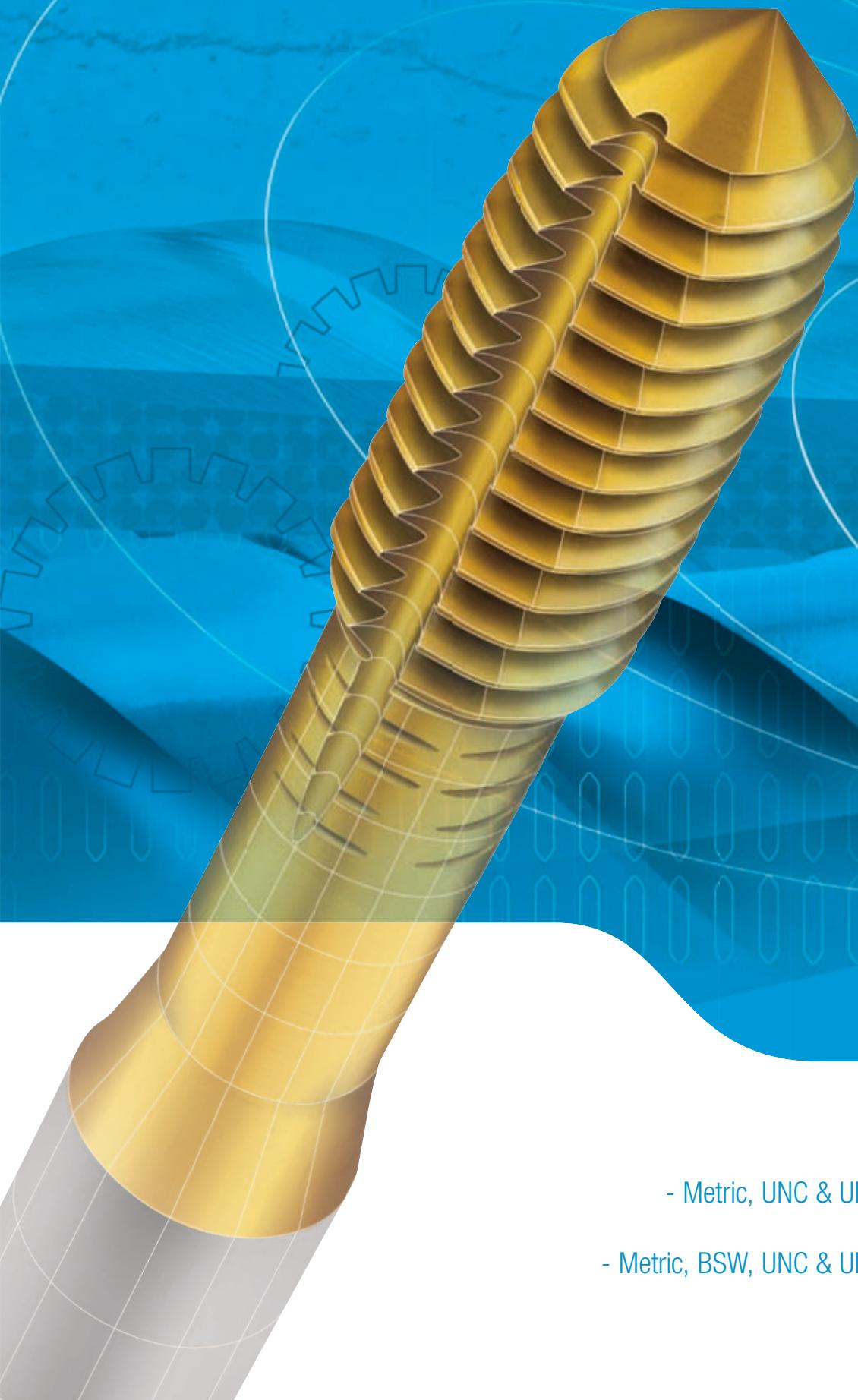


# JIS TAPS

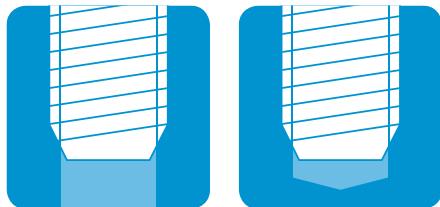


## Taps-JIS *Roll Taps*

- Metric, UNC & UNF standard thread forms
- SP & PO machine taps
- Metric, BSW, UNC & UNF standard thread forms



## For Thread Forming



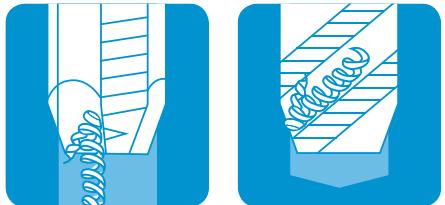
Page	M	Tap Forming, Single Cobalt Groove					
		178	178	178	180	180	180
UNC		200		200	201		201
UNF		204		204	205		205
Material		HSS Co.8			HSS Co.8		
Surface Finish		Ni	Blu	TiN	Ni	Blu	TiN
Colour Ring & Application							
Tapping Depth		$\leq 3 \times \text{D}$					

1.0 Steels	HB	N/mm <sup>2</sup>	% Elong.				
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 alloyed	<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				
2.0 Stainless Steels							
2.1 Free machining	<250	<850	25		●		○
2.2 Austenitic	<250	<850	20		●	○	●
2.3 Ferritic + martensitic	<250	<850	20				
3.0 Cast Irons							
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				
4.0 Titaniums							
4.1 Pure Titanium	<250	<850	20				
4.2 Titanium alloys	>250	>850	20				
5.0 Nickels							
5.1 Nickel alloys	<250	<850	25				
5.2 Nickel alloys	>250	>850	25				
6.0 Coppers							
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		●	○	●
7.0 Aluminiums							
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				
8.0 Plastics							
8.1 Plastics, Thermoplastics, Polyethylene	<340	<50	N				

● Optimal ○ Effective

## For Tapping Through & Blind Holes

Page	M	199	199	198	198
	UNC				
	UNF				
	BSW				
		<i>Tap Straight Flute GG</i>	<i>Tap Straight Flute GG</i>	<i>Tap Straight Flute XH</i>	<i>Tap Straight Flute VH</i>



### Material Surface Finish

### Colour Ring & Application

### Tapping Depth

	HB	N/mm <sup>2</sup>	% Elong.	HSSE V3	SPM	VHM
				Ni	TiCN	TiCN
<b>1.0 Steels</b>				GG	XH	VH
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 alloyed	<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			

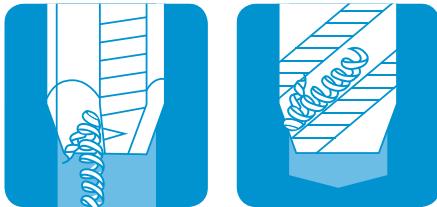
● Optimal ○ Effective



**Page**

M	182	182	182	182	183	184	185	186	187	187	188	188
UNC	202	202	202									
UNF	206	206	206									
BSW	208	208	208	208	209							

**For Tapping Through Holes**



Material Surface Finish Colour Ring & Application Tapping Depth	HSSE V3												PM-HSSE V3		HSSE V3				PM-HSS Co	
	Br	Blu	TiN	TiCN	Br	TiAlN	Ni	CrN	Blu	TiCN	Br	TiCN								
	N					UNI	W	Cu	VA	H										
	≤ 3xØ																			
<b>1.0 Steels</b>	HB	N/mm <sup>2</sup>	% Elong.																	
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 alloyed	<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	●	●	●		●	●	●	●	●	●	○	○	○				

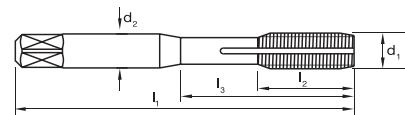
## Taps Finder-For Tapping Blind Holes

Tap Spiral Flute, R40 N															
Tap Spiral Flute, R40 N															
Tap Spiral Flute, R40 N															
Tap Spiral Flute, R40 N Extra Length															
189	189	189	189	190	191	192	193	194	195	195	195	196	197	197	197
203	203	203													
207	207	207													
210	210	210	210	210	211										
HSSE V3					PM-HSSE V3	HSSE V3					PM-HSSE V3	PM-HSS Co			
Brt	Blu	TiN	TiCN	Brt	TiAIN	Brt	Ni	CrN	Blu	TiCN	Brt	TiCN			
N					UNI	Al	W	Cu	VA	VADH	VA PM	H			
$\leq 2.5 \times \emptyset$															
●	●	●	●	●	●	●	●	●	●	●	●	●			
●	●	●	●	●	●	○	●	●	●	●	○	○			
○	●	●	●	○	●	○	○	○	○	○	●	○	●		
○	○	●	●	○	○	●	○	○	○	○	○	○	●		
	○				●										
					○										
●	○	○	●	○	○	○			●	●	●	●			
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●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●

## JIS Taps Metric, Forming, Single Coolant Groove



- For cold forming of threads in materials with good flow characteristics
- Brt-For non-ferrous materials
- Blue-For ferrous materials
- TiN-For steel materials up to 1000 N/mm<sup>2</sup>
- TiCN-For difficult materials
- Depths up to approx. 3 x d<sub>1</sub>



Catalogue Code Size Ref.

**T500** **0100**

Item #

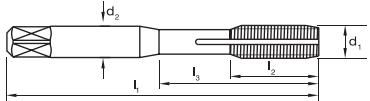
Size Ref.	d <sub>1</sub>	Pitch	Limit	Style*	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	z	Tap hole min/max	Catalogue Code	T510 D0606	T512 D0606	T514 D0614
												Discount Group	HSS Co.8	HSS Co.8	HSS Co.8
												Material	Ni	Blu	TiN
Geometry	Lead	Colour Ring & Application	General Production	General Production	Medium Production										
											Lead	1 Coolant Groove M3+	1 Coolant Groove M3+	1 Coolant Groove M3+	
													4 x P	4 x P	4 x P
<b>P Lead</b>															
<b>0100</b>	M 1	x 0.25	GH4	1	30	7	-	3.0	2.5	4	0.86-0.90		T510 0100	T512 0100	T514 0100
<b>0110</b>	M 1.1	x 0.25	GH4	1	32	7	-	3.0	3.0	4	0.96-1.00		T510 0110	T512 0110	T514 0110
<b>0120</b>	M 1.2	x 0.25	GH4	1	32	7	-	3.0	2.5	4	1.10-1.06		T510 0120	T512 0120	T514 0120
<b>0140</b>	M 1.4	x 0.30	GH4	1	34	7	-	3.0	2.5	4	1.23-1.28		T510 0140	T512 0140	T514 0140
<b>0145</b>	M 1.4	x 0.30	GH5	1	34	9	-	3.0	2.5	4	1.24-1.29		•	•	T514 0145
<b>0160</b>	M 1.6	x 0.35	GH4	1	36	10	-	3.0	2.5	4	1.40-1.46		T510 0160	T512 0160	T514 0160
<b>0170</b>	M 1.7	x 0.35	GH4	1	36	11	-	3.0	2.5	4	1.50-1.56		T510 0170	T512 0170	T514 0170
<b>0175</b>	M 1.7	x 0.35	GH5	1	36	11	-	3.0	2.5	4	1.51-1.57		•	•	T514 0175
<b>0180</b>	M 1.8	x 0.35	GH4	1	36	11	-	3.0	2.5	4	1.60-1.66		T510 0180	T512 0180	T514 0180
<b>0200</b>	M 2	x 0.40	GH4	1	40	12	-	3.0	2.5	4	1.77-1.84		T510 0200	T512 0200	T514 0200
<b>0205</b>	M 2	x 0.40	GH5	1	40	12	-	3.0	2.5	4	1.79-1.85		•	•	T514 0205
<b>0220</b>	M 2.2	x 0.45	GH4	1	42	13	-	3.0	2.5	4	1.95-2.02		T510 0220	T512 0220	T514 0220
<b>0230</b>	M 2.3	x 0.40	GH4	1	42	13	-	3.0	2.5	4	2.07-2.14		T510 0230	T512 0230	T514 0230
<b>0250</b>	M 2.5	x 0.45	GH4	1	44	14	-	3.0	2.5	4	2.25-2.32		T510 0250	T512 0250	T514 0250
<b>0255</b>	M 2.5	x 0.45	GH5	1	44	14	-	3.0	2.5	4	2.26-2.33		T510 0255	T512 0255	T514 0255
<b>0260</b>	M 2.6	x 0.45	GH4	1	44	14	-	3.0	2.5	4	2.35-2.42		T510 0260	T512 0260	T514 0260
<b>0265</b>	M 2.6	x 0.45	GH5	1	44	14	-	3.0	2.5	4	2.36-2.43		T510 0265	T512 0265	
<b>0300</b>	M 3	x 0.50	GH5	2	46	9	19	4.0	3.2	4	2.72-2.80		T510 0300	T512 0300	T514 0300
<b>0306</b>	M 3	x 0.50	GH6	2	46	9	19	4.0	3.2	4	2.73-2.81		T510 0306	T512 0306	T514 0306
<b>0307</b>	M 3	x 0.50	GH7	2	46	9	19	4.0	3.2	4	2.74-2.83		•	•	T514 0307
<b>0350</b>	M 3.5	x 0.60	GH5	2	48	9	23	4.0	3.2	4	3.20-3.25		T510 0350	T512 0350	T514 0350
<b>0356</b>	M 3.5	x 0.60	GH6	2	48	9	23	4.0	3.2	4	3.21-3.26		T510 0356	T512 0356	
<b>0400</b>	M 4	x 0.70	GH6	2	52	10	21	5.0	4.0	4	3.65-3.71		T510 0400	T512 0400	T514 0400
<b>0500</b>	M 5	x 0.80	GH6	2	60	11	24	5.5	4.5	4	4.59-4.66		T510 0500	T512 0500	T514 0500
<b>0600</b>	M 6	x 1.00	GH7	2	62	12	31	6.0	4.5	4	5.49-5.57		T510 0600	T512 0600	T514 0600
<b>0700</b>	M 7	x 1.00	GH7	3	65	18	-	6.2	5.0	4	6.49-6.57		•	•	•
<b>0800</b>	M 8	x 1.25	GH7	3	70	18	-	6.2	5.0	6	7.34-7.44		T510 0800	T512 0800	T514 0800
<b>1000</b>	M 10	x 1.50	GH7	3	75	19	-	7.0	5.5	6	9.18-9.31		T510 1000	T512 1000	T514 1000

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

# JIS Taps Metric, Forming, Single Coolant Groove



- For cold forming of threads in materials with good flow characteristics  
 Brt-For non-ferrous materials  
 Blue-For ferrous materials  
 TiN-For steel materials up to 1000 N/mm<sup>2</sup>  
 TiCN-For difficult materials  
 - Depths up to approx.  $3 \times d_1$



Catalogue Code      Size Ref.

**T500 0100**

Item #

Catalogue Code	T511 D0606	T513 D0606	T515 D0614
Discount Group	HSS Co.8	HSS Co.8	HSS Co.8
Material	Ni	Blu	TiN
Surface Finish			
Colour Ring & Application	General Production	General Production	Medium Production
Geometry			
Lead	1 Coolant Groove M3+	1 Coolant Groove M3+	1 Coolant Groove M3+
	2 x P	2 x P	2 x P

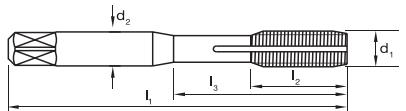
Size Ref.	d <sub>1</sub>	Pitch	Limit	Style <sup>*</sup>	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	z	Tap hole min/max	Item #	Item #	Item #
<b>B Lead</b>														
<b>0100</b>	M 1	x 0.25	GH4	1	30	7	-	3.0	2.5	4	0.86-0.90	T511 0100	T513 0100	T515 0100
<b>0110</b>	M 1.1	x 0.25	GH4	1	32	7	-	3.0	3	4	0.96-1.00	T511 0110	T513 0110	T515 0110
<b>0120</b>	M 1.2	x 0.25	GH4	1	32	7	-	3.0	2.5	4	1.10-1.06	T511 0120	T513 0120	T515 0120
<b>0140</b>	M 1.4	x 0.30	GH4	1	34	7	-	3.0	2.5	4	1.23-1.28	T511 0140	T513 0140	T515 0140
<b>0160</b>	M 1.6	x 0.35	GH4	1	36	10	-	3.0	2.5	4	1.40-1.46	T511 0160	T513 0160	T515 0160
<b>0170</b>	M 1.7	x 0.35	GH4	1	36	11	-	3.0	2.5	4	1.50-1.56	T511 0170	T513 0170	T515 0170
<b>0180</b>	M 1.8	x 0.35	GH4	1	36	11	-	3.0	2.5	4	1.60-1.66	T511 0180	T513 0180	T515 0180
<b>0200</b>	M 2	x 0.40	GH4	1	40	12	-	3.0	2.5	4	1.77-1.84	T511 0200	T513 0200	T515 0200
<b>0220</b>	M 2.2	x 0.45	GH4	1	42	13	-	3.0	2.5	4	1.95-2.02	T511 0220	T513 0220	T515 0220
<b>0230</b>	M 2.3	x 0.40	GH4	1	42	13	-	3.0	2.5	4	2.07-2.14	T511 0230	T513 0230	T515 0230
<b>0250</b>	M 2.5	x 0.45	GH4	1	44	14	-	3.0	2.5	4	2.25-2.32	T511 0250	T513 0250	T515 0250
<b>0255</b>	M 2.5	x 0.45	GH4	1	44	14	-	3.0	2.5	4	2.26-2.33			T515 0255
<b>0260</b>	M 2.6	x 0.45	GH4	1	44	14	-	3.0	2.5	4	2.35-2.42	T511 0260	T513 0260	T515 0260
<b>0300</b>	M 3	x 0.50	GH5	5	46	9	19	4.0	3.2	4	2.72-2.80	T511 0300	T513 0300	T515 0300
<b>0306</b>	M 3	x 0.50	GH6	2	46	9	19	4.0	3.2	4	2.73-2.81			T515 0306
<b>0350</b>	M 3.5	x 0.60	GH5	5	48	9	23	4.0	3.2	4	3.20-3.25	T511 0350	T513 0350	T515 0350
<b>0400</b>	M 4	x 0.70	GH6	5	52	10	21	5.0	4.0	4	3.65-3.71	T511 0400	T513 0400	T515 0400
<b>0500</b>	M 5	x 0.80	GH6	5	60	11	24	5.5	4.5	4	4.59-4.66	T511 0500	T513 0500	T515 0500
<b>0600</b>	M 6	x 1.00	GH7	5	62	12	31	6.0	4.5	4	5.49-5.57	T511 0600	T513 0600	T515 0600
<b>0700</b>	M 7	x 1.00	GH7	3	65	18	-	6.2	5.0	4	6.49-6.57	•	•	•
<b>0800</b>	M 8	x 1.25	GH7	3	70	18	-	6.2	5.0	6	7.34-7.44	T511 0800	T513 0800	T515 0800
<b>1000</b>	M 10	x 1.50	GH7	3	75	19	-	7.0	5.5	6	9.18-9.31	T511 1000	T513 1000	T515 1000

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

## JIS Taps Metric, Forming, Multi Coolant Groove



- For cold forming of threads in materials with good flow characteristics
- Brt-For non-ferrous materials.
- Blue-For ferrous materials.
- TiN-For steel materials up to 1000 N/mm<sup>2</sup>
- TiCN-For difficult materials
- Depths up to approx. 3 x d<sub>1</sub>



Catalogue Code      Size Ref.

**T500** **0100**

Item #

Catalogue Code	T516 D0606	T518 D0606	T520 D0614		
Discount Group	HSS Co.8 <i>Ni</i>	HSS Co.8 <i>Blu</i>	HSS Co.8 <i>TiN</i>		
Material	General Production	General Production	Medium Production		
Surface Finish	Colour Ring & Application				
Geometry	Lead				
Size Ref.	d <sub>1</sub> <b>P Lead</b>	Pitch Limit Style* l <sub>1</sub> l <sub>2</sub> l <sub>3</sub> d <sub>2</sub> sq z Tap hole min/max	Item #	Item #	Item #

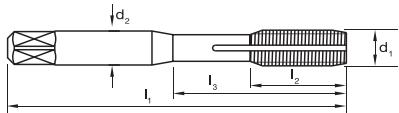
<b>0300</b>	M 3 x 0.50 GH5 2 46 9 19 4.0 3.2 4 2.72-2.80	T516 0300	T518 0300	T520 0300
<b>0350</b>	M 3.5 x 0.60 GH5 2 48 9 23 4.0 3.2 4 3.20-3.25	T516 0350	T518 0350	T520 0350
<b>0400</b>	M 4 x 0.70 GH6 2 52 10 21 5.0 4.0 4 3.65-3.71	T516 0400	T518 0400	T520 0400
<b>0500</b>	M 5 x 0.80 GH6 2 60 11 24 5.5 4.5 4 4.59-4.69	T516 0500	T518 0500	T520 0500
<b>0600</b>	M 6 x 1.00 GH7 2 62 12 31 6.0 4.5 4 5.49-5.57	T516 0600	T518 0600	T520 0600
<b>0800</b>	M 8 x 1.25 GH7 3 70 18 0 6.2 5.0 6 7.33-7.44	T516 0800	T518 0800	T520 0800
<b>1000</b>	M 10 x 1.50 GH7 3 75 19 0 7.0 5.5 6 9.18-9.30	T516 1000	T518 1000	T520 1000
<b>1200</b>	M 12 x 1.75 GH8 3 82 23 0 8.5 6.5 8 11.05-11.19	T516 1200	T518 1200	T520 1200
<b>1400</b>	M 14 x 2.00 GH10 3 88 25 0 10.5 8.0 8 12.92-13.08	T516 1400	T518 1400	T520 1400
<b>1600</b>	M 16 x 2.00 GH10 3 95 27 0 12.5 10.0 8 14.92-15.08	T516 1600	T518 1600	T520 1600
<b>1800</b>	M 18 x 2.50 GH11 3 100 29 0 14.0 11.0 8 16.64-16.84	T516 1800	T518 1800	T520 1800
<b>2000</b>	M 20 x 2.50 GH11 3 105 30 0 15.0 12.0 8 18.64-18.84	T516 2000	T518 2000	T520 2000

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

## **JIS Taps** Metric, Forming, Multi Coolant Groove



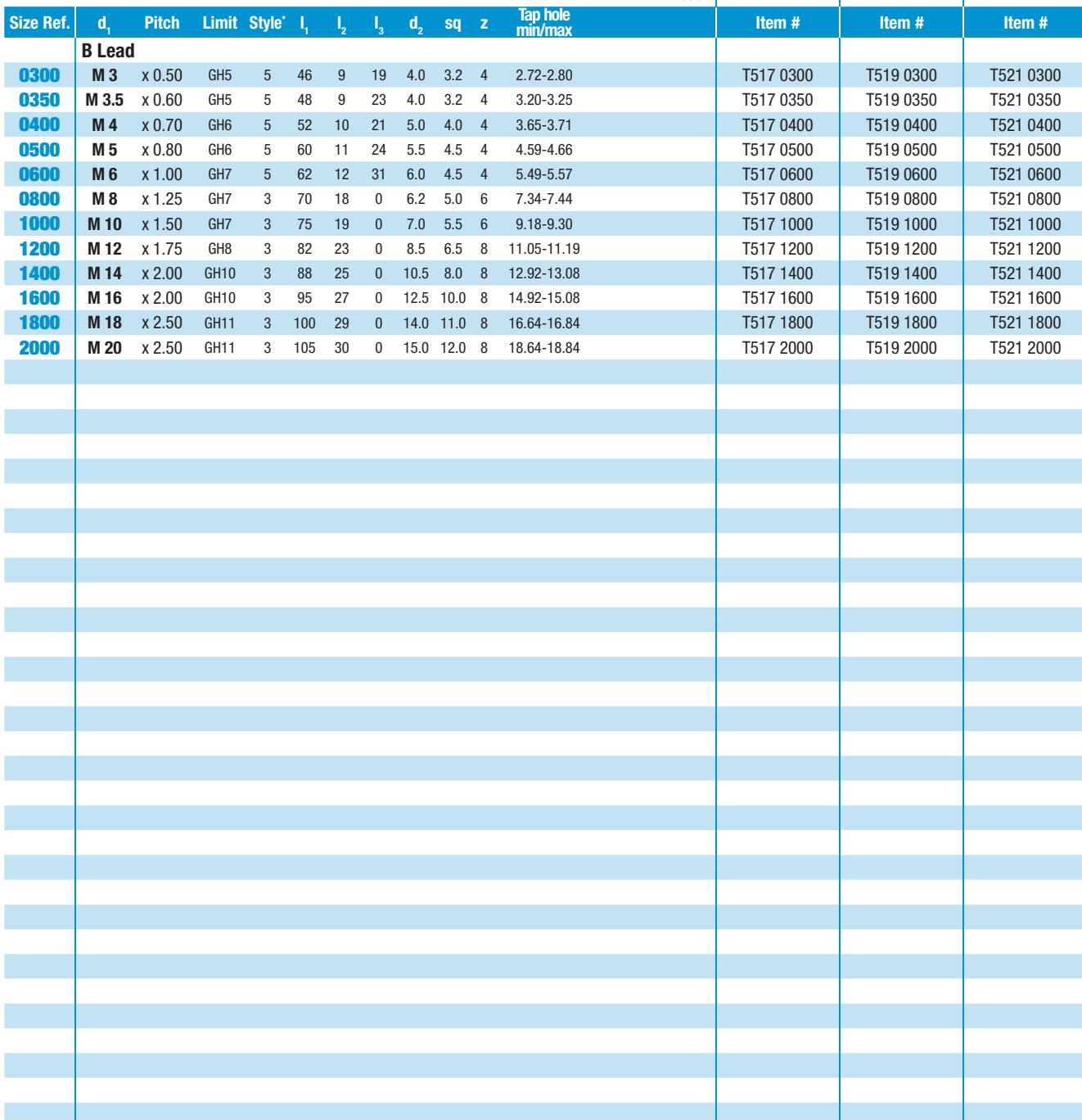
- For cold forming of threads in materials with good flow characteristics  
Brt-For non-ferrous materials.  
Blue-For ferrous materials.  
TiN-For steel materials up to 1000 N/mm<sup>2</sup>  
TiCN-For difficult materials
- Depths up to approx. 3 x d<sub>1</sub>



Catalogue Code      Size Ref.

**T500** **0100**

Item #

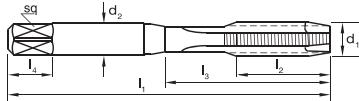


- Available on request as special manufacture. Subject to lead time.

# JIS Taps Metric, Gun, N (Spiral Point)



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



Catalogue Code Size Ref.

**T500 | 0100**

Item #

Catalogue Code

Discount Group

Material

Surface Finish

Colour Ring & Application

Geometry

Lead

**T499**

D0602

**T500**

D0602

**T502**

D0610

**T633**

D0610

**HSSE V3**

**HSSE V3**

**HSSE V3**

**HSSE V3**

**Br**

**Blu**

**TiN**

**TiCN**

**N**

**N**

**N**

**N**

5 x P

5 x P

5 x P

5 x P

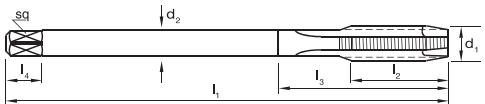
Size Ref.	d <sub>1</sub>	Pitch	Limit	Style*	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	z	drill Ø	Item #	Item #	Item #	Item #
<b>0100</b>	M 1	x 0.25	P1	1	30	7	-	3.0	2.5	2	0.75	T499 0100	•	•	•
<b>0110</b>	M 1.1	x 0.25	P1	1	32	8	-	3.0	2.5	2	0.85	T499 0110	•	•	•
<b>0120</b>	M 1.2	x 0.25	P1	1	32	8	-	3.0	2.5	2	0.95	T499 0120	•	•	•
<b>0140</b>	M 1.4	x 0.30	P1	1	34	9	-	3.0	2.5	2	1.1	T499 0140	•	•	•
<b>0160</b>	M 1.6	x 0.35	P1	1	36	10	-	3.0	2.5	2	1.25	T499 0160	•	•	•
<b>0170</b>	M 1.7	x 0.35	P1	1	36	11	-	3.0	2.5	2	1.35	T499 0170	•	•	•
<b>0180</b>	M 1.8	x 0.35	P1	1	36	11	-	3.0	2.5	2	1.45	T499 0180	•	•	•
<b>0200</b>	M 2	x 0.40	P2	1	40	12	-	3.0	2.5	2	1.60	T499 0200	T500 0200	T502 0200	T633 0200
<b>0220</b>	M 2.2	x 0.45	P2	1	42	13	-	3.0	2.5	2	1.75	T499 0220	T500 0220	•	•
<b>0230</b>	M 2.3	x 0.40	P2	1	42	13	-	3.0	2.5	2	1.9	T499 0230	T500 0230	•	•
<b>0250</b>	M 2.5	x 0.45	P2	1	44	14	-	3.0	2.5	2	2.05	T499 0250	T500 0250	T502 0250	T633 0250
<b>0260</b>	M 2.6	x 0.45	P2	1	44	14	-	3.0	2.5	2	2.15	T499 0260	T500 0260	T502 0260	T633 0260
<b>0300</b>	M 3	x 0.50	P2	2	46	11	19	4.0	3.2	3	2.5	T499 0300	T500 0300	T502 0300	T633 0300
<b>0350</b>	M 3.5	x 0.60	P2	2	48	13	23	4.0	3.2	3	2.9	T499 0350	T500 0350	T502 0350	T633 0350
<b>0400</b>	M 4	x 0.70	P2	2	52	13	21	5.0	4.0	3	3.3	T499 0400	T500 0400	T502 0400	T633 0400
<b>0500</b>	M 5	x 0.80	P2	2	60	16	24	5.5	4.5	3	4.2	T499 0500	T500 0500	T502 0500	T633 0500
<b>0600</b>	M 6	x 1.00	P2	2	62	19	31	6.0	4.5	3	5.0	T499 0600	T500 0600	T502 0600	T633 0600
<b>0700</b>	M 7	x 1.00	P2	3	65	22	-	6.2	5.0	3	6.0	T499 0700	T500 0700	T502 0700	T633 0700
<b>0800</b>	M 8	x 1.25	P3	3	70	22	-	6.2	5.0	3	6.8	T499 0800	T500 0800	T502 0800	T633 0800
<b>1006</b>	MF 10	x 1.25	P3	3	75	24	-	7.0	5.5	3	8.8	T499 1006	T500 1006	T502 1006	T633 1006
<b>1000</b>	M 10	x 1.50	P3	3	75	24	-	7.0	5.5	3	8.5	T499 1000	T500 1000	T502 1000	T633 1000
<b>1200</b>	M 12	x 1.75	P4	3	82	29	-	8.5	6.5	3	10.2	T499 1200	T500 1200	T502 1200	T633 1200
<b>1400</b>	M 14	x 2.00	P4	3	88	30	-	10.5	8.0	3	12.0	T499 1400	T500 1400	T502 1400	T633 1400
<b>1600</b>	M 16	x 2.00	P4	3	95	32	-	12.5	10.0	4	14.0	T499 1600	T500 1600	T502 1600	T633 1600
<b>1800</b>	M 18	x 2.50	P4	3	100	37	-	14.0	11.0	4	15.5	T499 1800	T500 1800	T502 1800	T633 1800
<b>2000</b>	M 20	x 2.50	P4	3	105	37	-	15.0	12.0	4	17.5	T499 2000	T500 2000	T502 2000	T633 2000
<b>2200</b>	M 22	x 2.50	P4	3	115	38	-	17.0	13.0	4	19.5	T499 2200	T500 2200	T502 2200	T633 2200
<b>2400</b>	M 24	x 3.00	P4	3	120	45	-	19.0	15.0	4	21.0	T499 2400	T500 2400	T502 2400	T633 2400

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

## **JIS Taps** Metric, Gun, N, Extra Length (Spiral Point)



- For long reach applications
  - Suitable for materials up to 1000 N/mm<sup>2</sup>
  - Through holes
  - Depths up to 3 x d<sub>1</sub>



Catalogue Code      Size Ref.

T500 0100

Item #

Size Ref.	d <sub>1</sub>	Pitch	Limit	Style*	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	z	drill Ø	Lead		SxT
												Top	Bottom	
<b>0400</b>	M 4	x 0.70	P2	2	100	13	21	5.0	4.0	3	3.3			T501 0400
<b>0500</b>	M 5	x 0.80	P2	2	100	16	24	5.5	4.5	3	4.2			T501 0500
<b>0600</b>	M 6	x 1.00	P2	2	100	19	31	6.0	4.5	3	5.0			T501 0600
<b>0800</b>	M 8	x 1.25	P3	3	100	22	-	6.2	5.0	3	6.8			T501 0800
<b>1000</b>	M 10	x 1.50	P3	3	150	24	-	7.0	5.5	3	8.5			T501 1000
<b>1200</b>	M 12	x 1.75	P3	3	150	29	-	8.5	6.5	3	10.2			T501 1200
<b>1600</b>	M 16	x 2.00	P3	3	200	32	-	12.5	10.0	4	14.0			T501 1600
<b>2000</b>	M 20	x 2.50	P3	3	200	37	-	15.0	12.0	4	17.5			T501 2000

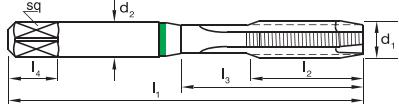
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## JIS Taps Metric, Gun, UNI (Spiral Point)



- Universal use
- Suitable for materials up to 1200 N/mm<sup>2</sup>
- Through holes
- Depths up to 3 x d<sub>1</sub>

Sutton Tools



Catalogue Code    Size Ref.

**T500 0100**

Item #

Catalogue Code	<b>T605</b>
Discount Group	D0610
Material	PM-HSSE V3
Surface Finish	TiAIN
Colour Ring & Application	UNI
Geometry	
Lead	5 x P

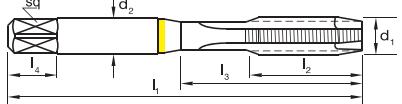
Size Ref.	d <sub>1</sub>	Pitch	Limit	Style*	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	z	drill Ø
<b>0200</b>	M 2	x 0.40	P2	1	40	12	-	3.0	2.5	2	1.60
<b>0250</b>	M 2.5	x 0.45	P2	1	44	14	-	3.0	2.5	2	2.05
<b>0260</b>	M 2.6	x 0.45	P2	1	44	14	-	3.0	2.5	2	2.15
<b>0300</b>	M 3	x 0.50	P2	2	46	11	19	4.0	3.2	3	2.5
<b>0350</b>	M 3.5	x 0.60	P2	2	48	13	23	4.0	3.2	3	2.9
<b>0400</b>	M 4	x 0.70	P2	2	52	13	21	5.0	4.0	3	3.3
<b>0500</b>	M 5	x 0.80	P2	2	60	16	24	5.5	4.5	3	4.2
<b>0600</b>	M 6	x 1.00	P2	2	62	19	31	6.0	4.5	3	5.0
<b>0700</b>	M 7	x 1.00	P2	3	65	22	-	6.2	5.0	3	6.0
<b>0800</b>	M 8	x 1.25	P3	3	70	22	-	6.2	5.0	3	6.8
<b>1000</b>	M 10	x 1.50	P3	3	75	24	-	7.0	5.5	3	8.5

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

## **JIS Taps** Metric, Gun, W (Spiral Point)



- For use in soft materials
  - Through holes
  - Depths up to  $3 \times d_1$



Catalogue Code      Size Ref.

T500 Q100

▼ Item #

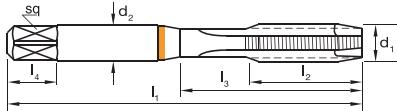
Size Ref.	d <sub>1</sub>	Pitch	Limit	Style*	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	z	drill Ø	Lead	3 x P
												Item #	
<b>0200</b>	M 2	x 0.40	P2	1	40	12	-	3.0	2.5	2	1.60		T546 0200
<b>0250</b>	M 2.5	x 0.45	P2	1	44	14	-	3.0	2.5	2	2.05		T546 0250
<b>0300</b>	M 3	x 0.50	P2	2	46	11	19	4.0	3.2	3	2.5		T546 0300
<b>0400</b>	M 4	x 0.70	P2	2	52	13	21	5.0	4.0	3	3.3		T546 0400
<b>0500</b>	M 5	x 0.80	P2	2	60	16	24	5.5	4.5	3	4.2		T546 0500
<b>0600</b>	M 6	x 1.00	P2	2	62	19	31	6.0	4.5	3	5.0		T546 0600
<b>0800</b>	M 8	x 1.25	P3	3	70	22	-	6.2	5.0	3	6.8		T546 0800
<b>1000</b>	M 10	x 1.50	P3	3	75	24	-	7.0	5.5	3	8.5		T546 1000

1

## **JIS Taps** Metric, Gun, Cu (Spiral Point)



- For copper and copper alloys
- Through holes
- Depths up to  $3 \times d_1$



Catalogue Code      Size Ref.

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T500 0100

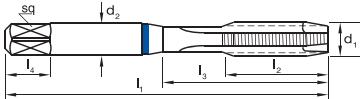
Item #

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

## **JIS Taps** Metric, Gun, VA (Spiral Point)



- Use in stainless steels and high strength steels
  - Suitable for materials up to 850 N/mm<sup>2</sup>
  - Through holes
  - Depths up to 3 x d<sub>1</sub>



Catalogue Code      Size Ref

T500 0100

Item #

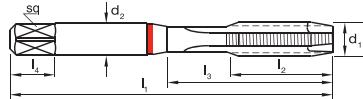


- Available on request as special manufacture. Subject to lead time.

## **JIS Taps** Metric, Gun, H (Spiral Point)



- For harder short chipping materials
- Suitable for materials up to 45 HR<sub>c</sub>
- Through holes
- Depths up to  $3 \times d_1$



Catalogue Code      Size Ref.

Item #

T500 0100

Size Ref.	d <sub>1</sub>	Pitch	Limit	Style*	I <sub>1</sub>	I <sub>2</sub>	I <sub>3</sub>	d <sub>2</sub>	sq	z	drill Ø
<b>0200</b>	<b>M 2</b>	x 0.40	P2	1	40	12	-	3.0	2.5	2	1.6
<b>0250</b>	<b>M 2.5</b>	x 0.45	P2	1	44	14	-	3.0	2.5	2	2.05
<b>0300</b>	<b>M 3</b>	x 0.50	P3	2	46	11	19	4.0	3.2	3	2.5
<b>0350</b>	<b>M 3.5</b>	x 0.60	P3	2	48	13	23	4.0	3.2	3	2.9
<b>0400</b>	<b>M 4</b>	x 0.70	P3	2	52	13	21	5.0	4.0	3	3.3
<b>0500</b>	<b>M 5</b>	x 0.80	P3	2	60	16	24	5.5	4.5	3	4.2
<b>0600</b>	<b>M 6</b>	x 1.00	P2	2	62	19	31	6.0	4.5	3	5.0
<b>0800</b>	<b>M 8</b>	x 1.25	P3	3	70	22		6.2	5.0	3	6.8
<b>1000</b>	<b>M 10</b>	x 1.50	P3	3	75	24		7.0	5.5	3	8.5
<b>1200</b>	<b>M 12</b>	x 1.75	P3	3	82	29		8.5	6.5	3	10.2
<b>1400</b>	<b>M 14</b>	x 2.00	P4	3	88	30		10.5	8.0	3	12.0
<b>1600</b>	<b>M 16</b>	x 2.00	P4	3	95	32		12.5	10.0	4	14.0
<b>1800</b>	<b>M 18</b>	x 2.50	P4	3	100	37		14.0	11.0	4	15.5
<b>2000</b>	<b>M 20</b>	x 2.50	P4	3	105	37		15.0	12.0	4	17.5

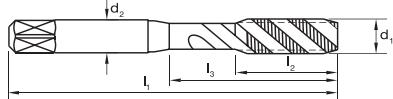
Catalogue Code	T550	T552
Discount Group	D0602	D0610
Material	PM-HSS Co	PM-HSS Co
Surface Finish	<i>Brt</i>	<i>TiCN</i>
Colour Ring & Application	H	H
Geometry	Low Relief	Low Relief
Lead	5 x P	5 x P
	Item #	Item #
	T550 0200	•
	T550 0250	•
	T550 0300	T552 0300
	T550 0350	•
	T550 0400	T552 0400
	T550 0500	T552 0500
	T550 0600	T552 0600
	T550 0800	T552 0800
	T550 1000	T552 1000
	T550 1200	T552 1200
	T550 1400	T552 1400
	T550 1600	T552 1600
	T550 1800	T552 1800
	T550 2000	T552 2000

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

# JIS Taps Metric, Spiral Flute, R40 N



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



Catalogue Code Size Ref.

**T500 0100**

Item #

Catalogue Code

Discount Group

Material

Surface Finish

Colour Ring & Application

Geometry

Lead

HSSE V3 Brt N R40 2.5 x P

D0602	D0602	D0610	D0610
HSSE V3	HSSE V3	HSSE V3	HSSE V3
<b>BrT</b>	<b>Blu</b>	<b>TiN</b>	<b>TiCN</b>
N	N	N	N
R40	R40	R40	R40
2.5 x P	2.5 x P	2.5 x P	2.5 x P

Size Ref.	d <sub>1</sub>	Pitch	Limit	Style*	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	z	drill Ø	Item #	Item #	Item #	Item #
<b>With Point</b>															
<b>0100</b>	M 1	x 0.25	P1	1	30	7	-	3.0	2.5	2	0.75	T503 0100	•	•	•
<b>0110</b>	M 1.1	x 0.25	P1	1	32	8	-	3.0	2.5	2	0.85	T503 0110	•	•	•
<b>0120</b>	M 1.2	x 0.25	P1	1	32	8	-	3.0	2.5	2	0.95	T503 0120	•	•	•
<b>0140</b>	M 1.4	x 0.30	P1	1	34	9	-	3.0	2.5	2	1.1	T503 0140	•	•	•
<b>0160</b>	M 1.6	x 0.35	P1	1	36	10	-	3.0	2.5	2	1.25	T503 0160	•	•	•
<b>0170</b>	M 1.7	x 0.35	P1	1	36	11	-	3.0	2.5	2	1.35	T503 0170	•	•	•
<b>0180</b>	M 1.8	x 0.35	P1	1	36	11	-	3.0	2.5	2	1.45	T503 0180	•	•	•
<b>0200</b>	M 2	x 0.40	P2	1	40	12	-	3.0	2.5	2	1.60	T503 0200	T504 0200	T508 0200	T634 0200
<b>0220</b>	M 2.2	x 0.45	P2	1	42	13	-	3.0	2.5	2	1.75	T503 0220	T504 0220	T508 0220	•
<b>0230</b>	M 2.3	x 0.40	P2	1	42	13	-	3.0	2.5	2	1.9	T503 0230	T504 0230	T508 0230	•
<b>0250</b>	M 2.5	x 0.45	P2	1	44	14	-	3.0	2.5	2	2.05	T503 0250	T504 0250	T508 0250	T634 0250
<b>0260</b>	M 2.6	x 0.45	P2	1	44	14	-	3.0	2.5	2	2.15	T503 0260	T504 0260	T508 0260	T634 0260
<b>0300</b>	M 3	x 0.50	P2	2	46	11	19	4.0	3.2	3	2.5	T503 0300	T504 0300	T508 0300	T634 0300
<b>0301</b>	M 3	x 0.50	P3	2	46	11	19	4.0	3.2	3	2.5	T503 0301			
<b>0350</b>	M 3.5	x 0.60	P1	2	48	13	23	4.0	3.2	3	2.9	T503 0350	T504 0350	T508 0350	T634 0350
<b>0400</b>	M 4	x 0.70	P2	2	52	13	21	5.0	4.0	3	3.3	T503 0400	T504 0400	T508 0400	T634 0400
<b>0401</b>	M 4	x 0.70	P3	2	52	13	21	5.0	4.0	3	3.3	T503 0401			
<b>0500</b>	M 5	x 0.80	P2	2	60	16	24	5.5	4.5	3	4.2	T503 0500	T504 0500	T508 0500	T634 0500
<b>0501</b>	M 5	x 0.80	P3	2	60	16	24	5.5	4.5	3	4.2	T503 0501			
<b>0600</b>	M 6	x 1.00	P2	2	62	19	31	6.0	4.5	3	5.0	T503 0600	T504 0600	T508 0600	T634 0600
<b>Without Point</b>															
<b>0200</b>	M 2	x 0.40	P2	4	40	12	-	3.0	2.5	2	1.60	T606 0200	T607 0200	•	•
<b>0250</b>	M 2.5	x 0.45	P2	4	44	14	-	3.0	2.5	2	2.05	T606 0250	T607 0250	•	•
<b>0300</b>	M 3	x 0.50	P2	5	46	11	19	4.0	3.2	3	2.5	T606 0300	T607 0300	•	•
<b>0350</b>	M 3.5	x 0.60	P1	5	48	13	23	4.0	3.2	3	2.9	T606 0350	T607 0350	•	•
<b>0400</b>	M 4	x 0.70	P2	5	52	13	21	5.0	4.0	3	3.3	T606 0400	T607 0400	•	•
<b>0500</b>	M 5	x 0.80	P2	5	60	16	24	5.5	4.5	3	4.2	T606 0500	T607 0500	•	•
<b>0600</b>	M 6	x 1.00	P2	5	62	19	31	6.0	4.5	3	5.0	T606 0600	T607 0600	•	•
<b>0700</b>	M 7	x 1.00	P2	3	65	22	-	6.2	5.0	3	6.0	T606 0700	T607 0700	T639 0700	T640 0700
<b>0800</b>	M 8	x 1.25	P2	3	70	22	-	6.2	5.0	3	6.8	T606 0800	T607 0800	T639 0800	T640 0800
<b>1006</b>	MF 10	x 1.25	P2	3	75	24	-	7.0	5.5	3	8.5	T606 1006	T607 1006	T639 1006	T640 1006
<b>1000</b>	M 10	x 1.50	P2	3	75	24	-	7.0	5.5	3	8.8	T606 1000	T607 1000	T639 1000	T640 1000
<b>1200</b>	M 12	x 1.75	P2	3	82	29	-	8.5	6.5	3	10.2	T606 1200	T607 1200	T639 1200	T640 1200
<b>1400</b>	M 14	x 2.00	P2	3	88	30	-	10.5	8.0	3	12.0	T606 1400	T607 1400	T639 1400	T640 1400
<b>1600</b>	M 16	x 2.00	P2	3	95	32	-	12.5	10.0	4	14.0	T606 1600	T607 1600	T639 1600	T640 1600
<b>1800</b>	M 18	x 2.50	P3	3	100	37	-	14.0	11.0	4	15.5	T606 1800	T607 1800	T639 1800	T640 1800
<b>2000</b>	M 20	x 2.50	P3	3	105	37	-	15.0	12.0	4	17.5	T606 2000	T607 2000	T639 2000	T640 2000
<b>2200</b>	M 22	x 2.50	P3	3	115	38	-	17.0	13.0	4	19.5	T606 2200	T607 2200	T639 2200	T640 2200
<b>2400</b>	M 24	x 3.00	P3	3	120	45	-	19.0	15.0	4	21.0	T606 2400	T607 2400	T639 2400	T640 2400

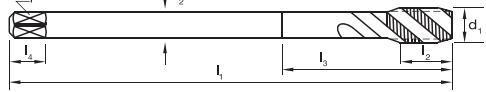
\* Available on request as special manufacture. Subject to lead time.

# JIS Taps Metric, Spiral Flute, R40 N, Extra Length



- For long reach applications
- Suitable for materials up to 1000 N/mm<sup>2</sup>
- Blind holes
- Depths up to 2.5 x d<sub>1</sub>

Sutton Tools



Catalogue Code    Size Ref.

**T500 0100**

Item #

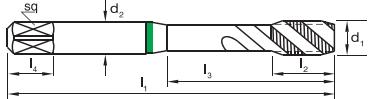
Catalogue Code	<b>T507</b>
Discount Group	D0602
Material	<b>HSSE V3</b>
Surface Finish	<b>BrT</b>
Colour Ring & Application	<b>N</b>
Geometry	R40 Extra Length
Lead	2.5 x P

Size Ref.	d <sub>1</sub>	Pitch	Limit	Style*	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	z	drill Ø
<b>0400</b>	M 4	x 0.70	P2	2	100	13	21	5.0	4.0	3	3.3
<b>0500</b>	M 5	x 0.80	P2	2	100	16	24	5.5	4.5	3	4.2
<b>0600</b>	M 6	x 1.00	P2	2	100	19	31	6.0	4.5	3	5.0
<b>0800</b>	M 8	x 1.25	P3	3	100	22	-	6.2	5.0	3	6.8
<b>1000</b>	M 10	x 1.50	P3	3	150	24	-	7.0	5.5	3	8.5
<b>1200</b>	M 12	x 1.75	P3	3	150	29	-	8.5	6.5	3	10.2
<b>1600</b>	M 16	x 2.00	P3	3	200	32	-	12.5	10.0	4	14.0
<b>2000</b>	M 20	x 2.50	P3	3	200	37	-	15.0	12.0	4	17.5

## **JIS Taps** Metric, Spiral Flute, R40 UNI



- Universal use
  - Suitable for materials up to 1200 N/mm<sup>2</sup>
  - Blind holes
  - Depths up to 3 x d<sub>1</sub>



Catalogue Code      Size Ref.

Size Ref.

T500 | 0100

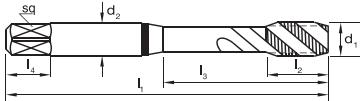
▼ Item #

Size Ref.	d <sub>1</sub>	Pitch	Limit	Style*	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	z	drill Ø	Lead	Item #
<b>WITH POINT</b>													<b>T576</b>
<b>0200</b>	M 2	x 0.40	P2	1	40	-	12	3.0	2.5	2	1.6		T576 0200
<b>0250</b>	M 2.5	x 0.45	P2	1	44	-	14	3.0	2.5	2	2.05		T576 0250
<b>0300</b>	M 3	x 0.50	P2	2	46	5	19	4.0	3.2	3	2.5		T576 0300
<b>0400</b>	M 4	x 0.70	P2	2	52	7	21	5.0	4.0	3	3.3		T576 0400
<b>0500</b>	M 5	x 0.80	P2	2	60	8	24	5.5	4.5	3	4.2		T576 0500
<b>0600</b>	M 6	x 1.00	P2	2	62	10	31	6.0	4.5	3	5.0		T576 0600
<b>WITHOUT POINT</b>													<b>T608</b>
<b>0200</b>	M 2	x 0.40	P2	4	40	-	12	3.0	2.5	2	1.6		T608 0200
<b>0250</b>	M 2.5	x 0.45	P2	4	44	-	14	3.0	2.5	2	2.05		T608 0250
<b>0300</b>	M 3	x 0.50	P2	5	46	5	19	4.0	3.2	3	2.5		T608 0300
<b>0400</b>	M 4	x 0.70	P2	5	52	7	21	5.0	4.0	3	3.3		T608 0400
<b>0500</b>	M 5	x 0.80	P2	5	60	8	24	5.5	4.5	3	4.2		T608 0500
<b>0600</b>	M 6	x 1.00	P2	5	62	10	31	6.0	4.5	3	5.0		T608 0600
<b>0800</b>	M 8	x 1.25	P3	3	70	13	-	6.2	5.0	3	6.8		T608 0800
<b>1000</b>	M 10	x 1.50	P3	3	75	15	-	7.0	5.5	3	8.5		T608 1000

## **JIS Taps** Metric, Spiral Flute, R45 Al



- Suitable for use in wrought aluminium and low silicon aluminium
- Blind holes
- Depths up to  $3 \times d_1$



Catalogue Code      Size Ref.

**T500** **0100**

**Item #**

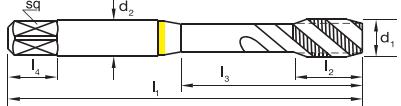
Catalogue Code	D0602
Discount Group	<b>HSSE V3</b>
Material	<b>Brt</b>
Surface Finish	<b>Al</b>
Colour Ring & Application	R45 2 Flute
Geometry	2.5 x P
Lead	

Size Ref.	d <sub>1</sub>	Pitch	Limit	Style*	I <sub>1</sub>	I <sub>2</sub>	I <sub>3</sub>	d <sub>2</sub>	sq	z	drill Ø	Item #
<b>With Point</b>												<b>T573</b>
<b>0200</b>	M 2	x 0.40	P1	1	40	12	-	3.0	2.5	2	1.6	T573 0200
<b>0250</b>	M 2.5	x 0.45	P2	1	44	14	-	3.0	2.5	2	2.05	T573 0250
<b>0300</b>	M 3	x 0.50	P2	2	46	5	19	4.0	3.2	2	2.5	T573 0300
<b>0400</b>	M 4	x 0.70	P2	2	52	7	21	5.0	4.0	2	3.3	T573 0400
<b>0500</b>	M 5	x 0.80	P2	2	60	8	24	5.5	4.5	2	4.2	T573 0500
<b>0600</b>	M 6	x 1.00	P2	2	62	10	31	6.0	4.5	2	5.0	T573 0600
<b>Without Point</b>												<b>T609</b>
<b>0200</b>	M 2	x 0.40	P1	4	40	12	-	3.0	2.5	2	1.6	T609 0200
<b>0250</b>	M 2.5	x 0.45	P2	4	44	14	-	3.0	2.5	2	2.05	T609 0250
<b>0300</b>	M 3	x 0.50	P2	5	46	5	19	4.0	3.2	2	2.5	T609 0300
<b>0400</b>	M 4	x 0.70	P2	5	52	7	21	5.0	4.0	2	3.3	T609 0400
<b>0500</b>	M 5	x 0.80	P2	5	60	8	24	5.5	4.5	2	4.2	T609 0500
<b>0600</b>	M 6	x 1.00	P2	5	62	10	31	6.0	4.5	2	5.0	T609 0600
<b>0800</b>	M 8	x 1.25	P3	3	70	13		6.2	5.0	2	6.8	T609 0800
<b>1000</b>	M 10	x 1.50	P3	3	75	15		7.0	5.5	2	8.5	T609 1000
<b>1200</b>	M 12	x 1.75	P3	3	82	17.5		8.5	6.5	2	10.2	T609 1200

## **JIS Taps** Metric, Spiral Flute, R45 W



- For soft materials
- Blind holes
- Depths up to  $3 \times d_1$



Catalogue Code      Size Ref.

T500 0100

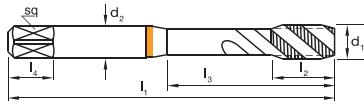
▼ Item #

Catalogue Code	D0602
Discount Group	<b>HSSE V3</b>
Material	<b>Ni</b>
Surface Finish	<b>W</b>
Colour Ring & Application	R45
Geometry	
Lead	2.5 x P

## **JIS Taps Metric, Spiral Flute, R45 Cu**



- For copper and copper alloys
- Blind holes
- Depths up to  $3 \times d_1$



Catalogue Code      Size Ref.

T500 0100

Item #

Size Ref.	d <sub>1</sub>	Pitch	Limit	Style*	I <sub>1</sub>	I <sub>2</sub>	I <sub>3</sub>	d <sub>2</sub>	sq	z	drill Ø
<b>0200</b>	<b>M 2</b>	x 0.40	P2	1	40	12	-	3.0	2.5	2	1.6
<b>0250</b>	<b>M 2.5</b>	x 0.45	P2	1	44	14	-	3.0	2.5	2	2.05
<b>0260</b>	<b>M 2.6</b>	x 0.45	P2	1	44	14	-	3.0	2.5	2	2.15
<b>0300</b>	<b>M 3</b>	x 0.50	P2	2	46	5	19	4.0	3.2	3	2.5
<b>0350</b>	<b>M 3.5</b>	x 0.60	P2	2	48	7	23	4.0	3.2	3	2.9
<b>0400</b>	<b>M 4</b>	x 0.70	P2	2	52	7	21	5.0	4.0	3	3.3
<b>0500</b>	<b>M 5</b>	x 0.80	P2	2	60	8	24	5.5	4.5	3	4.2
<b>0600</b>	<b>M 6</b>	x 1.00	P2	2	62	10	31	6.0	4.5	3	5.0
<b>0700</b>	<b>M 7</b>	x 1.00	P2	5	65	10	-	6.2	5.0	3	6.0
<b>0800</b>	<b>M 8</b>	x 1.25	P3	5	70	13	-	6.2	5.0	3	6.8
<b>1000</b>	<b>M 10</b>	x 1.50	P3	5	75	15	-	7.0	5.5	3	8.5

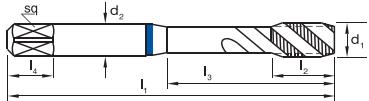
Catalogue Code	<b>T583</b>
Discount Group	D0610
Material	<b>HSSE V3</b>
Surface Finish	<b>CrN</b>
Colour Ring & Application	<b>Cu</b>
Geometry	R45
Lead	2.5 x P

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

## **JIS Taps** Metric, Spiral Flute, R45 VA DH



- Use in stainless steels and high strength steels up to 850N/mm<sup>2</sup>
  - VADH-Suitable for controlled tapping in deep holes
  - Suitable for synchronous tapping in machine operations
  - Blind holes
  - Depths up to approx. 3 x d,



Catalogue Code      Size Ref

T500 0100

Item #

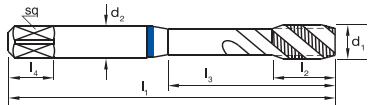


- Available on request as special manufacture. Subject to lead time.

**JIS Taps** Metric, Spiral Flute, R50 VA PM



- Universal high performance tapping
- PM-HSSE V3 offers superior tool life
- Use in stainless steels and high strength steels up to 850N/mm<sup>2</sup>
- Deep Blind holes
- Depths up to 3 x d<sub>1</sub>



Catalogue Code      Size Ref.

**T500** **0100**

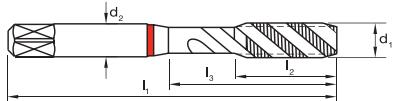
Item #

Catalogue Code	D0610
Discount Group	PM-HSSE V3
Material	TICN
Surface Finish	VA PM
Colour Ring & Application	R50°
Geometry	2.5 x P
Lead	

## **JIS Taps Metric, Spiral Flute, R15 H**



- Suitable for harder short chipping materials up to 45 HRc
  - Blind holes
  - Depths up to  $1.5 \times d_1$



Catalogue Code      Size Ref.

T500 0100

▼ Item #

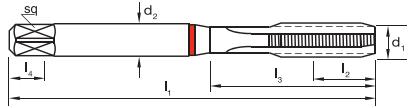
- Available on request as special manufacture. Subject to lead time.

# JIS Taps Metric, Straight Flute, XH & VH



Sutton Tools

- XH, use in hardened steels 42-52 HRc
- VH, use in hardened steels 50-60 HRc
- Through & blind holes
- Depths up to approx.  $1.5 \times d_1$



Catalogue Code Size Ref.

**T500** **0100**

Item #



Size Ref.	d <sub>1</sub>	Pitch	Limit	Style*	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	z	drill Ø
0300	M 3	x 0.50	6HX	2	46	11	18	3.5	2.7	4	2.55
0400	M 4	x 0.70	6HX	2	52	13	21	4.5	3.4	4	3.4
0500	M 5	x 0.80	6HX	2	60	16	25	6.0	4.9	4	4.3
0600	M 6	x 1.00	6HX	2	62	19	30	6.0	4.9	4	5.1
0800	M 8	x 1.25	6HX	3	70	22	-	6.0	4.9	5	6.9
1000	M 10	x 1.50	6HX	3	75	24	-	7.0	5.5	5	8.6
1200	M 12	x 1.75	6HX	3	82	29	-	9.0	7.0	5	10.3
1600	M 16	x 2.00	6HX	3	95	32	-	12.0	9.0	5	14.1
2000	M 20	x 2.50	6HX	3	105	37	-	16.0	12.0	5	17.7

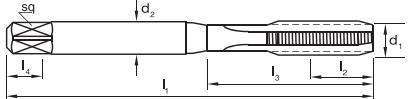
Catalogue Code	T294	T295	T296
Discount Group	D0610	D0610	D0610
Material	SPM	SPM	VHM
Surface Finish	TiCN	TiCN	TiCN
Colour Ring & Application	XH	XH	VH
Geometry	Special Relief	Special Relief	Special Relief
Lead	3 x P	5 x P	Form C/3 x P

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

## JIS Taps Metric, Straight Flute, GG



- For use in grey cast iron (GG)
  - Through & blind holes
  - Depths up to approx.  $3 \times d_1$



Catalogue Code      Size Ref.

T500 0100

▼ Item #

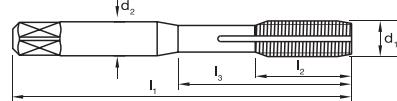
- Available on request as special manufacture. Subject to lead time.

# JIS Taps UNC, Forming, Single Coolant Groove



- For cold forming of threads in materials with good flow characteristics
- Brt-For non-ferrous materials
- TiN-For steel materials up to 1000 N/mm<sup>2</sup>
- TiCN-For difficult materials
- Depths up to approx. 3 x d<sub>1</sub>

Sutton Tools



Catalogue Code Size Ref.

**T500** **0100**

Item #

Catalogue Code

Discount Group

Material

Surface Finish

Colour Ring & Application

Geometry

Lead

D0606 D0614

HSS Co.8 HSS Co.8

Ni TiN

Small Production Medium Production

1 Coolant Groove #4+ 1 Coolant Groove #4+

2P & 4P 2P & 4P

Item # Item #

**T522** **T526**

T522 0185 T526 0185

T522 0218 T526 0218

T522 0251 T526 0251

T522 0284 T526 0284

T522 0318 T526 0318

T522 0351 T526 0351

T522 0417 T526 0417

T522 0483 T526 0483

T522 0549 T526 0549

T522 0635 T526 0635

T522 0794 T526 0794

T522 0953 T526 0953

T522 1111 T526 1111

T522 1270 T526 1270

**T523** **T527**

T523 0185 T527 0185

T523 0218 T527 0218

T523 0251 T527 0251

T523 0284 T527 0284

T523 0318 T527 0318

T523 0351 T527 0351

T523 0417 T527 0417

T523 0483 T527 0483

T523 0549 T527 0549

T523 0635 T527 0635

T523 0794 T527 0794

T523 0953 T527 0953

T523 1111 T527 1111

T523 1270 T527 1270

Size Ref.	d <sub>1</sub>	Pitch	Limit	Style*	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	z	Tap hole min/max
<b>P Lead</b>											
<b>0185</b>	#1	64	GH4	1	40	12	-	3	2.5	4	1.63 - 1.70
<b>0218</b>	#2	56	GH4	1	42	12	0	3	2.5	4	1.93 - 2.00
<b>0251</b>	#3	48	GH4	1	44	14	0	3.0	2.5	4	2.21 - 2.30
<b>0284</b>	#4	40	GH5	2	46	11	23	3.0	2.5	4	2.49 - 2.59
<b>0318</b>	#5	40	GH5	2	46	9	23	4.0	3.2	4	2.82 - 2.92
<b>0351</b>	#6	32	GH6	2	48	9	23	4.0	3.2	4	3.11 - 3.19
<b>0417</b>	#8	32	GH6	2	52	10	21	5.0	4.0	4	3.77 - 3.85
<b>0483</b>	#10	24	GH6	2	60	11	25	5.5	4.5	4	4.27 - 4.38
<b>0549</b>	#12	24	GH6	2	62	11	24	6.0	4.5	4	4.93 - 5.04
<b>0635</b>	1/4	20	GH7	2	62	14	31	6.0	4.5	4	5.67 - 5.80
<b>0794</b>	5/16	18	GH7	3	70	22	0	6.1	5.0	6	7.18 - 7.32
<b>0953</b>	3/8	16	GH7	3	75	24	0	7.0	5.5	6	8.66 - 8.82
<b>1111</b>	7/16	14	GH8	3	80	29	0	8.0	6.0	8	10.12 - 10.30
<b>1270</b>	1/2	13	GH8	3	85	29	0	9.0	7.0	8	11.63 - 11.82

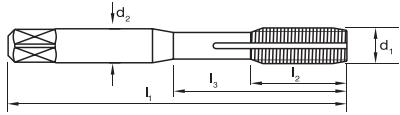
Size Ref.	d <sub>1</sub>	Pitch	Limit	Style*	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	z	Tap hole min/max
<b>B Lead</b>											
<b>0185</b>	#1	64	GH4	1	40	12	-	3	2.5	4	1.63 - 1.70
<b>0218</b>	#2	56	GH4	1	42	12	0	3	2.5	4	1.93 - 2.00
<b>0251</b>	#3	48	GH4	1	44	14	0	3.0	2.5	4	2.21 - 2.30
<b>0284</b>	#4	40	GH5	5	46	11	23	3.0	2.5	4	2.49 - 2.59
<b>0318</b>	#5	40	GH5	5	46	9	23	4.0	3.2	4	2.82 - 2.92
<b>0351</b>	#6	32	GH6	5	48	9	23	4.0	3.2	4	3.11 - 3.19
<b>0417</b>	#8	32	GH6	5	52	10	21	5.0	4.0	4	3.76 - 3.85
<b>0483</b>	#10	24	GH6	5	60	11	25	5.5	4.5	4	4.27 - 4.38
<b>0549</b>	#12	24	GH6	5	62	11	24	6.0	4.5	4	4.93 - 5.04
<b>0635</b>	1/4	20	GH7	5	62	14	31	6.0	4.5	4	5.68 - 5.80
<b>0794</b>	5/16	18	GH7	3	70	22	0	6.1	5.0	6	7.18 - 7.32
<b>0953</b>	3/8	16	GH7	3	75	24	0	7.0	5.5	6	8.66 - 8.82
<b>1111</b>	7/16	14	GH8	3	80	29	0	8.0	6.0	8	10.12 - 10.30
<b>1270</b>	1/2	13	GH8	3	85	29	0	9.0	7.0	8	11.63 - 11.82

UNC

## JIS Taps UNC, Forming, Multi Coolant Groove



- For cold forming of threads in materials with good flow characteristics
- Brt-For non-ferrous materials
- TiN-For steel materials up to 1000 N/mm<sup>2</sup>
- TiCN-For difficult materials
- Depths up to approx. 3 x d<sub>1</sub>



Catalogue Code Size Ref.

**T500** **0100**

Item #

Catalogue Code	D0606	D0614
Discount Group	HSS Co.8	HSS Co.8
Material	Ni	TiN
Surface Finish		
Colour Ring & Application		
Geometry		
Lead		

Size Ref.	d <sub>1</sub>	Pitch	Limit	Style*	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	z	Tap hole min/max
<b>P Lead</b>											
<b>0351</b>	#6	32	GH6	2	48	9	23	4.0	3.2	4	3.11 - 3.19
<b>0417</b>	#8	32	GH6	2	52	10	21	5.0	4.0	4	3.77 - 3.85
<b>0483</b>	#10	24	GH6	2	60	11	25	5.5	4.5	4	4.27 - 4.38
<b>0549</b>	#12	24	GH6	2	62	11	24	6.0	4.5	4	4.93 - 5.04
<b>0635</b>	1/4	20	GH7	2	62	14	31	6.0	4.5	4	5.67 - 5.80

<b>B Lead</b>	<b>T529</b>	<b>T663</b>									
<b>0351</b>	#6	32	GH6	5	48	9	23	4.0	3.2	4	3.11 - 3.19
<b>0417</b>	#8	32	GH6	5	52	10	21	5.0	4.0	4	3.77 - 3.85
<b>0483</b>	#10	24	GH6	5	60	11	25	5.5	4.5	4	4.27 - 4.38
<b>0549</b>	#12	24	GH6	5	62	11	24	6.0	4.5	4	4.93 - 5.04
<b>0635</b>	1/4	20	GH7	5	62	14	31	6.0	4.5	4	5.67 - 5.80

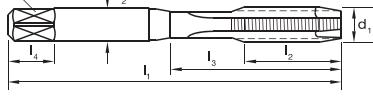


# JIS Taps UNC, Gun, N (Spiral Point)



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

Sutton Tools



Catalogue Code Size Ref.

T500 0100

Item #



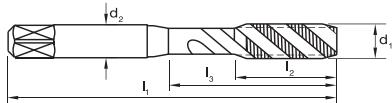
Catalogue Code	T615	T616	T617
Discount Group	D0602	D0602	D0610
Material	HSSE V3	HSSE V3	HSSE V3
Surface Finish	<i>Brt</i>	<i>Blu</i>	<i>TiN</i>
Colour Ring & Application			
Geometry			
Lead	5 x P	5 x P	5 x P

Size Ref.	d <sub>1</sub>	Pitch	Limit	Style*	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	z	drill Ø	Item #	Item #	Item #
<b>0185</b>	#1	64	2B	1	36				2	1.55		T615 0185	T616 0185	T617 0185
<b>0218</b>	#2	56	2B	1	42	10	0	3.0	2.5	2	1.80	T615 0218	T616 0218	T617 0218
<b>0251</b>	#3	48	2B	1	44	10	0	3.0	2.5	2	2.05	T615 0251	T616 0251	T617 0251
<b>0284</b>	#4	40	2B	2	46	11	23	3.0	2.5	2	2.30	T615 0284	T616 0284	T617 0284
<b>0318</b>	#5	40	2B	2	46	11	23	4.0	3.2	3	2.60	T615 0318	T616 0318	T617 0318
<b>0351</b>	#6	32	2B	2	48	13	23	4.0	3.2	3	2.80	T615 0351	T616 0351	T617 0351
<b>0417</b>	#8	32	2B	2	52	13	21	5.0	4.0	3	3.4	T615 0417	T616 0417	T617 0417
<b>0483</b>	#10	24	2B	2	60	16	25	5.5	4.5	3	3.9	T615 0483	T616 0483	T617 0483
<b>0549</b>	#12	24	2B	2	62	19	24	6.0	4.5	3	4.5	T615 0549	T616 0549	T617 0549
<b>0635</b>	1/4	20	2B	2	62	19	31	6.0	4.5	3	5.1	T615 0635	T616 0635	T617 0635
<b>0794</b>	5/16	18	2B	3	70	22	-	6.1	5.0	3	6.6	T615 0794	T616 0794	T617 0794
<b>0953</b>	3/8	16	2B	3	75	24	-	7.0	5.5	3	8.0	T615 0953	T616 0953	T617 0953
<b>1111</b>	7/16	14	2B	3	80	29	-	8.0	6.0	3	9.4	T615 1111	T616 1111	T617 1111
<b>1270</b>	1/2	13	2B	3	85	29	-	9.0	7.0	3	10.8	T615 1270	T616 1270	T617 1270
<b>1588</b>	5/8	11	2B	3	95	32	-	12.5	10.0	4	13.5	T615 1588	T616 1588	T617 1588
<b>1905</b>	3/4	10	2B	3	105	37	-	14.0	11.0	4	16.5	T615 1905	T616 1905	T617 1905
<b>2223</b>	7/8	9	2B	3	115	38	-	17.0	13.0	4	19.5	T615 2223	T616 2223	T617 2223
<b>2540</b>	1	8	2B	3	120	45	-	20.0	15.0	4	22.5	T615 2540	T616 2540	T617 2540

# JIS Taps UNC, Spiral Flute, R40 N



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



Catalogue Code      Size Ref.

**T500** | **0100**

▼ Item #

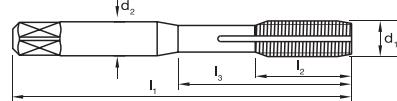


# JIS Taps UNF, Forming, Single Coolant Groove



- For cold forming of threads in materials with good flow characteristics
- Brt-For non-ferrous materials
- TiN-For steel materials up to 1000 N/mm<sup>2</sup>
- TiCN-For difficult materials
- Depths up to approx. 3 x d<sub>1</sub>

Sutton Tools



Catalogue Code Size Ref.

**T500 0100**

Item #

Catalogue Code

Discount Group

Material

Surface Finish

Colour Ring & Application

Geometry

Lead

D0606

D0614

HSS Co.8

HSS Co.8

Ni

TiN

Small Production

Medium Production

1 Coolant Groove #4+

1 Coolant Groove #4+

2P & 4P

2P & 4P

Item #

Item #

**T534**

**T538**

T534 0152

T538 0152

•

•

T534 0218

T538 0218

T534 0251

T538 0251

T534 0284

T538 0284

T534 0318

T538 0318

T534 0351

T538 0351

T534 0417

T538 0417

T534 0483

T538 0483

T534 0549

T538 0549

T534 0635

T538 0635

**T535**

**T539**

T535 0152

T539 0152

•

•

T535 0218

T539 0218

T535 0251

T539 0251

T535 0284

T539 0284

T535 0318

T539 0318

T535 0351

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T535 0483

T539 0483

T535 0549

T539 0549

T535 0635

T539 0635

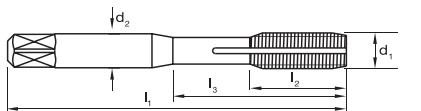
Size Ref.	d <sub>1</sub>	Pitch	Limit	Style*	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	z	Tap hole min/max
<b>P Lead</b>											
<b>0152</b>	#0	80	GH3	1	36	11	-	3.0	2.5	4	1.34 - 1.40
<b>0185</b>	#1	72	GH3	1	40	12	-	3.0	2.5	4	1.64 - 1.70
<b>0218</b>	#2	64	GH3	1	42	14	-	3.0	2.5	4	1.95 2.02
<b>0251</b>	#3	56	GH4	1	44	14	-	3.0	2.5	4	2.26 - 2.34
<b>0284</b>	#4	48	GH5	2	46	11	23	3.0	2.5	4	2.54 - 2.63
<b>0318</b>	#5	44	GH5	2	46	9	23	4.0	3.2	4	2.85 - 2.95
<b>0351</b>	#6	40	GH6	2	48	9	23	4.0	3.2	4	3.20 - 3.27
<b>0417</b>	#8	36	GH6	2	52	10	21	5.0	4	4	3.82 - 3.89
<b>0483</b>	#10	32	GH6	2	60	11	25	5.5	5	4	4.43 - 4.51
<b>0549</b>	#12	28	GH7	2	62	11	24	6.0	4.5	4	5.03 - 5.12
<b>0635</b>	1/4	28	GH7	2	62	14	31	6.0	4.5	4	5.93 - 5.98
<b>B Lead</b>											
<b>0152</b>	#0	80	GH3		36	11	-	3.0	2.5	4	1.34 - 1.40
<b>0185</b>	#1	72	GH3		40	12	-	3.0	2.5	4	1.64 - 1.70
<b>0218</b>	#2	64	GH3		42	14	-	3.0	2.5	4	1.95 2.02
<b>0251</b>	#3	56	GH4		44	14	-	3.0	2.5	4	2.26 - 2.34
<b>0284</b>	#4	48	GH5	5	46	11	23	3.0	2.5	4	2.54 - 2.63
<b>0318</b>	#5	44	GH5	5	46	9	23	4.0	3.2	4	2.85 - 2.95
<b>0351</b>	#6	40	GH6	5	48	9	23	4.0	3.2	4	3.20 - 3.27
<b>0417</b>	#8	36	GH6	5	52	10	21	5.0	4	4	3.82 - 3.89
<b>0483</b>	#10	32	GH6	5	60	11	25	5.5	5	4	4.43 - 4.51
<b>0549</b>	#12	28	GH7	5	62	11	24	6.0	4.5	4	5.03 - 5.12
<b>0635</b>	1/4	28	GH7	5	62	14	31	6.0	4.5	4	5.93 - 5.98

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

## JIS Taps UNF, Forming, Multi Coolant Groove



- For cold forming of threads in materials with good flow characteristics  
Brt-For non-ferrous materials  
TiN-For steel materials up to 1000 N/mm<sup>2</sup>  
TiCN-For difficult materials
- Depths up to approx. 3 x d<sub>1</sub>



Catalogue Code      Size Ref.

### Size Ref.

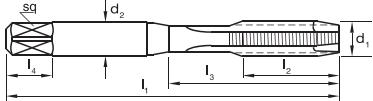
T500 | 0100

Item #

## **JIS Taps** UNF, Gun, N (Spiral Point)



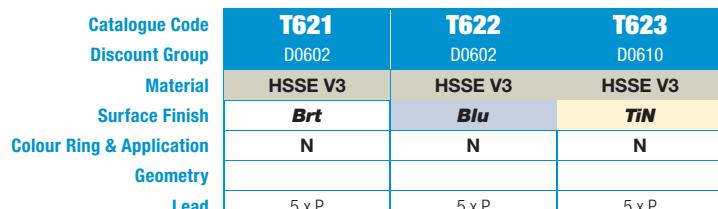
- General purpose use, materials up to approx. 1000 N/mm<sup>2</sup>
- Through holes
- Suitable for machine operations
- Depths up to approx. 3 x d<sub>1</sub>



- Catalogue Code      Size Ref.

T500 0100

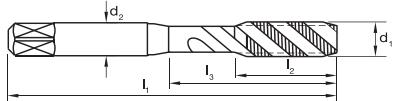
Item #



# JIS Taps UNF, Spiral Flute, R40 N



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



Catalogue Code Size Ref.

T500 0100  
Item #



Catalogue Code

Discount Group

Material

Surface Finish

Colour Ring & Application

Geometry

Lead

**T625**

D0602

**T626**

D0602

**T627**

D0610

HSSE V3

HSSE V3

HSSE V3

*Br*

*Blu*

*TiN*

N

N

N

R40

R40

R40

5xP

5xP

5xP

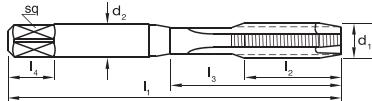
Size Ref.	d <sub>1</sub>	Pitch	Limit	Style*	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	z	drill Ø	Item #	Item #	Item #
<b>0152</b>	#0	80	2B	1	36	11	-	3.0	2.5	2	1.25	T625 0152	T626 0152	T627 0152
<b>0185</b>	#1	72	2B	1	40	12	-	3.0	2.5	2	1.55	T625 0185	T626 0185	T627 0185
<b>0218</b>	#2	64	2B	1	42	14	-	3.0	2.5	2	1.9	T625 0218	T626 0218	T627 0218
<b>0251</b>	#3	56	2B	1	44	14	-	3.0	2.5	2	2.1	T625 0251	T626 0251	T627 0251
<b>0284</b>	#4	48	2B	2	46	11	23	3.0	2.5	2	2.35	T625 0284	T626 0284	T627 0284
<b>0318</b>	#5	44	2B	2	46	11	23	4.0	3.2	3	2.65	T625 0318	T626 0318	T627 0318
<b>0351</b>	#6	40	2B	2	48	13	23	4.0	3.2	3	2.95	T625 0351	T626 0351	T627 0351
<b>0417</b>	#8	36	2B	2	52	13	21	5.0	4.0	3	3.5	T625 0417	T626 0417	T627 0417
<b>0483</b>	#10	32	2B	2	60	16	25	5.5	4.5	3	4.1	T625 0483	T626 0483	T627 0483
<b>0549</b>	#12	28	2B	2	62	19	24	6.0	4.5	3	4.6	T625 0549	T626 0549	T627 0549
<b>0635</b>	1/4	28	2B	2	62	19	31	6.0	4.5	3	5.5	T625 0635	T626 0635	T627 0635
<b>0794</b>	5/16	24	2B	3	70	22	-	6.1	5.0	3	6.9	T625 0794	T626 0794	T627 0794
<b>0953</b>	3/8	24	2B	3	75	24	-	7.0	5.5	3	8.5	T625 0953	T626 0953	T627 0953
<b>1111</b>	7/16	20	2B	3	80	29	-	8.0	6.0	3	9.9	T625 1111	T626 1111	T627 1111
<b>1270</b>	1/2	20	2B	3	85	29	-	9.0	7.0	3	11.5	T625 1270	T626 1270	T627 1270
<b>1588</b>	5/8	18	2B	3	95	32	-	12.5	10.0	4	14.5	T625 1588	T626 1588	T627 1588
<b>1905</b>	3/4	16	2B	3	105	37	-	14.0	11.0	4	17.5	T625 1905	T626 1905	T627 1905
<b>2223</b>	7/8	14	2B	3	115	38	-	17.0	13.0	4	20.4	T625 2223	T626 2223	T627 2223
<b>2540</b>	1	12	2B	3	120	45	-	20.0	15.0	4	23.3	T625 2540	T626 2540	T627 2540

UNF

## **JIS Taps** BSW, Gun, N (Spiral Point)



- General purpose use, materials up to approx.  $1000 \text{ N/mm}^2$
- Through holes
- Ideally suited for machine applications
- Depths up to approx.  $3 \times d_1$



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

## **JIS Taps** BSW, Gun, N, Extra Length (Spiral Point)



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



Catalogue Code      Size Ref.

T500 0100

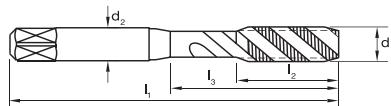
▼ Item #

BSW

## JIS Taps BSW, Spiral Flute, R40 N



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



Catalogue Code      Size Ref.

**T500** **0100**

Item #

**Catalogue Code**  
**Discount Group**  
**Material**  
**Surface Finish**  
**Colour Ring & Application**  
**Geometry**  
**Lead**



- Available on request as special manufacture. Subject to lead times.

## **JIS Taps** BSW, Spiral Flute, R40 N, Extra Length



- For long reach applications
  - Suitable for materials up to 1000 N/mm<sup>2</sup>
  - Blind holes
  - Depths up to 2.5 x d<sub>1</sub>



Catalogue Code      Size Ref.

T500 0100

Item #

BSW

# the ultimate reference book is here...

# BLACK BOOK

The ultimate reference book:

- Matt laminated grease proof pages
- Wire bound to stay flat on workbench when reading
- Ideal for engineers, trades people, apprentices, machine shops, tool rooms, technical colleges

## Engineers Black Book

- Tables • Standards • Illustrations
- Grinding wheels • Conversion factors
- Tapers • Lubricants-coolants • G Codes
- Spur gear calculations • Tolerances
- Hardening & tempering • Weights of metal
- Geometrical construction • Formulae
- Engineering drawing standards • Plastics
- Bolts & nuts • Tungsten carbide
- Keys & keyways • Tapping drill sizes
- Speeds & feeds • Equivalent charts
- Sharpening information

## Fastener Black Book

- Screw thread fundamentals • Standards
- Thread classes • Thread terminology
- Grades • Heat treatment • Material selection
- Materials & coatings • Failures & corrosion
- Fastener strengths & markings • Platings
- Tolerances • Hydrogen embrittlement
- Screw thread profiles • Torque control
- Galling • Elevated temperature effects
- Dimensional Specifications DIN / ISO / ANSI

