



METRIC
Product no. **23184 & 33184**

ROLL TAP – 6HX & 6GX
TiN coated

23184		6HX		HSSE-V3		DIN 371	
Ø	P	Drill Ø	Overall Length	Thread Length	Shank Ø	Square ■	Price £ each
M1,6	0,35	1,45	40	8	2,5	2,1	20.33
2	0,4	1,8	45	9	2,8	2,1	16.87
2,5	0,45	2,3	50	9	2,8	2,1	16.18
3	0,5	2,8	56	11	3,5	2,7	14.40
3,5	0,6	3,25	56	12	4	3	15.05
4	0,7	3,7	63	13	4,5	3,4	14.72
5	0,8	4,65	70	16	6	4,9	15.25
6	1	5,55	80	17	6	4,9	15.68
8	1,25	7,4	90	20	8	6,2	19.77
10	1,5	9,3	100	22	10	8	24.69

23184		6GX*		HSSE-V3		DIN 371	
Ø	P	Drill Ø	Overall Length	Thread Length	Shank Ø	Square ■	Price £ each
M2	0,4	1,8	45	9	2,8	2,1	17.58
2,5	0,45	2,3	50	9	2,8	2,1	16.64
3	0,5	2,8	56	11	3,5	2,7	14.92
3,5	0,6	3,25	56	12	4	3	15.55
4	0,7	3,7	63	13	4,5	3,4	15.12
5	0,8	4,65	70	16	6	4,9	15.75
6	1	5,55	80	17	6	4,9	16.19
8	1,25	7,4	90	20	8	6,2	20.30
10	1,5	9,3	100	22	10	8	25.47

33184		6HX		HSSE-V3		DIN 376	
Ø	P	Drill Ø	Overall Length	Thread Length	Shank Ø	Square ■	Price £ each
M12	1,75	11,2	110	24	9	7	30.70
16	2	15,1	110	27	12	9	48.64

33184		6GX*		HSSE-V3		DIN 376	
Ø	P	Drill Ø	Overall Length	Thread Length	Shank Ø	Square ■	Price £ each
M12	1,75	11,2	110	24	9	7	31.09
16	2	15,1	110	27	12	9	50.73

For materials with elongation factor >8%

* 6GX (oversize approx 0.03 – 0.04mm)

Material suitability
see p33



Roll Tapping

Hints and tips



Roll forming threads (both internal and external) is a long established method especially in the fastener industry, but curiously under used in general engineering products.

There are many advantages to rolling internal threads and perhaps no disadvantages, so long as the information shown on page 69 is followed.

