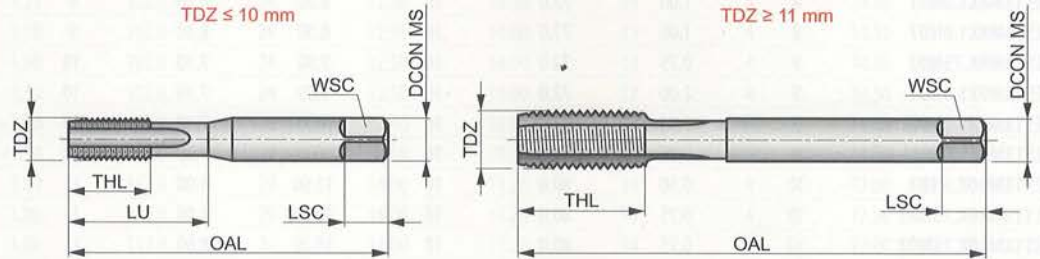


# E513



## HSS Straight Flute Hand Tap, Metric Fine, ISO Standard

A versatile tool, suitable for hand and machine tapping, with a straight flute design for both through and blind holes. Available with taper lead NO1 for short through holes, plug lead NO2 for deeper through holes or bottoming lead NO3 for blind holes. Also, as a set NO7 with a plug lead and bottoming lead tap.



	ISO 529	6H
	1.5xD	HSS
	R	Bright

Workpiece material group suitability and starting values for cutting speed (m/min).

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P4.1	K1.1	K1.2	K1.3	K2.1	K2.2
■ 7	■ 7	■ 8	■ 6	■ 5	■ 4	■ 4	■ 4	■ 3	■ 12	■ 9	■ 7	■ 12	■ 10
K3.1	K3.2	K4.1	K4.2	K5.1	K5.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	N4.2
■ 11	■ 8	■ 10	■ 8	■ 11	■ 9	■ 8	■ 11	■ 10	■ 17	■ 17	■ 10	■ 15	■ 15
N4.3													
■ 3													

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
E513M3X.35N01	3	0.35	48.0	12.5	3.15	2.50	5	3	2.65	12.50
E513M3X.35N02	3	0.35	48.0	12.5	3.15	2.50	5	3	2.65	12.50
E513M3X.35N03	3	0.35	48.0	12.5	3.15	2.50	5	3	2.65	12.50
E513M3.5X.35N03	3.5	0.35	48.0	12.5	3.15	2.50	5	3	3.20	12.50
E513M4X.5N01	4	0.50	53.0	14	4.00	3.15	6	3	3.50	14.00
E513M4X.5N02	4	0.50	53.0	14	4.00	3.15	6	3	3.50	14.00
E513M4X.5N03	4	0.50	53.0	14	4.00	3.15	6	3	3.50	14.00
E513M4X.5N07	4	0.50	53.0	14	4.00	3.15	6	3	3.50	14.00
E513M5X.5N01	5	0.50	58.0	11	5.00	4.00	7	3	4.50	22.00
E513M5X.5N02	5	0.50	58.0	11	5.00	4.00	7	3	4.50	22.00
E513M5X.5N03	5	0.50	58.0	11	5.00	4.00	7	3	4.50	22.00
E513M5X.5N07	5	0.50	58.0	11	5.00	4.00	7	3	4.50	22.00
E513M5X.75N01	5	0.75	58.0	11	5.00	4.00	7	3	4.30	22.00
E513M5X.75N02	5	0.75	58.0	11	5.00	4.00	7	3	4.30	22.00
E513M5X.75N03	5	0.75	58.0	11	5.00	4.00	7	3	4.30	22.00
E513M6X.5N01	6	0.50	66.0	13	6.30	5.00	8	3	5.50	26.00
E513M6X.5N02	6	0.50	66.0	13	6.30	5.00	8	3	5.50	26.00
E513M6X.5N03	6	0.50	66.0	13	6.30	5.00	8	3	5.50	26.00
E513M6X.75N01	6	0.75	66.0	13	6.30	5.00	8	3	5.30	26.00
E513M6X.75N02	6	0.75	66.0	13	6.30	5.00	8	3	5.30	26.00
E513M6X.75N03	6	0.75	66.0	13	6.30	5.00	8	3	5.30	26.00
E513M6X.75N07	6	0.75	66.0	13	6.30	5.00	8	3	5.30	26.00
E513M7X.75N01	7	0.75	66.0	13	7.10	5.60	8	3	6.30	26.00
E513M7X.75N02	7	0.75	66.0	13	7.10	5.60	8	3	6.30	26.00
E513M7X.75N03	7	0.75	66.0	13	7.10	5.60	8	3	6.30	26.00
E513M8X.5N01	8	0.50	72.0	16	8.00	6.30	9	3	7.50	29.00
E513M8X.5N02	8	0.50	72.0	16	8.00	6.30	9	3	7.50	29.00
E513M8X.5N03	8	0.50	72.0	16	8.00	6.30	9	3	7.50	29.00

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)		(mm)	(mm)
E513M8X.75N01	8	0.75	72.0	16	8.00	6.30	9	3	7.30	29.00
E513M8X.75N02	8	0.75	72.0	16	8.00	6.30	9	3	7.30	29.00
E513M8X.75N03	8	0.75	72.0	16	8.00	6.30	9	3	7.30	29.00
E513M8X.75N07	8	0.75	72.0	16	8.00	6.30	9	3	7.30	29.00
E513M8X1.0N01	8	1.00	72.0	16	8.00	6.30	9	3	7.00	29.00
E513M8X1.0N02	8	1.00	72.0	16	8.00	6.30	9	3	7.00	29.00
E513M8X1.0N03	8	1.00	72.0	16	8.00	6.30	9	3	7.00	29.00
E513M8X1.0N07	8	1.00	72.0	16	8.00	6.30	9	3	7.00	29.00
E513M9X.75N03	9	0.75	72.0	16	9.00	7.10	10	3	8.30	29.00
E513M9X1.0N01	9	1.00	72.0	16	9.00	7.10	10	3	8.00	29.00
E513M9X1.0N02	9	1.00	72.0	16	9.00	7.10	10	3	8.00	29.00
E513M9X1.0N03	9	1.00	72.0	16	9.00	7.10	10	3	8.00	29.00
E513M10X.5N03	10	0.50	80.0	18	10.00	8.00	11	3	9.50	34.00
E513M10X.75N01	10	0.75	80.0	18	10.00	8.00	11	3	9.30	34.00
E513M10X.75N02	10	0.75	80.0	18	10.00	8.00	11	3	9.30	34.00
E513M10X.75N03	10	0.75	80.0	18	10.00	8.00	11	3	9.30	34.00
E513M10X1.0N01	10	1.00	80.0	18	10.00	8.00	11	3	9.00	34.00
E513M10X1.0N02	10	1.00	80.0	18	10.00	8.00	11	3	9.00	34.00
E513M10X1.0N03	10	1.00	80.0	18	10.00	8.00	11	3	9.00	34.00
E513M10X1.0N06	10	1.00	80.0	18	10.00	8.00	11	3	9.00	34.00
E513M10X1.0N07	10	1.00	80.0	18	10.00	8.00	11	3	9.00	34.00
E513M10X1.25N01	10	1.25	80.0	18	10.00	8.00	11	3	8.80	34.00
E513M10X1.25N02	10	1.25	80.0	18	10.00	8.00	11	3	8.80	34.00
E513M10X1.25N03	10	1.25	80.0	18	10.00	8.00	11	3	8.80	34.00
E513M10X1.25N06	10	1.25	80.0	18	10.00	8.00	11	3	8.80	34.00
E513M10X1.25N07	10	1.25	80.0	18	10.00	8.00	11	3	8.80	34.00
E513M11X.75N01	11	0.75	85.0	19	8.00	6.30	9	3	10.30	-
E513M11X.75N02	11	0.75	85.0	19	8.00	6.30	9	3	10.30	-
E513M11X.75N03	11	0.75	85.0	19	8.00	6.30	9	3	10.30	-
E513M11X1.0N01	11	1.00	85.0	19	8.00	6.30	9	3	10.00	-
E513M11X1.0N02	11	1.00	85.0	19	8.00	6.30	9	3	10.00	-
E513M11X1.0N03	11	1.00	85.0	19	8.00	6.30	9	3	10.00	-
E513M11X1.25N03	11	1.25	85.0	19	8.00	6.30	9	3	9.80	-
E513M12X.75N03	12	0.75	89.0	22	9.00	7.10	10	3	11.30	-
E513M12X1.0N01	12	1.00	89.0	22	9.00	7.10	10	3	11.00	-
E513M12X1.0N02	12	1.00	89.0	22	9.00	7.10	10	3	11.00	-
E513M12X1.0N03	12	1.00	89.0	22	9.00	7.10	10	3	11.00	-
E513M12X1.0N07	12	1.00	89.0	22	9.00	7.10	10	3	11.00	-
E513M12X1.25N01	12	1.25	89.0	22	9.00	7.10	10	3	10.80	-
E513M12X1.25N02	12	1.25	89.0	22	9.00	7.10	10	3	10.80	-
E513M12X1.25N03	12	1.25	89.0	22	9.00	7.10	10	3	10.80	-
E513M12X1.25N06	12	1.25	89.0	22	9.00	7.10	10	3	10.80	-
E513M12X1.25N07	12	1.25	89.0	22	9.00	7.10	10	3	10.80	-
E513M12X1.5N01	12	1.50	89.0	22	9.00	7.10	10	3	10.50	-
E513M12X1.5N02	12	1.50	89.0	22	9.00	7.10	10	3	10.50	-
E513M12X1.5N03	12	1.50	89.0	22	9.00	7.10	10	3	10.50	-
E513M12X1.5N06	12	1.50	89.0	22	9.00	7.10	10	3	10.50	-
E513M12X1.5N07	12	1.50	89.0	22	9.00	7.10	10	3	10.50	-
E513M13X1.5N03	13	1.50	89.0	22	9.00	7.10	10	3	11.50	-
E513M14X1.0N01	14	1.00	95.0	24	11.20	9.00	12	4	13.00	-
E513M14X1.0N02	14	1.00	95.0	24	11.20	9.00	12	4	13.00	-
E513M14X1.0N03	14	1.00	95.0	24	11.20	9.00	12	4	13.00	-
E513M14X1.0N07	14	1.00	95.0	24	11.20	9.00	12	4	13.00	-
E513M14X1.25N01	14	1.25	95.0	24	11.20	9.00	12	4	12.80	-
E513M14X1.25N02	14	1.25	95.0	24	11.20	9.00	12	4	12.80	-
E513M14X1.25N03	14	1.25	95.0	24	11.20	9.00	12	4	12.80	-
E513M14X1.25N06	14	1.25	95.0	24	11.20	9.00	12	4	12.80	-
E513M14X1.5N01	14	1.50	95.0	24	11.20	9.00	12	4	12.50	-
E513M14X1.5N02	14	1.50	95.0	24	11.20	9.00	12	4	12.50	-
E513M14X1.5N03	14	1.50	95.0	24	11.20	9.00	12	4	12.50	-
E513M14X1.5N06	14	1.50	95.0	24	11.20	9.00	12	4	12.50	-
E513M14X1.5N07	14	1.50	95.0	24	11.20	9.00	12	4	12.50	-

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)		(mm)	(mm)
E513M15X1.5N02	15	1.50	95.0	24	11.20	9.00	12	4	13.50	—
E513M15X1.5N03	15	1.50	95.0	24	11.20	9.00	12	4	13.50	—
E513M16X1.0N01	16	1.00	102.0	24	12.50	10.00	13	4	15.00	—
E513M16X1.0N02	16	1.00	102.0	24	12.50	10.00	13	4	15.00	—
E513M16X1.0N03	16	1.00	102.0	24	12.50	10.00	13	4	15.00	—
E513M16X1.0N07	16	1.00	102.0	24	12.50	10.00	13	4	15.00	—
E513M16X1.25N03	16	1.25	102.0	24	12.50	10.00	13	4	14.80	—
E513M16X1.5N01	16	1.50	102.0	24	12.50	10.00	13	4	14.50	—
E513M16X1.5N02	16	1.50	102.0	24	12.50	10.00	13	4	14.50	—
E513M16X1.5N03	16	1.50	102.0	24	12.50	10.00	13	4	14.50	—
E513M16X1.5N06	16	1.50	102.0	24	12.50	10.00	13	4	14.50	—
E513M16X1.5N07	16	1.50	102.0	24	12.50	10.00	13	4	14.50	—
E513M18X1.0N01	18	1.00	112.0	29	14.00	11.20	14	4	17.00	—
E513M18X1.0N02	18	1.00	112.0	29	14.00	11.20	14	4	17.00	—
E513M18X1.0N03	18	1.00	112.0	29	14.00	11.20	14	4	17.00	—
E513M18X1.0N07	18	1.00	112.0	29	14.00	11.20	14	4	17.00	—
E513M18X1.5N01	18	1.50	112.0	29	14.00	11.20	14	4	16.50	—
E513M18X1.5N02	18	1.50	112.0	29	14.00	11.20	14	4	16.50	—
E513M18X1.5N03	18	1.50	112.0	29	14.00	11.20	14	4	16.50	—
E513M18X1.5N06	18	1.50	112.0	29	14.00	11.20	14	4	16.50	—
E513M18X1.5N07	18	1.50	112.0	29	14.00	11.20	14	4	16.50	—
E513M18X2.0N01	18	2.00	112.0	29	14.00	11.20	14	4	16.00	—
E513M18X2.0N02	18	2.00	112.0	29	14.00	11.20	14	4	16.00	—
E513M18X2.0N03	18	2.00	112.0	29	14.00	11.20	14	4	16.00	—
E513M18X2.0N07	18	2.00	112.0	29	14.00	11.20	14	4	16.00	—
E513M20X1.0N01	20	1.00	112.0	29	14.00	11.20	14	4	19.00	—
E513M20X1.0N02	20	1.00	112.0	29	14.00	11.20	14	4	19.00	—
E513M20X1.0N03	20	1.00	112.0	29	14.00	11.20	14	4	19.00	—
E513M20X1.0N07	20	1.00	112.0	29	14.00	11.20	14	4	19.00	—
E513M20X1.5N01	20	1.50	112.0	29	14.00	11.20	14	4	18.50	—
E513M20X1.5N02	20	1.50	112.0	29	14.00	11.20	14	4	18.50	—
E513M20X1.5N03	20	1.50	112.0	29	14.00	11.20	14	4	18.50	—
E513M20X1.5N06	20	1.50	112.0	29	14.00	11.20	14	4	18.50	—
E513M20X1.5N07	20	1.50	112.0	29	14.00	11.20	14	4	18.50	—
E513M20X2.0N01	20	2.00	112.0	29	14.00	11.20	14	4	18.00	—
E513M20X2.0N02	20	2.00	112.0	29	14.00	11.20	14	4	18.00	—
E513M20X2.0N03	20	2.00	112.0	29	14.00	11.20	14	4	18.00	—
E513M20X2.0N07	20	2.00	112.0	29	14.00	11.20	14	4	18.00	—
E513M22X1.0N02	22	1.00	118.0	29	16.00	12.50	16	4	21.00	—
E513M22X1.0N03	22	1.00	118.0	29	16.00	12.50	16	4	21.00	—
E513M22X1.0N07	22	1.00	118.0	29	16.00	12.50	16	4	21.00	—
E513M22X1.5N01	22	1.50	118.0	29	16.00	12.50	16	4	20.50	—
E513M22X1.5N02	22	1.50	118.0	29	16.00	12.50	16	4	20.50	—
E513M22X1.5N03	22	1.50	118.0	29	16.00	12.50	16	4	20.50	—
E513M22X1.5N07	22	1.50	118.0	29	16.00	12.50	16	4	20.50	—
E513M22X2.0N01	22	2.00	118.0	29	16.00	12.50	16	4	20.00	—
E513M22X2.0N02	22	2.00	118.0	29	16.00	12.50	16	4	20.00	—
E513M22X2.0N03	22	2.00	118.0	29	16.00	12.50	16	4	20.00	—
E513M22X2.0N07	22	2.00	118.0	29	16.00	12.50	16	4	20.00	—
E513M24X1.0N02	24	1.00	130.0	35	18.00	14.00	18	4	23.00	—
E513M24X1.0N03	24	1.00	130.0	35	18.00	14.00	18	4	23.00	—
E513M24X1.5N01	24	1.50	130.0	35	18.00	14.00	18	4	22.50	—
E513M24X1.5N02	24	1.50	130.0	35	18.00	14.00	18	4	22.50	—
E513M24X1.5N03	24	1.50	130.0	35	18.00	14.00	18	4	22.50	—
E513M24X1.5N07	24	1.50	130.0	35	18.00	14.00	18	4	22.50	—
E513M24X2.0N01	24	2.00	130.0	35	18.00	14.00	18	4	22.00	—
E513M24X2.0N02	24	2.00	130.0	35	18.00	14.00	18	4	22.00	—
E513M24X2.0N03	24	2.00	130.0	35	18.00	14.00	18	4	22.00	—
E513M24X2.0N07	24	2.00	130.0	35	18.00	14.00	18	4	22.00	—
E513M25X1.5N01	25	1.50	130.0	35	18.00	14.00	18	4	23.50	—
E513M25X1.5N02	25	1.50	130.0	35	18.00	14.00	18	4	23.50	—
E513M25X1.5N03	25	1.50	130.0	35	18.00	14.00	18	4	23.50	—

Product	TDZ	TP	OAL	THL	DCON MS	WSC	LSC	NOF	PHD	LU
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)		(mm)	(mm)
E513M25X1.5N06	25	1.50	130.0	35	18.00	14.00	18	4	23.50	-
E513M25X1.5N07	25	1.50	130.0	35	18.00	14.00	18	4	23.50	-
E513M26X1.5N02	26	1.50	130.0	35	18.00	14.00	18	4	24.50	-
E513M26X1.5N03	26	1.50	130.0	35	18.00	14.00	18	4	24.50	-
E513M27X1.5N02	27	1.50	135.0	35	20.00	16.00	20	4	25.50	-
E513M27X1.5N03	27	1.50	135.0	35	20.00	16.00	20	4	25.50	-
E513M27X2.0N03	27	2.00	135.0	35	20.00	16.00	20	4	25.00	-
E513M28X1.5N02	28	1.50	138.0	35	20.00	16.00	20	4	26.50	-
E513M28X1.5N03	28	1.50	138.0	35	20.00	16.00	20	4	26.50	-
E513M30X1.5N02	30	1.50	138.0	41	20.00	16.00	20	4	28.50	-
E513M30X1.5N03	30	1.50	138.0	41	20.00	16.00	20	4	28.50	-
E513M30X2.0N02	30	2.00	138.0	41	20.00	16.00	20	4	28.00	-
E513M30X2.0N03	30	2.00	138.0	41	20.00	16.00	20	4	28.00	-
E513M32X1.5N01	32	1.50	151.0	41	22.40	18.00	22	4	30.50	-
E513M32X1.5N02	32	1.50	151.0	41	22.40	18.00	22	4	30.50	-
E513M32X1.5N03	32	1.50	151.0	41	22.40	18.00	22	4	30.50	-
E513M33X2.0N02	33	2.00	151.0	41	22.40	18.00	22	4	31.00	-
E513M33X2.0N03	33	2.00	151.0	41	22.40	18.00	22	4	31.00	-
E513M35X1.5N02	35	1.50	162.0	47	25.00	20.00	24	4	33.50	-
E513M35X1.5N03	35	1.50	162.0	47	25.00	20.00	24	4	33.50	-
E513M36X1.5N03	36	1.50	162.0	47	25.00	20.00	24	4	34.50	-
E513M36X2.0N02	36	2.00	162.0	47	25.00	20.00	24	4	34.00	-
E513M36X2.0N03	36	2.00	162.0	47	25.00	20.00	24	4	34.00	-
E513M36X3.0N02	36	3.00	162.0	47	25.00	20.00	24	4	33.00	-
E513M36X3.0N03	36	3.00	162.0	47	25.00	20.00	24	4	33.00	-
E513M39X3.0N02	39	3.00	170.0	47	28.00	22.40	26	4	36.00	-
E513M39X3.0N03	39	3.00	170.0	47	28.00	22.40	26	4	36.00	-
E513M40X1.5N02	40	1.50	170.0	53	28.00	22.40	26	6	38.50	-
E513M40X1.5N03	40	1.50	170.0	53	28.00	22.40	26	6	38.50	-
E513M42X1.5N02	42	1.50	170.0	53	28.00	22.40	26	6	40.50	-
E513M42X1.5N03	42	1.50	170.0	53	28.00	22.40	26	6	40.50	-
E513M42X3.0N03	42	3.00	170.0	53	28.00	22.40	26	6	39.00	-
E513M45X1.5N02	45	1.50	187.0	54	31.50	25.00	28	6	43.50	-
E513M45X1.5N03	45	1.50	187.0	54	31.50	25.00	28	6	43.50	-
E513M48X1.5N03	48	1.50	187.0	60	31.50	25.00	28	6	46.50	-
E513M48X2.0N03	48	2.00	187.0	60	31.50	25.00	28	6	46.00	-
E513M48X3.0N03	48	3.00	187.0	60	31.50	25.00	28	6	45.00	-
E513M50X1.5N02	50	1.50	187.0	60	31.50	25.00	28	6	48.50	-
E513M50X1.5N03	50	1.50	187.0	60	31.50	25.00	28	6	48.50	-