

DORMER

Taps for Maintenance, Repair and Overhaul

New products 2016.2





INTRODUCTION

To complement a large range of threading products, Dormer has developed a range of machine taps suited for the MRO sector (Maintenance, Repair and Overhaul) who require a good quality, yet economic solution for tapping.

Available in Metric, Metric Fine and BSP thread forms in straight flute, spiral point and spiral flute, this range of taps delivers good performance across a wide range of work-piece materials

MATERIAL

Manufactured from premium quality High Speed Steel (HSS):

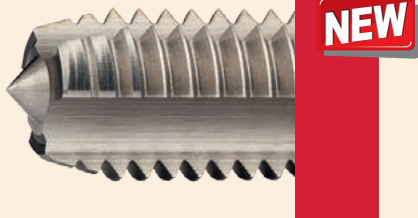
- Increased hardness and toughness
- Improved strength
- Good tool life

SURFACE TREATMENT

Bright Finish:

- Universally suitable for many materials
- Also works well in soft ductile materials which have a tendency to stick to the cutting edges

TAP STYLES



STRAIGHT FLUTE

First choice for short chipping materials such as cast irons

- Threading depths up to 1.5xD
- Chamfer form C for blind and through holes
- Bright finish for universal applications

RANGE:

E781 – Metric – M3 to M20

E784 – Metric Fine – M6 to M20

E787 – BSP(G) – 1/8" to 1"



SPIRAL POINT

First choice for through holes in a wide selection of materials

- Threading depths up to 2.5xD
- Chamfer form B for through holes
- Bright finish for universal applications

RANGE:

E782 – Metric – M3 to M20

E785 – Metric Fine – M6 to M20

E788 – BSP(G) – 1/8" to 1"



GEOMETRY AND CHAMFER

- Manufactured to DIN standard with optimized geometry for good chip control
- Available with chamfer form C for blind and through holes

APPLICATIONS

- The toughness of HSS makes this range of taps ideal for applications that are not clamped rigidly
- They are also suitable for running at lower speeds on more conventional machines, where vibration may occur
- The high strength of HSS provides a more secure cutting edge in materials or castings that are prone to having inclusions

AVAILABLE IN SETS

**NEW**

SPIRAL FLUTE

First choice for blind holes in a wide selection of materials

- 45 degree helix for threading depths up to 2.5xD
- Chamfer form C for blind holes
- Bright finish for universal applications

RANGE:

E783 – Metric – M3 to M20

E786 – Metric Fine – M6 to M20

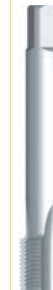
E789 – BSP(G) – 1/8" to 1"



FOR FURTHER ECONOMY

Bright Finish:

- Set number L700N781
 - Including Metric straight flute taps from M3 to M10
- Set number L700N782
 - Including Metric spiral point taps from M3 to M10
- Set number L700N783
 - Including Metric spiral flute taps from M3 to M10

	M	M	M	MF	MF	MF	G	G	G	
	DIN 3714 10 3763 12	DIN 3714 10 3763 12	DIN 3714 10 3763 12	DIN 374	DIN 374	DIN 374	DIN 5156	DIN 5156	DIN 5156	
	6H	6H	6H	6H	6H	6H	Normal	Normal	Normal	
										
	1.5XD	2.5XD	2.5XD	1.5XD	2.5XD	2.5XD	1.5XD	2.5XD	2.5XD	
	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	
	C 2-3	B 3.5-5	C 2-3	C 2-3	B 3.5-5	C 2-3	C 2-3	B 3.5-5	C 2-3	
										
										
										
										
	E781	E782	E783	E784	E785	E786	E787	E788	E789	L700
	M3 - M20	M3 - M20	M3 - M20	M6 - M20	M6 - M20	M6 - M20	1/8 - 1"	1/8 - 1"	1/8 - 1"	Set
	NEW	NEW	NEW	NEW	NEW	NEW	NEW	NEW	NEW	NEW
AMG										ISO
1.1	●7	●20	●20	●7	●20	●20	●7	●20	●20	P1
1.2	●6	●18	●18	●6	●18	●18	●6	●18	●18	P1
1.3	●5	●14	●14	●5	●14	●14	●5	●14	●14	P2
1.4	●4	●10	●10	●4	●10	●10	●4	●10	●10	P3
1.5	●3	●5	●5	●3	●5	●5	●3	●5	●5	P4
1.6										H1
1.7										H3
1.8										H4
2.1										M1
2.2										M3
2.3										M2
2.4										S2
3.1	●12	●12	●12	●12	●12	●12	●12	●12	●12	K1
3.2	●7	●7	●7	●7	●7	●7	●7	●7	●7	K2
3.3	●10	●10	●10	●10	●10	●10	●10	●10	●10	K3
3.4	●5	●5	●5	●5	●5	●5	●5	●5	●5	K4
4.1										S1
4.2										S2
4.3										S3
5.1										S1
5.2										S2
5.3										S3
6.1	●4	●10		●4	●10		●4	●10		N3
6.2	●10			●10			●10			N4
6.3	●7	●15		●7	●15		●7	●15		N3
6.4	●2			●2			●2			N4
7.1		●10	●10		●10	●10		●10	●10	N1
7.2	●12	●25	●25	●12	●25	●25	●12	●25	●25	N1
7.3	●7	●13	●13	●7	●13	●13	●7	●13	●13	N1
7.4	●5	●10	●10	●5	●10	●10	●5	●10	●10	N2
8.1	●8	●10		●8	●10		●8	●10		O
8.2	●5			●5			●5			O
8.3	●3			●3			●3			O
9.1										H
10.1										O



E781 • M Machine Tap Straight Flute

E781 • 1.1 1.2 1.3 1.4 1.5 3.1 3.2 3.3 3.4 6.1 6.2 6.3 6.4 7.2 7.3 7.4 8.1 8.2 8.3

E781

M

DIN
371 ≤ 10
376 ≥ 12

6H



1.5XD

HSS

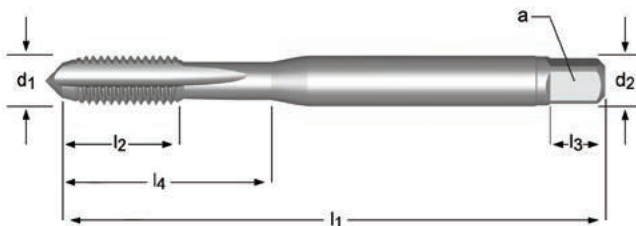
C
2-3



E781



M3 - M20



M	P mm	l ₁ mm	l ₂ mm	d ₂ Ø mm	□ a mm	l ₃ mm	z		l ₄ mm	E781
3	0.50	56	11	3.5	2.7	6	3	2.5	18	E781M3
4	0.70	63	13	4.5	3.4	6	3	3.3	21	E781M4
5	0.80	70	16	6.0	4.9	8	3	4.2	25	E781M5
6	1.00	80	19	6.0	4.9	8	3	5.0	30	E781M6
8	1.25	90	22	8.0	6.2	9	3	6.8	35	E781M8
10	1.50	100	24	10.0	8.0	11	4	8.5	39	E781M10
12	1.75	110	28	9.0	7.0	10	4	10.3	-	E781M12
16	2.00	110	32	12.0	9.0	12	4	14.0	-	E781M16
20	2.50	140	34	16.0	12.0	15	4	17.5	-	E781M20

E782 • M Machine Tap Spiral Point

E782 • 1.1 1.2 1.3 1.4 1.5 3.1 3.2 3.3 3.4 6.1 6.3 7.1 7.2 7.3 7.4 8.1

E782

M

DIN
371 ≤ 10
376 ≥ 12

6H



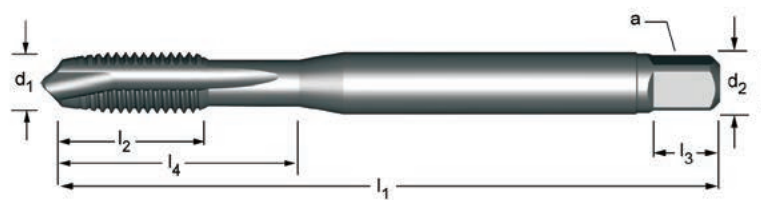
2.5XD

HSS

B
3.5-5



L700
14



E782



M3 - M20

M	P mm	l ₁ mm	l ₂ mm	d ₂ Ø mm	□ a mm	l ₃ mm	z		l ₄ mm	E782
3	0.50	56	11	3.5	2.7	6	3	2.5	18	E782M3
4	0.70	63	13	4.5	3.4	6	3	3.3	21	E782M4
5	0.80	70	16	6.0	4.9	8	3	4.2	25	E782M5
6	1.00	80	19	6.0	4.9	8	3	5.0	30	E782M6
8	1.25	90	22	8.0	6.2	9	3	6.8	35	E782M8
10	1.50	100	24	10.0	8.0	11	3	8.5	39	E782M10
12	1.75	110	28	9.0	7.0	10	4	10.3	-	E782M12
16	2.00	110	32	12.0	9.0	12	4	14.0	-	E782M16
20	2.50	140	34	16.0	12.0	15	4	17.5	-	E782M20

E783 • M Machine Tap Spiral Flute 45°

E783 • 1.1 1.2 1.3 1.4 1.5 3.1 3.2 3.3 3.4 7.1 7.2 7.3 7.4

E783

M

DIN
371 ≤ 10
376 ≥ 12

6H



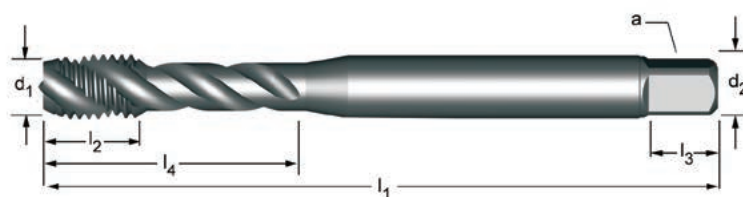
2.5XD

HSS

C
2-3



L700
14



E783



M3 - M20

M	P mm	l_1 mm	l_2 mm	d_2 Ø mm	$\square$ a mm	l_3 mm	z		l_4 mm	E783
3	0.50	56	5	3.5	2.7	6	3	2.5	18	E783M3
4	0.70	63	7	4.5	3.4	6	3	3.3	21	E783M4
5	0.80	70	8	6.0	4.9	8	3	4.2	25	E783M5
6	1.00	80	10	6.0	4.9	8	3	5.0	30	E783M6
8	1.25	90	13	8.0	6.2	9	3	6.8	35	E783M8
10	1.50	100	15	10.0	8.0	11	4	8.5	39	E783M10
12	1.75	110	18	9.0	7.0	10	4	10.3	-	E783M12
16	2.00	110	20	12.0	9.0	12	4	14.0	-	E783M16
20	2.50	140	25	16.0	12.0	15	4	17.5	-	E783M20

E784 • MF Machine Tap Straight Flute

E784 • 1.1 1.2 1.3 1.4 1.5 3.1 3.2 3.3 3.4 6.1 6.2 6.3 6.4 7.2 7.3 7.4 8.1 8.2 8.3

E784

MF

DIN
374

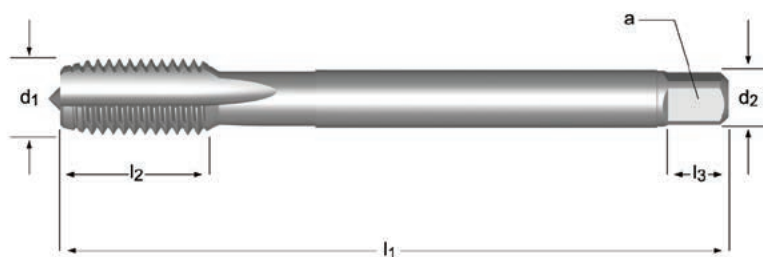
6H



1.5XD

HSS

C
2-3



E784



M6 - M20

MF	P mm	l ₁ mm	l ₂ mm	d ₂ Ø mm	□ a mm	l ₃ mm	z		E784
6	0.75	80	19	4.5	3.4	6.0	3	5.3	E784M6X.75
8	1.00	90	22	6.0	4.9	8.0	3	7.0	E784M8X1.0
10	1.00	90	20	7.0	5.5	8.0	4	9.0	E784M10X1.0
10	1.25	100	24	7.0	5.5	8.0	4	8.8	E784M10X1.25
12	1.25	100	22	9.0	7.0	10.0	4	10.8	E784M12X1.25
12	1.50	100	22	9.0	7.0	10.0	4	10.5	E784M12X1.5
16	1.50	100	22	12.0	9.0	12.0	4	14.5	E784M16X1.5
20	1.50	125	25	16.0	12.0	15.0	4	18.5	E784M20X1.5

E785 • MF Machine Tap Spiral Point

E785 • 1.1 1.2 1.3 1.4 1.5 3.1 3.2 3.3 3.4 6.1 6.3 7.1 7.2 7.3 7.4 8.1

E785

MF

DIN
374

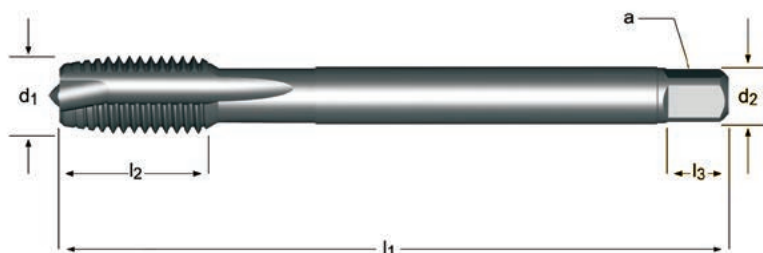
6H



2.5XD

HSS

B
3.5-5



E785



M6 - M20

MF	P mm	l_1 mm	l_2 mm	d_2 Ø mm	$\square$ a mm	l_3 mm	z		E785
6	0.75	80	19	4.5	3.4	6.0	3	5.3	E785M6X.75
8	1.00	90	22	6.0	4.9	8.0	3	7.0	E785M8X1.0
10	1.00	90	20	7.0	5.5	8.0	3	9.0	E785M10X1.0
10	1.25	100	24	7.0	5.5	8.0	3	8.8	E785M10X1.25
12	1.25	100	22	9.0	7.0	10.0	4	10.8	E785M12X1.25
12	1.50	100	22	9.0	7.0	10.0	4	10.5	E785M12X1.5
16	1.50	100	22	12.0	9.0	12.0	4	14.5	E785M16X1.5
20	1.50	125	25	16.0	12.0	15.0	4	18.5	E785M20X1.5

E786 • MF Machine Tap Spiral Flute 45°

E786 • 1.1 1.2 1.3 1.4 1.5 3.1 3.2 3.3 3.4 7.1 7.2 7.3 7.4

E786

MF

DIN
374

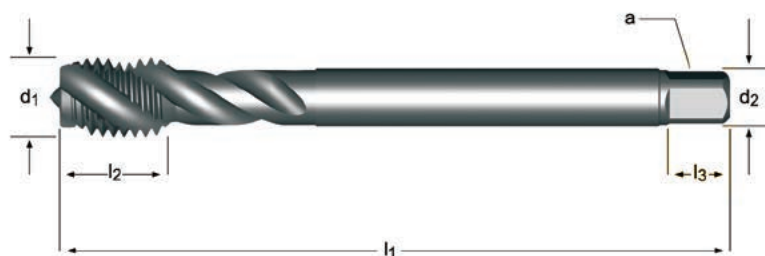
6H



2.5XD

HSS

C
2-3



E786



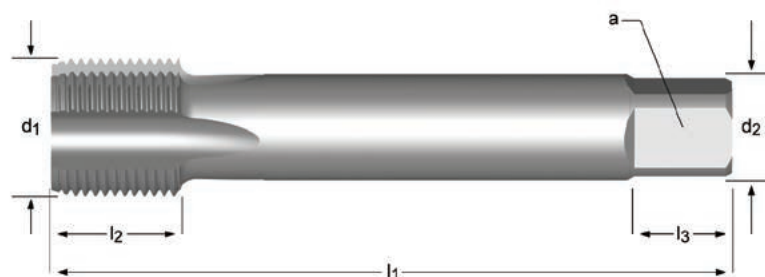
M6 - M20

MF	P mm	l_1 mm	l_2 mm	d_2 Ø mm	$\square$ a mm	l_3 mm	z		E786
6	0.75	80	10	4.5	3.4	6	3	5.3	E786M6X.75
8	1.00	90	13	6.0	4.9	8	3	7.0	E786M8X1.0
10	1.00	90	15	7.0	5.5	8	3	9.0	E786M10X1.0
10	1.25	100	15	7.0	5.5	8	3	8.8	E786M10X1.25
12	1.25	100	18	9.0	7.0	10	4	10.8	E786M12X1.25
12	1.50	100	18	9.0	7.0	10	4	10.5	E786M12X1.5
16	1.50	100	20	12.0	9.0	12	4	14.5	E786M16X1.5
20	1.50	125	25	16.0	12.0	15	4	18.5	E786M20X1.5

E787 • G(BSP) Machine Tap Straight Flute

E787 • 1.1 1.2 1.3 1.4 1.5 3.1 3.2 3.3 3.4 6.1 6.2 6.3 6.4 7.2 7.3 7.4 8.1 8.2 8.3

E787 **G** **DIN 5156** Normal  **1.5XD** **HSS** **C 2-3**    



E787



1/8 - 1"

G(BSP)	TPI	d ₁ nom mm	l ₁ mm	l ₂ mm	d ₂ Ø mm	□ a mm	l ₃ mm	z		E787
1/8	28	9.728	90	20	7.0	5.5	8	3	8.8	E7871/8
1/4	19	13.157	100	21	11.0	9.0	12	4	11.8	E7871/4
3/8	19	16.662	100	21	12.0	9.0	12	4	15.25	E7873/8
1/2	14	20.955	125	24	16.0	12.0	15	4	19.0	E7871/2
3/4	14	26.441	140	28	20.0	16.0	19	4	24.5	E7873/4
1"	11	33.249	160	30	25.0	20.0	23	4	30.75	E7871

E788 • G(BSP) Machine Tap Spiral Point

E788 • 1.1 1.2 1.3 1.4 1.5 3.1 3.2 3.3 3.4 6.1 6.3 7.1 7.2 7.3 7.4 8.1

E788

G

DIN
5156

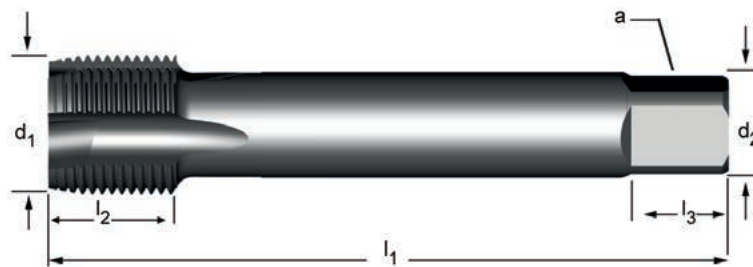
Normal



2.5XD

HSS

B
3.5-5



E788



1/8 - 1"

G(BSP)	TPI	d ₁ nom mm	l ₁ mm	l ₂ mm	d ₂ Ø mm	□ a mm	l ₃ mm	z		E788
1/8	28	9.728	90	18	7.0	5.5	8	3	8.8	E7881/8
1/4	19	13.157	100	21	11.0	9.0	12	3	11.8	E7881/4
3/8	19	16.662	100	21	12.0	9.0	12	4	15.25	E7883/8
1/2	14	20.955	125	24	16.0	12.0	15	4	19.0	E7881/2
3/4	14	26.441	140	28	20.0	16.0	19	4	24.5	E7883/4
1"	11	33.249	160	30	25.0	20.0	23	4	30.75	E7881

E789 • G(BSP) Machine Tap Spiral Flute 45°

E789 • 1.1 1.2 1.3 1.4 1.5 3.1 3.2 3.3 3.4 7.1 7.2 7.3 7.4

E789

G

DIN
5156

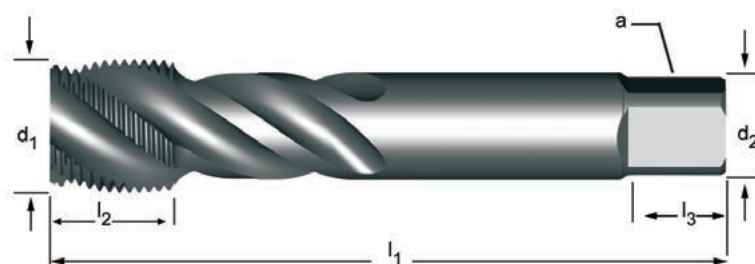
Normal



2.5XD

HSS

C
2-3



E789



1/8 - 1"

G(BSP)	TPI	d ₁ nom mm	l ₁ mm	l ₂ mm	d ₂ Ø mm	□ a mm	l ₃ mm	z		E789
1/8	28	9.728	90	13	7.0	5.5	8	3	8.8	E7891/8
1/4	19	13.157	100	15	11.0	9.0	12	3	11.8	E7891/4
3/8	19	16.662	100	15	12.0	9.0	12	4	15.25	E7893/8
1/2	14	20.955	125	18	16.0	12.0	15	4	19.0	E7891/2
3/4	14	26.441	140	20	20.0	16.0	19	4	24.5	E7893/4
1"	11	33.249	160	22	25.0	20.0	23	4	30.75	E7891

L700 • Metric Coarse Taps Set

A=Styles in Set, B=No. in Set, M=Tap diameters in Set



L700



Set

Nr.	A	B	M	L700
N781	E781	6	E781M3, E781M4, E781M5, E781M6, E781M8, E781M10	L700N781
N782	E782	6	E782M3, E782M4, E782M5, E782M6, E782M8, E782M10	L700N782
N783	E783	6	E783M3, E783M4, E783M5, E783M6, E783M8, E783M10	L700N783



SIMPLY RELIABLE

As a professional you can judge the quality of work by just looking at the chip. Our chip is a clean and uncomplicated shape that in itself tells a story. It is a clear and consistent signal and that's why we use it as a symbol for being **simply reliable**.

Argentina

T: 54 (11) 6777-6777
F: 54 (11) 4441-4467
info.ar@dormerpramet.com

Australia

T: 1300 131 274
F: 1300 809 510
info.au@dormerpramet.com

Austria

T: +31 10 2080 240
F: +31 10 2080 282
info.au@dormerpramet.com

Belgium & Luxembourg

T: +32 3 440 59 01
F: +32 3 449 15 43
info.be@dormerpramet.com

Brazil

T: +55 11 5660 3000
F: +55 11 5667 5883
info.br@dormerpramet.com

Canada

T: (888) 336 7637
En Français: (888) 368 8457
F: (905) 542 7000
cs.canada@dormerpramet.com

China

T: +86 21 2416 0508
F: +86 21 5442 6315
info.cn@dormerpramet.com

Croatia

T: +385 98 407 489
info.hr@dormerpramet.com

Czech Republic

T: +420 583 381 111
F: +420 583 215 401
info.cz@dormerpramet.com

Denmark

T: 808 82106
F: +46 35 16 52 90
info.se@dormerpramet.com

Finland

T: 0205 44 7003
F: 0205 44 7004
info.fi@dormerpramet.com

France

T: +33 (0)2 47 62 57 01
F: +33 (0)2 47 62 52 00
info.fr@dormerpramet.com

Germany

T: +49 9131 933 08 70
F: +49 9131 933 08 742
info.de@dormerpramet.com

Hungary

T: +36-96 / 522-846
F: +36-96 / 522-847
info.hu@dormerpramet.com

India

T: +91 11 4601 5686
info.in@dormerpramet.com

Italy

solid tools:
T: +39 02 38 04 51
F: +39 02 38 04 52 43
indexable tools:
T: +39 0523 55 19 11
F: +39 0523 55 18 00
info.it@dormerpramet.com

Kazakhstan

T: +7 771 305 11 45
info.kz@dormerpramet.com

Mexico

T: +52 (555) 7293981
F: +52 (555) 7293981
cs.mexico@dormerpramet.com

Netherlands

T: +31 10 2080 240
F: +31 10 2080 282
info.nl@dormerpramet.com

New Zealand

T: +64 9 2735858
F: +64 9 2735857
info.int@dormerpramet.com

Norway

T: 800 10 113
F: +46 35 16 52 90
info.se@dormerpramet.com

Poland

T: +48 32 78-15-890
F: +48 32 78-60-406
info.pl@dormerpramet.com

Romania

T: +4(0)730 015 885
info.ro@dormerpramet.com

Russia

T: +7 495 775 10 28
Φ: +7 (499) 763 38 90
info.ru@dormerpramet.com

Slovakia

T: +421 (41) 764 54 60
F: +421 (41) 763 74 49
info.sk@dormerpramet.com

Spain

T: +34 935717722
F: +34 935717765
info.es@dormerpramet.com

Portugal

T: +351 21 424 54 21
F: +351 21 424 54 25
info.pt@dormerpramet.com

Slovenia

T: +385 98 407 489
info.si@dormerpramet.com

Sweden

responsible for **Iceland**
T: +46 35 16 52 96
F: +46 35 16 52 90
info.se@dormerpramet.com

Switzerland

T: +31 10 2080 240
F: +31 10 2080 282
info.ch@dormerpramet.com

Turkey

T: +90 533 212 45 47
info.tr@dormerpramet.com

Ukraine

T: +38 056 376 51 19
F: +38 056 376 51 20
info.ua@dormerpramet.com

United Kingdom

responsible for **Ireland**
T: 0870 850 4466
F: 0870 850 8866
info.uk@dormerpramet.com

United States of America

T: (800) 877-3745
F: (847) 783-5760
cs@dormerpramet.com

Other countries

South America

T: +55 11 5660 3000
F: +55 11 5667 5883
info.br@dormerpramet.com

Central and Eastern Europe

T: +420 583 381 529
F: +420 583 381 401
info.rcee@dormerpramet.com

Rest of the World

Dormer Pramet International UK
T: +44 1246 571338
F: +44 1246 571339
info.int@dormerpramet.com

Dormer Pramet International CZ

T: +420 583 381 520
F: +420 583 215 401
info.int.cz@dormerpramet.com



880992

DOR-BRO-MRO-2016-2-EN

DORMER PRAMET

www.dormerpramet.com