

# Merlin Tools Ltd



## Machine Taps

**HSSE M35 & HSSEX ASP 2023**  
**Standard & High Performance**  
**Applications**

Manufactured in Europe  
Distributed in the UK



ISO 9001:2008



**NEW  
PRODUCT  
LINES**



# Machine Taps

## High Performance - Special Applications



**M**   Tol. ISO 2 6H DIN 371 DIN 376 HSSEX (ASP2023)

VAP Spiral Point



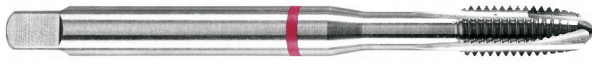
VAP Spiral Flute



TAP DIA	PITCH	SHANK DIA mm	OAL mm	mm	No. FLUTES	SPIRAL POINT	SPIRAL FLUTE
3	0.50	3.5	56	2.7	3	DIN 371	DIN 371
4	0.70	4.5	63	3.4	3	9110-62145	9120-63098
5	0.80	6	70	4.9	3	9110-62169	9120-63111
6	1.00	6	80	4.9	3	9110-62176	9120-63128
8	1.25	8	90	6.2	3	9110-62183	9120-63135
10	1.50	10	100	8	3	9110-62190	9120-63142
<b>DIN 376</b>							<b>DIN 376</b>
8	1.25	6	90	4.9	3	9110-57677	9120-59633
10	1.50	7	100	5.5	3	9110-57684	9120-59640
12	1.75	9	110	7	3	9110-57691	9120-59657
14	2.00	11	110	9	3	9110-57707	9120-59664
16	2.00	12	110	9	3	9110-57714	9120-59671
18	2.50	14	125	11	4	9110-57721	9120-59688
20	2.50	16	140	12	4	9110-57738	9120-59695

**M**   Tol. ISO 2 6H DIN 371 DIN 376 HSSEX (ASP2023)

Spiral Point



Spiral Flute



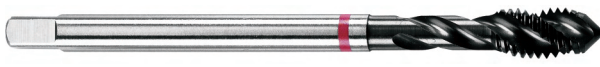
TAP DIA	PITCH	SHANK DIA mm	OAL mm	mm	No. FLUTES	SPIRAL POINT	SPIRAL FLUTE
3	0.50	3.5	56	2.7	3	DIN 371	DIN 371
4	0.70	4.5	63	3.4	3	9130-62077	9140-63036
5	0.80	6	70	4.9	3	9130-62091	9140-63043
6	1.00	6	80	4.9	3	9130-62107	9140-63050
8	1.25	8	90	6.2	3	9130-62114	9140-63067
10	1.50	10	100	8	3	9130-62121	9140-63074
<b>DIN 376</b>							<b>DIN 376</b>
8	1.25	6	90	4.9	3	9130-62138	9140-63081
10	1.50	7	100	5.5	3	9130-62145	9140-63088
12	1.75	9	110	7	3	9130-62152	9140-63095
14	2.00	11	110	9	3	9130-62159	9140-63102
16	2.00	12	110	9	3	9130-62166	9140-63109

**M**   Tol. ISO 2 6H DIN 371 DIN 376 HSSEX (ASP2023)




TiALN Spiral Point



TiALN Spiral Flute



TAP DIA	PITCH	SHANK DIA mm	OAL mm	mm	No. FLUTES	SPIRAL POINT	SPIRAL FLUTE
3	0.50	3.5	56	2.7	3	DIN 371	DIN 371
4	0.70	4.5	63	3.4	3	9150-66501	9160-66624
5	0.80	6	70	4.9	3	9150-66518	9160-66631
6	1.00	6	80	4.9	3	9150-66525	9160-66648
8	1.25	8	90	6.2	3	9150-66532	9160-66655
10	1.50	10	100	8	3	9150-66549	9160-66662
<b>DIN 376</b>							<b>DIN 376</b>
8	1.25	6	90	4.9	3	9150-66556	9160-66679
10	1.50	7	100	5.5	3	9150-66211	9160-66310
12	1.75	9	110	7	3	9150-66228	9160-66327
14	2.00	11	110	9	3	9150-66235	9160-66334
16	2.00	12	110	9	3	9150-66242	9160-66341
<b>DIN 376</b>							<b>DIN 376</b>
8	1.25	6	90	4.9	3	9150-66259	9160-66358

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# Machine Taps

## High Performance - Special Applications



**M**   Tol. ISO 2 6H DIN 371 DIN 376 HSSE (M35)



Spiral Point



Spiral Flute



TAP DIA	PITCH	SHANK DIA mm	OAL mm	mm	No. FLUTES	SPIRAL POINT	SPIRAL FLUTE
3	0.50	3.5	56	2.7	3	DIN 371	DIN 371
4	0.70	4.5	63	3.4	3	9200-62442	9210-63395
5	0.80	6	70	4.9	3	9200-62473	9210-63425
6	1.00	6	80	4.9	3	9200-62480	9210-63432
8	1.25	8	90	6.2	3	9200-62497	9210-63456
10	1.50	10	100	8	3	9200-62503	9210-63463
						<b>DIN 376</b>	<b>DIN 376</b>
8	1.25	6	90	4.9	3	9200-58117	9210-59909
10	1.50	7	100	5.5	3	9200-58131	9210-59923
12	1.75	9	110	7	3	9200-58148	9210-59930
14	2.00	11	110	9	3	9200-58155	9210-59947
16	2.00	12	110	9	3	9200-58162	9210-65245

**M**   Tol. ISO 2 6H DIN 371 DIN 376 HSSE (M35)

CrN Spiral Point



CrN Spiral Flute



TAP DIA	PITCH	SHANK DIA mm	OAL mm	mm	No. FLUTES	SPIRAL POINT	SPIRAL FLUTE
3	0.50	3.5	56	2.7	3	DIN 371	DIN 371
4	0.70	4.5	63	3.4	3	9220-66563	9230-66693
5	0.80	6	70	4.9	3	9220-66587	9230-66716
6	1.00	6	80	4.9	3	9220-66594	9230-66723
8	1.25	8	90	6.2	3	9220-66600	9230-66730
10	1.50	10	100	8	3	9220-66617	9230-66747
						<b>DIN 376</b>	<b>DIN 376</b>
8	1.25	6	90	4.9	3	9220-66266	9230-66389
10	1.50	7	100	5.5	3	9220-66273	9230-66396
12	1.75	9	110	7	3	9220-66280	9230-66402
14	2.00	11	110	9	3	9220-66297	9230-66419
16	2.00	12	110	9	3	9220-66303	9230-66426

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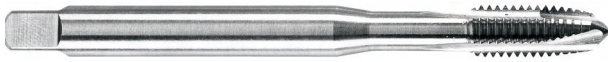
# Machine Taps Standard Applications



**M**

	Tol. ISO 2 6H	DIN 371 DIN 376	HSSE (M35)
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Spiral Point




Spiral Flute



TAP DIA	PITCH	SHANK DIA mm	OAL mm	mm	No. FLUTES	SPIRAL POINT	SPIRAL FLUTE
2	0.40	2.8	45	2.1	3	DIN 371	DIN 371
2.5	0.45	2.8	50	2.1	3	8110-61698	8120-62695
3	0.50	3.5	56	2.7	3	8110-61704	8120-62701
3.5	0.60	4	56	3	3	8110-61728	8120-62725
4	0.70	4.5	63	3.4	3	8110-61742	8120-62749
5	0.80	6	70	4.9	3	8110-61759	8120-62756
6	1.00	6	80	4.9	3	8110-61780	8120-62763
6	1.00	6	80	4.9	3	8110-61803	8120-62770
8	1.25	8	90	6.2	3	8110-61827	8120-62794
10	1.50	10	100	8	3	8110-61841	8120-62800
						<b>DIN 376</b>	<b>DIN 376</b>
8	1.25	6	90	4.9	3	8110-56410	8120-58858
10	1.50	7	100	5.5	3	8110-56434	8120-58872
12	1.75	9	110	7	3	8110-56458	8120-58896
14	2.00	11	110	9	3	8110-56472	8120-58902
16	2.00	12	110	9	3	8110-56496	8120-58919
18	2.50	14	125	11	4	8110-56502	8120-58926
20	2.50	16	140	12	4	8110-56519	8120-58933
22	2.50	18	140	14.5	4	8110-56526	8120-58940
24	3.00	18	160	14.5	4	8110-56533	8120-58957

**M**

	Tol. ISO 3 6H	DIN 371 DIN 376	HSSE (M35)
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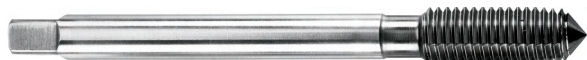
TICN

Fluteless (Roll Tap)




TiCN

Fluteless (Roll Tap)

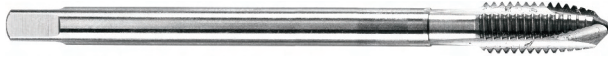


TAP DIA	PITCH	SHANK DIA mm	OAL mm	mm	No. FLUTES	SPIRAL POINT	SPIRAL FLUTE
3	0.50	3.5	56	2.7	-	DIN 371	DIN 371
4	0.70	4.5	63	3.4	-	8130-63739	8140-64781
5	0.80	6	70	4.9	-	8130-63746	8140-64798
6	1.00	6	80	4.9	-	8130-63753	8140-64804
6	1.00	6	80	4.9	-	8130-63760	8140-64811
8	1.25	8	90	6	-	8130-63784	8140-64828
10	1.50	10	100	8	-	8130-63791	8140-64835
						<b>DIN 376</b>	<b>DIN 376</b>
12	1.75	9	110	7	-	8130-60127	8140-64767

**MF**

	Tol. ISO 2 6H	DIN 374	HSSE (M35)
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Spiral Point




Spiral Flute



TAP DIA	PITCH	SHANK DIA mm	OAL mm	mm	No. FLUTES	SPIRAL POINT	SPIRAL FLUTE
8	1.00	6	90	4.9	3	DIN 374	DIN 374
10	1.00	7	90	5.5	3	8150-56656	8160-59008
10	1.25	7	100	5.5	3	8150-56687	8160-59022
12	1.00	9	100	7	3	8150-56694	8160-59039
12	1.00	9	100	7	3	8150-56724	8160-59060
12	1.50	9	100	7	3	8150-56748	8160-59084
14	1.50	11	100	9	3	8150-56774	8160-59114
16	1.50	12	100	9	3	8150-56809	8160-59114
16	1.50	12	100	9	3	8150-56861	8160-59152
18	1.50	14	110	11	4	8150-56885	8160-59169
20	1.50	16	125	12	4	8150-56915	8160-59183
22	1.50	18	125	14.5	4	8150-56946	8160-59190
24	1.50	18	125	14.5	4	8150-56977	8160-59206

**UNC**

	Tol. 2B	~DIN 371 ~DIN 376	HSSE (M35)
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Spiral Point



Spiral Flute



TAP DIA	PITCH	SHANK DIA mm	OAL mm	mm	No. FLUTES	SPIRAL POINT	SPIRAL FLUTE
						<b>~DIN 371</b>	<b>~DIN 371</b>
N#4	40	3.5	56	2.7	3	8170-61896	8180-62848
N#5	40	3.5	56	2.7	3	8170-61902	8180-62855
N#6	32	4	56	3	3	8170-61919	8180-62862
N#8	32	4.5	63	3.4	3	8170-61926	8180-62879
N#10	24	6	70	4.9	3	8170-61933	8180-62886
N#12	24	6	80	4.9	3	8170-61940	8180-62893
						<b>~DIN 376</b>	<b>~DIN 376</b>
1/4"	20	4.5	80	3.4	3	8170-57271	8180-59275
5/16"	18	6	90	4.9	3	8170-57301	8180-59305
3/8"	16	7	100	5.5	3	8170-57295	8180-59299
7/16"	14	8	100	6.2	3	8170-57325	8180-59329
1/2"	13	9	110	7	3	8170-57264	8180-59268
9/16"	12	11	110	9	3	8170-57349	8180-59343
5/8"	11	12	110	9	3	8170-57318	8180-59312
3/4"	10	14	125	11	4	8170-57288	8180-59282
7/8"	9	18	140	14.5	4	8170-57332	8180-59336
1"	8	20	160	16	4	8170-57356	8180-59350

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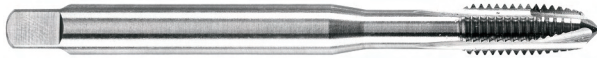
# Machine Taps Standard Applications



**UNF**

	Tol. 2B	~DIN 371 ~DIN 376	HSSE (M35)
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Spiral Point




Spiral Flute



TAP DIA	PITCH	SHANK DIA mm	OAL mm	mm	No. FLUTES	SPIRAL POINT	SPIRAL FLUTE
Nº10	32	6	70	4.9	3	~DIN 371	~DIN 371
Nº12	28	6	80	4.9	3	8190 -61995	8200 -62961
						8190 -62008	8200 -62978
						~DIN 374	~DIN 374
1/4"	28	4.5	80	3.4	3	8190 -57370	8200 -62909
5/16"	24	6	90	4.9	3	8190 -57400	8200 -59411
3/8"	24	7	100	5.5	3	8190 -57394	8200 -59404
7/16"	20	8	100	6.2	3	8190 -57424	8200 -59435
1/2"	20	9	100	7	3	8190 -57363	8200 -59381
9/16"	18	11	100	9	3	8190 -57448	8200 -59459
5/8"	18	12	100	9	3	8190 -57417	8200 -59428
3/4"	16	14	110	11	4	8190 -57387	8200 -59398
7/8"	14	18	125	14.5	4	8190 -57431	8200 -59442
1"	12	18	140	14.5	4	8190 -57455	8200 -59466

**G**

	Class A	DIN 5156	HSSE (M35)
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Spiral Point




Spiral Flute

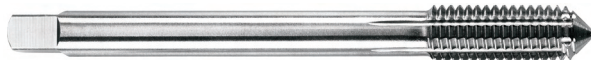


TAP DIA	PITCH	SHANK DIA mm	OAL mm	mm	No. FLUTES	SPIRAL POINT	SPIRAL FLUTE
1/8"	28	7	90	5.5	3	8210 -56250	8220 -58728
1/4"	19	11	100	9	3	8210 -56243	8220 -58711
3/8"	19	12	100	9	3	8210 -56274	8220 -58742
1/2"	14	16	125	12	4	8210 -56236	8220 -58704
5/8"	14	18	125	14.5	4	8210 -56281	8220 -58759
3/4"	14	20	140	16	4	8210 -56267	8220 -58735
7/8"	14	22	150	18	5	8210 -56298	8220 -58766
1"	11	25	160	20	5	8210 -56304	8220 -58773

**Rc**  
(BSPT)


		~DIN 5156	HSSE (M35)
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Straight Flute

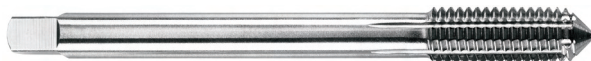


TAP DIA	PITCH	SHANK DIA mm	OAL mm	mm	No. FLUTES	
1/8"	28	7	90	5.5	3	8230 -52078
1/4"	19	11	100	9	4	8230 -52061
3/8"	19	12	100	9	5	8230 -52092
1/2"	14	16	140	12	5	8230 -52054
3/4"	14	20	140	16	5	8230 -52085
1"	11	25	160	20	6	8230 -52122




**NPT**

		~DIN 374	HSSE (M35)
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Straight Flute



TAP DIA	PITCH	SHANK DIA mm	OAL mm	mm	No. FLUTES	
1/8"	27	8	90	6.2	4	8240 -52078
1/4"	18	11	100	9	4	8240 -52061
3/8"	18	14	110	11	5	8240 -52092
1/2"	14	18	140	14.5	5	8240 -52054
3/4"	14	20	140	18	5	8240 -52085
1"	11.5	25	160	22	6	8240 -52122

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