

DISTINCTIVE GEOMETRIES , APPLICATION AGILITY AND COATING TOUGHNESS

ALL MAKE **SOMTA TOOLS** PROUD LEADERS OF **WORLD CLASS CUTTING TOOLS**

THAT CAN ENDURE IN ANY MACHINED MATERIAL



P 1 2 C A T A L O G U E



Manufacturers & Suppliers of Drills, Reamers, End Mills, Bore Cutters, Taps & Dies, Toolbits, Solid Carbide Tooling, Carbide Insert Tooling, Custom Tools and Surface Coatings

Somta Tools was founded in 1954 by Samuel Osborn Ltd of Sheffield, England, through its subsidiaries Osborn Steels and Osborn Mushet Tools. The name Somta was chosen as the acronym for these companies operating in South Africa.

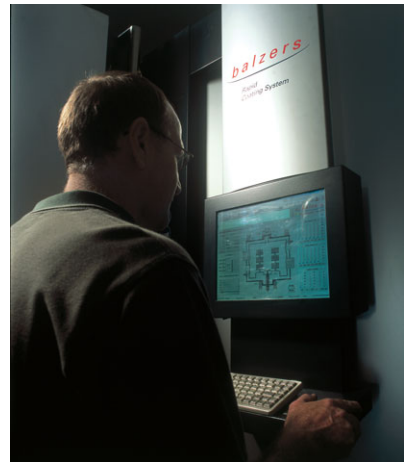
Somta continues to operate from its original site on Moses Mabhidale (formerly Edendale) Road in Pietermaritzburg. Somta's expansion has been brought about by the acquisition of two cutting tool companies during the 1980's. Additional growth is realised by continual investment in new plant, with emphasis on state of the art CNC equipment such as Junker, Normac, Rollomatic, Walter, Reinecker and Reishauer machines including new ANCA and Walter CNC grinding machines to further expand solid carbide range manufacturing capacity.

From humble beginnings in 1954 with 20 employees, Somta has grown into one of the largest cutting tool manufacturers in the southern hemisphere, operating from offices and modern manufacturing facilities laid out over 3 hectares with a complement of over 500 employees.

The factory in Pietermaritzburg manufactures 25 000 standard items and a further 6 000 made-to-order items to serve local markets and export markets in over 70 countries worldwide.

Somta Tools specialises in the design and manufacture of standard and custom tools for the industrial and "do it yourself" markets. Product categories can be summarised as drills, cutters, reamers, threading tools and toolbits, which are made in a wide range of sizes, using various materials (HSS and Solid Carbide) and Balzers PVD surface coatings to extend wear life.

The company's vision of "To manufacture and supply superior cutting tools, driven by a culture of service excellence, to global and domestic markets" is supported by ISO 9002 which was achieved in 1991 and ISO 9001 in 2003 and 2008.



Somta has integrated a state of the art Balzers PVD Rapid coating system into its manufacturing programme, offering the innovative range of Balzers BALINIT® high performance coatings on all cutting tools.





























ICON

LEGEND & DESCRIPTION

Material	HSS	High Speed Steel	HSS Co5	5% Cobalt High Speed Steel	HSS Co8	8% Cobalt High Speed Steel	HSS Co8e	8% Cobalt HSS, Eccentric Relief Sharpening		
	HSS V3	3% Vanadium High Speed Steel	SOLID CARBIDE	9-10% Cobalt, 0.2-0.8 µm Grain size.	CARBON STEEL	Carbon Steel				
Finish	BLUE FINISH	Steam (HOMO) Temper	BRIGHT FINISH	No Surface Treatment	BRIGHT FINISH WITH TIN TIP	TIN Coated for a length of 4 x diameter				
	GOLD OXIDE	Steam (HOMO) Temper Straw Colour	TiAIN	Titanium Aluminium Nitride (Black Finish)	TiIN	Titanium Nitride (Gold Finish)	X.TREME	TiAlN suited to Solid Carbide (Violet -grey Finish)		
Type	TYPE N	Type N Standard	TYPE W	Type W For Soft Materials	TYPE H	Type H For Hard Materials	TYPE FS	Parabolic Flute Strong Core		
	CBA	Colour Band Application								
Milling Profile		Staggered Teeth Side & Face Cutters		Straight Teeth Side & Face Cutters						
		Fine Pitch Knuckle Type Roughing Profile		Coarse Pitch Knuckle Type Roughing Profile		Fine Pitch Flat Crest Rough Semi-finishing Profile		Coarse Pitch Flat Crest Rough Semi-finishing Profile		
Standard	ISO 529	ISO Standard 529	DIN 371	DIN Standard 371	WORKS STD.	Factory Specifications				
	RF	Refined Flute	QS	Quick Spiral	H 7	Reamer to produce H7 Tolerance				
Shank		Flatted Shank h6 Tolerance		Plain Shank h7 Tolerance		Threaded Shank h8 Tolerance		Carbide Plain Shank h6 Tolerance		
		Morse Taper Shank MT 3 - 5								
Point Angle								Drill Point Angles		
		Countersink Angles 60° & 90°								
Lengths		Drills Stub Series		Drills Jobber Series		Drills Long Series		Drills Extra Length Series		
		End Mills Regular Series		End Mills Long Series						
Flute Helix Angle										Right hand helix
				Left hand helix						
Centre Drills		Form A Standard		Form B Protected		Form R Radius				
		To Suit 1 in 10 Taper		To Suit 1 in 50 Taper		To Suit 1 in 48 Taper				
Inclination	1:10		1:50		1:48					

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LEGEND & DESCRIPTION... from previous page

Threads	M	Metric	MF	Metric Fine	BSW	British Standard Whitworth	BSF	British Standard Whitworth Fine			
	UNC	Unified National Coarse	UNF	Unified National Fine	BSPT	British Standard Pipe Taper "F" Series	BSP	British Standard Pipe (Fine) "G" Series			
	NPS	National Pipe Straight	NPT	National Pipe Taper	BA	British Association	BSB	British Standard Brass			
				Thread Form - with 47 1/2°/55°/60° flank angle							
Tolerance							Tolerance on cutting Diameter				
			Woodruff Tolerance					Corner Rounding Tolerance			
Application						Direction of Cut					
		Taper, Through & Blind Hole				Through & Blind Hole			Blind Hole Tapping		Through Hole Tapping
		Left Hand Cutting				Right Hand Cutting					Hand Taps

GENERAL




















MATERIAL DESCRIPTIONS

Materials	Code 0	Code 1	Code 2	Code 3	Code 4	Code 5	Code 7
Free Cutting Steels	x	x	x	x	x	x	x
Carbon Steel	x	x	x	x	x	x	x
Alloy Steel	x	x	x	x	x	x	x
Stainless Steel	x	x	x	x	x	x	x
Heat Resisting Alloys		x	x				
Nimonic Alloys				x	x	x	x
Titanium	x	x	x	x	x	x	x
Tool Steel				x	x	x	x
Cast Irons	x	x	x	x	x	x	x
Nickel	x						
Manganese Steels		x	x			x	x
Aluminium Alloys	x	x	x	x	x	x	x
Magnesium Alloys		x	x			x	x
Zinc Alloys						x	x
Copper	x	x	x	x	x	x	x
Synthetics / Plastics	x	x	x	x	x	x	x



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THREADING TOOLS

PRODUCT	SPEC.	CODE TYPE	RANGE	PAGE	
Short Hand Taps Metric Coarse - HSS For general hand tapping.		ISO 529	501	M1-M68	120
Left Hand Short Hand Taps Metric Coarse - HSS For general hand tapping.		ISO 529	519	M3-M36	121
Serial Hand Taps Metric Coarse - HSSE-V3 For tapping in tougher materials.		DIN 352	518	M3-M24	122
Gun Nose Short Machine Taps Metric Coarse - HSSE-V3 For machine tapping of through holes.		ISO 529	508	M2-M36	123
15° Spiral Flute Short Machine Taps Metric Coarse - HSSE-V3 For machining blind holes in tougher materials.		ISO 529	509	M3-M24	124
35° Spiral Flute Short Machine Taps Metric Coarse - HSSE-V3 For machining blind holes in ductile materials.		ISO 529	510	M3-M24	124
CBA - Yellow Band Gun Nose Taps Metric Coarse - Bright Finish - HSSE-V3 For machine tapping of through holes in soft materials eg. Aluminium.		DIN 371	538	M3-M10	125
		DIN 376	548	M12-M24	125
CBA - Yellow Band Spiral Flute Taps Metric Coarse - Bright Finish - HSSE-V3 For machine tapping of blind holes in soft materials eg. Aluminium.		DIN 371	558	M3-M10	126
		DIN 376	569	M12-M24	126
CBA - Yellow Band Fluteless Taps Metric Coarse - TiN Coated - HSSE-V3 For cold forming threads in ductile materials.		DIN 371	512	M3-M12	127
CBA - Blue Band Gun Nose Taps Metric Coarse - TiAIN Coated - HSSE-V3 For machine tapping of through holes in tough materials eg. Stainless Steel.		DIN 371	539	M3-M10	128
		DIN 376	549	M12-M24	128
CBA - Blue Band Spiral Flute Taps Metric Coarse - TiAIN Coated - HSSE-V3 For machine tapping of blind holes in tough materials eg. Stainless Steel.		DIN 371	559	M3-M10	129
		DIN 376	570	M12-M24	129
CBA - Red Band Gun Nose Taps Metric Coarse - TiAIN Coated - HSSE-V3 For machine tapping of through holes in high tensile materials eg. Tool Steel.		DIN 371	540	M3-M10	130
		DIN 376	550	M12-M24	130

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PRODUCT	SPEC.	CODE TYPE	RANGE	PAGE	
CBA - Red Band Spiral Flute Taps Metric Coarse - TiAlN Coated - HSSE-V3 For machine tapping of blind holes in high tensile materials eg. Tool Steel.		DIN 371	564	M3-M10	131
		DIN 376	576	M12-M24	131
CBA - White Band Spiral Flute Taps Metric Coarse - TiAlN Coated - HSSE-V3 For machine tapping of blind holes or through holes in Cast Iron.		DIN 371	578	M3-M10	132
		DIN 376	579	M12-M24	132
CBA - Green Band Gun Nose Taps Metric Coarse - TiN Coated - HSSE-V3 For machine tapping of through holes in carbon steels.		DIN 371	561	M3-M10	133
		DIN 376	566	M5-M24	133
CBA - Green Band 15° Spiral Flute Taps Metric Coarse - TiN Coated - HSSE-V3 For machine tapping of blind holes in carbon steels.		DIN 371	562	M3-M10	134
		DIN 376	567	M3.5-M24	134
CBA - Green Band 35° Spiral Flute Taps Metric Coarse - TiN Coated - HSSE-V3 For machine tapping of blind holes in carbon steels.		DIN 371	563	M3-M10	135
		DIN 376	568	M3.5-M24	135
Short Hand Taps Metric Fine - HSS For general hand tapping.		ISO 529	511	MF3-MF52	136-137
Gun Nose Short Machine Taps Metric Fine - HSSE-V3 For machine tapping of through holes.		ISO 529	515	MF4-MF24	138
Short Hand Taps BSW - HSS For general hand tapping.		ISO 529	521	1/16-2"	139
Gun Nose Short Machine Taps BSW - HSSE-V3 For machine tapping of through holes.		ISO 529	526	1/8-1"	140
Spiral Flute Short Machine Taps BSW - HSSE-V3 For machine tapping of blind holes.		ISO 529	528	1/8-1"	140
Short Hand Taps BSF - HSS For general hand tapping.		ISO 529	531	3/16-2"	141
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Spiral Flute Short Machine Taps UNC - HSSE-V3 For machine tapping of blind holes.		ISO 529	546	No.6-1" 143
Short Hand Taps UNF - HSS For general hand tapping.		ISO 529	551	No.4-1.1/2 144
Gun Nose Short Machine Taps UNF - HSSE-V3 For machine tapping of through holes.		ISO 529	555	No.4-1" 145
Spiral Flute Short Machine Taps UNF - HSSE-V3 For machine tapping of blind holes.		ISO 529	556	No.4-1" 145
Parallel Pipe Taps - BSP-G - HSS For hand or machine tapping of through or blind holes.		ISO 2284	571	1/8-3" 146
Gun Nose Short Machine Taps BSP-G - HSSE-V3 For machine tapping of through holes.		ISO 2284	573	1/8-3/4 146
Taper Pipe Hand Taps - BSPT - HSS For hand or machine tapping of through or blind holes.		ISO 2284	575	1/8-2" 147
Parallel Pipe Taps - NPS - HSS For hand or machine tapping of through or blind holes.		ISO 2284	581	1/8-2" 148
Taper Pipe Taps - NPT - HSS For hand or machine tapping of through or blind holes.		ISO 2284	585	1/8-2" 148
Short Hand Taps - BA - HSS For general hand tapping.		ISO 529	591	No.12-0 149
Short Hand Taps BSB - HSS For general hand tapping.		ISO 529	595	1/4-1" 149
Circular Solid Dies Metric Coarse - HSS For hand or machine production of components 3 x D in length.		DIN 223	580	M1-M48 150
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Circular Solid Dies NPT - HSS For hand or machine production of components 3 x D in length.		DIN 223	590	1/8-2"	152
Die Nuts Metric Coarse - HSS For general purpose repairing or cleaning of threads.		DIN 382	507	M3-M36	153
Die Nuts Metric Fine - HSS For general purpose repairing or cleaning of threads.		DIN 382	577	MF3-MF36	153
Die Nuts BSW - HSS For general purpose repairing or cleaning of threads.		DIN 382	527	1/8-2"	154
Die Nuts BSF - HSS For general purpose repairing or cleaning of threads.		DIN 382	537	1/4-2"	154
Die Nuts UNC - HSS For general purpose repairing or cleaning of threads.		DIN 382	547	1/4-1.1/2	155
Die Nuts UNF - HSS For general purpose repairing or cleaning of threads.		DIN 382	557	1/4-1.1/2	155
Die Nuts BSP - HSS For general purpose repairing or cleaning of threads.		DIN 382	574	1/8-2"	156
Adjustable Tap Wrenches - HSS For direct application of hand taps.		DIN 1814	588	T1-T2 TL3-TL4 TW1-TW6	157
Die Stocks For direct application of circular solid dies - Din 223 without capsule.		DIN 225	589	0-9A	157
Tap & Die Cased Sets - HSS For hand or machine tapping of through or blind holes.		-	5A1	HS3-HS21	158-160
NEW CBA - Colour Band Jobber Drill and Gun Nose Tap Sets Drills are ideal for use on CNC machines where high productivity and accurate holes are required. Taps are for machine tapping of through holes.		DIN 338 DIN 371 DIN 376	5BB 5G7 5R5	4.2 - 10.2 M5-M12	161

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Carbon Steel Short Hand Tap Sets - Metric Coarse For general hand tapping.	ISO 529	901	M2-M36	163
				
Carbon Steel Short Hand Tap Sets - Metric Fine For general hand tapping.	ISO 529	902	MF4-MF24	164
				
Carbon Steel Short Hand Tap Sets - BSW For general hand tapping.	ISO 529	903	1/8-1.1/4	165
				
Carbon Steel Short Hand Tap Sets - BSF For general hand tapping.	ISO 529	904	3/16-1"	165
				
Carbon Steel Short Hand Tap Sets - UNC For general hand tapping.	ISO 529	905	1/4-1"	166
				
Carbon Steel Short Hand Tap Sets - UNF For general hand tapping.	ISO 529	906	1/4-1"	166
				
Carbon Steel Short Hand Tap Sets - BSP-G For general hand tapping.	ISO 529	907	1/8-2"	167
				
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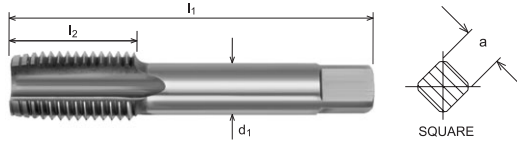
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Carbon Steel Die Nuts - BSW For general purpose repairing or cleaning of threads.		DIN 382	913 5/32-1.1/8	169
Carbon Steel Die Nuts - BSF For general purpose repairing or cleaning of threads.		DIN 382	914 1/4-1.1/4	169
Carbon Steel Die Nuts - UNC For general purpose repairing or cleaning of threads.		DIN 382	915 1/4-1.3/8	170
Carbon Steel Die Nuts - UNF For general purpose repairing or cleaning of threads.		DIN 382	916 3/8-1.1/2	170
Carbon Steel Die Nuts - BSP For general purpose repairing or cleaning of threads.		DIN 382	917 1/8-1"	171
Carbon Steel Die Nuts - BA For general purpose repairing or cleaning of threads.		DIN 382	918 0-6	171
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T H R E A D I N G T O O L S



Short Hand Taps



Code
501

Properties		
M	ISO 529	HSS
	ISO 2 6H	STRAIGHT FLUTE

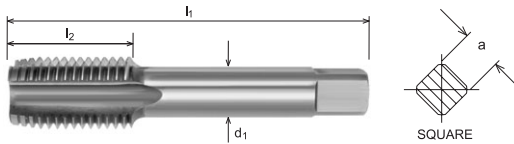
Suited Materials
GENERAL

Size	Pitch	l ₁	l ₂	d ₁	a	No. of Flutes	Code			
							Tap Set	Taper	Second	Bottom
M1	0.25	38.5	5.5	2.5	2	3	5010100	5010101	5010102	5010103
M1.1	0.25	38.5	5.5	2.5	2	3	5010110	5010111	5010112	5010113
M1.2	0.25	38.5	5.5	2.5	2	3	5010120	5010121	5010122	5010123
M1.4	0.3	40	7	2.5	2	3	5010140	5010141	5010142	5010143
M1.6	0.35	41	8	2.5	2	3	5010160	5010161	5010162	5010163
M1.8	0.35	41	8	2.5	2	3	5010180	5010181	5010182	5010183
M2	0.4	41	8	2.5	2	3	5010200	5010201	5010202	5010203
M2.2	0.45	44.5	9.5	2.8	2.24	3	5010220	5010221	5010222	5010223
M2.5	0.45	44.5	9.5	2.8	2.24	3	5010250	5010251	5010252	5010253
M3	0.5	48	11	3.15	2.5	3	5010300	5010301	5010302	5010303
M3.5	0.6	50	13	3.55	2.8	3	5010350	5010351	5010352	5010353
M4	0.7	53	13	4.0	3.15	3	5010400	5010401	5010402	5010403
M4.5	0.75	53	13	4.5	3.55	3	5010450	5010451	5010452	5010453
M5	0.8	58	16	5.0	4	3	5010500	5010501	5010502	5010503
M6	1.0	66	19	6.3	5	3	5010600	5010601	5010602	5010603
M7	1.0	66	19	7.1	5.6	4	5010700	5010701	5010702	5010703
M8	1.25	72	22	8.0	6.3	4	5010800	5010801	5010802	5010803
M9	1.25	72	22	9.0	7.1	4	5010900	5010901	5010902	5010903
M10	1.5	80	24	10.0	8	4	5011000	5011001	5011002	5011003
M11	1.5	85	25	8	6.3	4	5011100	5011101	5011102	5011103
M12	1.75	89	29	9.0	7.1	4	5011200	5011201	5011202	5011203
M14	2.0	95	30	11.2	9	4	5011400	5011401	5011402	5011403
M16	2.0	102	32	12.5	10	4	5011600	5011601	5011602	5011603
M18	2.5	112	37	14.0	11.2	4	5011800	5011801	5011802	5011803
M20	2.5	112	37	14	11.2	4	5012000	5012001	5012002	5012003
M22	2.5	118	38	16	12.5	4	5012200	5012201	5012202	5012203
M24	3.0	130	45	18	14	4	5012400	5012401	5012402	5012403
M27	3.0	135	45	20	16	4	5012700	5012701	5012702	5012703
M30	3.5	138	48	20	16	4	5013000	5013001	5013002	5013003
M33	3.5	151	51	22.4	18	4	5013300	5013301	5013302	5013303
M36	4.0	162	57	25	20	4	5013600	5013601	5013602	5013603
M39	4.0	170	60	28	22.4	6	5013900	5013901	5013902	5013903
M42	4.5	170	60	28	22.4	6	5014200	5014201	5014202	5014203
M45	4.5	187	67	31.5	25	6	5014500	5014501	5014502	5014503
M48	5.0	187	67	31.5	25	6	5014800	5014801	5014802	5014803
M52	5.0	200	70	35.5	28	6	5015200	5015201	5015202	5015203
M56	5.5	200	70	35.5	28	6	5015600	5015601	5015602	5015603
M60	5.5	221	76	40	31.5	6	5016000	5016001	5016002	5016003
M64	6.0	224	79	40	31.5	6	5016400	5016401	5016402	5016403
M68	6.0	234	79	45	35.5	8	5016800	5016801	5016802	5016803



THREADING TOOLS

Left Hand Short Hand Taps



Size	Pitch	l ₁	l ₂	d ₁	a	No. of Flutes	Code			
							Tap Set	Taper	Second	Bottom
M3	0.5	48	11	3.15	2.5	3	5190300	5190301	5190302	5190303
M4	0.7	53	13	4	3.15	3	5190400	5190401	5190402	5190403
M5	0.8	58	16	5	4	3	5190500	5190501	5190502	5190503
M6	1	66	19	6.3	5	3	5190600	5190601	5190602	5190603
M8	1.25	72	22	8	6.3	4	5190800	5190801	5190802	5190803
M10	1.5	80	24	10	8	4	5191000	5191001	5191002	5191003
M12	1.75	89	29	9	7.1	4	5191200	5191201	5191202	5191203
M14	2	95	30	11.2	9	4	5191400	5191401	5191402	5191403
M16	2	102	32	12.5	10	4	5191600	5191601	5191602	5191603
M18	2.5	112	37	14	11.2	4	5191800	5191801	5191802	5191803
M20	2.5	112	37	14	11.2	4	5192000	5192001	5192002	5192003
M22	2.5	118	38	16	12.5	4	5192200	5192201	5192202	5192203
M24	3	130	45	18	14	4	5192400	5192401	5192402	5192403
M27	3	135	45	20	16	4	-	-	5192702	-
M30	3.5	138	48	20	16	4	-	-	5193002	-
M33	3.5	151	51	22.4	18	4	-	-	5193302	-
M36	4	162	57	25	20	4	-	-	5193602	-

Code

519

Properties

M	ISO 529	HSS
	ISO 2 6H	STRAIGHT FLUTE

Suited Materials

GENERAL





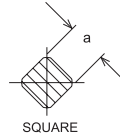
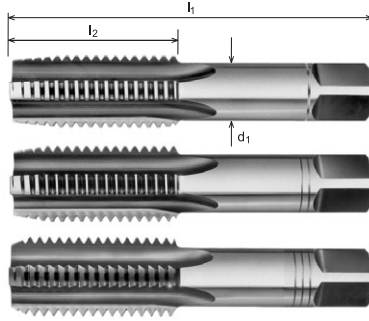
Serial Hand Taps

Code
518

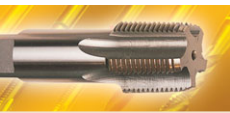
Properties

M	DIN 352	HSSE V3
	ISO 2 6H	STRAIGHT FLUTE

Suited Materials
GENERAL

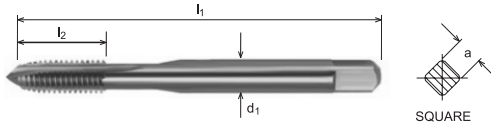


Size	Pitch	l ₁	l ₂	d ₁	a	No. of Flutes	Code			
							Tap Set	Rougher	Intermediate	Finisher
M3	0.5	40	11	3.5	2.7	3	5180300	5180301	5180302	5180303
M3.5	0.6	45	13	4	3	3	5180350	5180351	5180352	5180353
M4	0.7	45	13	4.5	3.4	3	5180400	5180401	5180402	5180403
M4.5	0.75	50	16	6	4.9	3	5180450	5180451	5180452	5180453
M5	0.8	50	16	6	4.9	3	5180500	5180501	5180502	5180503
M6	1	50	19	6	4.9	3	5180600	5180601	5180602	5180603
M7	1	50	19	6	4.9	4	5180700	5180701	5180702	5180703
M8	1.25	56	22	6	4.9	4	5180800	5180801	5180802	5180803
M9	1.25	63	22	7	5.5	4	5180900	5180901	5180902	5180903
M10	1.5	70	24	7	5.5	4	5181000	5181001	5181002	5181003
M12	1.75	75	29	9	7	4	5181200	5181201	5181202	5181203
M14	2	80	30	11	9	4	5181400	5181401	5181402	5181403
M16	2	80	32	12	9	4	5181600	5181601	5181602	5181603
M18	2.5	95	40	14	11	4	5181800	5181801	5181802	5181803
M20	2.5	95	40	16	12	4	5182000	5182001	5182002	5182003
M22	2.5	100	40	18	14.5	4	5182200	5182201	5182202	5182203
M24	3	110	50	18	14.5	4	5182400	5182401	5182402	5182403



THREADING TOOLS

Gun Nose Short Machine Taps



Size	Pitch	l_1	l_2	d_1	a	No. of Flutes	Code
M2	0.4	41	8	2.5	2	3	5080200
M3	0.5	48	11	3.15	2.5	3	5080300
M3.5	0.6	50	13	3.55	2.8	3	5080350
M4	0.7	53	13	4.0	3.15	3	5080400
M5	0.8	58	16	5.0	4	3	5080500
M6	1.0	66	19	6.3	5	3	5080600
M7	1.0	66	19	7.1	5.6	3	5080700
M8	1.25	72	22	8.0	6.3	3	5080800
M9	1.25	72	22	9.0	7.1	3	5080900
M10	1.5	80	24	10.0	8	3	5081000
M11	1.5	85	25	8.0	6.3	3	5081100
M12	1.75	89	29	9.0	7.1	3	5081200
M14	2.0	95	30	11.2	9	3	5081400
M16	2.0	102	32	12.5	10	4	5081600
M18	2.5	112	37	14.0	11.2	4	5081800
M20	2.5	112	37	14.0	11.2	4	5082000
M22	2.5	118	38	16.0	12.5	4	5082200
M24	3.0	130	45	18.0	14	4	5082400
M27	3.0	135	45	20.0	16	4	5082700
M30	3.5	138	48	20.0	16	4	5083000
M33	3.5	151	51	22.4	18	4	5083300
M36	4.0	162	57	25.0	20	4	5083600

Code

508

Properties

M	ISO 529	HSSE V3
	ISO 2 6H	GUN NOSE SPIRAL POINT

Suited Materials

GENERAL

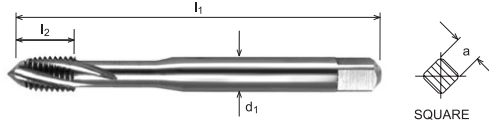


Spiral Flute Short Machine Taps

Code
509

Properties		
M	ISO 529	HSSE V3
	ISO 2 6H	

Suited Materials
GENERAL

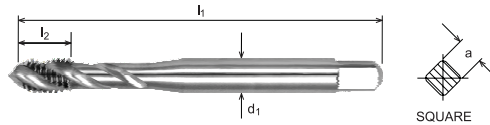


Size	Pitch	l_1	l_2	d_1	a	No. of Flutes	Code
M3	0.5	48	11	3.15	2.5	3	5090300
M3.5	0.6	50	13	3.55	2.8	3	5090350
M4	0.7	53	13	4.0	3.15	3	5090400
M5	0.8	58	16	5.0	4	3	5090500
M6	1.0	66	19	6.3	5	3	5090600
M7	1.0	66	19	7.1	5.6	3	5090700
M8	1.25	72	22	8.0	6.3	3	5090800
M9	1.25	72	22	9.0	7.1	3	5090900
M10	1.5	80	24	10.0	8	3	5091000
M11	1.5	85	25	8.0	6.3	3	5091100
M12	1.75	89	29	9.0	7.1	3	5091200
M14	2.0	95	30	11.2	9	3	5091400
M16	2.0	102	32	12.5	10	3	5091600
M18	2.5	112	37	14.0	11.2	4	5091800
M20	2.5	112	37	14.0	11.2	4	5092000
M22	2.5	118	38	16.0	12.5	4	5092200
M24	3.0	130	45	18.0	14	4	5092400

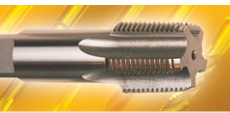
Code
510

Properties		
M	ISO 529	HSSE V3
	ISO 2 6H	

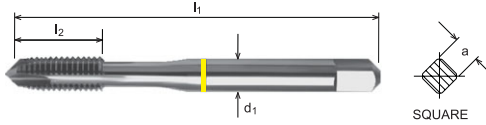
Suited Materials
GENERAL



Size	Pitch	l_1	l_2	d_1	a	No. of Flutes	Code
M3	0.5	48	11	3.15	2.5	3	5100300
M3.5	0.6	50	13	3.55	2.8	3	5100350
M4	0.7	53	13	4.0	3.15	3	5100400
M5	0.8	58	16	5.0	4	3	5100500
M6	1.0	66	19	6.3	5	3	5100600
M7	1.0	66	19	7.1	5.6	3	5100700
M8	1.25	72	22	8.0	6.3	3	5100800
M9	1.25	72	22	9.0	7.1	3	5100900
M10	1.5	80	24	10.0	8	3	5101000
M11	1.5	85	25	8.0	6.3	3	5101100
M12	1.75	89	29	9.0	7.1	3	5101200
M14	2.0	95	30	11.2	9	3	5101400
M16	2.0	102	32	12.5	10	3	5101600
M18	2.5	112	37	14.0	11.2	4	5101800
M20	2.5	112	37	14.0	11.2	4	5102000
M22	2.5	118	38	16.0	12.5	4	5102200
M24	3.0	130	45	18.0	14	4	5102400



Yellow Band Gun Nose Taps for tapping Aluminium



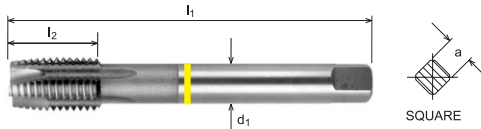
Size	Pitch	l_1	l_2	d_1	a	No. of Flutes	Code
M3	0.5	56	11	3.5	2.7	2	5380300
M4	0.7	63	13	4.5	3.4	2	5380400
M5	0.8	70	16	6	4.9	2	5380500
M6	1.0	80	19	6	4.9	2	5380600
M8	1.25	90	22	8	6.2	2	5380800
M10	1.5	100	24	10	8	3	5381000

Code
538

Properties		
M	DIN 371	HSSE V3
ISO 2 6H		GUN NOSE SPIRAL POINT
CBA		
		BRIGHT FINISH

Suited Materials		
ALUMINIUM	COPPER	SOFT BRASS
FREE CUTTING STEEL		

Yellow Band Gun Nose Taps for tapping Aluminium



Size	Pitch	l_1	l_2	d_1	a	No. of Flutes	Code
M12	1.75	110	29	9	7	3	5481200
M14	2	110	30	11	9	3	5481400
M16	2	110	32	12	9	3	5481600
M18	2.5	125	34	14	11	3	5481800
M20	2.5	140	34	16	12	3	5482000
M22	2.5	140	34	18	14.5	3	5482200
M24	3	160	38	18	14.5	3	5482400

Code
548

Properties		
M	DIN 376	HSSE V3
ISO 2 6H		GUN NOSE SPIRAL POINT
CBA		
		BRIGHT FINISH

Suited Materials		
ALUMINIUM	COPPER	SOFT BRASS
FREE CUTTING STEEL		



THREADING TOOLS

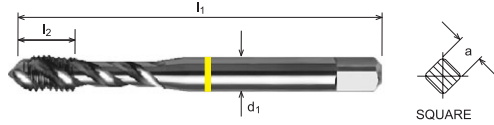


Yellow Band Spiral Flute Taps for tapping Aluminium

Code
558

Properties		
M	DIN 371	HSSE V3
ISO 2 6H		
CBA		
	BRIGHT FINISH	

Suited Materials		
ALUMINIUM	COPPER	SOFT BRASS
FREE CUTTING STEEL		

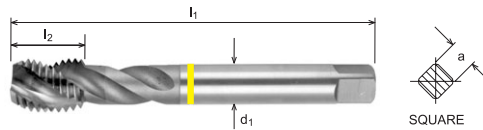


Size	Pitch	l ₁	l ₂	d ₁	a	No. of Flutes	Code
M3	0.5	56	5	3.5	2.7	2	5580300
M4	0.7	63	7	4.5	3.4	2	5580400
M5	0.8	70	8	6	4.9	2	5580500
M6	1.0	80	10	6	4.9	2	5580600
M8	1.25	90	12.5	8	6.2	2	5580800
M10	1.5	100	15	10	8	3	5581000

Code
569

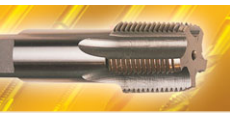
Properties		
M	DIN 376	HSSE V3
ISO 2 6H		
CBA		
	BRIGHT FINISH	

Suited Materials		
ALUMINIUM	COPPER	SOFT BRASS
FREE CUTTING STEEL		



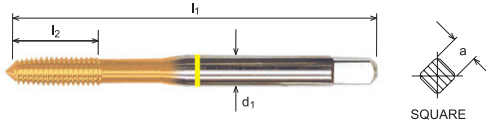
Yellow Band Spiral Flute Taps for tapping Aluminium

Size	Pitch	l ₁	l ₂	d ₁	a	No. of Flutes	Code
M12	1.75	110	17.5	9	7	3	5691200
M14	2	110	20	11	9	3	5691400
M16	2	110	20	12	9	3	5691600
M18	2.5	125	25	14	11	3	5691800
M20	2.5	140	25	16	12	3	5692000
M22	2.5	140	25	18	14.5	3	5692200
M24	3	160	30	18	14.5	3	5692400



THREADING
TOOLS

Yellow Band Fluteless Taps for threading Aluminium



Size	Pitch	l ₁	l ₂	d ₁	a	Code
M3	0.5	56	11	3.5	2.7	5120300
M4	0.7	63	13	4.5	3.4	5120400
M5	0.8	70	16	6	4.9	5120500
M6	1.0	80	19	6	4.9	5120600
M8	1.25	90	22	8	6.2	5120800
M10	1.5	100	24	10	8	5121000
*M12	1.75	110	29	9	7	5121200

* DIN 376

Code
512

Properties		
M	DIN 371	HSSE V3
6HX		FLUTELESS
CBA		TiN

Suited Materials		
ALUMINIUM	COPPER	SOFT BRASS
FREE CUTTING STEEL		



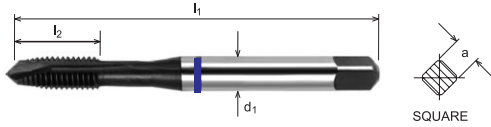


Blue Band Gun Nose Taps for tapping Stainless Steel

Code
539

Properties		
M	DIN 371	HSSE V3
ISO 2 6H		GUN NOSE SPIRAL POINT
CBA		
	TIAIN	

Suited Materials	
STAINLESS STEEL	TITANIUM ALLOYS
HEAT TREATABLE STEEL	

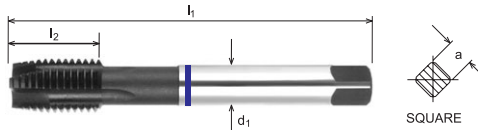


Size	Pitch	l_1	l_2	d_1	a	No. of Flutes	Code
M3	0.5	56	11	3.5	2.7	3	5390300
M4	0.7	63	13	4.5	3.4	3	5390400
M5	0.8	70	16	6	4.9	3	5390500
M6	1.0	80	19	6	4.9	3	5390600
M8	1.25	90	22	8	6.2	3	5390800
M10	1.5	100	24	10	8	3	5391000

Code
549

Properties		
M	DIN 376	HSSE V3
ISO 2 6H		GUN NOSE SPIRAL POINT
CBA		
	TIAIN	

Suited Materials	
STAINLESS STEEL	TITANIUM ALLOYS
HEAT TREATABLE STEEL	



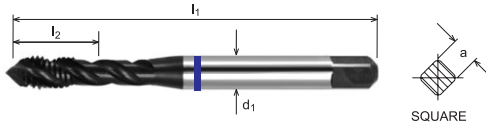
Blue Band Gun Nose Taps for tapping Stainless Steel

Size	Pitch	l_1	l_2	d_1	a	No. of Flutes	Code
M12	1.75	110	29	9	7	3	5491200
M14	2	110	30	11	9	3	5491400
M16	2	110	32	12	9	3	5491600
M18	2.5	125	34	14	11	4	5491800
M20	2.5	140	34	16	12	4	5492000
M22	2.5	140	34	18	14.5	4	5492200
M24	3	160	38	18	14.5	4	5492400



THREADING TOOLS

Blue Band Spiral Flute Taps for tapping Stainless Steel



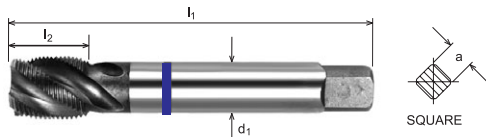
Size	Pitch	l_1	l_2	d_1	a	No. of Flutes	Code
M3	0.5	56	5	3.5	2.7	3	5590300
M4	0.7	63	7	4.5	3.4	3	5590400
M5	0.8	70	8	6	4.9	3	5590500
M6	1.0	80	10	6	4.9	3	5590600
M8	1.25	90	12.5	8	6.2	3	5590800
M10	1.5	100	15	10	8	3	5591000

Code
559

Properties		
M	DIN 371	HSSE V3
ISO 2 6H		
CBA		
		TIAIN

Suited Materials	
STAINLESS STEEL	TITANIUM ALLOYS
HEAT TREATABLE STEEL	

Blue Band Spiral Flute Taps for tapping Stainless Steel



Size	Pitch	l_1	l_2	d_1	a	No. of Flutes	Code
M12	1.75	110	17.5	9	7	3	5701200
M14	2	110	20	11	9	3	5701400
M16	2	110	20	12	9	3	5701600
M18	2.5	125	25	14	11	3	5701800
M20	2.5	140	25	16	12	3	5702000
M22	2.5	140	25	18	14.5	3	5702200
M24	3	160	30	18	14.5	4	5702400

Code
570

Properties		
M	DIN 376	HSSE V3
ISO 2 6H		
CBA		
		TIAIN

Suited Materials	
STAINLESS STEEL	TITANIUM ALLOYS
HEAT TREATABLE STEEL	






THREADING
TOOLS

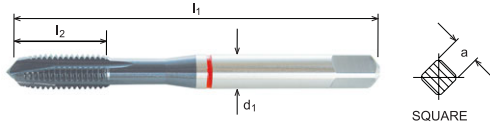


Red Band Gun Nose Taps for tapping Tough Treatable Steels

Code
540




Properties		
M	DIN 371	HSSE V3
ISO 2 6H		GUN NOSE SPIRAL POINT
CBA		TIAIN
		

Suited Materials	
TOUGH TREATABLE STEEL	
TOOL STEEL (ALLOY)	TITANIUM

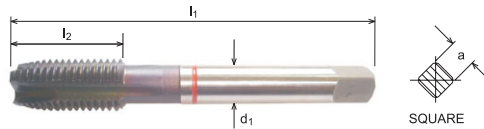


Size	Pitch	l ₁	l ₂	d ₁	a	No. of Flutes	Code
M3	0.5	56	11	3.5	2.7	3	5400300
M4	0.7	63	13	4.5	3.4	3	5400400
M5	0.8	70	16	6	4.9	3	5400500
M6	1.0	80	19	6	4.9	3	5400600
M8	1.25	90	22	8	6.2	3	5400800
M10	1.5	100	24	10	8	4	5401000

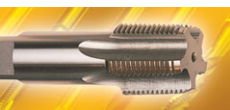
Code
550

Properties		
M	DIN 376	HSSE V3
ISO 2 6H		GUN NOSE SPIRAL POINT
CBA		TIAIN
		

Suited Materials	
TOUGH TREATABLE STEEL	
TOOL STEEL (ALLOY)	TITANIUM

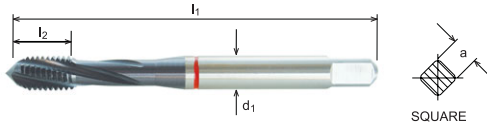


Size	Pitch	l ₁	l ₂	d ₁	a	No. of Flutes	Code
M12	1.75	110	29	9	7	4	5501200
M14	2	110	30	11	9	4	5501400
M16	2	110	32	12	9	4	5501600
M18	2.5	125	34	14	11	4	5501800
M20	2.5	140	34	16	12	4	5502000
M22	2.5	140	34	18	14.5	4	5502200
M24	3	160	38	18	14.5	4	5502400



THREADING
TOOLS

Red Band Spiral Flute Taps for tapping Tough Treatable Steels



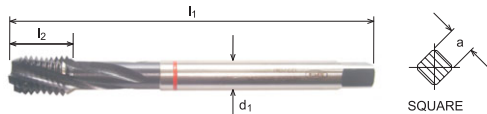
Size	Pitch	l_1	l_2	d_1	a	No. of Flutes	Code
M3	0.5	56	5	3.5	2.7	3	5640300
M4	0.7	63	7	4.5	3.4	3	5640400
M5	0.8	70	8	6	4.9	3	5640500
M6	1.0	80	10	6	4.9	3	5640600
M8	1.25	90	12.5	8	6.2	3	5640800
M10	1.5	100	15	10	8	4	5641000

Code
564

Properties		
M	DIN 371	HSSE V3
ISO 2 6H	60°	15°
CBA		
	RH	TIAIN

Suited Materials	
TOUGH TREATABLE STEEL	
TOOL STEEL (ALLOY)	TITANIUM

Red Band Spiral Flute Taps for tapping Tough Treatable Steels



Size	Pitch	l_1	l_2	d_1	a	No. of Flutes	Code
M12	1.75	110	17.5	9	7	4	5761200
M14	2	110	20	11	9	4	5761400
M16	2	110	20	12	9	4	5761600
M18	2.5	125	25	14	11	4	5761800
M20	2.5	140	25	16	12	4	5762000
M22	2.5	140	25	18	14.5	4	5762200
M24	3	160	30	18	14.5	4	5762400

Code
576

Properties		
M	DIN 376	HSSE V3
ISO 2 6H	60°	15°
CBA		
	RH	TIAIN

Suited Materials	
TOUGH TREATABLE STEEL	
TOOL STEEL (ALLOY)	TITANIUM











White Band Spiral Flute Taps for tapping Cast Iron

Code

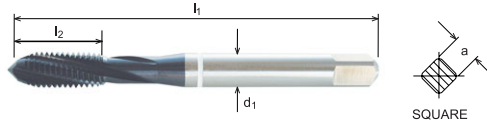
578

Properties

M	DIN 371	HSSE V3
ISO 2 6H		
CBA		
		TIAIN

Suited Materials

CAST IRON









Size	Pitch	l ₁	l ₂	d ₁	a	No. of Flutes	Code
M3	0.5	56	11	3.5	2.7	3	5780300
M4	0.7	63	13	4.5	3.4	3	5780400
M5	0.8	70	16	6.0	4.9	3	5780500
M6	1.0	80	19	6.0	4.9	3	5780600
M8	1.25	90	22	8.0	6.2	3	5780800
M10	1.5	100	24	10.0	8	4	5781000

Code

579

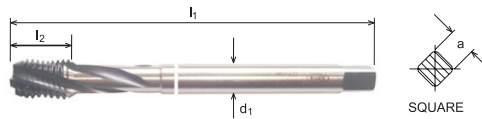
Properties

M	DIN 376	HSSE V3
ISO 2 6H		
CBA		
		TIAIN

Suited Materials

CAST IRON

White Band Spiral Flute Taps for tapping Cast Iron

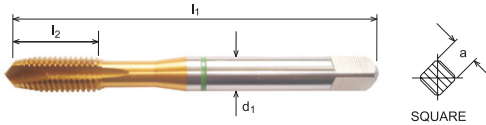


Size	Pitch	l ₁	l ₂	d ₁	a	No. of Flutes	Code
M12	1.75	110	20	9	7	4	5791200
M14	2	110	20	11	9	4	5791400
M16	2	110	20	12	9	4	5791600
M18	2.5	125	20	14	11	4	5791800
M20	2.5	140	20	16	12	4	5792000
M22	2.5	140	20	18	14.5	4	5792200
M24	3	160	30	18	14.5	4	5792400



THREADING
TOOLS

Green Band Gun Nose Taps for tapping Carbon Steels



Size	Pitch	l_1	l_2	d_1	a	No. of Flutes	Code
M3	0.5	56	11	3.5	2.7	3	5610300
M4	0.7	63	13	4.5	3.4	3	5610400
M5	0.8	70	16	6.0	4.9	3	5610500
M6	1.0	80	19	6.0	4.9	3	5610600
M7	1.0	80	19	7.0	5.5	3	5610700
M8	1.25	90	22	8.0	6.2	3	5610800
M10	1.5	100	24	10.0	8	3	5611000

Code

561

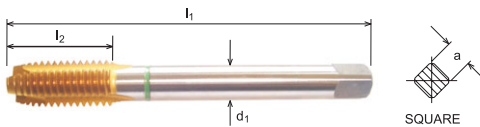
Properties

M	DIN 371	HSSE V3
ISO 2 6H		GUN NOSE SPIRAL POINT
CBA		
		TIN

Suited Materials

CARBON STEEL	CAST IRON	COPPER
FREE CUTTING STEEL		

Green Band Gun Nose Taps for tapping Carbon Steels



Size	Pitch	l_1	l_2	d_1	a	No. of Flutes	Code
M3.5	0.6	56	13	2.5	2.1	3	5660350
M4	0.7	63	13	2.8	2.1	3	5660400
M5	0.8	70	16	3.5	2.7	3	5660500
M6	1.0	80	19	4.5	3.4	3	5660600
M8	1.25	90	22	6.0	4.9	3	5660800
M10	1.5	100	24	7.0	5.5	3	5661000
M12	1.75	110	29	9.0	7	3	5661200
M14	2.0	110	30	11.0	9	3	5661400
M16	2.0	110	32	12.0	9	4	5661600
M18	2.5	125	34	14.0	11	4	5661800
M20	2.5	140	34	16.0	12	4	5662000
M22	2.5	140	34	18.0	14.5	4	5662200
M24	3.0	160	38	18.0	14.5	4	5662400

Code

566

Properties

M	DIN 376	HSSE V3
ISO 2 6H		GUN NOSE SPIRAL POINT
CBA		
		TIN

Suited Materials

CARBON STEEL	CAST IRON	COPPER
FREE CUTTING STEEL		



THREADING TOOLS

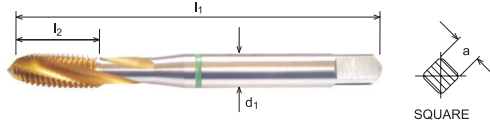


Green Band Spiral Flute Taps for tapping Carbon Steels

Code
562

Properties		
M	DIN 371	HSSE V3
ISO 2 6H		
CBA		
		TiN

Suited Materials		
CARBON STEEL	CAST IRON	COPPER
FREE CUTTING STEEL		



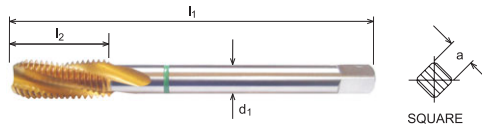
Size	Pitch	l_1	l_2	d_1	a	No. of Flutes	Code
M3	0.5	56	11	3.5	2.7	3	5620300
M4	0.7	63	13	4.5	3.4	3	5620400
M5	0.8	70	16	6.0	4.9	3	5620500
M6	1.0	80	19	6.0	4.9	3	5620600
M7	1.0	80	19	7.0	5.5	3	5620700
M8	1.25	90	22	8.0	6.2	3	5620800
M10	1.5	100	24	10.0	8	3	5621000

Code
567

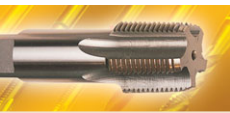
Properties		
M	DIN 376	HSSE V3
ISO 2 6H		
CBA		
		TiN

Suited Materials		
CARBON STEEL	CAST IRON	COPPER
FREE CUTTING STEEL		

Green Band Spiral Flute Taps for tapping Carbon Steels

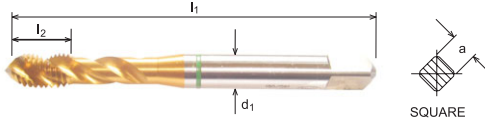


Size	Pitch	l_1	l_2	d_1	a	No. of Flutes	Code
M3.5	0.6	56	13	2.5	2.1	3	5670350
M4	0.7	63	13	2.8	2.1	3	5670400
M5	0.8	70	16	3.5	2.7	3	5670500
M6	1.0	80	19	4.5	3.4	3	5670600
M8	1.25	90	22	6.0	4.9	3	5670800
M10	1.5	100	24	7.0	5.5	3	5671000
M12	1.75	110	29	9.0	7	3	5671200
M14	2.0	110	30	11.0	9	3	5671400
M16	2.0	110	32	12.0	9	3	5671600
M18	2.5	125	34	14.0	11	4	5671800
M20	2.5	140	34	16.0	12	4	5672000
M22	2.5	140	34	18.0	14.5	4	5672200
M24	3.0	160	38	18.0	14.5	4	5672400



THREADING
TOOLS

Green Band Spiral Flute Taps for tapping Carbon Steels



Size	Pitch	l_1	l_2	d_1	a	No. of Flutes	Code
M3	0.5	56	5	3.5	2.7	3	5630300
M4	0.7	63	7	4.5	3.4	3	5630400
M5	0.8	70	8	6.0	4.9	3	5630500
M6	1.0	80	10	6.0	4.9	3	5630600
M7	1.0	80	10	7.0	5.5	3	5630700
M8	1.25	90	12.5	8.0	6.2	3	5630800
M10	1.5	100	15	10.0	8	3	5631000

Code

563

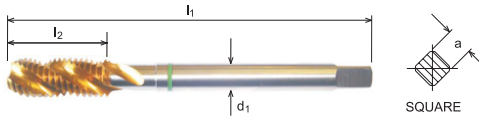
Properties

M	DIN 371	HSSE V3
ISO 2 6H		
CBA		TIN

Suited Materials

CARBON STEEL	CAST IRON	COPPER
FREE CUTTING STEEL		

Green Band Spiral Flute Taps for tapping Carbon Steels



Size	Pitch	l_1	l_2	d_1	a	No. of Flutes	Code
M3.5	0.6	56	6	2.5	2.1	3	5680350
M4	0.7	63	7	2.8	2.1	3	5680400
M5	0.8	70	8	3.5	2.7	3	5680500
M6	1.0	80	10	4.5	3.4	3	5680600
M8	1.25	90	12.5	6.0	4.9	3	5680800
M10	1.5	100	15	7.0	5.5	3	5681000
M12	1.75	110	17.5	9.0	7	3	5681200
M14	2.0	110	20	11.0	9	3	5681400
M16	2.0	110	20	12.0	9	3	5681600
M18	2.5	125	25	14.0	11	4	5681800
M20	2.5	140	25	16.0	12	4	5682000
M22	2.5	140	25	18.0	14.5	4	5682200
M24	3.0	160	30	18.0	14.5	4	5682400

Code

568

Properties

M	DIN 376	HSSE V3
ISO 2 6H		
CBA		TIN

Suited Materials

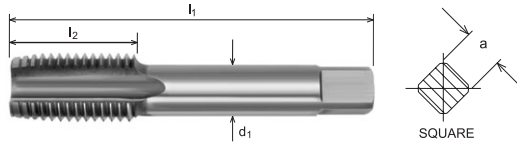
CARBON STEEL	CAST IRON	COPPER
FREE CUTTING STEEL		



THREADING
TOOLS



Short Hand Taps



Code
511

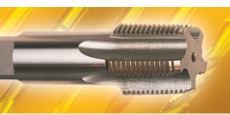
Properties		
MF	ISO 529	HSS
	ISO 2 6H	STRAIGHT FLUTE

Suited Materials
GENERAL

Size	Pitch	l ₁	l ₂	d ₁	a	No. of Flutes	Code		
							Tap Set	Taper	Bottom
MF3	0.35	48	11	3.15	2.5	3	5110300	5110301	5110303
MF4	0.5	53	13	4.0	3.15	3	5110400	5110401	5110403
MF4.5	0.5	53	13	4.5	3.55	3	5110450	5110451	5110453
MF5	0.5	58	16	5.0	4	3	5110500	5110501	5110503
MF5	0.75	58	16	5.0	4	3	5110510	5110511	5110513
MF5.5	0.5	62	17	5.6	4.5	3	5110550	5110551	5110553
MF6	0.75	66	19	6.3	5	3	5110600	5110601	5110603
MF7	0.75	66	19	7.1	5.6	4	5110700	5110701	5110703
MF8	0.75	69	19	8.0	6.3	4	5110790	5110791	5110793
MF8	1.0	69	19	8.0	6.3	4	5110800	5110801	5110803
MF9	0.75	69	19	9.0	7.1	4	5110890	5110891	5110893
MF9	1.0	69	19	9.0	7.1	4	5110900	5110901	5110903
MF10	0.75	76	20	10.0	8	4	5110990	5110991	5110993
#MF10	1.0	76	20	10.0	8	4	5111000	5111001	5111003
MF10	1.25	76	20	10.0	8	4	5111010	5111011	5111013
MF11	1.0	82	22	8.0	6.3	4	5111110	5111111	5111113
MF11	1.25	82	22	8.0	6.3	4	5111120	5111121	5111123
MF12	1.0	84	24	9.0	7.1	4	5111190	5111191	5111193
*MF12	1.25	84	24	9.0	7.1	4	5111200	5111201	5111203
MF12	1.5	89	29	9.0	7.1	4	5111210	5111211	5111213
MF14	1.0	90	25	11.2	9	4	5111390	5111391	5111393
*MF14	1.25	90	25	11.2	9	4	5111400	5111401	5111403
MF14	1.5	95	30	11.2	9	4	5111410	5111411	5111413
MF15	1.0	95	30	11.2	9	4	5111490	5111491	5111493
MF15	1.5	95	30	11.2	9	4	5111500	5111501	5111503
MF16	1.0	95	25	12.5	10	4	5111590	5111591	5111593
#MF16	1.5	102	32	12.5	10	4	5111600	5111601	5111603
MF17	1.5	102	32	12.5	10	4	5111700	5111701	5111703
MF18	1.0	104	29	14.0	11.2	4	5111780	5111781	5111783
MF18	1.25	104	29	14	11.2	4	5111790	5111791	5111793
*MF18	1.5	104	29	14	11.2	4	5111800	5111801	5111803
MF18	2.0	112	37	14	11.2	4	5111810	5111811	5111813
MF20	1.0	104	29	14	11.2	4	5111990	5111991	5111993
#MF20	1.5	104	29	14	11.2	4	5112000	5112001	5112003
MF20	2.0	112	37	14	11.2	4	5112010	5112011	5112013
MF22	1.0	113	33	16	12.5	4	5112190	5112191	5112193
MF22	1.5	113	33	16	12.5	4	5112200	5112201	5112203
MF22	2.0	118	38	16	12.5	4	5112210	5112211	5112213
MF24	1.0	120	35	18	14	4	5112390	5112391	5112393
MF24	1.5	120	35	18	14	4	5112400	5112401	5112403
MF24	2.0	120	35	18	14	4	5112410	5112411	5112413
MF25	1.0	120	35	18	14	4	5112490	5112491	5112493
#MF25	1.5	120	35	18	14	4	5112500	5112501	5112503
MF25	2.0	120	35	18	14	4	5112510	5112511	5112513
MF27	1.5	127	37	20	16	4	5112700	5112701	5112703
MF27	2.0	127	37	20	16	4	5112710	5112711	5112713
MF28	1.5	127	37	20	16	4	5112800	5112801	5112803

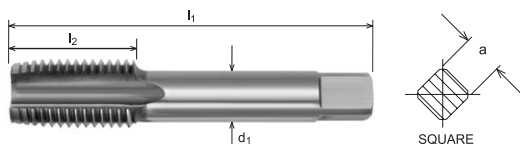
* Spark Plug
Conduit

Continued on next page...



THREADING TOOLS

Short Hand Taps



Size	Pitch	l ₁	l ₂	d ₁	a	No. of Flutes	Code		
							Tap Set	Taper	Bottom
... from previous page									
MF28	2.0	127	37	20	16	4	5112810	5112811	5112813
MF30	1.0	127	37	20	16	4	5112990	5112991	5112993
MF30	1.5	127	37	20	16	4	5113000	5113001	5113003
MF30	2.0	127	37	20	16	4	5113010	5113011	5113013
MF30	3.0	138	48	20	16	4	5113020	5113021	5113023
#MF32	1.5	137	37	22.4	18	4	5113200	5113201	5113203
MF32	2.0	137	37	22.4	18	4	5113210	5113211	5113213
MF33	1.5	137	37	22.4	18	4	5113300	5113301	5113303
MF33	2.0	137	37	22.4	18	4	5113310	5113311	5113313
MF33	3.0	151	51	22.4	18	4	5113320	5113321	5113323
MF35	1.5	144	39	25.0	20	4	5113500	5113501	5113503
MF36	1.5	144	39	25.0	20	4	5113600	5113601	5113603
MF36	2.0	144	39	25.0	20	4	5113610	5113611	5113613
MF36	3.0	162	57	25.0	20	4	5113620	5113621	5113623
MF38	1.5	149	39	28	22.4	6	5113810	5113811	5113813
MF38	2.0	149	39	28	22.4	6	5113820	5113821	5113823
MF39	1.5	149	39	28	22.4	6	5113900	5113901	5113903
MF39	2.0	149	39	28	22.4	6	5113910	5113911	5113913
MF39	3.0	170	60	28	22.4	6	5113920	5113921	5113923
MF40	2.0	149	39	28	22.4	6	5114010	5114011	5114013
MF40	3.0	170	60	28	22.4	6	5114020	5114021	5114023
MF42	1.5	149	39	28	22.4	6	5114200	5114201	5114203
MF42	2.0	149	39	28	22.4	6	5114210	5114211	5114213
MF42	3.0	170	60	28	22.4	6	5114220	5114221	5114223
MF42	4.0	170	60	28	22.4	6	5114230	5114231	5114233
MF45	1.5	165	45	31.5	25	6	5114500	5114501	5114503
MF45	2.0	165	45	31.5	25	6	5114510	5114511	5114513
MF45	3.0	187	67	31.5	25	6	5114520	5114521	5114523
MF48	1.5	165	45	31.5	25	6	5114800	5114801	5114803
MF48	2.0	165	45	31.5	25	6	5114810	5114811	5114813
MF48	3.0	187	67	31.5	25	6	5114820	5114821	5114823
MF48	4.0	187	67	31.5	25	6	5114830	5114831	5114833
MF50	3.0	187	67	31.5	25	6	5115020	5115021	5115023
MF52	2.0	175	45	35.5	28	6	5115210	5115211	5115213
MF52	3.0	200	70	35.5	28	6	5115220	5115221	5115223
MF52	4.0	200	70	35.5	28	6	5115230	5115231	5115233

* Spark Plug
Conduit

Code
511

Properties

MF	ISO 529	HSS
	ISO 2 6H	STRAIGHT FLUTE

Suited Materials
GENERAL



Gun Nose Short Machine Taps

Code

515

Properties

MF

ISO 529

HSSE V3



ISO 2 6H

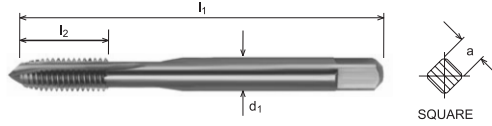
GUN NOSE SPIRAL POINT



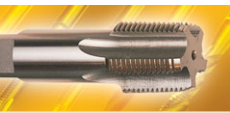
RH

Suited Materials

GENERAL

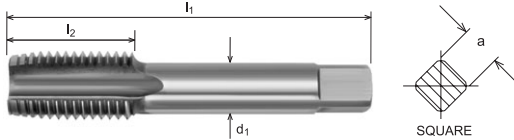


Size	Pitch	l_1	l_2	d_1	a	No. of Flutes	Code
MF4	0.5	53	13	4	3.15	3	5150400
MF5	0.75	58	16	5	4	3	5150500
MF6	0.75	66	19	6.3	5	3	5150600
MF8	1.0	69	19	8	6.3	3	5150800
MF9	1.0	69	19	9	7.1	3	5150900
MF10	1.0	76	20	10	8	3	5151000
MF10	1.25	76	20	10	8	3	5151010
MF12	1.0	84	24	9	7.1	3	5151190
MF12	1.25	84	24	9	7.1	3	5151200
MF12	1.5	89	29	9	7.1	3	5151210
MF14	1.0	90	25	11.2	9	3	5151390
MF14	1.25	90	25	11.2	9	3	5151400
MF14	1.5	95	30	11.2	9	3	5151410
MF16	1.5	102	32	12.5	10	4	5151600
MF18	1.5	104	29	14	11.2	4	5151800
MF20	1.5	104	29	14	11.2	4	5152000
MF22	1.5	113	33	16	12.5	4	5152200
MF24	1.5	120	35	18	14	4	5152400



THREADING
TOOLS

Short Hand Taps



Size	TPI	l ₁	l ₂	d ₁	a	No. of Flutes	Code			
							Tap Set	Taper	Second	Bottom
1/16	60	41	8	2.5	2	3	5210160	5210161	5210162	5210163
3/32	48	44.5	9.5	2.8	2.24	3	5210240	5210241	5210242	5210243
1/8	40	48	11	3.15	2.5	3	5210320	5210321	5210322	5210323
5/32	32	53	13	4	3.15	3	5210400	5210401	5210402	5210403
3/16	24	58	16	5	4	3	5210480	5210481	5210482	5210483
1/4	20	66	19	6.3	5	3	5210640	5210641	5210642	5210643
5/16	18	72	22	8	6.3	4	5210790	5210791	5210792	5210793
3/8	16	80	24	10	8	4	5210950	5210951	5210952	5210953
7/16	14	85	25	8	6.3	4	5211110	5211111	5211112	5211113
1/2	12	89	29	9	7.1	4	5211270	5211271	5211272	5211273
9/16	12	95	30	11.2	9	4	5211430	5211431	5211432	5211433
5/8	11	102	32	12.5	10	4	5211590	5211591	5211592	5211593
3/4	10	112	37	14	11.2	4	5211910	5211911	5211912	5211913
7/8	9	118	38	16	12.5	4	5212220	5212221	5212222	5212223
1"	8	130	45	18	14	4	5212540	5212541	5212542	5212543
1.1/8	7	138	48	20	16	4	5212860	5212861	5212862	5212863
1.1/4	7	151	51	22.4	18	4	5213170	5213171	5213172	5213173
1.1/2	6	170	60	28	22.4	6	5213810	5213811	5213812	5213813
1.3/4	5	187	67	31.5	25	6	5214450	5214451	5214452	5214453
2"	4.5	200	70	35.5	28	6	5215080	5215081	5215082	5215083

Code
521

Properties

BSW	ISO 529	HSS
	CLASS 2	STRAIGHT FLUTE

Suited Materials
GENERAL

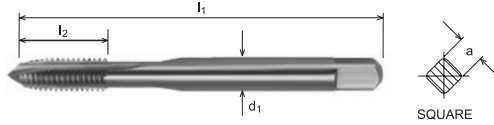


Gun Nose Short Machine Taps

Code
526

Properties		
BSW	ISO 529	HSSE V3
	CLASS 2	GUN NOSE SPIRAL POINT

Suited Materials
GENERAL

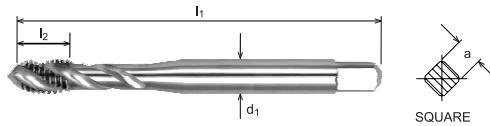


Size	TPI	l_1	l_2	d_1	a	No. of Flutes	Code
1/8	40	48	11	3.15	2.5	3	5260320
5/32	32	53	13	4	3.15	3	5260400
3/16	24	58	16	5	4	3	5260480
1/4	20	66	19	6.3	5	3	5260640
5/16	18	72	22	8	6.3	3	5260790
3/8	16	80	24	10	8	3	5260950
7/16	14	85	25	8	6.3	3	5261110
1/2	12	89	29	9	7.1	3	5261270
9/16	12	95	30	11.2	9	3	5261430
5/8	11	102	32	12.5	10	4	5261590
3/4	10	112	37	14	11.2	4	5261910
7/8	9	118	38	16	12.5	4	5262220
1"	8	130	45	18	14	4	5262540

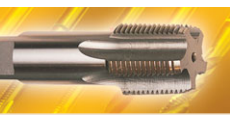
Code
528

Properties		
BSW	ISO 529	HSSE V3
	CLASS 2	35°

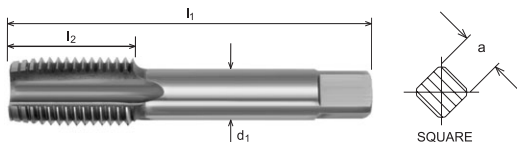
Suited Materials
GENERAL



Size	TPI	l_1	l_2	d_1	a	No. of Flutes	Code
1/8	40	48	11	3.15	2.5	3	5280320
5/32	32	53	13	4	3.15	3	5280400
3/16	24	58	16	5	4	3	5280480
1/4	20	66	19	6.3	5	3	5280640
5/16	18	72	22	8	6.3	3	5280790
3/8	16	80	24	10	8	3	5280950
7/16	14	85	25	8	6.3	3	5281110
1/2	12	89	29	9	7.1	3	5281270
9/16	12	95	30	11.2	9	3	5281430
5/8	11	102	32	12.5	10	3	5281590
3/4	10	112	37	14	11.2	4	5281910
7/8	9	118	38	16	12.5	4	5282220
1"	8	130	45	18	14	4	5282540



Short Hand Taps



Size	TPI	l ₁	l ₂	d ₁	a	No. of Flutes	Code			
							Tap Set	Taper	Second	Bottom
3/16	32	58	16	5	4	3	5310480	5310481	5310482	5310483
1/4	26	66	19	6.3	5	3	5310640	5310641	5310642	5310643
5/16	22	72	22	8	6.3	4	5310790	5310791	5310792	5310793
3/8	20	80	24	10	8	4	5310950	5310951	5310952	5310953
7/16	18	85	25	8	6.3	4	5311110	5311111	5311112	5311113
1/2	16	89	29	9	7.1	4	5311270	5311271	5311272	5311273
9/16	16	95	30	11.2	9	4	5311430	5311431	5311432	5311433
5/8	14	102	32	12.5	10	4	5311590	5311591	5311592	5311593
3/4	12	112	37	14	11.2	4	5311910	5311911	5311912	5311913
7/8	11	118	38	16	12.5	4	5312220	5312221	5312222	5312223
1"	10	130	45	18	14	4	5312540	5312541	5312542	5312543
1.1/8	9	138	48	20	16	4	5312860	5312861	5312862	5312863
1.1/4	9	151	51	22.4	18	4	5313180	5313181	5313182	5313183
1.3/8	8	162	57	25	20	4	5313490	5313491	5313492	5313493
1.1/2	8	170	60	28	22.4	6	5313810	5313811	5313812	5313813
1.5/8	8	170	60	28	22.4	6	5314120	5314121	5314122	5314123
1.3/4	7	187	67	31.5	25	6	5314450	5314451	5314452	5314453
2"	7	200	70	35.5	28	6	5315080	5315081	5315082	5315083

Code
531

Properties

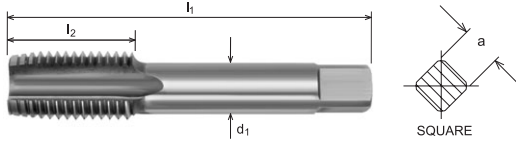
BSF	ISO 529	HSS
	CLASS 2	STRAIGHT FLUTE

Suited Materials
GENERAL





Short Hand Taps



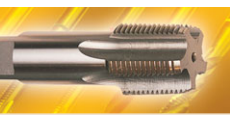
Code
541

Properties

UNC	ISO 529	HSS
	ISO 2 2B	STRAIGHT FLUTE

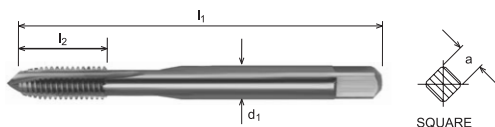
Suited Materials
GENERAL

Size	Nom. Dia.	TPI	l ₁	l ₂	d ₁	a	No. of Flutes	Code			
								Tap Set	Taper	Second	Bottom
No.4	2.84	40	48	11	3.15	2.5	3	5410280	5410281	5410282	5410283
No.5	3.18	40	48	11	3.15	2.5	3	5410320	5410321	5410322	5410323
No.6	3.51	32	50	13	3.55	2.8	3	5410350	5410351	5410352	5410353
No.8	4.17	32	53	13	4.5	3.55	3	5410420	5410421	5410422	5410423
No.10	4.83	24	58	16	5	4	3	5410480	5410481	5410482	5410483
No.12	5.49	24	62	17	5.6	4.5	3	5410550	5410551	5410552	5410553
1/4	20	66	19	6.3	5	3	3	5410640	5410641	5410642	5410643
5/16	18	72	22	8	6.3	4	4	5410790	5410791	5410792	5410793
3/8	16	80	24	10	8	4	4	5410950	5410951	5410952	5410953
7/16	14	85	25	8	6.3	4	4	5411110	5411111	5411112	5411113
1/2	13	89	29	9	7.1	4	4	5411270	5411271	5411272	5411273
9/16	12	95	30	11.2	9	4	4	5411430	5411431	5411432	5411433
5/8	11	102	32	12.5	10	4	4	5411590	5411591	5411592	5411593
3/4	10	112	37	14	11.2	4	4	5411910	5411911	5411912	5411913
7/8	9	118	38	16	12.5	4	4	5412220	5412221	5412222	5412223
1"	8	130	45	18	14	4	4	5412540	5412541	5412542	5412543
1.1/8	7	138	48	20	16	4	4	5412860	5412861	5412862	5412863
1.1/4	7	151	51	22.4	18	4	4	5413180	5413181	5413182	5413183
1.3/8	6	162	57	25	20	4	4	5413490	5413491	5413492	5413493
1.1/2	6	170	60	28	22.4	6	6	5413810	5413811	5413812	5413813
1.3/4	5	187	67	31.5	25	6	6	5414450	5414451	5414452	5414453
2"	4.1/2	200	70	35.5	28	6	6	5415080	5415081	5415082	5415083



THREADING TOOLS

Gun Nose Short Machine Taps



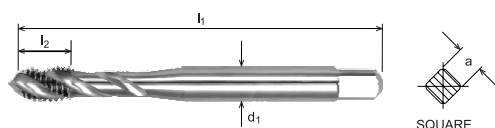
Size	Nominal Dia.	TPI	l_1	l_2	d_1	a	No. of Flutes	Code
No.6	3.51	32	50	13	3.55	2.8	3	5450350
No.8	4.17	32	53	13	4.5	3.55	3	5450420
No.10	4.83	24	58	16	5	4	3	5450480
No.12	5.49	24	62	17	5.6	4.5	3	5450550
1/4		20	66	19	6.3	5	3	5450640
5/16		18	72	22	8	6.3	3	5450790
3/8		16	80	24	10	8	3	5450950
7/16		14	85	25	8	6.3	3	5451110
1/2		13	89	29	9	7.1	3	5451270
9/16		12	95	30	11.2	9	3	5451430
5/8		11	102	32	12.5	10	4	5451590
3/4		10	112	37	14	11.2	4	5451910
7/8		9	118	38	16	12.5	4	5452220
1"		8	130	45	18	14	4	5452540

Code
545

Properties		
UNC	ISO 529	HSSE V3
	ISO 2 2B	GUN NOSE SPIRAL POINT

Suited Materials
GENERAL

Spiral Flute Short Machine Taps



Size	Nominal Dia.	TPI	l_1	l_2	d_1	a	No. of Flutes	Code
No.6	3.51	32	50	13	3.55	2.8	3	5460350
No.8	4.17	32	53	13	4.5	3.55	3	5460420
No.10	4.83	24	58	16	5	4	3	5460480
No.12	5.49	24	62	17	5.6	4.5	3	5460550
1/4		20	66	19	6.3	5	3	5460640
5/16		18	72	22	8	6.3	3	5460790
3/8		16	80	24	10	8	3	5460950
7/16		14	85	25	8	6.3	3	5461110
1/2		13	89	29	9	7.1	3	5461270
9/16		12	95	30	11.2	9	3	5461430
5/8		11	102	32	12.5	10	3	5461590
3/4		10	112	37	14	11.2	4	5461910
7/8		9	118	38	16	12.5	4	5462220
1"		8	130	45	18	14	4	5462540

Code
546

Properties		
UNC	ISO 529	HSSE V3
	ISO 2 2B	

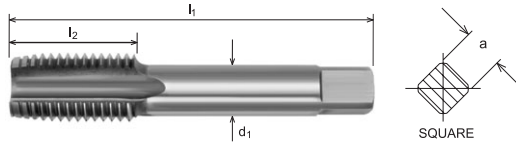
Suited Materials
GENERAL



THREADING
TOOLS



Short Hand Taps

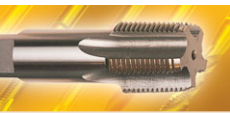


Code
551

Properties		
UNF	ISO 529	HSS
	ISO 2 2B	STRAIGHT FLUTE

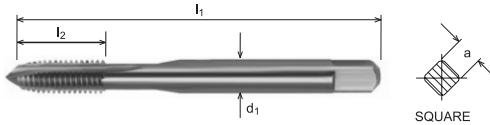
Suited Materials
GENERAL

Size	Nom. Dia.	TPI	l ₁	l ₂	d ₁	a	No. of Flutes	Code			
								Tap Set	Taper	Second	Bottom
No.4	2.85	48	48	11	3.15	2.5	3	5510280	5510281	5510282	5510283
No.5	3.18	44	48	11	3.15	2.5	3	5510320	5510321	5510322	5510323
No.6	3.51	40	50	13	3.55	2.8	3	5510350	5510351	5510352	5510353
No.8	4.17	36	53	13	4.5	3.55	3	5510420	5510421	5510422	5510423
No.10	4.83	32	58	16	5	4	3	5510480	5510481	5510482	5510483
No.12	5.49	28	62	17	5.6	4.5	3	5510550	5510551	5510552	5510553
1/4	28	66	19	6.3	5	3	5510640	5510641	5510642	5510643	
5/16	24	69	19	8	6.3	4	5510790	5510791	5510792	5510793	
3/8	24	76	20	10	8	4	5510950	5510951	5510952	5510953	
7/16	20	82	22	8	6.3	4	5511110	5511111	5511112	5511113	
1/2	20	84	24	9	7.1	4	5511270	5511271	5511272	5511273	
9/16	18	90	25	11.2	9	4	5511430	5511431	5511432	5511433	
5/8	18	95	25	12.5	10	4	5511590	5511591	5511592	5511593	
3/4	16	104	29	14	11.2	4	5511910	5511911	5511912	5511913	
7/8	14	113	33	16	12.5	4	5512220	5512221	5512222	5512223	
1"	12	120	35	18	14	4	5512540	5512541	5512542	5512543	
1.1/8	12	127	37	20	16	4	5512860	5512861	5512862	5512863	
1.1/4	12	137	37	22.4	18	4	5513180	5513181	5513182	5513183	
1.3/8	12	144	39	25	20	4	5513490	5513491	5513492	5513493	
1.1/2	12	149	39	28	22.4	6	5513810	5513811	5513812	5513813	



THREADING TOOLS

Gun Nose Short Machine Taps



Size	Nominal Dia.	TPI	l_1	l_2	d_1	a	No. of Flutes	Code
No.4	2.85	48	48	11	3.15	2.5	3	5550280
No.5	3.18	44	48	11	3.15	2.5	3	5550320
No.6	3.51	40	50	13	3.55	2.8	3	5550350
No.8	4.17	36	53	13	4.5	3.55	3	5550420
No.10	4.83	32	58	16	5	4	3	5550480
No.12	5.49	28	62	17	5.6	4.5	3	5550550
1/4		28	66	19	6.3	5	3	5550640
5/16		24	69	19	8	6.3	3	5550790
3/8		24	76	20	10	8	3	5550950
7/16		20	82	22	8	6.3	3	5551110
1/2		20	84	24	9	7.1	3	5551270
9/16		18	90	25	11.2	9	3	5551430
5/8		18	95	25	12.5	10	4	5551590
3/4		16	104	29	14	11.2	4	5551910
7/8		14	113	33	16	12.5	4	5552220
1"		12	120	35	18	14	4	5552540

Code

555

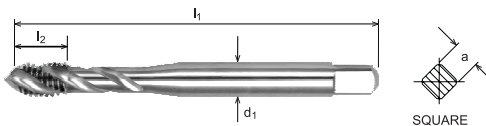
Properties

UNF	ISO 529	HSSE V3
	ISO 2 2B	GUN NOSE SPIRAL POINT

Suited Materials

GENERAL

Spiral Flute Short Machine Taps



Size	Nominal Dia.	TPI	l_1	l_2	d_1	a	No. of Flutes	Code
No.4	2.85	48	48	11	3.15	2.5	3	5560280
No.5	3.18	44	48	11	3.15	2.5	3	5560320
No.6	3.51	40	50	13	3.55	2.8	3	5560350
No.8	4.17	36	53	13	4.5	3.55	3	5560420
No.10	4.83	32	58	16	5	4	3	5560480
No.12	5.49	28	62	17	5.6	4.5	3	5560550
1/4		28	66	19	6.3	5	3	5560640
5/16		24	69	19	8	6.3	3	5560790
3/8		24	76	20	10	8	3	5560950
7/16		20	82	22	8	6.3	3	5561110
1/2		20	84	24	9	7.1	3	5561270
9/16		18	90	25	11.2	9	3	5561430
5/8		18	95	25	12.5	10	3	5561590
3/4		16	104	29	14	11.2	4	5561910
7/8		14	113	33	16	12.5	4	5562220
1"		12	120	35	18	14	4	5562540

Code

556

Properties

UNF	ISO 529	HSSE V3
	ISO 2 2B	

Suited Materials

GENERAL



THREADING TOOLS






Parallel Pipe Taps

Code

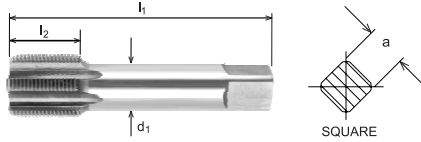
571

Properties

BSP	G SERIES	ISO 2284
HSS	 55°	BS 949 1982 PART 3
STRAIGHT FLUTE		

Suited Materials

GENERAL






Size	Nom. Dia.	TPI	l ₁	l ₂	d ₁	a	No. of Flutes	Code		
								Tap Set	Taper	Bottom
1/8	9.728	28	59	15	8	6.3	4	5710320	5710321	5710323
1/4	13.157	19	67	19	10	8	4	5710640	5710641	5710643
3/8	16.662	19	75	21	12.5	10	4	5710950	5710951	5710953
1/2	20.955	14	87	26	16	12.5	4	5711270	5711271	5711273
5/8	22.911	14	91	26	18	14	4	5711590	5711591	5711593
3/4	26.441	14	96	28	20	16	4	5711910	5711911	5711913
7/8	30.201	14	102	29	22.4	18	4	5712220	5712221	5712223
1"	33.249	11	109	33	25	20	6	5712540	5712541	5712543
1.1/4	41.910	11	119	36	31.5	25	6	5713170	5713171	5713173
1.1/2	47.803	11	125	37	35.5	28	6	5713810	5713811	5713813
1.3/4	53.746	11	132	39	35.5	28	6	5714450	5714451	5714453
2"	59.614	11	140	41	40	31.5	6	5715080	5715081	5715083
2.1/4	65.710	11	142	42	40	31.5	6	5715720	5715721	5715723
2.1/2	75.184	11	153	45	45	35.5	6	5716350	5716351	5716353
3"	87.884	11	164	48	50	40	6	5717620	5717621	5717623

Code

573

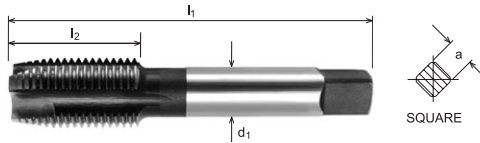
Properties

BSP	G SERIES	ISO 2284
HSSE V3	 55°	BS 949 1982 PART 3
GUN NOSE SPIRAL POINT		

Suited Materials

GENERAL

Gun Nose Short Machine Taps

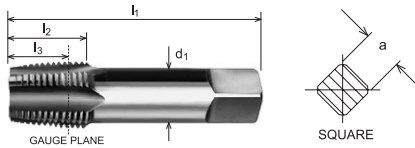


Size	Nominal Dia.	TPI	l ₁	l ₂	d ₁	a	No. of Flutes	Code
1/8	9.728	28	59	15	8	6.3	3	5730320
1/4	13.157	19	67	19	10	8	3	5730640
3/8	16.662	19	75	21	12.5	10	4	5730950
1/2	20.955	14	87	26	16	12.5	4	5731270
3/4	26.441	14	96	28	20	16	4	5731910



THREADING
TOOLS

Taper Pipe Hand Taps







Size	Nom. Dia. at Gauge Plane	TPI	l ₁	l ₂	l ₃	d ₁	a	No. of Flutes	Code		
									Tap Set	Taper	Bottom
1/8	9.728	28	59	15	10.1	8	6.3	3	5750320	5750321	5750323
1/4	13.157	19	67	19	15	10	8	5	5750640	5750641	5750643
3/8	16.662	19	75	21	15.4	12.5	10	5	5750950	5750951	5750953
1/2	20.955	14	87	26	20.5	16	12.5	5	5751270	5751271	5751273
3/4	26.441	14	96	28	21.8	20	16	5	5751910	5751911	5751913
1"	33.249	11	109	33	26	25	20	5	5752540	5752541	5752543
1.1/4	41.910	11	119	36	28.3	31.5	25	7	5753170	5753171	5753173
1.1/2	47.803	11	125	37	28.3	35.5	28	7	5753810	5753811	5753813
2"	59.614	11	140	41	32.7	40	31.5	7	5755080	5755081	5755083

Code

575

Properties

BSPT	Rc SERIES	ISO 2284
HSS		BS 949 1982 PART 3
STRAIGHT FLUTE		
		

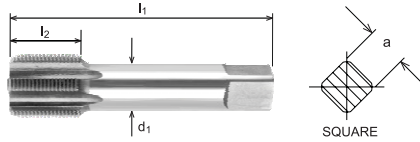
Suited Materials

GENERAL





Parallel Pipe Taps



Code
581

Properties		
NPS	ISO 2284	HSS
	ANSI B94.9 1979	STRAIGHT FLUTE

Suited Materials
GENERAL

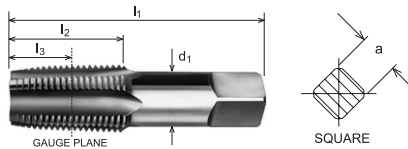
Size	Nom. Dia.	TPI	l ₁	l ₂	d ₁	a	No. of Flutes	Code		
								Tap Set	Taper	Bottom
1/8	10.272	27	59	15	8.0	6.3	4	5810320	5810321	5810323
1/4	13.571	18	67	19	10	8.0	4	5810640	5810641	5810643
3/8	17.054	18	75	21	12.5	10	4	5810950	5810951	5810953
1/2	21.224	14	87	26	16	12.5	4	5811270	5811271	5811273
3/4	26.568	14	96	28	20	16	4	5811910	5811911	5811913
1"	33.228	11.1/2	109	33	25	20	6	5812540	5812541	5812543
1.1/4	41.986	11.1/2	119	36	31.5	25	6	5813170	5813171	5813173
1.1/2	48.054	11.1/2	125	37	35.5	28	6	5813810	5813811	5813813
2"	60.091	11.1/2	140	41	40	31.5	6	5815080	5815081	5815083

Code
585

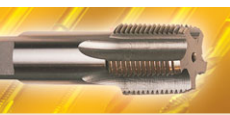
Properties		
NPT	ISO 2284	HSS
	ANSI B94.9 1979	STRAIGHT FLUTE

Suited Materials
GENERAL

Taper Pipe Taps

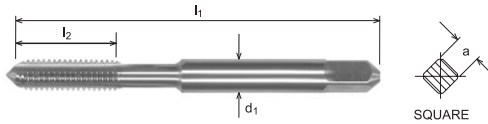


Size	Nom. Dia. at Gauge Plane	TPI	l ₁	l ₂	l ₃	d ₁	a	No. of Flutes	Code		
									Tap Set	Taper	Bottom
1/8	10.272	27	59	15	7.9	8.0	6.3	3	5850320	5850321	5850323
1/4	13.571	18	67	19	11.7	10	8.0	5	5850640	5850641	5850643
3/8	17.054	18	75	21	11.5	12.5	10	5	5850950	5850951	5850953
1/2	21.224	14	87	26	14.7	16	12.5	5	5851270	5851271	5851273
3/4	26.568	14	96	28	14.4	20	16	5	5851910	5851911	5851913
1"	33.228	11.1/2	109	33	17.2	25	20	5	5852540	5852541	5852543
1.1/4	41.986	11.1/2	119	36	17.4	31.5	25	7	5853170	5853171	5853173
1.1/2	48.054	11.1/2	125	37	17.8	35.5	28	7	5853810	5853811	5853813
2"	60.091	11.1/2	140	41	16.9	40	31.5	7	5855080	5855081	5855083



THREADING TOOLS

Short Hand Taps



Size	Nom. Dia.	Pitch	l ₁	l ₂	d ₁	a	No. of Flutes	Code			
								Tap Set	Taper	Second	Bottom
No.12	1.3	0.28	40	7	2.5	2	3	5910130	5910131	5910132	5910133
No.10	1.7	0.35	41	8	2.5	2	3	5910170	5910171	5910172	5910173
No.9	1.9	0.39	41	8	2.5	2	3	5910190	5910191	5910192	5910193
No.8	2.2	0.43	44.5	9.5	2.8	2.24	3	5910220	5910221	5910222	5910223
No.7	2.5	0.48	44.5	9.5	2.8	2.24	3	5910250	5910251	5910252	5910253
No.6	2.8	0.53	44.5	9.5	2.8	2.24	3	5910280	5910281	5910282	5910283
No.5	3.2	0.59	48	11	3.15	2.5	3	5910320	5910321	5910322	5910323
No.4	3.6	0.66	50	13	3.55	2.8	3	5910360	5910361	5910362	5910363
No.3	4.1	0.73	53	13	4.5	3.55	3	5910410	5910411	5910412	5910413
No.2	4.7	0.81	58	16	5	4	3	5910470	5910471	5910472	5910473
No.1	5.3	0.9	62	17	5.6	4.5	3	5910530	5910531	5910532	5910533
No.0	6.0	1	66	19	6.3	5	3	5910600	5910601	5910602	5910603

Code

591

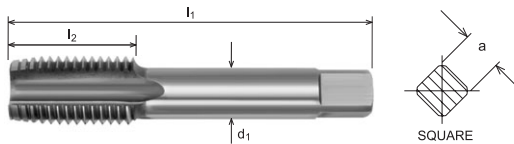
Properties

BA	ISO 529	HSS
	MED	STRAIGHT FLUTE

Suited Materials

GENERAL

Short Hand Taps



Size	TPI	l ₁	l ₂	d ₁	a	No. of Flutes	Code		
							Tap Set	Taper	Bottom
1/4	26	66	19	6.3	5	3	5950640	5950641	5950643
5/16	26	72	22	8	6.3	4	5950790	5950791	5950793
3/8	26	80	24	10	8	4	5950950	5950951	5950953
7/16	26	85	25	8	6.3	4	5951110	5951111	5951113
1/2	26	89	29	9	7.1	4	5951270	5951271	5951273
5/8	26	102	32	12.5	10	4	5951590	5951591	5951593
3/4	26	112	37	14	11.2	4	5951910	5951911	5951913
1"	26	130	45	18	14	4	5952540	5952541	5952543

Code

595

Properties

BSB	ISO 529	HSS
	STRAIGHT FLUTE	

Suited Materials

GENERAL



THREADING
TOOLS

Code

580

Properties

M

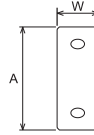
DIN 223

HSS



DIN 13

6G



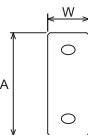
Size	Pitch	A	W	Code
M1	0.25	16	5	5800100
M1.1	0.25	16	5	5800110
M1.2	0.25	16	5	5800120
M1.4	0.30	16	5	5800140
M1.6	0.35	16	5	5800160
M1.7	0.35	16	5	5800170
M1.8	0.35	16	5	5800180
M1.9	0.35	16	5	5800190
M2	0.4	16	5	5800200
M2.2	0.45	16	5	5800220
M2.3	0.45	16	5	5800230
M2.5	0.45	16	5	5800250
M2.6	0.45	16	5	5800260
M3	0.5	20	5	5800300
M3.5	0.6	20	5	5800350
M4	0.7	20	5	5800400
M4.5	0.75	20	7	5800450
M5	0.8	20	7	5800500
M6	1	20	7	5800600
M7	1	20	7	5800700

Size	Pitch	A	W	Code
M8	1.25	25	9	5800800
M9	1.25	25	9	5800900
M10	1.5	30	11	5801000
M11	1.5	30	11	5801100
M12	1.75	38	14	5801200
M14	2	38	14	5801400
M16	2	45	18	5801600
M18	2.5	45	18	5801800
M20	2.5	45	18	5802000
M22	2.5	55	22	5802200
M24	3	55	22	5802400
M27	3	65	25	5802700
M30	3.5	65	25	5803000
M33	3.5	65	25	5803300
M36	4	65	25	5803600
M39	4	75	30	5803900
M42	4.5	75	30	5804200
M45	4.5	90	36	5804500
M48	5	90	36	5804800



THREADING TOOLS

Circular Solid Dies



Code
582

Size	Pitch	A	W	Code
MF2	0.25	16	5	5820200
MF2.2	0.25	16	5	5820220
MF2.3	0.25	16	5	5820230
MF2.5	0.25	16	5	5820250
MF2.6	0.25	16	5	5820259
MF2.6	0.35	16	5	5820260
MF3	0.35	20	5	5820300
MF3.5	0.35	20	5	5820350
MF4	0.35	20	5	5820390
MF4	0.5	20	5	5820400
MF5	0.5	20	5	5820500
MF5	0.75	20	7	5820510
MF6	0.5	20	5	5820600
MF6	0.75	20	7	5820610
MF7	0.75	25	9	5820700
MF8	0.5	25	9	5820789
MF8	0.75	25	9	5820790
MF8	1.0	25	9	5820800
MF9	0.75	25	9	5820890
MF9	1.0	25	9	5820900
MF10	0.5	30	11	5820989
MF10	0.75	30	11	5820990
MF10	1.0	30	11	5821000
MF10	1.25	30	11	5821010
MF11	1.0	30	11	5821110
MF12	0.75	38	10	5821189
MF12	1.0	38	10	5821190
MF12	1.25	38	10	5821200
MF12	1.5	38	10	5821210
MF13	1.0	38	10	5821290
MF13	1.5	38	10	5821300
MF14	0.75	38	10	5821389
MF14	1.0	38	10	5821390
MF14	1.25	38	10	5821400
MF14	1.5	38	10	5821410
MF15	1.0	38	10	5821490
MF15	1.5	38	10	5821500
MF16	1.0	45	14	5821590
MF16	1.5	45	14	5821600
MF18	1.0	45	14	5821780
MF18	1.5	45	14	5821800
MF18	2.0	45	14	5821810
MF20	1.0	45	14	5821990
MF20	1.5	45	14	5822000
MF20	2.0	45	14	5822010
MF22	1.0	55	16	5822190
MF22	1.5	55	16	5822200

Size	Pitch	A	W	Code
MF22	2.0	55	16	5822220
MF24	1.0	55	16	5822390
MF24	1.5	55	16	5822400
MF24	2.0	55	16	5822410
MF25	1.0	55	16	5822490
MF25	1.5	55	16	5822500
MF26	1.5	55	16	5822600
MF27	1.5	65	18	5822700
MF27	2.0	65	18	5822710
MF28	1.0	65	18	5822790
MF28	1.5	65	18	5822800
MF28	2.0	65	18	5822810
MF30	1.0	65	18	5822990
MF30	1.5	65	18	5823000
MF30	2.0	65	18	5823010
MF32	1.5	65	18	5823190
MF32	2.0	65	18	5823200
MF33	1.5	65	18	5823290
MF33	2.0	65	18	5823300
MF34	1.5	65	18	5823400
MF35	1.5	65	18	5823500
MF36	1.5	65	18	5823590
MF36	2.0	65	18	5823600
MF36	3.0	65	25	5823610
MF38	1.5	75	20	5823800
MF39	1.5	75	20	5823890
MF39	2.0	75	20	5823900
MF39	3.0	75	20	5823910
MF40	1.5	75	20	5823990
MF40	2.0	75	20	5824000
MF40	3.0	75	20	5824010
MF42	1.5	75	20	5824190
MF42	2.0	75	20	5824200
MF42	3.0	75	20	5824210
MF44	1.5	90	22	5824400
MF45	1.5	90	22	5824490
MF45	2.0	90	22	5824500
MF45	3.0	90	22	5824510
MF48	1.5	90	22	5824790
MF48	2.0	90	22	5824800
MF48	3.0	90	22	5824810
MF50	1.5	90	22	5824990
MF50	2.0	90	22	5825000
MF50	3.0	90	22	5825010
MF52	1.5	90	22	5825190
MF52	2.0	90	22	5825200
MF52	3.0	90	22	5825210

Properties		
MF	DIN 223	HSS
	DIN 13	6G




THREADING TOOLS

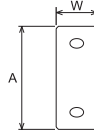
Circular Solid Dies

Code

587

Properties

BSP	DIN 223	HSS
	ISO 228	MEDIUM CLASS BOLT




Size	TPI	A	W	Code
1/8	28	38	10	5870320
1/4	19	38	10	5870640
3/8	19	45	14	5870950
1/2	14	45	14	5871270
5/8	14	55	16	5871590
3/4	14	65	18	5871910
7/8	14	65	18	5872220

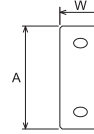
Size	TPI	A	W	Code
1"	11	65	18	5872540
1.1/8	11	75	20	5872858
1.1/4	11	75	20	5873170
1.3/8	11	90	22	5873493
1.1/2	11	90	22	5873810
1.3/4	11	90	22	5874445
2"	11	105	22	5875080

Code

590

Properties

NPT	DIN 223	HSS
	ANSI B1.20.1	CLASS 2A BOLT



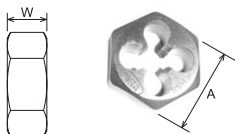
Size	TPI	A	W	Code
1/8	27	30	11	5900320
1/4	18	38	14	5900640
3/8	18	45	14	5900950
1/2	14	45	18	5901270
3/4	14	55	22	5901910

Size	TPI	A	W	Code
1"	11.1/2	65	25	5902540
1.1/4	11.1/2	75	26	5903170
1.1/2	11.1/2	90	27	5903810
2"	11.1/2	105	28	5905080



THREADING
TOOLS

Die Nuts



Size	Pitch	A	W	Code
M3	0.5	19	5	5070300
M4	0.7	19	5	5070400
M5	0.8	19	7	5070500
M6	1	19	7	5070600
M7	1	22	9	5070700
M8	1.25	22	9	5070800
M9	1.25	22	9	5070900
M10	1.5	27	11	5071000
M11	1.5	27	11	5071100
M12	1.75	36	14	5071200

Size	Pitch	A	W	Code
M14	2	36	14	5071400
M16	2	41	18	5071600
M18	2.5	41	18	5071800
M20	2.5	41	18	5072000
M22	2.5	50	22	5072200
M24	3	50	22	5072400
M27	3	60	25	5072700
M30	3.5	60	25	5073000
M33	3.5	60	25	5073300
M36	4	60	25	5073600

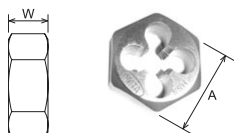
Code

507

Properties

M	DIN 382	HSS
	DIN 13	6G

Die Nuts



Size	Pitch	A	W	Code
MF3	0.35	19	5	5770300
MF4	0.5	19	5	5770400
MF6	0.75	19	7	5770610
MF8	0.75	22	9	5770790
MF8	1.0	22	9	5770800
MF10	0.75	27	11	5770990
MF10	1.0	27	11	5771000
MF10	1.25	27	11	5771010
MF12	1.0	36	10	5771190
MF12	1.25	36	10	5771200
MF12	1.5	36	10	5771210
MF14	1.0	36	10	5771390
MF14	1.25	36	10	5771400
MF14	1.5	36	10	5771410
MF16	1.0	41	14	5771590
MF16	1.5	41	14	5771600

Size	Pitch	A	W	Code
MF18	1.0	41	14	5771780
MF18	1.5	41	14	5771800
MF18	2.0	41	14	5771810
MF20	1.0	41	14	5771990
MF20	1.5	41	14	5772000
MF20	2.0	41	14	5772010
MF22	1.0	50	16	5772190
MF22	1.5	50	16	5772200
MF24	1.5	50	16	5772400
MF24	2.0	50	16	5772410
MF25	1.5	50	16	5772500
MF27	1.5	60	18	5772700
MF30	1.5	60	18	5773000
MF32	1.5	60	18	5773300
MF33	1.5	60	18	5773310
MF36	1.5	60	18	5773600

Code

577

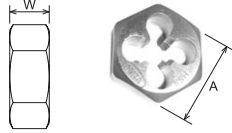
Properties

MF	DIN 382	HSS
	DIN 13	6G



THREADING
TOOLS


Die Nuts



Code

527

Properties

BSW	DIN 382	HSS
	BS 84	MEDIUM CLASS BOLT


Size	TPI	A	W	Code
1/8	40	19	5	5270320
3/16	24	19	7	5270480
1/4	20	19	7	5270640
5/16	18	22	9	5270790
3/8	16	27	11	5270950
7/16	14	27	11	5271110
1/2	12	36	14	5271270
9/16	12	36	14	5271430
5/8	11	41	18	5271590

Size	TPI	A	W	Code
3/4	10	41	18	5271910
7/8	9	50	22	5272220
1"	8	50	22	5272540
1.1/8	7	60	25	5272860
1.1/4	7	60	25	5273170
1.3/8	6	60	25	5273493
1.1/2	6	70	30	5273810
1.3/4	5	85	36	5274450
2"	4.1/2	85	36	5275080

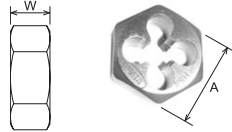
Code

537

Properties

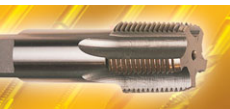
BSF	DIN 382	HSS
	BS 84	MEDIUM CLASS BOLT

Die Nuts



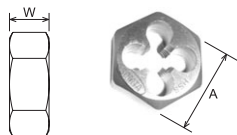
Size	TPI	A	W	Code
1/4	26	19	7	5370640
5/16	22	22	9	5370790
3/8	20	27	11	5370950
7/16	18	27	11	5371110
1/2	16	36	14	5371270
9/16	16	36	14	5371430
5/8	14	41	18	5371590

Size	TPI	A	W	Code
3/4	12	41	18	5371910
7/8	11	50	22	5372220
1"	10	50	22	5372540
1.1/8	9	60	25	5372860
1.1/4	9	60	25	5373180
1.1/2	8	70	30	5373810
2"	7	85	36	5375080



THREADING
TOOLS

Die Nuts




Size	TPI	A	W	Code
1/4	20	19	7	5470640
5/16	18	22	9	5470790
3/8	16	27	11	5470950
7/16	14	27	11	5471110
1/2	13	36	14	5471270
9/16	12	36	14	5471430
5/8	11	41	18	5471590

Size	TPI	A	W	Code
3/4	10	41	18	5471910
7/8	9	50	22	5472220
1"	8	50	22	5472540
1.1/8	7	60	25	5472860
1.1/4	7	60	25	5473180
1.1/2	6	70	30	5473810

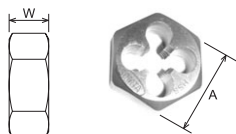
Code

547

Properties

UNC	DIN 382	HSS
	ANSI B1.1 1982	2A BOLT

Die Nuts




Size	TPI	A	W	Code
1/4	28	19	7	5570640
5/16	24	22	9	5570790
3/8	24	27	11	5570950
7/16	20	27	11	5571110
1/2	20	36	10	5571270
9/16	18	36	10	5571430
5/8	18	41	14	5571590

Size	TPI	A	W	Code
3/4	16	41	14	5571910
7/8	14	50	16	5572220
1"	12	50	16	5572540
1.1/8	12	60	18	5572860
1.1/4	12	60	18	5573180
1.1/2	12	70	20	5573810

Code

557

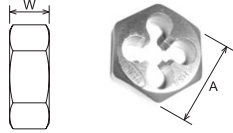
Properties

UNF	DIN 382	HSS
	ANSI B1.1 1982	2A BOLT



THREADING TOOLS


Die Nuts



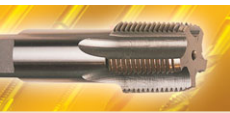
Code

574

Properties

BSP	DIN 382	HSS
 58°	ISO 228	MEDIUM CLASS BOLT

Size	On Nominal Diameter	TPI	A	W	Code
1/8	9.73	28	36	10	5740320
1/4	13.16	19	36	10	5740640
3/8	16.66	19	41	14	5740950
1/2	20.96	14	41	14	5741270
5/8	22.91	14	50	16	5741590
3/4	26.44	14	60	18	5741910
7/8	30.20	14	60	18	5742220
1"	33.25	11	60	18	5742540
1.1/8	37.90	11	70	20	5742860
1.1/4	41.91	11	70	20	5743170
1.3/8	44.32	11	85	22	5743493
1.1/2	47.80	11	85	22	5743810
1.3/4	53.75	11	100	22	5744445
2"	59.61	11	100	22	5745080



Adjustable Tap Wrenches



Code

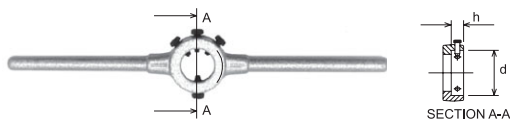
588

Ref.	Type	mm	Range Inches	Pipe	Code
T1	T	3-6	1/8 - 1/4	-	5880003
T2	T	8-12	5/16 - 1/2	1/8 - 1/4	5880004
TL3	T LONG REACH	2-6	1/16 - 1/4	-	5880005
TL4	T LONG REACH	8-12	5/16 - 1/2	1/8 - 1/4	5880006
TW1	BAR	2-6	1/16 - 1/4	-	5880001
TW2	BAR	3-12	1/8 - 1/2	1/8 - 1/2	5880002
TW3	BAR	3-12	1/8 - 1/2	1/8 - 1/4	5880007
TW4	BAR	6-20	1/4 - 3/4	1/8 - 3/8	5880008
TW5	BAR	12-27	1/2 - 1"	1/4 - 5/8	5880009
TW6	BAR	20-32	3/4 - 1.1/4	3/8 - 1"	5880010

Properties

DIN 1814

Die Stocks



Code

589

Ref.	d	h	Code	Ref.	d	h	Code
0	16	5	5890000	6A	45	14	5890060
1	20	5	5890010	6	45	18	5890065
2	20	7	5890020	7A	55	16	5890070
3	25	9	5890030	7	55	22	5890075
4	30	11	5890040	8A	65	18	5890080
5A	38	10	5890050	8	65	25	5890085
5	38	14	5890055	9A	75	20	5890090

Properties

DIN 225



THREADING TOOLS



Tap & Die Cased Sets

Code
5A1

Properties
HSS

See appropriate Catalogue Pages

Suited Materials
GENERAL



Description of Set	Ref No.	Code
1/8 - 1/2 BSW	HS 3	5A10003
THIS SET CONTAINS:		
TAPS (code 521)	DIES	
TAPER, BOTTOM		
1/8	1/8 x 13/16 O/D	
3/16	3/16 x 13/16 O/D	
1/4	1/4 x 13/16 O/D	
5/16	5/16 x 1" O/D	
3/8	3/8 x 1" O/D	
7/16	7/16 x 1" O/D	
1/2	1/2 x 1" O/D	
TAP WRENCH TW2		
DIESTOCK DS1, DS2		
3/16 - 1/2 BSF	HS 7	5A10007
THIS SET CONTAINS:		
TAPS (code 531)	DIES	
TAPER, BOTTOM		
3/16	3/16 x 13/16 O/D	
1/4	1/4 x 13/16 O/D	
5/16	5/16 x 1" O/D	
3/8	3/8 x 1" O/D	
7/16	7/16 x 1" O/D	
1/2	1/2 x 1" O/D	
TAP WRENCH TW2		
DIESTOCK DS1, DS2		
1/4 - 1/2 UNC	HS 10	5A10010
THIS SET CONTAINS:		
TAPS (code 541)	DIES	
TAPER, BOTTOM		
1/4	1/4 x 1" O/D	
5/16	5/16 x 1" O/D	
3/8	3/8 x 1" O/D	
7/16	7/16 x 1" O/D	
1/2	1/2 x 1" O/D	
TAP WRENCH TW2		
DIESTOCK DS2		

Hexagonal Die Nut Case Sets available on request.



THREADING
TOOLS

Tap & Die Cased Sets



Code

5A1

Properties

HSS

See appropriate
Catalogue Pages

Suited Materials

GENERAL

Description of Set	Ref No.	Code
1/4 - 1/2 UNF	HS 13	5A10013
THIS SET CONTAINS:		
TAPS (code 551)	DIES	
TAPER, BOTTOM		
1/4	1/4 x 1" O/D	
5/16	5/16 x 1" O/D	
3/8	3/8 x 1" O/D	
7/16	7/16 x 1" O/D	
1/2	1/2 x 1" O/D	
TAP WRENCH TW2		
DIESTOCK DS2		
M2 - M6	HS 16	5A10016
THIS SET CONTAINS:		
TAPS (code 501)	DIES	
TAPER, BOTTOM		
2 x 0.4	2 x 13/16 O/D	
3 x 0.5	3 x 13/16 O/D	
4 x 0.7	4 x 13/16 O/D	
5 x 0.8	5 x 13/16 O/D	
6 x 1	6 x 13/16 O/D	
TAP WRENCH TW1		
DIESTOCK DS1		
M2 - M12	HS 17	5A10017
THIS SET CONTAINS:		
TAPS (code 501)	DIES	
TAPER, BOTTOM		
2 x 0.4	2 x 13/16 O/D	
3 x 0.5	3 x 13/16 O/D	
4 x 0.7	4 x 13/16 O/D	
5 x 0.8	5 x 13/16 O/D	
6 x 1	6 x 13/16 O/D	
7 x 1	7 x 1" O/D	
8 x 1.25	8 x 1" O/D	
9 x 1.25	9 x 1" O/D	
10 x 1.5	10 x 1" O/D	
11 x 1.5	11 x 1" O/D	
12 x 1.75	12 x 1" O/D	
TAP WRENCH TW2		
DIESTOCK DS1, DS2		

Hexagonal Die Nut Case Sets available on request.



**THREADING
TOOLS**



Tap & Die Cased Sets

Code

5A1

Properties

HSS

See appropriate
Catalogue Pages

Suited Materials

GENERAL



Description of Sets	Ref No.	Code
M6 - M12	HS 19	5A10019
THIS SET CONTAINS:		
TAPS (code 501)	DIES	
TAPER, BOTTOM		
6 x 1	6 x 1" O/D	
7 x 1	7 x 1" O/D	
8 x 1.25	8 x 1" O/D	
9 x 1.25	9 x 1" O/D	
10 x 1.5	10 x 1" O/D	
11 x 1.5	11 x 1" O/D	
12 x 1.75	12 x 1" O/D	
TAP WRENCH TW2		
DIESTOCK DS2		
M6 - M24	HS 21	5A10021
THIS SET CONTAINS:		
TAPS (code 501)	DIES	
TAPER, BOTTOM		
6 x 1	6 x 1" O/D	
7 x 1	7 x 1" O/D	
8 x 1.25	8 x 1" O/D	
9 x 1.25	9 x 1" O/D	
10 x 1.5	10 x 1" O/D	
11 x 1.5	11 x 1-1/12 O/D	
12 x 1.75	12 x 1-1/12 O/D	
14 x 2	14 x 1-1/12 O/D	
16 x 2	16 x 1-1/12 O/D	
18 x 2.5	18 x 2" O/D	
20 x 2.5	20 x 2" O/D	
22 x 2.5	22 x 2" O/D	
24 x 3	24 x 2" O/D	
TAP WRENCH TW2, TW5		
DIESTOCK DS2, DS4, DS5		

Hexagonal Die Nut Case Sets available on request.



THREADING
TOOLS

Colour Band Jobber Drill and Gun Nose Tap Sets



NEW



**BLUE BAND
DRILL AND
TAP SET**



**GREEN BAND
DRILL AND
TAP SET**



**RED BAND
DRILL AND
TAP SET**

Code
**5BB
5G7
5R5**

Properties
See appropriate
Catalogue Pages

Suited Materials
See appropriate
Catalogue Pages

Description	Ref No.	Code
Blue Band Drill and Tap Set - TiAlN Coated	5BBS	5BB0000
THIS SET CONTAINS:		
JOBBER DRILLS	SPIRAL POINT TAPS	
4.2mm - 1BB0420	M5 - 5390500	
5.0mm - 1BB0500	M6 - 5390600	
6.8mm - 1BB0680	M8 - 5390800	
8.5mm - 1BB0850	M10 - 5391000	
10.2mm - 1BB1020	M12 - 5491200	
Green Band Drill and Tap Set - TiN Coated	5G7S	5G70000
THIS SET CONTAINS:		
JOBBER DRILLS	SPIRAL POINT TAPS	
4.2mm - 1G70420	M5 - 5610500	
5.0mm - 1G70500	M6 - 5610600	
6.8mm - 1G70680	M8 - 5610800	
8.5mm - 1G70850	M10 - 5611000	
10.2mm - 1G71020	M12 - 5661200	
Red Band Drill and Tap Set - TiAlN Coated	5R5S	5R50000
THIS SET CONTAINS:		
JOBBER DRILLS	SPIRAL POINT TAPS	
4.2mm - 1R50420	M5 - 5400500	
5.0mm - 1R50500	M6 - 5400600	
6.8mm - 1R50680	M8 - 5400800	
8.5mm - 1R50850	M10 - 5401000	
10.2mm - 1R51020	M12 - 5501200	

Sets also available with Spiral Flute Taps



**THREADING
TOOLS**



Drill and Tap Sets in Metal Index Cases



Code

598

Properties

M HSS

See appropriate Catalogue Pages

Suited Materials

See appropriate Catalogue Pages

Description	Code
M3 - M12 Second Short Hand Taps (code 501)	5980501
M3 - M12 Gun Nose Machine Taps (code 508)	5980503
M3 - M12 Spiral Flute Machine Taps (code 510)	5980504
M3 - M12 Short Hand Tap Sets (code 501)	5980506
M3 - M12 Short Hand Tap Sets (code 501) plus 2.5, 3.3, 4.2, 5.0, 6.8, 8.5 and 10.2 mm Straight Shank Drills (code 101)	5980511

Note: The above sets contain tap sizes M3, M4, M5, M6, M8, M10 and M12.

Code

5DT

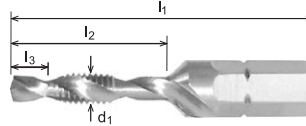
Properties

M HSS

Suited Materials

GENERAL

Combination Drill and Tap

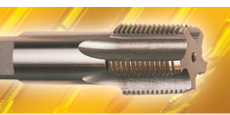


Size	Pitch	d ₁	l ₃	l ₂	l ₁	Code
M3	0.5	2.5	6	12	35	5DT0300
M4	0.7	3.3	6	14	38	5DT0400
M5	0.8	4.2	7	18	40	5DT0500
M6	1.0	5	9	18	43	5DT0600
M8	1.25	6.8	13	23	51	5DT0800
M10	1.5	8.5	16	32	59	5DT1000

Code

5AU

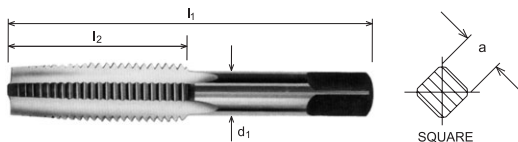
Somta Tapping, Reaming and Drilling Fluid



Description	Code
300 ml	5AU0010

THREADING TOOLS

Carbon Steel Short Hand Tap Sets



Size	Pitch	l ₁	l ₂	d ₁	a	Tap Set Code
M2	0.4	42.9	9.5	3.3	2.7	9010200
M3	0.5	47.6	14.3	3.3	2.7	9010300
M4	0.7	54	19.1	4.2	3.4	9010400
M5	0.8	60.3	22.2	5.4	4.2	9010500
M6	1.0	63.5	25.4	6.1	4.8	9010600
M7	1.0	63.5	25.4	7.2	5.6	9010700
M8	1.25	69.9	28.6	8.2	6.3	9010800
M9	1.25	74.6	31.8	9.1	7	9010900
M10	1.5	74.6	31.8	10.3	7.8	9011000
M11	1.5	80.2	36.5	8.2	6.1	9011100
M12	1.75	85.7	42.1	9.3	7	9011200
M14	2.0	91.3	42.1	10.9	8.2	9011400
M16	2.0	96.8	46	12.2	9.1	9011600
M18	2.5	102.4	46	13.8	10.3	9011800
M20	2.5	108	50.8	15	11.2	9012000
M22	2.5	119.1	56.4	17.7	13.3	9012200
M24	3.0	124.6	56.4	19.3	14.5	9012400
M27	3.0	130.2	63.5	20.3	15.2	9012700
M30	3.5	138.1	65.1	22.8	17.1	9013000
M33	3.5	146.1	65.1	25.9	19.5	9013300
M36	4.0	154	76.2	28.1	21.1	9013600

Hi-Cut

Code

901

Properties

M	BS 949: 1951	CARBON STEEL TO ZONE 5
60°	STRAIGHT FLUTE	Hand icon
Thread icon	RH	

Suited Materials

GENERAL





Carbon Steel Short Hand Tap Sets

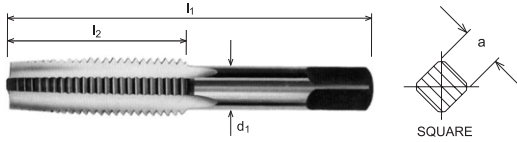
Hi-Cut

Code
902

Properties

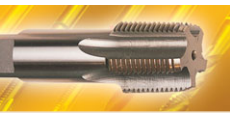
MF	BS 949: 1951	CARBON STEEL TO ZONE 5
	STRAIGHT FLUTE	

Suited Materials
GENERAL



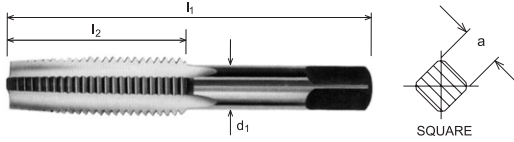
Size	Pitch	l ₁	l ₂	d ₁	a	Tap Set Code
MF4	0.5	54	19.1	4.2	3.4	9020390
MF4	0.75	54	19.1	4.2	3.4	9020400
MF5	0.9	60.3	22.2	5.4	4.2	9020500
MF8	1.0	69.9	28.6	8.2	6.3	9020800
*MF10	1.0	74.6	31.8	10.3	7.8	9021000
MF10	1.25	74.6	31.8	10.3	7.8	9021010
MF12	1.0	76.2	31.8	9.3	7	9021200
*MF12	1.25	76.2	31.8	9.3	7	9021210
MF12	1.5	76.2	31.8	9.3	7	9021220
*MF14	1.25	76.2	31.8	10.9	8.2	9021400
MF14	1.5	76.2	31.8	10.9	8.2	9021410
#MF16	1.5	76.2	31.8	12.2	9.1	9021600
*MF18	1.5	76.2	31.8	13.8	10.3	9021800
#MF20	1.5	82.6	38.1	15	11.2	9022000
*MF22	1.5	82.6	38.1	17.7	13.3	9022200
MF24	1.5	82.6	38.1	19.3	14.5	9022400

* Spark Plug
Conduit



THREADING TOOLS

Carbon Steel Short Hand Tap Sets



Size	TPI	l_1	l_2	d_1	a	Tap Set Code
1/8	40	49.2	15.9	3.3	2.7	9030320
5/32	32	54	19.1	4	3.1	9030400
7/32	24	60.3	22.2	5.6	4.4	9030560
1/4	20	63.5	25.4	6.4	5	9030640
5/16	18	69.9	28.6	8	6.1	9030790
3/8	16	74.6	31.8	9.6	7.5	9030950
7/16	14	80.2	36.5	8.2	6.1	9031110
1/2	12	85.7	42.1	9.3	7	9031270
9/16	12	91.3	42.1	10.9	8.2	9031430
5/8	11	96.8	46	12.2	9.1	9031590
3/4	10	108	50.8	15	11.2	9031910
7/8	9	119.1	56.4	17.7	13.3	9032220
1"	8	130.2	63.5	20.3	15.2	9032540
1.1/4	7	146.1	65.1	25.9	19.5	9033170

Hi-Cut

Code

903

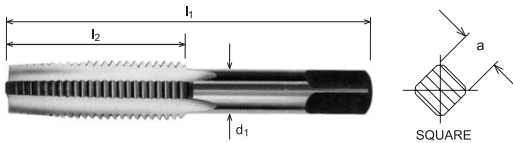
Properties

BSW	BS 949: 1951	CARBON STEEL TO ZONE 5
	STRAIGHT FLUTE	

Suited Materials

GENERAL

Carbon Steel Short Hand Tap Sets



Size	TPI	l_1	l_2	d_1	a	Tap Set Code
3/16	32	60.3	22.2	4.8	3.8	9040480
1/4	26	63.5	25.4	6.4	5	9040640
5/16	22	69.9	28.6	8	6.1	9040790
9/16	16	91.3	42.1	10.9	8.2	9041430
7/8	11	119.1	56.4	17.7	13.3	9042220
1"	10	130.2	63.5	20.3	15.2	9042540

Code

904

Properties

BSF	BS 949: 1951	CARBON STEEL TO ZONE 5
	STRAIGHT FLUTE	

Suited Materials

GENERAL



THREADING TOOLS

Carbon Steel Short Hand Tap Sets

Hi-Cut

Code

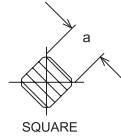
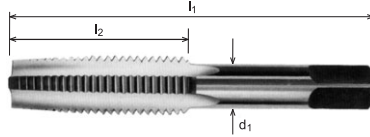
905

Properties

UNC	BS 949: 1951	CARBON STEEL TO ZONE 5
	STRAIGHT FLUTE	

Suited Materials

GENERAL



Size	TPI	l_1	l_2	d_1	a	Tap Set Code
1/4	20	63.5	25.4	6.5	4.9	9050640
5/16	18	69.1	28.6	8.1	6	9050790
3/8	16	74.6	31.8	9.7	7.3	9050950
7/16	14	80.2	36.5	8.2	6.1	9051110
1/2	13	85.7	42.1	9.3	7	9051270
9/16	12	91.3	42.1	10.9	8.2	9051430
5/8	11	96.8	46	12.2	9.1	9051590
3/4	10	108	50.8	15	11.2	9051910
7/8	9	119.1	56.4	17.7	13.3	9052220
1"	8	130.2	63.5	20.3	15.2	9052540

Code

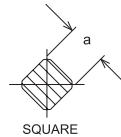
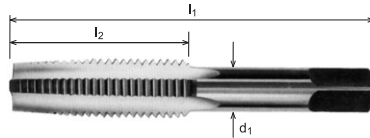
906

Properties

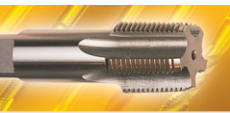
UNF	BS 949: 1951	CARBON STEEL TO ZONE 5
	STRAIGHT FLUTE	

Suited Materials

GENERAL

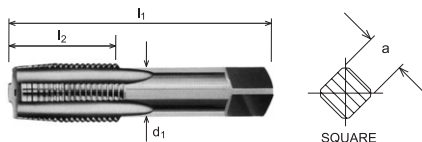


Size	TPI	l_1	l_2	d_1	a	Tap Set Code
1/4	28	63.5	25.4	6.5	4.9	9060640
5/16	24	69.1	28.6	8.1	6	9060790
3/8	24	74.6	31.8	9.7	7.3	9060950
7/16	20	80.2	36.5	8.2	6.1	9061110
1/2	20	85.7	42.1	9.3	7	9061270
9/16	18	91.3	42.1	10.9	8.2	9061430
5/8	18	96.8	46	12.2	9.1	9061590
3/4	16	108	50.8	15	11.2	9061910
7/8	14	119.1	56.4	17.7	13.3	9062220
1"	12	130.2	63.5	20.3	15.2	9062540



THREADING TOOLS

Carbon Steel Parallel Pipe Tap Sets



Size	Nom. Dia.	TPI	l ₁	l ₂	d ₁	a	Tap Set Code
1/8	9.728	28	54	19.1	8.1	6	9070320
1/4	13.157	19	61.9	27	10.9	8.2	9070640
3/8	16.662	19	65.1	27	13.8	10.3	9070950
1/2	20.955	14	79.4	34.9	17.4	13.1	9071270
5/8	22.911	14	81	34.9	20.3	15.2	9071590
3/4	26.441	14	82.6	34.9	23	17.2	9071910
1"	33.249	11	88.9	44.5	28.6	21.4	9072540
1.1/2	47.803	11	108	44.5	38.1	28.6	9073810
2"	59.614	11	114.3	44.5	47.6	35.7	9075080

Hi-Cut

Code

907

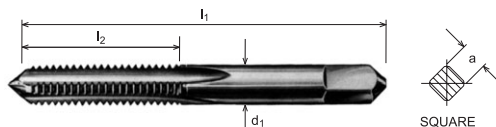
Properties

BSP	G SERIES	BS 949: 1951
CARBON STEEL TO ZONE 5	55% 	STRAIGHT FLUTE

Suited Materials

GENERAL

Carbon Steel Short Hand Tap Sets



Size	Nom. Dia.	Pitch	l ₁	l ₂	d ₁	a	Tap Set Code
No.6	2.8	0.53	47.6	14.3	3.3	2.7	9080600
No.5	3.2	0.59	49.2	15.9	3.3	2.7	9080500
No.4	3.6	0.66	50.8	17.5	3.7	2.9	9080400
No.3	4.1	0.73	54	19.1	4.2	3.4	9080300
No.2	4.7	0.81	60.3	22.2	4.8	3.8	9080200
No.1	5.3	0.9	60.3	22.2	5.4	4.2	9080100

Code

908

Properties

BA	BS 949: 1951	CARBON STEEL TO ZONE 5
47% 	STRAIGHT FLUTE	

Suited Materials

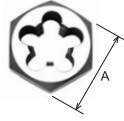
GENERAL



THREADING TOOLS

Carbon Steel Die Nuts


Hi-Cut



Code

911

Properties

M	BS 1127: 1974	CARBON STEEL CUT THREAD
	DIN 13	
	6G	


Size	Pitch	A	W	Code
M4	0.7	18	5	9110400
M5	0.8	18	7	9110500
M6	1	18	7	9110600
M7	1	20.8	9	9110700
M8	1.25	20.8	9	9110800
M9	1.25	23.4	9	9110900
M10	1.5	23.4	11	9111000
M11	1.5	25.7	11	9111100
M12	1.75	27.9	14	9111200
M14	2	33	14	9111400

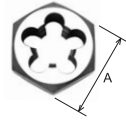
Size	Pitch	A	W	Code
M16	2	33	18	9111600
M18	2.5	37.6	18	9111800
M20	2.5	37.6	18	9112000
M22	2.5	42.4	22	9112200
M24	3	52.1	22	9112400
M27	3	56.4	25	9112700
M30	3.5	56.4	25	9113000
M33	3.5	65.5	25	9113300
M36	4	70.1	25	9113600
M39	4	70.1	30	9113900

Code

912

Properties

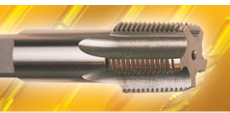
MF	BS 1127: 1974	CARBON STEEL CUT THREAD
	DIN 13	
	6G	



Carbon Steel Die Nuts

Size	Pitch	A	W	Code
MF8	1	20.8	9	9120800
MF10	1	23.4	11	9121000
MF10	1.25	23.4	11	9121010
MF12	1.25	27.9	10	9121210
MF12	1.5	27.9	10	9121220
MF14	1.25	33	10	9121400

Size	Pitch	A	W	Code
MF14	1.5	33	10	9121410
MF16	1.5	33	14	9121600
MF18	1.5	37.6	14	9121800
MF20	1.5	37.6	14	9122000
MF22	1.5	42.4	16	9122200
MF24	1.5	52.1	16	9122400



THREADING
TOOLS

Carbon Steel Die Nuts



Size	TPI	A	W	Code
5/32	32	18	6	9130400
7/32	24	18	7	9130560
1/4	20	18	7	9130640


Size	TPI	A	W	Code
5/8	11	33	18	9131590
3/4	10	37.6	18	9131910
1.1/8	7	56.4	25	9132860

Hi-Cut

Code

913

Properties

BSW	BS 1127: 1974	CARBON STEEL CUT THREAD
	55° 	BS 84 MEDIUM CLASS BOLT

Carbon Steel Die Nuts




Size	TPI	A	W	Code
1/4	26	18	7	9140640
1/2	16	27.9	11	9141270
1"	10	52.1	22	9142540

Size	TPI	A	W	Code
1.1/8	9	56.4	25	9142860
1.1/4	9	56.4	25	9143170

Code

914

Properties

BSF	BS 1127: 1974	CARBON STEEL CUT THREAD
	55° 	BS 84 MEDIUM CLASS BOLT




Carbon Steel Die Nuts

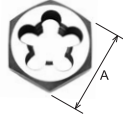
Hi-Cut

Code

915

Properties

UNC	BS	CARBON STEEL CUT THREAD
	1127: 1974	
	ANSI	2A BOLT
	B1.1 1982	




Size	TPI	A	W	Code
1/4	20	18	7	9150640
1/2	13	27.9	14	9151270
5/8	11	33	18	9151590
3/4	10	37.6	18	9151910

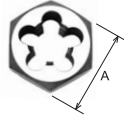
Size	TPI	A	W	Code
1.1/8	7	56.4	25	9152860
1.1/4	7	56.4	25	9153170
1.3/8	6	65.5	25	9153490

Code

916

Properties

UNF	BS	CARBON STEEL CUT THREAD
	1127: 1974	
	ANSI	2A BOLT
	B1.1 1982	



Size	TPI	A	W	Code
3/8	24	23.4	11	9160950
7/16	20	25.7	11	9161110
1/2	20	27.9	14	9161270

Size	TPI	A	W	Code
5/8	18	33	18	9161590
3/4	16	37.6	18	9161910
1.1/2	12	70.1	30	9163810



THREADING
TOOLS

Carbon Steel Die Nuts



Size	On Nominal Diameter	TPI	A	W	Code
1/8	9.728	28	23.4	10	9170320
1/4	13.157	19	27.9	14	9170640
1/2	20.955	14	42.4	19	9171270
3/4	26.441	14	52.1	20	9171910
1"	33.249	11	65.5	24	9172540

Hi-Cut

Code
917

Properties		
BSP	BS 1127; 1974	CARBON STEEL CUT THREAD
	ISO 228	MEDIUM CLASS BOLT

Carbon Steel Die Nuts



Size	Pitch	A	W	Code	Size	Pitch	A	W	Code
0	1	18	6.4	9180000	4	0.66	18	6.4	9180400
1	0.9	18	6.4	9180100	5	0.59	18	6.4	9180500
3	0.73	18	6.4	9180300	6	0.53	18	6.4	9180600

Code
918

Properties		
BA	BS 1127; 1974	CARBON STEEL CUT THREAD
MEDIUM CLASS BOLT		



Carbon Steel Tap Wrenches

Hi-Cut

Code

980

Properties

CARBON
STEEL



Reference	Tap Range	mm	Pipe	Code
BAR TYPE				
TW 1 / No. 0	1/16 - 1/4	2 - 6	-	9800001
TW 2 / No. 1.5	1/8 - 1/2	3 - 12	1/8 - 1/4	9800002
TW 3 / No. 2	1/8 - 1/2	3 - 12	1/8 - 1/4	9800007
TW 4 / No. 3	1/4 - 3/4	6 - 20	1/8 - 3/8	9800008
TW 5 / No. 4	1/2 - 1"	12 - 27	1/4 - 5/8	9800009
TW 6 / No. 5	3/4 - 1.1/4	20 - 32	3/8 - 1"	9800010
T-TYPE				
T 1	1/8 - 1/4	3 - 6	-	9800003
T 2	5/16 - 1/2	8 - 12	1/8 - 1/4	9800004
T-TYPE LONG REACH				
TL 3	1/16 - 1/4	2 - 6	-	9800005
TL 4	5/16 - 1/2	8 - 12	1/8 - 1/4	9800006

Code

976

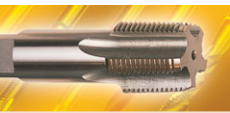
Properties

CARBON
STEEL

Metric Conduit Circular Solid Sets



Description	Ref No.	Code
THIS SET CONTAINS: 20 X 1.5/8 O/D DIE 25 X 1.5/8 O/D DIE CS1 DIESTOCK 20 X 1.5/8 O/D GUIDE 25 X 1.5/8 O/D GUIDE	CSM 185	9760185



THREADING
TOOLS

Carbon Steel Tap & Die Cased Sets



Hi-Cut



Codes

970 - 975

Properties

**CARBON
STEEL**

Suited Materials

GENERAL

Description of Set	Ref No.	Code
M2 - M6	C 111	9700111
THIS SET CONTAINS:		
TAPS	DIES	
TAPER, BOTTOM		
2 x 0.4	2 x 13/16 O/D	
3 x 0.5	3 x 13/16 O/D	
4 x 0.7	4 x 13/16 O/D	
5 x 0.8	5 x 13/16 O/D	
6 x 1	6 x 13/16 O/D	
TAP WRENCH TW1		
DIESTOCK DS1		
M2 - M12	C114	9700114
THIS SET CONTAINS:		
TAPS	DIES	
TAPER, BOTTOM		
2 x 0.4	2 x 13/16 O/D	
3 x 0.5	3 x 13/16 O/D	
4 x 0.7	4 x 13/16 O/D	
5 x 0.8	5 x 13/16 O/D	
6 x 1	6 x 13/16 O/D	
7 x 1	7 x 1" O/D	
8 x 1.25	8 x 1" O/D	
9 x 1.25	9 x 1" O/D	
10 x 1.5	10 x 1" O/D	
11 x 1.5	11 x 1" O/D	
12 x 1.75	12 x 1" O/D	
TAP WRENCH TW2		
DIESTOCKS DS1, DS2		
M6 - M12	C118	9700118
THIS SET CONTAINS:		
TAPS	DIES	
TAPER, BOTTOM		
6 x 1	6 x 1" O/D	
7 x 1	7 x 1" O/D	
8 x 1.25	8 x 1" O/D	
9 x 1.25	9 x 1" O/D	
10 x 1.5	10 x 1" O/D	
11 x 1.5	11 x 1" O/D	
12 x 1.75	12 x 1" O/D	
TAP WRENCH TW2		
DIESTOCK DS2		



**THREADING
TOOLS**

Carbon Steel Tap & Die Cased Sets

Hi-Cut

Codes

970 - 975

Properties

**CARBON
STEEL**

Suited Materials

GENERAL



Description of Set	Ref No.	Code
M6 - M20	C119	9700119
THIS SET CONTAINS:		
TAPS	DIES	
TAPER, BOTTOM		
6 x 1	6 x 1" O/D	
7 x 1	7 x 1" O/D	
8 x 1.25	8 x 1" O/D	
9 x 1.25	9 x 1" O/D	
10 x 1.5	10 x 1" O/D	
11 x 1.5	11 x 1.1/12 O/D	
12 x 1.75	12 x 1.1/12 O/D	
14 x 2	14 x 1.1/12 O/D	
16 x 2	16 x 1.1/12 O/D	
18 x 2.5	18 x 1.1/12 O/D	
20 x 2.5	20 x 1.1/12 O/D	
TAP WRENCH TW4		
DIESTOCKS DS2, DS4		
M6 - M24	C 120	9700120
THIS SET CONTAINS:		
TAPS	DIES	
TAPER, BOTTOM		
6 x 1	6 x 1" O/D	
7 x 1	7 x 1" O/D	
8 x 1.25	8 x 1" O/D	
9 x 1.25	9 x 1" O/D	
10 x 1.5	10 x 1" O/D	
11 x 1.5	11 x 1.1/12 O/D	
12 x 1.75	12 x 1.1/12 O/D	
14 x 2	14 x 1.1/12 O/D	
16 x 2	16 x 1.1/12 O/D	
18 x 2.5	18 x 2" O/D	
20 x 2.5	20 x 2" O/D	
22 x 2.5	22 x 2" O/D	
24 x 3	24 x 2" O/D	
TAP WRENCH TW2, TW5		
DIESTOCKS DS2, DS4, DS5		



**THREADING
TOOLS**

Carbon Steel Tap & Die Cased Sets



Hi-Cut

Codes

970 - 975

Properties

CARBON
STEEL

Suited Materials

GENERAL

Description of Set	Ref No.	Code
M6 - M20	CT 100	9701000
THIS SET CONTAINS:		
TAPS	DIES	
TAPER, BOTTOM		
6 x 1	6 x 1" O/D	
8 x 1.25	8 x 1" O/D	
10 x 1.5	10 x 1" O/D	
12 x 1.75	12 x 1" O/D	
14 x 2	14 x 1.1/12 O/D	
16 x 2	16 x 1.1/12 O/D	
18 x 2.5	18 x 1.1/12 O/D	
20 x 2.5	20 x 1.1/12 O/D	
TAP WRENCH TW4		
DIESTOCKS DS2, DS4		
M6 - M24	CT 101	9701010
THIS SET CONTAINS:		
TAPS	DIES	
TAPER, BOTTOM		
6 x 1	6 x 1.5/16 O/D	
8 x 1.25	8 x 1.5/16 O/D	
10 x 1.5	10 x 1.5/16 O/D	
12 x 1.75	12 x 1.5/16 O/D	
14 x 2	14 x 1.5/16 O/D	
16 x 2	16 x 2" O/D	
18 x 2.5	18 x 2" O/D	
20 x 2.5	20 x 2" O/D	
22 x 2.5	22 x 2" O/D	
24 x 3	24 x 2" O/D	
TAP WRENCH TW3, TW5		
DISTOCKS DS3, DS5		



THREADING
TOOLS

Carbon Steel Tap & Die Cased Sets

Hi-Cut

Codes

970 - 975

Properties

**CARBON
STEEL**

Suited Materials

GENERAL



Description of Set	Ref No.	Code
M6 - M24	CT 101F	9701011
THIS SET CONTAINS:		
TAPS	DIES	
TAPER, BOTTOM		
6 x 0.75	6 x 1.5/16 O/D	
8 x 1	8 x 1.5/16 O/D	
10 x 1.25	10 x 1.5/16 O/D	
12 x 1.5	12 x 1.5/16 O/D	
14 x 1.5	14 x 1.5/16 O/D	
16 x 1.5	16 x 2" O/D	
18 x 1.5	18 x 2" O/D	
20 x 1.5	20 x 2" O/D	
22 x 1.5	22 x 2" O/D	
24 x 1.5	24 x 2" O/D	
TAP WRENCH TW3, TW5		
DIESTOCKS DS3, DS5		
1/8 - 1/2 BSW	C 31	9710031
THIS SET CONTAINS:		
TAPS	DIES	
TAPER, BOTTOM		
1/8	1/8 x 13/16 O/D	
3/16	3/16 x 13/16 O/D	
1/4	1/4 x 13/16 O/D	
5/16	5/16 x 1" O/D	
3/8	3/8 x 1" O/D	
7/16	7/16 x 1" O/D	
1/2	1/2 x 1" O/D	
TAP WRENCH TW2		
DIESTOCKS DS1, DS2		
1/4 - 1/2 BSW	C 36	9710036
THIS SET CONTAINS:		
TAPS	DIES	
TAPER, BOTTOM		
1/4	1/4 x 1" O/D	
5/16	5/16 x 1" O/D	
3/8	3/8 x 1" O/D	
7/16	7/16 x 1" O/D	
1/2	1/2 x 1" O/D	
TAP WRENCH TW2		
DIESTOCK DS2		



**THREADING
TOOLS**

Carbon Steel Tap & Die Cased Sets



Hi-Cut

Codes

970 - 975

Properties

**CARBON
STEEL**

Suited Materials

GENERAL

Description of Set	Ref No.	Code
1/4 - 3/4 BSW	C 37	9710037
THIS SET CONTAINS:		
TAPS	DIES	
TAPER, BOTTOM		
1/4	1/4 x 1" O/D	
5/16	5/16 x 1" O/D	
3/8	3/8 x 1" O/D	
7/16	7/16 x 1.1/2 O/D	
1/2	1/2 x 1.1/2 O/D	
5/8	5/8 x 1.1/2 O/D	
3/4	3/4 x 1.1/2 O/D	
TAP WRENCH TW4		
DIESTOCKS DS2, DS4		
1/4 - 1" BSW	C 39	9710039
THIS SET CONTAINS:		
TAPS	DIES	
TAPER, BOTTOM		
1/4	1/4 x 1" O/D	
5/16	5/16 x 1" O/D	
3/8	3/8 x 1" O/D	
7/16	7/16 x 1.1/2 O/D	
1/2	1/2 x 1.1/2 O/D	
5/8	5/8 x 1.1/2 O/D	
3/4	3/4 x 2" O/D	
7/8	7/8 x 2" O/D	
1"	1" x 2" O/D	
TAP WRENCH TW2, TW5		
DIESTOCKS DS2, DS4, DS5		
3/16 - 1/2 BSF	C 52	9720052
THIS SET CONTAINS:		
TAPS	DIES	
TAPER, BOTTOM		
3/16	3/16 x 13/16 O/D	
1/4	1/4 x 13/16 O/D	
5/16	5/16 x 1" O/D	
3/8	3/8 x 1" O/D	
7/16	7/16 x 1" O/D	
1/2	1/2 x 1" O/D	
TAP WRENCH TW2		
DIESTOCKS DS1, DS2		



**THREADING
TOOLS**



Carbon Steel Tap & Die Cased Sets

Hi-Cut

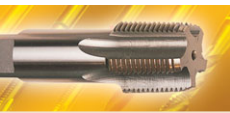


Codes
970 - 975

Properties
CARBON STEEL

Suited Materials
GENERAL

Description of Set	Ref No.	Code
1/4 - 1" BSF	C 58	9720058
THIS SET CONTAINS:		
TAPS	DIES	
TAPER, BOTTOM		
1/4	1/4 x 13/16 O/D	
5/16	5/16 x 1" O/D	
3/8	3/8 x 1" O/D	
7/16	7/16 x 1.1/2 O/D	
1/2	1/2 x 1.1/2 O/D	
5/8	5/8 x 1.1/2 O/D	
3/4	3/4 x 2" O/D	
7/8	7/8 x 2" O/D	
1"	1" x 2" O/D	
TAP WRENCH TW2, TW5		
DIESTOCKS DS2, DS4, DS5		
1/4 - 1/2 UNC	C 82	9730082
THIS SET CONTAINS:		
TAPS	DIES	
TAPER, BOTTOM		
1/4	1/4 x 1" O/D	
5/16	5/16 x 1" O/D	
3/8	3/8 x 1" O/D	
7/16	7/16 x 1" O/D	
1/2	1/2 x 1" O/D	
TAP WRENCH TW2		
DIESTOCK DS2		
1/4 - 1" UNC	C 85	9730085
THIS SET CONTAINS:		
TAPS	DIES	
TAPER, BOTTOM		
1/4	1/4 x 1" O/D	
5/16	5/16 x 1" O/D	
3/8	3/8 x 1" O/D	
7/16	7/16 x 1.1/2 O/D	
1/2	1/2 x 1.1/2 O/D	
5/8	5/8 x 1.1/2 O/D	
3/4	3/4 x 2" O/D	
7/8	7/8 x 2" O/D	
1"	1" x 2" O/D	
TAP WRENCH TW2, TW5		
DIESTOCKS DS2, DS4, DS5		



THREADING TOOLS

Carbon Steel Tap & Die Cased Sets



Hi-Cut



Codes
970 - 975

Properties
CARBON STEEL

Suited Materials
GENERAL

Description of Set	Ref No.	Code
1/4 - 1/2 UNF	C 92	9740092
THIS SET CONTAINS:		
TAPS	DIES	
TAPER, BOTTOM		
1/4	1/4 x 1" O/D	
5/16	5/16 x 1" O/D	
3/8	3/8 x 1" O/D	
7/16	7/16 x 1" O/D	
1/2	1/2 x 1" O/D	
TAP WRENCH TW2		
DIESTOCK DS2		
1/4 - 1" UNF	C 95	9740095
THIS SET CONTAINS:		
TAPS	DIES	
TAPER, BOTTOM		
1/4	1/4 x 1" O/D	
5/16	5/16 x 1" O/D	
3/8	3/8 x 1" O/D	
7/16	7/16 x 1.1/2 O/D	
1/2	1/2 x 1.1/2 O/D	
5/8	5/8 x 1.1/2 O/D	
3/4	3/4 x 2" O/D	
7/8	7/8 x 2" O/D	
1"	1" x 2" O/D	
TAP WRENCH TW2, TW5		
DIESTOCKS DS2, DS4, DS5		
0 - 10 BA	C 3	9750003
THIS SET CONTAINS:		
TAPS	DIES	
TAPER, BOTTOM		
0	0 x 13/16 O/D	
1	1 x 13/16 O/D	
2	2 x 13/16 O/D	
3	3 x 13/16 O/D	
4	4 x 13/16 O/D	
5	5 x 13/16 O/D	
6	6 x 13/16 O/D	
7	7 x 13/16 O/D	
8	8 x 13/16 O/D	
9	9 x 13/16 O/D	
10	10 x 13/16 O/D	
TAP WRENCH TW1		
DIESTOCK DS1		





Carbon Steel Tap & Die Cased Sets

Hi-Cut

Codes

970 - 975

Properties

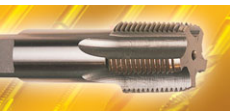
**CARBON
STEEL**

Suited Materials

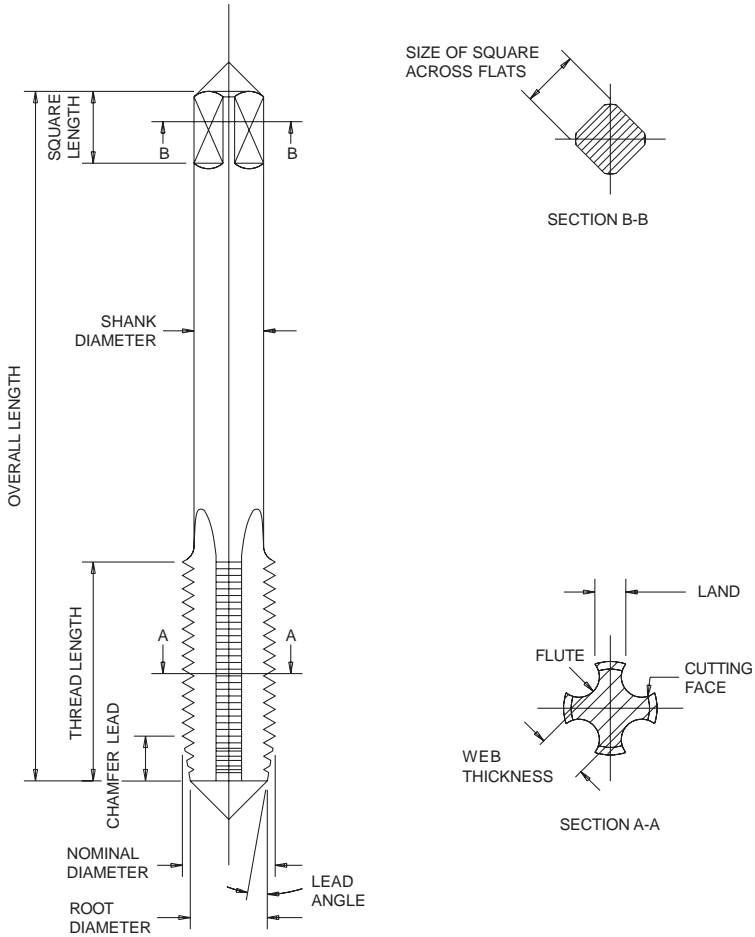
GENERAL



Description of Set	Ref No.	Code
0 - 6 BA	C 7	9750007
THIS SET CONTAINS:		
TAPS	DIES	
TAPER, BOTTOM		
0	0 x 13/16 O/D	
1	1 x 13/16 O/D	
2	2 x 13/16 O/D	
3	3 x 13/16 O/D	
4	4 x 13/16 O/D	
5	5 x 13/16 O/D	
6	6 x 13/16 O/D	
TAP WRENCH TW1		
DIESTOCK DS1		



**THREADING
TOOLS**



GENERAL SPECIFICATIONS

THREAD

METRIC
 METRIC LONG SERIES
 METRIC
 UNC, UNF
 BSW, BSF, BA, BSB
 BSP, BSPT
 NPS, NPT

GENERAL SPECIFICATIONS

ISO 529
 ISO 2283
 DIN 371 / DIN 374 / DIN 376
 ISO 529
 ISO 529
 ISO 2284
 ANSI 94.9 1979

THREADS GROUND TO

ISO 2857 - 1973, CLASS 2
 ISO 2857 - 1973 CLASS 2
 DIN 802 CLASS 6H
 ANSI B1.1 1982 2B
 BS 949: 1976 CLASS 2
 BS 949: 1976 1976-G SERIES
 ANSI 94.9 1979



TAP THREAD TOLERANCE

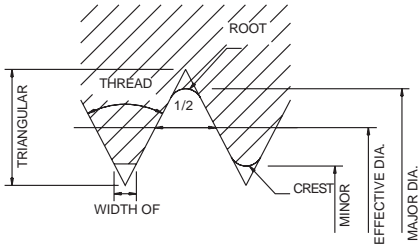
Basic sizes and tolerance classes

To allow for clearance between mating internal and external threads, taps are manufactured with oversize allowances added to the basic diameters.

These basic diameters plus the oversize allowances establish:

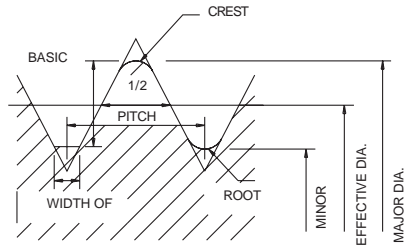
a) the minimum effective diameter; and

NUT



b) the minimum major diameter.

BOLT



Limits of Tolerance

Effective Diameter - The tolerance is the amount of variation allowed in the manufacture of the tap. This tolerance is added to the minimum effective diameter to establish the maximum effective diameter.

It follows that:

Basic Effective + Oversize = Minimum Effective

Basic Effective + Oversize + tolerance = Maximum Effective.

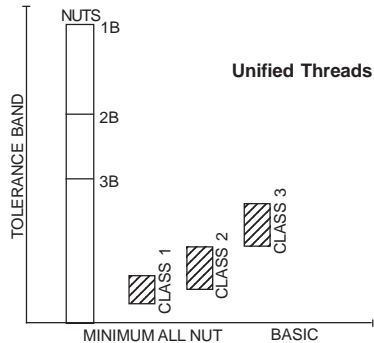
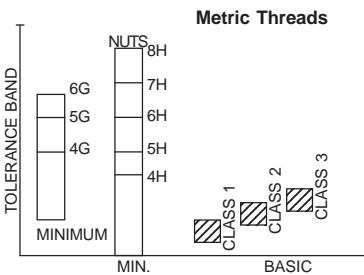
The effective diameter can only be measured with special tap measuring equipment.

Major Diameter - The minimum major diameter is established by adding the oversize allowance to the basic major diameter (the nominal thread size). Therefore, on measurement, the major diameter of the tap is larger than the nominal thread size, and must not be used to judge the size of the tap.

The maximum major diameter of the tap is governed by the thread form and is therefore not subject to a tolerance.

Tap Tolerance Classes

Relationships of Tap Classes to Nut Tolerances.



Class 1 Tap

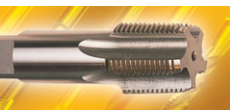
This is the closest to basic, having little oversize allowance, and is normally specified for "close" fit threads, eg. Unified 3B, Metric 4H, 5H.

Class 2 Tap

This is normally specified for "medium" fit threads, eg. Unified 2B, Metric 6H, 4G, 5G.

Class 3 Tap

This is furthestmost above basic size and used for "free" fit threads, eg. Unified 1B, Metric 7H, 8H, 6G.



TAP THREAD TOLERANCE

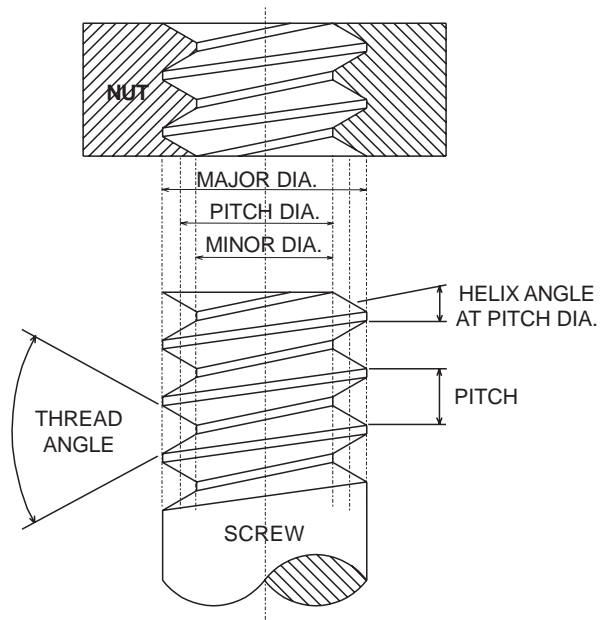
Under favourable working conditions, the following thread tolerances should be produced by the new class taps.

	Class 1	Class 2	Class 3
Metric	4H, 5H	6H, 4G, 5G	7H, 8H, 6G
Unified	3B	2B	1B
Whitworth Form	Close Class	Medium Class	Free Class
BA	Close Class	Medium Class	Free Class

All Somta HSS taps are supplied to Class 2, 6H unless otherwise specified.

BASIC THREAD FORMS

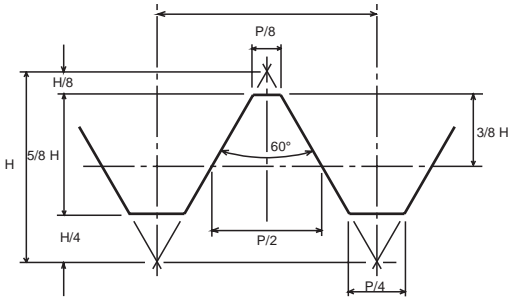
COMPONENT ELEMENTS



BASIC THREAD FORMS

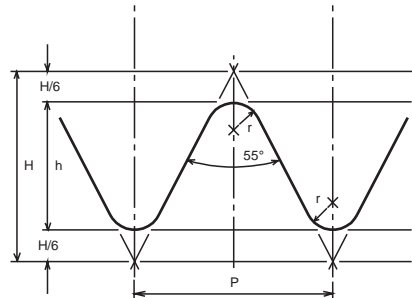
BASIC FORM OF ISO METRIC AND UNIFIED THREAD FORMS

$$\begin{aligned} H &= 0.86603 \times P \\ H/4 &= 0.21651 \times P \\ H/8 &= 0.10825 \times P \\ 3/8 H &= 0.32476 \times P \\ 5/8 H &= 0.54127 \times P \end{aligned}$$



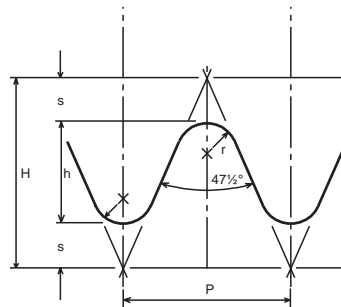
BASIC FORM OF WHITWORTH THREAD

$$\begin{aligned} H &= 0.96049 \times P \\ h &= 2/3 H = 0.64033 \times P \\ H/6 &= 0.16008 \times P \\ r &= 0.13733 \times P \end{aligned}$$



BASIC FORM OF BA THREAD

$$\begin{aligned} H &= 1.13630 \times P \\ h &= 0.60000 \times P \\ r &= 0.18083 \times P \\ s &= 0.26817 \times P \end{aligned}$$



MAIN TYPES OF TAPS

HAND TAPS (SHORT MACHINE)

This regular type is the basic tap designed as a general purpose tool for hand and machine operation.

As this basic tap will give acceptable performance in most materials and for short production runs, it is usually the most economical tap to use. However, it performs best in materials where the cutting action results in chips which break up readily and do not present problems of chip disposal.

The regular hand tap has four flutes in sizes larger than 1/4 inch diameter. These taps may not be suitable because of inadequate chip space when deep or blind holes have to be tapped in soft stringy materials. This applies particularly to the coarser pitch threads such as BSW and UNC.

If a gun tap or spiral fluted tap cannot be used, a three fluted tap which permits extra chip space, is recommended.

PIPE TAPS

Pipe taps are supplied with PARALLEL threads or with TAPER threads.

These taps are shorter than a similar size of regular hand tap, but the design features are the same. They are suitable for hand or machine use.

GUN NOSE TAPS. (SPIRAL POINT) FOR MACHINE USE ONLY

Gun nose taps have straight flutes supplemented by angular cutting faces at the point. These faces cut with a shearing action which propels the chips ahead of the tap leaving the flutes clear for the free flow of coolant to the point.

Primarily designed for use in through holes, these taps can be used in blind holes providing that there is ample clearance beyond the threaded section to accommodate the chips. The advantages of a gun nose tap are, the shearing action of the angular cutting faces which produce a fine finish on the threads and, shallower flutes which permit a stronger cross section throughout the tap.

SPIRAL FLUTE TAPS. FOR MACHINE USE ONLY

These taps are designed primarily for machine tapping of blind holes, are used to the best advantage in materials which produce long stringy chips. The shearing action provided by the spiral flutes produces a better finish on difficult to machine metals and causes the chips to be drawn back, eliminating clogging at the cutting chamfer.

SERIAL TAPS

Serial taps comprise of one or more undersized roughing taps which remove most of the material before final sizing with a finishing tap.

Some reasons for using serial taps are:

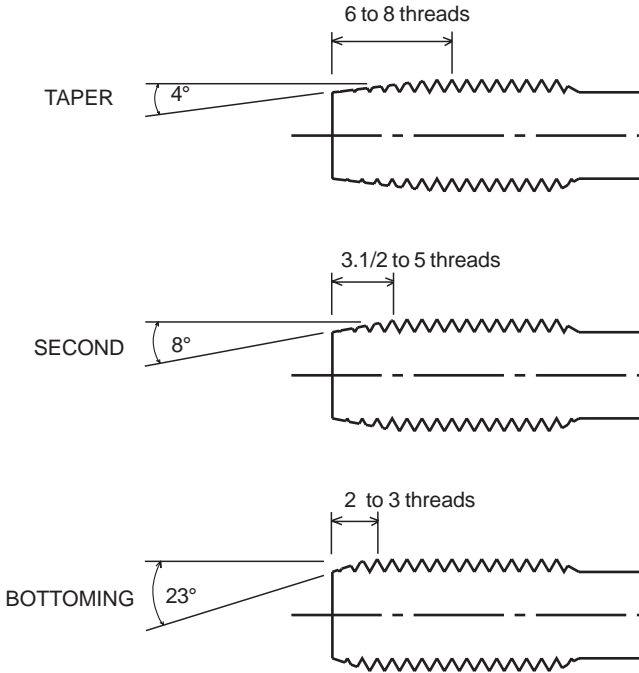
- (a) The toughness of the material being tapped.
- (b) The amount of material to be removed could cause swarf choking with a single tap.
- (c) The very small tolerance on pitch diameter.
- (d) An extremely good finish required.

FLUTELESS (ROLL) TAPS (Fluteless Chipless Tapping)

These taps are designed for machine tapping in ductile materials, "Fluteless" taps have no flutes or cutting faces, but have special roll forming lobes with circular lands and have long or short taper leads for through or blind holes.



STANDARD LEAD (CHAMFER ANGLES)



In some countries the name "PLUG" is commonly used to indicate a Bottoming tap.

In America it is used to indicate a Second tap. To avoid confusion with American terms, the terminology adopted by British Standard 949 1979 as shown above, should be used.

Short Hand and Machine, Long Shank Machine and Pipe Taps	4°	(6-8 threads) Taper
	8°	(3.1/2-5 threads) Second
	23°	(2-3 threads) Bottoming
Spiral Point Taps	8°	(4-5 threads)
Spiral Flute Taps	23°	(2-3 threads)
Fluteless Taps	23°	(2-3 threads)





General Terms and Conditions of Sale

All deliveries of goods will be made in terms of our General Terms and Conditions of Sale, which are available in detail, on request.

No modifications or allowances will be accepted unless agreed to in writing by the Company.

Delivery Terms

All deliveries inside the Republic of South Africa will be free of charge. The Company however reserves the right to charge a fee for special deliveries of small quantities.

For all deliveries outside the Republic of South Africa, the cost of delivery will be for the customer's account unless otherwise agreed to in writing by the Company.

Terms of Payment

All payments will be made in accordance with our General Terms and Conditions of Sale, and other terms agreed to in writing by the Company.

Special Tooling

Our delivery programme is based mainly on the standard tooling in this catalogue.

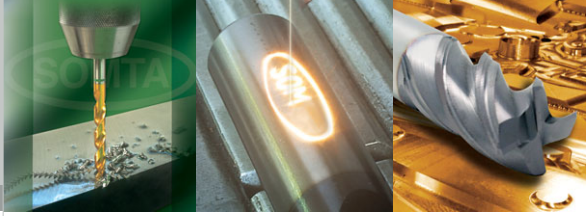
Special tooling can be provided on request, based on other international standards or customer's specifications and drawings.

Deliveries of such tooling will be subject to a quantity variation of +/- 10% of the order quantity, with a minimum quantity variation of one piece.

Request for tooling to customer specification will only be put into production against a signed copy of the customer's drawings and specifications, or a copy of our customer approval drawing.

No special tooling orders can be cancelled or returned.

Note : All terms and conditions may be changed at the discretion of the Company.



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