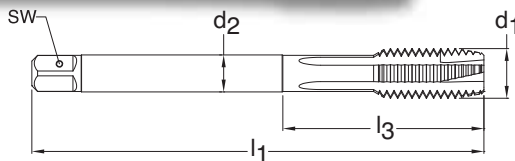


# METRIC



**Series 815**  
**Standard DIN 376**  
**Tool Material HSS-E (Cobalt)**  
**Spiral Point Straight flute**  
**Chamfer Form B • 3.5 - 5**  
**Class of Fit ISO 2(6H)**



**Through holes**



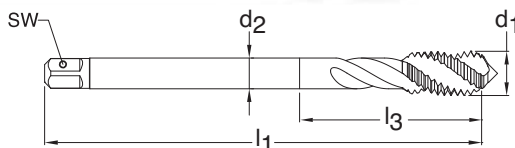
**Bright finish**



**External cooling**

d1 - P	D Limits	Tap Drill Range mm	Number of Flutes	d2 mm	SW mm	l1 mm	l3 mm	Order Code	EDP Number	Stock
M1.6 X 0.35	D2/D3	1.221 - 1.321	2	1.20	N/A	40.00	N/A	1.600	9008150016000	○
M1.8 X 0.35	D2/D3	1.421 - 1.521	2	1.20	N/A	40.00	N/A	1.800	9008150018000	○
M2 X 0.40	D2/D3	1.567 - 1.679	3	1.40	N/A	45.00	N/A	2.000	9008150020000	○
M2.5 X 0.45	D2/D3	2.013 - 2.138	3	1.80	N/A	50.00	N/A	2.500	9008150025000	●
M2.6 X 0.45	D2/D3	2.110 - 2.240	3	1.80	N/A	50.00	N/A	2.600	9008150026000	○
M3 X 0.50	D2/D3	2.459 - 2.599	3	2.20	N/A	56.00	N/A	3.000	9008150030000	●
M3.5 X 0.60	D3/D4	2.850 - 3.010	3	2.50	2.10	56.00	N/A	3.500	9008150035000	●
M4 X 0.70	D3/D4	3.242 - 3.422	3	2.80	2.10	63.00	N/A	4.000	9008150040000	●
M5 X 0.80	D3/D4	4.134 - 4.334	3	3.50	2.70	70.00	N/A	5.000	9008150050000	●
M6 X 1.00	D4/D5	4.917 - 5.153	3	4.50	3.40	80.00	N/A	6.000	9008150060000	●
M7 X 1.00	D4/D5	5.917 - 6.153	3	5.50	4.30	80.00	N/A	7.000	9008150070000	●
M8 X 1.25	D4/D5	6.647 - 6.912	3	6.00	4.90	90.00	N/A	8.000	9008150080000	●
M10 X 1.50	D4/D5	8.376 - 8.676	3	7.00	5.50	100.00	N/A	10.000	9008150100000	●
M12 X 1.75	D5/D6	10.106 - 10.441	3	9.00	7.00	110.00	N/A	12.000	9008150120000	●
M14 X 2.00	D5/D6	11.835 - 12.210	3	11.00	9.00	110.00	N/A	14.000	9008150140000	○
M16 X 2.00	D6/D7	13.835 - 14.210	3	12.00	9.00	110.00	N/A	16.000	9008150160000	○
M18 X 2.50	D6/D7	15.294 - 15.744	4	14.00	11.00	125.00	N/A	18.000	9008150180000	●
M20 X 2.50	D6/D7	17.294 - 17.744	4	16.00	12.00	140.00	N/A	20.000	9008150200000	●
M22 X 2.50	D6/D7	19.294 - 19.744	4	18.00	14.50	140.00	N/A	22.000	9008150220000	●
M24 X 3.00	D7/D8	20.752 - 21.252	4	18.00	14.50	160.00	N/A	24.000	9008150240000	○
M27 X 3.00	D7/D8	23.752 - 24.252	4	20.00	16.00	160.00	N/A	27.000	9008150270000	○
M30 X 3.50	D8/D9	26.211 - 26.771	4	22.00	18.00	180.00	N/A	30.000	9008150300000	○
M36 X 4.00	D8/D9	31.670 - 32.270	5	28.00	22.00	200.00	N/A	36.000	9008150360000	●

# METRIC



**Series 822**  
**Standard DIN 376**  
**Tool Material HSS-E (Cobalt)**  
**Spiral Flute 40° Helix**  
**Chamfer Form C • 2-3**  
**Class of Fit ISO 2(6H)**



**Blind holes**



**Bright finish**



**External cooling**

d1 - P	D Limits	Tap Drill Range mm	Number of Flutes	d2 mm	SW mm	l1 mm	l3 mm	Order Code	EDP Number	Stock
M3 X 0.50	D2/D3	2.459 - 2.599	3	2.20	N/A	56.00	N/A	3.000	9008220030000	○
M3.5 X 0.60	D3/D4	2.850 - 3.010	3	2.50	2.10	56.00	N/A	3.500	9008220035000	○
M4 X 0.70	D3/D4	3.242 - 3.422	3	2.80	2.10	63.00	N/A	4.000	9008220040000	●
M5 X 0.80	D3/D4	4.134 - 4.334	3	3.50	2.70	70.00	N/A	5.000	9008220050000	●
M6 X 1.00	D4/D5	4.917 - 5.153	3	4.50	3.40	80.00	N/A	6.000	9008220060000	○
M7 X 1.00	D4/D5	5.917 - 6.153	3	5.50	4.30	80.00	N/A	7.000	9008220070000	●
M8 X 1.25	D4/D5	6.647 - 6.912	3	6.00	4.90	90.00	N/A	8.000	9008220080000	●
M10 X 1.50	D4/D5	8.376 - 8.676	3	7.00	5.50	100.00	N/A	10.000	9008220100000	●
M12 X 1.75	D5/D6	10.106 - 10.441	3	9.00	7.00	110.00	N/A	12.000	9008220120000	○
M14 X 2.00	D5/D6	11.835 - 12.210	3	11.00	9.00	110.00	N/A	14.000	9008220140000	●
M16 X 2.00	D6/D7	13.835 - 14.210	3	12.00	9.00	110.00	N/A	16.000	9008220160000	●
M18 X 2.50	D6/D7	15.294 - 15.744	4	14.00	11.00	125.00	N/A	18.000	9008220180000	●
M20 X 2.50	D6/D7	17.294 - 17.744	4	16.00	12.00	140.00	N/A	20.000	9008220200000	○
M22 X 2.50	D6/D7	19.294 - 19.744	4	18.00	14.50	140.00	N/A	22.000	9008220220000	●
M24 X 3.00	D7/D8	20.752 - 21.252	4	18.00	14.50	160.00	N/A	24.000	9008220240000	○
M27 X 3.00	D7/D8	23.752 - 24.252	4	20.00	16.00	160.00	N/A	27.000	9008220270000	○
M30 X 3.50	D8/D9	26.211 - 26.771	4	22.00	18.00	180.00	N/A	30.000	9008220300000	○

"Tap drill Range" given is per the Class of Fit shown per Series #  
 Additional Tap Drill sizes & percent of thread engagement can be found on pages 199 - 206.