS-E Roll Form Taps



MOREX TiN, MOREX IK TiN, MOREX N TiN, MOREX N IKS TiN

For metric ISO fine pitch thread DIN 13

Cutting material: HSS-E



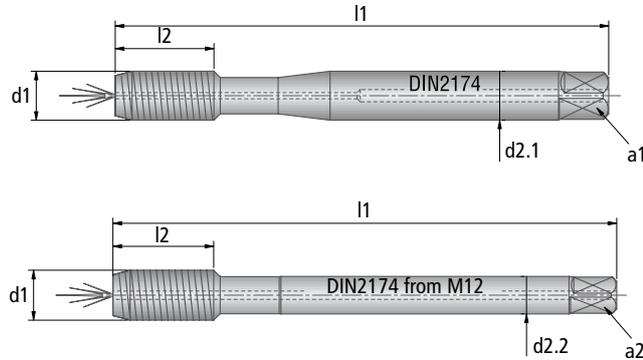
Type					MOREX TiN	MOREX IK TiN	MOREX N TiN	MOREX N IKS TiN
Tolerance field					ISO 2X	ISO 2X	ISO 2X	ISO 2X
Dimensions (DIN)					2174	2174	2174	2174
Material					HSS-E	HSS-E	HSS-E	HSS-E
Chamfer form					C	C	C	C
Version					TiN	TiN	TiN	TiN
								
Nom. Ø x P d1	l1	l2	d2.2	a2	Order No.	Order No.	Order No.	Order No.
M 3,5x0,35	56	10,0	2,5	2,1				
M 4x0,35	63	10,0	2,8	2,1				
M 4x0,5	63	10,0	2,8	2,1				
M 5x0,5	70	12,0	3,5	2,7				
M 6x0,5	80	14,0	4,5	3,4				
M 6x0,75	80	14,0	4,5	3,4				
M 7x0,75	80	14,0	5,5	4,3				
M 8x0,5	80	14,0	6,0	4,9				
M 8x0,75	80	14,0	6,0	4,9				
M 8x1	90	18,0	6,0	4,9				
M 9x1	90	18,0	7,0	5,5				
M10x0,75	90	14,0	7,0	5,5				
M10x1	90	18,0	7,0	5,5	20375002000094	20575002000094	20377002000094	20599002000094
M10x1,25	100	21,0	7,0	5,5				
M11x1	90	18,0	8,0	6,2				
M12x1	100	20,0	9,0	7,0				
M12x1,25	100	20,0	9,0	7,0				
M12x1,5	100	20,0	9,0	7,0	20375002000113	20575002000113	20377002000113	20599002000113
M14x1	100	20,0	11,0	9,0				
M14x1,25	100	20,0	11,0	9,0				
M14x1,5	100	20,0	11,0	9,0	20375002000131	20575002000131	20377002000131	20599002000131
M15x1	100	20,0	12,0	9,0				
M15x1,5	100	20,0	12,0	9,0				
M16x1	100	20,0	12,0	9,0				
M16x1,5	100	20,0	12,0	9,0	20375002000147	20575002000147	20377002000147	20599002000147
M18x1	110	24,0	14,0	11,0				
M18x1,5	110	24,0	14,0	11,0				
M18x2	125	24,0	14,0	11,0				
M20x1	125	24,0	16,0	12,0				
M20x1,5	125	24,0	16,0	12,0				
M20x2	140	24,0	16,0	12,0				

M Solid Carbide Roll Form Taps

MOREX IK, MOREX IK TiN

For metric ISO thread DIN 13

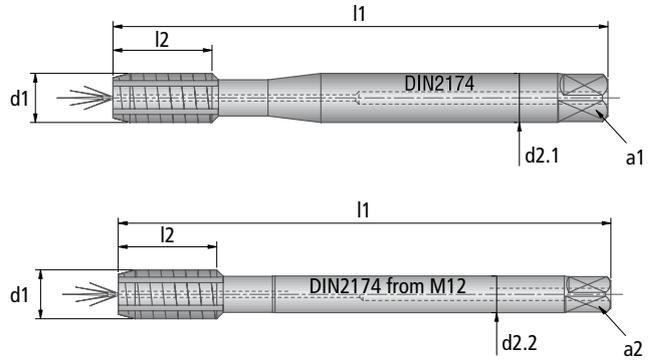
Tools with internal coolant
Cutting material: solid carbide

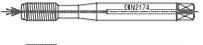


MOREX N IK, MOREX N IK TiN

For metric ISO thread DIN 13

Tools with internal coolant
Cutting material: solid carbide



Type								MOREX IK	MOREX IK TiN	MOREX N IK	MOREX N IK TiN
Tolerance field								ISO 2X	ISO 2X	ISO 2X	ISO 2X
Dimensions (DIN)								2174	2174	2174	2174
Material								solid carbide	solid carbide	solid carbide	solid carbide
Chamfer form								C	C	C	C
Version								uncoated	TiN	uncoated	TiN
Nom. Ø d1	P	l1	l2	d2.1	a1	d2.2	a2				
								Order No.	Order No.	Order No.	Order No.
M 1	0,25	40	5,5	2,5	2,1						
M 1,1	0,25	40	5,5	2,5	2,1						
M 1,2	0,25	40	5,5	2,5	2,1						
M 1,4	0,30	40	7,0	2,5	2,1						
M 1,6	0,35	40	8,0	2,5	2,1						
M 1,7	0,35	40	8,0	2,5	2,1						
M 1,8	0,35	40	8,0	2,5	2,1						
M 2	0,40	45	8,0	2,8	2,1						
M 2,2	0,45	45	9,0	2,8	2,1						
M 2,3	0,40	45	9,0	2,8	2,1						
M 2,5	0,45	50	9,0	2,8	2,1						
M 2,6	0,45	50	9,0	2,8	2,1						
M 3	0,50	56	11,0	3,5	2,7						
M 3,5	0,60	56	13,0	4,0	3,0						
M 4	0,70	63	13,0	4,5	3,4		80474001000015	80574001000015	80476001000015	80576001000015	
M 4,5	0,75	70	15,0	6,0	4,9						
M 5	0,80	70	16,0	6,0	4,9		80474001000017	80574001000017	80476001000017	80576001000017	
M 6	1,00	80	18,0	6,0	4,9		80474001000018	80574001000018	80476001000018	80576001000018	
M 7	1,00	80	18,0	7,0	5,5						
M 8	1,25	90	18,0	8,0	6,2		80474001000020	80574001000020	80476001000020	80576001000020	
M 9	1,25	90	18,0	9,0	7,0						
M10	1,50	100	21,0	10,0	8,0		80474001000022	80574001000022	80476001000022	80576001000022	
M11	1,50	100	21,0			8,0	6,2				
M12	1,75	110	24,0			9,0	7,0	80475001000024	80575001000024	80477001000024	80577001000024
M14	2,00	110	24,0			11,0	9,0				
M16	2,00	110	27,0			12,0	9,0				
M18	2,50	125	32,0			14,0	11,0				
M20	2,50	140	32,0			16,0	12,0				

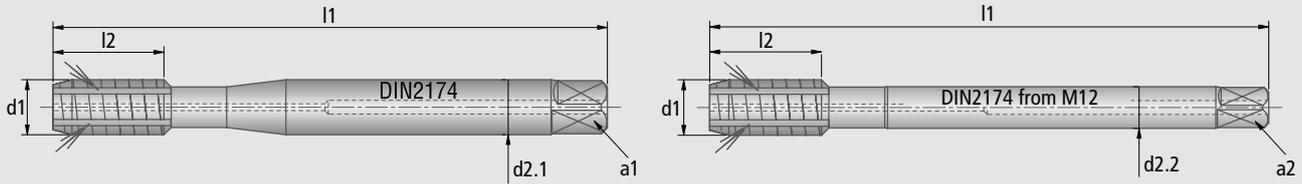
M Solid Carbide Roll Form Taps

MOREX N IKS

For metric ISO thread DIN 13

Tools with lateral flute coolant supply

Cutting material: solid carbide

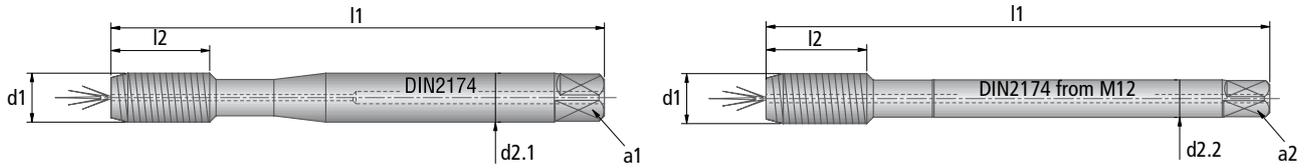


Type								MOREX N IKS	MOREX N IKS TiN
Tolerance field								ISO 2X	ISO 2X
Dimensions (DIN)								2174	2174
Material								solid carbide	solid carbide
Chamfer form								C	C
Version								uncoated	TiN
Nom. Ø d1	P	l1	l2	d2.1	a1	d2.2	a2		
								Order No.	Order No.
M 1	0,25	40	5,5	2,5	2,1				
M 1,1	0,25	40	5,5	2,5	2,1				
M 1,2	0,25	40	5,5	2,5	2,1				
M 1,4	0,30	40	7,0	2,5	2,1				
M 1,6	0,35	40	8,0	2,5	2,1				
M 1,7	0,35	40	8,0	2,5	2,1				
M 1,8	0,35	40	8,0	2,5	2,1				
M 2	0,40	45	8,0	2,8	2,1				
M 2,2	0,45	45	9,0	2,8	2,1				
M 2,3	0,40	45	9,0	2,8	2,1				
M 2,5	0,45	50	9,0	2,8	2,1				
M 2,6	0,45	50	9,0	2,8	2,1				
M 3	0,50	56	11,0	3,5	2,7				
M 3,5	0,60	56	13,0	4,0	3,0				
M 4	0,70	63	13,0	4,5	3,4			80494001000015	80594001000015
M 4,5	0,75	70	15,0	6,0	4,9				
M 5	0,80	70	16,0	6,0	4,9			80494001000017	80594001000017
M 6	1,00	80	18,0	6,0	4,9			80494001000018	80594001000018
M 7	1,00	80	18,0	7,0	5,5				
M 8	1,25	90	18,0	8,0	6,2			80494001000020	80594001000020
M 9	1,25	90	18,0	9,0	7,0				
M10	1,50	100	21,0	10,0	8,0			80494001000022	80594001000022
M11	1,50	100	21,0			8,0	6,2		
M12	1,75	110	24,0			9,0	7,0	80495001000024	80595001000024
M14	2,00	110	24,0			11,0	9,0		
M16	2,00	110	27,0			12,0	9,0		
M18	2,50	125	32,0			14,0	11,0		
M20	2,50	140	32,0			16,0	12,0		

M HSS-E Roll Form Taps with carbide strips

MOREX HML IK, MOREX HML IK TiN

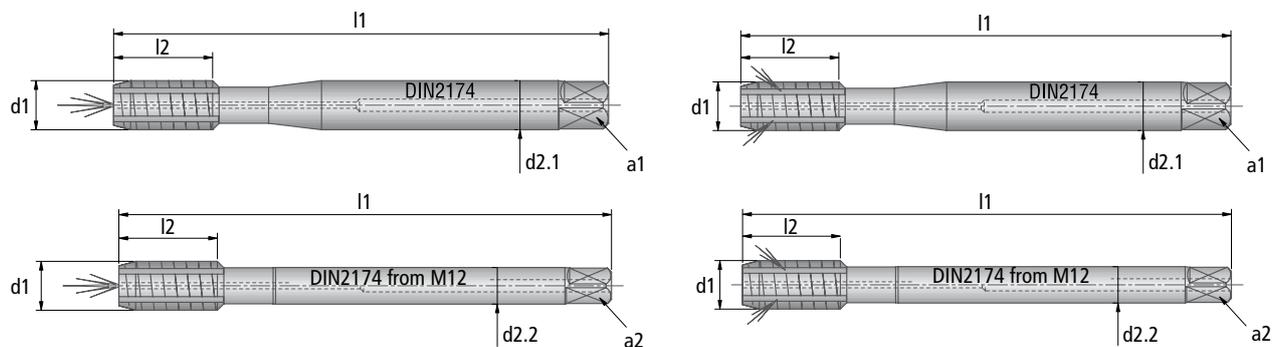
For metric ISO thread DIN 13
HSS-E with carbide strips
From nominal Ø M6 with internal coolant supply



Type		MOREX HML IK							MOREX HML IK TiN	
Tolerance field		ISO 2X							ISO 2X	
Dimensions (DIN)		2174							2174	
Material		Carbide tipped							Carbide tipped	
Chamfer form		C							C	
Version		uncoated							TiN	
M 5	0,80	70	16	6	5					
M 6	1,00	80	18	6	5			90174001000018	90374001000018	
M 8	1,25	90	18	8	6			90174001000020	90374001000020	
M10	1,50	100	21	10	8			90174001000022	90374001000022	
M12	1,75	110	24			9	7	90175001000024	90375001000024	
M14	2,00	110	24			11	9			
M16	2,00	110	27			12	9			

MOREX N HML IK, MOREX N HML IKS TiN

From nominal Ø M6 with lateral flute coolant supply



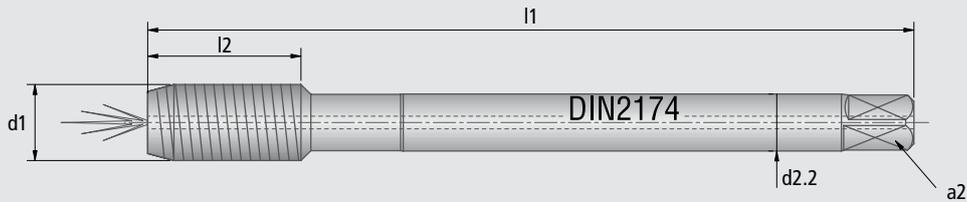
Type		MOREX N HML IK							MOREX N HML IKS TiN	
Tolerance field		ISO 2X							ISO 2X	
Dimensions (DIN)		2174							2174	
Material		Carbide tipped							Carbide tipped	
Chamfer form		C							C	
Version		uncoated							TiN	
M 6	1,00	80	18	6	5			90176001000018	90496001000018	
M 8	1,25	90	18	8	6			90176001000020	90496001000020	
M10	1,50	100	21	10	8			90176001000022	90496001000022	
M12	1,75	110	24			9	7	90177001000024	90497001000024	

MF HSS-E Roll Form Taps with carbide strips



MOREX HML IK

For metric ISO fine pitch thread DIN 13
HSS-E with carbide strips
From nominal Ø M6x0.75 with internal coolant supply



Type		MOREX HML IK					
Tolerance field		ISO 2X					
Dimensions (DIN)		2174					
Material		Carbide tipped					
Chamfer form		C					
Version		uncoated					
							
Nom. Ø x P d1	l1	l2	d2.1	a1	d2.2	a2	Order No.
M 6x0,75	80	14	6	5			
M 8x0,75	80	14	8	6			
M 8x1	90	18	8	6			
M10x1	90	18			7	6	90175002000094
M12x1	100	20			9	7	
M12x1,5	100	20			9	7	90175002000113
M14x1	100	20			11	9	
M14x1,5	100	20			11	9	
M16x1	100	20			12	9	
M16x1,5	100	20			12	9	
M18x1	110	24			14	11	
M18x1,5	110	24			14	11	
M20x1	125	24			16	12	
M20x1,5	125	24			16	12	