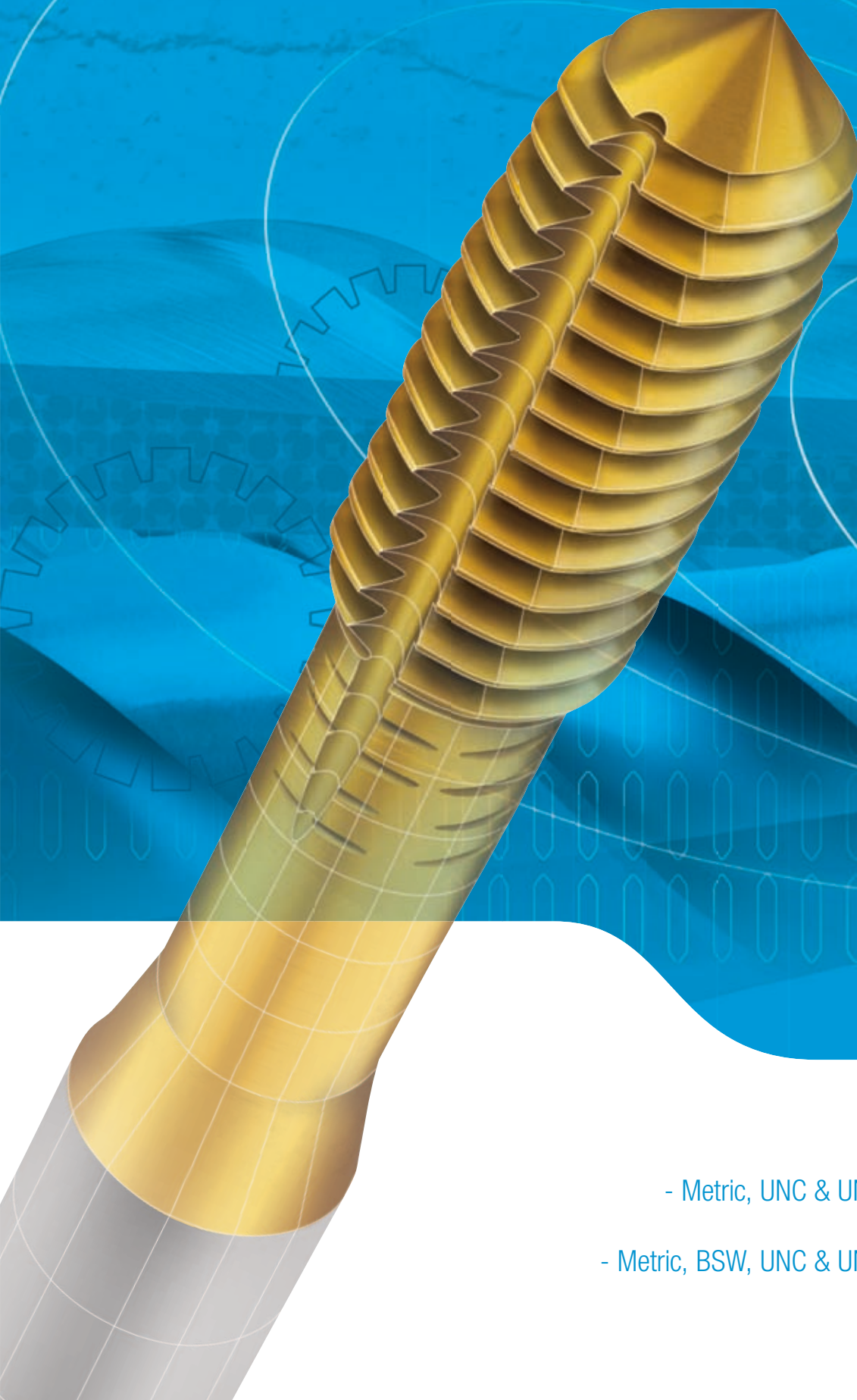


# JIS TAPS



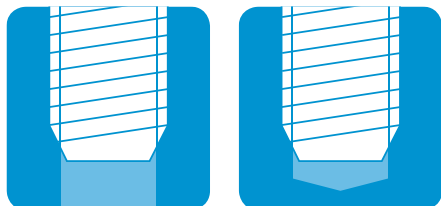
## **Taps-JIS**

### *Roll Taps*

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



## For Thread Forming



Page

M  
UNC  
UNF

	Tap Forming, Single Coaxial Groove	Tap Forming, Single Coaxial Groove	Tap Forming, Single Coaxial Groove	Tap Forming, Multi Coaxial Groove	Tap Forming, Multi Coaxial Groove	Tap Forming, Multi Coaxial Groove
M	178	178	178	180	180	180
UNC	200		200	201		201
UNF	204		204	205		205

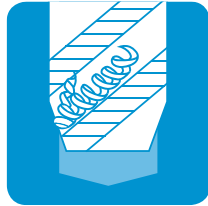
Material  
Surface Finish  
Colour Ring & Application  
Tapping Depth

	HSS Co.8			HSS Co.8		
	Ni	Blu	TIN	Ni	Blu	TIN
	≤ 3xØ					

	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 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

# For Tapping Through & Blind Holes

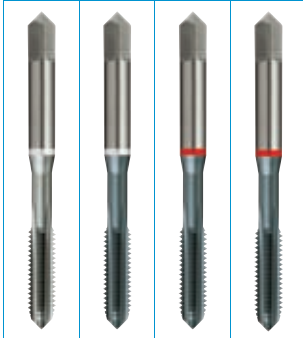


Page

M  
UNC  
UNF  
BSW



199	199	198	198
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Material

Surface Finish

Colour Ring & Application

Tapping Depth

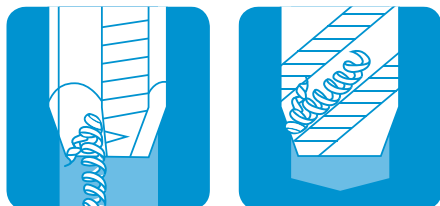
HSSE V3	SPM	VHM
Ni	TiCN	TiCN
GG	XH	VH
≤ 3xØ	≤ 1.5xØ	

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				●
<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



## For Tapping Through Holes



Page

M  
UNC  
UNF  
BSW

	Tap Gun, N	Tap Gun, N	Tap Gun, N	Tap Gun, N	Tap Gun, N, Extra Length	Tap Gun, UNI	Tap Gun, W	Tap Gun, Cu	Tap Gun, VA	Tap Gun, VA	Tap Gun, H	Tap Gun, H
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							
Material	HSSE V3				PM-HSSE V3	HSSE V3				PM-HSS Co		
Surface Finish	Brt	Blu	TiN	TiCN	Brt	TiAlN	Ni	CrN	Blu	TiCN	Brt	TiCN
Colour Ring & Application	N					UNI	W	Cu	VA	H		
Tapping Depth	≤ 3xØ											

	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 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

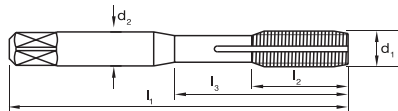
# Taps Finder-For Tapping Blind Holes

Tap Spiral Flute, R40 N		Tap Spiral Flute, R40 N		Tap Spiral Flute, R40 N		Tap Spiral Flute, R40 N		Tap Spiral Flute, R40 N, Extra Length		Tap Spiral Flute, R40 UNI		Tap Spiral Flute, R45 Al		Tap Spiral Flute, R45 W		Tap Spiral Flute, R45 Cu		Tap Spiral Flute, R45 VA		Tap Spiral Flute, R45 VADH		Tap Spiral Flute, R45 VADH		Tap Spiral Flute, R30 VA PM		Tap Spiral Flute, R15 H		Tap Spiral Flute, R15 H				
189	189	189	189	190	191	192	193	194	195	195	195	196	197	197																		
203	203	203																														
207	207	207																														
210	210	210	210	211																												
HSSE V3				PM-HSSE V3		HSSE V3						PM-HSSE V3		PM-HSS Co																		
<b>Brt</b>	<b>Blu</b>	<b>TiN</b>	<b>TiCN</b>	<b>Brt</b>	<b>TiAlN</b>	<b>Brt</b>	<b>Ni</b>	<b>CrN</b>	<b>Blu</b>			<b>TiCN</b>													<b>Brt</b>	<b>TiCN</b>						
N					<b>UNI</b>	<b>Al</b>	<b>W</b>	<b>Cu</b>	<b>VA</b>	<b>VADH</b>	<b>VADH</b>	<b>VA PM</b>	<b>H</b>																			
≤ 2.5xØ																		≤ 1.5xØ														
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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.



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>											
0100	M 1	x 0.25	GH4	1	30	7	-	3.0	2.5	4	0.86-0.90
0110	M 1.1	x 0.25	GH4	1	32	7	-	3.0	3.0	4	0.96-1.00
0120	M 1.2	x 0.25	GH4	1	32	7	-	3.0	2.5	4	1.10-1.06
0140	M 1.4	x 0.30	GH4	1	34	7	-	3.0	2.5	4	1.23-1.28
0145	M 1.4	x 0.30	GH5	1	34	9	-	3.0	2.5	4	1.24-1.29
0160	M 1.6	x 0.35	GH4	1	36	10	-	3.0	2.5	4	1.40-1.46
0170	M 1.7	x 0.35	GH4	1	36	11	-	3.0	2.5	4	1.50-1.56
0175	M 1.7	x 0.35	GH5	1	36	11	-	3.0	2.5	4	1.51-1.57
0180	M 1.8	x 0.35	GH4	1	36	11	-	3.0	2.5	4	1.60-1.66
0200	M 2	x 0.40	GH4	1	40	12	-	3.0	2.5	4	1.77-1.84
0205	M 2	x 0.40	GH5	1	40	12	-	3.0	2.5	4	1.79-1.85
0220	M 2.2	x 0.45	GH4	1	42	13	-	3.0	2.5	4	1.95-2.02
0230	M 2.3	x 0.40	GH4	1	42	13	-	3.0	2.5	4	2.07-2.14
0250	M 2.5	x 0.45	GH4	1	44	14	-	3.0	2.5	4	2.25-2.32
0255	M 2.5	x 0.45	GH5	1	44	14	-	3.0	2.5	4	2.26-2.33
0260	M 2.6	x 0.45	GH4	1	44	14	-	3.0	2.5	4	2.35-2.42
0265	M 2.6	x 0.45	GH5	1	44	14	-	3.0	2.5	4	2.36-2.43
0300	M 3	x 0.50	GH5	2	46	9	19	4.0	3.2	4	2.72-2.80
0306	M 3	x 0.50	GH6	2	46	9	19	4.0	3.2	4	2.73-2.81
0307	M 3	x 0.50	GH7	2	46	9	19	4.0	3.2	4	2.74-2.83
0350	M 3.5	x 0.60	GH5	2	48	9	23	4.0	3.2	4	3.20-3.25
0356	M 3.5	x 0.60	GH6	2	48	9	23	4.0	3.2	4	3.21-3.26
0400	M 4	x 0.70	GH6	2	52	10	21	5.0	4.0	4	3.65-3.71
0500	M 5	x 0.80	GH6	2	60	11	24	5.5	4.5	4	4.59-4.66
0600	M 6	x 1.00	GH7	2	62	12	31	6.0	4.5	4	5.49-5.57
0700	M 7	x 1.00	GH7	3	65	18	-	6.2	5.0	4	6.49-6.57
0800	M 8	x 1.25	GH7	3	70	18	-	6.2	5.0	6	7.34-7.44
1000	M 10	x 1.50	GH7	3	75	19	-	7.0	5.5	6	9.18-9.31



Catalogue Code	T510	T512	T514
Discount Group	D0606	D0606	D0614
Material	HSS Co.8	HSS Co.8	HSS Co.8
Surface Finish	Ni	Blu	TiN
General Production	General Production	General Production	Medium Production
Geometry	1 Coolant Groove M3+	1 Coolant Groove M3+	1 Coolant Groove M3+
Lead	4 x P	4 x P	4 x P

Item #	Item #	Item #
T510 0100	T512 0100	T514 0100
T510 0110	T512 0110	T514 0110
T510 0120	T512 0120	T514 0120
T510 0140	T512 0140	T514 0140
•	•	T514 0145
T510 0160	T512 0160	T514 0160
T510 0170	T512 0170	T514 0170
•	•	T514 0175
T510 0180	T512 0180	T514 0180
T510 0200	T512 0200	T514 0200
•	•	T514 0205
T510 0220	T512 0220	T514 0220
T510 0230	T512 0230	T514 0230
T510 0250	T512 0250	T514 0250
T510 0255	T512 0255	T514 0255
T510 0260	T512 0260	T514 0260
T510 0265	T512 0265	T514 0260
T510 0300	T512 0300	T514 0300
T510 0306	T512 0306	T514 0306
•	•	T514 0307
T510 0350	T512 0350	T514 0350
T510 0356	T512 0356	T514 0350
T510 0400	T512 0400	T514 0400
T510 0500	T512 0500	T514 0500
T510 0600	T512 0600	T514 0600
•	•	•
T510 0800	T512 0800	T514 0800
T510 1000	T512 1000	T514 1000

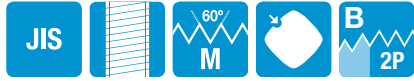
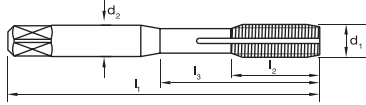
\* Available on request as special manufacture. Subject to lead time.



# 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 x d<sub>1</sub>



Catalogue Code    Size Ref.



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



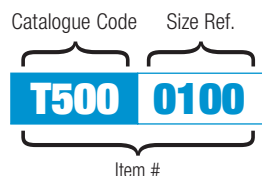
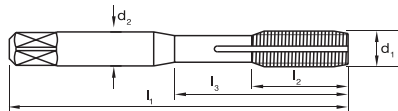
Size Ref.	d <sub>1</sub>	Pitch	Limit	Style*	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	z	Tap hole min/max	Item #	Item #	Item #
<b>B Lead</b>														
<b>0100</b>	<b>M 1</b>	x 0.25	GH4	1	30	7	-	3.0	2.5	4	0.86-0.90	T511 0100	T513 0100	T515 0100
<b>0110</b>	<b>M 1.1</b>	x 0.25	GH4	1	32	7	-	3.0	3	4	0.96-1.00	T511 0110	T513 0110	T515 0110
<b>0120</b>	<b>M 1.2</b>	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>	<b>M 1.4</b>	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>	<b>M 1.6</b>	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>	<b>M 1.7</b>	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>	<b>M 1.8</b>	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>	<b>M 2</b>	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>	<b>M 2.2</b>	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>	<b>M 2.3</b>	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>	<b>M 2.5</b>	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>	<b>M 2.5</b>	x 0.45	GH4	1	44	14	-	3.0	2.5	4	2.26-2.33			T515 0255
<b>0260</b>	<b>M 2.6</b>	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>	<b>M 3</b>	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>	<b>M 3</b>	x 0.50	GH6	2	46	9	19	4.0	3.2	4	2.73-2.81			T515 0306
<b>0350</b>	<b>M 3.5</b>	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>	<b>M 4</b>	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>	<b>M 5</b>	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>	<b>M 6</b>	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>	<b>M 7</b>	x 1.00	GH7	3	65	18	-	6.2	5.0	4	6.49-6.57	•	•	•
<b>0800</b>	<b>M 8</b>	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>	<b>M 10</b>	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>



<b>Catalogue Code</b>	<b>T516</b>	<b>T518</b>	<b>T520</b>
<b>Discount Group</b>	D0606	D0606	D0614
<b>Material</b>	HSS Co.8	HSS Co.8	HSS Co.8
<b>Surface Finish</b>	<i>Ni</i>	<i>Blu</i>	<i>TiN</i>
<b>Colour Ring &amp; Application</b>	General Production	General Production	Medium Production
<b>Geometry</b>	Multi Coolant Groove	Multi Coolant Groove	Multi Coolant Groove
<b>Lead</b>	4 x P	4 x P	4 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	Tap hole min/max	Item #	Item #	Item #
<b>P Lead</b>														
0300	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
0350	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
0400	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
0500	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
0600	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
0800	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
1000	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
1200	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
1400	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
1600	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
1800	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
2000	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

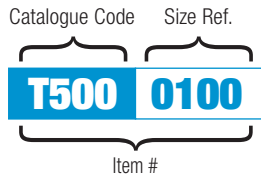
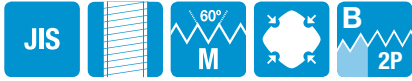
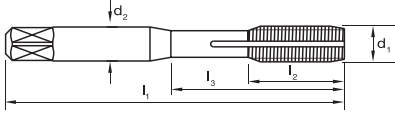
\* Available on request as special manufacture. Subject to lead time.



# 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
- Discount Group
- Material
- Surface Finish
- Colour Ring & Application
- Geometry
- Lead



	<b>T517</b>	<b>T519</b>	<b>T521</b>
Catalogue Code	D0606	D0606	D0614
Discount Group			
Material	<b>HSS Co.8</b>	<b>HSS Co.8</b>	<b>HSS Co.8</b>
Surface Finish	<b>Ni</b>	<b>Blu</b>	<b>TiN</b>
Colour Ring & Application	<b>General Production</b>	<b>General Production</b>	<b>Medium Production</b>
Geometry	Multi Coolant Groove	Multi Coolant Groove	Multi Coolant Groove
Lead	2 x P	2 x P	2 x P

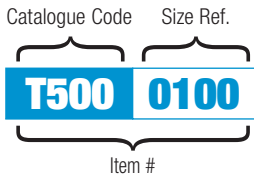
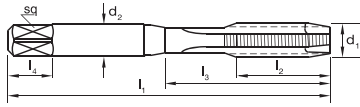
Size Ref.	d <sub>1</sub>	Pitch	Limit	Style*	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	z	Tap hole min/max	Item #	Item #	Item #
<b>B Lead</b>														
<b>0300</b>	<b>M 3</b>	x 0.50	GH5	5	46	9	19	4.0	3.2	4	2.72-2.80	T517 0300	T519 0300	T521 0300
<b>0350</b>	<b>M 3.5</b>	x 0.60	GH5	5	48	9	23	4.0	3.2	4	3.20-3.25	T517 0350	T519 0350	T521 0350
<b>0400</b>	<b>M 4</b>	x 0.70	GH6	5	52	10	21	5.0	4.0	4	3.65-3.71	T517 0400	T519 0400	T521 0400
<b>0500</b>	<b>M 5</b>	x 0.80	GH6	5	60	11	24	5.5	4.5	4	4.59-4.66	T517 0500	T519 0500	T521 0500
<b>0600</b>	<b>M 6</b>	x 1.00	GH7	5	62	12	31	6.0	4.5	4	5.49-5.57	T517 0600	T519 0600	T521 0600
<b>0800</b>	<b>M 8</b>	x 1.25	GH7	3	70	18	0	6.2	5.0	6	7.34-7.44	T517 0800	T519 0800	T521 0800
<b>1000</b>	<b>M 10</b>	x 1.50	GH7	3	75	19	0	7.0	5.5	6	9.18-9.30	T517 1000	T519 1000	T521 1000
<b>1200</b>	<b>M 12</b>	x 1.75	GH8	3	82	23	0	8.5	6.5	8	11.05-11.19	T517 1200	T519 1200	T521 1200
<b>1400</b>	<b>M 14</b>	x 2.00	GH10	3	88	25	0	10.5	8.0	8	12.92-13.08	T517 1400	T519 1400	T521 1400
<b>1600</b>	<b>M 16</b>	x 2.00	GH10	3	95	27	0	12.5	10.0	8	14.92-15.08	T517 1600	T519 1600	T521 1600
<b>1800</b>	<b>M 18</b>	x 2.50	GH11	3	100	29	0	14.0	11.0	8	16.64-16.84	T517 1800	T519 1800	T521 1800
<b>2000</b>	<b>M 20</b>	x 2.50	GH11	3	105	30	0	15.0	12.0	8	18.64-18.84	T517 2000	T519 2000	T521 2000

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

T499	T500	T502	T633
D0602	D0602	D0610	D0610
HSSE V3	HSSE V3	HSSE V3	HSSE V3
<i>Br</i>	<i>Blu</i>	<i>TiN</i>	<i>TiCN</i>
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 #
0100	M 1	x 0.25	P1	1	30	7	-	3.0	2.5	2	0.75	T499 0100	•	•	•
0110	M 1.1	x 0.25	P1	1	32	8	-	3.0	2.5	2	0.85	T499 0110	•	•	•
0120	M 1.2	x 0.25	P1	1	32	8	-	3.0	2.5	2	0.95	T499 0120	•	•	•
0140	M 1.4	x 0.30	P1	1	34	9	-	3.0	2.5	2	1.1	T499 0140	•	•	•
0160	M 1.6	x 0.35	P1	1	36	10	-	3.0	2.5	2	1.25	T499 0160	•	•	•
0170	M 1.7	x 0.35	P1	1	36	11	-	3.0	2.5	2	1.35	T499 0170	•	•	•
0180	M 1.8	x 0.35	P1	1	36	11	-	3.0	2.5	2	1.45	T499 0180	•	•	•
0200	M 2	x 0.40	P2	1	40	12	-	3.0	2.5	2	1.60	T499 0200	T500 0200	T502 0200	T633 0200
0220	M 2.2	x 0.45	P2	1	42	13	-	3.0	2.5	2	1.75	T499 0220	T500 0220	•	•
0230	M 2.3	x 0.40	P2	1	42	13	-	3.0	2.5	2	1.9	T499 0230	T500 0230	•	•
0250	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
0260	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
0300	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
0350	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
0400	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
0500	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
0600	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
0700	M 7	x 1.00	P2	3	65	22	-	6.2	5.0	3	6.0	T499 0700	T500 0700	T502 0700	T633 0700
0800	M 8	x 1.25	P3	3	70	22	-	6.2	5.0	3	6.8	T499 0800	T500 0800	T502 0800	T633 0800
1006	MF 10	x 1.25	P3	3	75	24	-	7.0	5.5	3	8.8	T499 1006	T500 1006	T502 1006	T633 1006
1000	M 10	x 1.50	P3	3	75	24	-	7.0	5.5	3	8.5	T499 1000	T500 1000	T502 1000	T633 1000
1200	M 12	x 1.75	P4	3	82	29	-	8.5	6.5	3	10.2	T499 1200	T500 1200	T502 1200	T633 1200
1400	M 14	x 2.00	P4	3	88	30	-	10.5	8.0	3	12.0	T499 1400	T500 1400	T502 1400	T633 1400
1600	M 16	x 2.00	P4	3	95	32	-	12.5	10.0	4	14.0	T499 1600	T500 1600	T502 1600	T633 1600
1800	M 18	x 2.50	P4	3	100	37	-	14.0	11.0	4	15.5	T499 1800	T500 1800	T502 1800	T633 1800
2000	M 20	x 2.50	P4	3	105	37	-	15.0	12.0	4	17.5	T499 2000	T500 2000	T502 2000	T633 2000
2200	M 22	x 2.50	P4	3	115	38	-	17.0	13.0	4	19.5	T499 2200	T500 2200	T502 2200	T633 2200
2400	M 24	x 3.00	P4	3	120	45	-	19.0	15.0	4	21.0	T499 2400	T500 2400	T502 2400	T633 2400

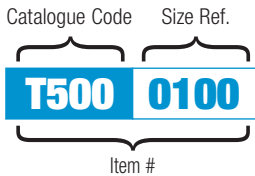
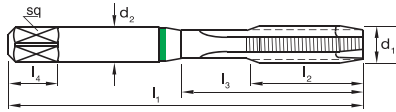
\* Available on request as special manufacture. Subject to lead time.



# JIS Taps Metric, Gun, 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>



Catalogue Code	<b>T605</b>
Discount Group	D0610
Material	<b>PM-HSSE V3</b>
Surface Finish	<b>TiAIN</b>
Colour Ring & Application	<b>UNI</b>
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	Item #
<b>0200</b>	<b>M 2</b>	x 0.40	P2	1	40	12	-	3.0	2.5	2	1.60	T605 0200
<b>0250</b>	<b>M 2.5</b>	x 0.45	P2	1	44	14	-	3.0	2.5	2	2.05	T605 0250
<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	11	19	4.0	3.2	3	2.5	T605 0300
<b>0350</b>	<b>M 3.5</b>	x 0.60	P2	2	48	13	23	4.0	3.2	3	2.9	•
<b>0400</b>	<b>M 4</b>	x 0.70	P2	2	52	13	21	5.0	4.0	3	3.3	T605 0400
<b>0500</b>	<b>M 5</b>	x 0.80	P2	2	60	16	24	5.5	4.5	3	4.2	T605 0500
<b>0600</b>	<b>M 6</b>	x 1.00	P2	2	62	19	31	6.0	4.5	3	5.0	T605 0600
<b>0700</b>	<b>M 7</b>	x 1.00	P2	3	65	22	-	6.2	5.0	3	6.0	•
<b>0800</b>	<b>M 8</b>	x 1.25	P3	3	70	22	-	6.2	5.0	3	6.8	T605 0800
<b>1000</b>	<b>M 10</b>	x 1.50	P3	3	75	24	-	7.0	5.5	3	8.5	T605 1000

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







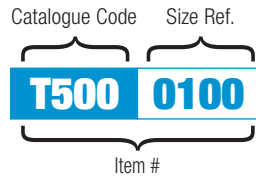
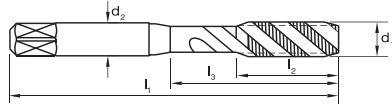




# JIS Taps Metric, Spiral Flute, R40 N



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

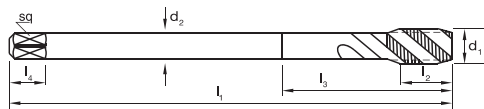
D0602	D0602	D0610	D0610
HSSE V3	HSSE V3	HSSE V3	HSSE V3
Br <sub>t</sub>	Bl <sub>u</sub>	T <sub>IN</sub>	T <sub>ICN</sub>
N	N	N	N
R40	R40	R40	R40
2.5 x P	2.5 x P	2.5 x P	2.5 x P
Item #	Item #	Item #	Item #
<b>T503</b>	<b>T504</b>	<b>T508</b>	<b>T634</b>
T503 0100	•	•	•
T503 0110	•	•	•
T503 0120	•	•	•
T503 0140	•	•	•
T503 0160	•	•	•
T503 0170	•	•	•
T503 0180	•	•	•
T503 0200	T504 0200	T508 0200	T634 0200
T503 0220	T504 0220	T508 0220	•
T503 0230	T504 0230	T508 0230	•
T503 0250	T504 0250	T508 0250	T634 0250
T503 0260	T504 0260	T508 0260	T634 0260
T503 0300	T504 0300	T508 0300	T634 0300
T503 0301			
T503 0350	T504 0350	T508 0350	T634 0350
T503 0400	T504 0400	T508 0400	T634 0400
T503 0401			
T503 0500	T504 0500	T508 0500	T634 0500
T503 0501			
T503 0600	T504 0600	T508 0600	T634 0600
<b>T606    T607    T639    T640</b>			
T606 0200	T607 0200	•	•
T606 0250	T607 0250	•	•
T606 0300	T607 0300	•	•
T606 0350	T607 0350	•	•
T606 0400	T607 0400	•	•
T606 0500	T607 0500	•	•
T606 0600	T607 0600	•	•
T606 0700	T607 0700	T639 0700	T640 0700
T606 0800	T607 0800	T639 0800	T640 0800
T606 1006	T607 1006	T639 1006	T640 1006
T606 1000	T607 1000	T639 1000	T640 1000
T606 1200	T607 1200	T639 1200	T640 1200
T606 1400	T607 1400	T639 1400	T640 1400
T606 1600	T607 1600	T639 1600	T640 1600
T606 1800	T607 1800	T639 1800	T640 1800
T606 2000	T607 2000	T639 2000	T640 2000
T606 2200	T607 2200	T639 2200	T640 2200
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>



Catalogue Code    Size Ref.



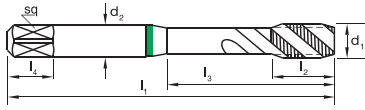
Catalogue Code	<b>T507</b>
Discount Group	D0602
Material	<b>HSSE V3</b>
Surface Finish	<b>Brt</b>
Colour Ring & Application	<b>N</b>
Geometry	R40 Extra Length
Lead	2.5 x P

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	Item #
<b>0400</b>	<b>M 4</b>	x 0.70	P2	2	100	13	21	5.0	4.0	3	3.3	T507 0400
<b>0500</b>	<b>M 5</b>	x 0.80	P2	2	100	16	24	5.5	4.5	3	4.2	T507 0500
<b>0600</b>	<b>M 6</b>	x 1.00	P2	2	100	19	31	6.0	4.5	3	5.0	T507 0600
<b>0800</b>	<b>M 8</b>	x 1.25	P3	3	100	22	-	6.2	5.0	3	6.8	T507 0800
<b>1000</b>	<b>M 10</b>	x 1.50	P3	3	150	24	-	7.0	5.5	3	8.5	T507 1000
<b>1200</b>	<b>M 12</b>	x 1.75	P3	3	150	29	-	8.5	6.5	3	10.2	T507 1200
<b>1600</b>	<b>M 16</b>	x 2.00	P3	3	200	32	-	12.5	10.0	4	14.0	T507 1600
<b>2000</b>	<b>M 20</b>	x 2.50	P3	3	200	37	-	15.0	12.0	4	17.5	T507 2000

# 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.



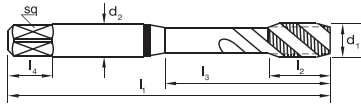
Catalogue Code	D0610
Discount Group	
Material	PM-HSSE V3
Surface Finish	TAIN
Colour Ring & Application	UNI
Geometry	R40
Lead	2.5 x P

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	Item #
<b>WITH POINT</b>												<b>T576</b>
0200	M 2	x 0.40	P2	1	40	-	12	3.0	2.5	2	1.6	T576 0200
0250	M 2.5	x 0.45	P2	1	44	-	14	3.0	2.5	2	2.05	T576 0250
0300	M 3	x 0.50	P2	2	46	5	19	4.0	3.2	3	2.5	T576 0300
0400	M 4	x 0.70	P2	2	52	7	21	5.0	4.0	3	3.3	T576 0400
0500	M 5	x 0.80	P2	2	60	8	24	5.5	4.5	3	4.2	T576 0500
0600	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>
0200	M 2	x 0.40	P2	4	40	-	12	3.0	2.5	2	1.6	T608 0200
0250	M 2.5	x 0.45	P2	4	44	-	14	3.0	2.5	2	2.05	T608 0250
0300	M 3	x 0.50	P2	5	46	5	19	4.0	3.2	3	2.5	T608 0300
0400	M 4	x 0.70	P2	5	52	7	21	5.0	4.0	3	3.3	T608 0400
0500	M 5	x 0.80	P2	5	60	8	24	5.5	4.5	3	4.2	T608 0500
0600	M 6	x 1.00	P2	5	62	10	31	6.0	4.5	3	5.0	T608 0600
0800	M 8	x 1.25	P3	3	70	13	-	6.2	5.0	3	6.8	T608 0800
1000	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 x d<sub>1</sub>



Catalogue Code    Size Ref.

**T500**    **0100**

Item #

Catalogue Code	D0602
Discount Group	HSSE V3
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*	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	z	drill Ø	Item #
<b>With Point</b>												<b>T573</b>
0200	M 2	x 0.40	P1	1	40	12	-	3.0	2.5	2	1.6	T573 0200
0250	M 2.5	x 0.45	P2	1	44	14	-	3.0	2.5	2	2.05	T573 0250
0300	M 3	x 0.50	P2	2	46	5	19	4.0	3.2	2	2.5	T573 0300
0400	M 4	x 0.70	P2	2	52	7	21	5.0	4.0	2	3.3	T573 0400
0500	M 5	x 0.80	P2	2	60	8	24	5.5	4.5	2	4.2	T573 0500
0600	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>
0200	M 2	x 0.40	P1	4	40	12	-	3.0	2.5	2	1.6	T609 0200
0250	M 2.5	x 0.45	P2	4	44	14	-	3.0	2.5	2	2.05	T609 0250
0300	M 3	x 0.50	P2	5	46	5	19	4.0	3.2	2	2.5	T609 0300
0400	M 4	x 0.70	P2	5	52	7	21	5.0	4.0	2	3.3	T609 0400
0500	M 5	x 0.80	P2	5	60	8	24	5.5	4.5	2	4.2	T609 0500
0600	M 6	x 1.00	P2	5	62	10	31	6.0	4.5	2	5.0	T609 0600
0800	M 8	x 1.25	P3	3	70	13		6.2	5.0	2	6.8	T609 0800
1000	M 10	x 1.50	P3	3	75	15		7.0	5.5	2	8.5	T609 1000
1200	M 12	x 1.75	P3	3	82	17.5		8.5	6.5	2	10.2	T609 1200

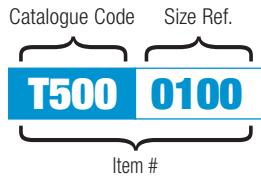
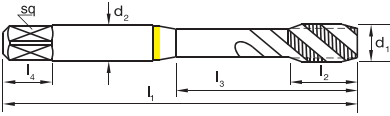
M



# JIS Taps Metric, Spiral Flute, R45 W



- For soft materials
- Blind holes
- Depths up to 3 x d<sub>1</sub>



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

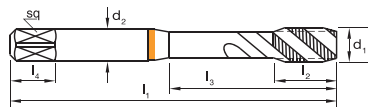
Size Ref.	d <sub>1</sub>	Pitch	Limit	Style*	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	z	drill Ø	Item #
<b>With Point</b>												<b>T567</b>
<b>0200</b>	<b>M 2</b>	x 0.40	P2	4	40	12	-	3.0	2.5	2	1.6	T567 0200
<b>0250</b>	<b>M 2.5</b>	x 0.45	P2	4	44	14	-	3.0	2.5	2	2.05	T567 0250
<b>0300</b>	<b>M 3</b>	x 0.50	P2	2	46	5	19	4.0	3.2	3	2.5	T567 0300
<b>0400</b>	<b>M 4</b>	x 0.70	P2	2	52	7	21	5.0	4.0	3	3.3	T567 0400
<b>0500</b>	<b>M 5</b>	x 0.80	P2	2	60	8	24	5.5	4.5	3	4.2	T567 0500
<b>0600</b>	<b>M 6</b>	x 1.00	P2	2	62	10	31	6.0	4.5	3	5.0	T567 0600
<b>Without Point</b>												<b>T610</b>
<b>0200</b>	<b>M 2</b>	x 0.40	P2	4	40	12	-	3.0	2.5	2	1.6	T610 0200
<b>0250</b>	<b>M 2.5</b>	x 0.45	P2	4	44	14	-	3.0	2.5	2	2.05	T610 0250
<b>0300</b>	<b>M 3</b>	x 0.50	P2	5	46	5	19	4.0	3.2	3	2.5	T610 0300
<b>0400</b>	<b>M 4</b>	x 0.70	P2	5	52	7	21	5.0	4.0	3	3.3	T610 0400
<b>0500</b>	<b>M 5</b>	x 0.80	P2	5	60	8	24	5.5	4.5	3	4.2	T610 0500
<b>0600</b>	<b>M 6</b>	x 1.00	P2	5	62	10	31	6.0	4.5	3	5.0	T610 0600
<b>0800</b>	<b>M 8</b>	x 1.25	P2	3	70	13		6.2	5.0	3	6.8	T610 0800
<b>1000</b>	<b>M 10</b>	x 1.50	P2	3	75	15		7.0	5.5	3	8.5	T610 1000
<b>1200</b>	<b>M 12</b>	x 1.75	P2	3	82	17.5		8.5	6.5	3	10.2	T610 1200
<b>1400</b>	<b>M 14</b>	x 2.00	P2	3	88	20		10.5	8.0	3	12.0	T610 1400
<b>1600</b>	<b>M 16</b>	x 2.00	P2	3	95	20		12.5	10.0	4	12.0	T610 1600
<b>1800</b>	<b>M 18</b>	x 2.50	P3	3	100	25		14.0	11.0	4	15.5	T610 1800
<b>2000</b>	<b>M 20</b>	x 2.50	P3	3	105	25		15.0	12.0	4	17.5	T610 2000



# JIS Taps Metric, Spiral Flute, R45 Cu



- For copper and copper alloys
- Blind holes
- Depths up to 3 x d<sub>1</sub>



Catalogue Code    Size Ref.

**T500**    **0100**

Item #

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

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 #
<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	•

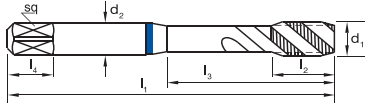
M

\* 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<sub>1</sub>



Catalogue Code Size Ref.



Catalogue Code

Discount Group

Material

Surface Finish

Colour Ring & Application

Geometry

Lead

**T690**

D0602

HSSE V3

*Blu*

VA

R45

2.5 x P

D0602

HSSE V3

*Blu*

VADH

R45

2.5 x P

D0610

HSSE V3

*TICN*

VADH

R45

2.5 x P

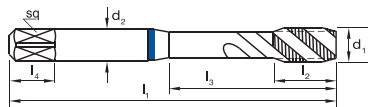
Size Ref.	d <sub>1</sub>	Pitch	Limit	Style*	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	z	drill Ø	Item #	Item #	Item #
<b>With Point</b>														
<b>0100</b>	<b>M 1</b>	x 0.25	P1	1	30	7	-	3.0	2.5	2	0.75	•	•	•
<b>0120</b>	<b>M 1.2</b>	x 0.25	P1	1	32	8	-	3.0	2.5	2	0.95	•	•	•
<b>0140</b>	<b>M 1.4</b>	x 0.30	P1	1	34	9	-	3.0	2.5	2	1.1	•	•	•
<b>0160</b>	<b>M 1.6</b>	x 0.35	P1	1	36	10	-	3.0	2.5	2	1.25	•	•	•
<b>0200</b>	<b>M 2</b>	x 0.40	P2	1	40	12	-	3.0	2.5	2	1.6	•	T570 0200	•
<b>0250</b>	<b>M 2.5</b>	x 0.45	P2	1	44	14	-	3.0	2.5	2	2.05	•	T570 0250	•
<b>0300</b>	<b>M 3</b>	x 0.50	P2	2	46	5	19	4.0	3.2	3	2.5	T690 0300	T570 0300	T571 0300
<b>0400</b>	<b>M 4</b>	x 0.70	P2	2	52	7	21	5.0	4.0	3	3.3	T690 0400	T570 0400	T571 0400
<b>0500</b>	<b>M 5</b>	x 0.80	P2	2	60	8	24	5.5	4.5	3	4.2	T690 0500	T570 0500	T571 0500
<b>0600</b>	<b>M 6</b>	x 1.00	P2	2	62	10	31	6.0	4.5	3	5.0	T690 0600	T570 0600	T571 0600
<b>Without Point</b>														
<b>0200</b>	<b>M 2</b>	x 0.40	P2	4	40	12	-	3.0	2.5	2	1.6	•	•	T612 0200
<b>0250</b>	<b>M 2.5</b>	x 0.45	P2	4	44	14	-	3.0	2.5	2	2.05	•	•	T612 0250
<b>0300</b>	<b>M 3</b>	x 0.50	P2	5	46	5	19	4.0	3.2	3	2.5	•	•	T612 0300
<b>0400</b>	<b>M 4</b>	x 0.70	P2	5	52	7	21	5.0	4.0	3	3.3	•	•	T612 0400
<b>0500</b>	<b>M 5</b>	x 0.80	P2	5	60	8	24	5.5	4.5	3	4.2	•	•	T612 0500
<b>0600</b>	<b>M 6</b>	x 1.00	P2	5	62	10	31	6.0	4.5	3	5.0	•	•	T612 0600
<b>0800</b>	<b>M 8</b>	x 1.25	P3	3	70	13	-	6.2	5.0	3	6.8	T690 0800	T611 0800	T612 0800
<b>1000</b>	<b>M 10</b>	x 1.50	P3	3	75	15	-	7.0	5.5	3	8.5	•	T611 1000	T612 1000
<b>1200</b>	<b>M 12</b>	x 1.75	P3	3	82	17.5	-	8.5	6.5	3	10.2	•	T611 1200	T612 1200
<b>1400</b>	<b>M 14</b>	x 2.00	P3	3	88	20	-	10.5	8.0	3	12.0	•	T611 1400	T612 1400
<b>1600</b>	<b>M 16</b>	x 2.00	P3	3	95	20	-	12.5	10.0	4	14.0	•	T611 1600	T612 1600
<b>1800</b>	<b>M 18</b>	x 2.50	P3	3	100	25	-	14.0	11.0	4	15.5	•	T611 1800	T612 1800
<b>2000</b>	<b>M 20</b>	x 2.50	P3	3	105	25	-	15.0	12.0	4	17.5	•	T611 2000	T612 2000

• 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.



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

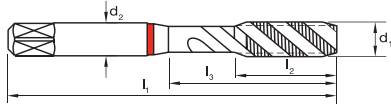
Size Ref.	d <sub>1</sub>	Pitch	Limit	Style*	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	z	drill Ø	Item #
<b>With Point</b>												<b>T566</b>
0200	M 2	x 0.40	P1	1	40	12	-	3.0	2.5	2	1.6	T566 0200
0250	M 2.5	x 0.45	P2	1	44	14	-	3.0	2.5	2	2.05	T566 0250
0300	M 3	x 0.50	P2	2	46	5	19	4.0	3.2	3	2.5	T566 0300
0400	M 4	x 0.70	P2	2	52	7	21	5.0	4.0	3	3.3	T566 0400
0500	M 5	x 0.80	P2	2	60	8	24	5.5	4.5	3	4.2	T566 0500
0600	M 6	x 1.00	P2	2	62	10	31	6.0	4.5	3	5.0	T566 0600
<b>Without Point</b>												<b>T613</b>
0200	M 2	x 0.40	P1	4	40	12	-	3.0	2.5	2	1.6	T613 0200
0250	M 2.5	x 0.45	P2	4	44	14	-	3.0	2.5	2	2.05	T613 0250
0300	M 3	x 0.50	P2	5	46	5	19	4.0	3.2	3	2.5	T613 0300
0400	M 4	x 0.70	P2	5	52	7	21	5.0	4.0	3	3.3	T613 0400
0500	M 5	x 0.80	P2	5	60	8	24	5.5	4.5	3	4.2	T613 0500
0600	M 6	x 1.00	P2	5	62	10	31	6.0	4.5	3	5.0	T613 0600
0800	M 8	x 1.25	P3	3	70	13		6.2	5.0	3	6.8	T613 0800
1000	M 10	x 1.50	P3	3	75	15		7.0	5.5	3	8.5	T613 1000

M

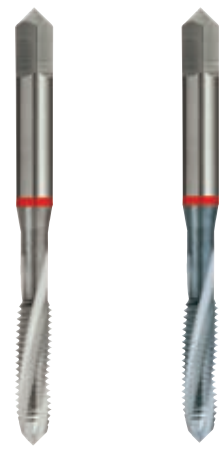
# JIS Taps Metric, Spiral Flute, R15 H



- Suitable for harder short chipping materials up to 45 HR.
- Blind holes
- Depths up to 1.5 x d<sub>1</sub>



Catalogue Code    Size Ref.



<b>Catalogue Code</b>	D0602	D0610
<b>Discount Group</b>		
<b>Material</b>	PM-HSS Co	PM-HSS Co
<b>Surface Finish</b>	<b>Brt</b>	<b>TiCN</b>
<b>Colour Ring &amp; Application</b>	<b>H</b>	<b>H</b>
<b>Geometry</b>	R15 Low Relief	R15 Low Relief
<b>Lead</b>	3 x P	3 x P

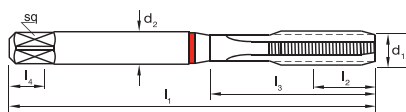
Size Ref.	d <sub>1</sub>	Pitch	Limit	Style*	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	z	drill Ø	Item #	Item #
<b>With Point</b>													
<b>0200</b>	<b>M 2</b>	x 0.40	P2	1	40	12	-	3.0	2.5	2	1.6	<b>T577</b>	<b>T578</b>
<b>0250</b>	<b>M 2.5</b>	x 0.45	P2	1	44	14	-	3.0	2.5	2	2.05	T577 0200	•
<b>0300</b>	<b>M 3</b>	x 0.50	P3	2	46	11	19	4.0	3.2	3	2.5	T577 0250	•
<b>0400</b>	<b>M 4</b>	x 0.70	P3	2	52	13	21	5.0	4.0	3	3.3	T577 0300	T578 0300
<b>0500</b>	<b>M 5</b>	x 0.80	P3	2	60	16	24	5.5	4.5	3	4.2	T577 0400	T578 0400
<b>0600</b>	<b>M 6</b>	x 1.00	P2	2	62	19	31	6.0	4.5	3	5.0	T577 0500	T578 0500
												T577 0600	T578 0600
<b>Without Point</b>													
<b>0200</b>	<b>M 2</b>	x 0.40	P2	4	40	12	-	3.0	2.5	2	1.6	<b>T638</b>	<b>T614</b>
<b>0250</b>	<b>M 2.5</b>	x 0.45	P2	4	44	14	-	3.0	2.5	2	2.05	•	T614 0200
<b>0300</b>	<b>M 3</b>	x 0.50	P3	5	46	11	19	4.0	3.2	3	2.5	•	T614 0250
<b>0400</b>	<b>M 4</b>	x 0.70	P3	5	52	13	21	5.0	4.0	3	3.3	•	T614 0300
<b>0500</b>	<b>M 5</b>	x 0.80	P3	5	60	16	24	5.5	4.5	3	4.2	•	T614 0400
<b>0600</b>	<b>M 6</b>	x 1.00	P2	5	62	19	31	6.0	4.5	3	5.0	•	T614 0500
<b>0800</b>	<b>M 8</b>	x 1.25	P3	3	70	22		6.2	5.0	3	6.8	•	T614 0600
<b>1000</b>	<b>M 10</b>	x 1.50	P3	3	75	24		7.0	5.5	3	8.5	T638 0800	T614 0800
<b>1200</b>	<b>M 12</b>	x 1.75	P3	3	82	29		8.5	6.5	3	10.2	T638 1000	T614 1000
<b>1400</b>	<b>M 14</b>	x 2.00	P4	3	88	30		10.5	8.0	3	12.0	T638 1200	T614 1200
<b>1600</b>	<b>M 16</b>	x 2.00	P4	3	95	32		12.5	10.0	4	14.0	T638 1400	T611 1400
<b>1800</b>	<b>M 18</b>	x 2.50	P4	3	100	37		14.0	11.0	4	15.5	T638 1600	T611 1600
<b>2000</b>	<b>M 20</b>	x 2.50	P4	3	105	37		15.0	12.0	4	17.5	T638 1800	T611 1800
												T638 2000	T611 2000

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

# JIS Taps Metric, Straight Flute, XH & VH



- XH, use in hardened steels 42-52 HR<sub>c</sub>
- VH, use in hardened steels 50-60 HR<sub>c</sub>
- Through & blind holes
- Depths up to approx. 1.5 x d<sub>1</sub>



Catalogue Code    Size Ref.



<b>Catalogue Code</b>	<b>T294</b>	<b>T295</b>	<b>T296</b>
<b>Discount Group</b>	D0610	D0610	D0610
<b>Material</b>	<b>SPM</b>	<b>SPM</b>	<b>VHM</b>
<b>Surface Finish</b>	<b>TICN</b>	<b>TICN</b>	<b>TICN</b>
<b>Colour Ring &amp; Application</b>	<b>XH</b>	<b>XH</b>	<b>VH</b>
<b>Geometry</b>	Special Relief	Special Relief	Special Relief
<b>Lead</b>	3 x P	5 x P	Form C/3 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>0300</b>	<b>M 3</b>	x 0.50	6HX	2	46	11	18	3.5	2.7	4	2.55	T294 0300	T295 0300	T296 0300
<b>0400</b>	<b>M 4</b>	x 0.70	6HX	2	52	13	21	4.5	3.4	4	3.4	T294 0400	T295 0400	T296 0400
<b>0500</b>	<b>M 5</b>	x 0.80	6HX	2	60	16	25	6.0	4.9	4	4.3	T294 0500	T295 0500	T296 0500
<b>0600</b>	<b>M 6</b>	x 1.00	6HX	2	62	19	30	6.0	4.9	4	5.1	T294 0600	T295 0600	T296 0600
<b>0800</b>	<b>M 8</b>	x 1.25	6HX	3	70	22	-	6.0	4.9	5	6.9	T294 0800	T295 0800	T296 0800
<b>1000</b>	<b>M 10</b>	x 1.50	6HX	3	75	24	-	7.0	5.5	5	8.6	T294 1000	T295 1000	T296 1000
<b>1200</b>	<b>M 12</b>	x 1.75	6HX	3	82	29	-	9.0	7.0	5	10.3	T294 1200	T295 1200	T296 1200
<b>1600</b>	<b>M 16</b>	x 2.00	6HX	3	95	32	-	12.0	9.0	5	14.1	T294 1600	T295 1600	•
<b>2000</b>	<b>M 20</b>	x 2.50	6HX	3	105	37	-	16.0	12.0	5	17.7	T294 2000	T295 2000	•

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

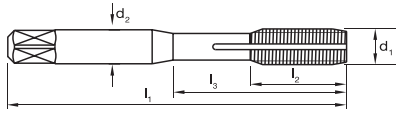




# JIS Taps UNC, Forming, Single Coolant Groove



- 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>



Catalogue Code Size Ref.



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>											
0185	#1	64	GH4	1	40	12	-	3	2.5	4	1.63 - 1.70
0218	#2	56	GH4	1	42	12	0	3	2.5	4	1.93 - 2.00
0251	#3	48	GH4	1	44	14	0	3.0	2.5	4	2.21 - 2.30
0284	#4	40	GH5	2	46	11	23	3.0	2.5	4	2.49 - 2.59
0318	#5	40	GH5	2	46	9	23	4.0	3.2	4	2.82 - 2.92
0351	#6	32	GH6	2	48	9	23	4.0	3.2	4	3.11 - 3.19
0417	#8	32	GH6	2	52	10	21	5.0	4.0	4	3.77 - 3.85
0483	#10	24	GH6	2	60	11	25	5.5	4.5	4	4.27 - 4.38
0549	#12	24	GH6	2	62	11	24	6.0	4.5	4	4.93 - 5.04
0635	1/4	20	GH7	2	62	14	31	6.0	4.5	4	5.67 - 5.80
0794	5/16	18	GH7	3	70	22	0	6.1	5.0	6	7.18 - 7.32
0953	3/8	16	GH7	3	75	24	0	7.0	5.5	6	8.66 - 8.82
1111	7/16	14	GH8	3	80	29	0	8.0	6.0	8	10.12 - 10.30
1270	1/2	13	GH8	3	85	29	0	9.0	7.0	8	11.63 - 11.82
<b>B Lead</b>											
0185	#1	64	GH4	1	40	12	-	3	2.5	4	1.63 - 1.70
0218	#2	56	GH4	1	42	12	0	3	2.5	4	1.93 - 2.00
0251	#3	48	GH4	1	44	14	0	3.0	2.5	4	2.21 - 2.30
0284	#4	40	GH5	5	46	11	23	3.0	2.5	4	2.49 - 2.59
0318	#5	40	GH5	5	46	9	23	4.0	3.2	4	2.82 - 2.92
0351	#6	32	GH6	5	48	9	23	4.0	3.2	4	3.11 - 3.19
0417	#8	32	GH6	5	52	10	21	5.0	4.0	4	3.76 - 3.85
0483	#10	24	GH6	5	60	11	25	5.5	4.5	4	4.27 - 4.38
0549	#12	24	GH6	5	62	11	24	6.0	4.5	4	4.93 - 5.04
0635	1/4	20	GH7	5	62	14	31	6.0	4.5	4	5.68 - 5.80
0794	5/16	18	GH7	3	70	22	0	6.1	5.0	6	7.18 - 7.32
0953	3/8	16	GH7	3	75	24	0	7.0	5.5	6	8.66 - 8.82
1111	7/16	14	GH8	3	80	29	0	8.0	6.0	8	10.12 - 10.30
1270	1/2	13	GH8	3	85	29	0	9.0	7.0	8	11.63 - 11.82

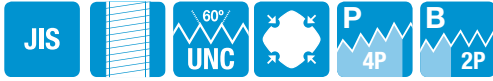
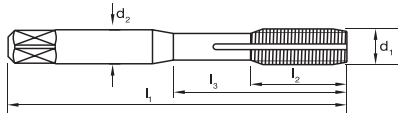


Catalogue Code	D0606	D0614
Discount Group	HSS Co.8	HSS Co.8
Material	Ni	TiN
Surface Finish	Small Production	Medium Production
Colour Ring & Application	1 Coolant Groove #4+	1 Coolant Groove #4+
Geometry	2P & 4P	2P & 4P
Lead	Item #	Item #
	<b>T522</b>	<b>T526</b>
	T522 0185	T526 0185
	T522 0218	T526 0218
	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
	<b>T523</b>	<b>T527</b>
	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

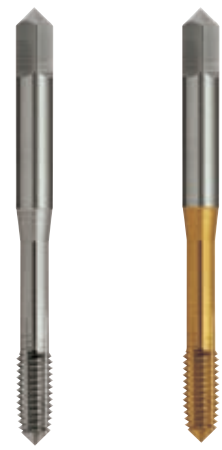
# JIS Taps UNC, Forming, Multi Coolant Groove



- 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.



<b>Catalogue Code</b>	D0606	D0614
<b>Discount Group</b>		
<b>Material</b>	HSS Co.8	HSS Co.8
<b>Surface Finish</b>	Ni	TiN
<b>Colour Ring &amp; Application</b>	Small Production	Medium Production
<b>Geometry</b>	Multi Coolant Groove	Multi Coolant Groove
<b>Lead</b>	2P & 4P	2P & 4P

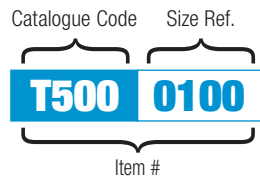
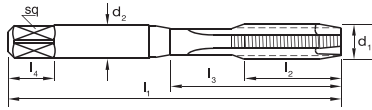
Size Ref.	d <sub>1</sub>	Pitch	Limit	Style*	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	z	Tap hole min/max	Item #	Item #
<b>P Lead</b>													
<b>0351</b>	<b>#6</b>	32	GH6	2	48	9	23	4.0	3.2	4	3.11 - 3.19	<b>T528</b>	<b>T662</b>
<b>0417</b>	<b>#8</b>	32	GH6	2	52	10	21	5.0	4.0	4	3.77 - 3.85	T528 0351	T662 0351
<b>0483</b>	<b>#10</b>	24	GH6	2	60	11	25	5.5	4.5	4	4.27 - 4.38	T528 0417	T662 0417
<b>0549</b>	<b>#12</b>	24	GH6	2	62	11	24	6.0	4.5	4	4.93 - 5.04	T528 0483	T662 0483
<b>0635</b>	<b>1/4</b>	20	GH7	2	62	14	31	6.0	4.5	4	5.67 - 5.80	T528 0549	T662 0549
												T528 0635	T662 0635
<b>B Lead</b>													
<b>0351</b>	<b>#6</b>	32	GH6	5	48	9	23	4.0	3.2	4	3.11 - 3.19	<b>T529</b>	<b>T663</b>
<b>0417</b>	<b>#8</b>	32	GH6	5	52	10	21	5.0	4.0	4	3.77 - 3.85	T529 0351	T663 0351
<b>0483</b>	<b>#10</b>	24	GH6	5	60	11	25	5.5	4.5	4	4.27 - 4.38	T529 0417	T663 0417
<b>0549</b>	<b>#12</b>	24	GH6	5	62	11	24	6.0	4.5	4	4.93 - 5.04	T529 0483	T663 0483
<b>0635</b>	<b>1/4</b>	20	GH7	5	62	14	31	6.0	4.5	4	5.67 - 5.80	T529 0549	T663 0549
												T529 0635	T663 0635

UNC

# 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>



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

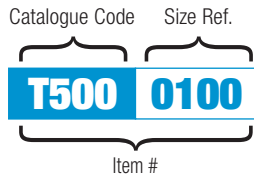
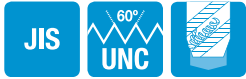
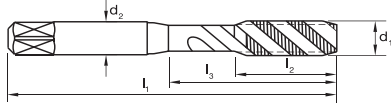


Catalogue Code	T615	T616	T617
Discount Group	D0602	D0602	D0610
Material	HSSE V3	HSSE V3	HSSE V3
Surface Finish	<i>Brt</i>	<i>Blu</i>	<i>TiN</i>
Colour Ring & Application	N	N	N
Geometry			
Lead	5 x P	5 x P	5 x P
Item #	Item #	Item #	Item #
T615 0185	T616 0185	T617 0185	
T615 0218	T616 0218	T617 0218	
T615 0251	T616 0251	T617 0251	
T615 0284	T616 0284	T617 0284	
T615 0318	T616 0318	T617 0318	
T615 0351	T616 0351	T617 0351	
T615 0417	T616 0417	T617 0417	
T615 0483	T616 0483	T617 0483	
T615 0549	T616 0549	T617 0549	
T615 0635	T616 0635	T617 0635	
T615 0794	T616 0794	T617 0794	
T615 0953	T616 0953	T617 0953	
T615 1111	T616 1111	T617 1111	
T615 1270	T616 1270	T617 1270	
T615 1588	T616 1588	T617 1588	
T615 1905	T616 1905	T617 1905	
T615 2223	T616 2223	T617 2223	
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	<b>T618</b>	<b>T619</b>	<b>T620</b>
Discount Group	D0602	D0602	D0610
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	R40	R40	R40
Lead	2.5 x P	2.5 x P	2.5 x P

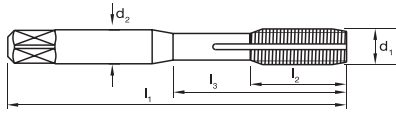
Size Ref.	d <sub>1</sub>	Pitch	Limit	Style*	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	z	drill Ø	Item #	Item #	Item #
<b>0185</b>	<b>#1</b>	64	2B	1	40	12	-	3.0	2.5	2	1.55	T618 0185	T619 0185	T620 0185
<b>0218</b>	<b>#2</b>	56	2B	1	42	14	-	3.0	2.5	2	1.80	T618 0218	T619 0218	T620 0218
<b>0251</b>	<b>#3</b>	48	2B	1	44	14	-	3.0	2.5	2	2.05	T618 0251	T619 0251	T620 0251
<b>0284</b>	<b>#4</b>	40	2B	2	46	11	23	3.0	2.5	2	2.30	T618 0284	T619 0284	T620 0284
<b>0318</b>	<b>#5</b>	40	2B	2	46	11	23	4.0	3.2	3	2.60	T618 0318	T619 0318	T620 0318
<b>0351</b>	<b>#6</b>	32	2B	2	48	13	23	4.0	3.2	3	2.80	T618 0351	T619 0351	T620 0351
<b>0417</b>	<b>#8</b>	32	2B	2	52	13	21	5.0	4.0	3	3.4	T618 0417	T619 0417	T620 0417
<b>0483</b>	<b>#10</b>	24	2B	2	60	16	25	5.5	4.5	3	3.9	T618 0483	T619 0483	T620 0483
<b>0549</b>	<b>#12</b>	24	2B	2	62	19	24	6.0	4.5	3	4.5	T618 0549	T619 0549	T620 0549
<b>0635</b>	<b>1/4</b>	20	2B	2	62	19	31	6.0	4.5	3	5.1	T618 0635	T619 0635	T620 0635
<b>0794</b>	<b>5/16</b>	18	2B	3	70	22	-	6.1	5.0	3	6.6	T618 0794	T619 0794	T620 0794
<b>0953</b>	<b>3/8</b>	16	2B	3	75	24	-	7.0	5.5	3	8.0	T618 0953	T619 0953	T620 0953
<b>1111</b>	<b>7/16</b>	14	2B	3	80	29	-	8.0	6.0	3	9.4	T618 1111	T619 1111	T620 1111
<b>1270</b>	<b>1/2</b>	13	2B	3	85	29	-	9.0	7.0	3	10.8	T618 1270	T619 1270	T620 1270
<b>1588</b>	<b>5/8</b>	11	2B	3	95	32	-	12.5	10.0	4	13.5	T618 1588	T619 1588	T620 1588
<b>1905</b>	<b>3/4</b>	10	2B	3	105	37	-	14.0	11.0	4	16.5	T618 1905	T619 1905	T620 1905
<b>2223</b>	<b>7/8</b>	9	2B	3	115	38	-	17.0	13.0	4	19.5	T618 2223	T619 2223	T620 2223
<b>2540</b>	<b>1</b>	8	2B	3	120	45	-	20.0	15.0	4	22.5	T618 2540	T619 2540	T620 2540

UNC

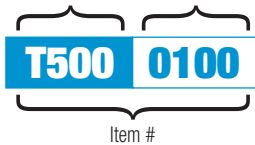
# JIS Taps UNF, Forming, Single Coolant Groove



- 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>



Catalogue Code    Size Ref.



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



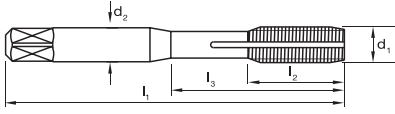
Catalogue Code	D0606	D0614
Discount Group	HSS Co.8	HSS Co.8
Material	Ni	TiN
Surface Finish	Small Production	Medium Production
Colour Ring & Application	1 Coolant Groove #4+	1 Coolant Groove #4+
Geometry	2P & 4P	2P & 4P
Lead	Item #	Item #
	<b>T534</b>	<b>T538</b>
	T534 0152	T538 0152
	•	•
	T534 0218	T538 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
	<b>T535</b>	<b>T539</b>
	T535 0152	T539 0152
	•	•
	T535 0218	T539 0218
	T535 0251	T539 0251
	T535 0284	T539 0284
	T535 0318	T539 0318
	T535 0351	T539 0351
	T535 0417	T539 0417
	T535 0483	T539 0483
	T535 0549	T539 0549
	T535 0635	T539 0635

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

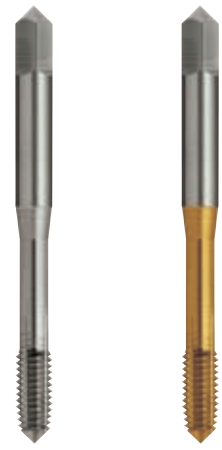
# JIS Taps UNF, Forming, Multi Coolant Groove



- 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.



<b>Catalogue Code</b>	D0606	D0614
<b>Discount Group</b>		
<b>Material</b>	HSS Co.8	HSS Co.8
<b>Surface Finish</b>	Ni	TiN
<b>Colour Ring &amp; Application</b>	Small Production	Medium Production
<b>Geometry</b>	Multi Coolant Groove	Multi Coolant Groove
<b>Lead</b>	2P & 4P	2P & 4P

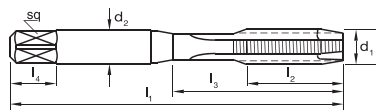
Size Ref.	d <sub>1</sub>	Pitch	Limit	Style*	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	z	Tap hole min/max	Item #	Item #
<b>P Lead</b>													
<b>0351</b>	<b>#6</b>	40	GH6	2	48	9	23	4.0	3.2	4	3.20 - 3.27	T540 0351	T544 0351
<b>0417</b>	<b>#8</b>	36	GH6	2	52	10	21	5.0	4.0	4	3.82 - 3.89	T540 0417	T544 0417
<b>0483</b>	<b>#10</b>	32	GH6	2	60	11	25	5.5	4.5	4	4.43 - 4.51	T540 0483	T544 0483
<b>0549</b>	<b>#12</b>	28	GH6	2	62	11	24	6.0	4.5	4	5.03 - 5.12	T540 0549	T544 0549
<b>0635</b>	<b>1/4</b>	28	GH7	2	62	14	31	6.0	4.5	4	5.93 - 5.98	T540 0635	T544 0635
<b>B Lead</b>													
<b>0351</b>	<b>#6</b>	40	GH6	5	48	9	23	4.0	3.2	4	3.20 - 3.27	T541 0351	T545 0351
<b>0417</b>	<b>#8</b>	36	GH6	5	52	10	21	5.0	4.0	4	3.82 - 3.89	T541 0417	T545 0417
<b>0483</b>	<b>#10</b>	32	GH6	5	60	11	25	5.5	4.5	4	4.43 - 4.51	T541 0483	T545 0483
<b>0549</b>	<b>#12</b>	28	GH6	5	62	11	24	6.0	4.5	4	5.03 - 5.12	T541 0549	T545 0549
<b>0635</b>	<b>1/4</b>	28	GH7	5	62	14	31	6.0	4.5	4	5.93 - 5.98	T541 0635	T545 0635

UNF

# 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.



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



Catalogue Code	<b>T621</b>	<b>T622</b>	<b>T623</b>
Discount Group	D0602	D0602	D0610
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			
Lead	5 x P	5 x P	5 x P

Item #	Item #	Item #
T621 0152	T622 0152	T623 0152
T621 0185	T622 0185	T623 0185
T621 0218	T622 0218	T623 0218
T621 0251	T622 0251	T623 0251
T621 0284	T622 0284	T623 0284
T621 0318	T622 0318	T623 0318
T621 0351	T622 0351	T623 0351
T621 0417	T622 0417	T623 0417
T621 0483	T622 0483	T623 0483
T621 0549	T622 0549	T623 0549
T621 0635	T622 0635	T623 0635
T621 0794	T622 0794	T623 0794
T621 0953	T622 0953	T623 0953
T621 1111	T622 1111	T623 1111
T621 1270	T622 1270	T623 1270
T621 1588	T622 1588	T623 1588
T621 1905	T622 1905	T623 1905
T621 2223	T622 2223	T623 2223
T621 2540	T622 2540	T623 2540

UNF

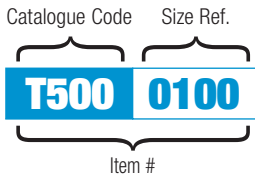
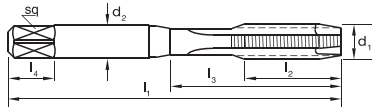




# JIS Taps BSW, Gun, N (Spiral Point)



- 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  
Discount Group  
Material  
Surface Finish  
Colour Ring & Application  
Geometry  
Lead

	<b>T491</b>	<b>T492</b>	<b>T494</b>	<b>T635</b>
	D0602	D0602	D0610	D0610
	<b>HSSE V3</b>	<b>HSSE V3</b>	<b>HSSE V3</b>	<b>HSSE V3</b>
	<b>Brt</b>	<b>Blu</b>	<b>TiN</b>	<b>TiCN</b>
	<b>N</b>	<b>N</b>	<b>N</b>	<b>N</b>
	5 x P	5 x P	5 x P	5 x P
	<b>Item #</b>	<b>Item #</b>	<b>Item #</b>	<b>Item #</b>
<b>0318</b>	T491 0318	T492 0318	T494 0318	•
<b>0397</b>	•	•	•	•
<b>0476</b>	T491 0476	T492 0476	T494 0476	•
<b>0556</b>	T491 0556	T492 0556	•	•
<b>0635</b>	T491 0635	T492 0635	T494 0635	T635 0635
<b>0794</b>	T491 0794	T492 0794	T494 0794	T635 0794
<b>0953</b>	T491 0953	T492 0953	T494 0953	T635 0953
<b>1111</b>	T491 1111	T492 1111	T494 1111	T635 1111
<b>1270</b>	T491 1270	T492 1270	T494 1270	T635 1270
<b>1428</b>	T491 1428	T492 1428	T494 1428	T635 1428
<b>1588</b>	T491 1588	T492 1588	T494 1588	T635 1588
<b>1905</b>	T491 1905	T492 1905	T494 1905	T635 1905
<b>2223</b>	T491 2223	T492 2223	T494 2223	T635 2223
<b>2540</b>	T491 2540	T492 2540	T494 2540	T635 2540

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>0318</b>	1/8	40	GH3	2	46	11	19	4.0	3.2	3	2.55
<b>0397</b>	5/32	32	GH3	2	52	13	21	5.0	4.0	3	3.2
<b>0476</b>	3/16	24	GH3	2	60	16	25	5.5	4.5	3	3.7
<b>0556</b>	7/32	24	GH3	2	62	19	24	6.0	4.5	3	4.5
<b>0635</b>	1/4	20	GH4	2	62	19	31	6.0	4.5	3	5.1
<b>0794</b>	5/16	18	GH4	3	70	22	-	6.1	5.0	3	6.5
<b>0953</b>	3/8	16	GH4	3	75	24	-	7.0	5.5	3	8
<b>1111</b>	7/16	14	GH4	3	80	29	-	8.0	6.0	3	9.3
<b>1270</b>	1/2	12	GH5	3	85	29	-	9.0	7.0	3	10.5
<b>1428</b>	9/16	12	GH5	3	88	30	-	11.0	8.0	3	12.2
<b>1588</b>	5/8	11	GH5	3	95	32	-	12.5	10.0	4	13.5
<b>1905</b>	3/4	10	GH5	3	105	37	-	14.0	11.0	4	16.5
<b>2223</b>	7/8	9	GH5	3	115	38	-	17.0	13.0	4	19.5
<b>2540</b>	1	8	GH6	3	120	45	-	20.0	15.0	4	22

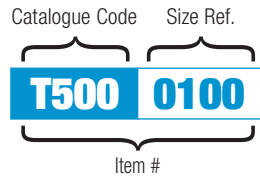
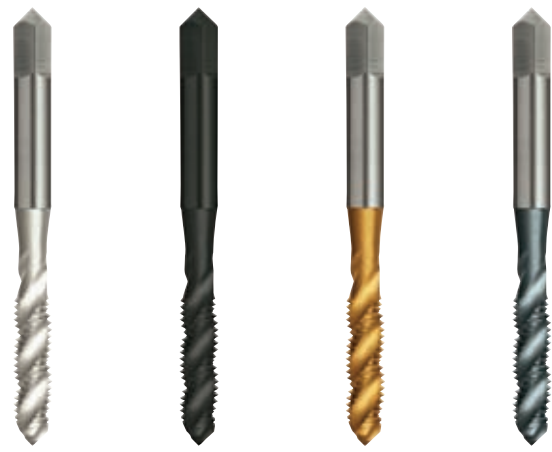
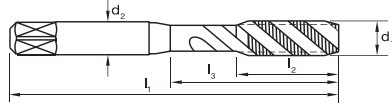
\* Available on request as special manufacture. Subject to lead time.



# 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>1</sub>



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

	<b>T495</b>	<b>T496</b>	<b>T498</b>	<b>T636</b>
	D0602	D0602	D0610	D0610
	<b>HSSE V3</b>	<b>HSSE V3</b>	<b>HSSE V3</b>	<b>HSSE V3</b>
	<b>Brt</b>	<b>Blu</b>	<b>TiN</b>	<b>TiCN</b>
	<b>N</b>	<b>N</b>	<b>N</b>	<b>N</b>
	R40	R40	R40	R40
	2.5 x P	2.5 x P	2.5 x P	2.5 x P
Item #	Item #	Item #	Item #	Item #
T495 0318	T496 0318	T498 0318	•	•
•	•	•	•	•
T495 0476	T496 0476	T498 0476	•	T636 0476
•	•	•	•	•
T495 0635	T496 0635	T498 0635	•	T636 0635
T495 0636				
T495 0794	T496 0794	T498 0794	•	T636 0794
T495 0953	T496 0953	T498 0953	•	T636 0953
•	•	•	•	•
T495 1270	T496 1270	T498 1270	•	T636 1270
•	•	•	•	•
T495 1588	T496 1588	T498 1588	•	T636 1588
T495 1905	T496 1905	T498 1905	•	T636 1905
T495 2223	T496 2223	T498 2223	•	T636 2223
T495 2540	T496 2540	T498 2540	•	T636 2540

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>0318</b>	1/8	40	Z3	2	46	11	19	4.0	3.2	3	2.55
<b>0397</b>	5/32	32	Z3	2	52	13	21	5.0	4.0	3	3.2
<b>0476</b>	3/16	24	Z3	2	60	16	25	5.5	4.5	3	3.7
<b>0556</b>	7/32	24	Z3	2	62	19	24	6.0	4.5	3	4.5
<b>0635</b>	1/4	20	Z3	2	62	19	31	6.0	4.5	3	5.1
<b>0636</b>	1/4	20	P2	2	62	19	31	6.0	4.5	3	5.1
<b>0794</b>	5/16	18	Z3	3	70	22	-	6.1	5.0	3	6.5
<b>0953</b>	3/8	16	Z3	3	75	24	-	7.0	5.5	3	8
<b>1111</b>	7/16	14	Z3	3	80	29	-	8.0	6.0	3	9.3
<b>1270</b>	1/2	12	Z3	3	85	29	-	9.0	7.0	3	10.5
<b>1428</b>	9/16	12	Z3	3	88	30	-	11.0	8.0	3	12.2
<b>1588</b>	5/8	11	Z3	3	95	32	-	12.5	10.0	4	13.5
<b>1905</b>	3/4	10	Z3	3	105	37	-	14.0	11.0	4	16.5
<b>2223</b>	7/8	9	Z3	3	115	38	-	17.0	13.0	4	19.5
<b>2540</b>	1	8	Z3	3	120	45	-	20.0	15.0	4	22

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



# 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

