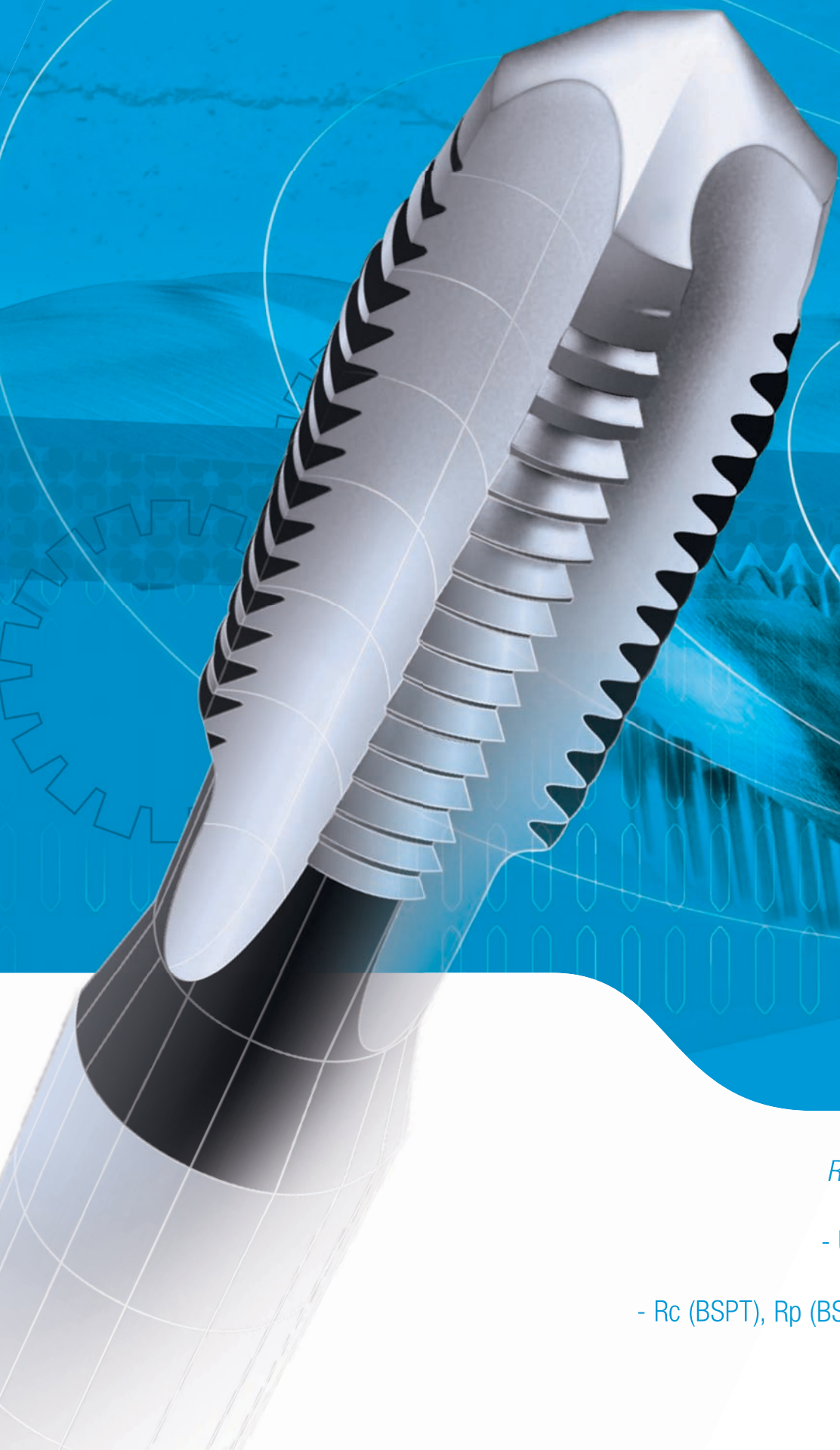


# TAPS



## **Taps** - ISO

*Reliable, precision threading*

- M, MF
- UNC, UNF, UNEF, UN, UNS
- BSW, BSF, BA, BSB
- Rc (BSPT), Rp (BSPPL), Pg Series, G (BSPF)
- NPT, NPTF, NPSF

# special taps express delivery service...

# SUPA FAST



Sutton Tools has a dedicated production facility for express delivery service on special taps.

With our state of the art CNC grinding equipment almost any profile can be achieved.

- Straight Flute Taps M1 to M127
- Spiral & Gun Taps M1 to M52

All Thread Forms:

Metric, MJ, UN, UNJC, UNJF, Pg, Whit, Rope forms & Acme and more!!

Surface Finishes and Treatments:

- All latest PVD coatings available

Contact our sales team for more information.

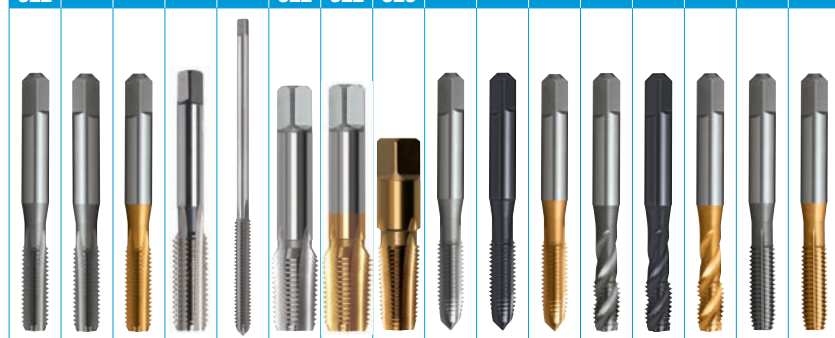


[www.suttontools.com.au/Solutions\\_SpecialTools](http://www.suttontools.com.au/Solutions_SpecialTools)



Page	M	288	290	289	290						291	291	291	292	292	292	293	293
	MF	294		295							296	296	296	297		297		
	UNC	298	300	299		304					301	301	301	302	302	302	303	303
	UNF	305	307	306							309	309	309	310		310	311	
	BSW	312	314	313		318					315	315	315	316	316	316	317	317
	BSF, BA, BSB (Brass)	319																
	G (BSPF)	320		321							320			320				
	Rc (BSPT), Rp (BSPPL), Pg, NPT, NPTF, NPSF	322				322	322	323										

Tap Straight Flute, N  
 Tap Straight Flute, N, Left Hand  
 Tap Straight Flute, N  
 Tap Straight Flute, Oversize  
 Tap Machine Nut, Long Shank  
 Tap Straight Flute, Pipe  
 Tap Straight Flute, Pipe  
 Tap Straight Flute, Pipe, NPT  
 Tap Gun, N  
 Tap Gun, N  
 Tap Gun, N  
 Tap Spiral Flute, N  
 Tap Spiral Flute, N  
 Tap Spiral Flute, N  
 Tap Forming, Single Coaxial Groove  
 Tap Forming, Single Coaxial Groove



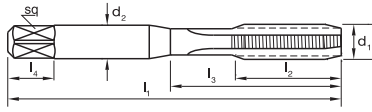
Material	HSS		HSS		HSS		HSS		HSS		HSSE V3			HSSE V3			HSSE V3	
Surface Finish	Brt	TiN	Brt	Brt	Brt	TiN	Colour Temp	Brt	Blu	TiN	Brt	Blu	TiN	Brt	Blu	TiN	Brt	TiN
Colour Ring & Application	N		Machine Nut		N			N			N			N		N		
Tapping Depth	≤ 1xØ		≤ 2xØ		-			≤ 3xØ			≤ 2.5xØ			≤ 1.5xØ				
Material Limit & Nut Tolerance	ISO 2 / 6H		2B		Z3		-	ISO 2 / 6H			ISO 2 / 6H			ISO 2 / 6H				

Material	HB	N/mm <sup>2</sup>	% Elong.															
<b>1.0 Steels</b>																		
1.1 Mild steels, magnetic soft steel	<200	>200 <400	10	●	●	●	●	●	●	●	●	●	●	●	●	●	○	●
1.2 Free cutting, structural, unalloyed	<200	>350 <700	30	●	●	●	●	●	●	●	●	●	●	●	●	●	○	●
1.3 Plain carbon, low allowed	<300	>350 <850	20	●	●	●	●	●	●	●	○	●	○	●	●			○
1.4 Alloy steels harden. / tempered	<250	>500 <850	30	○	○	○	○	○	○	○	○	○	○	○	○	○	○	
1.5 Alloy steels harden. / tempered	<350	>850 <1200	30			○							○				○	
1.6 Hardened, heat treated, high tensile alloy	<420	>1500	12										○				○	
1.7 Hardened Steel 45-50 Rc	<550		<12															
1.8 Hardened Steel 50-62 Rc	<700		<12															
<b>2.0 Stainless Steels</b>																		
2.1 Free machining	<250	<850	25			○		○	○	○	○	○	○	○	○	○		○
2.2 Austenitic	<250	<850	20			○		○	○	○	○	○	○	○	○	○		○
2.3 Ferritic + martensitic	<250	<850	20			○					○	○	○	○	○			
<b>3.0 Cast Irons</b>																		
3.1 Lamellar graphite (Grey soft)	<150	<500	10	○	○	○	○	○	○	○	○	○	○	○	○	○		
3.2 Lamellar graphite (Grey hard)	<300	<1000	10								○	○	○	○	○			
3.3 Nodular (spheroidal) graphite & malleable	<200	<700	10										○				○	
<b>4.0 Titaniums</b>																		
4.1 Pure Titanium	<250	<850	20															
4.2 Titanium alloys	>250	>850	20															
<b>5.0 Nickels</b>																		
5.1 Nickel alloys	<250	<850	25															
5.2 Nickel alloys	>250	>850	25															
<b>6.0 Coppers</b>																		
6.1 Pure Copper (electrolytic copper)	<120	<400	12	○	○	○	○	○	○	○			○				○	○
6.2 Short chip Brass, Phosphor Bronze, gun metal	<200	<700	12							○	○	○	○	○	○		○	
6.3 Long chip Brass, Bronze	<200	<700	12	○	○	○	○	○	○	○	●	○	●				●	●
<b>7.0 Aluminiums</b>																		
7.1 Aluminium unalloyed	<100	<350	15	○	○	○	○	○	○	○			○	○	○	○	○	○
7.2 Magnesium unalloyed	<150	<350	15	○	○	○	○	○	○	○			○	○	○	○	○	○
7.3 Al Alloyed Si < 1.5 %	<120	<500	15	○	○	○	○	○	○	○			○	○	○	○	○	○
7.4 Al Alloyed 1.5 % < Si < 10%	<120	<400	10	○	○	○	○	○	○	○			○	○	○	○	○	○
7.5 Al Alloyed > 10% Si	-	<400	N										○				○	
7.6 Magnesium alloys	-	<400	N															
<b>8.0 Plastics</b>																		
8.1 Plastics, Thermoplastics, Polyethylene	<340	<50	N	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

# Taps Metric, Straight Flute, N



- General purpose use
- Suitable for materials up to 1000N/mm<sup>2</sup>
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d<sub>1</sub>



Catalogue Code											T384	T385	T386	T901
Discount Group											D0702	D0702	D0702	D0702
Material											HSS	HSS	HSS	HSS
Surface Finish											<i>Brt</i>	<i>Brt</i>	<i>Brt</i>	<i>Brt</i>
Colour Ring & Application											N	N	N	N
Geometry											-	-	-	-
Chamfer											Taper	Intermediate	Bottoming	Set
Limit & Nut Tolerance											ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H
d <sub>1</sub>	Pitch	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>4</sub>	z	drill Ø	Item #	Item #	Item #	Item #	
M 2	x 0.40	41	8	-	2.50	2.00	4	3	1.6	T384 0200	T385 0200	T386 0200	T901 0200	
M 2.5	x 0.45	45	10	-	2.80	2.24	5	3	2.05	T384 0250	T385 0250	T386 0250	T901 0250	
M 3	x 0.50	48	15	15	3.15	2.50	5	3	2.5	T384 0300	T385 0300	T386 0300	T901 0300	
M 3.5	x 0.60	50	17	17.5	3.55	2.80	5	3	2.9	T384 0350	T385 0350	T386 0350	T901 0350	
M 4	x 0.70	53	17	18	4.00	3.15	6	3	3.3	T384 0400	T385 0400	T386 0400	T901 0400	
M 4.5	x 0.75	53	13	19	4.50	3.55	6	3	3.7	T384 0450	T385 0450	T386 0450	T901 0450	
M 5	x 0.80	58	16	22	5.00	4.00	7	3	4.2	T384 0500	T385 0500	T386 0500	T901 0500	
M 6	x 1.00	66	19	26	6.30	5.00	8	3	5.0	T384 0600	T385 0600	T386 0600	T901 0600	
M 7	x 1.00	66	19	26	7.10	5.60	8	4	6.0	T384 0700	T385 0700	T386 0700	T901 0700	
M 8	x 1.25	72	22	30	8.00	6.30	9	4	6.8	T384 0800	T385 0800	T386 0800	T901 0800	
M 9	x 1.25	72	22	31	9.00	7.10	10	4	7.8	T384 0900	T385 0900	T386 0900	T901 0900	
M 10	x 1.50	80	24	34	10.00	8.00	11	4	8.5	T384 1000	T385 1000	T386 1000	T901 1000	
M 11	x 1.50	85	25	-	8.00	6.30	9	4	9.5	T384 1100	T385 1100	T386 1100	T901 1100	
M 12	x 1.75	89	29	-	9.00	7.10	10	4	10.2	T384 1200	T385 1200	T386 1200	T901 1200	
M 14	x 2.00	95	30	-	11.20	9.00	12	4	12.0	T384 1400	T385 1400	T386 1400	T901 1400	
M 16	x 2.00	102	32	-	12.50	10.00	13	4	14.0	T384 1600	T385 1600	T386 1600	T901 1600	
M 18	x 2.50	112	37	-	14.00	11.20	14	4	15.5	T384 1800	T385 1800	T386 1800	T901 1800	
M 20	x 2.50	112	37	-	14.00	11.20	14	4	17.5	T384 2000	T385 2000	T386 2000	T901 2000	
M 22	x 2.50	118	38	-	16.00	12.50	16	4	19.5	T384 2200	T385 2200	T386 2200	T901 2200	
M 24	x 3.00	130	45	-	18.00	14.00	18	4	21.0	T384 2400	T385 2400	T386 2400	T901 2400	
M 27	x 3.00	135	45	-	20.00	16.00	20	4	24.0	T384 2700	T385 2700	T386 2700	•	
M 30	x 3.50	138	48	-	20.00	16.00	20	4	26.5	T384 3000	T385 3000	T386 3000	•	
M 33	x 3.50	151	51	-	22.40	18.00	22	4	29.5	T384 3300	T385 3300	T386 3300	•	
M 36	x 4.00	162	57	-	25.00	20.00	24	4	32.0	T384 3600	T385 3600	T386 3600	•	
M 39	x 4.00	170	60	-	28.00	22.40	26	4	35.0	T384 3900	T385 3900	T386 3900	•	
M 42	x 4.50	170	60	-	28.00	22.40	26	4	37.5	T384 4200	T385 4200	T386 4200	•	
M 45	x 4.50	187	67	-	31.50	25.00	28	4	40.5	T384 4500	T385 4500	T386 4500	•	
M 48	x 5.00	187	67	-	31.50	25.00	28	4	43.0	T384 4800	T385 4800	T386 4800	•	
M 52	x 5.00	200	70	-	35.50	28.00	31	4	47.0	T384 5200	T385 5200	T386 5200	•	

## SD&T1 Tap & Drill Set

- M 3 x 0.50 with 2.5mm tapping drill
- M 4 x 0.70 with 3.3mm tapping drill
- M 5 x 0.80 with 4.2mm tapping drill
- M 6 x 1.00 with 5.0mm tapping drill
- M 8 x 1.25 with 6.8mm tapping drill
- M 10 x 1.50 with 8.5mm tapping drill
- M 12 x 1.75 with 10.2mm tapping drill



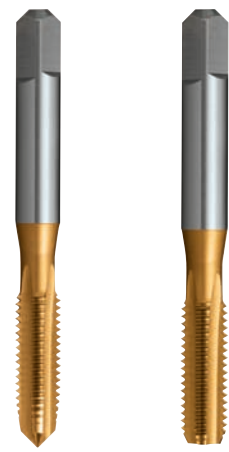
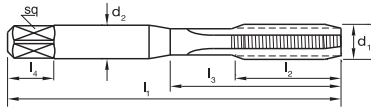
T901 SDT1

• Available on request as special manufacture. Subject to lead time.

# Taps Metric, Straight Flute, N



- General purpose use
- Suitable for materials up to 1000N/mm<sup>2</sup>
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d<sub>1</sub>



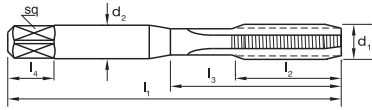
Catalogue Code											T387	T388
Discount Group											D0706	D0706
Material											HSS	HSS
Surface Finish											TIN	TIN
Colour Ring & Application											N	N
Geometry											-	-
Chamfer											Intermediate	Bottoming
Limit & Nut Tolerance											ISO 2 / 6H	ISO 2 / 6H
d <sub>1</sub>	Pitch	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>1</sub>	z	drill Ø		Item #	Item #
M 2	x 0.40	41	8	-	2.50	2.00	4	3	1.6		T387 0200	T388 0200
M 2.5	x 0.45	45	10	-	2.80	2.24	5	3	2.05	•	•	
M 3	x 0.50	48	15	-	3.15	2.50	5	3	2.5		T387 0300	T388 0300
M 3.5	x 0.60	50	17	-	3.55	2.80	5	3	2.9		T387 0350	T388 0350
M 4	x 0.70	53	17	-	4.00	3.15	6	3	3.3		T387 0400	T388 0400
M 4.5	x 0.75	53	13	19	4.50	3.55	6	3	3.7	•	•	
M 5	x 0.80	58	16	22	5.00	4.00	7	3	4.2		T387 0500	T388 0500
M 6	x 1.00	66	19	26	6.30	5.00	8	3	5.0		T387 0600	T388 0600
M 7	x 1.00	66	19	26	7.10	5.60	8	4	6.0	•	•	T388 0700
M 8	x 1.25	72	22	30	8.00	6.30	9	4	6.8		T387 0800	T388 0800
M 9	x 1.25	72	22	31	9.00	7.10	10	4	7.8	•	•	
M 10	x 1.50	80	24	34	10.00	8.00	11	4	8.5		T387 1000	T388 1000
M 11	x 1.50	85	25	-	8.00	6.30	9	4	9.5	•	•	
M 12	x 1.75	89	29	-	9.00	7.10	10	4	10.2		T387 1200	T388 1200
M 14	x 2.00	95	30	-	11.20	9.00	12	4	12.0		T387 1400	T388 1400
M 16	x 2.00	102	32	-	12.50	10.00	13	4	14.0		T387 1600	T388 1600
M 18	x 2.50	112	37	-	14.00	11.20	14	4	15.5		T387 1800	T388 1800
M 20	x 2.50	112	37	-	14.00	11.20	14	4	17.5		T387 2000	T388 2000
M 22	x 2.50	118	38	-	16.00	12.50	16	4	19.5	•	•	
M 24	x 3.00	130	45	-	18.00	14.00	18	4	21.0	•	•	
M 27	x 3.00	135	45	-	20.00	16.00	20	4	24.0	•	•	
M 30	x 3.50	138	48	-	20.00	16.00	20	4	26.5	•	•	
M 33	x 3.50	151	51	-	22.40	18.00	22	4	29.5	•	•	
M 36	x 4.00	162	57	-	25.00	20.00	24	4	32.0	•	•	
M 39	x 4.00	170	60	-	28.00	22.40	26	4	35.0	•	•	
M 42	x 4.50	170	60	-	28.00	22.40	26	4	37.5	•	•	
M 45	x 4.50	187	67	-	31.50	25.00	28	4	40.5	•	•	
M 48	x 5.00	187	67	-	31.50	25.00	28	4	43.0	•	•	
M 52	x 5.00	200	70	-	35.50	28.00	31	4	47.0	•	•	

• Available on request as special manufacture. Subject to lead time.

## Taps Metric, Straight Flute, N, Left Hand



- General purpose use
- Suitable for materials up to 1000N/mm<sup>2</sup>
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d<sub>1</sub>

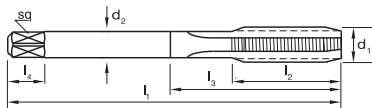


Catalogue Code	<b>T389</b>	<b>T390</b>	<b>T391</b>									
Discount Group	D0702	D0702	D0702									
Material	<b>HSS</b>	<b>HSS</b>	<b>HSS</b>									
Surface Finish	<b>Brt</b>	<b>Brt</b>	<b>Brt</b>									
Colour Ring & Application	<b>N</b>	<b>N</b>	<b>N</b>									
Geometry	Left Hand	Left Hand	Left Hand									
Chamfer	<b>Taper</b>	<b>Intermediate</b>	<b>Bottoming</b>									
Limit & Nut Tolerance	ISO 2 / 6H LH	ISO 2 / 6H LH	ISO 2 / 6H LH									
d <sub>1</sub>	Pitch	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>4</sub>	z	drill Ø	Item #	Item #	Item #
M 3	x 0.50	48	15	15	3.15	2.50	5	3	2.5	T389 0300	T390 0300	T391 0300
M 4	x 0.70	53	17	18	4.00	3.15	6	3	3.3	T389 0400	T390 0400	T391 0400
M 5	x 0.80	58	16	22	5.00	4.00	7	3	4.2	T389 0500	T390 0500	T391 0500
M 6	x 1.00	66	19	26	6.30	5.00	8	3	5.0	T389 0600	T390 0600	T391 0600
M 8	x 1.25	72	22	30	8.00	6.30	9	4	6.8	T389 0800	T390 0800	T391 0800
M 10	x 1.50	80	24	34	10.00	8.00	11	4	8.5	T389 1000	T390 1000	T391 1000
M 12	x 1.75	89	29	-	9.00	7.10	10	4	10.2	T389 1200	T390 1200	T391 1200
M 14*	x 2.00	95	30	-	11.20	9.00	12	4	12.0	T389 1400	T390 1400	T391 1400
M 16*	x 2.00	102	32	-	12.50	10.00	13	4	14.0	T389 1600	T390 1600	T391 1600
M 18*	x 2.50	112	37	-	14.00	11.20	14	4	15.5	T389 1800	T390 1800	T391 1800
M 20*	x 2.50	112	37	-	14.00	11.20	14	4	17.5	T389 2000	T390 2000	T391 2000

## Taps Metric, Straight Flute, Oversize



- Oversize allowance to suit components for galvanize plating
- General purpose use, materials up to 1000N/mm<sup>2</sup>
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx 1 x d<sub>1</sub>
- Taper and inter leads available on request



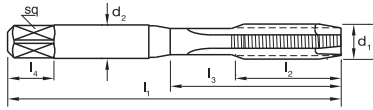
d <sub>1</sub>	Pitch	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>4</sub>	z	drill Ø	Item #
M 10 +0.4	x 1.5	85	25	-	8.0	6.3	9.0	4	8.9	<b>T392</b> T392 1000
M 12 +0.4	x 1.75	89	29	-	9.0	7.1	10.0	4	10.6	T392 1200
M 16 +0.4	x 2.0	112	37	-	12.5	10.0	13.0	4	14.4	T392 1600
M 20 +0.4	x 2.5	118	38	-	16.0	12.5	16.0	4	17.9	T392 2000
M 24 +0.45	x 3.0	130	45	-	18.0	14.0	18.0	4	21.5	T392 2400

\* Available on request as special manufacture. Subject to lead time.

# Taps Metric, Gun, N



- General purpose use
- Suitable for materials up to 1000N/mm<sup>2</sup>
- Through holes
- Depths up to approx. 3 x d<sub>1</sub>



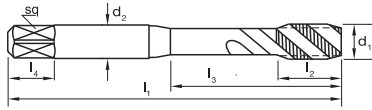
Catalogue Code											T393	T394	T395
Discount Group											D0702	D0702	D0706
Material											HSSE V3	HSSE V3	HSSE V3
Surface Finish											<b>Br</b>	<b>Blu</b>	<b>TIN</b>
Colour Ring & Application											N	N	N
Geometry											-	-	-
Chamfer											Intermediate	Intermediate	Intermediate
Limit & Nut Tolerance											ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H
d <sub>1</sub>	Pitch	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>4</sub>	z	drill Ø		Item #	Item #	Item #
M 2.5	x 0.45	45	10	-	2.80	2.24	5	3	2.05		•	T394 0250	•
M 3	x 0.50	48	15	15	3.15	2.50	5	3	2.5	T393 0300	T394 0300	T395 0300	
M 3.5	x 0.60	50	17	17.5	3.55	2.80	5	3	2.9	T393 0350	T394 0350	•	
M 4	x 0.70	53	17	18	4.00	3.15	6	3	3.3	T393 0400	T394 0400	T395 0400	
M 5	x 0.80	58	16	22	5.00	4.00	7	3	4.2	T393 0500	T394 0500	T395 0500	
M 6	x 1.00	66	19	26	6.30	5.00	8	3	5.0	T393 0600	T394 0600	T395 0600	
M 8	x 1.25	72	22	30	8.00	6.30	9	3	6.8	T393 0800	T394 0800	T395 0800	
M 10	x 1.50	80	24	34	10.00	8.00	11	3	8.5	T393 1000	T394 1000	T395 1000	
M 12	x 1.75	89	29	-	9.00	7.10	10	3	10.2	T393 1200	T394 1200	T395 1200	
M 14	x 2.00	95	30	-	11.20	9.00	12	3	12.0	T393 1400	T394 1400	•	
M 16	x 2.00	102	32	-	12.50	10.00	13	3	14.0	T393 1600	T394 1600	T395 1600	
M 18	x 2.50	112	37	-	14.00	11.20	14	4	15.5	T393 1800	T394 1800	T395 1800	
M 20	x 2.50	112	37	-	14.00	11.20	14	4	17.5	T393 2000	T394 2000	T395 2000	
M 22*	x 2.50	118	38	-	16.00	12.50	16	4	19.5	•	T394 2200	•	
M 24*	x 3.00	130	45	-	18.00	14.00	18	4	21.0	•	T394 2400	•	
M 30*	x 3.50	138	48	-	20.00	16.00	20	4	26.5	•	T394 3000	•	

\*HSS >20mm • Available on request as special manufacture. Subject to lead time.

# Taps Metric, Spiral Flute, N



- General purpose use
- Suitable for materials up to 1000N/mm<sup>2</sup>
- Blind holes
- Depths up to approx. 2.5 x d<sub>1</sub>



Catalogue Code											<b>T397</b>	<b>T396</b>	<b>T398</b>
Discount Group											D0702	D0702	D0706
Material											<b>HSSE V3</b>	<b>HSSE V3</b>	<b>HSSE V3</b>
Surface Finish											<b>Brt</b>	<b>Blu</b>	<b>TiN</b>
Colour Ring & Application											<b>N</b>	<b>N</b>	<b>N</b>
Geometry											-	-	-
Chamfer											<b>Bottoming</b>	<b>Bottoming</b>	<b>Bottoming</b>
Limit & Nut Tolerance											ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H
d <sub>1</sub>	Pitch	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>4</sub>	z	drill Ø		Item #	Item #	Item #
M 2.5	x 0.45	45	5	-	2.80	2.24	5	2	2.05		T397 0250	•	•
M 3	x 0.50	48	6	15	3.15	2.50	5	3	2.5		T397 0300	T396 0300	T398 0300
M 3.5	x 0.60	50	6	17.5	3.55	2.80	5	3	2.9		T397 0350	T396 0350	•
M 4	x 0.70	53	7	18	4.00	3.15	6	3	3.3		T397 0400	T396 0400	T398 0400
M 5	x 0.80	58	8	22	5.00	4.00	7	3	4.2		T397 0500	T396 0500	T398 0500
M 6	x 1.00	66	10	26	6.30	5.00	8	3	5.0		T397 0600	T396 0600	T398 0600
M 8	x 1.25	72	13	30	8.00	6.30	9	3	6.8		T397 0800	T396 0800	T398 0800
M 10	x 1.50	80	15	34	10.00	8.00	11	3	8.5		T397 1000	T396 1000	T398 1000
M 12	x 1.75	89	18	-	9.00	7.10	10	3	10.2		T397 1200	T396 1200	T398 1200
M 14	x 2.00	95	20	-	11.20	9.00	12	3	12.0		T397 1400	T396 1400	•
M 16	x 2.00	102	20	-	12.50	10.00	13	3	14.0		T397 1600	T396 1600	T398 1600
M 18	x 2.50	112	25	-	14.00	11.20	14	4	15.5		T397 1800	T396 1800	T398 1800
M 20	x 2.50	112	25	-	14.00	11.20	14	4	17.5		T397 2000	T396 2000	T398 2000
M 22*	x 2.50	118	38	-	16.00	12.50	16	4	19.5		T397 2200	•	•
M 24*	x 3.00	130	45	-	18.00	14.00	18	4	21.0		T397 2400	•	•
M 30*	x 3.50	138	48	-	20.00	16.00	20	4	26.5		T397 3000	•	•

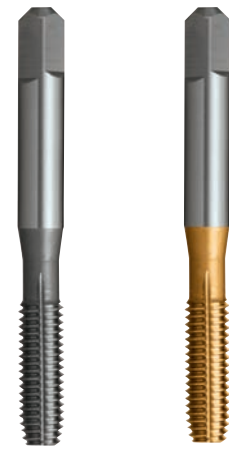
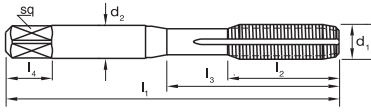
\*HSS >20mm • Available on request as special manufacture. Subject to lead time.



# Taps Metric, Forming, Single Coolant Groove



- For cold forming of threads in materials with good flow characteristics
- Through or Blind holes
- Depths up to approx. 1.5 x d<sub>1</sub>
- TiN for longer tool life



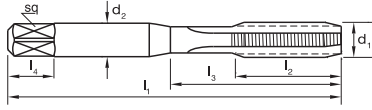
Catalogue Code											<b>T399</b>	<b>T400</b>
Discount Group											D0702	D0706
Material											<b>HSSE V3</b>	<b>HSSE V3</b>
Surface Finish											<b>Brt</b>	<b>TiN</b>
Colour Ring & Application											<b>N</b>	<b>N</b>
Geometry											Single Coolant Groove ≥ M3	Single Coolant Groove ≥ M3
Chamfer											Short	Short
Limit & Nut Tolerance											GH4 / 6H	GH4 / 6H
d <sub>1</sub>	Pitch	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>4</sub>	z	drill Ø		Item #	Item #
M 2.5	x 0.45	45	10	-	2.80	2.24	5	-	2.3		T399 0250	•
M 3	x 0.5	48	15	15	3.15	2.50	5	-	2.8		T399 0300	T400 0300
M 3.5	x 0.6	50	17	17.5	3.55	2.80	5	-	3.2		T399 0350	•
M 4	x 0.7	53	17	18	4.00	3.15	6	-	3.7		T399 0400	T400 0400
M 5	x 0.8	58	16	22	5.00	4.00	7	-	4.6		T399 0500	T400 0500
M 6	x 1.0	66	19	26	6.30	5.00	8	-	5.5		T399 0600	T400 0600
M 8	x 1.25	72	22	30	8.00	6.30	9	-	7.4		T399 0800	•
M 10	x 1.5	80	24	34	10.00	8.00	11	-	9.3		T399 1000	•
M 12	x 1.75	89	29	-	9.00	7.10	10	-	11.2		T399 1200	•
<b>Metric Fine</b>											<b>T637</b>	
M 10	x 1.0	80	24	34	10.00	8.00	11	-	9.5		T637 1005	•
M 12	x 1.25	89	29	-	9.00	7.00	10	-	11.4		T637 1206	•

• Available on request as special manufacture. Subject to lead time.

# Taps Metric Fine, Straight Flute, N



- General purpose use
- Suitable for materials up to 1000N/mm<sup>2</sup>
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d<sub>1</sub>



Catalogue Code											<b>T401</b>	<b>T402</b>	<b>T403</b>	<b>T902</b>
Discount Group											D0702	D0702	D0702	D0702
Material											<b>HSS</b>	<b>HSS</b>	<b>HSS</b>	<b>HSS</b>
Surface Finish											<b>Brt</b>	<b>Brt</b>	<b>Brt</b>	<b>Brt</b>
Colour Ring & Application											<b>N</b>	<b>N</b>	<b>N</b>	<b>N</b>
Geometry											-	-	-	-
Chamfer											<b>Taper</b>	<b>Intermediate</b>	<b>Bottoming</b>	<b>Set</b>
Limit & Nut Tolerance											ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H
d <sub>1</sub>	Pitch	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>4</sub>	z	drill Ø		Item #	Item #	Item #	Item #
M 5	x 0.50	58	16	22	5.0	4.0	7	4	4.5		•	•	T403 0503	•
M 6	x 0.75	66	19	26	6.3	5.0	8	4	5.3		•	•	T403 0604	•
M 8	x 1.0*	72	22	30	8.0	6.3	9	4	7.0		T401 0805	T402 0805	T403 0805	T902 0805
M 8	x 0.75	72	22	30	8.0	6.3	9	4	7.3		•	•	T403 0804	•
M 10	x 1.25*	80	24	34	10.0	8.0	11	4	8.8		T401 1006	T402 1006	T403 1006	T902 1006
M 10	x 1.00	80	24	34	10.0	8.0	11	4	9.0		T401 1005	T402 1005	T403 1005	T902 1005
M 10	x 0.75	80	24	34	10.0	8.0	11	4	9.3		•	•	T403 1004	•
M 12	x 1.5*	89	29	-	9.0	7.1	10	4	10.5		T401 1207	T402 1207	T403 1207	T902 1207
M 12	x 1.25	89	29	-	9.0	7.1	10	4	10.8		T401 1206	T402 1206	T403 1206	T902 1206
M 12	x 1.00	89	29	-	9.0	7.1	10	4	11.0		T401 1205	T402 1205	T403 1205	•
M 14	x 1.5*	95	30	-	11.2	9.0	12	4	12.5		T401 1407	T402 1407	T403 1407	T902 1407
M 14	x 1.00	95	30	-	11.2	9.0	12	4	13.0		•	•	T403 1405	•
M 16	x 1.5*	102	32	-	12.5	10.0	13	4	14.5		T401 1607	T402 1607	T403 1607	T902 1607
M 16	x 1.25	102	32	-	12.5	10.0	13	4	14.8		•	•	T403 1606	•
M 16	x 1.00	102	32	-	12.5	10.0	13	4	15.0		•	•	T403 1605	•
M 18	x 1.5*	112	37	-	14.0	11.2	14	4	16.5		T401 1807	T402 1807	T403 1807	T902 1807
M 18	x 1.25	112	37	-	14.0	11.2	14	4	16.8		•	•	T403 1806	•
M 20	x 2.0*	112	37	-	14.0	11.2	14	4	18.0		•	•	T403 2008	•
M 20	x 1.5**	112	37	-	14.0	11.2	14	4	18.5		T401 2007	T402 2007	T403 2007	T902 2007
M 20	x 1.25	112	37	-	14.0	11.2	14	4	18.8		•	•	T403 2006	•
M 22	x 2.00	118	38	-	16.0	12.5	16	4	20.0		•	•	T403 2208	•
M 22	x 1.50	118	38	-	16.0	12.5	16	4	20.5		T401 2207	T402 2207	T403 2207	T902 2207
M 24	x 2.0*	130	45	-	18.0	14.0	18	4	22.0		T401 2408	T402 2408	T403 2408	T902 2408
M 24	x 1.50	130	45	-	18.0	14.0	18	4	22.5		•	•	T403 2407	•
M 25	x 1.5**	130	45	-	18.0	14.0	18	4	23.5		T401 2507	T402 2507	T403 2507	•
M 27	x 2.00	135	45	-	20.0	16.0	20	4	25.0		•	•	T403 2708	•
M 30	x 1.50	138	48	-	20.0	16.0	20	4	28.5		T401 3007	T402 3007	T403 3007	•
M 30	x 2.00	138	48	-	20.0	16.0	20	4	28.0		T401 3008	T402 3008	T403 3008	•
M 32	x 1.5**	151	51	-	22.4	18.0	22	4	30.5		T401 3207	T402 3207	T403 3207	•
M 40	x 1.5**	170	60	-	28.0	22.4	26	4	38.5		T401 4007	T402 4007	T403 4007	•
Spark Plug														
M 10	x 1.00	80	24	34	10.0	8.0	11	4	9.0		T401 1005	T402 1005	T403 1005	T902 1005
M 12	x 1.25	89	29	-	9.0	7.1	10	4	10.8		T401 1206	T402 1206	T403 1206	T902 1206
M 14	x 1.25	95	30	-	11.2	9.0	12	4	12.8		T401 1406	T402 1406	T403 1406	T902 1406
M 18	x 1.50	112	37	-	14.0	11.2	14	4	16.5		T401 1807	T402 1807	T403 1807	T902 1807

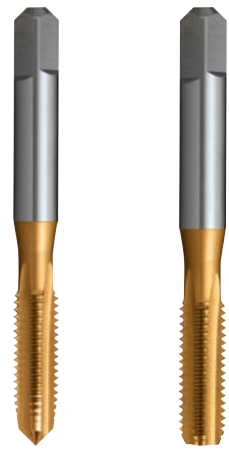
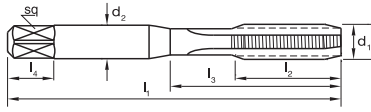
**MF**

\* Alternative Metric Fine \*\* Conduit Metric • Available on request as special manufacture. Subject to lead time.

# Taps Metric Fine, Straight Flute, N



- General purpose use
- Suitable for materials up to 1000N/mm<sup>2</sup>
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d<sub>1</sub>



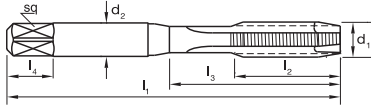
Catalogue Code											T404	T405
Discount Group											D0706	D0706
Material											HSS	HSS
Surface Finish											TIN	TIN
Colour Ring & Application											N	N
Geometry											-	-
Chamfer											Intermediate	Bottoming
Limit & Nut Tolerance											ISO 2 / 6H	ISO 2 / 6H
d <sub>1</sub>	Pitch	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>4</sub>	z	drill Ø		Item #	Item #
M 5	x 0.50	58	16	22	5.0	4.0	7	4	4.5	•	•	
M 6	x 0.75	66	19	26	6.3	5.0	8	4	5.3	•	•	
M 8	x 1.0*	72	22	30	8.0	6.3	9	4	7.0	T404 0805	T405 0805	
M 8	x 0.75	72	22	30	8.0	6.3	9	4	7.3	•	•	
M 10	x 1.25*	80	24	34	10.0	8.0	11	4	8.8	T404 1006	T405 1006	
M 10	x 1.00	80	24	34	10.0	8.0	11	4	9.0	T404 1005	T405 1005	
M 10	x 0.75	80	24	34	10.0	8.0	11	4	9.3	•	•	
M 12	x 1.5*	89	29	-	9.0	7.1	10	4	10.5	T404 1207	T405 1207	
M 12	x 1.25	89	29	-	9.0	7.1	10	4	10.8	T404 1206	T405 1206	
M 12	x 1.00	89	29	-	9.0	7.1	10	4	11.0	•	•	
M 14	x 1.5*	95	30	-	11.2	9.0	12	4	12.5	T404 1407	T405 1407	
M 14	x 1.00	95	30	-	11.2	9.0	12	4	13.0	•	•	
M 16	x 1.5*	102	32	-	12.5	10.0	13	4	14.5	•	T405 1607	
M 16	x 1.25	102	32	-	12.5	10.0	13	4	14.8	•	•	
M 16	x 1.00	102	32	-	12.5	10.0	13	4	15.0	•	•	
M 18	x 1.5*	112	37	-	14.0	11.2	14	4	16.5	•	•	
M 18	x 1.25	112	37	-	14.0	11.2	14	4	16.8	•	•	
M 20	x 2.0*	112	37	-	14.0	11.2	14	4	18.0	•	•	
M 20	x 1.5**	112	37	-	14.0	11.2	14	4	18.5	•	•	
M 20	x 1.25	112	37	-	14.0	11.2	14	4	18.8	•	•	
M 22	x 2.00	118	38	-	16.0	12.5	16	4	20.0	•	•	
M 22	x 1.50	118	38	-	16.0	12.5	16	4	20.5	•	•	
M 24	x 2.0*	130	45	-	18.0	14.0	18	4	22.0	•	•	
M 24	x 1.50	130	45	-	18.0	14.0	18	4	22.5	•	•	
M 25	x 1.5**	130	45	-	18.0	14.0	18	4	23.5	•	•	
M 27	x 2.00	135	45	-	20.0	16.0	20	4	25.0	•	•	
M 30	x 1.50	138	48	-	20.0	16.0	20	4	28.5	•	•	
M 30	x 2.00	138	48	-	20.0	16.0	20	4	28.0	•	•	
M 32	x 1.5**	151	51	-	22.4	18.0	22	4	30.5	•	•	
M 40	x 1.5**	170	60	-	28.0	22.4	26	4	38.5	•	•	
Spark Plug												
M 10	x 1.00	80	24	34	10.0	8.0	11	4	9.0	T404 1005	T405 1005	
M 12	x 1.25	89	29	-	9.0	7.1	10	4	10.8	T404 1206	T405 1206	
M 14	x 1.25	95	30	-	11.2	9.0	12	4	12.8	T404 1406	T405 1406	
M 18	x 1.50	112	37	-	14.0	11.2	14	4	16.5			

\* Alternative Metric Fine \*\* Conduit Metric • Available on request as special manufacture. Subject to lead time.

# Taps Metric Fine, Gun, N



- General purpose use
- Suitable for materials up to 1000N/mm<sup>2</sup>
- Through holes
- Depths up to approx. 3 x d<sub>1</sub>



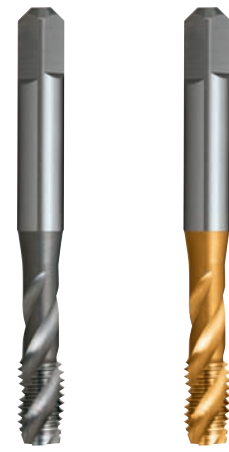
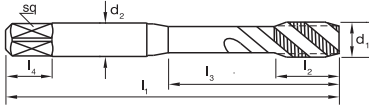
Catalogue Code											T406	T407	T408
Discount Group											D0702	D0702	D0706
Material											HSSE V3	HSSE V3	HSSE V3
Surface Finish											<b>Brt</b>	<b>Blu</b>	<b>TiN</b>
Colour Ring & Application											N	N	N
Geometry											-	-	-
Chamfer											Intermediate	Intermediate	Intermediate
Limit & Nut Tolerance											ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H
d <sub>1</sub>	Pitch	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>4</sub>	z	drill Ø		Item #	Item #	Item #
M 5	x 0.50	58	16	22	5.0	4.0	7	3	4.5	•	T407 0503	•	
M 6	x 0.75	66	19	26	6.3	5.0	8	3	5.3	•	T407 0604	•	
M 8	x 1.00	72	22	30	8.0	6.3	9	3	7.0	T406 0805	T407 0805	T408 0805	
M 10	x 1.25	80	24	34	10.0	8.0	11	3	8.8	T406 1006	T407 1006	T408 1006	
M 10	x 1.00	80	24	34	10.0	8.0	11	3	9.0	•	T407 1005	•	
M 12	x 1.50	89	29	-	9.0	7.1	10	3	10.5	T406 1207	T407 1207	T408 1207	
M 12	x 1.25	89	29	-	9.0	7.1	10	3	10.8	•	T407 1206	•	
M 14	x 1.50	95	30	-	11.2	9.0	12	3	12.5	•	T407 1407	•	
M 16	x 1.50	102	32	-	12.5	10.0	13	3	14.5	•	T407 1607	•	
M 18	x 1.50	112	37	-	14.0	11.2	14	4	16.5	•	T407 1807	•	
M 20	x 1.50	112	37	-	14.0	11.2	14	4	18.5	•	T407 2007	•	
M 22	x 1.50	118	38	-	16.0	12.5	16	4	20.5	•	T407 2207	•	

MF

# Taps Metric Fine, Spiral Flute, N



- General purpose use
- Suitable for materials up to 1000N/mm<sup>2</sup>
- Blind holes
- Depths up to approx. 2.5 x d<sub>1</sub>



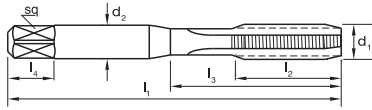
Catalogue Code											T409	T411
Discount Group											D0702	D0706
Material											HSSE V3	HSSE V3
Surface Finish											<b>Brt</b>	<b>TIN</b>
Colour Ring & Application											N	N
Geometry											-	-
Chamfer											<b>Bottoming</b>	<b>Bottoming</b>
Limit & Nut Tolerance											ISO 2 / 6H	ISO 2 / 6H
d <sub>1</sub>	Pitch	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>4</sub>	z	drill Ø		Item #	Item #
M 5	x 0.50	58	16	22	5.0	4.0	7	3	4.5		T409 0503	•
M 6	x 0.75	66	19	26	6.3	5.0	8	3	5.3		T409 0604	•
M 8	x 1.00	72	22	30	8.0	6.3	9	3	7.0		T409 0805	T411 0805
M 10	x 1.00	80	24	34	10.0	8.0	11	3	9.0		T409 1005	•
M 10	x 1.25	80	24	34	10.0	8.0	11	3	8.8		T409 1006	T411 1006
M 12	x 1.25	89	29	-	9.0	7.1	10	3	10.8		T409 1206	•
M 12	x 1.50	89	29	-	9.0	7.1	10	3	10.5		T409 1207	T411 1207
M 14	x 1.25	95	30	-	11.2	9.0	12	3	12.8		T409 1406	•
M 14	x 1.50	95	30	-	11.2	9.0	12	3	12.5		T409 1407	•
M 16	x 1.50	102	32	-	12.5	10.0	13	3	14.5		T409 1607	•
M 18	x 1.50	112	37	-	14.0	11.2	14	4	16.5		T409 1807	•
M 20	x 1.50	112	37	-	14.0	11.2	14	4	18.5		T409 2007	•
M 22	x 1.50	118	38	-	16.0	12.5	16	4	20.5		T409 2207	•

• Available on request as special manufacture. Subject to lead time.

# Taps UNC, Straight Flute, N



- General purpose use
- Suitable for materials up to 1000N/mm<sup>2</sup>
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d<sub>1</sub>



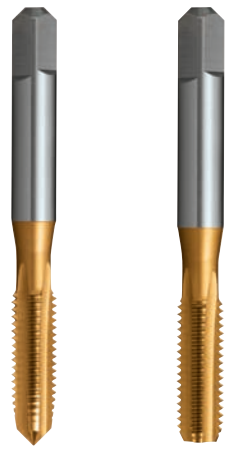
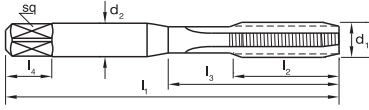
Catalogue Code											T414	T415	T416	T903
Discount Group											D0702	D0702	D0702	D0702
Material											HSS	HSS	HSS	HSS
Surface Finish											<b>Br</b> t	<b>Br</b> t	<b>Br</b> t	<b>Br</b> t
Colour Ring & Application											N	N	N	N
Geometry											-	-	-	-
Chamfer											Taper	Intermediate	Bottoming	Set
Limit & Nut Tolerance											2B	2B	2B	2B
d <sub>1</sub>	TPI	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>4</sub>	z	drill Ø		Item #	Item #	Item #	Item #
#3	-	48	45	10	-	2.80	2.24	5	3	2.1	T414 0251	T415 0251	T416 0251	•
#4	-	40	48	15	14.5	3.15	2.50	5	3	2.3	T414 0284	T415 0284	T416 0284	T903 0284
#5	-	40	48	15	15	3.15	2.50	5	3	2.6	T414 0318	T415 0318	T416 0318	T903 0318
#6	-	32	50	17	17.5	3.55	2.80	5	3	2.8	T414 0351	T415 0351	T416 0351	T903 0351
#8	-	32	53	13	17	4.50	3.55	6	3	3.4	T414 0417	T415 0417	T416 0417	T903 0417
#10	-	24	58	16	22	5.00	4.00	7	3	3.8	T414 0483	T415 0483	T416 0483	T903 0483
#12	-	24	62	17	23	5.60	4.50	7	3	4.5	T414 0549	T415 0549	T416 0549	T903 0549
3/16	-	24 (UNS)	58	16	22	5.00	4.00	7	3	3.7	T414 0476	T415 0476	T416 0476	T903 0476
1/4	-	20	66	19	25	6.30	5.00	8	3	5.1	T414 0635	T415 0635	T416 0636	T903 0635
1/4*	-	20	66	19	25	6.30	5.00	8	3	5.1	•	•	T416 0635	•
5/16	-	18	72	22	30	8.00	6.30	9	4	6.6	T414 0794	T415 0794	T416 0795	T903 0794
5/16*	-	18	72	22	30	8.00	6.30	9	4	6.6	•	•	T416 0794	•
3/8	-	16	80	24	33	10.00	8.00	11	4	8.0	T414 0953	T415 0953	T416 0953	T903 0953
7/16	-	14	85	25	-	8.00	6.30	9	4	9.4	T414 1111	T415 1111	T416 1111	T903 1111
1/2	-	13	89	29	-	9.00	7.10	10	4	10.8	T414 1270	T415 1270	T416 1270	T903 1270
9/16	-	12	95	30	-	11.20	9.00	12	4	12.2	T414 1429	T415 1429	T416 1429	T903 1429
5/8	-	11	102	32	-	12.50	10.00	13	4	13.5	T414 1588	T415 1588	T416 1588	T903 1588
3/4	-	10	112	37	-	14.00	11.20	14	4	16.5	T414 1905	T415 1905	T416 1905	T903 1905
7/8	-	9	118	38	-	16.00	12.50	16	4	19.5	T414 2223	T415 2223	T416 2223	T903 2223
1	-	8	130	45	-	18.00	14.00	18	4	22.2	T414 2540	T415 2540	T416 2540	T903 2540
1-1/8	-	7	138	48	-	20.00	16.00	20	4	25.0	T414 2858	T415 2858	T416 2858	•
1-1/4	-	7	151	51	-	22.40	18.00	22	4	28.0	T414 3175	T415 3175	T416 3175	T903 3175
1-1/2	-	6	170	60	-	28.00	22.40	26	4	34.0	T414 3810	T415 3810	T416 3810	T903 3810

\* Alternative Limit • Available on request as special manufacture. Subject to lead time.

# Taps UNC, Straight Flute, N



- General purpose use
- Suitable for materials up to 1000N/mm<sup>2</sup>
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d<sub>1</sub>



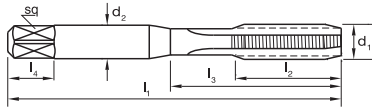
Catalogue Code												T417	T418
Discount Group												D0706	D0706
Material												HSS	HSS
Surface Finish												TIN	TIN
Colour Ring & Application												N	N
Geometry												-	-
Chamfer												Intermediate	Bottoming
Limit & Nut Tolerance												2B	2B
d <sub>1</sub>	TPI	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>4</sub>	z	Limit	drill Ø	Item #	Item #	
#3	- 48	45	10	-	2.80	2.24	5	3	GH2	2.1	•	•	
#4	- 40	48	15	14.5	3.15	2.50	5	3	GH2	2.3	•	•	
#5	- 40	48	15	15	3.15	2.50	5	3	GH2	2.6	•	•	
#6	- 32	50	17	17.5	3.55	2.80	5	3	GH3	2.8	T417 0351	T418 0351	
#8	- 32	53	13	18	4.50	3.55	6	3	GH3	3.4	T417 0417	T418 0417	
#10	- 24	58	16	22	5.00	4.00	7	3	GH4	3.8	T417 0483	T418 0483	
#12	- 24	62	17	23	5.60	4.50	7	3	GH4	4.5	•	•	
3/16	- 24 (UNS)	58	16	22	5.00	4.00	7	3	GH4	3.7	•	•	
1/4	- 20	66	19	25	6.30	5.00	8	3	GH4	5.1	T417 0635	T418 0635	
1/4*	- 20	66	19	25	6.30	5.00	8	3	GH3	5.1	•	•	
5/16	- 18	72	22	30	8.00	6.30	9	4	GH5	6.6	T417 0794	T418 0794	
5/16*	- 18	72	22	30	8.00	6.30	9	4	GH3	6.6	•	•	
3/8	- 16	80	24	33	10.00	8.00	11	4	GH5	8.0	T417 0953	T418 0953	
7/16	- 14	85	25	-	8.00	6.30	9	4	GH3	9.4	T417 1111	T418 1111	
1/2	- 13	89	29	-	9.00	7.10	10	4	GH6	10.8	T417 1270	T418 1270	
9/16	- 12	95	30	-	11.20	9.00	12	4	GH6	12.2	•	•	
5/8	- 11	102	32	-	12.50	10.00	13	4	GH6	13.5	T417 1588	T418 1588	
3/4	- 10	112	37	-	14.00	11.20	14	4	GH7	16.5	T417 1905	T418 1905	
7/8	- 9	118	38	-	16.00	12.50	16	4	GH7	19.5	•	•	
1	- 8	130	45	-	18.00	14.00	18	4	GH7	22.2	•	•	
1-1/8	- 7	138	48	-	20.00	16.00	20	4	GH8	25.0	•	•	
1-1/4	- 7	151	51	-	22.40	18.00	22	4	GH8	28.0	•	•	
1-1/2	- 6	170	60	-	28.00	22.40	26	4	GH8	34.0	•	•	

\* Alternative Limit • Available on request as special manufacture. Subject to lead time.

# Taps UNC, Straight Flute, N, Left Hand



- General purpose use
- Suitable for materials up to 1000N/mm<sup>2</sup>
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d<sub>1</sub>



Catalogue Code												T419	T420	T421
Discount Group												D0702	D0702	D0702
Material												HSS	HSS	HSS
Surface Finish												<b>Br</b> t	<b>Br</b> t	<b>Br</b> t
Colour Ring & Application												N	N	N
Geometry												Left Hand	Left Hand	Left Hand
Chamfer												Taper	Intermediate	Bottoming
Limit & Nut Tolerance												2B LH	2B LH	2B LH
d <sub>1</sub>	TPI	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>4</sub>	z	Limit	drill Ø		Item #	Item #	Item #
1/4	- 20	66	19	25	6.30	5.00	8	3	GH4	5.1		T419 0635	T420 0635	T421 0635
5/16	- 18	72	22	30	8.00	6.30	9	4	GH5	6.6		T419 0794	T420 0794	T421 0794
3/8	- 16	80	24	33	10.00	8.00	11	4	GH5	8.0		T419 0953	T420 0953	T421 0953
7/16	- 14	85	25	-	8.00	6.30	9	4	GH5	9.4		T419 1111	T420 1111	T421 1111
1/2	- 13	89	29	-	9.00	7.10	10	4	GH6	10.8		T419 1270	T420 1270	T421 1270
9/16	- 12	95	30	-	11.20	9.00	12	4	GH6	12.2		T419 1429	T420 1429	T421 1429
5/8	- 11	102	32	-	12.50	10.00	13	4	GH6	13.5		T419 1588	T420 1588	T421 1588
3/4	- 10	112	37	-	14.00	11.20	14	4	GH7	16.5		T419 1905	T420 1905	T421 1905
7/8	- 9	118	38	-	16.00	12.50	16	4	GH7	19.5		•	•	•
1	- 8	130	45	-	18.00	14.00	18	4	GH7	22.2		•	•	•
1-1/8	- 7	138	48	-	20.00	16.00	20	4	GH8	25.0		•	•	•
1-1/4	- 7	151	51	-	22.40	18.00	22	4	GH8	28.0		•	•	•
1-1/2	- 6	170	60	-	28.00	22.40	26	4	GH8	34.0		•	•	•

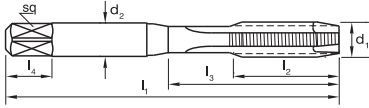
• Available on request as special manufacture. Subject to lead time.



# Taps UNC, Gun, N



- General purpose use
- Suitable for materials up to 1000N/mm<sup>2</sup>
- Through holes
- Depths up to approx. 3 x d<sub>1</sub>



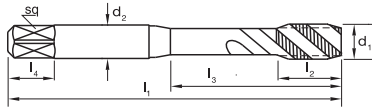
Catalogue Code												T422	T423	T424
Discount Group												D0702	D0702	D0706
Material												HSSE V3	HSSE V3	HSSE V3
Surface Finish												<b>Brt</b>	<b>Blu</b>	<b>TIN</b>
Colour Ring & Application												N	N	N
Geometry												-	-	-
Chamfer												Intermediate	Intermediate	Intermediate
Limit & Nut Tolerance												2B	2B	2B
d <sub>1</sub>	TPI	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>4</sub>	z	Limit	drill Ø	Item #	Item #	Item #	
#4	-	40	48	15	14.5	3.15	2.50	5	2	GH2/2B	2.3	T422 0284	T423 0284	•
#6	-	32	50	17	17.5	3.55	2.80	5	3	GH3/2B	2.8	T422 0351	T423 0351	T424 0351
#8	-	32	53	13	18	4.50	3.55	6	3	GH3/2B	3.4	T422 0417	T423 0417	T424 0417
#10	-	24	58	16	22	5.00	4.00	7	3	GH4/2B	3.8	T422 0483	T423 0483	T424 0483
1/4	-	20	66	19	25	6.30	5.00	8	3	GH4/2B	5.1	T422 0635	T423 0635	T424 0635
5/16	-	18	72	22	30	8.00	6.30	9	3	GH5/2B	6.6	T422 0794	T423 0794	T424 0794
3/8	-	16	80	24	33	10.00	8.00	11	3	GH5/2B	8.0	T422 0953	T423 0953	T424 0953
7/16	-	14	85	25	-	8.00	6.30	9	3	GH5/2B	9.4	T422 1111	T423 1111	•
1/2	-	13	89	29	-	9.00	7.10	10	3	GH6/2B	10.8	T422 1270	T423 1270	T424 1270
5/8	-	11	102	32	-	12.50	10.00	13	3	GH6/2B	13.5	T422 1588	T423 1588	T424 1588
3/4	-	10	112	37	-	14.00	11.20	14	4	GH7/2B	16.5	T422 1905	T423 1905	T424 1905
7/8	-	9	118	38	-	16.00	12.50	16	4	GH7/2B	19.5	•	T423 2223	•
1	-	8	130	45	-	18.00	14.00	18	4	GH7/2B	22.2	•	T423 2540	•

• Available on request as special manufacture. Subject to lead time.

# Taps UNC, Spiral Flute, N



- General purpose use
- Suitable for materials up to 1000N/mm<sup>2</sup>
- Blind holes
- Depths up to approx. 2.5 x d<sub>1</sub>



Catalogue Code												T425	T426	T427
Discount Group												D0702	D0702	D0706
Material												HSSE V3	HSSE V3	HSSE V3
Surface Finish												<b>Brt</b>	<b>Blu</b>	<b>TiN</b>
Colour Ring & Application												N	N	N
Geometry												-	-	-
Chamfer												Bottoming	Bottoming	Bottoming
Limit & Nut Tolerance												2B	2B	2B
d <sub>1</sub>	TPI	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>4</sub>	z	Limit	drill Ø	Item #	Item #	Item #	
#2	-	56	41	8	-	2.5	2.0	-	2	GH2/2B	1.85	T425 0218	•	•
#4	-	40	48	6	-	3.15	2.50	5	3	GH2/2B	2.3	T425 0284	•	•
#6	-	32	50	6	-	3.55	2.80	5	3	GH3/2B	2.8	T425 0351	•	•
#8	-	32	53	8	18	4.50	3.55	6	3	GH3/2B	3.4	T425 0417	•	•
#10	-	24	58	11	22	5.00	4.00	7	3	GH4/2B	3.8	T425 0483	•	T427 0483
1/4	-	20	66	10	25	6.30	5.00	8	3	GH4/2B	5.1	T425 0635	T426 0635	T427 0635
5/16	-	18	72	13	30	8.00	6.30	9	3	GH5/2B	6.6	T425 0794	T426 0794	T427 0794
3/8	-	16	80	16	33	10.00	8.00	11	3	GH5/2B	8.0	T425 0953	T426 0953	T427 0953
7/16	-	14	85	18	-	8.00	6.30	9	3	GH5/2B	9.4	T425 1111	T426 1111	T427 1111
1/2	-	13	89	20	-	9.00	7.10	10	3	GH6/2B	10.8	T425 1270	T426 1270	T427 1270
5/8	-	11	102	20	-	12.50	10.00	13	3	GH6/2B	13.5	T425 1588	T426 1588	T427 1588
3/4	-	10	112	25	-	14.00	11.20	14	4	GH7/2B	16.5	T425 1905	T426 1905	T427 1905
7/8	-	9	118	38	-	16.00	12.50	16	4	GH7/2B	19.5	T425 2223	•	•
1	-	8	130	45	-	18.00	14.00	18	4	GH7/2B	22.2	T425 2540	•	•

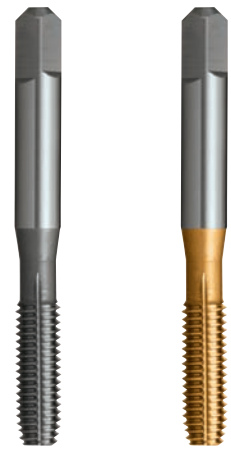
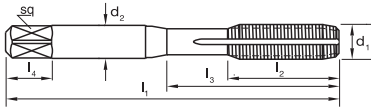
UNC

• Available on request as special manufacture. Subject to lead time.

# Taps UNC, Forming, Single Coolant Groove



- For cold forming of threads in materials with good flow characteristics
- Through or Blind holes
- Depths up to approx.  $1.5 \times d_1$
- TiN for longer tool life



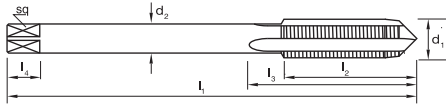
Catalogue Code												T428	T429
Discount Group												D0702	D0706
Material												HSSE V3	HSSE V3
Surface Finish												<b>Brt</b>	<b>TiN</b>
Colour Ring & Application												<b>N</b>	<b>N</b>
Geometry												Single Coolant Groove	Single Coolant Groove
Chamfer												Short	Short
Limit & Nut Tolerance												2B	2B
d <sub>1</sub>	TPI	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>4</sub>	z	Limit	drill Ø	Item #	Item #	
#5	- 40	48	15	15	3.15	2.50	5	-	GH5/2B	2.9	T428 0318	•	
#6	- 32	50	17	17.5	3.55	2.80	5	-	GH6/2B	3.2	T428 0351	T429 0351	
#8	- 32	53	13	18	4.50	3.55	6	-	GH6/2B	3.8	T428 0417	T429 0417	
#10	- 24	58	16	22	5.00	4.00	7	-	GH6/2B	4.4	T428 0483	T429 0483	
1/4	- 20	66	19	25	6.30	5.00	8	-	GH7/2B	5.8	T428 0635	T429 0635	
5/16	- 18	72	22	30	8.00	6.30	9	-	GH7/2B	7.3	T428 0794	•	
3/8	- 16	80	24	33	10.00	8.00	11	-	GH7/2B	8.8	T428 0953	•	
1/2	- 13	89	29	-	9.00	7.10	10	-	GH8/2B	11.7	T428 1270	•	

• Available on request as special manufacture. Subject to lead time.

# Taps UNC, Machine Nut, Long Shank



- Suited to long reach applications
- Suitable for materials up to 1000N/mm<sup>2</sup>
- Through holes
- Depths up to approx. 2 x d<sub>1</sub>

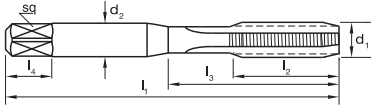


<b>Catalogue Code</b>	<b>T430</b>																																																												
<b>Discount Group</b>	D0702																																																												
<b>Material</b>	<b>HSS</b>																																																												
<b>Surface Finish</b>	<b>Brt</b>																																																												
<b>Colour Ring &amp; Application</b>	<b>N</b>																																																												
<b>Geometry</b>	Extra Length																																																												
<b>Chamfer</b>	<b>Bottoming</b>																																																												
<b>Limit &amp; Nut Tolerance</b>	2B																																																												
<table border="1"> <thead> <tr> <th>d<sub>1</sub></th> <th>TPI</th> <th>l<sub>1</sub></th> <th>l<sub>2</sub></th> <th>l<sub>3</sub></th> <th>d<sub>2</sub></th> <th>sq</th> <th>l<sub>4</sub></th> <th>z</th> <th>Limit</th> <th>drill Ø</th> <th>Item #</th> </tr> </thead> <tbody> <tr> <td>1/4</td> <td>- 20</td> <td>110</td> <td>38</td> <td>-</td> <td>4.5</td> <td>3.55</td> <td>6</td> <td>4</td> <td>GH4/2B</td> <td>5.1</td> <td>T430 0635</td> </tr> <tr> <td>5/16</td> <td>- 18</td> <td>125</td> <td>43</td> <td>-</td> <td>6</td> <td>4.5</td> <td>7</td> <td>4</td> <td>GH5/2B</td> <td>6.6</td> <td>T430 0794</td> </tr> <tr> <td>3/8</td> <td>- 16</td> <td>140</td> <td>48</td> <td>-</td> <td>7</td> <td>5.6</td> <td>8</td> <td>4</td> <td>GH5/2B</td> <td>8.0</td> <td>T430 0953</td> </tr> <tr> <td>1/2</td> <td>- 13</td> <td>180</td> <td>59</td> <td>-</td> <td>9.5</td> <td>7.5</td> <td>10</td> <td>4</td> <td>GH6/2B</td> <td>10.8</td> <td>T430 1270</td> </tr> </tbody> </table>	d <sub>1</sub>	TPI	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>4</sub>	z	Limit	drill Ø	Item #	1/4	- 20	110	38	-	4.5	3.55	6	4	GH4/2B	5.1	T430 0635	5/16	- 18	125	43	-	6	4.5	7	4	GH5/2B	6.6	T430 0794	3/8	- 16	140	48	-	7	5.6	8	4	GH5/2B	8.0	T430 0953	1/2	- 13	180	59	-	9.5	7.5	10	4	GH6/2B	10.8	T430 1270	
d <sub>1</sub>	TPI	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>4</sub>	z	Limit	drill Ø	Item #																																																		
1/4	- 20	110	38	-	4.5	3.55	6	4	GH4/2B	5.1	T430 0635																																																		
5/16	- 18	125	43	-	6	4.5	7	4	GH5/2B	6.6	T430 0794																																																		
3/8	- 16	140	48	-	7	5.6	8	4	GH5/2B	8.0	T430 0953																																																		
1/2	- 13	180	59	-	9.5	7.5	10	4	GH6/2B	10.8	T430 1270																																																		

# Taps UNF, Straight Flute, N



- General purpose use
- Suitable for materials up to 1000N/mm<sup>2</sup>
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d<sub>1</sub>



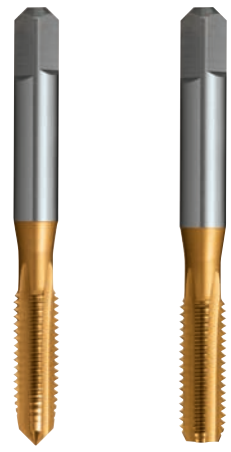
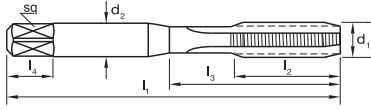
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Discount Group											D0702	D0702	D0702	D0702
Material											<b>HSS</b>	<b>HSS</b>	<b>HSS</b>	<b>HSS</b>
Surface Finish											<b>Brt</b>	<b>Brt</b>	<b>Brt</b>	<b>Brt</b>
Colour Ring & Application											<b>N</b>	<b>N</b>	<b>N</b>	<b>N</b>
Geometry											-	-	-	-
Chamfer											<b>Taper</b>	<b>Intermediate</b>	<b>Bottoming</b>	<b>Set</b>
Limit & Nut Tolerance											2B	2B	2B	2B
d <sub>1</sub>	TPI	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>1</sub>	z	drill Ø		Item #	Item #	Item #	Item #
#3	- 56	45	10	-	2.80	2.24	5	3	2.1		T431 0251	T432 0251	T433 0251	•
#4	- 48	48	15	14.5	3.15	2.50	5	3	2.35		T431 0284	T432 0284	T433 0284	T904 0284
#5	- 44	48	15	15	3.15	2.50	5	3	2.65		T431 0318	T432 0318	T433 0318	T904 0318
#6	- 40	50	17	17.5	3.55	2.80	5	3	2.9		T431 0351	T432 0351	T433 0351	T904 0351
#8	- 36	53	13	17	4.50	3.55	6	3	3.5		T431 0417	T432 0417	T433 0417	T904 0417
#10	- 32	58	16	22	5.00	4.00	7	3	4.1		T431 0483	T432 0483	T433 0483	T904 0483
#12	- 28	62	17	23	5.60	4.50	7	3	4.6		T431 0549	T432 0549	T433 0549	T904 0549
3/16	- 32 (UNS)	58	16	22	5.00	4.00	7	3	4.0		T431 0476	T432 0476	T433 0476	T904 0476
1/4	- 28	66	19	25	6.30	5.00	8	3	5.5		T431 0635	T432 0635	T433 0635	T904 0635
5/16	- 24	72	22	30	8.00	6.30	9	4	6.9		T431 0794	T432 0794	T433 0794	T904 0794
3/8	- 24	80	24	33	10.00	8.00	11	4	8.5		T431 0953	T432 0953	T433 0953	T904 0953
7/16	- 20	85	25	-	8.00	6.30	9	4	9.8		T431 1111	T432 1111	T433 1111	T904 1111
1/2	- 20	89	29	-	9.00	7.10	10	4	11.5		T431 1270	T432 1270	T433 1270	T904 1270
9/16	- 18	95	30	-	11.20	9.00	12	4	12.8		T431 1429	T432 1429	T433 1429	T904 1429
5/8	- 18	102	32	-	12.50	10.00	13	4	14.5		T431 1588	T432 1588	T433 1588	T904 1588
3/4	- 16	112	37	-	14.00	11.20	14	4	17.5		T431 1905	T432 1905	T433 1905	T904 1905
7/8	- 14	118	38	-	16.00	12.50	16	4	20.5		T431 2223	T432 2223	T433 2223	T904 2223
1	- 12	130	45	-	18.00	14.00	18	4	23.5		T431 2540	T432 2540	T433 2540	T904 2540
1	- 14 (UNS)	130	45	-	18.00	14.00	18	4	24.0		T431 2541	T432 2541	T433 2541	T904 2541
1-1/8	- 12	138	48	-	20.00	16.00	20	4	26.5		T431 2858	T432 2858	T433 2858	•
1-1/4	- 12	151	51	-	22.40	18.00	22	4	29.5		T431 3175	T432 3175	T433 3175	•
1-1/2	- 12	170	60	-	28.00	22.40	26	4	36.0		T431 3810	T432 3810	T433 3810	•

• Available on request as special manufacture. Subject to lead time.

# Taps UNF, Straight Flute, N



- General purpose use
- Suitable for materials up to 1000N/mm<sup>2</sup>
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d<sub>1</sub>



Catalogue Code											T434	T435
Discount Group											D0706	D0706
Material											HSS	HSS
Surface Finish											TIN	TIN
Colour Ring & Application											N	N
Geometry											-	-
Chamfer											Intermediate	Bottoming
Limit & Nut Tolerance											2B	2B
d <sub>1</sub>	TPI	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>4</sub>	z	drill Ø		Item #	Item #
#3	- 56	45	10	-	2.80	2.24	5	3	2.1		•	•
#4	- 48	48	15	14.5	3.15	2.50	5	3	2.35		•	•
#5	- 44	48	15	15	3.15	2.50	5	3	2.65		•	•
#6	- 40	50	17	17.5	3.55	2.80	5	3	2.9		•	•
#8	- 36	53	13	18	4.50	3.55	6	3	3.5		•	•
#10	- 32	58	16	22	5.00	4.00	7	3	4.1	T434 0483		T435 0483
#12	- 28	62	17	23	5.60	4.50	7	3	4.6		•	•
3/16	- 32 (UNS)	58	16	22	5.00	4.00	7	3	4.0		•	•
1/4	- 28	66	19	25	6.30	5.00	8	3	5.5	T434 0635		T435 0635
5/16	- 24	72	22	30	8.00	6.30	9	4	6.9	T434 0794		T435 0794
3/8	- 24	80	24	33	10.00	8.00	11	4	8.5	T434 0953		T435 0953
7/16	- 20	85	25	-	8.00	6.30	9	4	9.8	T434 1111		T435 1111
1/2	- 20	89	29	-	9.00	7.10	10	4	11.5	T434 1270		T435 1270
9/16	- 18	95	30	-	11.20	9.00	12	4	12.8		•	•
5/8	- 18	102	32	-	12.50	10.00	13	4	14.5	T434 1588		T435 1588
3/4	- 16	112	37	-	14.00	11.20	14	4	17.5	T434 1905		T435 1905
7/8	- 14	118	38	-	16.00	12.50	16	4	20.5		•	•
1	- 12	130	45	-	18.00	14.00	18	4	23.5		•	•
1	- 14 (UNS)	130	45	-	18.00	14.00	18	4	24.0		•	•
1-1/8	- 12	138	48	-	20.00	16.00	20	4	26.5		•	•
1-1/4	- 12	151	51	-	22.40	18.00	22	4	29.5		•	•
1-1/2	- 12	170	60	-	28.00	22.40	26	4	36.0		•	•

UNF

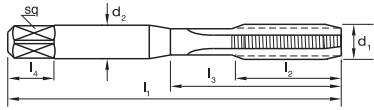
• Available on request as special manufacture. Subject to lead time.



# Taps UNEF & 8UN, Straight Flute, N



- General purpose use
- Suitable for materials up to 1000N/mm<sup>2</sup>
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d<sub>1</sub>



Catalogue Code														
Discount Group												D0702	D0702	D0702
Material												HSS	HSS	HSS
Surface Finish												<i>Brt</i>	<i>Brt</i>	<i>Brt</i>
Colour Ring & Application												N	N	N
Geometry												Extra Fine	Extra Fine	Extra Fine
Chamfer												Taper	Intermediate	Bottoming
Limit & Nut Tolerance												2B	2B	2B
d <sub>1</sub>	TPI	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>4</sub>	z	Limit	drill Ø	Item #	Item #	Item #	
<b>UNEF Series</b>												<b>T445</b>	<b>T446</b>	<b>T447</b>
1/4	- 32	66	19	25	6.30	5.00	8	3	GH3/2B	5.6	T445 0635	T446 0635	T447 0635	
5/16	- 32	72	22	30	8.00	6.30	9	4	GH4/2B	7.2	T445 0794	T446 0794	T447 0794	
3/8	- 32	80	24	33	10.00	8.00	11	4	GH4/2B	8.8	T445 0953	T446 0953	T447 0953	
1/2	- 28	89	29	-	9.00	7.10	10	4	GH5/2B	11.8	T445 1270	T446 1270	T447 1270	
5/8	- 24	102	32	-	12.50	10.00	13	4	GH5/2B	14.75	T445 1588	T446 1588	T447 1588	
3/4	- 20	112	37	-	14.00	11.20	14	4	GH6/2B	18.0	T445 1905	T446 1905	T447 1905	
1	- 20	130	45	-	18.00	14.00	18	4	GH7/2B	24.2	T445 2540	T446 2540	T447 2540	
<b>8 UN Series</b>												<b>T448</b>	<b>T449</b>	<b>T450</b>
1-1/8	- 8	138	48	-	20.00	16.00	20	4	GH8/2B	25.5	T448 2858	T449 2858	T450 2858	
1-1/4	- 8	151	51	-	22.40	18.00	22	4	GH8/2B	28.5	T448 3175	T449 3175	T450 3175	
1-1/2	- 8	170	60	-	28.00	22.40	26	4	GH8/2B	35.0	T448 3810	T449 3810	T450 3810	
1-3/4	- 8	187	67	-	31.50	25.00	28	4	GH8/2B	41.5	T448 4445	T449 4445	T450 4445	
2	- 8	200	70	-	35.50	28.00	31	4	GH8/2B	47.5	T448 5080	T449 5080	T450 5080	
<b>Tyre Valve Tap (UNS)</b>														<b>T489</b>
5V1	(0.21) 36	62	17	23	5.60	4.50	7	3	-	4.6	•	•	T489 0533	
<b>Stitching Tap</b>														<b>T490</b>
#1		64	36	-	8.08	6.15	9.5	4	-	5.0	•	•	T490 0655	

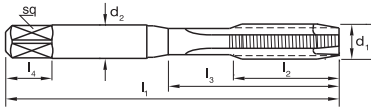
• Available on request as special manufacture. Subject to lead time.



# Taps UNF, Gun, N



- General purpose use
- Suitable for materials up to 1000N/mm<sup>2</sup>
- Through holes
- Depths up to approx. 3 x d<sub>1</sub>



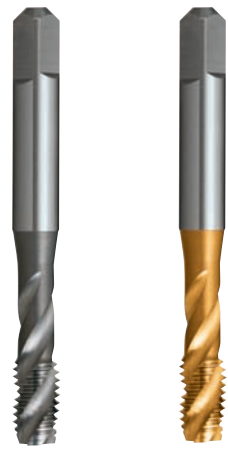
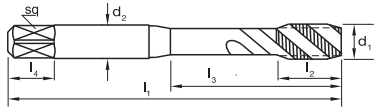
Catalogue Code												T439	T440	T441
Discount Group												D0702	D0702	D0706
Material												HSSE V3	HSSE V3	HSSE V3
Surface Finish												<b>Brt</b>	<b>Blu</b>	<b>TIN</b>
Colour Ring & Application												N	N	N
Geometry												-	-	-
Chamfer												Intermediate	Intermediate	Intermediate
Limit & Nut Tolerance												2B	2B	2B
d <sub>1</sub>	TPI	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>4</sub>	z	Limit	drill Ø	Item #	Item #	Item #	
#10	- 32	58	16	22	5.00	4.00	7	3	GH3/2B	4.1	T439 0483	T440 0483	T441 0483	
1/4	- 28	66	19	25	6.30	5.00	8	3	GH3/2B	5.5	T439 0635	T440 0635	T441 0635	
5/16	- 24	72	22	30	8.00	6.30	9	3	GH4/2B	6.9	T439 0794	T440 0794	T441 0794	
3/8	- 24	80	24	33	10.00	8.00	11	3	GH4/2B	8.5	T439 0953	T440 0953	T441 0953	
7/16	- 20	85	25	-	8.00	6.30	9	3	GH5/2B	9.8	T439 1111	T440 1111	•	
1/2	- 20	89	29	-	9.00	7.10	10	3	GH5/2B	11.5	T439 1270	T440 1270	T441 1270	
5/8	- 18	102	32	-	12.50	10.00	13	3	GH5/2B	12.8	T439 1588	T440 1588	T441 1588	
3/4	- 16	112	37	-	14.00	11.20	14	4	GH6/2B	17.5	T439 1905	T440 1905	T441 1905	
7/8	- 14	118	38	-	16.00	12.50	16	4	GH6/2B	20.5	•	T440 2223	•	
1	- 12	130	45	-	18.00	14.00	18	4	GH7/2B	23.5	•	T440 2540	•	

• Available on request as special manufacture. Subject to lead time.

# Taps UNF, Spiral Flute, N



- General purpose use
- Suitable for materials up to 1000N/mm<sup>2</sup>
- Blind holes
- Depths up to approx. 2.5 x d<sub>1</sub>



Catalogue Code												T442	T443
Discount Group												D0702	D0706
Material												HSSE V3	HSSE V3
Surface Finish												<b>Brt</b>	<b>TiN</b>
Colour Ring & Application												N	N
Geometry												-	-
Chamfer												<b>Bottoming</b>	<b>Bottoming</b>
Limit & Nut Tolerance												2B	2B
d <sub>1</sub>	TPI	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>4</sub>	z	Limit	drill Ø		Item #	Item #
#10	-	32	58	11	22	5.00	4.00	7	3	GH3/2B	4.1	T442 0483	T443 0483
1/4	-	28	66	10	25	6.30	5.00	8	3	GH3/2B	5.5	T442 0635	T443 0635
5/16	-	24	72	13	30	8.00	6.30	9	3	GH4/2B	6.9	T442 0794	T443 0794
3/8	-	24	80	16	33	10.00	8.00	11	3	GH4/2B	8.5	T442 0953	T443 0953
7/16	-	20	85	18	-	8.00	6.30	9	3	GH5/2B	9.8	T442 1111	•
1/2	-	20	89	20	-	9.00	7.10	10	3	GH5/2B	11.5	T442 1270	T443 1270
5/8	-	18	102	20	-	12.50	10.00	13	3	GH5/2B	12.8	T442 1588	T443 1588
3/4	-	16	112	25	-	14.00	11.20	14	4	GH6/2B	17.5	T442 1905	T443 1905

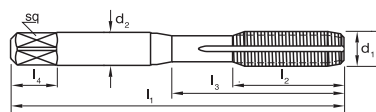
UNF

• Available on request as special manufacture. Subject to lead time.

# Taps UNF, Forming, Single Coolant Groove



- For cold forming of threads in materials with good flow characteristics
- Through or Blind holes
- Depths up to approx.  $1.5 \times d_1$



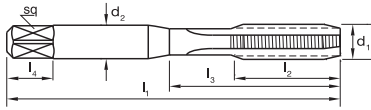
Catalogue Code											<b>T444</b>
Discount Group											D0702
Material											<b>HSSE V3</b>
Surface Finish											<b>Br</b>
Colour Ring & Application											<b>N</b>
Geometry											Single Coolant Groove
Chamfer											Short
Limit & Nut Tolerance											2B
$d_1$	TPI	$l_1$	$l_2$	$l_3$	$d_2$	sq	$l_4$	z	Limit	drill $\varnothing$	Item #
1/4	- 28	66	19	25	6.30	5.00	7	-	GH7/2B	5.5	T444 0635
5/16	- 24	72	22	30	8.00	6.30	8	-	GH7/2B	6.9	T444 0794
3/8	- 24	80	24	33	10.00	8.00	9	-	GH7/2B	8.5	T444 0953
1/2	- 20	89	29	-	9.00	7.10	10	-	GH8/2B	11.5	T444 1270

UNF

# Taps BSW, Straight Flute, N



- General purpose use
- Suitable for materials up to 1000N/mm<sup>2</sup>
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d<sub>1</sub>



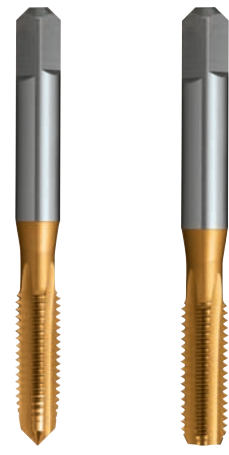
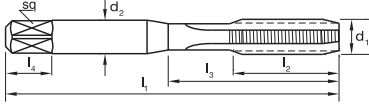
Catalogue Code											<b>T451</b>		<b>T452</b>		<b>T453</b>		<b>T905</b>	
Discount Group											D0702		D0702		D0702		D0702	
Material											HSS		HSS		HSS		HSS	
Surface Finish											<b>Brt</b>		<b>Brt</b>		<b>Brt</b>		<b>Brt</b>	
Colour Ring & Application											N		N		N		N	
Geometry											-		-		-		-	
Chamfer											Taper		Intermediate		Bottoming		Set	
Limit & Nut Tolerance											Z3 Medium		Z3 Medium		Z3 Medium		Z3 Medium	
d <sub>1</sub>	TPI	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>4</sub>	z	drill Ø	Item #	Item #	Item #	Item #					
3/32	- 48(WHIT)	45	10	-	2.80	2.24	5	3	1.85	T451 0238	T452 0238	T453 0238	T905 0238					
1/8	- 40	48	15	15	3.15	2.50	5	3	2.55	T451 0318	T452 0318	T453 0318	T905 0318					
5/32	- 32(WHIT)	53	17	17	4.00	3.15	6	3	3.2	T451 0397	T452 0397	T453 0397	T905 0397					
3/16	- 24	58	16	22	5.00	4.00	7	3	3.7	T451 0476	T452 0476	T453 0476	T905 0476					
7/32	- 24(WHIT)	62	17	23	5.60	4.50	7	3	4.5	T451 0556	T452 0556	T453 0556	T905 0556					
1/4	- 20	66	19	25	6.30	5.00	8	3	5.1	T451 0635	T452 0635	T453 0635	T905 0635					
5/16	- 18	72	22	30	8.00	6.30	9	4	6.5	T451 0794	T452 0794	T453 0794	T905 0794					
3/8	- 16	80	24	33	10.00	8.00	11	4	7.9	T451 0953	T452 0953	T453 0953	T905 0953					
7/16	- 14	85	25	-	8.00	6.30	9	4	9.3	T451 1111	T452 1111	T453 1111	T905 1111					
1/2	- 12	89	29	-	9.00	7.10	10	4	10.5	T451 1270	T452 1270	T453 1270	T905 1270					
9/16	- 12	95	30	-	11.20	9.00	12	4	12.1	T451 1429	T452 1429	T453 1429	T905 1429					
5/8	- 11	102	32	-	12.50	10.00	13	4	13.5	T451 1588	T452 1588	T453 1588	T905 1588					
3/4	- 10	112	37	-	14.00	11.20	14	4	16.25	T451 1905	T452 1905	T453 1905	T905 1905					
7/8	- 9	118	38	-	16.00	12.50	16	4	19.25	T451 2223	T452 2223	T453 2223	T905 2223					
1	- 8	130	45	-	18.00	14.00	18	4	22.0	T451 2540	T452 2540	T453 2540	T905 2540					
1-1/8	- 7	138	48	-	20.00	16.00	20	4	24.75	T451 2858	T452 2858	T453 2858	•					
1-1/4	- 7	151	51	-	22.40	18.00	22	4	28.0	T451 3175	T452 3175	T453 3175	•					
1-1/2	- 6	170	60	-	28.00	22.40	26	4	33.5	T451 3810	T452 3810	T453 3810	•					
1-3/4	- 5	187	67	-	31.50	25.00	28	4	39.0	T451 4445	T452 4445	T453 4445	•					
2	- 4-1/2	200	70	-	35.50	28.00	31	4	44.5	T451 5080	T452 5080	T453 5080	•					

BSW

# Taps BSW, Straight Flute, N



- General purpose use
- Suitable for materials up to 1000N/mm<sup>2</sup>
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d<sub>1</sub>



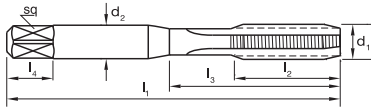
Catalogue Code										<b>T454</b>	<b>T455</b>
Discount Group										D0706	D0706
Material										<b>HSS</b>	<b>HSS</b>
Surface Finish										<b>TIN</b>	<b>TIN</b>
Colour Ring & Application										<b>N</b>	<b>N</b>
Geometry										-	-
Chamfer										<b>Intermediate</b>	<b>Bottoming</b>
Limit & Nut Tolerance										Z3 Medium	Z3 Medium
d <sub>1</sub>	TPI	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>4</sub>	z	drill Ø	Item #	Item #
3/32	- 48(WHIT)	45	10	-	2.80	2.24	5	3	1.85	•	•
1/8	- 40	48	15	15	3.15	2.50	5	3	2.55	T454 0318	T455 0318
5/32	- 32(WHIT)	53	17	17	4.00	3.15	6	3	3.2	T454 0397	T455 0397
3/16	- 24	58	16	22	5.00	4.00	7	3	3.7	T454 0476	T455 0476
7/32	- 24(WHIT)	62	17	23	5.60	4.50	7	3	4.5	•	•
1/4	- 20	66	19	25	6.30	5.00	8	3	5.1	T454 0635	T455 0635
5/16	- 18	72	22	30	8.00	6.30	9	4	6.5	T454 0794	T455 0794
3/8	- 16	80	24	33	10.00	8.00	11	4	7.9	T454 0953	T455 0953
7/16	- 14	85	25	-	8.00	6.30	9	4	9.3	T454 1111	T455 1111
1/2	- 12	89	29	-	9.00	7.10	10	4	10.5	T454 1270	T455 1270
9/16	- 12	95	30	-	11.20	9.00	12	4	12.1	•	•
5/8	- 11	102	32	-	12.50	10.00	13	4	13.5	T454 1588	T455 1588
3/4	- 10	112	37	-	14.00	11.20	14	4	16.25	T454 1905	T455 1905
7/8	- 9	118	38	-	16.00	12.50	16	4	19.25	•	•
1	- 8	130	45	-	18.00	14.00	18	4	22.0	•	•
1-1/8	- 7	138	48	-	20.00	16.00	20	4	24.75	•	•
1-1/4	- 7	151	51	-	22.40	18.00	22	4	28.0	•	•
1-1/2	- 6	170	60	-	28.00	22.40	26	4	33.5	•	•
1-3/4	- 5	187	67	-	31.50	25.00	28	4	39.0	•	•
2	- 4-1/2	200	70	-	35.50	28.00	31	4	44.5	•	•

• Available on request as special manufacture. Subject to lead time.

## Taps BSW, Straight Flute, N, Left Hand



- General purpose use
- Suitable for materials up to 1000N/mm<sup>2</sup>
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d<sub>1</sub>



Catalogue Code	<b>T456</b>
Discount Group	D0702
Material	<b>HSS</b>
Surface Finish	<b>Brt</b>
Colour Ring & Application	<b>N</b>
Geometry	Left Hand
Chamfer	<b>Bottoming</b>
Limit & Nut Tolerance	Z3 LH Medium

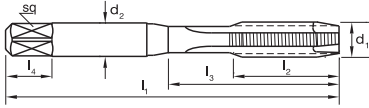
d <sub>1</sub>	TPI	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>4</sub>	z	drill Ø	Item #
1/4	- 20	66	19	25	6.30	5.00	8	3	5.1	T456 0635
5/16	- 18	72	22	30	8.00	6.30	9	4	6.5	T456 0794
3/8	- 16	80	24	33	10.00	8.00	11	4	7.9	T456 0953
7/16	- 14	85	25	-	8.00	6.30	9	4	9.3	T456 1111
1/2	- 12	89	29	-	9.00	7.10	10	4	10.5	T456 1270
9/16	- 12	95	30	-	11.20	9.00	12	4	12.1	T456 1429
5/8	- 11	102	32	-	12.50	10.00	13	4	13.5	T456 1588
3/4	- 10	112	37	-	14.00	11.20	14	4	16.25	T456 1905

**BSW**

# Taps BSW, Gun, N



- General purpose use
- Suitable for materials up to 1000N/mm<sup>2</sup>
- Through holes
- Depths up to approx. 3 x d<sub>1</sub>



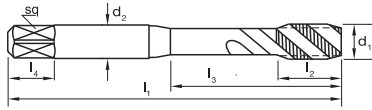
Catalogue Code											T457	T458	T459
Discount Group											D0702	D0702	D0706
Material											HSSE V3	HSSE V3	HSSE V3
Surface Finish											<b>Brt</b>	<b>Blu</b>	<b>TIN</b>
Colour Ring & Application											N	N	N
Geometry											-	-	-
Chamfer											Intermediate	Intermediate	Intermediate
Limit & Nut Tolerance											Z3 Medium	Z3 Medium	Z3 Medium
d <sub>1</sub>	TPI	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>4</sub>	z	drill Ø		Item #	Item #	Item #
1/8	- 40	48	15	15	3.15	2.50	5	2	2.55		T457 0318	T458 0318	T459 0318
5/32	- 32(WHIT)	53	17	17	4.00	3.15	6	3	3.2		T457 0397	T458 0397	T459 0397
3/16	- 24	58	16	22	5.00	4.00	7	3	3.7		T457 0476	T458 0476	T459 0476
1/4	- 20	66	19	25	6.30	5.00	8	3	5.1		T457 0635	T458 0635	T459 0635
5/16	- 18	72	22	30	8.00	6.30	9	3	6.5		T457 0794	T458 0794	T459 0794
3/8	- 16	80	24	33	10.00	8.00	11	3	7.9		T457 0953	T458 0953	T459 0953
7/16	- 14	85	25	-	8.00	6.30	9	3	9.3		T457 1111	T458 1111	•
1/2	- 12	89	29	-	9.00	7.10	10	3	10.5		T457 1270	T458 1270	T459 1270
5/8	- 11	102	32	-	12.50	10.00	13	3	13.5		T457 1588	T458 1588	T459 1588
3/4	- 10	112	37	-	14.00	11.20	14	4	16.25		T457 1905	T458 1905	T459 1905
7/8	- 9	118	38	-	16.00	12.50	16	4	19.25		•	T458 2223	•
1	- 8	130	45	-	18.00	14.00	18	4	22.0		•	T458 2540	•

• Available on request as special manufacture. Subject to lead time.

# Taps BSW, Spiral Flute, N



- General purpose use
- Suitable for materials up to 1000N/mm<sup>2</sup>
- Blind holes
- Depths up to approx. 2.5 x d<sub>1</sub>



Catalogue Code											T460	T461	T462
Discount Group											D0702	D0702	D0706
Material											HSSE V3	HSSE V3	HSSE V3
Surface Finish											<b>Brt</b>	<b>Blu</b>	<b>TiN</b>
Colour Ring & Application											N	N	N
Geometry											-	-	-
Chamfer											Bottoming	Bottoming	Bottoming
Limit & Nut Tolerance											Z3 Medium	Z3 Medium	Z3 Medium
d <sub>1</sub>	TPI	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>4</sub>	z	drill Ø		Item #	Item #	Item #
1/8	- 40	48	6	15	3.15	2.50	5	3	2.55		T460 0318	•	•
5/32	- 32(WHIT)	53	7	17	4.00	3.15	6	3	3.2		T460 0397	•	•
3/16	- 24	58	11	22	5.00	4.00	7	3	3.7		T460 0476	•	T462 0476
1/4	- 20	66	10	25	6.30	5.00	8	3	5.1		T460 0635	T461 0635	T462 0635
5/16	- 18	72	13	30	8.00	6.30	9	3	6.5		T460 0794	T461 0794	T462 0794
3/8	- 16	80	16	33	10.00	8.00	11	3	7.9		T460 0953	T461 0953	T462 0953
7/16	- 14	85	18	-	8.00	6.30	9	3	9.3		T460 1111	T461 1111	•
1/2	- 12	89	20	-	9.00	7.10	10	3	10.5		T460 1270	T461 1270	T462 1270
5/8	- 11	102	20	-	12.50	10.00	13	3	13.5		T460 1588	T461 1588	T462 1588
3/4	- 10	112	25	-	14.00	11.20	14	4	16.25		T460 1905	T461 1905	•
7/8	- 9	118	28	-	16.00	12.50	16	4	19.25		T460 2223	•	•
1	- 8	130	35	-	18.00	14.00	18	4	22.0		T460 2540	•	•

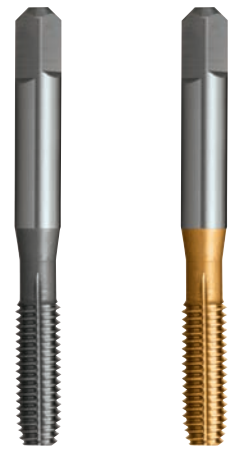
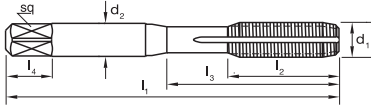
• Available on request as special manufacture. Subject to lead time.



# Taps BSW, Forming, Single Coolant Groove



- For cold forming of threads in materials with good flow characteristics
- Through or Blind holes
- Depths up to approx. 1.5 x d<sub>1</sub>
- TiN for longer tool life



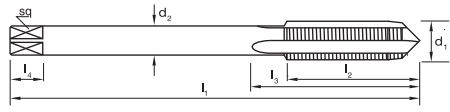
Catalogue Code											T463	T464
Discount Group											D0702	D0706
Material											HSSE V3	HSSE V3
Surface Finish											<b>Brt</b>	<b>TiN</b>
Colour Ring & Application											N	N
Geometry											Single Coolant Groove	Single Coolant Groove
Chamfer											Short	Short
Limit & Nut Tolerance											Z3 Medium	Z3 Medium
d <sub>1</sub>	TPI	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>4</sub>	z	drill Ø		Item #	Item #
1/8	- 40	48	15	15	3.15	2.50	5	-	2.9		T463 0318	•
5/32	- 32(WHIT)	53	17	17	4.00	3.15	6	-	3.6		T463 0397	T464 0397
3/16	- 24	58	16	22	5.00	4.00	7	-	4.3		T463 0476	T464 0476
1/4	- 20	66	19	25	6.30	5.00	8	-	5.8		T463 0635	•
5/16	- 18	72	22	30	8.00	6.30	9	-	7.3		T463 0794	•
3/8	- 16	80	24	33	10.00	8.00	11	-	8.8		T463 0953	•

• Available on request as special manufacture. Subject to lead time.

# Taps BSW, Machine Nut, Long Shank



- Suited to long reach applications
- Suitable for materials up to 1000N/mm<sup>2</sup>m<sup>2</sup>
- Through holes
- Depths up to approx. 2 x d<sub>1</sub>

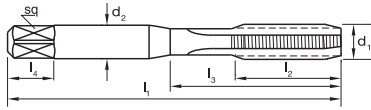


<b>Catalogue Code</b>											<b>T465</b>
<b>Discount Group</b>											D0702
<b>Material</b>											<b>HSS</b>
<b>Surface Finish</b>											<b>Brt</b>
<b>Colour Ring &amp; Application</b>											<b>N</b>
<b>Geometry</b>											-
<b>Chamfer</b>											<b>Bottoming</b>
<b>Limit &amp; Nut Tolerance</b>											Z3 Medium
d <sub>1</sub>	TPI	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>4</sub>	z	drill Ø	Item #	
1/4	- 20	110	38	-	4.5	3.55	6	4	5.1	T465 0635	
5/16	- 18	125	43	-	6	4.5	7	4	6.5	T465 0794	
3/8	- 16	140	48	-	7	5.6	8	4	7.9	T465 0953	
1/2	- 12	180	59	-	9.5	7.5	10	4	10.5	T465 1270	
5/8	- 11	200	70	-	12.5	10.0	13	4	13.5	T465 1588	
3/4	- 10	250	76	-	14	11.2	14	4	16.25	T465 1905	
1	- 8	280	95	-	18	14.0	18	4	22.0	T465 2540	

# Taps BSF, BA & BSB, Straight Flute, N



- General purpose use
- Suitable for materials up to 1000N/mm<sup>2</sup>
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d<sub>1</sub>



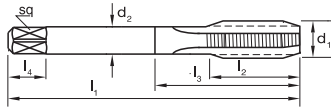
Catalogue Code										D0702	D0702	D0702	D0702
Discount Group													
Material										HSS			
Surface Finish										Brt			
Colour Ring & Application										N			
Geometry										-			
Chamfer										Taper			
Limit & Nut Tolerance										Z3 Medium			
d <sub>1</sub>	TPI	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>1</sub>	z	drill Ø	Item #	Item #	Item #	Item #
<b>BSF</b>										<b>T466</b>	<b>T467</b>	<b>T468</b>	<b>T906</b>
3/16	- 32	58	16	22	5.00	4.00	7	3	4.0	T466 0476	T467 0476	T468 0476	T906 0476
1/4	- 26	66	19	25	6.30	5.00	8	3	5.3	T466 0635	T467 0635	T468 0635	T906 0635
5/16	- 22	72	22	30	8.00	6.30	9	4	6.8	T466 0794	T467 0794	T468 0794	T906 0794
3/8	- 20	80	24	33	10.00	8.00	11	4	8.3	T466 0953	T467 0953	T468 0953	T906 0953
7/16	- 18	85	25	-	8.00	6.30	9	4	9.8	T466 1111	T467 1111	T468 1111	T906 1111
1/2	- 16	89	29	-	9.00	7.10	10	4	11.0	T466 1270	T467 1270	T468 1270	T906 1270
9/16	- 16	95	30	-	11.20	9.00	12	4	12.7	T466 1429	T467 1429	T468 1429	•
5/8	- 14	102	32	-	12.50	10.00	13	4	14.0	T466 1588	T467 1588	T468 1588	•
3/4	- 12	112	37	-	14.00	11.20	14	4	16.75	T466 1905	T467 1905	T468 1905	•
7/8	- 11	118	38	-	16.00	12.50	16	4	19.75	T466 2223	T467 2223	T468 2223	•
1	- 10	130	45	-	18.00	14.00	18	4	22.75	T466 2540	T467 2540	T468 2540	•
<b>BA</b>										<b>T469</b>	<b>T470</b>	<b>T471</b>	<b>T907</b>
0	- 1	66	19	26	6.30	5.00	8	3	5.1	T469 0600	T470 0600	T471 0600	•
1	- 0.90	62	17	23	5.60	4.50	7	3	4.5	T469 0530	T470 0530	T471 0530	T907 0530
2	- 0.81	58	16	22	5.00	4.00	7	3	4.0	T469 0470	T470 0470	T471 0470	T907 0470
3	- 0.73	53	13	18	4.50	3.55	6	3	3.4	T469 0410	T470 0410	T471 0410	T907 0410
4	- 0.66	50	17	-	3.55	2.80	5	3	3.0	T469 0360	T470 0360	T471 0360	T907 0360
5	- 0.59	48	15	-	3.15	2.50	5	3	2.65	T469 0320	T470 0320	T471 0320	T907 0320
6	- 0.53	48	15	-	3.15	2.50	5	3	2.3	T469 0280	T470 0280	T471 0280	T907 0280
7	- 0.48	45	10	-	2.80	2.24	5	3	2.05	T469 0250	T470 0250	T471 0250	T907 0250
8	- 0.43	45	10	-	2.80	2.24	5	3	1.8	T469 0220	T470 0220	T471 0220	T907 0220
9	- 0.39	41	8	-	2.50	2.00	4	3	1.55	T469 0190	T470 0190	T471 0190	T907 0190
10	- 0.35	41	8	-	2.50	2.00	4	3	1.4	T469 0170	T470 0170	T471 0170	T907 0170
<b>BSB - Brass Series</b>										<b>T472</b>	<b>T473</b>	<b>T474</b>	<b>T908</b>
1/4	- 26(BSF)	66	19	25	6.30	5.00	8	3	5.2	T466 0635	T467 0635	T468 0635	T906 0635
5/16*	- 26	72	22	30	8.00	6.30	9	4	6.8	T472 0794	T473 0794	T474 0794	T908 0794
3/8*	- 26	80	24	33	10.00	8.00	11	4	8.4	T472 0953	T473 0953	T474 0953	T908 0953
7/16*	- 26	85	25	-	8.00	6.30	9	4	10.0	T472 1111	T473 1111	T474 1111	T908 1111
1/2*	- 26	89	29	-	9.00	7.10	10	4	11.6	T472 1270	T473 1270	T474 1270	T908 1270
9/16*	- 26	95	30	-	11.20	9.00	12	4	13.2	•	•	T474 1429	•
5/8*	- 26	102	32	-	12.50	10.00	13	4	14.8	•	•	T474 1588	•
3/4*	- 26	112	37	-	14.00	11.20	14	4	18.0	•	•	T474 1905	•
7/8*	- 26	118	38	-	16.00	12.50	16	4	20.8	•	•	T474 2223	•
1*	- 26	130	45	-	18.00	14.00	18	4	24.3	•	•	T474 2540	•

• Available on request as special manufacture. Subject to lead time.  
\* Limit & Nut Tolerance = Z4

## Taps G (BSPF), Pipe, Straight Flute



- General purpose use
- Suitable for materials up to 1000N/mm<sup>2</sup>
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d<sub>1</sub>



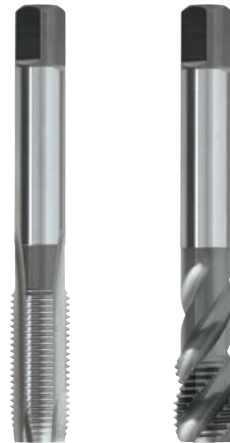
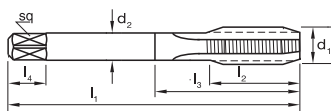
Catalogue Code	T479		T480		T481		T909							
Discount Group	D0702		D0702		D0702		D0702							
Surface Finish	<b>Br</b>		<b>Br</b>		<b>Br</b>		<b>Br</b>							
Colour Ring & Application	<b>N</b>		<b>N</b>		<b>N</b>		<b>N</b>							
Geometry	-		-		-		-							
Chamfer	<b>Taper</b>		<b>Intermediate</b>		<b>Bottoming</b>		<b>Set</b>							
Limit & Nut Tolerance	Z3		Z3		Z3		Z3							
d <sub>1</sub>	TPI	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>4</sub>	z	drill Ø	Item #	Item #	Item #	Item #	
<b>G Series (BSPF) Straight Flute Parallel, Mechanical Fastening</b>														
1/8	-	28	59	15	-	8.0	6.3	9	4	8.8	T479 0973	T480 0973	T481 0973	T909 0973
1/4	-	19	67	19	-	10.0	8.0	11	4	11.8	T479 1316	T480 1316	T481 1316	T909 1316
3/8	-	19	75	21	-	12.5	10.0	13	4	15.3	T479 1666	T480 1666	T481 1666	T909 1666
1/2	-	14	87	26	-	16.0	12.5	16	4	19.0	T479 2096	T480 2096	T481 2096	T909 2096
5/8	-	14	91	26	-	18.0	14.0	18	4	21.0	T479 2291	T480 2291	T481 2291	T909 2291
3/4	-	14	96	28	-	20.0	16.0	20	4	24.5	T479 2644	T480 2644	T481 2644	T909 2644
7/8	-	14	102	29	-	22.4	18.0	22	4	28.5	T479 3020	T480 3020	T481 3020	•
1	-	11	109	33	-	25.0	20.0	24	4	31.0	T479 3325	T480 3325	T481 3325	T909 3325
1-1/4	-	11	119	36	-	31.5	25.0	28	4	39.5	T479 4191	T480 4191	T481 4191	•
1-1/2	-	11	125	37	-	35.5	28.0	31	4	45.5	T479 4780	T480 4780	T481 4780	•
1-3/4	-	11	132	39	-	35.5	28.0	31	6	51.5	T479 5375	T480 5375	T481 5375	•
2	-	11	140	41	-	40.0	31.5	34	6	57.5	T479 5961	T480 5961	T481 5961	•

G (BSPF)

## Taps G (BSPF), Pipe, Gun & Spiral Flute



- General purpose use
- Suitable for materials up to 1000N/mm<sup>2</sup>
- Through & blind holes
- Depths up to approx. 1 x d<sub>1</sub>



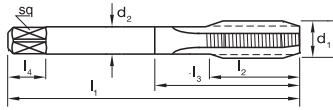
d <sub>1</sub>	TPI	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>4</sub>	z	drill Ø	Item #	Item #	
<b>G Series (BSPF)</b>												
1/8	-	28	80	24	33	10	8	11	3	8.8	T484 0973	T485 0973
1/4	-	19	95	30	-	11.2	9	12	3	11.8	T484 1316	T485 1316
3/8	-	19	112	37	-	14	11.2	14	4	15.3	T484 1666	T485 1666
1/2	-	14	118	38	-	16	12.5	16	4	19.0	T484 2096	T485 2096
3/4	-	14	135	45	-	20	16	20	4	24.5	T484 2644	T485 2644

• Available on request as special manufacture. Subject to lead time.

# Taps G (BSPF), Pipe, Straight Flute



- General purpose use
- Suitable for materials up to 1000N/mm<sup>2</sup>
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d<sub>1</sub>



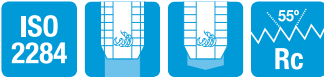
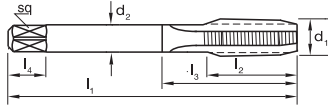
Catalogue Code											<b>T482</b>	<b>T483</b>
Discount Group											D0706	D0706
Material											<b>HSS</b>	<b>HSS</b>
Surface Finish											<b>TIN</b>	<b>TIN</b>
Colour Ring & Application											<b>N</b>	<b>N</b>
Geometry											-	-
Chamfer											<b>Intermediate</b>	<b>Bottoming</b>
Limit & Nut Tolerance											Z3	Z3
d <sub>1</sub>	TPI	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>4</sub>	z	drill Ø		Item #	Item #
<b>G Series (BSPF) Straight Flute Parallel, Mechanical Fastening</b>												
1/8	- 28	59	15	-	8.0	6.3	9	4	8.8		T482 0973	T483 0973
1/4	- 19	67	19	-	10.0	8.0	11	4	11.8		T482 1316	T483 1316
3/8	- 19	75	21	-	12.5	10.0	13	4	15.3		T482 1666	T483 1666
1/2	- 14	87	26	-	16.0	12.5	16	4	19.0		T482 2096	T483 2096
5/8	- 14	91	26	-	18.0	14.0	18	4	21.0	•	•	•
3/4	- 14	96	28	-	20.0	16.0	20	4	24.5	•	•	T483 2644
7/8	- 14	102	29	-	22.4	18.0	22	4	28.5	•	•	•
1	- 11	109	33	-	25.0	20.0	24	4	31.0	•	•	•
1-1/4	- 11	119	36	-	31.5	25.0	28	4	39.5	•	•	•
1-1/2	- 11	125	37	-	35.5	28.0	31	4	45.5	•	•	•
1-3/4	- 11	132	39	-	35.5	28.0	31	6	51.5	•	•	•
2	- 11	140	41	-	40.0	31.5	34	6	57.5	•	•	•

• Available on request as special manufacture. Subject to lead time.

## Taps Rc (BSPT), Pipe, Straight Flute



- General purpose use
- Suitable for materials up to 1000N/mm<sup>2</sup>
- Through & blind holes
- Suitable for both hand and machine operations
- Taper pipe reamer recommended prior to tapping Rc (BSPT) thread forms

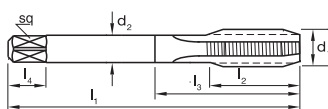


<b>Catalogue Code</b>	<b>T475</b>	<b>T476</b>									
<b>Discount Group</b>	D0702	D0706									
<b>Material</b>	<b>HSS</b>	<b>HSS</b>									
<b>Surface Finish</b>	<b>Brt</b>	<b>TiN</b>									
<b>Colour Ring &amp; Application</b>	<b>N</b>	<b>N</b>									
<b>Geometry</b>	-	-									
<b>Chamfer</b>	<b>Bottoming</b>	<b>Bottoming</b>									
<b>Limit &amp; Nut Tolerance</b>	To Suit	To Suit									
<b>d<sub>1</sub></b> <b>TPI</b> <b>l<sub>1</sub></b> <b>l<sub>2</sub></b> <b>l<sub>3</sub></b> <b>d<sub>2</sub></b> <b>sq</b> <b>l<sub>4</sub></b> <b>z</b> <b>drill Ø</b>	<b>Item #</b>	<b>Item #</b>									
<b>Rc (BSPT) 1:16 Taper Rate</b>											
1/8	28	59	15	-	8.0	6.3	9	4	8.4	T475 0973	T476 0973
1/4	19	67	19	-	10.0	8.0	11	4	10.8	T475 1316	T476 1316
3/8	19	75	21	-	12.5	10.0	13	4	14.5	T475 1666	T476 1666
1/2	14	87	26	-	16.0	12.5	16	4	18.0	T475 2096	T476 2096
3/4	14	96	28	-	20.0	16.0	20	4	23.0	T475 2644	•
1	11	109	33	-	25.0	20.0	24	5	29.0	T475 3325	•
1-1/4	11	119	36	-	31.5	25.0	28	5	38.0	T475 4191	•
1-1/2	11	125	37	-	35.5	28.0	31	7	44.0	T475 4780	•
2	11	140	41	-	40.0	31.5	34	7	55.0	T475 5961	•

## Taps Rp & Pg Series, Pipe, Straight Flute



- General Purpose use for materials up to approx. 1000 N/mm<sup>2</sup>
- Through & blind holes
- Suitable for both hand and machine operations



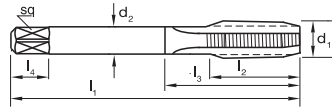
<b>d<sub>1</sub></b> <b>TPI</b> <b>l<sub>1</sub></b> <b>l<sub>2</sub></b> <b>l<sub>3</sub></b> <b>d<sub>2</sub></b> <b>sq</b> <b>l<sub>4</sub></b> <b>z</b> <b>drill Ø</b> <b>Nominal OD</b>	<b>Item #</b>	<b>Item #</b>										
<b>Rp Series (BSPPL) Sealing Pipe Thread Parallel</b>												
1/8	28	59	15	-	8.0	6.3	9	4	8.6	-	T477 0973	
1/4	19	67	19	-	10.0	8.0	11	4	11.5	-	T477 1316	
3/8	19	75	21	-	12.5	10.0	13	4	15.0	-	T477 1666	
1/2	14	87	26	-	16.0	12.5	16	4	18.5	-	T477 2096	
3/4	14	96	28	-	20.0	16.0	20	4	24.0	-	T477 2644	
1	11	109	33	-	25.0	20.0	24	4	30.2	-	T477 3325	
1-1/4	11	119	36	-	31.5	25.0	28	4	39.0	-	T477 4191	
1-1/2	11	125	37	-	35.5	28.0	31	4	45.0	-	T477 4780	
2	11	140	41	-	40.0	31.5	34	4	56.4	-	T477 5961	
<b>Pg – Steel Conduit (Armour Pipe)</b>												
Pg 7	20	89	29	-	9	7.1	10	4	11.3	12.5	T478 1250	
Pg 9	18	102	32	-	12.5	10	12	4	13.9	15.2	T478 1520	
Pg 11	18	112	37	-	14	11.2	14	4	17.3	18.6	T478 1860	
Pg 13.5	18	118	38	-	16	12.5	16	4	19.1	20.4	T478 2040	
Pg 16	18	118	38	-	16	12.5	16	4	21.2	22.5	T478 2250	
Pg 21	16	138	48	-	20	16	20	4	26.8	28.3	T478 2830	

• Available on request as special manufacture. Subject to lead time.

# Taps National Pipe Series, Straight Flute



- General purpose use, materials up to approx. 1000 N/mm<sup>2</sup>
- Suitable for both hand and machine operations
- Taper pipe reamer recommended prior to tapping

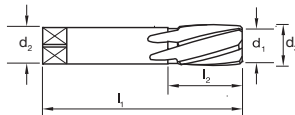


Catalogue Code											D0702
Discount Group											HSS
Material											Colour Temp
Surface Finish											N
Colour Ring & Application											-
Geometry											Bottoming
Chamfer											Refer Limit
Limit & Nut Tolerance											Item #
d <sub>1</sub>	TPI	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>4</sub>	z	Limit	drill Ø	Item #
<b>NPSF (Dryseal Straight)</b>											
1/8	- 27	54	19	-	11.11	8.33	9.5	4	GH3	8.6	T486 1029
1/4	- 18	62	27	-	14.29	10.70	11.1	4	GH4	11.0	T486 1372
3/8	- 18	65	27	-	17.78	13.49	12.7	4	GH4	14.5	T486 1715
1/2	- 14	79	35	-	17.46	13.08	15.9	4	GH5	18.0	T486 2134
<b>NPT (National Pipe Taper) 15° Chamfer (1:16 Taper Rate)</b>											
1/8	- 27	54	19	-	11.11	8.33	9.5	4	-	8.2	T487 1029
1/4	- 18	62	27	-	14.29	10.70	11.1	4	-	10.8	T487 1372
3/8	- 18	65	27	-	17.78	13.49	12.7	4	-	14.0	T487 1715
1/2	- 14	79	35	-	17.46	13.08	15.9	4	-	17.5	T487 2134
3/4	- 14	82	35	-	23.00	17.25	17.5	4	-	23.0	T487 2667
1	- 11-1/2	95	44.5	-	28.60	21.40	20.6	5	-	28.5	T487 3340
1-1/4	- 11-1/2	102	44.5	-	33.30	25.00	23.8	5	-	37.0	T487 4216
<b>NPTF (Dryseal Taper) 15° Chamfer (1:16 Taper Rate)</b>											
1/8	- 27	54	19	-	11.11	8.33	9.5	4	-	8.2	T488 1029
1/4	- 18	62	27	-	14.29	10.70	11.1	4	-	10.8	T488 1372
3/8	- 18	65	27	-	17.78	13.49	12.7	4	-	14.0	T488 1715
1/2	- 14	79	35	-	17.46	13.08	15.9	4	-	17.50	T488 2134

# Reamers Taper Pipe



- Used prior to tapping
- For Rc (BSPT), NPT & NPTF tapered threads
- Prolongs tap life, especially in tough materials



Size	d <sub>1</sub>	l <sub>1</sub>	l <sub>2</sub>	d <sub>3</sub>	d <sub>2</sub>	z	Item #
<b>R108</b>							
1/8	.316	2-11/32	19/32	.353	.315	6	R108 0803
1/4	.406	2-21/32	25/32	.453	.394	6	R108 1031
3/8	.540	2-31/32	7/8	.592	.492	6	R108 1372
1/2	.665	3-7/16	1-1/32	.729	.630	6	R108 1689
3/4	.876	3-25/32	1-1/8	.945	.787	6	R108 2225
1	1.103	4-5/16	1-5/16	1.184	.984	6	R108 2802
1-1/4	1.444	4-11/16	1-7/16	1.529	1.240	6	R108 3668
1-1/2	1.684	4-15/16	1-15/32	1.775	1.398	8	R108 4277
2	2.159	5-17/32	1-5/8	2.260	1.575	8	R108 5484

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