



Since 1993

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HOUSE OF QUALITY FASTENERS

# J.C. GUPTA & SONS

7/A, Sadar Patrappe Road,  
Bangalore - 560002

**BAER UNiform Machine Forming Taps**

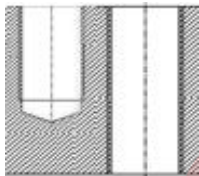
Catalogue Data Sheet L2F13



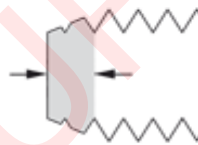
Machine Forming Taps specially designed for forming threads in blind and through holes. The Forming Tap has improved geometry for an optimal processing of a big range of materials. The lubrication grooves provide the necessary lubrication to depths of 2.5 D.

These taps have the following advantages:

- No chips
- Up to 20 times longer lifetime (compared to taps)
- Wide range of materials can be processed
- Intersection of the thread is impossible
- No pitch or flank angle errors
- Very high trueness
- Increased strength of the thread through material deformation and uninterrupted grain flow
- Higher surface quality
- Much higher cutting speed



through holes  
& blind holes  
up to 2.5 x D



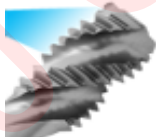
lead-in chamfer:  
2-3 threads



material:  
HSE TIN



Threading  
with no chips



outside cooling  
and lubrication

## TOL



ISO2/6HX

## N/mm<sup>2</sup> HRC

to 850 N/mm<sup>2</sup>  
25.5 HRC



with oil grooves



Since 1993

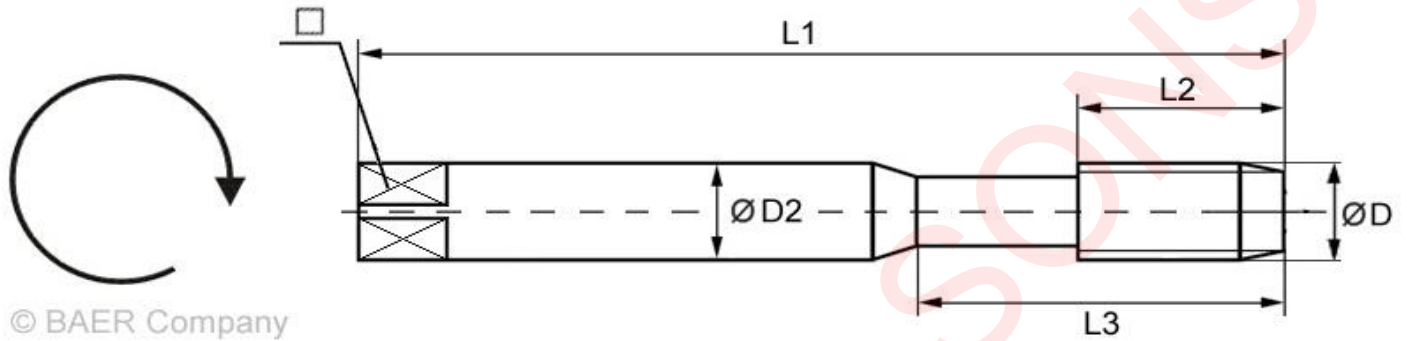
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# HOUSE OF QUALITY FASTENERS J.C. GUPTA & SONS

BAER UNiform Machine Forming Taps

Catalogue Data Sheet L2F13



Size	D1	D2	L1	L2	Square	Drill Dia	JC part number	Baer part number
<b>M 2 x 0.4</b>	<b>2,00</b>	<b>2,8</b>	<b>45.00</b>	<b>8.00</b>	<b>2,1</b>	<b>1,85</b>	<b>L2F1302000</b>	<b>34TD70313601</b>
M 2.2 x 0.45	2,20	2,8	45.00	8.00	2,1	2,03	L2F1302020	34TD70315601
<b>M 2.3 x 0.4</b>	<b>2,30</b>	<b>2,8</b>	<b>45.00</b>	<b>8.00</b>	<b>2,1</b>	<b>2,15</b>	<b>L2F1302030</b>	<b>34TD70319601</b>
M 2.5 x 0.45	2,50	2,8	50.00	9.00	2,1	2,33	L2F1302050	34TD70317601
<b>M 2.6 x 0.45</b>	<b>2,60</b>	<b>2,8</b>	<b>50.00</b>	<b>9.00</b>	<b>2,1</b>	<b>2,43</b>	<b>L2F1302060</b>	<b>34TD70349601</b>
M 3 x 0.5	3,00	3,5	56.00	11.00	2,7	2,80	L2F1303000	34TD70320601
<b>M 3.5 x 0.6</b>	<b>3,50</b>	<b>4,0</b>	<b>56.00</b>	<b>13.00</b>	<b>3,0</b>	<b>3,25</b>	<b>L2F1303050</b>	<b>34TD70322601</b>
M 4 x 0.7	4,00	4,5	63.00	13.00	3,4	3,70	L2F1304000	34TD70324601
<b>M 4.5 x 0.75</b>	<b>4,50</b>	<b>6,0</b>	<b>70.00</b>	<b>14.00</b>	<b>4,9</b>	<b>4,20</b>	<b>L2F1304050</b>	<b>34TD70326601</b>
M 5 x 0.8	5,00	6,0	70.00	16.00	4,9	4,65	L2F1305000	34TD70328601
<b>M 6 x 1.0</b>	<b>6,00</b>	<b>6,0</b>	<b>80.00</b>	<b>19.00</b>	<b>4,9</b>	<b>5,10</b>	<b>L2F1306000</b>	<b>34TD70331601</b>
M 8 x 1.25	8,00	8,0	90.00	22.00	6,2	7,45	L2F1308000	34TD70336601
<b>M 10 x 1.5</b>	<b>10,00</b>	<b>10,0</b>	<b>100.00</b>	<b>24.00</b>	<b>8,0</b>	<b>9,35</b>	<b>L2F1310000</b>	<b>34TD70342601</b>
M 12 x 1.75	12,00	9,0	110.00	29.00	7,0	11,25	L2F1312000	34TD70350601
<b>M 14 x 2.0</b>	<b>14,00</b>	<b>11,0</b>	<b>110.00</b>	<b>30.00</b>	<b>9,0</b>	<b>13,10</b>	<b>L2F1314000</b>	<b>34TD70354601</b>
M 16 x 2.0	16,00	12,0	110.00	32.00	9,0	15,10	L2F1316000	34TD70360601
<b>M 18 x 2.5</b>	<b>18,00</b>	<b>14,0</b>	<b>125.00</b>	<b>34.00</b>	<b>11,0</b>	<b>16,85</b>	<b>L2F1318000</b>	<b>34TD70365601</b>
M 20 x 2.5	20,00	16,0	140.00	34.00	12,0	18,85	L2F1320000	34TD70370601

Sizes in BLUE are non-preferred. Availability is limited and MOQ is higher.

Data is strictly informative