



# Threading Solutions 2026



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## Complete Threading Range

Solutions for all materials and applications

## Improve Thread Consistency

Improve consistency & reduce thread issues with application focused solutions

## Expert Tool Selection Support

Technical guidance on tool selection for maximum productivity



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# The tooling partner precision engineers trust

Across the UK and Ireland, we help precision engineers choose the right tooling, solve machining challenges and improve productivity with reliable, repeatable results.

★★★★★ Excellent 2,500+ Reviews

**13,000+**  
Customers supported

**40,000+**  
Tools in UK stock

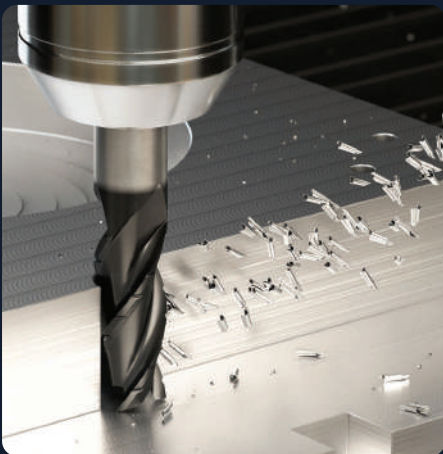
**99.8%**  
Dispatch accuracy

**150,000+**  
Annual orders

Our approach

## Built to improve your machining performance

In addition to supplying precision tooling, we provide the advice, stock availability and technical services needed to keep your machining operation moving.



### 40,000+ tools in UK stock

From cutting tools to metrology, we keep workshops supplied with over 40,000 products ready for next-day delivery, helping reduce delays and keep production moving.



### Expert technical support

Application-led guidance from machining specialists who understand your challenges, helping you choose the right tooling based on your material, machine, operation and performance goals.



### Machine shop services

Reconditioning, calibration, servicing, cutting fluid support, carbide recycling and custom tooling solutions designed to help you improve performance and get more from your processes.

## Thread Mills

High performance solid carbide thread mills for internal and external CNC threading.

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## Machine Taps

Designed for CNC internal threading with accuracy, repeatability and performance.

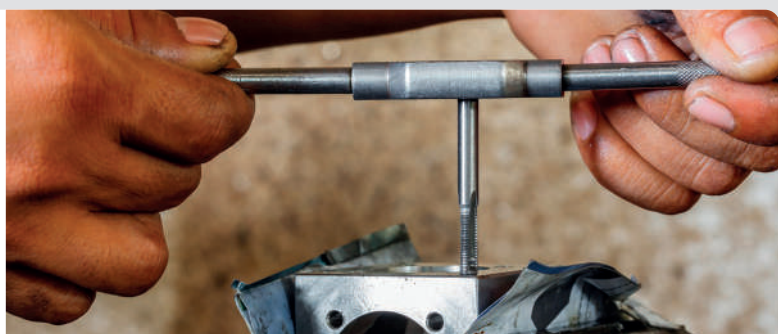
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## Hand Taps

Reliable, clean thread cutting for workshop, maintenance and engineering applications.

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## Dies

Reliable cutting, restoring and maintaining external threads on metal components.

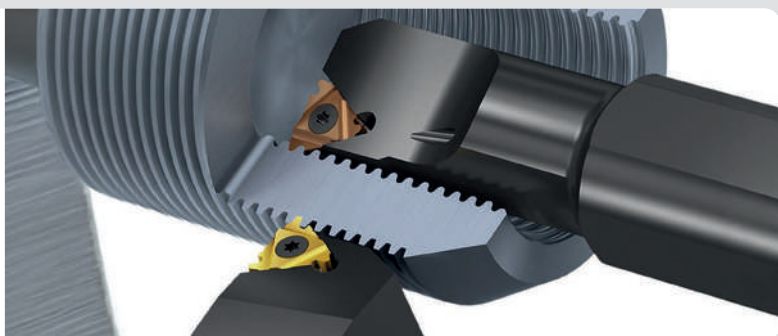
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## Thread Turning

Single point threading holders and inserts for all thread forms and sizes.

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## Thread Gauges

Accurate identification and inspection of metric and imperial screw threads.

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# Thread Mills

VARDEX cutwel **PRO**











**Solid carbide thread mills for internal and external CNC threading.**

A highly versatile alternative to tapping, thread mills offer lower cutting forces, reduced risk of tool breakage and the ability to produce multiple thread sizes with a single tool.

It is ideal for difficult materials, larger threads and high value components where thread quality and reliability are critical.

Our range includes cost effective Cutwel Pro thread mills for everyday machining, alongside premium Vardex solutions from Vargus for high-performance applications.

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## At the heart of the Vargus portfolio is Vardex, one of the most recognised names in threading.

### Tooling Solutions

- Thread turning, milling, tapping & whirling solutions
- Indexable and solid carbide systems
- Tooling for aerospace, oil & gas, medical and general machining
- High productivity systems (MACH range for faster cycle times)

### Vargus Services

- VARGUS GENius™ software for tool selection, cutting data and CNC program generation
- Technical support and application engineering expertise
- Custom tooling solutions tailored to specific applications and industries
- ISO certified production ensuring consistent quality and repeatability

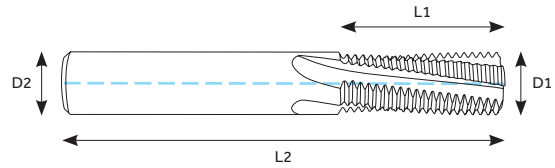
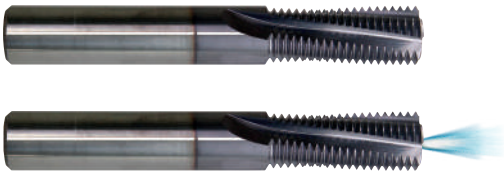
### We partner with Vargus to help the customer achieve:

- Higher productivity through optimised cutting strategies
- Reduced cycle times and tooling costs
- Confidence in repeatable, high precision results

cutwel **PRO****METRIC (DIN 13) THREAD MILLS - HELICAL FLUTES**

Cost Effective Solution For Everyday Thread Milling Operations

- TNF coated carbide thread mills for steel <HRC45, stainless steel & aluminium
- Suitable for right and left hand threads
- Available in internal and external



Thread	Pitch mm	D1	D2	L1	L2	No. of Flutes	Order Code			
							Solid (Standard)	Price	Through Coolant	Price
<b>Internal</b>										
M4	0.7	3.1	6	8	54	3	CTM-METHF03T	£69.31	CTM-METHF03TCF	£86.13
M5	0.8	4	6	12	54	3	CTM-METHF00T	£69.31	CTM-METHF00TCF	£152.90
MF6	0.5	4.5	6	12	54	3	CTM-METHF27T	£96.20	CTM-METHF27TCF	£139.53
MF6	0.75	4.5	6	12	54	3	CTM-METHF01T	£69.31	CTM-METHF01TCF	£86.13
M6, M7	1	4.5	6	12	54	3	CTM-METHF02T	£69.31	CTM-METHF02TCF	£152.90
MF8	0.5	6	6	12	54	3	CTM-METHF07T	£96.20	CTM-METHF07TCF	£139.53
MF8	0.75	6	6	15	54	3	CTM-METHF04T	£103.36	CTM-METHF04TCF	£103.36
MF8	1	6	6	15	54	3	CTM-METHF05T	£83.16	CTM-METHF05TCF	£103.36
M8, M9	1.25	6	6	15	54	3	CTM-METHF06T	£83.16	CTM-METHF06TCF	£178.40
MF10	0.5	8	8	20	65	3	CTM-METHF13T	£157.29	CTM-METHF13TCF	£162.77
MF10	0.75	8	8	20	65	3	CTM-METHF08T	£120.58	CTM-METHF08TCF	£120.58
MF10	1	8	8	20	65	3	CTM-METHF09T	£135.92	CTM-METHF09TCF	£120.58
MF10, MF12	1.25	8	8	20	65	3	CTM-METHF10T	£135.92	CTM-METHF10TCF	£120.58
M10, M11, MF12	1.5	8	8	20	65	3	CTM-METHF11T	£96.99	CTM-METHF11TCF	£203.87
M12	1.75	8	8	20	65	3	CTM-METHF12T	£96.99	CTM-METHF12TCF	£203.87
MF12	0.5	10	10	25	80	4	CTM-METHF18T	£204.71	CTM-METHF18TCF	£204.71
MF12	1	10	10	25	80	4	CTM-METHF14T	£122.00	CTM-METHF14TCF	£151.63
MF14	1.25	10	10	25	80	4	CTM-METHF15T	£151.63	CTM-METHF15TCF	£151.63
MF14	1.5	10	10	25	80	4	CTM-METHF16T	£151.63	CTM-METHF16TCF	£151.63
M14	2	10	10	25	80	4	CTM-METHF17T	£122.00	CTM-METHF17TCF	£254.83
MF14	0.5	12	12	30	82	4	CTM-METHF22T	£255.81	CTM-METHF22TCF	£255.81
MF14	1	12	12	30	82	4	CTM-METHF19T	£189.49	CTM-METHF19TCF	£189.49
MF16	1.5	12	12	30	82	4	CTM-METHF20T	£152.42	CTM-METHF20TCF	£189.49
M16	2	12	12	30	82	4	CTM-METHF21T	£152.42	CTM-METHF21TCF	£305.80
MF16	1	14	14	35	100	4	CTM-METHF23T	£223.95	CTM-METHF23TCF	£223.95
MF18	1.5	14	14	35	100	4	CTM-METHF24T	£252.45	CTM-METHF24TCF	£223.95
MF18	2	14	14	35	100	4	CTM-METHF25T	£223.95	CTM-METHF25TCF	£223.95
M18	2.5	14	14	35	100	4	CTM-METHF26T	£180.15	CTM-METHF26TCF	£223.95
MF18, MF20	1	16	16	40	100	5	CTM-METHF28T	£258.39	CTM-METHF28TCF	£258.39
MF20, MF22	1.5	16	16	40	100	5	CTM-METHF29T	£258.39	CTM-METHF29TCF	£258.39
MF20, MF22	2	16	16	40	100	5	CTM-METHF30T	£207.87	CTM-METHF30TCF	£258.39
M20, M22	2.5	16	16	40	100	5	CTM-METHF31T	£207.87	CTM-METHF31TCF	£258.39
MF22>	1	20	20	40	110	5	CTM-METHF33T	£334.22	CTM-METHF33TCF	£334.22
MF24>	1.5	20	20	40	110	5	CTM-METHF34T	£334.22	CTM-METHF34TCF	£334.22
MF24>	2	20	20	40	110	5	CTM-METHF35T	£334.22	CTM-METHF35TCF	£334.22
M24	3	20	20	40	110	5	CTM-METHF36T	£268.86	CTM-METHF36TCF	£334.22
M30	2.5	25	25	78	155	5	CTM-METHF40T	£504.50	CTM-METHF40TCF	£504.50
M36, M42	4	25	25	78	155	5	CTM-METHF38T	£504.50	CTM-METHF38TCF	£504.50
<b>External 2xD Max Depth</b>										
M6x1.0	1	8	64	20	8	3	CTM-METHFEX17T	£239.48	-	-
M8x1.25	1.25	10	79	25	10	4	CTM-METHFEX19T	£302.88	-	-
M10x1.5	1.5	12	81	30	12	4	CTM-METHFEX21T	£378.44	-	-
M12x1.75	1.75	14	99	35	14	4	CTM-METHFEX23T	£447.25	-	-
M14x2.0	2	16	99	40	16	5	CTM-METHFEX25T	£516.05	-	-
M20-M22x2.5	2.5	18	109	40	18	5	CTM-METHFEX27T	£591.88	-	-
M24x3.0	3	20	109	40	20	5	CTM-METHFEX29T	£667.48	-	-

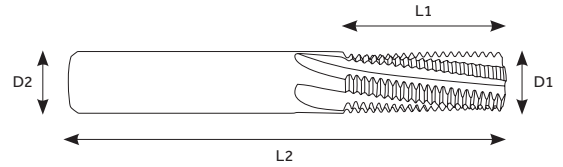
**VARDEX**

**Buy 3 Get 1 Free on all Vardex Thread Mills**  
Valid until 31/12/2026

## METRIC (DIN 13) THREAD MILLS - HELICAL FLUTES

Premium Vardex Thread Mills For High Performance Applications

- TiAIN coated carbide thread mills
- Suitable for internal right and left hand threads
- Available in solid or axial through coolant (for blind holes)
- Thread milling of steel, stainless steel, HRSA's, aluminium & cast iron up to HRC45



Thread	Pitch mm	D1	D2	L1	L2	No. of Flutes	Order Code	Price
<b>Internal 2xD Max Depth (Solid)</b>								
M3, MF3.5	0.5	2.2	4	6	45	3	101-00027	£141.06
MF4	0.5	3	4	8	45	3	101-00028	£141.06
MF5>	0.5	3.9	4	10	45	3	101-00029	£141.06
M4	0.7	2.8	4	8.4	45	3	101-00025	£141.06
MF6	0.75	3.9	4	12	45	3	101-00026	£141.06
M5	0.8	3.5	4	10.4	45	3	101-00006	£141.06
M6	1	3.9	4	12	45	3	101-00009	£141.06
MF8	1	5.9	6	16	57	3	101-00012	£168.29
MF10	1	7.9	8	20	63	3	101-00015	£196.05
MF12>	1	9.9	10	24	73	4	101-00010	£205.96
MF8	1.25	5.8	6	16.25	57	3	101-00016	£168.29
M10	1.25	7.7	8	20	63	3	101-00018	£196.05
M10>	1.5	7.7	8	21	63	3	101-00008	£196.05
MF12	1.5	9.4	10	24	73	4	101-00011	£205.96
MF14	1.5	11.2	12	28.5	83	4	101-00013	£280.16
MF16>	1.5	11.9	12	33	83	4	101-00014	£280.16
M12	1.75	8.7	10	24.5	73	4	101-00019	£205.96
M14	2	9.9	10	28	73	4	101-00021	£205.96
M16, MF17>	2	11.9	12	32	83	4	101-00022	£280.16
M18	2.5	13.9	16	40	92	5	101-00024	£389.29
M24	3	15.9	16	42	92	4	101-00023	£389.29
<b>Internal 2xD Max Depth (Axial Coolant)</b>								
M3, MF3.5	0.5	2.4	4	6.2	45	3	104-00001	£172.36
MF4	0.5	3.2	4	8.2	45	3	104-00003	£172.36
MF5>	0.5	4.2	6	10.2	57	3	104-00005	£198.00
M4	0.7	3.15	4	8.7	45	3	104-00006	£172.36
MF6	0.75	5	6	12.4	57	3	104-00008	£198.00
M5	0.8	3.9	4	10.8	45	3	104-00010	£172.36
M6	1	4.8	6	12.5	57	3	104-00012	£198.00
MF8	1	6.7	8	16.5	61	3	104-00016	£230.70
MF10	1	8.7	10	20.5	73	3	104-00018	£242.38
MF12>	1	10.7	12	24.5	73	4	104-00020	£329.72
M8	1.25	6.5	8	16.9	61	3	104-00022	£230.70
MF10	1.25	8.5	10	20.6	73	3	104-00024	£242.38
M10	1.5	8.2	10	20.2	73	3	104-00026	£242.38
MF12	1.5	9.9	10	24.7	73	4	104-00030	£242.38
MF14	1.5	11.9	12	29.2	80	4	104-00032	£329.72
MF16>	1.5	13.9	14	32.2	92	4	104-00034	£376.37
M12	1.75	9.9	10	25.4	73	4	104-00036	£242.38
M14	2	11.6	12	29	80	4	104-00038	£329.72
M16, MF17>	2	13.6	14	33	92	4	104-00041	£376.37
M18	2.5	14.8	16	36.2	92	4	104-00045	£458.09
M20	2.5	17.1	18	41.2	102	4	104-00047	£500.08
M24	3	19.9	20	49.5	102	4	104-00055	£500.08

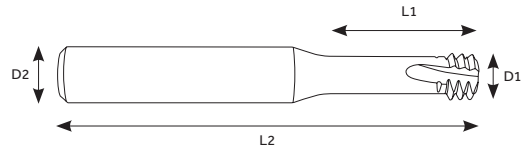
METRIC THREAD MILLS



## METRIC (DIN 13) THREAD MILLS - MINIATURE TYPE

Cost Effective Solution For Everyday Thread Milling Operations

- TNF coated carbide thread mills for steel <HRC45, stainless steel & aluminium
- TX coated carbide thread mills for hardened steels HRC40-60
- Suitable for right and left hand internal threads
- 3-tooth design for faster cycle times, improved stability and higher productivity in miniature threading applications



Thread	Pitch mm	D1	D2	L1	L2	No. of Flutes		Solid (Standard)	Price	Hardened Steel	Price
						Standard	Hardened Steel				
<b>Internal 2xD Max Depth</b>											
M1.2	0.25	0.9	3	3	39	3	4	CTM-MET3T01T	£107.90	-	-
M1.6	0.35	1.2	3	4.5	39	3	4	CTM-MET3T04T	£107.90	-	-
M2	0.4	1.55	3	4.5	39	3	4	CTM-MET3T03T	£107.90	CTM-MET3T03HS	£143.59
M2.5	0.45	1.65	6	5	54	3	4	CTM-MET3T05T	£107.90	-	-
M3	0.5	2.35	6	6.5	54	3	4	CTM-MET3T09T	£107.90	CTM-MET3T09HS	£143.59
M4	0.7	3.1	6	9	54	3	4	CTM-MET3T13T	£110.08	CTM-MET3T13HS	£143.59
M5	0.8	3.8	6	12.5	54	3	4	CTM-MET3T15T	£110.08	CTM-MET3T15HS	£143.59
M6, MF8	1	4.65	6	14	54	3	4	CTM-MET3T17T	£110.08	CTM-MET3T17HS	£143.59
M8	1.25	5.95	6	18	54	3	4	CTM-MET3T19T	£110.08	CTM-MET3T19HS	£143.59
M10, MF12	1.5	7.8	8	23	64	3	4	CTM-MET3T21T	£124.66	CTM-MET3T21HS	£162.63
M12	1.75	9	10	26	73	3	4	CTM-MET3T23T	£151.60	CTM-MET3T23HS	£197.79
M16	2	11.8	12	35	80	4	4	CTM-MET3T25T	£194.05	-	-
M20	2.5	15	16	43	100	5	4	CTM-MET3T27T	£371.94	-	-
<b>Internal 3xD Max Depth</b>											
M1.6	0.35	1.2	3	5	39	3	4	CTM-MET3T31T	£110.08	-	-
M2	0.4	1.55	3	6	39	3	4	CTM-MET3T33T	£110.08	CTM-MET3T33HS	£143.59
M3	0.5	2.35	6	9.5	54	3	4	CTM-MET3T37T	£110.08	CTM-MET3T37HS	£143.59
M3.5	0.6	2.75	6	10	54	3	4	CTM-MET3T38T	£110.08	-	-
M4	0.7	3.1	6	12.5	54	3	4	CTM-MET3T39T	£110.08	CTM-MET3T39HS	£143.59
M4.5	0.75	3.4	6	14	54	3	4	CTM-MET3T40T	£110.08	-	-
M5	0.8	3.8	6	16	54	3	4	CTM-MET3T41T	£110.08	CTM-MET3T43HS	£143.59
M6, MF8	1	4.65	6	20	54	3	4	CTM-MET3T43T	£110.08	CTM-MET3T45HS	£143.59
M8	1.25	5.95	6	24	54	3	4	CTM-MET3T45T	£110.08	CTM-MET3T47HS	£143.59

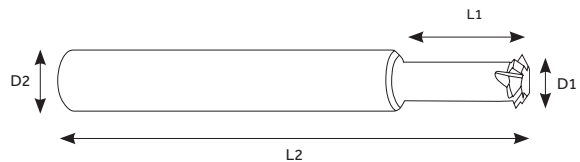
METRIC THREAD MILLS



## METRIC (DIN 13) THREAD MILLS - SINGLE TOOTH LONG REACH

Cost Effective Solution For Everyday Thread Milling Operations

- 1 flute long reach design for deep hole threading (>3xD) and improved access in difficult to reach applications
- TNF coated carbide thread mills
- Suitable for internal right and left hand threads
- Miniature thread milling of steel, stainless steel, HRSA's, aluminium & cast iron up to HRC45



Thread	Pitch mm	D1	D2	L1	L2	No. of Flutes	Order Code	Price
M6, MF8	1	4.1	8	19	63	3	CTM-METLR03T	£111.57
M8	1.25	5.8	10	26	73	3	CTM-METLR05T	£121.88
M10	1.5	7.7	10	32	73	3	CTM-METLR07T	£121.88
MF12	1.5	9.4	12	38	83	4	CTM-METLR09T	£138.90
M12	1.75	8.7	12	38	83	4	CTM-METLR11T	£138.90
M14	2	10.2	16	44	92	4	CTM-METLR13T	£199.74
M16	2	12.2	16	50	100	4	CTM-METLR15T	£199.74
M18	2.5	12.9	16	57	108	5	CTM-METLR17T	£199.74
M20	2.5	14.8	16	63	114	5	CTM-METLR19T	£199.74

VARDEX

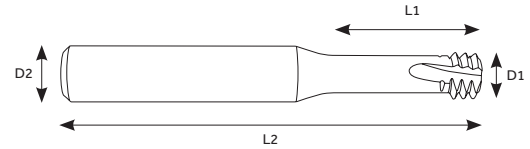
Buy 3 Get 1 Free on all Vardex Thread Mills

Valid until 31/12/2026

## METRIC (DIN 13) THREAD MILLS - MINIATURE 3 TOOTH MILLIPRO

Premium Vardex Thread Mills For High Performance Applications

- TiAlN coated carbide thread mills
- Suitable for internal right and left hand threads
- Miniature design with 3 flutes
- 3-tooth design for faster cycle times, improved stability and higher productivity in miniature threading applications
- Miniature thread milling of steel, stainless steel, HRSA's, aluminium & cast iron up to HRC45



Thread	Pitch mm	D1	D2	L1	L2	Order Code	Price
<b>Internal 2xD Max Depth</b>							
M1.6	0.35	1.2	3	3.4	30	102-80420	£131.30
M2	0.4	1.55	6	4.2	57	102-80254	£131.30
M2.2	0.45	1.65	6	4.6	57	102-80255	£131.30
M2.5	0.45	1.95	6	5.2	57	102-80256	£131.30
M3, MF3.5>	0.5	2.4	6	6.2	57	102-80257	£131.30
M3.5	0.6	2.75	6	7.3	57	102-80258	£131.30
M4	0.7	3.15	6	8.3	57	102-80259	£131.30
M5	0.8	4.05	6	10.4	57	102-80260	£131.30
M6, MF8>	1	4.8	6	12.5	57	102-80261	£131.30
M8	1.25	6.5	8	16.6	63	102-80262	£149.02
M10, MF12>	1.5	8.2	10	20.8	73	102-80418	£163.29
M12	1.75	9.9	10	25	73	102-80419	£163.29
M16	2	11.9	12	33	83	102-00093	£178.01
M20	2.5	15.9	16	41.3	92	102-00073	£214.13
<b>Internal 3xD Max Depth</b>							
M1.6	0.35	1.2	3	5	30	102-80421	£131.30
M2	0.4	1.55	3	6.2	30	102-00100	£131.30
M2	0.4	1.55	6	6.2	57	102-80422	£131.30
M2.5	0.45	1.95	3	7.7	30	102-00094	£131.30
M2.5	0.45	1.95	6	7.7	57	102-80265	£131.30
M3, MF3.5>	0.5	2.4	3	9.2	30	102-00099	£131.30
M3, MF3.5>	0.5	2.4	6	9.2	57	102-80266	£131.30
M4	0.7	3.15	6	12.3	57	102-80267	£131.30
M5	0.8	4.05	6	15.4	57	102-80268	£131.30
M6, MF8>	1	4.8	6	18.5	57	102-80269	£131.30
M8	1.25	6.5	8	24.6	63	102-80270	£149.02

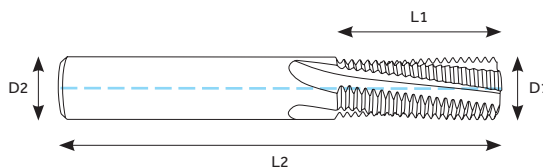
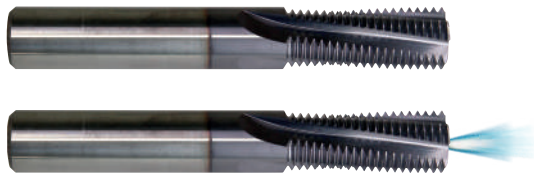
METRIC THREAD MILLS



## UN UNIFIED NATIONAL (ANSI B1.1:74) THREAD MILLS - HELICAL FLUTES

Cost Effective Solution For Everyday Thread Milling Operations

- TNF coated carbide thread mills
- Suitable for right and left hand internal threads
- Through coolant for blind holes, radial coolant for through holes
- Thread milling of steel, stainless steel, HRSA's, aluminium & cast iron up to HRC45



Thread	TPI	D1	D2	L1	L2	No. of Flutes	Order Code			
							Solid	Price	Through Coolant	Price
1/4" UNF	28	4.5	6	12	54	3	CTM-UNHF03T	£73.62	CTM-UNHF03TCF	£86.13
1/4" UNC	20	4.5	6	12	54	3	CTM-UNHF01T	£73.62	CTM-UNHF01TCF	£152.90
5/16" UNF	24	5.5	6	15	54	3	CTM-UNHF09T	£115.95	CTM-UNHF09TCF	£103.36
5/16" UNC	18	5.5	6	15	54	3	CTM-UNHF07T	£88.34	CTM-UNHF07TCF	£178.40
3/8" UNC	16	7.5	8	20	65	3	CTM-UNHF05T	£103.06	CTM-UNHF05TCF	£203.87
3/8" UNF	24	8	8	20	65	3	CTM-UNHF15T	£103.06	CTM-UNHF15TCF	£120.58
7/16" UNF	20	8	8	20	65	3	CTM-UNHF13T	£120.58	CTM-UNHF13TCF	£120.58
7/16" UNC	14	8	8	20	65	3	CTM-UNHF11T	£103.06	CTM-UNHF11TCF	£203.87
1/2" UNF	20	10	10	25	80	4	CTM-UNHF23T	£129.61	CTM-UNHF23TCF	£151.63
9/16" UNF	18	10	10	25	80	4	CTM-UNHF21T	£151.63	CTM-UNHF21TCF	£151.63
1/2" UNC	13	10	10	25	80	4	CTM-UNHF19T	£129.61	CTM-UNHF19TCF	£254.86
9/16" UNC	12	10	10	25	80	4	CTM-UNHF17T	£129.61	CTM-UNHF17TCF	£254.86
5/8" UNF	18	12	12	30	82	4	CTM-UNHF25T	£161.95	CTM-UNHF25TCF	£189.49
5/8" UNC	11	12	12	30	82	4	CTM-UNHF27T	£161.95	CTM-UNHF27TCF	£166.81
3/4" UNF	16	15.5	16	40	100	5	CTM-UNHF29T	£220.83	CTM-UNHF29TCF	£258.39
7/8" UNF	14	15.5	16	40	100	5	CTM-UNHF33T	£258.39	CTM-UNHF33TCF	£258.39
3/4" UNC	10	15.5	16	40	100	5	CTM-UNHF31T	£220.83	CTM-UNHF31TCF	£428.19
7/8" UNF	14	18	18	40	110	5	CTM-UNHF37T	£253.30	CTM-UNHF37TCF	£296.35
7/8" UNC	9	18	18	40	110	5	CTM-UNHF35T	£253.30	CTM-UNHF35TCF	£489.41
1" UNF	12	20	20	40	110	5	CTM-UNHF41T	£285.66	CTM-UNHF41TCF	£334.22
1" UNC	8	20	20	40	110	5	CTM-UNHF39T	£285.66	CTM-UNHF39TCF	£560.82

UN THREAD MILLS

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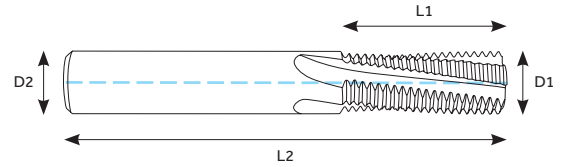
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Valid until 31/12/2026

## UN UNIFIED NATIONAL (ANSI B1.1:74) THREAD MILLS - HELICAL FLUTES

Premium Vardex Thread Mills For High Performance Applications

- TiAlN coated carbide thread mills
- Suitable for internal right and left hand threads
- Available in solid or axial through coolant (for blind holes)
- Thread milling of steel, stainless steel, HRSA's, aluminium & cast iron up to HRC45



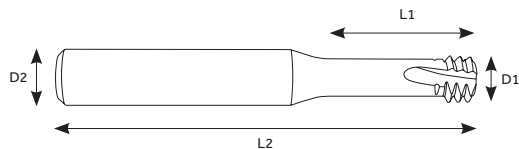
UNC	Thread UNF	Thread UNEF	TPI	D1	D2	L1	L2	No. of Flutes	Order Code	Price
<b>Internal 2xD Max Depth (Solid)</b>										
-	No.8 UNF	-	36	3	4	8.5	45	3	101-00053	£141.06
-	No.10 UNF	No.12-3/8" UNEF	32	3.3	4	11.1	45	3	101-00052	£141.06
-	No.12, 1/4" UNF	7/16", 1/2" UNEF	28	3.8	4	11.8	45	3	101-00050	£141.06
-	1/4" UNF	7/16", 1/2" UNEF	28	4.6	6	12.7	57	3	101-00071	£168.29
-	-	7/16", 1/2" UNEF	28	9.2	10	22.7	73	4	101-00051	£205.96
No.10 UNC	5/16", 3/8" UNF	9/16"-11/16" UNEF	24	2.9	4	10.6	45	3	101-00045	£141.06
No.12	5/16", 3/8" UNF	9/16"-11/16" UNEF	24	3.5	4	11.6	45	3	101-00046	£141.06
-	5/16", 3/8" UNF	9/16"-11/16" UNEF	24	5.7	6	15.9	57	3	101-00047	£168.29
-	3/8" UNF	9/16"-11/16" UNEF	24	7.4	8	19.1	63	3	101-00048	£196.05
-	-	9/16"-11/16" UNEF	24	11.9	12	28.6	83	4	101-00049	£280.16
1/4"x20 UNC	7/16", 1/2" UNF	3/4"-1" UNEF	20	3.9	4	12.7	45	3	101-00070	£141.06
-	7/16", 1/2" UNF	3/4"-1" UNEF	20	8.5	10	22.9	73	4	101-00042	£205.96
-	1/2" UNF	3/4"-1" UNEF	20	9.9	10	25.4	73	4	101-00043	£205.96
-	-	3/4"-1" UNEF	20	15.9	16	38.1	92	5	101-00044	£389.29
5/16" UNC	9/16", 5/8" UNF	11/16"-1 11/16" UNEF	18	5.2	6	16.9	57	3	101-00069	£168.29
-	9/16", 5/8" UNF	11/16"-1 11/16" UNEF	18	11.3	12	29.6	83	4	101-00040	£280.16
-	5/8" UNF	11/16"-1 11/16" UNEF	18	11.9	12	32.5	83	4	101-00041	£280.16
3/8" UNC	3/4" UNF	-	16	6.7	8	19.1	63	3	101-00038	£196.05
-	3/4" UNF	-	16	15.9	16	38.1	92	4	101-00039	£389.29
7/16" UNC	7/8" UNF	-	14	7.6	8	23.6	63	4	101-00036	£196.05
-	7/8" UNF	-	14	18.7	20	44.4	104	4	101-00037	£424.92
1/2" UNC	-	-	13	8.9	10	25.4	73	4	101-00035	£205.96
9/16" UNC	1"-1 1/2" UNF	-	12	10.3	12	29.6	83	4	101-00034	£280.16
-	1"-1 1/2" UNF	-	12	19.9	20	50.8	104	5	101-00017	£424.92
5/8" UNC	-	-	11	11	12	32.3	83	4	101-00033	£280.16
3/4" UNC	-	-	10	13.5	16	38.1	92	5	101-00032	£389.29
7/8" UNC	-	-	9	15.2	16	45.2	92	4	101-00031	£389.29
1" UNC	-	-	8	17	20	50.8	104	4	101-00030	£424.92
<b>Internal 2xD Max Depth (Axial Coolant)</b>										
-	No.10 UNF	No.12-3/8" UNEF	32	3.8	4	9.9	45	3	104-00056	£172.36
-	-	No.12-3/8" UNEF	32	4.4	6	11.5	57	3	104-00057	£198.00
-	No.12, 1/4" UNF	7/16", 1/2" UNEF	28	4.3	6	11.3	57	3	104-00059	£198.00
-	1/4" UNF	7/16", 1/2" UNEF	28	5.15	6	13.1	57	3	104-00279	£198.00
-	UNF	7/16", 1/2" UNEF	28	9.9	10	22.2	73	3	104-00061	£242.38
No.10 UNC	5/16", 3/8" UNF	9/16"-11/16" UNEF	24	3.58	4	10	45	3	104-00062	£172.36
No.12 UNC	5/16", 3/8" UNF	9/16"-11/16" UNEF	24	4.15	6	11.1	57	3	104-00063	£198.00
-	5/16", 3/8" UNF	9/16"-11/16" UNEF	24	6.68	8	16.4	61	3	104-00065	£230.70
-	3/8" UNF	9/16"-11/16" UNEF	24	8.2	10	19.6	73	3	104-00066	£242.38
-	-	9/16"-11/16" UNEF	24	12.9	14	29.1	92	4	104-00067	£376.37
1/4" UNC	7/16", 1/2" UNF	3/4"-1" UNEF	20	4.88	6	13.3	57	3	104-00068	£198.00
-	7/16", 1/2" UNF	3/4"-1" UNEF	20	9.6	10	22.2	73	3	104-00070	£242.38
-	1/2" UNF	3/4"-1" UNEF	20	11.1	12	26	80	4	104-00071	£329.72
-	-	3/4"-1" UNEF	20	17.4	18	38.7	102	4	104-00072	£500.08
5/16" UNC	9/16", 5/8" UNF	11/16"-1, 11/16" UNEF	18	6.15	8	16.2	61	3	104-00074	£230.70
-	9/16", 5/8" UNF	11/16"-1, 11/16" UNEF	18	12.5	14	28.9	92	4	104-00076	£376.37
-	5/8" UNF	11/16"-1, 11/16" UNEF	18	14.1	16	31.7	92	4	104-00078	£458.09
3/8" UNC	3/4" UNF	-	16	7.65	8	19.8	61	3	104-00079	£230.70
-	3/4" UNF	-	16	17	18	38.8	102	4	104-00081	£500.08
7/16" UNC	7/8" UNF	-	14	9	10	22.7	73	3	104-00083	£242.38
-	7/8" UNF	-	14	19.9	20	44.4	102	4	104-00086	£500.08
1/2" UNC	-	-	13	10.35	12	26.4	80	4	104-00087	£329.72
9/16" UNC	1"-1 1/2" UNF	-	12	11.8	12	28.6	80	4	104-00089	£329.72
-	1"-1 1/2" UNF	-	12	19.9	20	51.9	102	4	104-00091	£500.08
5/8" UNC	-	-	11	13.1	14	33.5	92	4	104-00093	£376.37
3/4" UNC	-	-	10	15.9	16	39.4	92	4	104-00094	£458.09
7/8" UNC	-	-	9	19	20	46.6	102	4	104-00095	£500.08
1" UNC	-	-	8	19.9	20	52.4	102	4	104-00096	£500.08

UN THREAD MILLS

cutwel **PRO****UN UNIFIED NATIONAL (ANSI B1.1:74) THREAD MILLS - MINIATURE 3 TOOTH**

Cost Effective Solution For Everyday Thread Milling Operations

- TNF coated carbide thread mills
- Suitable for right and left hand internal threads
- 3-tooth design for faster cycle times, improved stability and higher productivity in miniature threading applications
- Thread milling of steel, stainless steel, HRSA's, aluminium & cast iron up to HRC45



Thread	TPI	D1	D2	L1	L2	No. of Flutes	Order Code	Price
<b>Internal 2xD Max Depth</b>								
No.1 UNF	72	1.45	3	3.7	39	3	CTM-UN3T01T	£120.42
No.1 UNC, No.2 UNF	64	1.4	3	3.8	39		CTM-UN3T03T	£114.67
No.2 UNC, No.3 UNF	56	1.65	6	4.4	54		CTM-UN3T05T	£114.67
No.3 UNC, No.4 UNF	48	1.9	6	5.2	54		CTM-UN3T07T	£114.67
No.4 UNC	40	2.1	6	6.3	54		CTM-UN3T09T	£114.67
No.5 UNC, No.6 UNF	40	2.45	6	7	54		CTM-UN3T11T	£114.67
No.8 UNF	36	3.3	6	9	54		CTM-UN3T13T	£120.42
No.6 UNC	32	2.55	6	7.1	54		CTM-UN3T15T	£114.67
No.8 UNC, No.10 UNF	32	3.2	6	9.5	54		CTM-UN3T17T	£114.67
No.12 UNF, 1/4 UNF	28	4.2	6	11	54		CTM-UN3T21T	£120.42
No.10 UNC, 5/16 UNF	24	3.5	6	10.6	54		CTM-UN3T25T	£116.96
1/4" UNC	20	4.75	6	14	54		CTM-UN3T29T	£116.96
7/16" UNF	20	8	8	25	64		CTM-UN3T31T	£139.08
5/16" UNC	18	6	6	17	54		CTM-UN3T33T	£116.96
3/8" UNC	16	6.7	8	22	64		CTM-UN3T37T	£132.45
7/16" UNC	14	7.7	8	25	64		CTM-UN3T39T	£132.45
<b>Internal 3xD Max Depth</b>								
No.0 UNF	80	1.15	3	4	39	3	CTM-UN3T49T	£122.81
No.1 UNF	72	1.45	3	6	39		CTM-UN3T51T	£122.81
No.2 UNC, No.3 UNF	56	1.65	6	6.6	54		CTM-UN3T53T	£116.96
No.4 UNC, No.6 UNF	40	2.1	6	8	54		CTM-UN3T55T	£116.96
No.5 UNC	40	2.45	6	9.6	54		CTM-UN3T57T	£116.96
No.6 UNC	32	2.55	6	10.5	54		CTM-UN3T59T	£122.81
No.8 UNC	32	3.2	6	12.5	54		CTM-UN3T61T	£116.96
No.10 UNF	32	3.7	6	15	54		CTM-UN3T63T	£122.81
1/4" UNF	28	5	6	19	54		CTM-UN3T65T	£122.81
5/16" UNF	24	6.6	8	24	64		CTM-UN3T67T	£139.08
1/4" UNC, 7/16" UNF	20	4.75	6	19	54		CTM-UN3T69T	£116.96
5/16" UNC	18	6	6	23	54		CTM-UN3T71T	£116.96

VARDEX

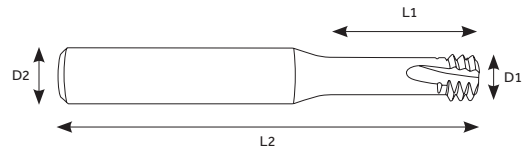
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## UN UNIFIED NATIONAL (ANSI B1.1:74) THREAD MILLS - MINIATURE 3 TOOTH MILLIPRO

Premium Vardex Thread Mills For High Performance Applications

- TiAIN coated carbide thread mills
- Suitable for right and left hand internal threads
- 3-tooth design for faster cycle times, improved stability and higher productivity in miniature threading applications
- Miniature thread milling of steel, stainless steel, HRSA's, aluminium & cast iron up to HRC45



Thread		TPI	D1	D2	L1	L2	No. of Flutes	Order Code	Price	
UNC	UNF									
<b>Internal 2xD Max Depth (Solid)</b>										
-	No.1 UNF	72	1.45	6	3.9	57	3	102-00014	£131.30	
No.1 UNC	No.2 UNF	64	1.4	6	4.2	57		102-00012	£131.30	
No.2 UNC	No.3 UNF	56	1.65	6	5	57		102-00015	£131.30	
No.3 UNC	No.4 UNF	48	1.9	6	6	57		102-00017	£131.30	
No.4, No.5 UNC	No.6 UNF	40	2.1	6	6	57		102-00019	£131.30	
No.5 UNC	No.6 UNF	40	2.45	6	7.2	57		102-00021	£131.30	
-	No.8 UNF	36	3.3	6	8.7	57		102-00023	£131.30	
No.6, No.8 UNC	No.10 UNF	32	2.55	6	7.4	57		102-00024	£131.30	
No.8 UNC	No.10 UNF	32	3.2	6	10	57		102-00025	£131.30	
-	No.10 UNF	32	3.8	6	10.3	57		102-00147	£131.30	
-	1/4" UNF	28	5.25	6	13.2	57		102-00028	£131.30	
-	5/16" UNF	24	6.68	8	16.5	63		102-00042	£149.02	
1/4" UNC	7/16" UNF	20	4.88	6	13.4	57		102-00034	£131.30	
-	7/16" UNF	20	9.55	10	23	73		102-00037	£163.29	
5/16" UNC	-	18	6.15	8	16.9	63		102-00154	£149.02	
3/8" UNC	-	16	6.7	8	19.1	63		102-00070	£149.02	
7/16" UNC	-	14	9	10	23.3	73		102-00038	£163.29	
<b>Internal 3xD Max Depth (Solid)</b>										
-	No.1 UNF	72	1.45	3	5.75	30		3	102-00095	£131.30
-	No.1 UNF	72	1.45	6	5.75	57			102-00039	£131.30
No.2 UNC	No.3 UNF	56	1.65	3	7	30	102-00096		£131.30	
No.4, No.5 UNC	No.6 UNF	40	2.1	3	9	30	102-00097		£131.30	
No.4, No.5 UNC	No.6 UNF	40	2.1	6	9	57	102-00071		£131.30	
No.5 UNC	No.6 UNF	40	2.45	6	10	57	102-00022		£131.30	
No.6 No.8 UNC	No.10 UNF	32	2.55	3	11	30	102-00098		£131.30	
No.6, No.8 UNC	No.10 UNF	32	2.55	6	11	57	102-00072		£131.30	
No.8 UNC	No.10 UNF	32	3.2	6	13	57	102-00027		£131.30	
-	No.10 UNF	32	3.8	6	15.1	57	102-00148		£131.30	
No.12 UNC	1/4" UNF	28	4.4	6	17	57	102-00155		£131.30	
-	1/4" UNF	28	5.25	6	19.6	57	102-00033		£131.30	
-	5/16" UNF	24	6.68	8	24.5	63	102-00044		£149.02	
1/4" UNC	7/16" UNF	20	4.88	6	19.8	57	102-00036		£131.30	
5/16" UNC	-	18	6.15	8	24	63	102-00153		£149.02	

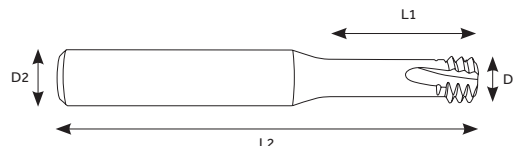
UN THREAD MILLS



## UNJ UNIFIED NATIONAL (MIL-S-8879C) THREAD MILLS - MINIATURE 3 TOOTH

Cost Effective Solution For Everyday Thread Milling Operations

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- Suitable for right and left hand internal threads
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Thread	TPI	D1	D2	L1	L2	No. of Flutes	Order Code	Price
No.6 UNJC, No.10 UNJF	32	2.6	6	7	54	3	CTM-UNJ3T05T	£69.95
No.12 UNJF, 1/4 UNJF	28	4	6	11	54	3	CTM-UNJ3T11T	£69.95
No.10 UNJC, No.12 UNJC, 5/16 UNJF, 3/8 UNJF	24	3	6	9	54	3	CTM-UNJ3T09T	£69.95
1/4 UNJC, 7/16" UNJF, 1/2" UNJF	20	5	6	14.5	54	3	CTM-UNJ3T13T	£69.95
5/16" UNJC, 9/16" UNJF	18	6.4	8	17	64	3	CTM-UNJ3T15T	£79.24
3/8" UNJC, 3/4" UNJF	16	7.7	8	25	64	3	CTM-UNJ3T19T	£79.24
7/16" UNJC, 7/8" UNJF	14	9.2	10	27.5	73	4	CTM-UNJ3T21T	£96.36
1/2" UNJC	13	9.9	10	27.5	73	4	CTM-UNJ3T25T	£96.36

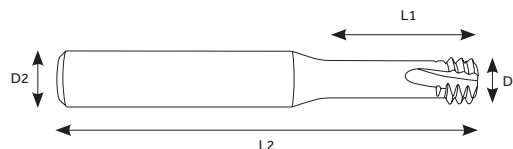
UNJ THREAD MILLS



## UNJ UNIFIED NATIONAL (MIL-S-8879C) THREAD MILLS - MINIATURE 3 TOOTH MILLIPRO

Premium Vardex Thread Mills For High Performance Applications

- TiAlN coated carbide thread mills
- Suitable for right and left hand internal threads
- 3-tooth design for faster cycle times, improved stability and higher productivity in miniature threading applications
- Miniature thread milling of steel, stainless steel, HRSA's, aluminium & cast iron up to HRC45



UNJC	UNJF	TPI	D1	D2	L1	L2	No. of Flutes	Order Code	Price
No.6 UNJC	No.10 UNJF	32	2.7	6	11	57	3	102-00083	£131.30
-	No.12, 1/4 UNJF	28	5.4	6	19.5	57		102-00084	£131.30
No.10 UNJC	-	24	3.7	6	14.9	57		102-00085	£131.30
-	5/16 UNJF	24	6.7	8	24.1	63		102-00086	£149.02
1/4 UNJC	-	20	5	6	19.5	57		102-00087	£131.30
-	7/16" UNJF	20	9.6	10	33.5	73		102-00088	£163.29
5/16" UNJC	9/16" UNJF	18	6.4	8	24.1	63		102-00089	£149.02
3/8" UNJC	3/4" UNJF	16	7.7	8	29	63		102-00090	£149.02
7/16" UNJC	7/8" UNJF	14	9.2	10	33.5	73		102-00091	£163.29
1/2" UNJC	-	13	9.9	10	38.5	73		102-00092	£163.29

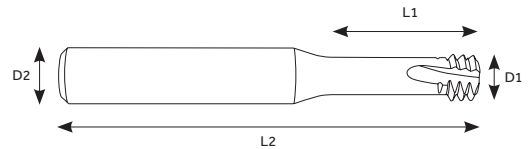
**Buy 3 Get 1 Free on all Vardex Thread Mills**  
Valid until 31/12/2026



## MJ METRIC (DIN ISO 5855) THREAD MILLS - MINIATURE 3 TOOTH

Cost Effective Solution For Everyday Thread Milling Operations

- TNF coated carbide thread mills
- Suitable for right and left hand thread
- Suitable for internal threads
- 3-tooth design for faster cycle times, improved stability and higher productivity in miniature threading applications
- Miniature thread milling of steel, stainless steel, HRSA's, aluminium & cast iron up to HRC45



Thread	Pitch mm	D1	D2	L1	L2	No. of Flutes	Order Code	Price
MJ 3	0.5	2.35	6	6.5	54	3	CTM-MJ3T01T	£153.89
MJ 4	0.7	3.1	6	9	54	3	CTM-MJ3T05T	£153.89
MJ 5	0.8	3.8	6	12.5	54	3	CTM-MJ3T07T	£153.89
MJ 6	1	4.65	6	14	54	3	CTM-MJ3T09T	£153.89
MJ 8	1.25	5.95	6	18	54	3	CTM-MJ3T11T	£153.89
MJ 10	1.5	7.8	8	23	64	3	CTM-MJ3T13T	£174.32
MJ 12	1.75	9	10	26	73	3	CTM-MJ3T15T	£211.99
MJ 14	2	10.4	12	35	80	4	CTM-MJ3T17T	£271.38
MJ 16	2	11.8	12	35	80	4	CTM-MJ3T19T	£271.38

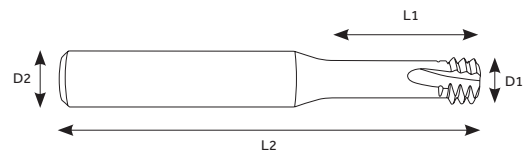


## MJ METRIC (DIN ISO 5855) THREAD MILLS - MINIATURE 3 TOOTH MILLIPRO

Premium Vardex Thread Mills For High Performance Applications

- TiAlN coated carbide thread mills
- Suitable for internal right and left hand threads
- 3-tooth design for faster cycle times, improved stability and higher productivity in miniature threading applications
- Miniature thread milling of steel, stainless steel, HRSA's, aluminium & cast iron up to HRC45

**Buy 3 Get 1 Free on all Vardex Thread Mills**  
Valid until 31/12/2026



Thread MJ	Pitch mm	D1	D2	L1	L2	No. of Flutes	Order Code	Price
MJ 3	0.5	2.4	6	9.2	57	3	102-00074	£131.30
MJ 3.5	0.6	2.85	6	11	57	3	102-00075	£131.30
MJ 4	0.7	3.15	6	12.3	57	3	102-00076	£131.30
MJ 5	0.8	4.05	6	15.4	57	3	102-00077	£131.30
MJ 6	1	4.8	6	18.5	57	3	102-00078	£131.30
MJ 8	1.25	6.5	8	24.6	63	3	102-00079	£149.02
MJ 10	1.5	8.2	10	30.8	73	3	102-00080	£163.29
MJ 12	1.75	9.9	10	37	73	4	102-00081	£163.29
MJ 14	2	11.9	12	42.5	83	4	102-00082	£178.01



## BSP (G) BRITISH STANDARD GAS (B.S.2779:1956) THREAD MILLS - HELICAL FLUTES

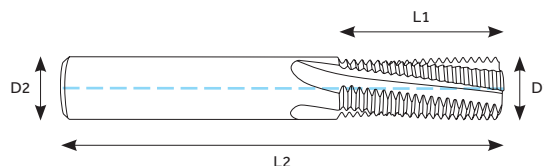
Cost Effective Solution For Everyday Thread Milling Operations

- TNF coated carbide thread mills
- Suitable for right and left hand threads
- Suitable for internal and external threads
- Optional through coolant available
- Thread milling of steel, stainless steel, HRSA's, aluminium & cast iron up to HRC45

Solid



Through Coolant



Thread	Pitch TPI	D1	D2	L1	L2	No. of Flutes	Order Code			
							Standard	Price	Through Coolant	Price
1/8" BSP	28	8	8	20	65	3	CTM-BSPHF01T	£90.95	CTM-BSPHF01TCF	£160.18
1/4" BSP	19	10	10	25	80	4	CTM-BSPHF03T	£114.37	CTM-BSPHF03TCF	£200.26
3/8" BSP	19	14	14	14	35	4	CTM-BSPHF05T	£168.89	CTM-BSPHF05TCF	£157.27
1/2" BSP	14	16	16	16	40	5	CTM-BSPHF07T	£194.86	CTM-BSPHF07TCF	£336.44
5/8" BSP	14	20	20	20	40	5	CTM-BSPHF09T	£252.07	CTM-BSPHF09TCF	£440.63
1" BSP	11	20	20	20	40	5	CTM-BSPHF11T	£252.07	CTM-BSPHF11TCF	£367.21

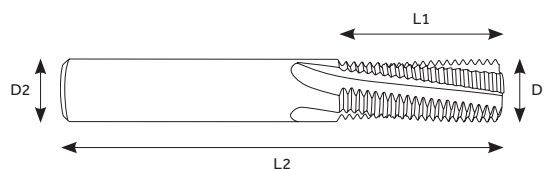


## BSP (G) BRITISH STANDARD GAS (B.S.2779:1956) THREAD MILLS HELICAL FLUTES

Premium Vardex Thread Mills For High Performance Applications

- TiAlN coated carbide thread mills
- Suitable for internal right and left hand threads
- Thread milling of steel, stainless steel, HRSA's, aluminium & cast iron up to HRC45

**Buy 3 Get 1 Free on all Vardex Thread Mills**  
Valid until 31/12/2026



Thread BSP(G)	TPI	D1	D2	L1	L2	No. of Flutes	Order Code	Price
1/16", 1/8" BSP	28	5.8	6	16.3	57	3	101-00054	£168.29
1/8" BSP	28	7.7	8	20	63	3	101-00055	£196.05
1/4", 3/8" BSP	19	9.9	10	26.7	73	4	101-00056	£205.96
3/8" BSP	19	13.4	16	33.4	92	4	101-00057	£389.29
1/2", 3/4" BSP	14	15.7	16	43.5	92	5	101-00058	£389.29
1", 1 1/2", 2", 2 1/2" BSP	11	19.9	20	41.6	104	5	101-00020	£424.92

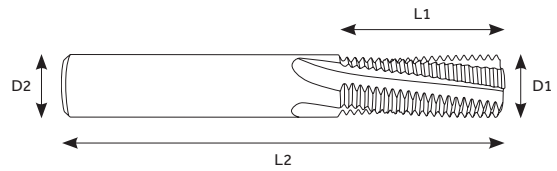
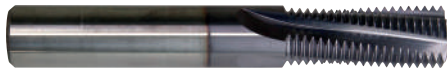
BSP(G) THREAD MILLS



### BSW/BSF WHITWORTH (B.S.84 1956, DIN 259) THREAD MILLS - HELICAL FLUTES

Cost Effective Solution For Everyday Thread Milling Operations

- TNF coated carbide thread mills
- Suitable for right and left hand threads internal & external threads
- Thread milling of steel, stainless steel, HRSA's, aluminium & cast iron up to HRC45



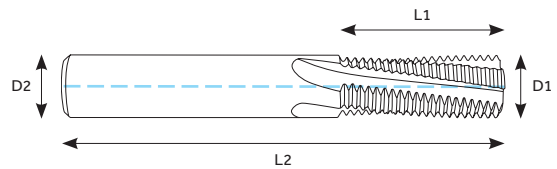
Thread	TPI	D1	D2	L1	L2	No. of Flutes	Order Code	Price
1/4" BSF	26	5	6	13.2	57	3	CTM-BSWHF01T	£107.64
5/16" BSF	26	6.35	8	16.2	61	3	CTM-BSWHF03T	£125.55
1/4" BSW, 3/8" BSF	20	4.45	6	13.3	57	3	CTM-BSWHF05T	£107.64
5/16" BSW, 7/16" BSF	18	5.85	6	16.2	57	3	CTM-BSWHF09T	£107.64
3/8" BSW, 1/2" BSF, 9/16" BSF	16	7.2	8	61	19.8	3	CTM-BSWHF13T	£125.55
7/16" BSW, 5/8" BSF, 11/16" BSF	14	8.5	10	73	22.7	3	CTM-BSWHF19T	£157.88
1/2" BSW	12	9.65	10	73	26.5	3	CTM-BSWHF25T	£157.88
9/16" BSW, 3/4" BSF	12	11.25	12	80	28.6	4	CTM-BSWHF27T	£197.29
5/8" BSW, 11/16" BSW, 7/8" BSF	11	12.6	14	92	33.5	4	CTM-BSWHF31T	£209.67



### BSW/BSF WHITWORTH (B.S.84 1956, DIN 259) THREAD MILLS HELICAL FLUTES

Premium Vardex Thread Mills For High Performance Applications

- TiAlN coated carbide thread mills
- Suitable for internal right and left hand threads
- Axial coolant for blind holes
- Thread milling of steel, stainless steel, HRSA's, aluminium & cast iron up to HRC45



**Buy 3 Get 1 Free on all Vardex Thread Mills**  
Valid until 31/12/2026

Thread	TPI	D1	D2	L1	L2	No. of Flutes	Order Code	Price
BSW - 1/4"x26 BSF	26	5	6	13.2	57	3	104-00097	£198.00
BSW - 5/16"x22 BSF	22	6.35	8	16.7	61	3	104-00098	£230.70
BSW 1/4"x20 BSF	20	4.45	6	13.3	57	3	104-00099	£198.00
BSW - 3/8"x20 BSF	20	7.65	8	19.7	61	3	104-00100	£230.70
BSW 5/16"x18 BSF	18	5.85	6	16.2	57	3	104-00101	£198.00
BSW - 7/16"x18	18	9.2	10	23.3	73	3	104-00102	£242.38
BSW 3/8"x16 BSF	16	7.2	8	19.8	61	3	104-00103	£230.70
BSW - 1/2", 9/16"x16	16	10.5	12	26.2	80	4	104-00104	£329.72
BSW 9/16"x16 BSF	16	12.15	14	29.4	92	4	104-00105	£376.37
BSW 7/16"x14 BSF	14	8.5	10	22.7	73	3	104-00106	£242.38
BSW - 5/8", 11/16"x14	14	13.4	14	31.7	92	4	104-00107	£376.37
BSW - 11/16"x14	14	15	16	35.4	92	4	104-00108	£458.09
BSW 1/2"x12 BSF	12	9.65	10	26.5	73	3	104-00109	£242.38
BSW 9/16"x12 BSF	12	11.25	12	28.6	80	4	104-00110	£329.72
BSW - 3/4"x12	12	16.2	18	39.2	102	4	104-00111	£500.08
BSW 5/8"x11 BSF	11	12.6	14	33.5	92	4	104-00112	£376.37
BSW 11/16"x11 BSF	11	14.2	16	35.8	92	4	104-00113	£458.09



## BSPT BRITISH STANDARD PIPE TAPER (B.S.21:1985) THREAD MILLS - HELICAL FLUTES

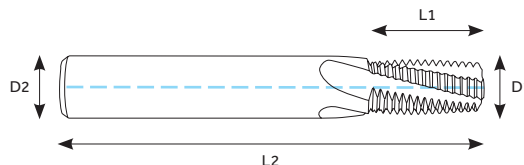
Cost Effective Solution For Everyday Thread Milling Operations

- TNF coated carbide thread mills
- Optional through coolant for improved chip evacuation in blind holes
- Thread milling of steel, stainless steel, HRSA's, aluminium & cast iron up to HRC45

Solid



Through Coolant



Thread BSPT	TPI	D1	D2	L1	L2	No. of Flutes	Order Code			
							Solid	Price	Through Coolant	Price
1/16" BSPT	28	5.8	8	16.3	57	3	CTM-BSPHFTC20T	£149.66	CTM-BSPHFTC20TCF	£163.78
1/8" BSPT	28	7.7	8	20.0	63	3	CTM-BSPHFTC22T	£149.40	CTM-BSPHFTC22TCF	£190.44
1/4" BSPT	19	9.9	12	26.7	73	4	CTM-BSPHFTC24T	£192.07	CTM-BSPHFTC24TCF	£238.00
3/8" BSPT	19	13.4	12	33.4	92	4	CTM-BSPHFTC26T	£288.12	CTM-BSPHFTC26TCF	£218.14
1/2" BSPT	14	15.7	16	43.5	92	4	CTM-BSPHFTC28T	£320.14	CTM-BSPHFTC28TCF	£309.05
1" BSPT	11	19.9	20	41.6	104	5	CTM-BSPHFTC30T	£372.67	CTM-BSPHFTC30TCF	£411.73



## BSPT BRITISH STANDARD PIPE TAPER (B.S.21:1985) THREAD MILLS HELICAL FLUTES

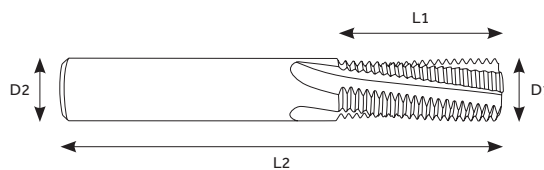
Premium Vardex Thread Mills For High Performance Applications

- TiAlN coated carbide thread mills
- Suitable for internal & external right and left hand threads
- Thread milling of steel, stainless steel, HRSA's, aluminium & cast iron up to HRC45

Solid



Through Coolant



**Buy 3 Get 1 Free on all Vardex Thread Mills**  
Valid until 31/12/2026

Thread BSPT	TPI	D1	D2	L1	L2	No. of Flutes	Order Code	Price
<b>Solid</b>								
1/16" BSPT	28	5.8	6	16.3	57	3	101-00089	£168.29
1/8" BSPT	28	7.7	8	20	63	3	101-00090	£196.05
1/4" BSPT	19	9.9	10	26.7	73	4	101-00091	£205.96
3/8" BSPT	19	13.4	16	33.4	92	4	101-00092	£389.29
1/2", 3/4" BSPT	14	15.7	16	43.5	92	5	101-00093	£389.29
1", 1 1/2", 2", 2 1/2" BSPT	11	19.9	20	41.6	104	5	101-00094	£424.92
<b>Through Coolant</b>								
1/16" BSPT	28	5.9	6	10.2	57	3	104-00132	£172.36
1/8" BSPT	28	7.65	8	10.2	61	3	104-00133	£202.69
1/4" BSPT	19	9.9	10	15.4	73	4	104-00134	£202.69
3/8" BSPT	19	11.15	12	15.4	73	4	104-00135	£277.40
1/2", 3/4" BSPT	14	14.25	16	22.7	92	4	104-00136	£446.08
1", 1 1/2", 2", 2 1/2" BSPT	11	19.6	20	28.9	102	4	104-00137	£431.46

BSPT THREAD MILLS

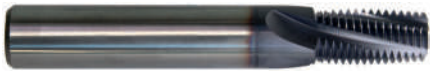


## NPT / NPTF NATIONAL PIPE TAPER (B2.1:1965) THREAD MILLS - HELICAL FLUTES

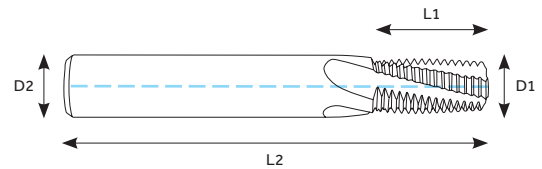
Cost Effective Solution For Everyday Thread Milling Operations

- TNF coated carbide thread mills
- Optional through coolant for improved chip evacuation in blind holes
- Thread milling of steel, stainless steel, HRSA's, aluminium & cast iron up to HRC45

Solid



Through Coolant



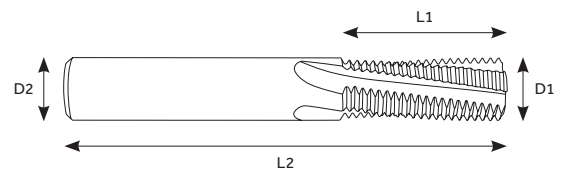
Thread Size	TPI	D1	D2	L1	L2	No. of Flutes	Order Code			
							Solid	Price	Through Coolant	Price
<b>NPT Internal / External</b>										
1/16"	27	5.90	8	9.88	55	3	CTM-NPTHF01T	£171.96	CTM-NPTHF01TCF	£176.69
1/8"	27	7.65	8	9.88	55	3	CTM-NPTHF03T	£171.96	CTM-NPTHF03TCF	£176.69
1/4"	18	10.15	12	14.82	75	4	CTM-NPTHF05T	£300.25	CTM-NPTHF05TCF	£265.01
3/8"	18	11.15	12	14.82	75	4	CTM-NPTHF07T	£270.22	CTM-NPTHF07TCF	£265.01
1/2"	14	14.25	16	19.05	80	4	CTM-NPTHF09T	£368.47	CTM-NPTHF09TCF	£371.11
1"	11.5	19.60	20	23.19	90	5	CTM-NPTHF11T	£476.61	CTM-NPTHF11TCF	£494.42
<b>NPTF Internal / External</b>										
1/16"	27	5.90	8	9.88	55	3	CTM-NPTFHF01T	£110.69	-	-
1/8"	27	7.65	8	9.88	55	3	CTM-NPTFHF03T	£169.73	-	-
1/4"	18	10.15	12	14.82	75	4	CTM-NPTFHF05T	£266.71	-	-
3/8"	18	11.15	12	14.82	75	4	CTM-NPTFHF07T	£266.71	-	-
1/2"	14	14.25	16	19.05	80	4	CTM-NPTFHF09T	£363.66	-	-
1"	11.5	19.60	20	23.19	90	5	CTM-NPTFHF11T	£306.77	-	-



## NPT NATIONAL PIPE TAPER (B2.1:1965) THREAD MILLS HELICAL FLUTES

Premium Vardex Thread Mills For High Performance Applications

- TiAlN coated carbide thread mills



Buy 3 Get 1 Free on all Vardex Thread Mills

Valid until 31/12/2026

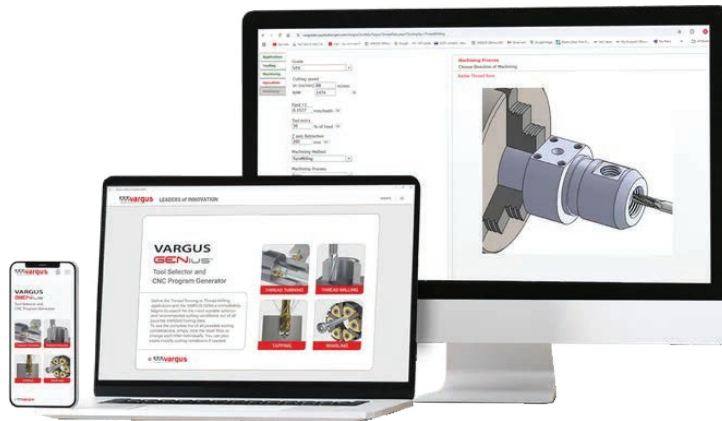
Thread Size	TPI	D1	D2	L1	L2	No. of Flutes	Order Code		Price
							NPT Internal / External	NPTF Internal / External	
<b>NPT Internal / External</b>									
1/16"	27	5.3	6	9.4	57	3	101-00075		£168.29
1/8"	27	7.5	8	9.4	63	4	101-00076		£196.05
1/4"	18	9.4	10	14.1	73	4	101-00077		£205.96
3/8"	18	11.9	12	14.1	83	4	101-00078		£280.16
1/2"	14	15.5	16	25.4	92	5	101-00079		£389.29
1"	11.5	19.9	20	33.1	104	5	101-00080		£424.92
2 1/2"	8	19.9	20	38.1	104	4	101-00081		£424.92
<b>NPTF Internal / External</b>									
1/16"	27	5.3	6	9.4	57	3	101-00082		£168.29
1/8"	27	7.5	8	9.4	63	4	101-00083		£196.05
1/4"	18	9.4	10	14.1	73	4	101-00084		£205.96
3/8"	18	11.9	12	14.1	83	4	101-00085		£280.16
1/2"	14	15.5	16	25.4	92	5	101-00086		£389.29
1"	11.5	19.9	20	33.1	104	5	101-00087		£424.92
2 1/2"	8	19.9	20	38.1	104	4	101-00088		£424.92

Material	Workpiece		Vc [m/min]			Feed fz [mm/tooth]		
	Group	Detail	Hardness Brinell HB	Helical Flute Deep Threading	Miniature	Helical	Deep Threading	Miniature
P Steel	Unalloyed Steel	Low Carbon (C=0.1-0.25%)	125	80-250	60-120	0.03-0.15	0.03-0.23	0.03-0.12
		Medium Carbon (C=0.25-0.55%)	150	80-230	60-120	0.03-0.1	0.03-0.15	0.03-0.12
		High Carbon (C=0.55-0.85%)	170	80-200	60-90	0.03-0.08	0.03-0.12	0.03-0.12
	Low Alloy Steel (Alloying Elements 5%)	Non Hardened	180	60-180	60-90	0.03-0.1	0.03-0.15	0.03-0.1
		Hardened	275	60-170	50-80	0.03-0.07	0.03-0.11	0.03-0.07
		Hardened	350	60-160	50-80	0.01-0.03	0.01-0.05	0.03
	High Alloy Steel (Alloying Elements >5%)	Annealed	200	40-100	50-80	0.03-0.05	0.03-0.08	0.03-0.05
		Hardened	325	30-80	50-80	0.01-0.03	0.01-0.05	0.03
Cast Steel	Low Alloy (Alloying Elements <5%)	200	80-250	70-90	0.03-0.1	0.03-0.15	0.03-0.1	
	High Alloy (Alloying Elements >5%)	225	60-170	60-80	0.01-0.03	0.01-0.05	0.03	
M Stainless Steel	Stainless Steel Ferritic	Non Hardened	200	60-150	60-90	0.04-0.1	0.04-0.15	0.03-0.1
		Hardened	330	60-120	50-80	0.01-0.05	0.01-0.08	0.03
	Stainless Steel Austenitic	Austenitic	180	60-140	60-90	0.04-0.1	0.04-0.15	0.03-0.1
		Super Austenitic	200	60-130	50-80	0.04-0.1	0.04-0.15	0.03-0.1
	Stainless Steel Cast Ferritic	Non Hardened	200	60-160	60-90	0.04-0.1	0.04-0.15	0.03-0.1
		Hardened	330	60-110	50-80	0.03-0.05	0.03-0.08	0.03
	Stainless Steel Cast Austenitic	Austenitic	200	60-150	60-90	0.04-0.1	0.04-0.15	0.03-0.1
		Hardened	330	60-100	50-80	0.03-0.05	0.03-0.08	0.03
K Cast Iron	Malleable	Ferritic (Short Chips)	130	60-70	50-80	0.01-0.03	0.01-0.05	0.03
	Cast Iron	Pearlitic (Long Chips)	230	60-150	60-90	0.03-0.05	0.03-0.08	0.05
	Grey Cast Iron	Low Tensile Strength	180	70-160	70-100	0.025-0.1	0.05-0.15	0.04-0.1
		High Tensile Strength	260	40-120	60-90	0.03-0.05	0.03-0.08	0.05
	Nodular Sg Iron	Ferritic	160	40-110	70-100	0.05-0.1	0.05-0.15	0.04-0.1
		Pearlitic	260	40-100	60-90	0.03-0.05	0.03-0.08	0.05
N Non-Ferrous Metals	Aluminium Alloys Wrought	Non Aging	60	200-300	60-250	0.1-0.25	0.10-0.38	0.05-0.15
		Aged	100	150-250	60-150	0.1-0.2	0.10-0.30	0.04-0.12
	Aluminium Alloys	Cast	75	100-200	60-250	0.1-0.2	0.10-0.30	0.04-0.12
		Cast & Aged	90	120-220	60-150	0.1-0.15	0.10-0.23	0.03-0.1
	Aluminium Alloys	Cast Si 13-22%	130	200-300	250	0.1-0.2	0.10-0.30	0.05-0.1
	Copper & Copper Alloys	Brass	90	200-300	60-250	0.1-0.25	0.10-0.38	0.04-0.12
		Bronze & Non Leaded Copper	100	150-250	60-150	0.1-0.2	0.10-0.30	0.05-0.1
S Heat Resistant Material	High Temperature Alloys	Annealed (Iron Based)	200	30-60	60	0.04-0.1	0.04-0.15	0.03-0.1
		Aged (Iron Based)	280	20-50	50	0.01-0.03	0.01-0.05	0.03
		Annealed (Nickel Or Cobalt Based)	250	15-35	20-40	0.01-0.03	0.01-0.05	0.03
		Aged (Nickel Or Cobalt Based)	350	15-30	15-30	0.01-0.03	0.01-0.05	0.03
	Titanium Alloys	Pure 99.5 Ti	400Rm	40-80	30-50	0.03-0.05	0.03-0.08	0.03-0.06
A+B Alloys		1050Rm	20-50	25-35	0.03-0.05	0.03-0.08	0.03-0.07	
H Hardened Steel	Extra Hard Steel	Hardened & Tempered	45-50HRC	15-45	30-45	0.005-0.01	0.005-0.02	0.01
		Hardened & Tempered	51-55HRC	15-40	15-30	0.005-0.01	0.005-0.02	0.01
		Hardened & Tempered	55-60HRC	40-60	-	0.005-0.025	-	-
		Hardened & Tempered	60-63HRC	30-40	-	0.005-0.015	-	-
		Hardened & Tempered	63-66HRC	30-40	-	0.005-0.015	-	-



## The VARGUS GENIUS™ simplifies threading applications by helping users quickly select the correct tooling, optimise cutting data, and automatically generate CNC programs.

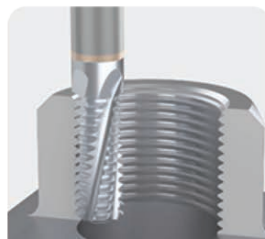
It reduces setup time, improves machining accuracy and consistency, and increases productivity while minimising programming and tooling selection errors.



Find out More



Thread Turning



Thread Milling



Tapping



Whirling

# Machine Taps

**W/G** **US** **cutwel** **PRO**

## Accurate and reliable CNC threading.

Improve thread quality, increase tool life and reduce failures with our comprehensive range of machine taps, from cost effective general purpose options to high-performance solutions.

Designed for blind holes, through holes, difficult materials and high-volume production, the right tap geometry and coating can improve chip control, reduce breakage and deliver more consistent results.

Backed by expert technical support, we can help you choose the best machine tap for your application and achieve more reliable machining performance.

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Best all-round high-performance tapping across an extensive range of materials, with up to **50% faster cutting speeds** and **double the tool life** of HSSE taps.

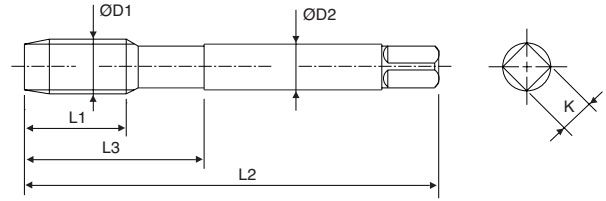




Multi Purpose

### METRIC COARSE DIN 13 MACHINE TAPS - SPIRAL FLUTE

- Machine taps for multi material tapping
- COMBO tap** - 1st choice for general tapping with exceptional reliability
- PRIME X tap** - advanced geometry & powder metal substrate for higher speed tapping, enhanced tool life and best performance on steel & stainless steel
- Spiral flute for blind holes



FIRST CHOICE

										TC804		TD804		TRE30		TRE39	
										YG - Combo Tap		YG - Combo Tap		YG - Prime X		YG - Prime X Coolant	
										HSS 5% Cobalt		HSS 5% Cobalt		HSS Powder Metal		HSS Powder Metal	
										Bright		TIN Coated		X-Coated		X-Coated	
										6H		6H		6HX		6HX	
										R40°		R40°		R45°		R45°	
										Form C: 2-3		Form C: 2-3		Form C: 2-3		Form C: 2-3	
										2.5xD		2.5xD		2.5xD		2.5xD	
										-		-		-		-	
										●●○●○●		●●●○●○		●●●●●○		●●●●●○	
Series	Brand / Geometry	Substrate	Surface Treatment	Tolerance	Helix Angle	Chamfer Lead	Maximum Depth	Through Coolant	Performance	Order Code	Price	Order Code	Price	Order Code	Price	Order Code	Price
M2	0.4	8	45	13	2.8	2.1	3	1.6	TC804136	£16.97	TD804136	£19.96	TRE30136GS	£23.91	-	-	
M2.5	0.45	9	50	15	2.8	2.1	3	2.05	TC804176	£14.13	TD804176	£17.21	TRE30176GS	£20.28	-	-	
M3	0.5	11	56	18	3.5	2.7	3	2.5	TC804206	£11.18	TD804206	£14.20	TRE30206GS	£16.62	-	-	
M3.5	0.6	12	56	20	4	3	3	2.9	TC804226	£8.55	TD804226	£15.73	TRE30226GS	£19.48	-	-	
M4	0.7	13	63	21	4.5	3.4	3	3.3	TC804246	£11.18	TD804246	£14.43	TRE30246GS	£16.90	-	-	
M4.5	0.75	14	70	25	6	4.9	3	3.7	TC804266	£7.80	TD804266	£14.94	-	-	-	-	
M5	0.8	15	70	25	6	4.9	3	4.2	TC804286	£11.58	TD804286	£14.94	TRE30286GS	£17.57	-	-	
M6	1	17	80	30	6	4.9	3	5	TC804316	£11.58	TD804316	£14.94	TRE30316GS	£17.96	TRE39316GS	£25.84	
M7	1	17	80	30	7	5.5	3	6	TC804346	£12.40	TD804346	£17.68	TRE30346GS	£25.60	-	-	
M8	1.25	20	90	35	8	6.2	3	6.8	TC804366	£15.03	TD804366	£20.38	TRE30366GS	£24.68	TRE39366GS	£35.55	
M10	1.5	22	100	39	10	8	3	8.5	TC804426	£18.18	TD804426	£24.38	TRE30426GS	£30.34	TRE39426GS	£43.71	
M12	1.75	24	110	44	9	7	3	10.2	TC804506	£24.26	TD804506	£32.51	TRE30506GS	£39.85	TRE39506GS	£57.39	
M14	2	26	110	44	11	9	3	12	TC804546	£27.05	TD804546	£39.08	TRE30546GS	£47.67	TRE39546GS	£68.67	
M16	2	27	110	44	12	9	3	14	TC804606	£37.03	TD804606	£47.14	TRE30606GS	£58.60	TRE39606GS	£84.38	
M18	2.5	30	125	50	14	11	4	15.5	TC804656	£32.52	TD804656	£61.42	TRE30656GS	£78.69	TRE39656GS	£113.34	
M20	2.5	32	140	54	16	12	4	17.5	TC804706	£57.56	TD804706	£73.46	TRE30706GS	£98.91	TRE39706GS	£142.46	
M22	2.5	32	140	54	18	14.5	4	19.5	TC804746	£49.92	TD804746	£92.74	TRE30746GS	£121.50	TRE39746GS	£174.94	
M24	3	34	160	60	18	14.5	4	21	TC804786	£78.13	TD804786	£99.88	TRE30786GS	£138.41	TRE39786GS	£199.34	
M27	3	36	160	60	20	16	4	24	TC804866	£84.04	TD804866	£151.47	-	-	-	-	
M30	3.5	40	180	70	22	18	4	26.5	TC804946	£151.16	TD804946	£185.22	-	-	-	-	
M33	3.5	34	160	60	18	14.5	4	21	TC804A46	£129.81	TD804A46	£474.18	-	-	-	-	
M36	4	36	160	60	20	16	4	24	TC804B36	£159.29	TD804B36	£223.09	-	-	-	-	
M39	4	40	180	70	22	18	4	26.5	TC804C06	£247.06	TD804C06	£279.15	-	-	-	-	
M42	4.5	40	180	70	25	20	4	29.5	TC804C86	£261.83	TD804C86	£422.36	-	-	-	-	
M45	4.5	50	200	80	28	22	4	32	TC804D56	£302.38	TD804D56	£456.57	-	-	-	-	
M48	5	50	200	80	32	24	4	35	TC804E26	£335.59	TD804E26	£594.96	-	-	-	-	
M52	5	56	200	85	32	24	4	37.5	TC804F36	£508.75	TD804F36	£719.95	-	-	-	-	

### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

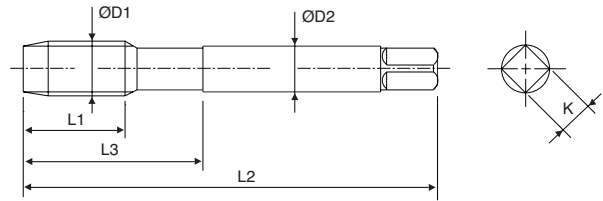
Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/ Graphite			Ti	Ti Alloy
	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
TC804	15-20	15-20	12-18	10-15	6-10	-	-	-	-	10-15	5-8	10-15	5-8	10-15	-
TD804	-	-	-	-	-	-	7-10	5-8	4-6	-	-	-	-	-	-
TRE30	20-30	20-30	20-25	15-20	5-12	-	10-15	8-10	6-8	-	-	15-20	10-15	-	-
TRE39	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
Series	Titanium			Inconel, Hastelloy, Nickel			Copper, Brass, Bronze			Aluminium			Plastics / Composites		
	Ti Alloy	Nickel	Nickel Alloy	Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP	
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	
TC804	-	8-12	-	-	8-12	25-35	15-20	-	-	25-35	15-20	10-15	-	-	
TD804	-	-	-	-	-	-	-	-	-	-	-	-	-	-	
TRE30	-	-	-	-	-	-	20-25	-	-	25-30	20-25	-	-	-	
TRE39	-	-	-	-	-	-	-	-	-	-	-	-	-	-	



Multi Purpose

### METRIC COARSE DIN 13 MACHINE TAPS - SPIRAL POINT

- Machine taps for multi material tapping
- COMBO tap** - 1st choice for general tapping with exceptional reliability
- PRIME X tap** - advanced geometry & powder metal substrate for higher speed tapping, enhanced tool life and best performance on steel & stainless steel
- Spiral point for through holes



										FIRST CHOICE							
										TC814	TD814	TRJ15	TRJ24				
										YG - Combo Tap	YG - Combo Tap	YG - Prime X	YG - Prime X Coolant				
										HSS 5% Cobalt	HSS 5% Cobalt	HSS Powder Metal	HSS Powder Metal				
										Bright	TIN Coated	X-Coated	X-Coated				
										6H	6H	6HX	6HX				
										-	-	-	-				
										Form B: 4-5	Form B: 4-5	Form B: 4-5	Form B: 4-5				
										3xD	3xD	3xD	3xD				
										-	-	-	-				
										Performance	Performance	Performance	Performance				
										Order Code	Price	Order Code	Price	Order Code	Price	Order Code	Price
ØD1	Pitch	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.		Order Code	Price	Order Code	Price	Order Code	Price	Order Code	Price
M2	0.4	8	45	13	2.8	2.1	3	1.6		TC814136	£16.97	TD814136	£19.96	TRJ15136GS	£23.91	-	-
M2.5	0.45	9	50	15	2.8	2.1	3	2.05		TC814176	£14.13	TD814176	£17.21	TRJ15176GS	£20.28	-	-
M3	0.5	11	56	18	3.5	2.7	3	2.5		TC814206	£11.18	TD814206	£14.20	TRJ15206GS	£16.62	-	-
M3.5	0.6	12	56	20	4	3	3	2.9		TC814226	£11.67	TD814226	£15.73	TRJ15226GS	£19.48	-	-
M4	0.7	13	63	21	4.5	3.4	3	3.3		TC814246	£11.18	TD814246	£14.43	TRJ15246GS	£16.90	-	-
M4.5	0.75	14	70	25	6	4.9	3	3.7		TC814266	£10.64	TD814266	£14.94	-	-	-	-
M5	0.8	15	70	25	6	4.9	3	4.2		TC814286	£11.58	TD814286	£14.94	TRJ15286GS	£17.57	-	-
M6	1	17	80	30	6	4.9	3	5		TC814316	£11.58	TD814316	£14.94	TRJ15316GS	£17.96	TRJ24316GSP	£25.84
M7	1	17	80	30	7	5.5	3	6		TC814346	£12.40	TD814346	£17.68	TRJ15346GS	£25.60	-	-
M8	1.25	20	90	35	8	6.2	3	6.8		TC814366	£15.03	TD814366	£20.38	TRJ15366GS	£24.68	TRJ24366GSP	£35.55
M10	1.5	22	100	39	10	8	3	8.5		TC814426	£18.18	TD814426	£24.38	TRJ15426GS	£30.34	TRJ24426GSP	£43.71
M12	1.75	24	110	44	9	7	3	10.2		TC814506	£24.26	TD814506	£32.51	TRJ15506GS	£39.85	TRJ24506GSP	£57.39
M14	2	26	110	44	11	9	3	12		TC814546	£27.05	TD814546	£39.08	TRJ15546GS	£47.67	TRJ24546GSP	£68.67
M16	2	27	110	44	12	9	3	14		TC814606	£24.93	TD814606	£47.14	TRJ15606GS	£58.60	TRJ24606GSP	£84.38
M18	2.5	30	125	50	14	11	4	15.5		TC814656	£44.35	TD814656	£61.42	TRJ15656GS	£78.69	TRJ24656GSP	£113.34
M20	2.5	32	140	54	16	12	4	17.5		TC814706	£57.56	TD814706	£73.46	TRJ15706GS	£98.91	TRJ24706GSP	£142.46
M22	2.5	32	140	54	18	14.5	4	19.5		TC814746	£49.92	TD814746	£92.74	TRJ15746GS	£121.50	TRJ24746GSP	£174.94
M24	3	34	160	60	18	14.5	4	21		TC814786	£52.60	TD814786	£99.88	TRJ15786GS	£138.41	TRJ24786GSP	£199.34
M27	3	36	160	60	20	16	4	24		TC814866	£84.04	TD814866	£151.47	-	-	-	-
M30	3.5	40	180	70	22	18	4	26.5		TC814946	£101.75	TD814946	£185.22	-	-	-	-
M33	3.5	34	160	60	18	14.5	4	21		TC814A46	£129.81	TD814A46	£223.09	-	-	-	-
M36	4	36	160	60	20	16	4	24		TC814B36	£159.29	TD814B36	£279.15	-	-	-	-
M39	4	40	180	70	22	18	4	26.5		TC814C06	£247.06	TD814C06	£422.36	-	-	-	-
M42	4.5	40	180	70	25	20	4	29.5		TC814C86	£261.83	TD814C86	£474.18	-	-	-	-
M45	4.5	50	200	80	28	22	4	32		TC814D56	£302.38	TD814D56	£456.57	-	-	-	-
M48	5	50	200	80	32	24	4	35		TC814E26	£335.59	TD814E26	£594.96	-	-	-	-
M52	5	56	200	85	32	24	4	37.5		TC814F36	£508.75	TD814F36	£719.95	-	-	-	-

METRIC COARSE MACHINE TAPS

### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/ Graphite			Ti	Ti Alloy
TC814	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
TD814	15-20	15-20	12-18	10-15	6-10	-	7-10	5-8	4-6	10-15	5-8	10-15	5-8	10-15	-
TRJ15	20-30	20-30	20-25	15-20	5-12	-	10-15	8-10	6-8	-	-	15-20	10-15	-	-
TRJ24	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
Series	Titanium	Inconel, Hastelloy, Nickel			Copper, Brass, Bronze				Aluminium			Plastics / Composites			
	Ti Alloy	Nickel	Nickel Alloy		Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP	
TC814	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	
TD814	-	8-12	-	-	8-12	25-35	15-20	-	-	25-35	15-20	10-15	-	-	
TRJ15	-	-	-	-	-	-	20-25	-	-	25-30	20-25	-	-	-	
TRJ24	-	-	-	-	-	-	-	-	-	-	-	-	-	-	

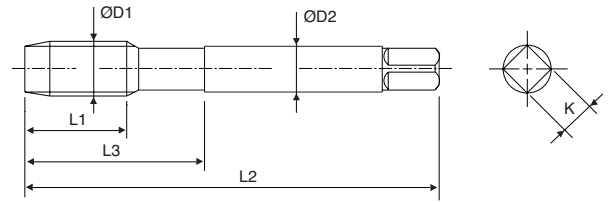


## METRIC COARSE DIN 13 MACHINE TAPS - SPIRAL FLUTE - FORM E

- Short chamfer (form E) for thin wall components
- Machine taps for multi material tapping
- **COMBO tap** - 1st choice for general tapping
- **PRIME X tap geometry** - advanced geometry & powder metal substrate for higher speed tapping, enhanced tool life and best performance on steel & stainless steel
- Spiral flute for blind holes

Multi Purpose

Short Chamfer



Series	TC807	TRE34	TRE41
Brand / Geometry	YG - Combo Tap	YG - Prime X	YG - Prime X Coolant
Substrate	HSS 5% Cobalt	HSS Powder Metal	HSS Powder Metal
Surface Treatment	Bright	X-Coated	X-Coated
Tolerance	6H	6HX	6HX
Helix Angle	R40°	R45°	R45°
Chamfer Lead	Form E: 1.5-2	Form E: 1.5-2	Form E: 1.5-2
Maximum Depth	2.5xD	3xD	3xD
Through Coolant	-	-	
Performance			

ØD1	Pitch	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price	Order Code	Price	Order Code	Price
M2	0.4	8	45	13	2.8	2.1	3	1.6	TC807136	£23.89	TRE34136GS	£25.11	-	-
M2.5	0.45	9	50	15	2.8	2.1	3	2.05	TC807176	£17.97	-	-	-	-
M3	0.5	11	56	18	3.5	2.7	3	2.5	TC807206	£15.80	TRE34206GS	£17.45	-	-
M3.5	0.6	12	56	20	4	3	3	2.9	TC807226	£16.13	-	-	-	-
M4	0.7	13	63	21	4.5	3.4	3	3.3	TC807246	£15.80	TRE34246GS	£17.73	-	-
M4.5	0.75	14	70	25	6	4.9	3	3.7	TC807266	£14.78	-	-	-	-
M5	0.8	15	70	25	6	4.9	3	4.2	TC807286	£16.33	TRE34286GS	£18.44	-	-
M6	1	17	80	30	6	4.9	3	5	TC807316	£16.33	TRE34316GS	£18.86	TRE41316GS	£36.28
M7	1	17	80	30	7	5.5	3	6	TC807346	£19.14	-	-	-	-
M8	1.25	20	90	35	8	6.2	3	6.8	TC807366	£21.21	TRE34366GS	£25.91	TRE41366GS	£49.89
M10	1.5	22	100	39	10	8	3	8.5	TC807426	£25.38	TRE34426GS	£31.85	TRE41426GS	£61.40
M12	1.75	24	110	44	9	7	3	10.2	TC807506	£34.28	TRE34506GS	£41.84	TRE41506GS	£80.64
M14	2	26	110	44	11	9	3	12	TC807546	£41.48	TRE34546GS	£50.04	TRE41546GS	£96.46
M16	2	27	110	44	12	9	3	14	TC807606	£52.13	TRE34606GS	£61.52	TRE41606GS	£118.54
M18	2.5	30	125	50	14	11	4	15.5	TC807656	£62.22	-	-	-	-
M20	2.5	32	140	54	16	12	4	17.5	TC807706	£82.07	TRE34706GS	£103.86	TRE41706GS	£200.12
M22	2.5	32	140	54	18	14.5	4	19.5	TC807746	£92.02	-	-	-	-
M24	3	34	160	60	18	14.5	4	21	TC807786	£93.85	-	-	-	-
M27	3	36	160	60	20	16	4	24	TC807866	£143.90	-	-	-	-
M30	3.5	40	180	70	22	18	4	26.5	TC807946	£184.07	-	-	-	-

### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast Iron	Malleable Cast Iron/Graphite		Ti	Ti Alloy	
	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
TC807	15-20	15-20	12-18	10-15	6-10	-	-	-	-	10-15	5-8	10-15	5-8	10-15	-
TRE34	20-30	20-30	20-25	15-20	5-12	-	10-15	8-10	6-8	-	-	15-20	10-15	-	-
TRE41	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
Series	Titanium				Copper, Brass, Bronze				Aluminium			Plastics / Composites			
	Ti Alloy	Nickel	Nickel Alloy		Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP	
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	
TC807	-	8-12	-	-	8-12	25-35	15-20	-	-	25-35	15-20	10-15	-	-	
TRE34	-	-	-	-	-	-	20-25	-	-	25-30	20-25	-	-	-	
TRE41	-	-	-	-	-	-	-	-	-	-	-	-	-	-	

METRIC COARSE MACHINE TAPS

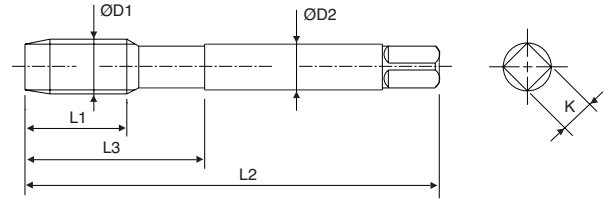


Long Chipping Steels

Chip Breaker

### METRIC COARSE DIN 13 MACHINE TAPS - SPIRAL FLUTE - CHIPBREAKER

- Particularly suitable for machining non-alloy steel, low alloy steel, high alloy steel, and tool steel
- Solve productivity problems caused by long chips, avoiding bird nesting
- Spiral flute for blind holes



Series	TDE27
Brand / Geometry	YG - Chip Breaker
Substrate	HSS-E
Surface Treatment	TIN Coated
Tolerance	6H
Helix Angle	R15°
Chamfer Lead	Form E
Maximum Depth	2xD
Through Coolant	-
Performance	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>

ØD1	Pitch	L1	L2	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price
M8	1	10	90	6	4.9	3	7	TDE27376R	£23.18
M10	1.25	16	100	7	5.5	3	8.8	TDE27436R	£28.21
M10	1	10	90	7	5.5	3	9	TDE27446R	£26.86
M12	1.5	15	100	9	7	3	10.5	TDE27516R	£30.54
M12	1.25	15	100	9	7	3	10.8	TDE27526R	£32.75
M14	1.5	15	100	11	9	3	12.5	TDE27556R	£36.79
M16	1.5	15	100	12	9	3	14.5	TDE27616R	£46.68
M18	1.5	17	110	14	11	4	16.5	TDE27676R	£59.51
M20	1.5	17	125	16	12	4	18.5	TDE27726R	£67.77

METRIC COARSE MACHINE TAPS





## TAP CHIP BREAKER

### The Trouble-Shooter

YG Tap Chip Breaker provides a solution to solve the productivity problem caused by long chips, avoiding bird nesting.

Particularly suitable for machining non-alloy steel, low alloy steel, high alloy steel, and tool steel.



Material Applications N/mm<sup>2</sup>      Cutting Speed m/min

● Excellent    ○ Good

Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/ Graphite		Ti	Ti Alloy	
	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
TDE27	7-12	7-12	4-8	4-8	-	-	-	-	-	-	-	-	-	-	-
Series	Titanium				Copper, Brass, Bronze				Aluminium			Plastics / Composites			
	Ti Alloy	Nickel	Nickel Alloy		Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP	
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	-
TDE27	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-



## METRIC COARSE DIN 13 MACHINE TAPS - SPIRAL FLUTE - LONG SHANK

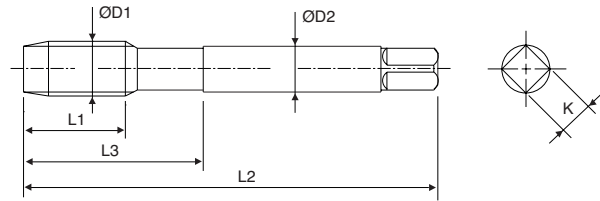
- Long shank
- Machine taps for multi material tapping
- COMBO tap geometry** - 1st choice for general tapping
- Spiral flute for blind holes
- Spiral point for through holes

Multi Purpose

Long Shank



Combo



Type	Spiral Flute	Spiral Point
Series	TC633	TC445
Brand / Geometry	YG - Combo Tap	YG - Combo Tap
Substrate	HSS 5% Cobalt	HSS 5% Cobalt
Surface Treatment	Bright	Bright
Tolerance	6H	6H
Helix Angle	R40°	R40°
Chamfer Lead	Form C: 2-3	Form B: 4-5
Maximum Depth	2.5xD	3xD
Through Coolant	-	-
Performance	<input checked="" type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	<input checked="" type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>

ØD1	Pitch	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price	Order Code	Price
M3	0.5	11	100	18	3.5	2.7	3	2.5	TC633206	£16.78	TC445206	£24.63
M4	0.7	13	125	21	4.5	3.4	3	3.3	TC633246	£19.01	TC445246	£24.88
M5	0.8	15	140	25	6	4.9	3	4.2	TC633286	£19.81	TC445286	£25.97
M6	1	17	160	30	6	4.9	3	5	TC633316	£20.41	TC445316	£26.71
M8	1.25	20	180	35	6	4.9	3	6.8	TC633366	£26.37	TC445366	£44.33
M10	1.5	22	200	39	7	5.5	3	8.5	TC633426	£30.13	TC445426	£44.65
M12	1.75	24	220	44	9	7	3	10.2	TC633506	£62.24	TC445506	£74.00
M14	2	26	220	44	11	9	3	12	TC633546	£71.68	TC445546	£85.22
M16	2	27	220	44	12	9	3	14	TC633606	£97.40	TC445606	£115.69
M20	2.5	32	280	54	16	12	4	17.5	TC633706	£138.65	TC445706	£162.76

### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

Series	Steels			Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels	Carbon	Alloy	Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/ Graphite	Grey Cast iron	Malleable Cast Iron/ Graphite	Ti	Ti Alloy
TC633	<400	<700	<850	<1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
TC445	15-20	15-20	12-18	10-15	6-10	-	-	-	10-15	5-8	10-15	5-8	10-15	-
Series	Titanium			Copper, Brass, Bronze			Aluminium			Plastics / Composites				
	Ti Alloy	Inconel, Hastelloy, Nickel	Nickel Alloy	Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP	
TC633	<1300	<500	<900	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	
TC445	-	8-12	-	8-12	25-35	15-20	-	-	25-35	15-20	10-15	-	-	

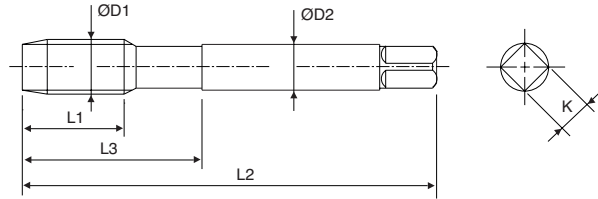
METRIC COARSE MACHINE TAPS



Multi Purpose

### METRIC COARSE DIN 13 MACHINE TAPS - NUT TAP

- For nut manufacturing
- Machine taps for multi material tapping
- The work pieces can be taken out from shank side only



Series	TC803
Brand / Geometry	YG - Nut Tap
Substrate	HSS 5% Cobalt
Surface Treatment	Bright
Tolerance	6H
Helix Angle	-
Chamfer Lead	Long
Maximum Depth	2xD
Through Coolant	-
Performance	<input checked="" type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>

ØD1	Pitch	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price
M4	0.7	25	90	45	2.8	2.1	3	3.3	TC803246	£21.25
M5	0.8	28	100	50	3.5	2.7	3	4.2	TC803286	£21.25
M6	1	32	110	55	4.5	3.4	3	5	TC803316	£21.25
M7	1	36	110	55	5.5	4.3	3	6	TC803346	£27.17
M8	1.25	40	125	62	6	4.9	3	6.8	TC803366	£27.17
M10	1.5	45	140	70	7	5.5	3	8.5	TC803426	£42.10
M12	1.75	50	180	90	9	7	3	10.2	TC803506	£53.85
M14	2	56	200	100	11	9	4	12	TC803546	£61.47
M16	2	63	200	100	12	9	4	14	TC803606	£114.65
M18	2.5	63	220	110	14	11	4	15.5	TC803656	£96.78
M20	2.5	70	250	125	16	12	4	17.5	TC803706	£128.01

METRIC COARSE MACHINE TAPS

#### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/ Graphite		Ti	Ti Alloy	
	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
TC803	15-20	15-20	12-18	10-15	6-10	-	-	-	-	-	-	10-15	5-8	-	-
Series	Titanium, Inconel, Hastelloy, Nickel				Copper, Brass, Bronze			Aluminium			Plastics / Composites				
	Ti Alloy	Nickel	Nickel Alloy		Cu	Cu Alloy		Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	-
TC803	-	-	-	-	8-12	25-35	15-20	-	-	-	-	10-15	-	-	-

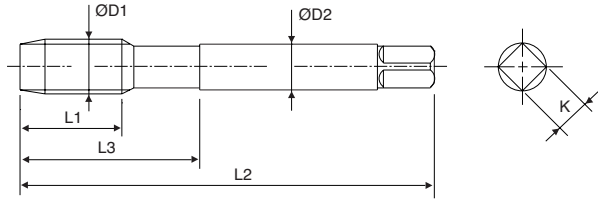


## METRIC COARSE DIN 13 MACHINE TAPS - SPIRAL FLUTE & POINT 4H TOLERANCE

Multi Purpose

4H Tolerance

- Machine taps for multi material tapping
- COMBO tap geometry** - 1st choice for general tapping with exceptional reliability
- Spiral flute for blind holes, spiral point for through holes



Combo

Type	Spiral Flute	Spiral Flute	Spiral Point	Spiral Point
Series	TCE05	TDE05	TCJ05	TDJ05
Brand / Geometry	YG - Combo Tap	YG - Combo Tap	YG - Combo Tap	YG - Combo Tap
Substrate	HSS 5% Cobalt	HSS 5% Cobalt	HSS 5% Cobalt	HSS 5% Cobalt
Surface Treatment	Bright	TIN Coated	Bright	TIN Coated
Tolerance	4H	4H	4H	4H
Helix Angle	R40°	R40°	-	-
Chamfer Lead	Form C: 2-3	Form C: 2-3	Form B: 4-5	Form B: 4-5
Maximum Depth	2.5xD	2.5xD	3xD	3xD
Through Coolant	-	-	-	-
Performance	<input checked="" type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	<input checked="" type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	<input checked="" type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	<input checked="" type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>

ØD1	Pitch	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price	Order Code	Price	Order Code	Price	Order Code	Price
M2	0.4	8	45	13	2.8	2.1	3	1.6	TCE05136	£26.21	TDE05136	£25.89	TCJ05136	£26.21	TDJ05136	£25.91
M2.2	0.45	8	45	13	2.8	2.1	3	1.75	TCE05156	£24.51	TDE05156	£28.47	TCJ05156	£24.63	TDJ05156	£28.61
M2.3	0.4	8	45	13	2.8	2.1	3	1.9	TCE05196	£27.55	TDE05196	£31.44	TCJ05196	£27.71	TDJ05196	£31.60
M2.5	0.45	9	50	15	2.8	2.1	3	2.05	TCE05176	£18.16	TDE05176	£21.95	TCJ05176	£18.41	TDJ05176	£22.29
M2.6	0.45	9	50	15	2.8	2.1	3	2.1	TCE05496	£17.49	TDE05496	£21.34	TCJ05496	£17.49	TDJ05496	£21.34
M3	0.5	6	56	18	3.5	2.7	3	2.5	TCE05206	£17.37	TDE05206	£18.41	TCJ05206	£17.37	TDJ05206	£18.41
M3.5	0.6	7	56	20	4	3	3	2.9	TCE05226	£16.51	TDE05226	£20.43	TCJ05226	£16.55	TDJ05226	£20.43
M4	0.7	7	63	21	4.5	3.4	3	3.3	TCE05246	£17.37	TDE05246	£18.76	TCJ05246	£17.37	TDJ05246	£18.76
M4.5	0.75	8	70	25	6	4.9	3	3.7	TCE05266	£15.04	TDE05266	£19.19	TCJ05266	£15.04	TDJ05266	£19.19
M5	0.8	8	70	25	6	4.9	3	4.2	TCE05286	£17.95	TDE05286	£19.19	TCJ05286	£17.95	TDJ05286	£19.19
M6	1	10	80	30	6	4.9	3	5	TCE05316	£17.95	TDE05316	£19.19	TCJ05316	£17.95	TDJ05316	£19.19
M7	1	10	80	30	7	5.5	3	6	TCE05346	£19.44	TDE05346	£24.69	TCJ05346	£17.64	TDJ05346	£22.90
M8	1.25	13	90	35	8	6.2	3	6.8	TCE05366	£23.20	TDE05366	£26.28	TCJ05366	£23.20	TDJ05366	£26.28
M9	1.25	13	90	35	9	7	3	7.8	TCE05396	£23.46	TDE05396	£30.70	TCJ05396	£23.46	TDJ05396	£30.70
M10	1.5	15	100	39	10	8	3	8.5	TCE05426	£28.02	TDE05426	£31.63	TCJ05426	£28.02	TDJ05426	£31.63
M11	1.5	17	100	40	8	6.2	3	9.5	TCE05466	£31.55	TDE05466	£40.43	TCJ05466	£26.09	TDJ05466	£34.95
M12	1.75	18	110	44	9	7	3	10.2	TCE05506	£37.65	TDE05506	£42.12	TCJ05506	£37.65	TDJ05506	£42.12
M14	2	20	110	44	11	9	3	12	TCE05546	£45.61	TDE05546	£50.57	TCJ05546	£45.61	TDJ05546	£50.57
M16	2	20	110	44	12	9	3	14	TCE05606	£57.25	TDE05606	£61.06	TCJ05606	£57.25	TDJ05606	£61.06
M18	2.5	25	125	50	14	11	4	15.5	TCE05656	£63.41	TDE05656	£80.26	TCJ05656	£62.79	TDJ05656	£79.53
M20	2.5	25	140	54	16	12	4	17.5	TCE05706	£86.56	TDE05706	£95.96	TCJ05706	£86.56	TDJ05706	£95.01
M22	2.5	25	140	54	18	14.5	4	19.5	TCE05746	£93.79	TDE05746	£117.56	TCJ05746	£96.17	TDJ05746	£119.83
M24	3	30	160	60	18	14.5	4	21	TCE05786	£102.09	TDE05786	£129.98	TCJ05786	£101.52	TDJ05786	£129.24
M27	3	30	160	60	20	16	4	24	TCE05866	£146.68	TDE05866	£180.74	TCJ05866	£162.05	TDJ05866	£196.13
M30	3.5	35	180	70	22	18	4	26.5	TCE05946	£187.65	TDE05946	£231.18	TCJ05946	£196.13	TDJ05946	£239.88

### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

Series	Steels			Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels <400	Carbon <700	Alloy <850	Pre-Hard <1200	Hardened >1200	Free Mach. <850	Austenitic <850	Fer/Marten. <1000	Grey Cast iron <500	Malleable Cast Iron/Graphite <1000	<700	<1000	Ti <700	Ti Alloy <900
TCE05	15-20	15-20	12-18	10-15	6-10	-	-	-	10-15	5-8	10-15	5-8	10-15	-
TDE05	-	-	-	-	-	7-10	5-8	4-6	-	-	-	-	-	-
TCJ05	-	-	-	-	-	-	-	-	-	-	-	-	-	-
TDJ05	-	-	-	-	-	7-10	5-8	4-6	-	-	-	-	-	-

Series	Titanium	Inconel, Hastelloy, Nickel		Copper, Brass, Bronze			Aluminium			Plastics / Composites					
	Ti Alloy <1300	Nickel <500	Nickel Alloy <900	<1400	Cu <350	Cu Alloy Short	Long	Cu-Al-Fe <1500	Al/Mg <350	Al Wrought	Al Si ≤10%	Al Si >10%	Thermo	Thermoset	CFRP/GFRP
TCE05	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
TDE05	-	8-12	-	-	8-12	25-35	15-20	-	-	25-35	15-20	10-15	-	-	-
TCJ05	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
TDJ05	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

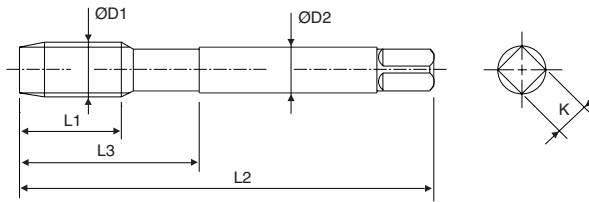


Multi Purpose

6G Tolerance

### METRIC COARSE DIN 13 MACHINE TAPS - SPIRAL FLUTE & POINT 6G TOLERANCE

- Machine taps for multi material tapping
- COMBO tap geometry** - 1st choice for general tapping with exceptional reliability
- Spiral flute for blind holes, spiral point for through holes



Combo

Type	Spiral Flute	Spiral Flute	Spiral Point	Spiral Point
Series	TCE07	TDE07	TCJ07	TDJ07
Brand / Geometry	YG - Combo Tap	YG - Combo Tap	YG - Combo Tap	YG - Combo Tap
Substrate	HSS 5% Cobalt	HSS 5% Cobalt	HSS 5% Cobalt	HSS 5% Cobalt
Surface Treatment	Bright	TIN Coated	Bright	TIN Coated
Tolerance	6G	6G	6G	6G
Helix Angle	R40°	R40°	-	-
Chamfer Lead	Form C: 2-3	Form C: 2-3	Form B: 4-5	Form B: 4-5
Maximum Depth	2.5xD	2.5xD	3xD	3xD
Through Coolant	-	-	-	-
Performance	●●○	●●●○	●●○	●●●○

ØD1	Pitch	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price	Order Code	Price	Order Code	Price	Order Code	Price
M2	0.4	8	45	13	2.8	2.1	3	1.6	TCE07136	£24.94	TDE07136	£24.44	TCJ07136	£24.94	TDJ07136	£24.51
M2.2	0.45	8	45	13	2.8	2.1	3	1.75	TCE07156	£23.30	TDE07156	£26.83	TCJ07156	£23.44	TDJ07156	£26.96
M2.3	0.4	8	45	13	2.8	2.1	3	1.9	TCE07196	£26.11	TDE07196	£29.68	TCJ07196	£26.21	TDJ07196	£29.86
M2.5	0.45	9	50	15	2.8	2.1	3	2.05	TCE07176	£17.13	TDE07176	£20.90	TCJ07176	£17.47	TDJ07176	£21.05
M2.6	0.45	9	50	15	2.8	2.1	3	2.1	TCE07496	£16.55	TDE07496	£20.18	TCJ07496	£16.55	TDJ07496	£20.18
M3	0.5	6	56	18	3.5	2.7	3	2.5	TCE07206	£16.42	TDE07206	£17.47	TCJ07206	£16.42	TDJ07206	£17.47
M3.5	0.6	7	56	20	4	3	3	2.9	TCE07226	£15.55	TDE07226	£19.14	TCJ07226	£15.62	TDJ07226	£19.14
M4	0.7	7	63	21	4.5	3.4	3	3.3	TCE07246	£16.42	TDE07246	£17.80	TCJ07246	£16.42	TDJ07246	£17.80
M4.5	0.75	8	70	25	6	4.9	3	3.7	TCE07266	£14.18	TDE07266	£18.16	TCJ07266	£14.18	TDJ07266	£18.16
M5	0.8	8	70	25	6	4.9	3	4.2	TCE07286	£16.89	TDE07286	£18.16	TCJ07286	£16.89	TDJ07286	£18.16
M6	1	10	80	30	6	4.9	3	5	TCE07316	£16.89	TDE07316	£18.16	TCJ07316	£16.89	TDJ07316	£18.16
M7	1	10	80	30	7	5.5	3	6	TCE07346	£18.41	TDE07346	£23.46	TCJ07346	£16.63	TDJ07346	£21.59
M8	1.25	13	90	35	8	6.2	3	6.8	TCE07366	£22.02	TDE07366	£24.71	TCJ07366	£22.02	TDJ07366	£24.71
M9	1.25	13	90	35	9	7	3	7.8	TCE07396	£22.08	TDE07396	£29.07	TCJ07396	£22.08	TDJ07396	£29.07
M10	1.5	15	100	39	10	8	3	8.5	TCE07426	£26.38	TDE07426	£29.97	TCJ07426	£26.38	TDJ07426	£29.97
M11	1.5	17	100	40	8	6.2	3	9.5	TCE07466	£29.86	TDE07466	£38.22	TCJ07466	£24.61	TDJ07466	£32.99
M12	1.75	18	110	44	9	7	3	10.2	TCE07506	£35.65	TDE07506	£39.77	TCJ07506	£35.65	TDJ07506	£39.77
M14	2	20	110	44	11	9	3	12	TCE07546	£43.09	TDE07546	£47.80	TCJ07546	£43.09	TDJ07546	£47.80
M16	2	20	110	44	12	9	3	14	TCE07606	£54.06	TDE07606	£57.63	TCJ07606	£54.06	TDJ07606	£57.63
M18	2.5	25	125	50	14	11	4	15.5	TCE07656	£60.00	TDE07656	£75.89	TCJ07656	£59.33	TDJ07656	£75.22
M20	2.5	25	140	54	16	12	4	17.5	TCE07706	£84.40	TDE07706	£90.74	TCJ07706	£84.40	TDJ07706	£89.86
M22	2.5	25	140	54	18	14.5	4	19.5	TCE07746	£88.62	TDE07746	£111.09	TCJ07746	£90.97	TDJ07746	£113.43
M24	3	30	160	60	18	14.5	4	21	TCE07786	£96.51	TDE07786	£122.78	TCJ07786	£95.92	TDJ07786	£122.17
M27	3	30	160	60	20	16	4	24	TCE07866	£138.65	TDE07866	£170.95	TCJ07866	£153.29	TDJ07866	£185.47
M30	3.5	35	180	70	22	18	4	26.5	TCE07946	£177.34	TDE07946	£218.61	TCJ07946	£185.47	TDJ07946	£226.76

METRIC COARSE MACHINE TAPS

### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

Series	Steels			Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels <400	Carbon <700	Alloy <850	Pre-Hard ≤1200	Hardened >1200	Free Mach. <850	Austenitic <850	Fer/Marten. <1000	Grey Cast iron <500	Malleable Cast Iron/Graphite <1000	<700	<1000	Ti <700	Ti Alloy <900
TCE07	15-20	15-20	12-18	10-15	6-10	-	-	-	10-15	5-8	10-15	5-8	10-15	-
TDE07						7-10	5-8	4-6						
TCJ07						-	-	-						
TDJ07						7-10	5-8	4-6						

Series	Titanium	Inconel, Hastelloy, Nickel		Copper, Brass, Bronze			Aluminium			Plastics / Composites				
	Ti Alloy ≤1300	Nickel <500	Nickel Alloy <900	Cu ≤350	Cu Alloy Short	Long	Cu-Al-Fe <1500	Al/Mg ≤350	Al Wrought	Al Si ≤10%	Al Si >10%	Thermo	Thermoset	CFRP/GFRP
TCE07	-	-	-	-	-	-	-	-	25-35	15-20	10-15	-	-	-
TDE07														
TCJ07														
TDJ07														

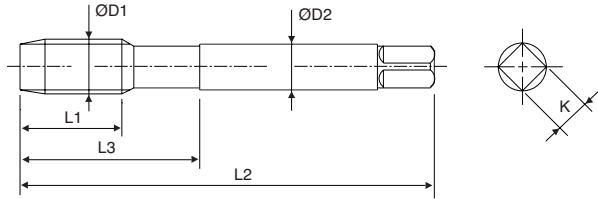


Multi Purpose

6H+0.1 Tolerance

## METRIC COARSE DIN 13 MACHINE TAPS - SPIRAL FLUTE & POINT 6H+0.1 TOLERANCE

- Machine taps for multi material tapping
- COMBO tap geometry** - 1st choice for general tapping with exceptional reliability
- Spiral flute for blind holes, spiral point for through holes



Combo

Type	Spiral Flute	Spiral Flute	Spiral Point	Spiral Point
Series	TCE06	TDE06	TCJ06	TDJ06
Brand / Geometry	YG - Combo Tap	YG - Combo Tap	YG - Combo Tap	YG - Combo Tap
Substrate	HSS 5% Cobalt	HSS 5% Cobalt	HSS 5% Cobalt	HSS 5% Cobalt
Surface Treatment	Bright	TIN Coated	Bright	TIN Coated
Tolerance	6H+0.1	6H+0.1	6H+0.1	6H+0.1
Helix Angle	R40°	R40°	-	-
Chamfer Lead	Form C: 2-3	Form C: 2-3	Form B: 4-5	Form B: 4-5
Maximum Depth	2.5xD	2.5xD	3xD	3xD
Through Coolant	-	-	-	-
Performance	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>

METRIC COARSE MACHINE TAPS

ØD1	Pitch	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price	Order Code	Price	Order Code	Price	Order Code	Price
M2	0.4	8	45	13	2.8	2.1	3	1.7	TCE06136	£21.92	TDE06136	£25.89	TCJ06136	£21.95	TDJ06136	£25.91
M2.2	0.45	8	45	13	2.8	2.1	3	1.85	TCE06156	£24.51	TDE06156	£28.47	TCJ06156	£24.63	TDJ06156	£28.61
M2.3	0.4	8	45	13	2.8	2.1	3	2	TCE06196	£27.55	TDE06196	£31.44	TCJ06196	£27.71	TDJ06196	£31.60
M2.5	0.45	9	50	15	2.8	2.1	3	2.15	TCE06176	£18.16	TDE06176	£21.95	TCJ06176	£18.41	TDJ06176	£22.29
M2.6	0.45	9	50	15	2.8	2.1	3	2.2	TCE06496	£17.49	TDE06496	£21.34	TCJ06496	£17.49	TDJ06496	£21.34
M3	0.5	6	56	18	3.5	2.7	3	2.6	TCE06206	£17.37	TDE06206	£18.41	TCJ06206	£17.37	TDJ06206	£18.41
M3.5	0.6	7	56	20	4	3	3	3	TCE06226	£16.51	TDE06226	£20.43	TCJ06226	£16.55	TDJ06226	£20.43
M4	0.7	7	63	21	4.5	3.4	3	3.4	TCE06246	£17.37	TDE06246	£18.76	TCJ06246	£17.37	TDJ06246	£18.76
M4.5	0.75	8	70	25	6	4.9	3	3.8	TCE06266	£15.04	TDE06266	£19.19	TCJ06266	£15.04	TDJ06266	£19.19
M5	0.8	8	70	25	6	4.9	3	4.3	TCE06286	£17.95	TDE06286	£19.19	TCJ06286	£17.95	TDJ06286	£19.19
M6	1	10	80	30	6	4.9	3	5.1	TCE06316	£17.95	TDE06316	£19.19	TCJ06316	£17.95	TDJ06316	£19.19
M7	1	10	80	30	7	5.5	3	6.1	TCE06346	£19.44	TDE06346	£24.69	TCJ06346	£17.64	TDJ06346	£22.90
M8	1.25	13	90	35	8	6.2	3	6.9	TCE06366	£23.20	TDE06366	£26.28	TCJ06366	£23.20	TDJ06366	£26.28
M9	1.25	13	90	35	9	7	3	7.9	TCE06396	£23.46	TDE06396	£30.70	TCJ06396	£23.46	TDJ06396	£30.70
M10	1.5	15	100	39	10	8	3	8.6	TCE06426	£28.02	TDE06426	£31.63	TCJ06426	£28.02	TDJ06426	£31.63
M11	1.5	17	100	40	8	6.2	3	9.6	TCE06466	£31.55	TDE06466	£40.43	TCJ06466	£26.09	TDJ06466	£34.95
M12	1.75	18	110	44	9	7	3	10.3	TCE06506	£37.65	TDE06506	£42.12	TCJ06506	£37.65	TDJ06506	£42.12
M14	2	20	110	44	11	9	3	12.1	TCE06546	£45.61	TDE06546	£50.57	TCJ06546	£45.61	TDJ06546	£50.57
M16	2	20	110	44	12	9	3	14.1	TCE06606	£57.25	TDE06606	£61.06	TCJ06606	£57.25	TDJ06606	£61.06
M18	2.5	25	125	50	14	11	4	15.6	TCE06656	£63.41	TDE06656	£80.26	TCJ06656	£62.79	TDJ06656	£79.53
M20	2.5	25	140	54	16	12	4	17.6	TCE06706	£89.15	TDE06706	£95.96	TCJ06706	£89.15	TDJ06706	£95.01
M22	2.5	25	140	54	18	14.5	4	19.6	TCE06746	£93.79	TDE06746	£117.56	TCJ06746	£96.17	TDJ06746	£119.83
M24	3	30	160	60	18	14.5	4	21.1	TCE06786	£102.09	TDE06786	£129.98	TCJ06786	£101.52	TDJ06786	£129.24
M27	3	30	160	60	20	16	4	24.1	TCE06866	£146.68	TDE06866	£180.74	TCJ06866	£162.05	TDJ06866	£196.13
M30	3.5	35	180	70	22	18	4	26.6	TCE06946	£187.65	TDE06946	£231.18	TCJ06946	£196.13	TDJ06946	£239.88

### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

Series	Steels			Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels <400	Carbon <700	Alloy <850	Pre-Hard <1200	Hardened >1200	Free Mach. <850	Austenitic <850	Fer/Marten. <1000	Grey Cast iron <500	Malleable Cast Iron/Graphite <1000	<700	<1000	Ti <700	Ti Alloy <900
TCE05	15-20	15-20	12-18	10-15	6-10	-	-	-	10-15	5-8	10-15	5-8	10-15	-
TDE05						7-10	5-8	4-6						
TCJ05														
TDJ05						7-10	5-8	4-6						

Series	Titanium	Inconel, Hastelloy, Nickel		Copper, Brass, Bronze			Aluminium			Plastics / Composites				
	Ti Alloy <1300	Nickel <500	Nickel Alloy <900	Cu <350	Cu Alloy Short	Long	Cu-Al-Fe <1500	Al/Mg <350	Al Wrought	Al Si ≤10%	Al Si >10%	Thermo	Thermoset	CFRP/GFRP
TCE05	-	-	-	-	-	-	-	-	-	-	-	-	-	-
TDE05	-	8-12	-	-	8-12	25-35	15-20	-	-	25-35	15-20	10-15	-	-
TCJ05	-	-	-	-	-	-	-	-	-	-	-	-	-	-
TDJ05	-	-	-	-	-	-	-	-	-	-	-	-	-	-

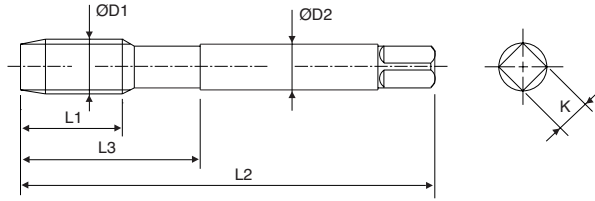


Multi Purpose

7G Tolerance

### METRIC COARSE DIN 13 MACHINE TAPS - SPIRAL FLUTE & POINT 7G TOLERANCE

- Machine taps for multi material tapping
- COMBO tap geometry** - 1st choice for general tapping with exceptional reliability
- Spiral flute for blind holes, spiral point for through holes



Combo

Type	Spiral Flute	Spiral Flute	Spiral Point	Spiral Point
Series	TCE08	TDE08	TCJ08	TDJ08
Brand / Geometry	YG - Combo Tap	YG - Combo Tap	YG - Combo Tap	YG - Combo Tap
Substrate	HSS 5% Cobalt	HSS 5% Cobalt	HSS 5% Cobalt	HSS 5% Cobalt
Surface Treatment	Bright	TIN Coated	Bright	TIN Coated
Tolerance	7G	7G	7G	7G
Helix Angle	R40°	R40°	-	-
Chamfer Lead	Form C: 2-3	Form C: 2-3	Form B: 4-5	Form B: 4-5
Maximum Depth	2.5xD	2.5xD	3xD	3xD
Through Coolant	-	-	-	-
Performance	○○○○○	○○○○○	○○○○○	○○○○○

ØD1	Pitch	L1	L2	L3	K	No. of Flutes	Drill Dia.	Order Code	Price	Order Code	Price	Order Code	Price	Order Code	Price
M2	0.4	8	45	13	2.1	3	1.6	TCE08136	£27.63	TDE08136	£26.96	TCJ08136	£27.63	TDJ08136	£27.01
M2.2	0.45	8	45	13	2.1	3	1.75	TCE08156	£25.74	TDE08156	£29.61	-	-	TDJ08156	£29.86
M2.3	0.4	8	45	13	2.1	3	1.9	TCE08196	£28.84	TDE08196	£32.81	-	-	TDJ08196	£32.90
M2.5	0.45	9	50	15	2.1	3	2.05	TCE08176	£19.00	TDE08176	£23.16	-	-	TDJ08176	£23.36
M2.6	0.45	9	50	15	2.1	3	2.1	TCE08496	£18.22	TDE08496	£22.29	-	-	TDJ08496	£22.29
M3	0.5	6	56	18	2.7	3	2.5	TCE08206	£18.16	TDE08206	£19.19	TCJ08206	£18.16	TDJ08206	£19.19
M3.5	0.6	7	56	20	3	3	2.9	TCE08226	£17.11	TDE08226	£21.32	-	-	TDJ08226	£21.32
M4	0.7	7	63	21	3.4	3	3.3	TCE08246	£18.16	TDE08246	£19.62	TCJ08246	£18.16	TDJ08246	£19.62
M4.5	0.75	8	70	25	4.9	3	3.7	TCE08266	£15.71	TDE08266	£20.08	-	-	TDJ08266	£20.08
M5	0.8	8	70	25	4.9	3	4.2	TCE08286	£18.76	TDE08286	£20.08	TCJ08286	£18.76	TDJ08286	£20.08
M6	1	10	80	30	4.9	3	5	TCE08316	£18.76	TDE08316	£20.08	TCJ08316	£18.76	TDJ08316	£20.08
M7	1	10	80	30	5.5	3	6	TCE08346	£20.43	TDE08346	£25.91	-	-	TDJ08346	£23.89
M8	1.25	13	90	35	6.2	3	6.8	TCE08366	£24.44	TDE08366	£27.32	TCJ08366	£24.44	TDJ08366	£27.32
M9	1.25	13	90	35	7	3	7.8	TCE08396	£24.51	TDE08396	£32.18	-	-	TDJ08396	£32.18
M10	1.5	15	100	39	8	3	8.5	TCE08426	£29.25	TDE08426	£33.14	TCJ08426	£29.25	TDJ08426	£33.14
M11	1.5	17	100	40	6.2	3	9.5	TCE08466	£32.90	TDE08466	£42.32	-	-	TDJ08466	£36.57
M12	1.75	18	110	44	7	3	10.2	TCE08506	£39.30	TDE08506	£43.96	TCJ08506	£39.30	TDJ08506	£43.96
M14	2	20	110	44	9	3	12	TCE08546	£47.66	TDE08546	£52.94	TCJ08546	£47.66	TDJ08546	£52.94
M16	2	20	110	44	9	3	14	TCE08606	£59.91	TDE08606	£63.85	TCJ08606	£59.91	TDJ08606	£63.85
M18	2.5	25	125	50	11	3	15.5	TCE08656	£66.32	TDE08656	£83.90	-	-	TDJ08656	£83.16
M20	2.5	25	140	54	12	3	17.5	TCE08706	£93.26	TDE08706	£100.34	TCJ08706	£93.26	TDJ08706	£99.43
M22	2.5	25	140	54	14.5	3	19.5	TCE08746	£98.02	TDE08746	£122.97	-	-	TDJ08746	£125.47
M24	3	30	160	60	14.5	3	21	TCE08786	£106.77	TDE08786	£135.83	-	-	TDJ08786	£135.14
M27	3	30	160	60	16	3	24	TCE08866	£153.37	TDE08866	£188.96	-	-	TDJ08866	£205.09
M30	3.5	35	180	70	18	3	26.5	TCE08946	£196.13	TDE08946	£241.83	-	-	TDJ08946	£250.71

METRIC COARSE MACHINE TAPS

#### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels <400	Carbon <700	Alloy <850	Alloy <850	Pre-Hard ≤1200	Hardened >1200	Free Mach. <850	Austenitic <850	Fer/Marten. <1000	Grey Cast iron <500	Malleable Cast Iron/Graphite <1000	<700	<1000	Ti <700	Ti Alloy <900
TCE07	15-20	15-20	12-18	10-15	6-10	-	7-10	5-8	4-6	10-15	5-8	10-15	5-8	10-15	-
TDE07	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
TCJ07	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
TDJ07	-	-	-	-	-	-	7-10	5-8	4-6	-	-	-	-	-	-

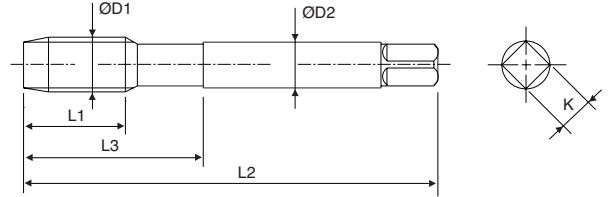
Series	Titanium	Inconel, Hastelloy, Nickel		Copper, Brass, Bronze			Aluminium			Plastics / Composites					
	Ti Alloy ≤1300	Nickel <500	Nickel Alloy <900	Nickel Alloy ≤1400	Cu <350	Cu Alloy Short	Long	Cu-Al-Fe <1500	Al/Mg <350	Al Wrought	Al Si ≤10%	Al Si >10%	Thermo	Thermoset	CFRP/GFRP
TCE07	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
TDE07	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
TCJ07	-	8-12	-	-	8-12	25-35	15-20	-	-	25-35	15-20	10-15	-	-	-
TDJ07	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-



High Resistance / Hardened Steel

### METRIC COARSE DIN 13 MACHINE TAPS - SPIRAL FLUTE

- Machine taps for tapping high alloy steels, tool steels and hardened steels
- YG-HR** TiAlN coated HSS for general tapping performance
- UFS-HR** TiAlN coated powder metal for high performance tapping and ultimate tool life
- R15° helix flute for higher strength in tapping hard materials
- Spiral flute for blind holes



Series	TY313	K40M-TXC	K40MFOR-TXC
Brand / Geometry	YG - HR	UFS Top Line - HR	UFS Top Line - HR
Substrate	HSS 5% Cobalt	HSS Powder Metal	HSS Powder Metal
Surface Treatment	TiAlN Coated	TXC Coated	TXC Coated
Tolerance	6H	6HX	6HX
Helix Angle	R40°	R15°	R15°
Chamfer Lead	Form C: 2-3	Form C: 2-3	Form C: 2-3
Maximum Depth	2.5xD	1.5xD	2.5xD
Through Coolant	-	-	☑
Performance	○○○○○	○○○○○	○○○○○

ØD1	Pitch	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price	Order Code	Price	Order Code	Price
M2	0.4	8	45	13	2.8	2.1	3	1.6	TY313136	£28.01	-	-	-	-
M3	0.5	11	56	18	3.5	2.7	3	2.5	TY313206	£22.41	-	-	-	-
M4	0.7	13	63	21	4.5	3.4	3	3.3	TY313246	£22.41	-	-	-	-
M5	0.8	15	70	25	6	4.9	3	4.2	TY313286	£22.81	-	-	-	-
M6	1	17	80	30	6	4.9	3	5	TY313316	£22.57	-	-	-	-
M8	1.25	20	90	35	8	6.2	3	6.8	TY313366	£32.27	-	-	-	-
M10	1.5	22	100	39	10	8	3	8.5	TY313426	£37.65	-	-	-	-
M12	1.75	24	110	44	9	7	3	10.2	TY313506	£47.07	-	-	-	-
M14	2	26	110	44	11	9	3	12	TY313546	£57.11	-	-	-	-
M16	2	27	110	44	12	9	3	14	TY313606	£63.98	-	-	-	-
M20	2.5	32	140	54	16	12	4	17.5	TY313706	£113.60	-	-	-	-
M3	0.5	5	56	-	3.5	2.7	3	2.5	-	-	K40M3TXC	£24.52	-	-
M4	0.7	7	63	-	4.5	3.4	3	3.3	-	-	K40M4TXC	£24.52	-	-
M5	0.8	8	70	-	6	4.9	3	4.2	-	-	K40M5TXC	£24.52	-	-
M6	1	10	80	-	6	4.9	3	5	-	-	K40M6TXC	£24.52	K40M6FOR-TXC	£52.31
M8	1.25	13	90	-	8	6.2	3	6.8	-	-	K40M8TXC	£31.67	K40M8FOR-TXC	£64.19
M10	1.5	15	100	-	10	8	3	8.5	-	-	K40M10TXC	£34.34	K40M10FOR-TXC	£71.50
M12	1.75	18	110	-	9	7	4	10.3	-	-	K41M12TXC	£42.86	K41M12FOR-TXC	£84.98
M14	2	20	110	-	11	9	4	12	-	-	K41M14TXC	£69.42	K41M14FOR-TXC	£103.96
M16	2	20	110	-	12	9	4	14	-	-	K41M16TXC	£66.55	K41M16FOR-TXC	£113.93

#### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

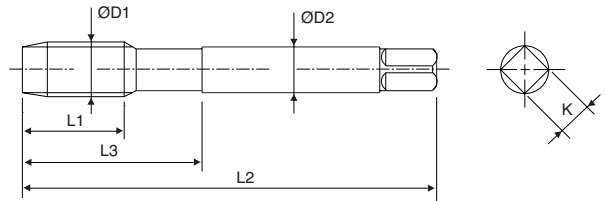
Series	Steels			Hardened Steels		Stainless Steels			Cast Iron			Titanium			
	Soft Steels	Carbon	Alloy	Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite	Ti	Ti Alloy			
TY313	<400	<700	<850	<1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900	
K40M-TXC	-	-	-	6-10	3-5	-	-	4-6	-	-	-	-	-	-	
K40MFOR	-	-	-	5-12	5-8	-	-	-	-	-	15-20	20-25	-	-	
Series	Titanium			Inconel, Hastelloy, Nickel			Copper, Brass, Bronze			Aluminium			Plastics / Composites		
	Ti Alloy	Nickel	Nickel Alloy	Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP		
TY313	≤1300	<500	<900	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	8-12	5-7		
K40M-TXC	-	-	-	-	25-35	-	3-5	-	-	-	-	-	-		
K40MFOR	-	-	-	-	25-30	-	-	-	-	-	25-30	-	-		



High Resistance / Hardened Steel

METRIC COARSE DIN 13 MACHINE TAPS - STRAIGHT FLUTE & SPIRAL POINT

- Machine taps for tapping high alloy steels, tool steels and hardened steels
- YG-HR TiAlN coated HSSE for general tapping performance
- UFS-HR TiAlN coated powder metal for high performance tapping and ultimate tool life
- Spiral point for through holes



Type	Spiral Point	Straight Flute	Straight Flute
Series	TY283	K20M-TXC	K22MFOR-TXC
Brand / Geometry	YG - HR	UFS Top Line - HR	UFS Top Line - HR
Substrate	HSS 5% Cobalt	HSS Powder Metal	HSS Powder Metal
Surface Treatment	TiAlN Coated	TXC Coated	TXC Coated
Tolerance	6H	6HX	6HX
Helix Angle	-	-	-
Chamfer Lead	Form B: 4-5	Form B: 4-5	Form B: 4-5
Maximum Depth	3xD	3xD	3.5xD
Through Coolant	-	-	
Performance			

ØD1	Pitch	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price	Order Code	Price	Order Code	Price
M2	0.4	8	45	13	2.8	2.1	3	1.6	TY283136	£28.01	-	-	-	-
M3	0.5	11	56	18	3.5	2.7	3	2.5	TY283206	£22.41	-	-	-	-
M4	0.7	13	63	21	4.5	3.4	3	3.3	TY283246	£22.41	-	-	-	-
M5	0.8	15	70	25	6	4.9	3	4.2	TY283286	£22.81	-	-	-	-
M6	1	17	80	30	6	4.9	3	5	TY283316	£22.57	-	-	-	-
M8	1.25	20	90	35	8	6.2	3	6.8	TY283366	£32.27	-	-	-	-
M10	1.5	22	100	39	10	8	3	8.5	TY283426	£37.65	-	-	-	-
M12	1.75	24	110	44	9	7	3	10.2	TY283506	£47.07	-	-	-	-
M14	2	26	110	44	11	9	3	12	TY283546	£57.11	-	-	-	-
M16	2	27	110	44	12	9	3	14	TY283606	£63.98	-	-	-	-
M20	2.5	32	140	54	16	12	4	17.5	TY283706	£113.60	-	-	-	-
M3	0.5	10	56	-	3.5	2.7	3	2.5	-	-	K20M3TXC	£29.91	-	-
M4	0.7	13	63	-	4.5	3.4	3	3.3	-	-	K20M4TXC	£29.91	-	-
M5	0.8	13	70	-	6	4.9	3	4.2	-	-	K20M5TXC	£29.91	-	-
M6	1	16	80	-	6	4.9	3	5	-	-	K20M6TXC	£29.91	K22M6FOR-TXC	£51.65
M8	1.25	18	90	-	8	6.2	3	6.8	-	-	K20M8TXC	£37.61	K22M8FOR-TXC	£62.29
M10	1.5	20	100	-	10	8	3	8.5	-	-	K20M10TXC	£40.45	K22M10FOR-TXC	£74.07
M12	1.75	25	110	-	9	7	4	10.3	-	-	K21M12TXC	£51.83	K23M12FOR-TXC	£83.46
M14	2	28	110	-	11	9	4	12	-	-	K21M14TXC	£67.31	K23M14FOR-TXC	£101.89
M16	2	28	110	-	12	9	4	14	-	-	K21M16TXC	£78.99	K23M16FOR-TXC	£113.56

Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

Series	Steels			Hardened Steels		Stainless Steels			Cast Iron			Titanium			
	Soft Steels	Carbon	Alloy	Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast Iron	Malleable Cast Iron/Graphite	Ti	Ti Alloy			
TY283	<400	<700	<850	<1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000			
K20M-TXC	-	-	-	6-10	3-5	-	-	4-6	-	-	-	-			
K22MFOR	-	-	-	5-12	5-8	-	-	-	-	15-20	20-25	-			
Series	Titanium			Inconel, Hastelloy, Nickel			Copper, Brass, Bronze			Aluminium			Plastics / Composites		
	Ti Alloy	Nickel	Nickel Alloy	Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP		
TY283	≤1300	<500	<900	<350	Short	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	-		
K20M-TXC	-	-	-	-	25-35	3-5	-	-	-	-	8-12	5-7	-		
K22MFOR	-	-	-	-	25-30	-	-	-	-	25-30	-	-	-		



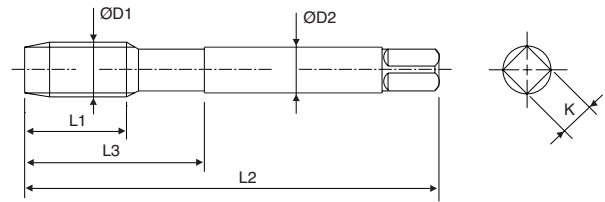
METRIC COARSE MACHINE TAPS



Stainless Steel

### METRIC COARSE DIN 13 MACHINE TAPS - SPIRAL FLUTE

- Machine taps for tapping high stainless steels
- YG-INOX** hardslick coated HSSE for general tapping performance on stainless steels
- UFS-TOP LINE** vanadium cobalt for high performance tapping.
- UFS-TOP LINE** powder metal INOX taper for highest performance tapping and longest tool life
- Spiral flute for blind holes



Series
Brand / Geometry
Substrate
Surface Treatment
Tolerance
Helix Angle
Chamfer Lead
Maximum Depth
Through Coolant
Performance

	TCH14	V82M-TXC	K82M-TXC
Brand / Geometry	YG - INOX	UFS Top Line - INOX	UFS Top Line- INOX
Substrate	HSS 5% Cobalt	HSS Vanadium Cobalt	HSS Powder Metal
Surface Treatment	Hardslick Coated	TXC Coated	TXC Coated
Tolerance	6H	6HX	6HX
Helix Angle	R40°	R48°	R48°
Chamfer Lead	Form C: 2-3	Form C: 2-3	Form C: 2-3
Maximum Depth	2.5xD	3.5xD	3.5xD
Through Coolant	-	-	-
Performance	○○○○○	○○○○○	○○○○○

ØD1	Pitch	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price	Order Code	Price	Order Code	Price
M2	0.4	8	45	13	2.8	2.1	3	1.6	TCH14136	£24.72	-	-	-	-
M2.5	0.45	9	50	15	2.8	2.1	3	2.05	TCH14176	£21.48	-	-	-	-
M3	0.5	6	56	18	3.5	2.7	3	2.5	TCH14206	£18.41	-	-	-	-
M3.5	0.6	7	56	20	4	3	3	2.9	TCH14226	£20.02	-	-	-	-
M4	0.7	7	63	21	4.5	3.4	3	3.3	TCH14246	£18.51	-	-	-	-
M4.5	0.75	8	70	25	6	4.9	3	3.7	TCH14266	£19.03	-	-	-	-
M5	0.8	8	70	25	6	4.9	3	4.2	TCH14286	£19.03	-	-	-	-
M6	1	10	80	30	6	4.9	3	5	TCH14316	£19.78	-	-	-	-
M7	1	10	80	30	7	5.5	3	6	TCH14346	£26.86	-	-	-	-
M8	1.25	13	90	35	8	6.2	3	6.8	TCH14366	£27.64	-	-	-	-
M9	1.25	13	90	35	9	7	3	7.8	TCH14396	£31.31	-	-	-	-
M10	1.5	15	100	39	10	8	3	8.5	TCH14426	£32.50	-	-	-	-
M11	1.5	17	100	40	8	6.2	3	9.5	TCH14466	£38.84	-	-	-	-
M12	1.75	18	110	44	9	7	3	10.2	TCH14506	£40.13	-	-	-	-
M14	2	20	110	44	11	9	3	12	TCH14546	£45.97	-	-	-	-
M16	2	20	110	44	12	9	3	14	TCH14606	£54.66	-	-	-	-
M18	2.5	25	125	50	14	11	4	15.5	TCH14656	£73.62	-	-	-	-
M20	2.5	25	140	54	16	12	4	17.5	TCH14706	£96.47	-	-	-	-
M22	2.5	25	140	54	18	14.5	4	19.5	TCH14746	£111.70	-	-	-	-
M24	3	30	160	60	18	14.5	4	21	TCH14786	£132.81	-	-	-	-
M27	3	30	160	60	20	16	4	24	TCH14866	£179.56	-	-	-	-
M30	3.5	35	180	70	22	18	4	26.5	TCH14946	£225.49	-	-	-	-
M3	0.5	10	56	-	3.5	2.7	3	2.5	-	-	V82M3TXC	£17.84	-	-
M4	0.7	13	63	-	4.5	3.4	3	3.3	-	-	V82M4TXC	£17.84	K82M4X-TXC	£27.34
M5	0.8	13	70	-	6	4.9	3	4.2	-	-	V82M5TXC	£17.84	K82M5X-TXC	£27.34
M6	1	16	80	-	6	4.9	3	5	-	-	V82M6TXC	£17.84	K82M6X-TXC	£27.34
M8	1.25	18	90	-	8	6.2	3	6.8	-	-	V82M8TXC	£22.11	K82M8X-TXC	£32.05
M10	1.5	20	100	-	10	8	3	8.5	-	-	V82M10TXC	£24.94	K82M10X-TXC	£37.62
M12	1.75	25	110	-	9	7	4	10.3	-	-	V83M12TXC	£30.41	K83M12X-TXC	£50.71
M14	2	28	110	-	11	9	4	12	-	-	V83M14TXC	£48.34	K83M14X-TXC	£64.95
M16	2	28	110	-	12	9	4	14	-	-	V83M16TXC	£42.86	K83M16X-TXC	£72.33
M20	2.5	33	140	-	16	12	4	17.5	-	-	V83M20TXC	£80.40	-	-
M24	3	39	160	-	18	14.5	4	21	-	-	V83M24TXC	£116.80	-	-

Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast Iron	Malleable Cast Iron/Graphite			Ti	Ti Alloy
TCH14	<400	<700	<850	<850	<1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
V82M	-	15-20	-	10-15	-	-	7-10	5-8	-	-	-	-	-	-	-
K82M	-	-	20-25	15-20	5-12	-	10-15	8-10	6-8	-	-	-	-	-	-
Series	Titanium				Copper, Brass, Bronze				Aluminium			Plastics / Composites			
	Ti Alloy	Nickel	Nickel Alloy		Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP	
TCH14	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	
V82M	-	-	-	-	-	-	-	-	-	-	-	-	-	-	
K82M	-	-	-	-	-	-	-	-	-	-	-	-	-	-	

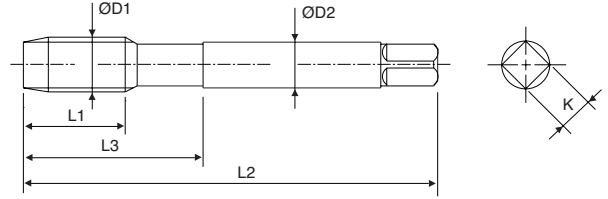




Stainless Steel

METRIC COARSE DIN 13 MACHINE TAPS - SPIRAL POINT

- Machine taps for tapping high stainless steels
- YG-INOX hardslick coated HSSE for general tapping performance on stainless steels
- UFS-TOP LINE vanadium cobalt for high performance tapping.
- UFS-TOP LINE powder metal INOX taper for highest performance tapping and longest tool life
- Spiral point for through holes



Series
Brand / Geometry
Substrate
Surface Treatment
Tolerance
Helix Angle
Chamfer Lead
Maximum Depth
Through Coolant
Performance

	TCH23	V24M-TXC	K24M-TXC
Brand / Geometry	YG - INOX	UFS Top Line - INOX	UFS Top Line - INOX
Substrate	HSS 5% Cobalt	HSS Vanadium Cobalt	HSS Powder Metal
Surface Treatment	Hardslick Coated	TXC Coated	TXC Coated
Tolerance	6H	6HX	6HX
Helix Angle	R40°	R48°	R48°
Chamfer Lead	Form B: 4-5	Form B: 4-5	Form B: 4-5
Maximum Depth	2.5xD	3xD	3xD
Through Coolant	-	-	-
Performance	○○○○○	○○○○○	○○○○○

ØD1	Pitch	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price	Order Code	Price	Order Code	Price
M2	0.4	8	45	13	2.8	2.1	3	1.6	TCH23136	£22.69	-	-	-	-
M2.5	0.45	9	50	15	2.8	2.1	3	2.05	TCH23176	£20.00	-	-	-	-
M3	0.5	6	56	18	3.5	2.7	3	2.5	TCH23206	£17.00	-	-	-	-
M3.5	0.6	7	56	20	4	3	3	2.9	TCH23226	£18.41	-	-	-	-
M4	0.7	7	63	21	4.5	3.4	3	3.3	TCH23246	£17.00	-	-	-	-
M4.5	0.75	8	70	25	6	4.9	3	3.7	TCH23266	£17.47	-	-	-	-
M5	0.8	8	70	25	6	4.9	3	4.2	TCH23286	£17.47	-	-	-	-
M6	1	10	80	30	6	4.9	3	5	TCH23316	£18.32	-	-	-	-
M7	1	10	80	30	7	5.5	3	6	TCH23346	£25.15	-	-	-	-
M8	1.25	13	90	35	8	6.2	3	6.8	TCH23366	£25.92	-	-	-	-
M9	1.25	13	90	35	9	7	3	7.8	TCH23396	£29.19	-	-	-	-
M10	1.5	15	100	39	10	8	3	8.5	TCH23426	£30.38	-	-	-	-
M11	1.5	17	100	40	8	6.2	3	9.5	TCH23466	£35.23	-	-	-	-
M12	1.75	18	110	44	9	7	3	10.2	TCH23506	£37.59	-	-	-	-
M14	2	20	110	44	11	9	3	12	TCH23546	£43.50	-	-	-	-
M16	2	20	110	44	12	9	3	14	TCH23606	£51.49	-	-	-	-
M18	2.5	25	125	50	14	11	4	15.5	TCH23656	£69.03	-	-	-	-
M20	2.5	25	140	54	16	12	4	17.5	TCH23706	£90.84	-	-	-	-
M22	2.5	25	140	54	18	14.5	4	19.5	TCH23746	£104.80	-	-	-	-
M24	3	30	160	60	18	14.5	4	21	TCH23786	£125.36	-	-	-	-
M27	3	30	160	60	20	16	4	24	TCH23866	£168.78	-	-	-	-
M30	3.5	35	180	70	22	18	4	26.5	TCH23946	£211.65	-	-	-	-
M3	0.5	10	56	-	3.5	2.7	3	2.5	-	-	V24M3TXC	£17.84	K24M3X-TXC	£24.90
M4	0.7	13	63	-	4.5	3.4	3	3.3	-	-	V24M4TXC	£17.84	K24M4X-TXC	£24.90
M5	0.8	13	70	-	6	4.9	3	4.2	-	-	V24M5TXC	£17.84	K24M5X-TXC	£24.90
M6	1	16	80	-	6	4.9	3	5	-	-	V24M6TXC	£17.84	K24M6X-TXC	£24.90
M8	1.25	18	90	-	8	6.2	3	6.8	-	-	V24M8TXC	£22.11	K24M8X-TXC	£31.21
M10	1.5	20	100	-	10	8	3	8.5	-	-	V24M10TXC	£22.02	K24M10X-TXC	£37.62
M12	1.75	25	110	-	9	7	4	10.3	-	-	V25M12TXC	£30.41	K25M12X-TXC	£43.63
M14	2	28	110	-	11	9	4	12	-	-	V25M14TXC	£35.20	K25M14X-TXC	£72.25
M16	2	28	110	-	12	9	4	14	-	-	V25M16TXC	£42.86	-	-
M20	2.5	33	140	-	16	12	4	17.5	-	-	V25M20TXC	£80.40	-	-
M24	3	39	160	-	18	14.5	4	21	-	-	V25M24TXC	£116.80	-	-

Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

Series	Steels				Hardened Steels		Stainless Steels			Cast Iron			Titanium		
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast Iron	Malleable Cast Iron/Graphite		Ti	Ti Alloy	
TCH23	<400	<700	<850	<850	-	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
V24M	20-25	20-25	18-24	15-20	-	-	10-13	8-11	6-8	-	-	-	-	-	-
K24M	-	15-20	-	10-15	-	-	7-10	5-8	-	-	-	-	-	-	-
	-	-	20-25	15-20	5-12	-	10-15	8-10	6-8	-	-	-	-	-	-
Series	Titanium				Copper, Brass, Bronze				Aluminium			Plastics / Composites			
	Ti Alloy	Nickel	Nickel Alloy		Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP	
TCH23	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	
V24M	-	-	-	-	-	-	-	-	-	-	-	-	-	-	
K24M	-	-	-	-	-	-	-	-	-	-	-	-	-	-	

METRIC COARSE MACHINE TAPS

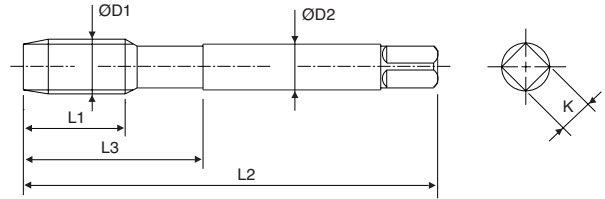


NI

Exotics  
Nickel Alloys

### METRIC COARSE DIN 13 MACHINE TAPS - SPIRAL FLUTE

- Specially designed for tapping nickel alloys such as inconel, hastelloy, waspaloy
- **YG-NI** powder metal for reliable tapping performance
- **UFS-TOP LINE** powder metal with R10° helix for higher strength in high performance tapping applications
- Spiral flute for blind holes



Series	TZ933	K42M-NI
Brand / Geometry	YG - NI	UFS Top Line - NI
Substrate	HSS Powder Metal	HSS Powder Metal
Surface Treatment	TiAlN Coated	TiCN Coated
Tolerance	6H	6HX
Helix Angle	R40°	R10°
Chamfer Lead	Form C: 2-3	Form C: 2-3
Maximum Depth	2.5xD	1.5xD
Through Coolant	-	-
Performance	●●●●○	●●●●●

ØD1	Pitch	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price	Order Code	Price
M3	0.5	6	56	18	3.5	2.7	3	2.5	TZ933206	£16.94	-	-
M4	0.7	7	63	21	4.5	3.4	3	3.3	TZ933246	£17.28	-	-
M5	0.8	8	70	25	6	4.9	3	4.2	TZ933286	£17.87	-	-
M6	1	10	80	30	6	4.9	3	5	TZ933316	£18.79	-	-
M8	1.25	13	90	35	8	6.2	3	6.8	TZ933366	£26.78	-	-
M10	1.5	15	100	39	10	8	3	8.5	TZ933426	£32.21	-	-
M12	1.75	18	110	44	9	7	3	10.2	TZ933506	£40.71	-	-
M3	0.5	10	56	-	3.5	2.7	3	2.5	-	-	K42M3NI-CT	£31.14
M4	0.7	13	63	-	4.5	3.4	3	3.3	-	-	K42M4NI-CT	£30.95
M5	0.8	15	70	-	6	4.9	3	4.2	-	-	K42M5NI-CT	£31.05
M6	1	18	80	-	6	4.9	3	5	-	-	K42M6NI-CT	£31.05
M8	1.25	25	90	-	8	6.2	3	6.8	-	-	K42M8NI-CT	£37.12
M10	1.5	30	100	-	10	8	3	8.5	-	-	K42M10NI-CT	£43.40
M12	1.75	50	110	-	12	9	4	10.3	-	-	K42M12NI-CT	£51.83

### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

Series	Steels			Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels	Carbon	Alloy	Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite			Ti	Ti Alloy
TZ933	<400	<700	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
K52M-NI	-	-	12-18	-	5-8	-	-	-	-	-	-	-	-	-
Series	Titanium			Copper, Brass, Bronze			Aluminium			Plastics / Composites				
	Ti Alloy	Inconel, Hastelloy, Nickel	Nickel Alloy	Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP	
TZ933	≤1300	<500	<900	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	
K52M-NI	4-6	-	10-15	-	-	-	3-5	5-8	-	-	-	-	-	

METRIC COARSE MACHINE TAPS

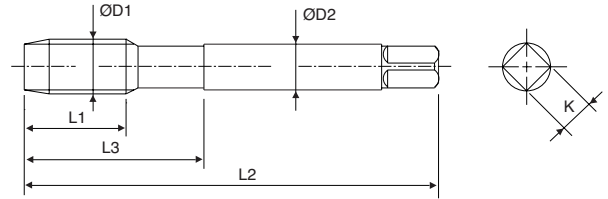


NI

Exotics  
Nickel Alloys

### METRIC COARSE DIN 13 MACHINE TAPS - SPIRAL POINT

- Specially designed for tapping nickel alloys such as inconel, hastelloy, waspaloy
- **YG-NI** TiCN coated HSSE for reliable tapping performance
- **UFS-TOP LINE** powder metal L10° helix for higher strength in high performance tapping applications
- Spiral point for blind holes



Series	TZ923	K42M-NI
Brand / Geometry	YG - NI	UFS Top Line - NI
Substrate	HSS Powder Metal	HSS Powder Metal
Surface Treatment	TiAlN Coated	TiCN Coated
Tolerance	6H	6HX
Helix Angle	-	L10°
Chamfer Lead	Form B: 4-5	Form D: 4-5
Maximum Depth	3xD	3xD
Through Coolant	-	-
Performance	●●●●○	●●●●●

ØD1	Pitch	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price	Order Code	Price
M3	0.5	11	56	18	3.5	2.7	3	2.5	TZ923206	£15.72	-	-
M4	0.7	13	63	21	4.5	3.4	3	3.3	TZ923246	£15.86	-	-
M5	0.8	15	70	25	6	4.9	3	4.2	TZ923286	£16.59	-	-
M6	1	17	80	30	6	4.9	3	5	TZ923316	£17.44	-	-
M8	1.25	20	90	35	8	6.2	3	6.8	TZ923366	£25.19	-	-
M10	1.5	22	100	39	10	8	3	8.5	TZ923426	£30.36	-	-
M12	1.75	24	110	44	9	7	3	10.2	TZ923506	£38.48	-	-
M4	0.7	13	63	-	4.5	3.4	3	3.3	-	-	K52M4NI-CT	£31.24
M5	0.8	15	70	-	6	4.9	3	4.2	-	-	K52M5NI-CT	£31.24
M6	1	18	80	-	6	4.9	3	5	-	-	K52M6NI-CT	£31.24
M8	1.25	25	90	-	8	6.2	3	6.8	-	-	K52M8NI-CT	£38.36
M10	1.5	30	100	-	10	8	3	8.5	-	-	K52M10NI-CT	£42.73
M12	1.75	50	110	-	12	9	4	10.3	-	-	K52M12NI-CT	£51.57

METRIC COARSE MACHINE TAPS

### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

Series	Steels			Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels	Carbon	Alloy	Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite			Ti	Ti Alloy
TZ923	<400	<700	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
K42M-NI	-	-	12-18	-	-	-	-	-	-	-	-	-	-	-
Series	Titanium			Copper, Brass, Bronze			Aluminium			Plastics / Composites				
	Ti Alloy	Nickel	Nickel Alloy	Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP	
TZ923	≤1300	<500	<900	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	
K42M-NI	4-6	-	10-15	-	-	-	3-5	-	-	-	-	-	-	



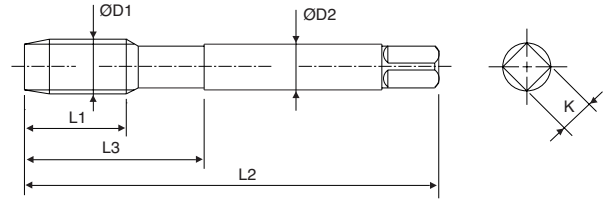


NI

Exotics  
Titanium Alloys

## METRIC COARSE DIN 13 MACHINE TAPS - SPIRAL FLUTE

- Specially designed for tapping titanium and ti-alloys
- **YG-TI** powder metal with R25° helix for reliable tapping performance
- **UFS-TOP LINE** powder metal L15° helix for higher strength in high performance tapping applications
- Spiral flute for blind holes



Series	TZ903	K42M-CT
Brand / Geometry	YG - NI	UFS Top Line - NI
Substrate	HSS Powder Metal	HSS Powder Metal
Surface Treatment	TiAlN Coated	TiCN Coated
Tolerance	6H	6HX
Helix Angle	R25°	R15°
Chamfer Lead	Form C: 2-3	Form C: 2-3
Maximum Depth	2.5xD	1.5xD
Through Coolant	-	-
Performance	★★★★○	★★★★○

ØD1	Pitch	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price	Order Code	Price
M3	0.5	11	56	18	3.5	2.7	3	2.5	TZ903206	£16.94	-	-
M4	0.7	13	63	21	4.5	3.4		3.3	TZ903246	£17.28	-	-
M5	0.8	15	70	25	6	4.9		4.2	TZ903286	£17.87	-	-
M6	1	17	80	30	6	4.9		5	TZ903316	£18.79	-	-
M8	1.25	20	90	35	8	6.2		6.8	TZ903366	£26.78	-	-
M10	1.5	22	100	39	10	8		8.5	TZ903426	£32.21	-	-
M12	1.75	24	110	44	9	7	10.2	TZ903506	£40.71	-	-	
M3	0.5	10	56	-	3.5	2.7	3	2.5	-	-	K42M3CT	£22.16
M4	0.7	13	63	-	4.5	3.4		3.3	-	-	K42M4CT	£22.16
M5	0.8	15	70	-	6	4.9		4.2	-	-	K42M5CT	£22.16
M6	1	18	80	-	6	4.9		5	-	-	K42M6CT	£22.16
M8	1.25	25	90	-	8	6.2		6.8	-	-	K42M8CT	£28.48
M10	1.5	30	100	-	10	8		8.5	-	-	K42M10CT	£30.98
M12	1.75	50	110	-	12	9	10.3	-	-	K43M12CT	£41.80	
M16	2	28	110	-	12	9	14	-	-	K43M16CT	£73.96	

### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium		
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite			Ti	Ti Alloy	
TZ903	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900	
K42M-TI	-	-	-	-	-	-	-	-	-	-	-	-	-	10-15	8-12	
														5-10	4-8	
Series	Titanium			Inconel, Hastelloy, Nickel			Copper, Brass, Bronze				Aluminium			Plastics / Composites		
	Ti Alloy	Nickel	Nickel Alloy				Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP
TZ903	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	-	
K42M-TI	4-6	-	-	-	-	-	-	-	-	-	-	-	-	-	-	
	2-4	-	-	-	-	-	-	-	-	-	-	-	-	-	-	

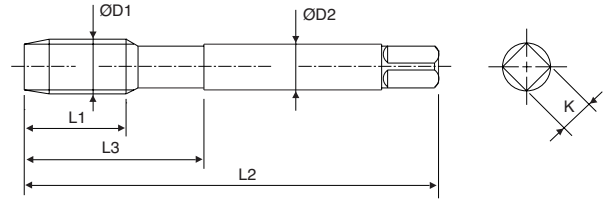


NI

Exotics  
Titanium Alloys

### METRIC COARSE DIN 13 MACHINE TAPS - SPIRAL POINT

- Specially designed for tapping titanium and ti-alloys
- YG-NI TiCN coated HSSE for reliable tapping performance
- UFS-TOP LINE powder metal L15° helix for higher strength in high performance tapping applications
- Spiral point for blind holes



Series	TZ293	K52M-CT
Brand / Geometry	YG - NI	UFS Top Line - NI
Substrate	HSS Powder Metal	HSS Powder Metal
Surface Treatment	TiAlN Coated	TiCN Coated
Tolerance	6H	6HX
Helix Angle	-	L15°
Chamfer Lead	Form B: 4-5	Form D: 4-5
Maximum Depth	3xD	3xD
Through Coolant	-	-
Performance	●●●●○	●●●●●

ØD1	Pitch	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price	Order Code	Price
M3	0.5	11	56	18	3.5	2.7	3	2.5	TZ293206	£17.18	-	-
M4	0.7	13	63	21	4.5	3.4		3.3	TZ293246	£17.28	-	-
M5	0.8	15	70	25	6	4.9		4.2	TZ293286	£17.92	-	-
M6	1	17	80	30	6	4.9		5	TZ293316	£18.79	-	-
M8	1.25	20	90	35	8	6.2		6.8	TZ293366	£26.88	-	-
M10	1.5	22	100	39	10	8		8.5	TZ293426	£32.21	-	-
M12	1.75	24	110	44	9	7	10.2	TZ293506	£41.02	-	-	
M3	0.5	10	56	-	3.5	2.7	3	2.5	-	-	K52M3CT	£23.15
M4	0.7	13	63	-	4.5	3.4		3.3	-	-	K52M4CT	£23.15
M5	0.8	13	70	-	6	4.9		4.2	-	-	K52M5CT	£23.15
M6	1	16	80	-	6	4.9		5	-	-	K52M6CT	£23.15
M8	1.25	18	90	-	8	6.2		6.8	-	-	K52M8CT	£27.87
M10	1.5	20	100	-	10	8		8.5	-	-	K52M10CT	£40.26
M12	1.75	25	110	-	9	7	10.3	-	-	K53M12CT	£47.57	
M16	2	28	110	-	12	9	14	-	-	K53M16CT	£71.02	

METRIC COARSE MACHINE TAPS

#### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

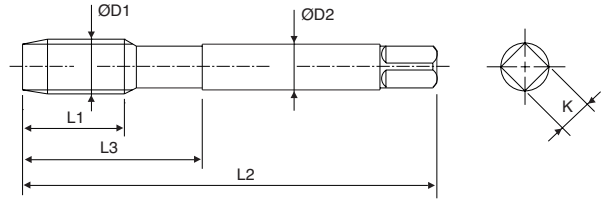
Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/ Graphite			Ti	Ti Alloy
TZ293	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
K52M-TI	-	-	-	-	-	-	-	-	-	-	-	-	-	10-15	8-12
														5-10	4-8
Series	Titanium			Inconel, Hastelloy, Nickel			Copper, Brass, Bronze			Aluminium			Plastics / Composites		
	Ti Alloy	Nickel	Nickel Alloy	Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP		
TZ293	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	-
K52M-TI	4-6	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	2-4	-	-	-	-	-	-	-	-	-	-	-	-	-	-



Aluminium & Non-Ferrous

### METRIC COARSE DIN 13 MACHINE TAPS - SPIRAL FLUTE

- Machine taps for tapping aluminium, plastic, copper and brass
- Deep flute pockets aid chip evacuation and prevents chip build up in soft materials
- Bright finish prevents built-up edge in sticky materials
- TiAlN +C Coating offers exceptional wear resistance in short-medium chipping aluminium alloys, aerospace aluminium and copper alloys
- Spiral flute for blind holes



Series	TC163	E70M	E70M-TXC
Brand / Geometry	YG - Alu	UFS Top Line - Alu	UFS Top Line - Alu
Substrate	HSS 5% Cobalt	HSS 5% Cobalt	HSS 5% Cobalt
Surface Treatment	Bright	Bright	TiAlN+C
Tolerance	6H	6H	6H
Helix Angle	R45°	R45°	R45°
Chamfer Lead	Form C: 2-3	Form C: 2-3	Form C: 2-3
Maximum Depth	2.5xD	3xD	3xD
Through Coolant	-	-	-
Performance	○○○○○	○○○○○	○○○○○

ØD1	Pitch	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price	Order Code	Price	Order Code	Price
M2	0.4	8	45	13	2.8	2.1	3	1.6	TC163136	£15.42	-	-	-	-
M2.5	0.45	9	50	15	2.8	2.1	3	2.05	TC163176	£13.97	-	-	-	-
M3	0.5	11	56	18	3.5	2.7	3	2.5	TC163206	£11.07	-	-	-	-
M4	0.7	13	63	21	4.5	3.4	3	3.3	TC163246	£11.07	-	-	-	-
M5	0.8	15	70	25	6	4.9	3	4.2	TC163286	£11.56	-	-	-	-
M6	1	17	80	30	6	4.9	3	5	TC163316	£11.56	-	-	-	-
M8	1.25	20	90	35	8	6.2	3	6.8	TC163366	£14.87	-	-	-	-
M10	1.5	22	100	39	10	8	3	8.5	TC163426	£17.83	-	-	-	-
M12	1.75	24	110	44	9	7	3	10.2	TC163506	£23.80	-	-	-	-
M14	2	26	110	44	11	9	3	12	TC163546	£28.89	-	-	-	-
M16	2	27	110	44	12	9	3	14	TC163606	£36.21	-	-	-	-
M18	2.5	30	125	50	14	11	3	15.5	TC163656	£47.34	-	-	-	-
M20	2.5	32	140	54	16	12	3	17.5	TC163706	£56.35	-	-	-	-
M3	0.5	10	56	-	3.5	2.7	2	2.5	-	-	E70M3	£17.35	E70M3TXC	£21.34
M4	0.7	13	63	-	4.5	3.4	2	3.3	-	-	E70M4	£16.55	E70M4TXC	£21.34
M5	0.8	13	70	-	6	4.9	2	4.2	-	-	E70M5	£16.23	E70M5TXC	£21.34
M6	1	16	80	-	6	4.9	2	5	-	-	E70M6	£16.55	E70M6TXC	£21.34
M8	1.25	18	90	-	8	6.2	2	6.8	-	-	E70M8	£18.72	E70M8TXC	£26.54
M10	1.5	20	100	-	10	8	2	8.5	-	-	E70M10	£20.82	E70M10TXC	£32.22
M12	1.75	25	110	-	9	7	3	10.3	-	-	E71M12	£28.43	E71M12TXC	£38.30
M14	2	28	110	-	11	9	3	12	-	-	E71M14	£32.97	E71M14TXC	£51.16
M16	2	28	110	-	12	9	3	14	-	-	E71M16	£39.92	E71M16TXC	£57.19

#### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

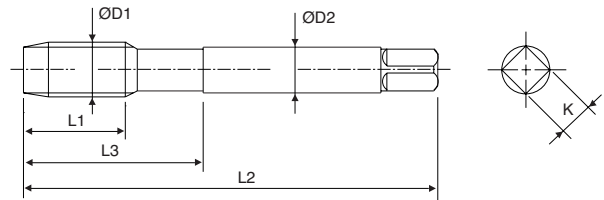
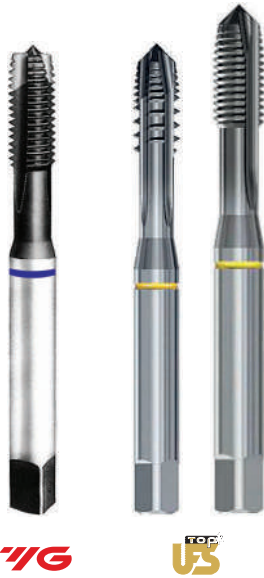
Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast Iron	Malleable Cast Iron/Graphite		Ti	Ti Alloy	
TC163	<400	<850	<850		<1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	10-15	<900
E70M	15-20	15-20	12-18		-	-	-	-	-	-	-	-	-	5-8	-
E70M-TXC	20-30	-	-		-	-	-	-	-	-	-	-	-	-	-
Series	Titanium				Copper, Brass, Bronze				Aluminium				Plastics / Composites		
	Ti Alloy	Nickel	Nickel Alloy		Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP	
TC163	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	-
E70M	-	6-8	-	-	8-12	-	-	-	10-15	25-35	15-20	10-15	-	-	-
E70M-TXC	-	-	-	-	15-20	-	-	-	20-25	20-25	20-25	25-30	20-25	-	-



Aluminium & Non-Ferrous

METRIC COARSE DIN 13 MACHINE TAPS - SPIRAL POINT

- Machine taps for tapping aluminium, plastic, copper and brass
- Interrupted pitch prevent chips from clogging in through hole tapping, ideal for long chipping aluminium
- Bright finish prevents built-up edge in sticky materials
- TiAlN +C Coating offers exceptional wear resistance in short-medium chipping aluminium alloys, aerospace aluminium and copper alloys
- Spiral point for through holes



Series	TC622	E24M-AZ	E24MAL-TXC
Brand / Geometry	YG - Alu	UFS Top Line - Alu	UFS Top Line - Alu
Substrate	HSS 5% Cobalt	HSS 5% Cobalt	HSS 5% Cobalt
Surface Treatment	Bright	Bright	TiAlN+C
Tolerance	6H	6HX	6HX
Flute Type	Interrupted	Interrupted	Standard
Chamfer Lead	Form B: 4-5	Form B: 4-5	Form B: 4-5
Maximum Depth	3xD	3xD	3xD
Through Coolant	-	-	-
Performance	○○○○○	○○○○○	○○○○○

ØD1	Pitch	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price	Order Code	Price	Order Code	Price
M2	0.4	8	45	13	2.8	2.1	3	1.6	TC622136	£15.42	-	-	-	-
M2.5	0.45	9	50	15	2.8	2.1	3	2.05	TC622176	£13.97	-	-	-	-
M3	0.5	11	56	18	3.5	2.7	3	2.5	TC622206	£11.07	-	-	-	-
M4	0.7	13	63	21	4.5	3.4	3	3.3	TC622246	£11.07	-	-	-	-
M5	0.8	15	70	25	6	4.9	3	4.2	TC622286	£11.56	-	-	-	-
M6	1	17	80	30	6	4.9	3	5	TC622316	£11.56	-	-	-	-
M8	1.25	20	90	35	8	6.2	3	6.8	TC622366	£14.87	-	-	-	-
M10	1.5	22	100	39	10	8	3	8.5	TC622426	£17.83	-	-	-	-
M12	1.75	24	110	44	9	7	3	10.2	TC622506	£23.80	-	-	-	-
M14	2	26	110	44	11	9	3	12	TC622546	£28.89	-	-	-	-
M16	2	27	110	44	12	9	3	14	TC622606	£36.21	-	-	-	-
M18	2.5	30	125	50	14	11	3	15.5	TC622656	£47.34	-	-	-	-
M20	2.5	32	140	54	16	12	3	17.5	TC622706	£56.35	-	-	-	-
M3	0.5	10	56	-	3.5	2.7	3	2.5	-	-	E24M3AZ	£18.20	E24M3AL-TXC	£27.95
M4	0.7	13	63	-	4.5	3.4	3	3.3	-	-	E24M4AZ	£17.29	E24M4AL-TXC	£27.95
M5	0.8	13	70	-	6	4.9	3	4.2	-	-	E24M5AZ	£17.66	E24M5AL-TXC	£27.95
M6	1	16	80	-	6	4.9	3	5	-	-	E24M6AZ	£17.74	E24M6AL-TXC	£27.95
M8	1.25	18	90	-	8	6.2	3	6.8	-	-	E24M8AZ	£19.35	E24M8AL-TXC	£34.03
M10	1.5	20	100	-	10	8	3	8.5	-	-	E24M10AZ	£21.55	E24M10AL-TXC	£38.87
M12	1.75	25	110	-	9	7	3	10.3	-	-	E25M12AZ	£29.31	E25M12AL-TXC	£49.18
M14	2	28	110	-	11	9	3	12	-	-	E25M14AZ	£47.00	E25M14AL-TXC	£60.93
M16	2	28	110	-	12	9	3	14	-	-	-	-	E25M16AL-TXC	£68.53

METRIC COARSE MACHINE TAPS

Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels	Carbon	Alloy	Alloy	Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite	Ti	Ti Alloy	Ti	Ti Alloy
TC622	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	10-15	<900
E24M-AZ	15-20	15-20	12-18	-	-	-	-	-	-	-	-	-	-	5-8	-
E24MAL-TXC	20-30	-	-	-	-	-	-	-	-	-	-	-	-	-	-
Series	Titanium				Copper, Brass, Bronze				Aluminium			Plastics / Composites			
	Ti Alloy	Nickel	Nickel Alloy	Nickel Alloy	Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP	
TC622	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	
E24M-AZ	-	6-8	-	-	8-12	-	-	-	10-15	25-35	15-20	-	20-25	-	
E24MAL-TXC	-	-	-	-	15-20	-	-	-	20-25	20-25	25-30	20-25	-	-	

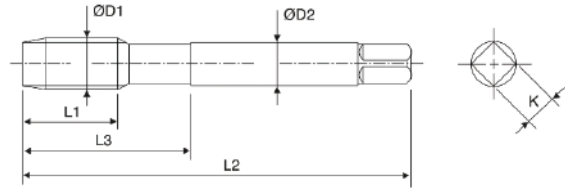




**Cast Iron**

**METRIC COARSE DIN 13 MACHINE TAPS - STRAIGHT FLUTE**

- Suitable for tapping grey, nodular and malleable cast iron, short chipping copper alloy, graphite, highly abrasive aluminium and magnesium alloy
- **YG** Nitrided finish HSSE for reliable tapping performance
- **YG** TiAlN Coated HSSE for increased tool life over nitrided finish
- **UFS-TOP LINE** powder metal for longest tool life and highest performance
- Straight flute for through & blind holes



Series	TE821	TY821	K26M-TX	K26MFOR-TX
Brand / Geometry	YG - GG	YG - GG	UFS - Top Line GG	UFS - Top Line GG
Substrate	HSS 5% Cobalt	HSS 5% Cobalt	HSS Powder Metal	HSS Powder Metal
Surface Treatment	Nitrided	TiAlN Coated	TiAlN Coated	TiAlN Coated
Tolerance	6HX	6HX	6HX	6HX
Helix Angle	-	-	-	-
Chamfer Lead	Form C: 2-3	Form C: 2-3	Form C: 2-3	Form C: 2-3
Maximum Depth	2xD	2xD	3xD	3.5xD
Through Coolant	-	-	-	Yes
Performance	●●●○	●●●○	●●●●●	●●●●●

ØD1	Pitch	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price	Order Code	Price	Order Code	Price	Order Code	Price
M2	0.4	8	45	13	2.8	2.1	3	1.6	TE821136	£21.40	TY821136	£20.99	-	-	-	-
M2.5	0.45	9	50	15	2.8	2.1	3	2.05	TE821176	£17.87	TY821176	£18.72	-	-	-	-
M3	0.5	11	56	18	3.5	2.7	3	2.5	TE821206	£13.98	TY821206	£16.25	-	-	-	-
M4	0.7	13	63	21	4.5	3.4	3	3.3	TE821246	£14.12	TY821246	£16.40	-	-	-	-
M5	0.8	15	70	25	6	4.9	4	4.2	TE821286	£14.62	TY821286	£16.66	-	-	-	-
M6	1	17	80	30	6	4.9	4	5	TE821316	£14.62	TY821316	£17.68	-	-	-	-
M8	1.25	20	90	35	8	6.2	4	6.8	TE821366	£18.88	TY821366	£25.60	-	-	-	-
M10	1.5	22	100	39	10	8	4	8.5	TE821426	£22.84	TY821426	£29.81	-	-	-	-
M12	1.75	24	110	44	9	7	4	10.2	TE821506	£30.32	TY821506	£36.27	-	-	-	-
M14	2	26	110	44	11	9	4	12	TE821546	£36.87	TY821546	£41.46	-	-	-	-
M16	2	27	110	44	12	9	4	14	TE821606	£46.80	TY821606	£48.57	-	-	-	-
M18	2.5	30	125	50	14	11	4	15.5	TE821656	£60.87	TY821656	£65.26	-	-	-	-
M20	2.5	32	140	54	16	12	4	17.5	TE821706	£72.44	TY821706	£85.38	-	-	-	-
M22	2.5	32	140	54	18	14.5	4	19.5	TE821746	£98.38	TY821746	£105.22	-	-	-	-
M24	3	34	160	60	18	14.5	4	21	TE821786	£112.01	TY821786	£130.96	-	-	-	-
M4	0.7	13	63	-	4.5	3.4	3	3.3	-	-	-	-	K26M4TX	£28.66	-	-
M5	0.8	13	70	-	6	4.9	3	4.2	-	-	-	-	K26M5TX	£28.66	-	-
M6	1	16	80	-	6	4.9	4	5	-	-	-	-	K26M6TX	£28.66	K26M6FOR-TX	£50.32
M8	1.25	18	90	-	8	6.2	4	6.8	-	-	-	-	K26M8TX	£35.70	K26M8FOR-TX	£60.40
M10	1.5	20	100	-	10	8	4	8.5	-	-	-	-	K26M10TX	£38.36	K26M10FOR-TX	£66.94
M12	1.75	25	110	-	9	7	4	10.3	-	-	-	-	K27M12TX	£47.95	K27M12FOR-TX	£79.56
M14	2	28	110	-	11	9	4	12	-	-	-	-	K27M14TX	£65.14	K27M14FOR-TX	£99.68
M16	2	28	110	-	12	9	4	14	-	-	-	-	K27M16TX	£73.59	K27M16FOR-TX	£105.40

**Material Applications N/mm<sup>2</sup> Cutting Speed m/min**

● Excellent ○ Good

Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium				
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/ Graphite			Ti	Ti Alloy			
TE812 TY821 K26M-TX K26MFOR-TX	<400 <700	<850 <850			≤1200 >1200		<850	<850	<1000	<500 <1000	<700 <1000	<700 <1000		<700	<900			
										10-15 5-8								
										25-30 20-25	25-30 20-25							
Series	Titanium				Inconel, Hastelloy, Nickel				Copper, Brass, Bronze				Aluminium			Plastics / Composites		
	Ti Alloy	Nickel	Nickel Alloy		Cu	Cu Alloy	Long	Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP			
TE812 TY821 K26M-TX K26MFOR-TX	<1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si >10%	Si >10%						
					8-12										5-7			
					8-12													
						25-30		5-8				25-30						

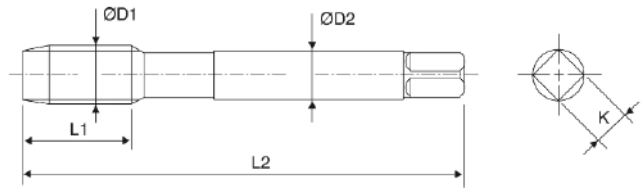


GG

Cast Iron

### METRIC COARSE DIN 13 MACHINE TAPS - SPIRAL FLUTE

- Designed for tapping nodular and malleable cast iron & high strength alloy steels
- R25° geometry with TiCN coating
- Spiral flute for blind holes



Series	K28M-CT
Brand / Geometry	UFS - Top Line GG
Substrate	HSS Powder Metal
Surface Treatment	TiCN Coated
Tolerance	6HX
Helix Angle	R25°
Chamfer Lead	Form C: 2-3
Maximum Depth	2.5xD
Through Coolant	-
Performance	<span style="color: orange;">■</span> <span style="color: orange;">■</span> <span style="color: orange;">■</span> <span style="color: orange;">■</span> <span style="color: orange;">■</span>

ØD1	Pitch	L1	L2	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price
M4	0.7	13	63	4.5	3.4	3	3.3	K28M4CT	£21.70
M5	0.8	13	70	6	4.9	3	4.2	K28M5CT	£21.70
M6	1	16	80	6	4.9	3	5	K28M6CT	£21.70
M8	1.25	18	90	8	6.2	3	6.8	K28M8CT	£27.41
M10	1.5	20	100	10	8	3	8.5	K28M10CT	£30.85
M12	1.75	25	110	9	7	4	10.3	K29M12CT	£49.85
M16	2	28	110	12	9	4	14	K29M16CT	£72.54

METRIC COARSE MACHINE TAPS

#### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite		Ti	Ti Alloy	
	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
K28M-CT	-	-	-	15-20	5-12	-	-	-	-	-	-	20-25	15-20	-	-

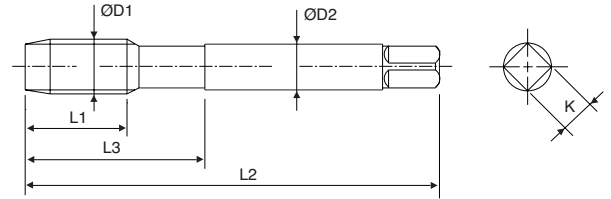
Series	Titanium	Inconel, Hastelloy, Nickel			Copper, Brass, Bronze			Aluminium			Plastics / Composites				
	Ti Alloy	Nickel	Nickel Alloy		Cu	Cu Alloy		Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	-
K28M-CT	-	-	-	-	-	-	-	5-8	-	-	-	-	-	-	-



Forming Roll Taps

## METRIC COARSE DIN 13 MACHINE TAPS - FORMING / ROLL TAPS

- Roll forming taps for stronger threads, better surface finish and longer tool life vs machine taps
- YG-ROLL TAP GEOMETRY** - 1st choice for general tapping
- PRIME X ROLL TAP** - advanced geometry & powder metal substrate for higher speed tapping, enhanced tool life and best performance on steel & stainless steel
- SYNCHRO ROLL TAP** - for high speed roll tapping
- For blind and through holes



Series	TD723	TD703	TRQ10	TTS37
Brand / Geometry	YG-Roll	YG-Roll	YG - Prime X Roll	YG - Synchro Roll
Substrate	HSS 5% Cobalt	HSS 5% Cobalt	HSS Powder Metal	HSS Powder Metal
Surface Treatment	TIN Coated	TIN Coated	X-Coated	TIN Coated
Tolerance	6H	6HX	6HX	6HX
Chamfer Lead	Form C: 2-3	Form C: 2-3	Form C: 2-3	Form C: 2-3
Maximum Depth	3xD	3xD	3xD	3xD
Coolant	Without Oil Grooves	With Oil Grooves	With Oil Grooves	With Oil Grooves
Performance	○○○○○	○○○○○	○○○○○	○○○○○

ØD1	Pitch	L1	L2	L3	ØD2	K	Drill Dia.	Order Code	Price	Order Code	Price	Order Code	Price	Order Code	Price
M2	0.4	8	45	13	2.8	2.1	1.83	TD723136	£21.53	TD703136	£22.38	-	-	-	-
M2.5	0.45	9	50	15	2.8	2.1	2.3	TD723176	£18.54	TD703176	£19.33	-	-	-	-
M3	0.5	11	56	18	3.5	2.7	2.8	TD723206	£15.74	TD703206	£16.27	-	-	-	-
M4	0.7	13	63	21	4.5	3.4	3.7	TD723246	£15.74	TD703246	£16.27	-	-	-	-
M5	0.8	15	70	25	6	4.9	4.65	TD723286	£16.23	TD703286	£16.71	-	-	-	-
M6	1	17	80	30	6	4.9	5.55	TD723316	£16.23	TD703316	£16.71	-	-	-	-
M8	1.25	20	90	35	8	6.2	7.4	TD723366	£22.08	TD703366	£22.75	-	-	-	-
M10	1.5	22	100	39	10	8	9.3	TD723426	£26.67	TD703426	£27.33	-	-	-	-
M12	1.75	24	110	44	9	7	11.2	TD723506	£35.40	TD703506	£36.41	-	-	-	-
M14	2	26	110	44	11	9	13	TD723546	£42.63	TD703546	£43.94	-	-	-	-
M16	2	27	110	44	12	9	15	TD723606	£51.18	TD703606	£52.89	-	-	-	-
M18	2.5	30	125	50	14	11	16.8	TD723656	£66.73	TD703656	£72.40	-	-	-	-
M20	2.5	32	140	54	16	12	18.8	TD723706	£79.66	TD703706	£82.40	-	-	-	-
M3	0.5	6	56	18	3.5	2.7	2.8	-	-	-	-	TRQ10206GS	£19.55	TTS37206	£15.40
M3.5	0.6	7.2	56	20	4	3	3.25	-	-	-	-	TRQ10226GS	£21.81	-	-
M4	0.7	8.4	63	21	4.5	3.4	3.7	-	-	-	-	TRQ10246GS	£19.84	TTS37246	£15.52
M5	0.8	9.6	70	25	6	4.9	4.65	-	-	-	-	TRQ10286GS	£20.65	TTS37286	£16.25
M6	1.0	10	80	30	6	4.9	5.55	-	-	-	-	TRQ10316GS	£21.09	TTS37316	£16.25
M7	1.0	10	80	30	7	5.5	6.55	-	-	-	-	TRQ10346GS	£28.64	-	-
M8	1.25	12	90	35	8	6.2	7.4	-	-	-	-	TRQ10366GS	£29.02	TTS37366	£22.38
M9	1.25	12	90	35	9	7	8.4	-	-	-	-	TRQ10396GS	£34.15	-	-
M10	1.5	15	100	39	10	8	9.3	-	-	-	-	TRQ10426GS	£35.66	TTS37426	£26.91
M12	1.75	17	110	44	9	7	11.2	-	-	-	-	TRQ10506GS	£46.85	TTS37506	£37.59
M14	2.0	20	110	44	11	9	13	-	-	-	-	TRQ10546GS	£56.07	-	-
M16	2.0	20	110	44	12	9	15	-	-	-	-	TRQ10606GS	£68.88	-	-
M18	2.5	20	125	50	14	11	16.8	-	-	-	-	TRQ10656GS	£92.54	-	-
M20	2.5	20	140	54	16	12	18.8	-	-	-	-	TRQ10706GS	£116.32	-	-
M22	2.5	20	140	54	18	14.5	20.8	-	-	-	-	TRQ10746GS	£142.85	-	-
M24	3.0	24	160	60	18	14.5	22.5	-	-	-	-	TRQ10786GS	£162.75	-	-

### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels		Carbon	Alloy	Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/ Graphite		Ti	Ti Alloy	
	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
TD723	15-20	15-20	12-18	10-15	-	-	7-10	5-8	-	-	-	-	-	10-15	-
TD703	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
TRQ10	15-40	15-30	15-30	5-20	-	-	5-15	5-15	-	-	-	-	-	-	-
TTS37	15-20	15-20	12-18	10-15	-	-	7-10	5-8	-	-	-	-	-	-	-
Series	Titanium	Inconel, Hastelloy, Nickel			Copper, Brass, Bronze				Aluminium			Plastics / Composites			
	Ti Alloy	Nickel	Nickel Alloy		Cu	Cu Alloy		Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	-
TD723	-	8-12	-	-	8-12	-	15-20	-	10-15	25-35	15-20	-	-	-	-
TD703	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
TRQ10	-	-	-	-	10-30	10-30	10-30	20-40	-	20-50	20-50	20-50	-	-	-
TTS37	-	-	-	-	8-12	-	15-20	-	10-15	25-35	15-20	-	-	-	-



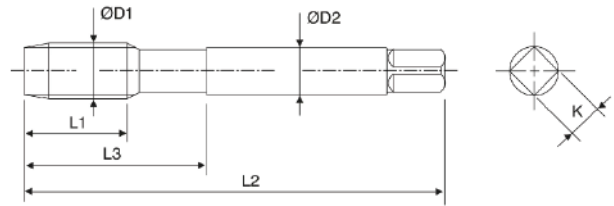
Synchro Taps

METRIC COARSE DIN 13 MACHINE TAPS - SYNCHRO RIGID

- High speed rigid tapping of steels, cast iron, copper, copper alloys and high silicon aluminium
- TiN coating with premium powder metal substrate for extreme tool life
- Up to 4 times faster than conventional rigid tapping
- Spiral flute for blind holes, Spiral point for through holes
- Synchro taps should only be used in synchro tap chucks



Synchro TAP



Type	Spiral Flute	Spiral Point
Series	TTS31	TTS33
Brand / Geometry	YG - Synchro	YG - Synchro
Substrate	HSS Powder Metal	HSS Powder Metal
Surface Treatment	TIN Coated	TIN Coated
Tolerance	6HX	6HX
Helix Angle	R45°	-
Chamfer Lead	Form C: 2-3	Form B: 4-5
Maximum Depth	2.5xD	3xD
Performance	★★★★★	★★★★★

ØD1	Pitch	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price	Order Code	Price
M3	0.5	6	56	18	3.5	2.7	3	2.5	TTS31206	£16.24	TTS33206	£16.62
M4	0.7	7	63	21	4.5	3.4	3	3.3	TTS31246	£16.42	TTS33246	£16.72
M5	0.8	8	70	25	6	4.9	3	4.2	TTS31286	£18.21	TTS33286	£18.56
M6	1	10	80	30	6	4.9	3	5	TTS31316	£18.21	TTS33316	£18.56
M8	1.25	13	90	35	8	6.2	3	6.8	TTS31366	£26.47	TTS33366	£26.47
M10	1.5	15	100	39	10	8	3	8.5	TTS31426	£31.64	TTS33426	£31.64
M12	1.75	18	110	44	9	7	3	10.2	TTS31506	£43.18	TTS33506	£43.18
M14	2	20	110	44	11	9	3	12	TTS31546	£52.12	TTS33546	£52.12
M16	2	20	110	44	12	9	3	14	TTS31606	£64.24	TTS33606	£64.24
M18	2.5	25	125	50	14	11	4	15.5	TTS31656	£84.72	TTS33656	£84.72
M20	2.5	25	140	54	16	12	4	17.5	TTS31706	£101.17	TTS33706	£101.17

METRIC COARSE MACHINE TAPS

Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite			Ti	Ti Alloy
TTS31 TTS33	<400 <700	<850 <850			≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
	41-46	41-46	35-40	28-33	-	-	-	-	-	28-33	-	28-33	-	-	-
Series	Titanium				Copper, Brass, Bronze				Aluminium			Plastics / Composites			
	Ti Alloy	Inconel, Hastelloy, Nickel	Nickel	Nickel Alloy	Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP	
TTS31 TTS33	≤1300	<500 <900 ≤1400			<350	Short Long	<1500	<350	Wrought	Si ≤10% Si >10%					
	-	-	-	-	22-27	-	41-46	-	-	41-46	28-33	60-65	-	-	

## ISO METRIC COARSE DIN 13 MACHINE TAPS - SOLID CARBIDE

- Up to 10x more tool life than HSS taps
- Suitable for high speed tapping
- Must be used with a synchro or tension compression tap chuck
- Made in Italy
- Same tap can be used for blind and through holes
- NFS Coated
- ideal for steel, tool steel, stainless steel, HRSA's & cast iron



Series	HMIG-N
Brand / Geometry	Cutwel Pro
Substrate	Micrograin Carbide
Surface Treatment	NFS Coated
Tolerance	6HX
Helix Angle	60°
Chamfer Lead	Form C: 2-3
Maximum Depth	3xD
Through Coolant	-
Performance	★★★★

ØD1	Pitch	L1	L2	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price
M3	0.5	11	56	3.5	2.7	3	2.5	HMIG110.M3X0.5.N	£108.40
M4	0.7	13	63	4.5	3.4	3	3.3	HMIG110.M4X0.7.N	£109.48
M5	0.8	16	70	6	4.9	4	4.2	HMIG110.M5X0.8.N	£120.23
M6	1	19	80	6	4.9	4	5	HMIG110.M6X1.N	£136.17
M8	1.25	22	90	8	6.2	4	6.8	HMIG110.M8X1.25.N	£211.81
M10	1.5	24	100	10	8	4	8.5	HMIG110.M10X1.5.N	£257.91
M12	1.75	28	110	9	7	5	10.25	HMIG120.M12X1.75.N	£281.99
M14	2	30	110	11	9	5	12	HMIG120.M14X2.N	£330.82
M16	2	32	110	12	9	5	14	HMIG120.M16X2.N	£379.63
M20	2.5	34	140	16	12	5	17.5	HMIG120.M20X2.5.N	£474.54

METRIC COARSE MACHINE TAPS

### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

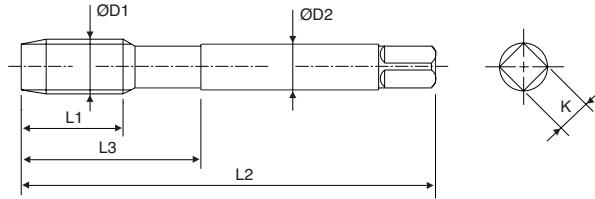
Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/ Graphite			Ti	Ti Alloy
	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
HMIG-N	-	15-35	10-20	4-10	2-4	-	-	-	-	20-40	20-40	30-70	30-70	-	-
Series	Titanium				Copper, Brass, Bronze				Aluminium			Plastics / Composites			
	Ti Alloy	Nickel	Nickel Alloy		Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP	
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	
HMIG-N	-	-	-	-	-	-	-	-	-	-	30-70	30-60	-	-	



Thread Repair

### EG M METRIC COARSE TAP - THREAD REPAIR

- BRIGHT finish prevents swarf sticking to the tap flutes, ideal for steel, copper, and aluminium
- Suitable for tapping holes for use with all major brand thread repair inserts
- Spiral flute for blind holes, spiral point for through holes
- 6H tolerance



Type	Spiral Flute	Spiral Point
Series	TC909	TC973
Brand / Geometry	YG - Thread Repair	YG - Thread Repair
Substrate	HSS 5% Cobalt	HSS 5% Cobalt
Surface Treatment	Bright	Bright
Tolerance	6H Mod	6H Mod
Helix Angle	R40°	-
Chamfer Lead	Form C: 2-3	Form B: 4-5
Maximum Depth	2.5xD	3xD
Performance	●●●●○	●●●●○

ØD1	Pitch	L1	L2	L2	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price	Order Code	Price
M2.5	0.45	6	56	18	3.5	2.7	3	2.65	TC909176	£26.25	TC973176	£24.96
M3	0.5	5	63	21	4.5	3.4	3	3.15	TC909206	£18.80	TC973206	£17.82
M3.5	0.6	8	70	25	6	4.9	3	3.7	TC909226	£22.77	TC973226	£21.68
M4	0.7	8	70	25	6	4.9	3	4.2	TC909246	£19.36	TC973246	£18.52
M5	0.8	8	80	30	6	4.9	3	5.25	TC909286	£19.96	TC973286	£19.02
M6	1	10	90	35	8	6.2	3	6.3	TC909316	£19.96	TC973316	£19.02
M8	1.25	16	100	39	10	8	3	8.4	TC909366	£25.05	TC973366	£24.00
M10	1.5	15	110	44	9	7	3	10.4	TC909426	£30.09	TC973426	£28.67
M12	1.75	20	110	44	11	9	3	12.5	TC909506	£40.67	TC973506	£38.57
M14	2	22	110	44	12	9	3	14.5	TC909546	£49.25	TC973546	£46.62
M16	2	25	125	50	14	11	4	16.5	TC909606	£61.66	TC973606	£58.69
M18	2.5	27	140	54	18	14.5	4	18.75	TC909656	£80.72	TC973656	£77.02
M20	2.5	30	160	60	18	14.5	4	20.75	TC909706	£95.99	TC973706	£91.63

METRIC COARSE MACHINE TAPS

#### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

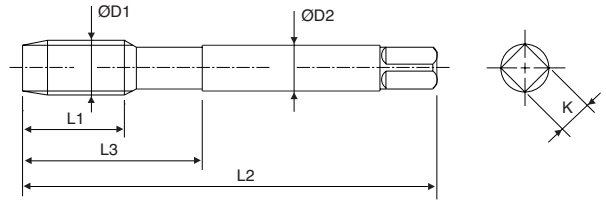
Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite			Ti	Ti Alloy
TC909 TC973	<400 <700	<850 <850			≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
Series	Titanium				Copper, Brass, Bronze				Aluminium			Plastics / Composites			
	Ti Alloy	Inconel, Hastelloy, Nickel	Nickel	Nickel Alloy	Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP	
TC909 TC973	≤1300	<500 <900 ≤1400			<350	Short Long	<1500	<350	Wrought	Si ≤10% Si >10%					



Multi Purpose

### METRIC FINE DIN 13 MACHINE TAPS - SPIRAL FLUTE

- Machine taps for multi material tapping
- COMBO tap geometry** - 1st choice for general tapping with exceptional reliability
- PRIME X tap** - advanced geometry & powder metal substrate for higher speed tapping, enhanced tool life and best performance on steel & stainless steel
- Spiral flute for blind holes



										FIRST CHOICE						
Series										TC844	TD844	TRE31	TRE40			
Brand / Geometry										YG - Combo Tap	YG - Combo Tap	YG - Prime X	YG - Prime X Coolant			
Substrate										HSS 5% Cobalt	HSS 5% Cobalt	HSS Powder Metal	HSS Powder Metal			
Surface Treatment										Bright	TIN Coated	X-Coated	X-Coated			
Tolerance										6H	6H	6HX	6HX			
Helix Angle										R40°	R40°	R45°	R45°			
Chamfer Lead										Form C: 2-3	Form C: 2-3	Form C: 2-3	Form C: 2-3			
Maximum Depth										2.5xD	2.5xD	2.5xD	2.5xD			
Through Coolant										-	-	-				
Performance																
ØD1	Pitch	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price	Order Code	Price	Order Code	Price	Order Code	Price
M4	0.5	10	63	21	2.8	2.1	3	3.5	TC844256	£23.11	TD844256	£22.73	TRE31256GS	£27.20	-	-
M5	0.5	11	70	25	3.5	2.7	3	4.5	TC844296	£23.48	TD844296	£23.00	TRE31296GS	£27.79	-	-
M6	0.75	13	80	30	4.5	3.4	3	5.2	TC844326	£23.11	TD844326	£22.73	TRE31326GS	£28.16	TRE40326GS	£40.56
M6	0.5	13	80	30	4.5	3.4	3	5.5	TC844336	£23.48	TD844336	£23.00	TRE31336GS	£28.45	TRE40336GS	£40.96
M7	0.75	14	80	30	5.5	4.3	3	6.2	TC844356	£34.27	TD844356	£32.67	-	-	-	-
M8	1	17	90	36	6	4.9	3	7	TC844376	£25.22	TD844376	£26.38	TRE31376GS	£33.07	TRE40376GS	£47.66
M8	0.75	14	80	36	6	4.9	3	7.2	TC844386	£26.88	TD844386	£26.89	TRE31386GS	£34.08	TRE40386GS	£49.08
M10	1.25	22	100	40	7	5.5	3	8.8	TC844436	£30.68	TD844436	£31.97	TRE31436GS	£40.55	TRE40436GS	£58.34
M10	1	18	90	40	7	5.5	3	9	TC844446	£29.56	TD844446	£30.41	TRE31446GS	£38.51	TRE40446GS	£55.46
M10	0.75	18	90	40	7	5.5	3	9.2	TC844456	£37.31	TD844456	£36.87	TRE31456GS	£46.76	TRE40456GS	£67.37
M12	1.5	22	100	40	9	7	3	10.5	TC844516	£32.94	TD844516	£34.96	TRE31516GS	£43.68	TRE40516GS	£62.88
M12	1.25	22	100	40	9	7	3	10.8	TC844526	£36.06	TD844526	£37.46	TRE31526GS	£46.96	TRE40526GS	£67.65
M12	1	18	100	40	9	7	3	11	TC844536	£34.29	TD844536	£36.02	TRE31536GS	£45.35	TRE40536GS	£65.27
M14	1.5	22	100	40	11	9	3	12.5	TC844556	£40.44	TD844556	£41.79	TRE31556GS	£53.75	TRE40556GS	£77.42
M14	1.25	22	100	40	11	9	3	12.8	TC844566	£43.64	TD844566	£44.53	TRE31566GS	£57.28	TRE40566GS	£82.51
M14	1	22	100	40	11	9	3	13	TC844576	£42.42	TD844576	£43.33	TRE31576GS	£55.93	TRE40576GS	£80.50
M16	1.5	22	100	40	12	9	3	14.5	TC844616	£51.33	TD844616	£52.86	TRE31616GS	£67.05	TRE40616GS	£96.54
M16	1	18	100	40	12	9	3	15	TC844626	£55.62	TD844626	£56.38	TRE31626GS	£71.75	TRE40626GS	£103.31
M18	1.5	25	110	44	14	11	4	16.5	TC844676	£66.79	TD844676	£67.55	TRE31676GS	£86.59	TRE40676GS	£124.72
M18	1	20	110	44	14	11	4	17	TC844686	£73.42	TD844686	£73.10	TRE31686GS	£93.66	TRE40686GS	£134.92
M20	1.5	25	125	50	16	12	4	18.5	TC844726	£73.95	TD844726	£76.25	TRE31726GS	£102.58	TRE40726GS	£147.72
M20	1	20	125	50	16	12	4	19	TC844736	£79.64	TD844736	£81.06	TRE31736GS	£108.62	TRE40736GS	£156.39
M22	1.5	25	125	50	18	14.5	4	20.5	TC844766	£85.31	TD844766	£88.29	TRE31766GS	£116.50	TRE40766GS	£167.82
M22	1	20	125	50	18	14.5	4	21	TC844776	£106.69	TD844776	£106.18	TRE31776GS	£139.37	TRE40776GS	£200.70
M24	2	27	140	54	18	14.5	4	22	TC844796	£104.84	TD844796	£107.45	TRE31796GS	£146.82	TRE40796GS	£211.43
M24	1.5	27	140	54	18	14.5	4	22.5	TC844806	£99.58	TD844806	£102.95	TRE31806GS	£138.05	TRE40806GS	£198.83
M26	1.5	28	140	54	18	14.5	4	24.5	TC844856	£127.98	TD844856	£129.45	-	-	-	-
M27	2	28	140	54	20	16	4	25	TC844876	£143.06	TD844876	£142.96	-	-	-	-
M27	1.5	28	140	54	20	16	4	25.5	TC844886	£141.99	TD844886	£142.17	-	-	-	-
M28	1.5	28	140	54	20	16	4	26.5	TC844916	£144.88	TD844916	£146.11	-	-	-	-
M30	2	30	150	57	22	18	4	28	TC844966	£168.25	TD844966	£171.42	-	-	-	-
M30	1.5	30	150	57	22	18	4	28.5	TC844976	£163.37	TD844976	£167.27	-	-	-	-

#### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

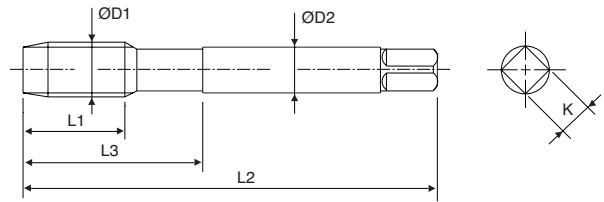
Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels		Carbon	Alloy	Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron		Malleable Cast Iron/Graphite		Ti	Ti Alloy
	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
TC844	15-20	15-20	12-18	10-15	6-10	-	-	-	-	10-15	5-8	10-15	5-8	10-15	-
TD844	-	-	-	-	-	-	7-10	5-8	4-6	-	-	-	-	-	-
TRE31	20-30	20-30	20-25	15-20	5-12	-	10-15	8-10	6-8	-	-	15-20	10-15	-	-
TRE40	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
Series	Titanium	Inconel, Hastelloy, Nickel		Copper, Brass, Bronze				Aluminium			Plastics / Composites				
	Ti Alloy	Nickel	Nickel Alloy	Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP		
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-		
TC844	-	8-12	-	-	8-12	25-35	15-20	-	-	25-35	15-20	10-15	-		
TD844	-	-	-	-	-	-	-	-	-	-	-	-	-		
TRE31	-	-	-	-	-	-	20-25	-	-	25-30	20-25	-	-		
TRE40	-	-	-	-	-	-	-	-	-	-	-	-	-		



Multi Purpose

### METRIC FINE DIN 13 MACHINE TAPS - SPIRAL POINT

- Machine taps for multi material tapping
- COMBO tap geometry** - 1st choice for general tapping with exceptional reliability
- PRIME X tap** - advanced geometry & powder metal substrate for higher speed tapping, enhanced tool life and best performance on steel & stainless steel
- Spiral point for through holes



FIRST CHOICE

Series	TC854	TD854	TRJ16	TRJ25
Brand / Geometry	YG - Combo Tap	YG - Combo Tap	YG - Prime X	YG - Prime X Coolant
Substrate	HSS 5% Cobalt	HSS 5% Cobalt	HSS Powder Metal	HSS Powder Metal
Surface Treatment	Bright	TIN Coated	X-Coated	X-Coated
Tolerance	6H	6H	6HX	6HX
Helix Angle	-	-	-	-
Chamfer Lead	Form B: 4-5	Form B: 4-5	Form B: 4-5	Form B: 4-5
Maximum Depth	3xD	3xD	3xD	3xD
Through Coolant	-	-	-	Water
Performance	4 stars	5 stars	5 stars	5 stars

ØD1	Pitch	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price	Order Code	Price	Order Code	Price	Order Code	Price
M4	0.5	10	63	21	2.8	2.1	3	3.5	TC854256	£23.11	TD854256	£22.73	TRJ16256GS	£27.20	-	-
M5	0.5	11	70	25	3.5	2.7	3	4.5	TC854296	£23.48	TD854296	£23.00	TRJ16296GS	£27.79	-	-
M6	0.75	13	80	30	4.5	3.4	3	5.2	TC854326	£23.11	TD854326	£22.73	TRJ16326GS	£28.16	TRJ25326GS	£40.56
M6	0.5	13	80	30	4.5	3.4	3	5.5	TC854336	£23.48	TD854336	£23.00	TRJ16336GS	£28.45	TRJ25336GS	£40.96
M7	0.75	14	80	30	5.5	4.3	3	6.2	TC854356	£34.27	TD854356	£32.67	-	-	-	-
M8	1	17	90	36	6	4.9	3	7	TC854376	£25.22	TD854376	£26.38	TRJ16376GS	£33.07	TRJ25376GS	£47.66
M8	0.75	14	80	36	6	4.9	3	7.2	TC854386	£26.88	TD854386	£26.89	TRJ16386GS	£34.08	TRJ25386GS	£49.08
M10	1.25	22	100	40	7	5.5	3	8.8	TC854436	£30.68	TD854436	£31.97	TRJ16436GS	£40.55	TRJ25436GS	£58.34
M10	1	18	90	40	7	5.5	3	9	TC854446	£29.56	TD854446	£30.41	TRJ16446GS	£38.51	TRJ25446GS	£55.46
M10	0.75	18	90	40	7	5.5	3	9.2	TC854456	£37.31	TD854456	£36.87	TRJ16456GS	£46.76	TRJ25456GS	£67.37
M12	1.5	22	100	40	9	7	3	10.5	TC854516	£32.94	TD854516	£34.96	TRJ16516GS	£43.68	TRJ25516GS	£62.88
M12	1.25	22	100	40	9	7	3	10.8	TC854526	£36.06	TD854526	£37.46	TRJ16526GS	£46.96	TRJ25526GS	£67.65
M12	1	18	100	40	9	7	3	11	TC854536	£34.29	TD854536	£36.02	TRJ16536GS	£45.35	TRJ25536GS	£65.27
M14	1.5	22	100	40	11	9	3	12.5	TC854556	£40.44	TD854556	£41.79	TRJ16556GS	£53.75	TRJ25556GS	£77.42
M14	1.25	22	100	40	11	9	3	12.8	TC854566	£43.64	TD854566	£44.53	TRJ16566GS	£57.28	TRJ25566GS	£82.51
M14	1	22	100	40	11	9	3	13	TC854576	£42.42	TD854576	£43.33	TRJ16576GS	£55.93	TRJ25576GS	£80.50
M16	1.5	22	100	40	12	9	3	14.5	TC854616	£51.33	TD854616	£52.86	TRJ16616GS	£67.05	TRJ25616GS	£96.54
M16	1	18	100	40	12	9	3	15	TC854626	£55.62	TD854626	£56.38	TRJ16626GS	£71.75	TRJ25626GS	£103.31
M18	1.5	25	110	44	14	11	4	16.5	TC854676	£66.79	TD854676	£67.55	TRJ16676GS	£86.59	TRJ25676GS	£124.72
M18	1	20	110	44	14	11	4	17	TC854686	£73.42	TD854686	£73.10	TRJ16686GS	£93.66	TRJ25686GS	£134.92
M20	1.5	25	125	50	16	12	4	18.5	TC854726	£73.95	TD854726	£76.25	TRJ16726GS	£102.58	TRJ25726GS	£147.72
M20	1	20	125	50	16	12	4	19	TC854736	£79.64	TD854736	£81.06	TRJ16736GS	£108.62	TRJ25736GS	£156.39
M22	1.5	25	125	50	18	14.5	4	20.5	TC854766	£85.31	TD854766	£88.29	TRJ16766GS	£116.50	TRJ25766GS	£167.82
M22	1	20	125	50	18	14.5	4	21	TC854776	£106.69	TD854776	£106.18	TRJ16776GS	£139.37	TRJ25776GS	£200.70
M24	2	27	140	54	18	14.5	4	22	TC854796	£104.84	TD854796	£107.45	TRJ16796GS	£146.82	TRJ25796GS	£211.43
M24	1.5	27	140	54	18	14.5	4	22.5	TC854806	£99.58	TD854806	£102.95	TRJ16806GS	£138.05	TRJ25806GS	£198.83
M26	1.5	28	140	54	18	14.5	4	24.5	TC854856	£127.98	TD854856	£129.45	-	-	-	-
M27	2	28	140	54	20	16	4	25	TC854876	£143.06	TD854876	£142.96	-	-	-	-
M27	1.5	28	140	54	20	16	4	25.5	TC854886	£141.99	TD854886	£142.17	-	-	-	-
M28	1.5	28	140	54	20	16	4	26.5	TC854916	£144.88	TD854916	£146.11	-	-	-	-
M30	2	30	150	57	22	18	4	28	TC854966	£168.25	TD854966	£171.42	-	-	-	-
M30	1.5	30	150	57	22	18	4	28.5	TC854976	£163.37	TD854976	£167.27	-	-	-	-

### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

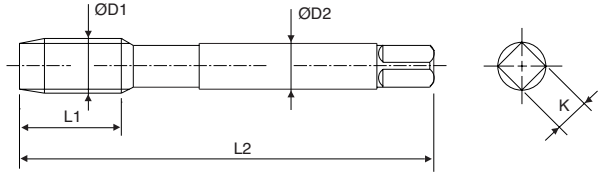
Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite			Ti	Ti Alloy
	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
TC854	15-20	15-20	12-18	10-15	6-10	-	7-10	5-8	4-6	10-15	5-8	10-15	5-8	10-15	-
TD844	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
TRJ16	20-30	20-30	20-25	15-20	5-12	-	10-15	8-10	6-8	-	-	15-20	10-15	-	-
TRJ25	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
Series	Titanium	Inconel, Hastelloy, Nickel		Copper, Brass, Bronze				Aluminium			Plastics / Composites				
	Ti Alloy	Nickel	Nickel Alloy	Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP		
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-		
TC854	-	8-12	-	-	8-12	25-35	15-20	-	-	25-35	15-20	10-15	-		
TD844	-	-	-	-	-	-	-	-	-	-	-	-	-		
TRJ16	-	-	-	-	-	-	20-25	-	-	25-30	20-25	-	-		
TRJ25	-	-	-	-	-	-	-	-	-	-	-	-	-		



High Resistance / Hardened Steel

## MF METRIC FINE DIN 13 TOP-LINE TAP - SPIRAL FLUTE & POINT

- Powder metal substrate for increased tool life over HSSE
- TiAlN +C coating offers exceptional wear resistance
- Short flute and 40° helix gives exceptional strength for tapping hard steels (spiral flute)
- Spiral flute for blind holes, Spiral point for through holes



Series	K25MF-TXC	K81MF-TXC
Brand / Geometry	UFS Top Line - Spiral Point	UFS Top Line - Spiral Flute
Substrate	HSS Powder Metal	HSS Powder Metal
Surface Treatment	TiAlN+C	TiAlN+C
Tolerance	6HX	6HX
Helix Angle	R40°	R40°
Chamfer Lead	Form B: 4-5	Form C: 2-3
Maximum Depth	3xD	2.5xD
Through Coolant	-	-
Performance	★★★★	★★★★

ØD1	Pitch	L1	L2	ØD2 h9	K h12	No. of Flutes	Drill Dia.	Order Code	Price	Order Code	Price
<b>Spiral Point</b>											
M8	1	18	90	6	4.9	3	7	K25MF8X1TXC	£44.53	-	-
M10	1	15	90	7	5.5	3	9	K25MF10X1TXC	£51.46	-	-
M10	1.25	20	100	7	5.5	3	8.75	K25MF10X1.25TXC	£51.46	-	-
M12	1.25	22	100	9	7	4	10.75	K25MF12X1.25TXC	£58.77	-	-
M12	1.5	22	100	9	7	4	10.5	K25MF12X1.5TXC	£58.77	-	-
M14	1.5	22	100	11	9	4	12.5	K25MF14X1.5TXC	£71.12	-	-
M16	1.5	22	100	12	9	4	14.5	K25MF16X1.5TXC	£89.24	-	-
<b>Spiral Flute</b>											
M8	1	13	90	6	4.9	3	7	-	-	K81MF8X1TXC	£45.38
M10	1	15	90	7	5.5	3	9	-	-	K81MF10X1TXC	£53.27
M10	1.25	15	100	7	5.5	3	8.75	-	-	K81MF10X1.25TXC	£53.27
M12	1.25	13	100	9	7	4	10.75	-	-	K81MF12X1.25TXC	£62.75
M12	1.5	13	100	9	7	4	10.5	-	-	K81MF12X1.5TXC	£62.75
M14	1.5	15	100	11	9	4	12.5	-	-	K81MF14X1.5TXC	£77.48
M16	1.5	15	100	12	9	4	14.5	-	-	K81MF16X1.5TXC	£85.46

### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite			Ti	Ti Alloy
K25MF-TXC K81MF-TXC	<400 <700	<850 <850		15-20	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
Series	Titanium			Inconel, Hastelloy, Nickel			Copper, Brass, Bronze			Aluminium			Plastics / Composites		
	Ti Alloy	Nickel	Nickel Alloy		Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP	
K25MF-TXC K81MF-TXC	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%			

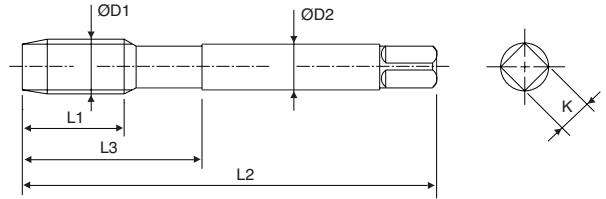


Long Chipping Steels

Chip Breaker

### METRIC FINE DIN 13 MACHINE TAPS - SPIRAL FLUTE - CHIP BREAKER

- Particularly suitable for machining non-alloy steel, low alloy steel, high alloy steel, and tool steel
- YG tap chip breaker provides a solution to solve the productivity problem caused by long chips, avoiding bird nesting
- Spiral flute for blind holes



Series	TDE25
Brand / Geometry	YG - Chipbreaker
Substrate	HSS 5% Cobalt
Surface Treatment	TIN Coated
Tolerance	6H
Helix Angle	R15°
Chamfer Lead	Form C: 2-3
Maximum Depth	2xD
Through Coolant	-
Performance	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>

ØD1	Pitch	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price
M8	1	10	90	36	6	4.9	3	7	TDE25376R	£23.18
M10	1.25	16	100	40	7	5.5	3	8.8	TDE25436R	£28.21
M10	1	10	90	36	7	5.5	3	9	TDE25446R	£26.86
M12	1.5	15	100	40	9	7	3	10.5	TDE25516R	£30.54
M12	1.25	15	100	40	9	7	3	10.8	TDE25526R	£32.75
M14	1.5	15	100	40	11	9	3	12.5	TDE25556R	£36.79
M16	1.5	15	100	40	12	9	3	14.5	TDE25616R	£46.68
M18	1.5	17	110	44	14	11	4	16.5	TDE25676R	£59.51
M20	1.5	17	125	50	16	12	4	18.5	TDE25726R	£67.77





## TAP CHIP BREAKER

**The Trouble-Shooter**

**Short Chip Obtained With YG Tap Chip Breaker**

YG Tap Chip Breaker provides a solution to solve the productivity problem caused by long chips, avoiding bird nesting.

Particularly suitable for machining non-alloy steel, low alloy steel, high alloy steel, and tool steel.



Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels		Carbon	Alloy	Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/ Graphite		Ti	Ti Alloy	
	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
TDE25	7-12	7-12	4-8	4-8	-	-	-	-	-	-	-	-	-	-	-
Series	Titanium				Copper, Brass, Bronze				Aluminium			Plastics / Composites			
	Ti Alloy	Nickel	Nickel Alloy		Cu	Cu Alloy		Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	-
TDE25	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

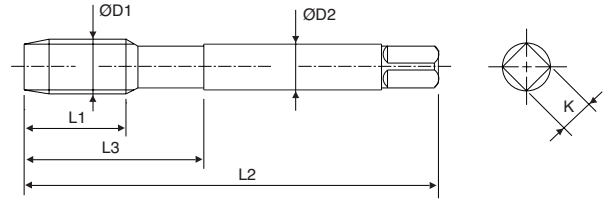
METRIC FINE MACHINE TAPS

**YG** INOX

Stainless Steel

**METRIC FINE DIN 13 MACHINE TAPS - SPIRAL FLUTE**

- Machine taps for tapping high stainless steels
- YG-INOX** steam tempered HSSE for general tapping performance on stainless steels
- Spiral flute for blind holes



Series	TB183
Brand / Geometry	YG - INOX
Substrate	HSS 5% Cobalt
Surface Treatment	Steam Tempered
Tolerance	6HX
Helix Angle	R40°
Chamfer Lead	Form C: 2-3
Maximum Depth	2.5xD
Through Coolant	-
Performance	<span style="color: orange;">■</span> <span style="color: red;">■</span> <span style="color: blue;">■</span> <span style="color: green;">■</span> <span style="color: purple;">■</span>

ØD1	Pitch	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price
M4	0.5	5	61.5	21	2.8	2.1	3	3.5	TB183256	£30.64
M5	0.5	5	70	25	3.5	2.7	3	4.5	TB183296	£31.44
M6	0.75	8	78	30	4.5	3.4	3	5.2	TB183326	£31.01
M6	0.5	5	78	30	4.5	3.4	3	5.2	TB183336	£31.44
M7	0.75	10	80	30	5.5	4.3	3	6.2	TB183356	£31.83
M8	1	10	90	36	6	4.9	3	7	TB183376	£33.46
M8	0.75	8	80	30	6	4.9	3	7.2	TB183386	£35.83
M10	1.25	16	100	40	7	5.5	3	8.8	TB183436	£43.59
M10	1	10	90	36	7	5.5	3	9	TB183446	£43.59
M10	0.75	10	90	36	7	5.5	3	9.2	TB183456	£49.01
M12	1.5	15	100	40	9	7	3	10.5	TB183516	£43.74
M12	1.25	15	100	40	9	7	3	10.8	TB183526	£47.73
M12	1	11	100	40	9	7	3	11	TB183536	£45.26
M14	1.5	15	100	40	11	9	3	12.5	TB183556	£52.96
M14	1.25	15	100	40	11	9	3	12.8	TB183566	£57.25
M16	1.5	15	100	40	12	9	3	14.5	TB183616	£67.47
M18	1.5	17	110	44	14	11	4	16.5	TB183676	£87.45
M20	1.5	17	125	50	16	12	4	18.5	TB183726	£105.61
M22	1.5	17	125	50	18	14.5	4	20.5	TB183766	£121.68
M24	1.5	20	140	54	18	14.5	4	22.5	TB183806	£142.05

**Material Applications N/mm<sup>2</sup> Cutting Speed m/min**

● Excellent ○ Good

Series	Steels			Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels	Carbon	Alloy	Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite			Ti	Ti Alloy
TB183	<400	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
V24MF	20-25	18-24	15-20	-	-	10-13	8-11	6-8	-	-	-	-	-	-
	-	-	10-15	-	-	7-10	5-8	-	-	-	-	-	-	-
Series	Titanium			Copper, Brass, Bronze			Aluminium			Plastics / Composites				
	Ti Alloy	Nickel	Nickel Alloy	Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP	
TB183	≤1300	<500	<900	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	
V24MF	-	-	-	-	-	-	-	-	-	-	-	-	-	

METRIC FINE MACHINE TAPS

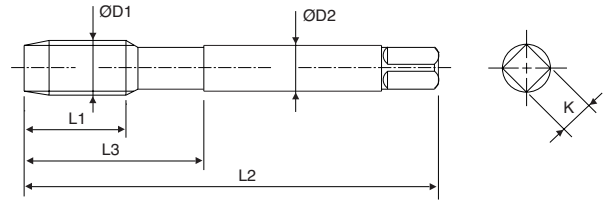


INOX

Stainless Steel

### METRIC FINE DIN 13 MACHINE TAPS - SPIRAL POINT

- Machine taps for tapping high stainless steels
- YG-INOX steam tempered HSSE for general tapping performance on stainless steel
- Spiral point for through holes



Series	TB123
Brand / Geometry	YG - INOX
Substrate	HSS 5% Cobalt
Surface Treatment	Steam Tempered
Tolerance	6HX
Helix Angle	-
Chamfer Lead	Form B: 4-5
Maximum Depth	3xD
Through Coolant	-
Performance	<span style="color: orange;">●</span> <span style="color: orange;">●</span> <span style="color: orange;">●</span> <span style="color: orange;">●</span> <span style="color: orange;">●</span>

ØD1	Pitch	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price
M4	0.5	10	61.5	21	2.8	2.1	3	2.1	TB123256	£27.63
M5	0.5	11	68	25	3.5	2.7	3	2.7	TB123296	£28.42
M6	0.75	13	78	30	4.5	3.4	3	3.4	TB123326	£25.37
M6	0.5	13	78	30	4.5	3.4	3	3.4	TB123336	£28.42
M7	0.75	14	80	30	5.5	4.3	3	4.3	TB123356	£29.71
M8	1	17	90	36	6	4.9	3	4.9	TB123 376	£27.38
M8	0.75	14	80	30	6	4.9	3	4.9	TB123386	£32.32
M10	1.25	22	100	40	7	5.5	3	5.5	TB123436	£31.33
M10	1	18	90	36	7	5.5	3	5.5	TB123446	£35.19
M10	0.75	18	90	36	7	5.5	3	5.5	TB123456	£44.38
M12	1.5	22	100	40	9	7	3	7	TB123516	£39.34
M12	1.25	22	100	40	9	7	3	7	TB123526	£42.88
M12	1	18	100	40	9	7	3	7	TB123536	£40.89
M14	1.5	22	100	40	11	9	3	9	TB123556	£47.92
M14	1.25	22	100	40	11	9	3	9	TB123566	£51.77
M16	1.5	22	100	40	12	9	3	9	TB123616	£60.89
M18	1.5	25	110	44	14	11	4	11	TB123676	£78.61
M20	1.5	25	125	50	16	12	4	12	TB123726	£95.45
M22	1.5	25	125	50	18	14.5	4	14.5	TB123766	£109.78
M24	1.5	27	140	54	18	14.5	4	14.5	TB123806	£127.78

METRIC FINE MACHINE TAPS

#### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium		
	Soft Steels		Carbon	Alloy	Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite			Ti	Ti Alloy	
TB123	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900	
V82MF	20-25	20-25	18-24	15-20	-	-	10-13	8-11	6-8	-	-	-	-	-	-	
	-	15-20	-	10-15	-	-	7-10	5-8	-	-	-	-	-	-	-	
Series	Titanium			Inconel, Hastelloy, Nickel			Copper, Brass, Bronze				Aluminium			Plastics / Composites		
	Ti Alloy	Nickel	Nickel Alloy	Cu	Cu Alloy		Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP		
TB123	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	-	
V82MF	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	

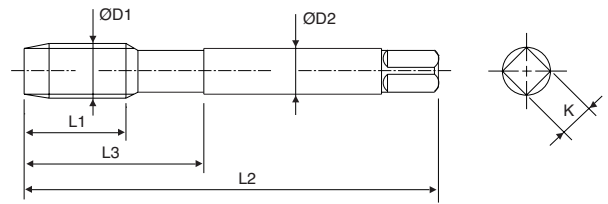


GG

Cast Iron

### METRIC FINE DIN 13 MACHINE TAPS - STRAIGHT FLUTE

- Suitable for tapping grey cast iron, short chipping brass/bronze and GFRP/CFRP
- Straight flute for through & blind holes



Series	TE403
Brand / Geometry	YG - GG
Substrate	HSS 5% Cobalt
Surface Treatment	Nitrided
Tolerance	6HX
Helix Angle	-
Chamfer Lead	Form C: 2-3
Maximum Depth	2xD
Through Coolant	-
Performance	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>

ØD1	Pitch	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price
M4	0.5	10	63	21	2.8	2.1	3	3.5	TE403256	£18.41
M5	0.5	11	70	25	3.5	2.7	4	4.5	TE403296	£18.67
M6	0.75	13	80	30	4.5	3.4	4	5.2	TE403326	£18.41
M6	0.5	13	80	30	4.5	3.4	4	5.5	TE403336	£18.67
M7	0.75	14	80	30	5.5	4.3	4	6.2	TE403356	£27.17
M8	1	17	90	36	6	4.9	4	7	TE403376	£20.07
M8	0.75	14	80	30	6	4.9	4	7.2	TE403386	£21.33
M10	1.25	22	100	40	7	5.5	4	8.8	TE403436	£24.40
M10	1	18	90	36	7	5.5	4	9	TE403446	£23.50
M10	0.75	18	90	36	7	5.5	4	9.2	TE403456	£29.63
M12	1.5	22	100	40	9	7	4	10.5	TE403516	£26.14
M12	1.25	22	100	40	9	7	4	10.8	TE403526	£28.57
M12	1	18	100	40	9	7	4	11	TE403536	£27.19
M14	1.5	22	100	40	11	9	4	12.5	TE403556	£32.03
M14	1.25	22	100	40	11	9	4	12.8	TE403566	£34.76
M16	1.5	22	100	40	12	9	4	14.5	TE403616	£40.73
M18	1.5	25	110	44	14	11	4	16.5	TE403676	£51.52
M20	1.5	25	125	50	16	12	4	18.5	TE403726	£58.71
M22	1.5	25	125	50	18	14.5	4	20.5	TE403766	£67.67
M24	1.5	27	140	54	18	14.5	4	22.5	TE403806	£79.08

METRIC FINE MACHINE TAPS

### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

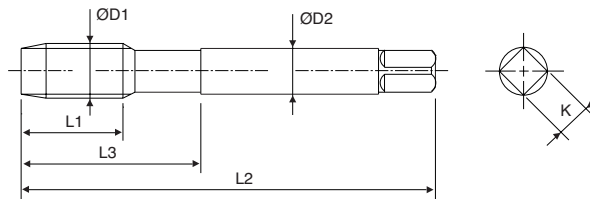
Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite		Ti	Ti Alloy	
TE403	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
	-	-	-	-	-	-	-	-	-	10-15	5-8	-	-	-	-
Series	Titanium	Inconel, Hastelloy, Nickel			Copper, Brass, Bronze				Aluminium			Plastics / Composites			
	Ti Alloy	Nickel	Nickel Alloy		Cu	Cu Alloy		Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP
TE403	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	5-7
	-	-	-	-	-	25-35	-	-	-	-	-	-	-	-	-



**Exotics**  
Titanium Alloys

**METRIC FINE DIN 13 MACHINE TAPS - SPIRAL FLUTE & POINT**

- Specially designed for tapping titanium and ti-alloys
- TiCN coated for ti-alloys, high chrome stainless steel, cast iron & high strength bronze
- Powder metal substrate for long tool life
- Spiral flute for through holes, spiral point for blind holes



Type	Spiral Flute	Spiral Point
Series	K42MF-CT	K22MF-CT
Brand / Geometry	UFS Top Line - TI	UFS Top Line - TI
Substrate	HSS Powder Metal	HSS Powder Metal
Surface Treatment	TiCN Coated	TiCN Coated
Tolerance	6HX	6HX
Helix Angle	R15°	L15°
Chamfer Lead	Form C: 2-3	Form D: 4-5
Maximum Depth	1.5xD	3xD
Through Coolant	-	-
Performance	★★★★	★★★★

ØD1	Pitch	L1	L2	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price	Order Code	Price
M8	1	13	90	8	6.2	3	7	K42MF8X1CT	£39.12	-	-
M10	1	15	100	10	8	3	9	K42MF10X1CT	£40.36	-	-
M10	1.25	15	100	10	8	3	8.75	K42MF10X1.25CT	£40.36	-	-
M12	1.25	13	100	9	7	4	10.75	K43MF12X1.25CT	£49.08	-	-
M12	1.5	13	100	9	7	4	10.5	K43MF12X1.5CT	£49.08	-	-
M14	1.5	15	100	11	9	4	12.5	K43MF14X1.5CT	£62.75	-	-
M16	1.5	15	100	12	9	4	14.5	K43MF16X1.5CT	£67.80	-	-
M8	1	18	90	8	6.2	3	7	-	-	K52MF8X1CT	£40.07
M10	1	20	100	10	8	3	9	-	-	K52MF10X1CT	£40.63
M10	1.25	20	100	10	8	3	8.75	-	-	K52MF10X1.25CT	£40.63
M12	1.25	22	100	9	7	3	10.75	-	-	K53MF12X1.25CT	£49.08
M12	1.5	22	100	9	7	3	10.5	-	-	K53MF12X1.5CT	£49.08
M14	1.5	22	100	11	9	3	12.5	-	-	K53MF14X1.5CT	£58.59
M16	1.5	22	100	12	9	3	14.5	-	-	K53MF16X1.5CT	£65.99

METRIC FINE MACHINE TAPS

**Material Applications N/mm<sup>2</sup> Cutting Speed m/min**

● Excellent ○ Good

Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite			Ti	Ti Alloy
K42MF	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
K52MF	-	-	-	-	-	5-8	-	-	6-8	-	-	20-25	15-20	-	4-8
Series	Titanium	Inconel, Hastelloy, Nickel			Copper, Brass, Bronze				Aluminium			Plastics / Composites			
	Ti Alloy	Nickel	Nickel Alloy		Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP	
K42MF	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	-
K52MF	2-4	-	2-4	-	-	25-30	-	5-8	-	-	-	25-30	-	-	-



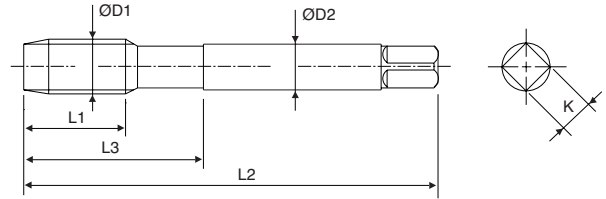
Forming Roll Taps

### METRIC FINE DIN 13 MACHINE TAPS - FORMING / ROLL TAPS

- Machine taps for multi material tapping
- PRIME X ROLL** tap - advanced geometry & powder metal substrate for higher speed tapping, enhanced tool life and best performance on steel & stainless steel
- For blind and through holes



PRIME X



Series	TRQ11
Brand / Geometry	YG - Prime X Roll
Substrate	HSS Powder Metal
Surface Treatment	X-Coated
Tolerance	6HX
Chamfer Lead	Form C: 2-3
Maximum Depth	3xD
Coolant	With Oil Grooves
Performance	★★★★

ØD1	Pitch	L1	L2	L3	ØD2	K	Drill Dia.	Order Code	Price
M6	0.75	10	80	30	4.5	3.4	5.65	TRQ11326GS	£33.11
M6	0.5	10	80	30	4.5	3.4	5.75	TRQ11336GS	£33.45
M8	1.0	12	90	36	6	4.9	7.5	TRQ11376GS	£38.92
M8	0.75	12	80	30	6	4.9	7.65	TRQ11386GS	£40.11
M10	1.25	15	100	40	7	5.5	9.4	TRQ11436GS	£47.62
M10	1.0	15	90	36	7	5.5	9.5	TRQ11446GS	£45.24
M10	0.75	15	90	36	7	5.5	9.65	TRQ11456GS	£54.95
M12	1.5	17	100	40	9	7	11.25	TRQ11516GS	£51.33
M12	1.25	17	100	40	9	7	11.4	TRQ11526GS	£55.18
M12	1.0	17	100	40	9	7	11.5	TRQ11536GS	£53.28
M14	1.5	20	100	40	11	9	13.25	TRQ11556GS	£63.18
M14	1.25	20	100	40	11	9	13.4	TRQ11566GS	£67.39
M14	1.0	20	100	40	11	9	13.5	TRQ11576GS	£65.74
M16	1.5	20	100	40	12	9	15.25	TRQ11616GS	£78.82
M16	1.0	20	100	40	12	9	15.5	TRQ11626GS	£84.33
M18	2.0	20	125	50	14	11	17	TRQ11666GS	£106.57
M18	1.5	15	110	44	14	11	17.25	TRQ11676GS	£101.78
M18	1.0	10	110	44	14	11	17.5	TRQ11686GS	£110.11
M20	2.0	20	140	54	16	12	19	TRQ11716GS	£150.14
M20	1.5	15	125	50	16	12	19.25	TRQ11726GS	£120.59
M20	1.0	10	125	50	16	12	19.5	TRQ11736GS	£127.69
M22	1.5	15	125	50	18	14.5	21.25	TRQ11766GS	£137.02
M24	1.5	15	140	54	18	14.5	23.25	TRQ11806GS	£162.33

### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium		
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite			Ti	Ti Alloy	
TRQ11	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900	
TRQ11	15-40	15-30	15-30	5-20	-	-	5-15	5-15	-	-	-	-	-	-	-	
Series	Titanium			Inconel, Hastelloy, Nickel			Copper, Brass, Bronze				Aluminium			Plastics / Composites		
	Ti Alloy	Nickel	Nickel Alloy	Cu	Cu Alloy		Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP		
TRQ11	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	-	



METRIC FINE MACHINE TAPS



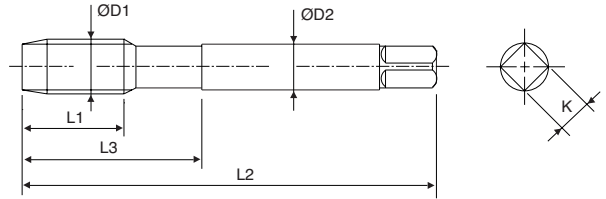
Synchro Taps

## MF METRIC FINE DIN 13 SYNCHRO RIGID MACHINE TAPS - SPIRAL FLUTE & POINT

- High speed rigid tapping of steels, cast iron, copper, copper alloys and high silicon aluminium
- TiN coating with premium powder metal substrate for extreme tool life
- Up to 4 times faster than conventional rigid tapping
- Spiral flute for blind holes, Spiral point for through holes
- 6HX tolerance
- Synchro taps should only be used in synchro tap chucks



Synchro TAP



Type	Spiral Flute	Spiral Point
Series	TTS32	TTS34
Brand / Geometry	YG - Synchro	YG - Synchro
Substrate	HSS Powder Metal	HSS Powder Metal
Surface Treatment	TiN Coated	TiN Coated
Tolerance	6HX	6HX
Helix Angle	R45°	-
Chamfer Lead	Form C: 2-3	Form B: 4-5
Maximum Depth	2.5xD	3xD
Performance	★★★★	★★★★

ØD1	Pitch	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price	Order Code	Price
M8	1	10	90	36	6	4.9	3	7	TTS32376	£27.73	TTS34376	£27.73
M10	1.25	13	100	40	7	5.5	3	8.75	TTS32436	£33.08	TTS34436	£33.08
M10	1	10	90	40	7	5.5	3	9	TTS32446	£31.43	TTS34446	£31.43
M12	1.5	15	100	40	9	7	4	10.5	TTS32516	£36.93	TTS34516	£36.93
M12	1.25	13	100	40	9	7	4	10.75	TTS32526	£39.71	TTS34526	£39.71
M14	1.5	15	100	40	11	9	4	12.5	TTS32556	£45.90	TTS34556	£45.90
M16	1.5	15	100	40	12	9	4	14.5	TTS32616	£57.32	TTS34616	£57.32
M18	1.5	17	110	44	14	11	4	16.5	TTS32676	£72.76	TTS34676	£72.76
M20	1.5	17	125	50	16	12	4	18.5	TTS32726	£81.93	TTS34726	£81.93

METRIC FINE MACHINE TAPS

### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

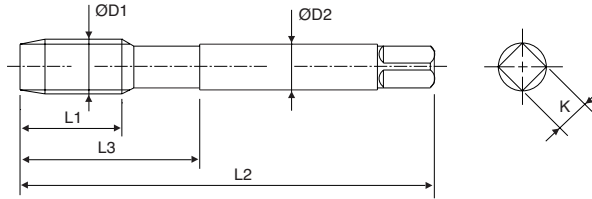
Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite			Ti	Ti Alloy
TTS32 TTS34	<400 <700	<850 <850	<850 <850	-	≤1200	>1200	<850 18-23	<850 13-18	<1000 10-14	<500 28-33	<1000 -	<700 -	<1000 -	<700 -	<900 -
Series	Titanium			Inconel, Hastelloy, Nickel			Copper, Brass, Bronze			Aluminium			Plastics / Composites		
	Ti Alloy	Nickel	Nickel Alloy		Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP	
TTS32 TTS34	≤1300	<500	<900 ≤1400	-	<350	Short 25-30	Long -	<1500 41-46	<350 -	Wrought -	Si ≤10% -	Si >10% -	-	-	-



Multi Purpose

## UNC (UNIFIED COARSE) ANSI B1.1 MACHINE TAPS - SPIRAL FLUTE

- Machine taps for multi material tapping
- COMBO** tap geometry - 1st choice for general tapping with exceptional reliability
- PRIME X tap** - advanced geometry & powder metal substrate for higher speed tapping, enhanced tool life and best performance on steel & stainless steel
- Spiral flute for blind holes



Series	TC824	TD824	TRE32
Brand / Geometry	YG - Combo Tap	YG - Combo Tap	YG - Prime X
Substrate	HSS 5% Cobalt	HSS 5% Cobalt	HSS Powder Metal
Surface Treatment	Bright	TIN Coated	X-Coated
Tolerance	2B	2B	2BX
Helix Angle	R40°	R40°	R45°
Chamfer Lead	Form C: 2-3	Form C: 2-3	Form C: 2-3
Maximum Depth	2.5xD	2.5xD	2.5xD
Through Coolant	-	-	-
Performance	🔴🟡🟢🟠	🔴🟡🟢🟠	🔴🟡🟢🟠

ØD1	TPI	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price	Order Code	Price	Order Code	Price
No.4	40	11	56	18	3.5	2.7	3	2.3	TC824162	£16.72	TD824162	£19.36	TRE32162GS	£23.24
No.5	40	11	56	18	3.5	2.7	3	2.6	TC824202	£13.19	TD824202	£15.94	TRE32202GS	£19.24
No.6	32	12	56	20	4	3	3	2.85	TC824242	£14.99	TD824242	£17.64	TRE32242GS	£19.24
No.8	32	13	63	21	4.5	3.4	3	3.5	TC824282	£13.19	TD824282	£16.11	TRE32282GS	£19.24
No.10	24	15	70	25	6	4.9	3	3.9	TC824322	£13.65	TD824322	£16.58	TRE32322GS	£20.42
No.12	24	16	80	30	6	4.9	3	4.5	TC824362	£13.65	TD824362	£16.58	TRE32362GS	£20.78
1/4	20	17	80	30	7	5.5	3	5.2	TC824402	£13.65	TD824402	£16.58	TRE32402GS	£22.27
5/16	18	20	90	35	8	6.2	3	6.6	TC824442	£17.76	TD824442	£21.76	TRE32442GS	£27.93
3/8	16	22	100	39	9	7	3	8	TC824482	£21.28	TD824482	£26.69	TRE32482GS	£33.66
7/16	14	22	100	40	8	6.2	3	9.4	TC824522	£28.67	TD824522	£34.96	TRE32522GS	£44.82
1/2	13	25	110	44	9	7	3	10.75	TC824562	£28.67	TD824562	£36.12	TRE32562GS	£45.35
9/16	12	26	110	44	11	9	3	12.25	TC824602	£34.64	TD824602	£43.42	TRE32602GS	£58.79
5/8	11	27	110	44	12	9	3	13.5	TC824642	£43.56	TD824642	£52.78	TRE32642GS	£66.37
3/4	10	30	125	50	14	11	4	16.5	TC824702	£67.82	TD824702	£80.09	TRE32702GS	£115.12
7/8	9	32	140	54	18	14.5	4	19.5	TC824742	£84.11	TD824742	£100.58	TRE32742GS	£147.15
1"	8	36	160	60	20	16	4	22.25	TC824782	£117.33	TD824782	£137.68	TRE32782GS	£199.42

### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast Iron	Malleable Cast Iron/Graphite			Ti	Ti Alloy
	<400	<700	<850	<850	<1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
TC824	15-20	15-20	12-18	10-15	6-10	-	-	-	-	10-15	5-8	10-15	5-8	10-15	-
TD824	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
TRE32	20-30	20-30	20-25	15-20	5-12	-	10-15	8-10	6-8	-	-	15-20	10-15	-	-
Series	Titanium				Copper, Brass, Bronze				Aluminium			Plastics / Composites			
	Ti Alloy	Nickel	Inconel, Hastelloy, Nickel	Nickel Alloy	Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP	
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	
TC824	-	8-12	-	-	8-12	25-35	15-20	-	-	25-35	15-20	10-15	-	-	
TD824	-	-	-	-	-	-	-	-	-	-	-	-	-	-	
TRE32	-	-	-	-	-	-	20-25	-	-	25-30	20-25	-	-	-	

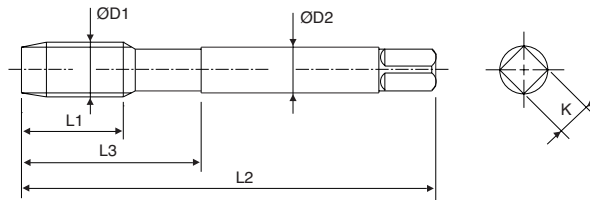
UNC MACHINE TAPS



Multi Purpose

### UNC (UNIFIED COARSE) ANSI B1.1 MACHINE TAPS - SPIRAL POINT

- Machine taps for multi material tapping
- COMBO** tap geometry - 1st choice for general tapping with exceptional reliability
- PRIME X tap** - advanced geometry & powder metal substrate for higher speed tapping, enhanced tool life and best performance on steel & stainless steel
- Spiral point for through holes



Series	TC834		TD834		TRJ17	
	Brand / Geometry	Substrate	Surface Treatment	Tolerance	Helix Angle	Chamfer Lead
Brand / Geometry	YG - Combo Tap	HSS 5% Cobalt	Bright	2B	-	Form B: 4-5
Substrate	YG - Combo Tap	HSS 5% Cobalt	TIN Coated	2B	-	Form B: 4-5
Surface Treatment	HSS 5% Cobalt	HSS 5% Cobalt	X-Coated	2BX	-	Form B: 4-5
Tolerance	-	-	-	-	-	-
Helix Angle	-	-	-	-	-	-
Chamfer Lead	Form B: 4-5	Form B: 4-5	Form B: 4-5	Form B: 4-5	Form B: 4-5	Form B: 4-5
Maximum Depth	3xD	3xD	3xD	3xD	3xD	3xD
Through Coolant	-	-	-	-	-	-
Performance	<input checked="" type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>		<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>		<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>	

ØD1	TPI	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price	Order Code	Price	Order Code	Price
No.4	40	11	56	18	3.5	2.7	3	2.3	TC834162	£16.72	TD834162	£19.36	TRJ17162GS	£23.24
No.5	40	11	56	18	3.5	2.7	3	2.6	TC834202	£13.19	TD834202	£15.94	TRJ17202GS	£19.24
No.6	32	12	56	20	4	3	3	2.85	TC834242	£14.99	TD834242	£17.64	TRJ17242GS	£19.24
No.8	32	13	63	21	4.5	3.4	3	3.5	TC834282	£13.19	TD834282	£16.11	TRJ17282GS	£19.24
No.10	24	15	70	25	6	4.9	3	3.9	TC834322	£13.65	TD834322	£16.58	TRJ17322GS	£20.42
No.12	24	16	80	30	6	4.9	3	4.5	TC834362	£13.65	TD834362	£16.58	TRJ17362GS	£20.78
1/4	20	17	80	30	7	5.5	3	5.2	TC834402	£13.65	TD834402	£16.58	TRJ17402GS	£22.27
5/16	18	20	90	35	8	6.2	3	6.6	TC834442	£17.76	TD834442	£21.76	TRJ17442GS	£27.93
3/8	16	22	100	39	9	7	3	8	TC834482	£21.28	TD834482	£26.69	TRJ17482GS	£33.66
7/16	14	22	100	40	8	6.2	3	9.4	TC834522	£28.67	TD834522	£34.96	TRJ17522GS	£44.82
1/2	13	25	110	44	9	7	3	10.75	TC834562	£28.67	TD834562	£36.12	TRJ17562GS	£45.35
9/16	12	26	110	44	11	9	3	12.25	TC834602	£34.64	TD834602	£43.42	TRJ17602GS	£58.79
5/8	11	27	110	44	12	9	3	13.5	TC834642	£43.56	TD834642	£52.78	TRJ17642GS	£66.37
3/4	10	30	125	50	14	11	4	16.5	TC834702	£67.82	TD834702	£80.09	TRJ17702GS	£115.12
7/8	9	32	140	54	18	14.5	4	19.5	TC834742	£84.11	TD834742	£100.58	TRJ17742GS	£147.15
1"	8	36	160	60	20	16	4	22.25	TC834782	£117.33	TD834782	£137.68	TRJ17782GS	£199.42

UNC MACHINE TAPS

#### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast Iron	Malleable Cast Iron/Graphite		Ti	Ti Alloy	
	<400	<700	<850	<850	<1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
TC834	15-20	15-20	12-18	10-15	6-10	-	-	-	-	10-15	5-8	10-15	5-8	10-15	-
TD834	-	-	-	-	-	-	7-10	5-8	4-6	-	-	-	-	-	-
TRJ17	20-30	20-30	20-25	15-20	5-12	-	10-15	8-10	6-8	-	-	15-20	10-15	-	-

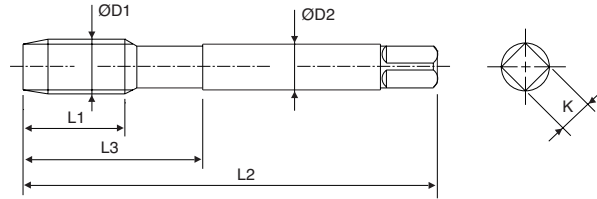
Series	Titanium				Inconel, Hastelloy, Nickel				Copper, Brass, Bronze				Aluminium			Plastics / Composites		
	Ti Alloy	Nickel	Nickel Alloy		Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP				
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%						
TC834	-	8-12	-	-	8-12	25-35	15-20	-	-	25-35	15-20	10-15	-	-	-			
TD834	-	-	-	-	-	-	20-25	-	-	25-30	20-25	-	-	-	-			
TRJ17	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-			



Stainless Steel

### UNC (UNIFIED COARSE) ANSI B1.1 MACHINE TAPS - SPIRAL FLUTE

- Machine taps for tapping high stainless steels
- YG-INOX** steam tempered HSSE for general tapping performance on stainless steels
- UFS-TOP LINE** vanadium cobalt for high performance tapping
- Spiral flute for blind holes



Series	TB904	V82UNC
Brand / Geometry	YG - INOX	UFS Top Line - INOX
Substrate	HSS 5% Cobalt	HSS Vanadium Cobalt
Surface Treatment	Steam Tempered	TXC Coated
Tolerance	2B	2BX
Helix Angle	R40°	R48°
Chamfer Lead	Form C: 2-3	Form C: 2-3
Maximum Depth	2.5xD	2.5xD
Through Coolant	-	-
Performance	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input type="checkbox"/>

ØD1	TPI	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price	Order Code	Price
No.10	24	10	70	25	6	4.9	3	3.9	TB904322	£15.89	-	-
No.12	24	10	80	30	6	4.9	3	4.5	TB904362	£15.89	-	-
1/4	20	13	80	30	7	5.5	3	5.2	TB904402	£15.89	-	-
5/16	18	14	90	35	8	6.2	3	6.6	TB904442	£20.70	-	-
3/8	16	16	100	39	9	7	3	8	TB904482	£24.90	-	-
7/16	14	17	100	40	8	6.2	3	9.4	TB904522	£33.35	-	-
1/2	13	20	110	44	9	7	3	10.75	TB904562	£33.35	-	-
9/16	12	20	110	44	11	9	3	12.25	TB904602	£44.75	-	-
5/8	11	22	110	44	12	9	3	13.5	TB904642	£50.84	-	-
3/4	10	25	125	50	14	11	4	16.5	TB904702	£89.44	-	-
7/8	9	27	140	54	18	14.5	4	19.5	TB904742	£110.81	-	-
No.6	32	7	56	-	4	3	3	2.85	-	-	V82UNC6-32TXC	£29.31
No.8	32	7	63	-	4.5	3.4	3	3.5	-	-	V82UNC8-32TXC	£29.31
No.10	24	8	70	-	6	4.9	3	3.9	-	-	V82UNC10-24TXC	£29.31
1/4	20	10	80	-	7	5.5	3	5.1	-	-	V82UNC1/4TXC	£21.35
5/16	18	13	90	-	8	6.2	3	6.6	-	-	V82UNC5/16TXC	£31.97
3/8	16	15	100	-	10	8	3	8	-	-	V82UNC3/8TXC	£35.64
7/16	14	15	100	-	8	6.2	3	9.4	-	-	V83UNC7/16TXC	£42.79
1/2	13	18	110	-	9	7	3	10.8	-	-	V83UNC1/2TXC	£48.73
9/16	12	20	110	-	11	9	4	12.2	-	-	V83UNC9/16TXC	£61.76
5/8	11	20	110	-	12	9	4	13.5	-	-	V83UNC5/8TXC	£68.60
3/4	10	25	125	-	14	11	4	16.5	-	-	V83UNC3/4TXC	£87.25

#### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite			Ti	Ti Alloy
TB904	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
V82UNC	20-25	20-25	18-24	15-20	-	-	10-13	8-11	6-8	-	-	-	-	-	-
	-	-	20-25	15-20	5-12	-	10-15	8-10	6-8	-	-	-	-	-	-
Series	Titanium			Inconel, Hastelloy, Nickel			Copper, Brass, Bronze			Aluminium			Plastics / Composites		
	Ti Alloy	Nickel	Nickel Alloy				Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset
TB904	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	-
V82UNC	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

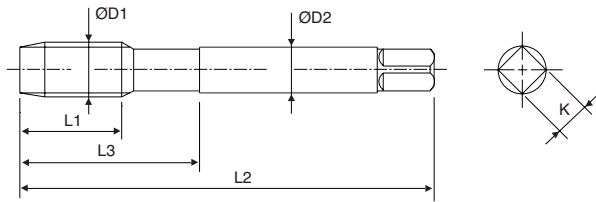
UNC MACHINE TAPS



Stainless Steel

### UNC (UNIFIED COARSE) ANSI B1.1 MACHINE TAPS - SPIRAL POINT

- Machine taps for tapping high stainless steels
- YG-INOX** steam tempered HSS-E for general tapping performance on stainless steels
- UFS-TOP LINE** vanadium cobalt for high performance tapping
- Spiral point for through holes



Series	TB264	V24UNC
Brand / Geometry	YG - INOX	UFS Top Line - INOX
Substrate	HSS 5% Cobalt	HSS Vanadium Cobalt
Surface Treatment	Steam Tempered	TXC Coated
Tolerance	2B	2BX
Helix Angle	-	-
Chamfer Lead	Form B: 4-5	Form B: 4-5
Maximum Depth	2.5xD	2.5xD
Through Coolant	-	-
Performance	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>

ØD1	TPI	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price	Order Code	Price
No.10	24	15	70	25	6	4.9	3	3.9	TB264322	£16.07	-	-
No.12	24	16	80	30	6	4.9	3	4.5	TB264362	£16.07	-	-
1/4	20	17	80	30	7	5.5	3	5.2	TB264402	£16.07	-	-
5/16	18	20	90	35	8	6.2	3	6.6	TB264442	£20.82	-	-
3/8	16	22	100	39	9	7	3	8	TB264482	£25.08	-	-
7/16	14	22	100	44	8	6.2	3	9.4	TB264522	£33.88	-	-
1/2	13	25	110	44	9	7	3	10.75	TB264562	£33.88	-	-
9/16	12	26	110	44	11	9	3	12.25	TB264602	£40.82	-	-
5/8	11	27	110	44	12	9	3	13.5	TB264642	£51.34	-	-
3/4	10	30	125	50	14	11	4	16.5	TB264702	£80.03	-	-
7/8	9	32	140	54	18	14.5	4	19.5	TB264742	£99.19	-	-
No.6	32	11	56	-	4	3	3	2.85	-	-	V24UNC6-32TXC	£21.40
No.8	32	13	63	-	4.5	3.4	3	3.5	-	-	V24UNC8-32TXC	£21.40
No.10	24	13	70	-	6	4.9	3	3.9	-	-	V24UNC10-24TXC	£21.40
1/4	20	16	80	-	7	5.5	3	5.1	-	-	V24UNC1/4TXC	£19.02
5/16	18	18	90	-	8	6.2	3	6.6	-	-	V24UNC5/16TXC	£20.34
3/8	16	20	100	-	10	8	3	8	-	-	V24UNC3/8TXC	£22.12
7/16	14	20	100	-	8	6.2	3	9.4	-	-	V25UNC7/16TXC	£38.15
1/2	13	25	110	-	9	7	4	10.8	-	-	V25UNC1/2TXC	£44.70
9/16	12	28	110	-	11	9	4	12.2	-	-	V25UNC9/16TXC	£52.39
5/8	11	28	110	-	12	9	4	13.5	-	-	V25UNC5/8TXC	£58.32
3/4	10	32	125	-	14	11	4	16.5	-	-	V25UNC3/4TXC	£75.91

UNC MACHINE TAPS

#### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium		
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite			Ti	Ti Alloy	
TB264	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900	
V24UNC	20-25	20-25	18-24	15-20	-	-	10-13	8-11	6-8	-	-	-	-	-	-	
	-	-	20-25	15-20	5-12	-	10-15	8-10	6-8	-	-	-	-	-	-	
Series	Titanium			Inconel, Hastelloy, Nickel			Copper, Brass, Bronze				Aluminium			Plastics / Composites		
	Ti Alloy	Nickel	Nickel Alloy				Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP
TB264	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	-	
V24UNC	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	



GG

Cast Iron

### UNC (UNIFIED COARSE) ANSI B1.1 MACHINE TAPS - STRAIGHT FLUTE

- Suitable for tapping grey cast iron, short chipping brass/bronze and GFRP/CFRP
- Straight flute for through & blind holes



Series	TE434
Brand / Geometry	YG - GG
Substrate	HSS 5% Cobalt
Surface Treatment	Nitrided
Tolerance	2BX
Helix Angle	-
Chamfer Lead	Form C: 2-3
Maximum Depth	2xD
Through Coolant	-
Performance	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>

ØD1	TPI	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price
No.10	24	15	70	25	6	4.9	3	3.9	TE434322	£11.40
No.12	24	16	80	30	6	4.9	3	4.5	TE434362	£11.40
1/4	20	17	80	30	7	5.5	4	5.2	TE434402	£11.40
5/16	18	20	90	35	8	6.2	4	6.6	TE434442	£14.70
3/8	16	22	100	39	9	7	4	8	TE434482	£17.80
7/16	14	22	100	40	8	6.2	4	9.4	TE434522	£23.74
1/2	13	25	110	44	9	7	4	10.75	TE434562	£23.74
9/16	12	26	110	44	11	9	4	12.25	TE434602	£30.11
5/8	11	27	110	44	12	9	4	13.5	TE434642	£36.53
3/4	10	30	125	50	14	11	4	16.5	TE434702	£52.93

UNC MACHINE TAPS

#### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite		Ti	Ti Alloy	
	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
TE434	-	-	-	-	-	-	-	-	-	10-15	5-8	-	-	-	-

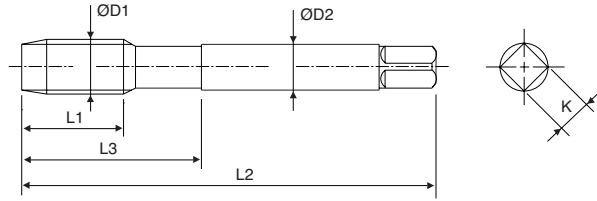
Series	Titanium	Inconel, Hastelloy, Nickel		Copper, Brass, Bronze			Aluminium			Plastics / Composites				
	Ti Alloy	Nickel	Nickel Alloy	Cu	Cu Alloy		Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%		
TE434	-	-	-	-	-	25-35	-	-	-	-	-	-	-	5-7



Exotics  
Titanium Alloys

## UNC (UNIFIED COARSE) ANSI B1.1 MACHINE TAPS - SPIRAL FLUTE & POINT

- Specially designed for tapping titanium and ti-alloys
- TiCN coated for ti-alloys, high chrome stainless steel, cast iron & high strength bronze
- Powder metal substrate for long tool life
- Spiral flute for blind holes, spiral point for through holes



Type	Spiral Flute	Spiral Point
Series	K42UNC-CT	K52UNC-CT
Brand / Geometry	UFS Top Line - TI	UFS Top Line - TI
Substrate	HSS Powder Metal	HSS Powder Metal
Surface Treatment	TICN Coated	TICN Coated
Tolerance	2BX	2BX
Helix Angle	R15°	L15°
Chamfer Lead	Form C: 2-3	Form D: 4-5
Maximum Depth	1.5xD	3xD
Through Coolant	-	-
Performance	★★★★★	★★★★★

ØD1	TPI	L1	L2	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price	Order Code	Price
No.10	24	8	70	6	4.9	3	3.9	K42UNC10-24CT	£30.95	-	-
1/4	20	10	80	7	5.5	3	5.1	K42UNC1/4CT	£29.54	-	-
5/16	18	13	90	8	6.2	3	6.6	K42UNC5/16CT	£39.50	-	-
3/8	16	15	100	10	8	3	8	K42UNC3/8CT	£41.87	-	-
7/16	14	15	100	8	6.2	4	9.4	K43UNC7/16CT	£49.18	-	-
1/2	13	18	110	9	7	4	10.8	K43UNC1/2CT	£53.93	-	-
5/8	11	20	110	12	9	4	13.5	K43UNC5/8CT	£75.20	-	-
3/4	10	25	125	14	11	4	16.5	K43UNC3/4CT	£99.41	-	-
No.10	24	13	70	6	4.9	3	3.9	-	-	K52UNC10-24CT	£31.72
1/4	20	16	80	7	5.5	3	5.1	-	-	K52UNC1/4CT	£36.93
5/16	18	18	90	8	6.2	3	6.6	-	-	K52UNC5/16CT	£40.36
3/8	16	20	100	10	8	3	8	-	-	K52UNC3/8CT	£42.07
7/16	14	20	100	8	6.2	3	9.4	-	-	K53UNC7/16CT	£47.57
1/2	13	25	110	9	7	3	10.8	-	-	K53UNC1/2CT	£55.83
5/8	11	28	110	12	9	3	13.5	-	-	K53UNC5/8CT	£75.77
3/4	10	32	125	14	11	4	16.5	-	-	K53UNC3/4CT	£99.41

UNC MACHINE TAPS

### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite			Ti	Ti Alloy
K42UNC K52UNC	<400 <700	<850 <850			≤1200	>1200	<850 - -	<850 - -	<1000 6-8	<500 - -	<1000 - -	<700 20-25	<1000 15-20	<700 -	<900 4-8
Series	Titanium	Inconel, Hastelloy, Nickel			Copper, Brass, Bronze				Aluminium			Plastics / Composites			
	Ti Alloy	Nickel	Nickel Alloy		Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP	
K42UNC K52UNC	≤1300	<500	<900 ≤1400		<350	Short Long	<1500	<350	Wrought	Si ≤10% Si >10%					
	2-4	-	2-4	-	-	25-30	-	5-8	-	-	-	25-30	-	-	-





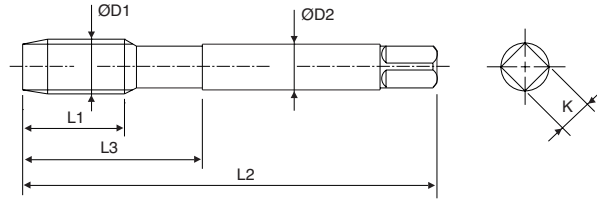
Forming Roll Taps

## UNC (UNIFIED COARSE) ANSI B1.1 MACHINE TAPS - FORMING / ROLL TAPS

- Machine taps for multi material tapping
- PRIME X ROLL tap - advanced geometry & powder metal substrate for higher speed tapping, enhanced tool life and best performance on steel & stainless steel
- For blind and through holes



PRIME X



Series	TRQ18
Brand / Geometry	YG - Prime X Roll
Substrate	HSS Powder Metal
Surface Treatment	X-Coated
Tolerance	2BX
Chamfer Lead	Form C: 2-3
Maximum Depth	3xD
Coolant	With Oil Grooves
Performance	★★★★

ØD1	TPI	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price
No.4	40	7.6	56	18	3.5	2.7	4	2.6	TRQ18162GS	£27.28
No.5	40	7.6	56	18	3.5	2.7	4	2.9	TRQ18202GS	£22.64
No.6	32	9.5	56	20	4	3	4	3.15	TRQ18242GS	£22.64
No.8	32	9.5	63	21	4.5	3.4	4	3.8	TRQ18282GS	£22.64
No.10	24	12.7	70	25	6	4.9	5	4.3	TRQ18322GS	£23.98
No.12	24	12.7	80	30	6	4.9	5	4.95	TRQ18362GS	£24.44
1/4	20	12.7	80	30	7	5.5	5	5.7	TRQ18402GS	£26.16
5/16	18	14.1	90	35	8	6.2	5	7.2	TRQ18442GS	£32.84
3/8	16	15.9	100	39	9	7	8	8.7	TRQ18482GS	£39.60
7/16	14	18.1	100	40	8	6.2	8	10.2	TRQ18522GS	£52.68
1/2	13	19.5	110	44	9	7	8	11.7	TRQ18562GS	£53.28
9/16	12	21.2	110	44	11	9	8	13.2	TRQ18602GS	£69.13
5/8	11	23.1	110	44	12	9	8	14.7	TRQ18642GS	£78.02
3/4	10	20.3	125	50	14	11	8	17.8	TRQ18702GS	£135.34
7/8	9	22.6	140	54	18	14.5	8	20.8	TRQ18742GS	£173.01
1"	8	25.4	160	60	20	16	8	23.8	TRQ18782GS	£234.45

### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite			Ti	Ti Alloy
	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
TRQ18	15-40	15-30	15-30	5-20	-	-	5-15	5-15	-	-	-	-	-	-	-
Series	Titanium				Copper, Brass, Bronze				Aluminium			Plastics / Composites			
	Ti Alloy	Nickel	Nickel Alloy		Cu	Cu Alloy		Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	-
TRQ18	-	-	-	-	10-30	10-30	10-30	20-40	-	20-50	20-50	20-50	-	-	-

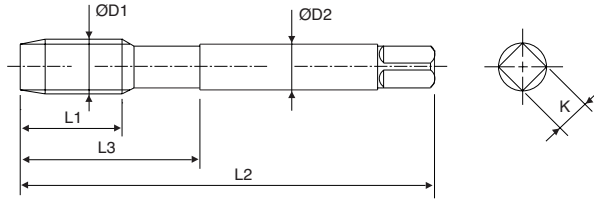
UNC MACHINE TAPS



Thread Repair

### EG-UNC (UNIFIED COARSE) ANSI B1.1 MACHINE TAPS -THREAD REPAIR

- BRIGHT finish prevents swarf sticking to the tap flutes, ideal for steel, copper, aluminium, titanium and nickel
- Suitable for tapping holes for use with all major brand thread repair inserts
- Spiral flute for blind holes, spiral point for through holes
- 2B tolerance



Type	Spiral Flute	Spiral Point
Series	TC944	TC934
Brand / Geometry	YG - Thread Repair	YG - Thread Repair
Substrate	HSS 5% Cobalt	HSS 5% Cobalt
Surface Treatment	Bright	Bright
Tolerance	2B	2B
Helix Angle	R40°	-
Chamfer Lead	Form C: 2-3	Form B: 4-5
Maximum Depth	2.5xD	3xD
Performance	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input type="checkbox"/>	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input type="checkbox"/>

ØD1	TPI	L1	L2	L2	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price	Order Code	Price
No.4	40	7	63	21	4.5	3.4	3	3.1	TC944162	£25.96	TC934162	£27.88
No.5	40	7	63	21	4.5	3.4	3	3.4	TC944202	£20.50	TC934202	£29.60
No.6	32	8	70	25	6	4.9	3	3.8	TC944242	£23.27	TC934242	£31.17
No.8	32	8	80	25	6	4.9	3	4.4	TC944282	£20.50	TC944202	£32.87
No.10	24	10	80	30	7	5.5	3	5.2	TC944322	£21.21	TC934322	£34.60
No.12	24	10	80	30	7	5.5	3	5.8	TC944362	£20.39	TC934362	£36.39
1/4	20	14	90	35	8	6.2	3	6.7	TC944402	£19.19	TC934402	£36.86
5/16	18	16	100	39	10	8	3	8.4	TC944442	£25.64	TC934442	£39.62
3/8	16	16	110	39	12	9	3	10	TC944482	£30.89	TC934482	£41.27
7/16	14	20	110	44	11	9	3	11.6	TC944522	£40.12	TC934522	£42.99
1/2	13	22	110	44	12	9	3	13.3	TC944562	£40.12	TC934562	£44.77
9/16	12	22	125	50	14	11	3	15	TC944602	£48.47	TC934602	£46.42
5/8	11	25	125	50	14	11	4	16.5	TC944642	£60.73	TC934642	£48.18
3/4	10	27	140	56	18	14.5	4	19.75	TC944702	£94.82	TC934702	£49.68

UNC MACHINE TAPS

#### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

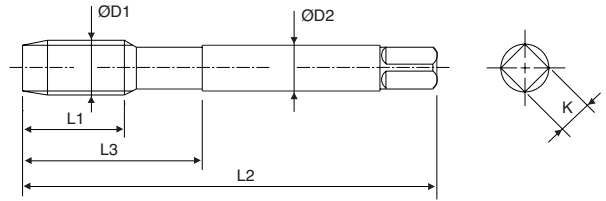
Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium		
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite			Ti	Ti Alloy	
TC944	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900	
TC934	15-20	15-20	12-18	-	-	-	-	-	-	-	-	-	-	-	-	
Series	Titanium				Inconel, Hastelloy, Nickel			Copper, Brass, Bronze			Aluminium			Plastics / Composites		
	Ti Alloy	Nickel	Nickel Alloy		Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP		
TC944	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	-	
TC934	-	-	-	-	8-12	-	-	15-20	-	10-15	10-15	10-15	-	-	-	



Multi Purpose

## UNF (UNIFIED FINE) ANSI B1.1 MACHINE TAPS - SPIRAL FLUTE

- Machine taps for multi material tapping
- COMBO** tap geometry - 1st choice for general tapping with exceptional reliability
- PRIME X tap** - advanced geometry & powder metal substrate for higher speed tapping, enhanced tool life and best performance on steel & stainless steel
- Spiral flute for blind holes



Series	TC864	TD864	TRE33
Brand / Geometry	YG - Combo Tap	YG - Combo Tap	YG - Prime X
Substrate	HSS 5% Cobalt	HSS 5% Cobalt	HSS Powder Metal
Surface Treatment	Bright	TIN Coated	X-Coated
Tolerance	2B	2B	2BX
Helix Angle	R40°	R40°	R45°
Chamfer Lead	Form C: 2-3	Form C: 2-3	Form C: 2-3
Maximum Depth	2.5xD	2.5xD	2.5xD
Through Coolant	-	-	-
Performance	🔴🔴🔴🔴	🔴🔴🔴🔴	🔴🔴🔴🔴

ØD1	TPI	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Series	Order Code	Price	Order Code	Price	Order Code	Price
No.4	48	11	56	18	3.5	2.7	3	2.4	TC864	TC864182	£30.27	TD864182	£34.99	TRE33182GS	£44.50
No.5	44	11	56	18	3.5	2.7	3	2.7	TC864	TC864222	£24.16	TD864222	£28.63	TRE33222GS	£36.18
No.6	40	12	56	20	4	3	3	3	TC864	TC864262	£24.16	TD864262	£28.63	TRE33262GS	£36.18
No.8	36	13	63	21	4.5	3.4	3	3.5	TC864	TC864302	£24.16	TD864302	£28.83	TRE33302GS	£36.33
No.10	32	15	70	25	6	4.9	3	4.1	TC864	TC864342	£24.65	TD864342	£29.27	TRE33342GS	£37.06
No.12	28	16	80	30	6	4.9	3	4.7	TC864	TC864382	£24.16	TD864382	£28.83	TRE33382GS	£37.28
1/4	28	17	80	30	7	5.5	3	5.5	TC864	TC864422	£24.16	TD864422	£28.83	TRE33422GS	£38.79
5/16	24	17	90	35	8	6.2	3	6.9	TC864	TC864462	£26.46	TD864462	£32.51	TRE33462GS	£42.55
3/8	24	18	100	39	9	7	3	8.5	TC864	TC864502	£31.02	TD864502	£38.61	TRE33502GS	£49.99
7/16	20	22	100	40	8	6.2	3	9.9	TC864	TC864542	£37.67	TD864542	£46.75	TRE33542GS	£60.97
1/2	20	22	100	40	9	7	3	11.5	TC864	TC864582	£37.67	TD864582	£47.14	TRE33582GS	£60.97
9/16	18	22	100	40	11	9	3	12.9	TC864	TC864622	£42.30	TD864622	£52.60	TRE33622GS	£69.14
5/8	18	22	100	40	12	9	3	14.5	TC864	TC864662	£53.87	TD864662	£65.62	TRE33662GS	£86.13
3/4	16	25	110	44	14	11	4	17.5	TC864	TC864722	£77.34	TD864722	£94.66	TRE33722GS	£125.81
7/8	14	26	125	50	18	14.5	4	20.5	TC864	TC864762	£89.36	TD864762	£111.33	TRE33762GS	£149.48
1"	12	28	140	54	20	16	4	23.25	TC864	TC864802	£114.76	TD864802	£142.29	TRE33802GS	£195.91

### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

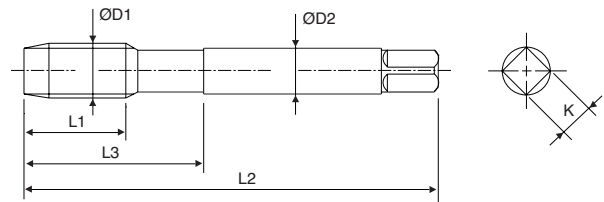
Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite			Ti	Ti Alloy
	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
TC864	15-20	15-20	12-18	10-15	6-10	-	-	-	-	10-15	5-8	10-15	5-8	10-15	-
TD864	-	-	-	-	-	-	7-10	5-8	4-6	-	-	-	-	-	-
TRE33	20-30	20-30	20-25	15-20	5-12	-	10-15	8-10	6-8	-	-	15-20	10-15	-	-
Series	Titanium				Copper, Brass, Bronze				Aluminium			Plastics / Composites			
	Ti Alloy	Nickel	Nickel Alloy		Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP	
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%			
TC864	-	8-12	-	-	8-12	25-35	15-20	-	-	25-35	15-20	10-15	-	-	
TD864	-	-	-	-	-	-	20-25	-	-	25-30	20-25	-	-	-	
TRE33	-	-	-	-	-	-	-	-	-	-	-	-	-	-	



Multi Purpose

### UNF (UNIFIED FINE) ANSI B1.1 MACHINE TAPS - SPIRAL POINT

- Machine taps for multi material tapping
- COMBO** tap geometry - 1st choice for general tapping with exceptional reliability
- PRIME X tap** - advanced geometry & powder metal substrate for higher speed tapping, enhanced tool life and best performance on steel & stainless steel
- Spiral point for through holes



Series	TC874	TD874	TRJ18
Brand / Geometry	YG - Combo Tap	YG - Combo Tap	YG - Prime X
Substrate	HSS 5% Cobalt	HSS 5% Cobalt	HSS Powder Metal
Surface Treatment	Bright	TIN Coated	X-Coated
Tolerance	2B	2B	2BX
Helix Angle	-	-	-
Chamfer Lead	Form B: 4-5	Form B: 4-5	Form B: 4-5
Maximum Depth	3xD	3xD	2.5xD
Through Coolant	-	-	-
Performance	🔴🔴🔴🔴	🔴🔴🔴🔴	🔴🔴🔴🔴

ØD1	TPI	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price	Order Code	Price	Order Code	Price
No.4	48	11	56	18	3.5	2.7	3	2.4	TC874182	£30.27	TD874182	£34.99	TRJ18182GS	£44.50
No.5	44	11	56	18	3.5	2.7	3	2.7	TC874222	£24.16	TD874222	£28.63	TRJ18222GS	£36.18
No.6	40	12	56	20	4	3	3	3	TC874262	£24.16	TD874262	£28.63	TRJ18262GS	£36.18
No.8	36	13	63	21	4.5	3.4	3	3.5	TC874302	£24.16	TD874302	£28.83	TRJ18302GS	£36.33
No.10	32	15	70	25	6	4.9	3	4.1	TC874342	£24.65	TD874342	£29.27	TRJ18342GS	£37.06
No.12	28	16	80	30	6	4.9	3	4.7	TC874382	£24.16	TD874382	£28.83	TRJ18382GS	£37.28
1/4	28	17	80	30	7	5.5	3	5.5	TC874422	£24.16	TD874422	£28.83	TRJ18422GS	£38.79
5/16	24	17	90	35	8	6.2	3	6.9	TC874462	£26.46	TD874462	£32.51	TRJ18462GS	£42.55
3/8	24	18	100	39	9	7	3	8.5	TC874502	£31.02	TD874502	£38.61	TRJ18502GS	£49.99
7/16	20	22	100	40	8	6.2	3	9.9	TC874542	£37.67	TD874542	£46.75	TRJ18542GS	£60.97
1/2	20	22	100	40	9	7	3	11.5	TC874582	£37.67	TD874582	£47.14	TRJ18582GS	£60.97
9/16	18	22	100	40	11	9	3	12.9	TC874622	£42.30	TD874622	£52.60	TRJ18622GS	£69.14
5/8	18	22	100	40	12	9	3	14.5	TC874662	£53.87	TD874662	£65.62	TRJ18662GS	£86.13
3/4	16	25	110	44	14	11	4	17.5	TC874722	£77.34	TD874722	£94.66	TRJ18722GS	£125.81
7/8	14	26	125	50	18	14.5	4	20.5	TC874762	£89.36	TD874762	£111.33	TRJ18762GS	£149.48
1"	12	28	140	54	20	16	4	23.25	TC874802	£114.76	TD874802	£142.29	TRJ18802GS	£195.91

UNF MACHINE TAPS

### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite		Ti	Ti Alloy	
	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
TC834	15-20	15-20	12-18	10-15	6-10	-	-	-	-	10-15	5-8	10-15	5-8	10-15	
TD834	-	-	-	-	-	-	7-10	5-8	4-6	-	-	-	-	-	
TRJ17	20-30	20-30	20-25	15-20	5-12	-	10-15	8-10	6-8	-	-	15-20	10-15	-	
Series	Titanium				Copper, Brass, Bronze				Aluminium			Plastics / Composites			
	Ti Alloy	Nickel	Nickel Alloy		Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP	
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	
TC834	-	8-12	-	-	8-12	25-35	15-20	-	-	25-35	15-20	10-15	-	-	
TD834	-	-	-	-	-	-	-	-	-	-	-	-	-	-	
TRJ17	-	-	-	-	-	-	20-25	-	-	25-30	20-25	-	-	-	

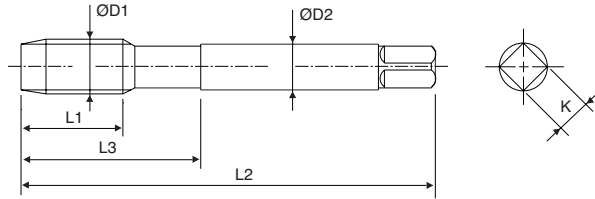




Stainless Steel

### UNF (UNIFIED FINE) ANSI B1.1 MACHINE TAPS - SPIRAL FLUTE

- Machine taps for tapping high stainless steels
- YG-INOX** steam tempered HSSE for general tapping performance on stainless steels
- UFS-TOP LINE** vanadium cobalt for high performance tapping
- Spiral flute for blind holes



Series	TB924	V82/83UNF-TXC
Brand / Geometry	YG - INOX	UFS Top Line - INOX
Substrate	HSS 5% Cobalt	HSS Vanadium Cobalt
Surface Treatment	Steam Tempered	TXC Coated
Tolerance	2B	TBX
Helix Angle	R40°	R48°
Chamfer Lead	Form C: 2-3	Form C: 2-3
Maximum Depth	2.5xD	3.5xD
Through Coolant	-	-
Performance	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input type="checkbox"/>

ØD1	TPI	L1	L2	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price	Order Code	Price
No.10	32	10	70	6	4.9	3	4.1	TB924342	£29.07	-	-
No.12	28	10	80	6	4.9	3	4.7	TB924382	£28.65	-	-
1/4	28	10	80	7	5.5	3	5.5	TB924422	£27.64	-	-
5/16	24	10	90	8	6.2	3	6.9	TB924462	£30.75	-	-
3/8	24	10	100	9	7	3	8.5	TB924502	£35.48	-	-
7/16	20	13	100	8	6.2	3	9.9	TB924542	£44.28	-	-
1/2	20	13	100	9	7	3	11.5	TB924582	£43.86	-	-
9/16	18	15	100	11	9	3	12.9	TB924622	£49.31	-	-
5/8	18	15	100	12	9	3	14.5	TB924662	£62.64	-	-
3/4	16	17	110	14	11	3	17.5	TB924722	£90.41	-	-
7/8	14	17	125	18	14.5	4	20.5	TB924762	£104.05	-	-
No.6	40	7	56	4	3	3	2.95	-	-	V82UNF640TXC	£27.71
No.8	36	7	63	4.5	3.4	3	3.5	-	-	V82UNF836TXC	£27.71
No.10	32	8	70	6	4.9	3	4.1	-	-	V82UNF1032TXC	£30.98
1/4	28	10	80	7	5.5	3	5.5	-	-	V82UNF1/4TXC	£33.26
3/8	24	15	90	7	5.5	3	8.5	-	-	V83UNF3/8TXC	£40.21
7/16	20	15	100	8	6.2	3	9.9	-	-	V83UNF7/16TXC	£47.05
1/2	20	13	100	9	7	4	11.5	-	-	V83UNF1/2TXC	£53.83
9/16	18	15	100	11	9	4	12.9	-	-	V83UNF9/16TXC	£68.38
5/8	18	15	100	12	9	4	14.5	-	-	V83UNF5/8TXC	£72.47
3/4	16	17	110	14	11	4	17.5	-	-	V83UNF3/4TXC	£111.16

UNF MACHINE TAPS

### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

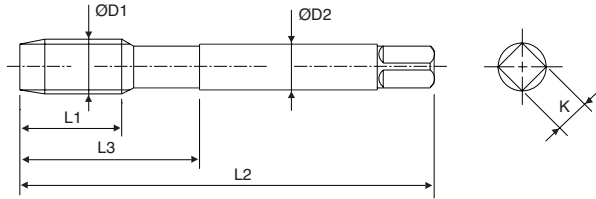
Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium		
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite			Ti	Ti Alloy	
TB924	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900	
V82UNF	20-25	20-25	18-24	15-20	-	-	10-13	8-11	6-8	-	-	-	-	-	-	
	-	-	20-25	15-20	5-12	-	10-15	8-10	6-8	-	-	-	-	-	-	
Series	Titanium			Inconel, Hastelloy, Nickel			Copper, Brass, Bronze				Aluminium			Plastics / Composites		
	Ti Alloy	Nickel	Nickel Alloy				Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP
TB924	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	-	
V82UNF	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	



Stainless Steel

UNF (UNIFIED FINE) ANSI B1.1 MACHINE TAPS - SPIRAL POINT

- Machine taps for tapping high stainless steels
- YG-INOX steam tempered HSS-E for general tapping performance on stainless steels
- UFS-TOP LINE vanadium cobalt for high performance tapping
- Spiral point for through holes



Series	TB274	V24/25UNF-TXC
Brand / Geometry	YG - INOX	UFS Top Line - INOX
Substrate	HSS 5% Cobalt	HSS Vanadium Cobalt
Surface Treatment	Steam Tempered	TXC Coated
Tolerance	2B	2BX
Helix Angle	-	-
Chamfer Lead	Form B: 4-5	Form B: 4-5
Maximum Depth	3xD	3xD
Through Coolant	-	-
Performance	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input type="checkbox"/>

ØD1	TPI	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price	Order Code	Price
No.10	32	15	70	25	6	4.9	3	4.1	TB274342	£28.47	-	-
No.12	28	16	80	30	6	4.9	3	4.7	TB274382	£28.01	-	-
1/4	28	17	80	30	7	5.5	3	5.5	TB274422	£27.15	-	-
5/16	24	17	90	35	8	6.2	3	6.9	TB274462	£30.18	-	-
3/8	24	18	100	39	9	7	3	8.5	TB274502	£34.74	-	-
7/16	20	22	100	40	8	6.2	3	9.9	TB274542	£43.21	-	-
1/2	20	22	100	40	9	7	3	11.5	TB274582	£43.01	-	-
9/16	18	22	100	40	11	9	3	12.9	TB274622	£48.41	-	-
5/8	18	22	100	40	12	9	3	14.5	TB274662	£61.41	-	-
3/4	16	25	110	44	14	11	4	17.5	TB274722	£88.74	-	-
7/8	14	26	125	50	18	14.5	4	20.5	TB274762	£102.13	-	-
No.6	40	11	56	-	4	3	3	2.95	-	-	V24UNF6-40TXC	£22.16
No.8	36	13	63	-	4.5	3.4	3	3.5	-	-	V24UNF8-36TXC	£22.16
No.10	32	13	70	-	6	4.9	3	4.1	-	-	V24UNF10-32TXC	£22.16
1/4	28	16	80	-	7	5.5	3	5.5	-	-	V24UNF1/4TXC	£28.48
5/16	24	18	90	-	6	4.9	3	6.9	-	-	V25UNF5/16TXC	£31.29
3/8	24	15	90	-	7	5.5	3	8.5	-	-	V25UNF3/8TXC	£34.19
7/16	20	20	100	-	8	6.2	3	9.9	-	-	V25UNF7/16TXC	£42.48
1/2	20	20	100	-	9	7	4	11.5	-	-	V25UNF1/2TXC	£48.57
9/16	18	22	100	-	11	9	4	12.9	-	-	V25UNF9/16TXC	£57.18
5/8	18	22	100	-	12	9	4	14.5	-	-	V25UNF5/8TXC	£61.98
3/4	16	25	110	-	14	11	4	17.5	-	-	V25UNF3/4TXC	£86.03

UNF MACHINE TAPS

Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium		
	Soft Steels		Carbon	Alloy	Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite			Ti	Ti Alloy	
TB274	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900	
V25UNF	20-25	20-25	18-24	15-20	-	-	10-13	8-11	6-8	-	-	-	-	-	-	
	-	-	20-25	15-20	5-12	-	10-15	8-10	6-8	-	-	-	-	-	-	
Series	Titanium			Inconel, Hastelloy, Nickel			Copper, Brass, Bronze				Aluminium			Plastics / Composites		
	Ti Alloy	Nickel	Nickel Alloy	Cu	Cu Alloy		Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP		
TB274	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	-	
V25UNF	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	

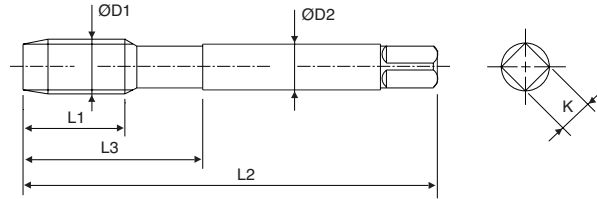


GG

Cast Iron

## UNF (UNIFIED FINE) ANSI B1.1 MACHINE TAPS - STRAIGHT FLUTE

- Suitable for tapping grey cast iron, short chipping brass/bronze and GFRP/CFRP
- Straight flute for through & blind holes



Series	TE454
Brand / Geometry	YG - GG
Substrate	HSS 5% Cobalt
Surface Treatment	Nitrided
Tolerance	2BX
Helix Angle	-
Chamfer Lead	Form C: 2-3
Maximum Depth	2xD
Through Coolant	-
Performance	<span style="color: orange;">■</span> <span style="color: red;">■</span> <span style="color: blue;">■</span> <span style="color: green;">■</span> <span style="color: purple;">■</span>

ØD1	TPI	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price
No.10	32	15	70	25	6	4.9	3	4.1	TE454342	£18.41
No.12	28	16	80	30	6	4.9	4	4.7	TE454382	£18.41
1/4	28	17	80	30	7	5.5	4	5.5	TE454422	£18.41
5/16	24	17	90	35	8	6.2	4	6.9	TE454462	£23.93
3/8	24	18	100	39	9	7	4	8.5	TE454502	£28.86
7/16	20	22	100	40	8	6.2	4	9.9	TE454542	£38.38
1/2	20	22	100	40	9	7	4	11.5	TE454582	£38.38
9/16	18	22	100	40	11	9	4	12.9	TE454622	£48.76
5/8	18	22	100	40	12	9	4	14.5	TE454662	£59.08
3/4	16	25	110	44	14	11	4	17.5	TE454722	£85.80
7/8	14	26	125	50	18	14.5	4	20.5	TE454762	£106.34

UNF MACHINE TAPS

### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

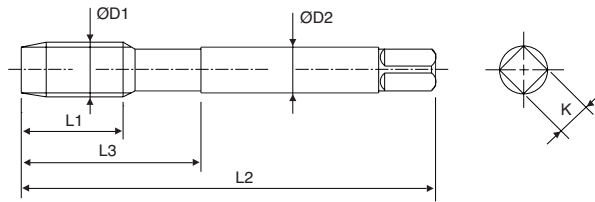
Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite		Ti	Ti Alloy	
TE454	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
Series	Titanium	Inconel, Hastelloy, Nickel			Copper, Brass, Bronze				Aluminium			Plastics / Composites			
TE454	Ti Alloy	Nickel	Nickel Alloy		Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP	
TE454	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	5-7



Forming Roll Taps

## UNF (UNIFIED FINE) ANSI B1.1 MACHINE TAPS - FORMING / ROLL TAPS

- Machine taps for multi material tapping
- PRIME X ROLL TAP** - advanced geometry & powder metal substrate for higher speed tapping enhanced tool life and best performance on steel & stainless steel
- For blind and through holes



Series	TRQ19
Brand / Geometry	YG - Prime X Roll
Substrate	HSS Powder Metal
Surface Treatment	X-Coated
Tolerance	2BX
Chamfer Lead	Form C: 2-3
Maximum Depth	3xD
Coolant	With Oil Grooves
Performance	★★★★

ØD1	TPI	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price
No.4	48	7.6	56	18	3.5	2.7	4	2.6	TRQ19182GS	£52.28
No.5	44	7.6	56	18	3.5	2.7	4	2.9	TRQ19222GS	£42.53
No.6	40	9.5	56	20	4	3	4	3.25	TRQ19262GS	£42.53
No.8	36	9.5	63	21	4.5	3.4	4	3.9	TRQ19302GS	£42.53
No.10	32	12.7	70	25	6	4.9	5	4.45	TRQ19342GS	£43.52
No.12	28	12.7	80	30	6	4.9	5	5.05	TRQ19382GS	£43.82
1/4	28	12.7	80	30	7	5.5	5	5.9	TRQ19422GS	£45.60
5/16	24	14.1	90	35	8	6.2	5	7.4	TRQ19462GS	£50.03
3/8	24	15.9	100	39	9	7	8	9	TRQ19502GS	£58.79
7/16	20	18.1	100	40	8	6.2	8	10.5	TRQ19542GS	£71.72
1/2	20	19.5	100	40	9	7	8	12.1	TRQ19582GS	£71.72
9/16	18	21.2	100	40	11	9	8	13.6	TRQ19622GS	£81.28
5/8	18	23.1	100	40	12	9	8	15.2	TRQ19662GS	£101.23
3/4	16	15.9	110	44	14	11	8	18.3	TRQ19722GS	£147.93
7/8	14	18.1	125	50	18	14.5	8	21.3	TRQ19762GS	£175.75
1"	12	21.2	140	54	20	16	8	24.3	TRQ19802GS	£230.32

UNF MACHINE TAPS

### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite			Ti	Ti Alloy
	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
TRQ19	15-40	15-30	15-30	5-20	-	-	5-15	5-15	-	-	-	-	-	-	-
Series	Titanium				Copper, Brass, Bronze				Aluminium				Plastics / Composites		
	Ti Alloy	Nickel	Nickel Alloy		Cu	Cu Alloy		Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	-
TRQ19	-	-	-	-	10-30	10-30	10-30	20-40	-	20-50	20-50	20-50	-	-	-

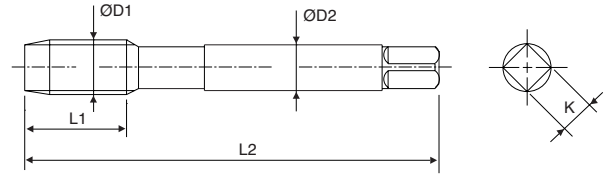


Multi Purpose

## UNEF (EXTRA FINE) ANSI B1.1 TAP MACHINE TAPS - SPIRAL FLUTE & POINT

HSS 5% Cobalt Machine Taps for General Purpose Machine Tapping

- Designed for everyday tapping of a wide range of materials including low to medium hardness steels, aluminium, copper & brass
- BRIGTH finish prevents swarf sticking to the tap flutes
- Spiral flute for blind holes and spiral point through holes



Type	Spiral Point	Spiral Flute
Series	E25UNEF	E61UNEF
Brand / Geometry	UFS	UFS
Substrate	HSS 5% Cobalt	HSS 5% Cobalt
Surface Treatment	Bright	Bright
Tolerance	2B	2B
Helix Angle	-	R40°
Chamfer Lead	Form B: 4-5	Form C: 2-3
Maximum Depth	3xD	3xD
Through Coolant	-	-
Performance	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>

ØD1	TPI	L1	L2	ØD2 h9	K h12	No. of Flutes	Drill Dia.	Order Code	Price	Order Code	Price
<b>Spiral Point</b>											
1/4	32	16	80	4.5	3.4	3	5.55	E25UNEF1/4	£43.03	-	-
5/16	32	18	90	6	4.9	3	7.15	E25UNEF5/16	£53.63	-	-
3/8	32	15	90	7	5.5	3	8.7	E25UNEF3/8	£61.22	-	-
7/16	28	20	100	8	6.2	3	10.2	E25UNEF7/16	£68.24	-	-
1/2	28	20	100	9	7	3	11.8	E25UNEF1/2	£71.80	-	-
9/16	24	22	100	11	9	4	13.2	E25UNEF9/16	£87.86	-	-
5/8	24	22	100	12	9	4	14.8	E25UNEF5/8	£104.08	-	-
11/16	24	25	110	14	11	4	16.4	E25UNEF11/16	£113.54	-	-
3/4	20	25	110	14	11	4	17.8	E25UNEF3/4	£120.78	-	-
13/16	20	25	125	18	14.5	4	19.4	E25UNEF13/16	£129.75	-	-
7/8	20	25	125	18	14.5	4	20.95	E25UNEF7/8	£136.50	-	-
<b>Spiral Flute</b>											
1/4	32	10	80	4.5	3.4	3	5.55	-	-	E61UNEF1/4	£33.29
5/16	32	13	90	6	4.9	3	7.15	-	-	E61UNEF5/16	£42.39
3/8	32	15	90	7	5.5	3	8.7	-	-	E61UNEF3/8	£48.54
7/16	28	15	100	8	6.2	3	10.2	-	-	E61UNEF7/16	£53.06
1/2	28	13	100	9	7	3	11.8	-	-	E61UNEF1/2	£56.15
9/16	24	15	100	11	9	4	13.2	-	-	E61UNEF9/16	£68.19
5/8	24	15	100	12	9	4	14.8	-	-	E61UNEF5/8	£81.81
11/16	24	17	110	14	11	4	16.4	-	-	E61UNEF11/16	£87.62
3/4	20	17	110	14	11	4	17.8	-	-	E61UNEF3/4	£94.21
13/16	20	18	125	18	14.5	4	19.4	-	-	E61UNEF13/16	£100.22
7/8	20	18	125	18	14.5	4	20.95	-	-	E61UNEF7/8	£105.55

### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite			Ti	Ti Alloy
E25UNEF	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
E61UNEF	10-15	10-15	10-12	8-10	-	-	-	-	-	-	-	-	-	-	-
Series	Titanium				Copper, Brass, Bronze				Aluminium			Plastics / Composites			
	Ti Alloy	Nickel	Nickel Alloy		Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP	
E25UNEF	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	
E61UNEF	-	-	-	-	8-12	-	10-15	-	10-15	-	15-20	-	-	-	

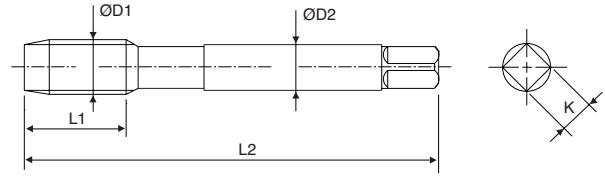


Multi Purpose

## UNS (UNIFIED NATIONAL SPECIAL) ANSI B1.1 MACHINE TAP - STRAIGHT FLUTE

HSS 5% Cobalt Machine Taps for General Purpose Machine Tapping

- Designed for everyday tapping of a wide range of materials including low to medium hardness steel, cast iron, aluminium, copper, brass & short chipping plastic
- BRIGHT finish prevents swarf sticking to the tap flutes
- Straight flute for blind and through holes



Series	E20/21-UNS
Brand / Geometry	UFS
Substrate	HSS 5% Cobalt
Surface Treatment	Bright
Tolerance	2B
Helix Angle	-
Chamfer Lead	Form C: 2-3
Maximum Depth	1.5xD
Through Coolant	-
Performance	

ØD1	TPI	L1	L2	ØD2 h9	K h12	No. of Flutes	Drill Dia.	Order Code	Price
No.10	48	13	70	6	4.9	3	4.3	E20-48UNS10	£25.52
No.10	40	13	70	6	4.9	3	4.2	E20-40UNS10	£25.52
No.12	36	16	80	6	4.9	3	4.8	E20-36UNS12	£25.52
1/4	40	16	80	7	5.5	3	5.7	E20-40UNS1/4	£23.86
1/4	36	16	80	7	5.5	3	5.6	E20-36UNS1/4	£25.15
1/4	24	16	80	7	5.5	3	5.3	E20-24UNS1/4	£28.91
5/16	40	18	90	6	4.9	3	7.3	E21-40UNS5/16	£28.25
3/8	40	15	90	7	5.5	3	8.9	E21-40UNS3/8	£31.32
3/8	27	15	90	7	5.5	3	8.6	E21-27UNS3/8	£32.94
3/8	18	20	100	7	5.5	3	8.1	E21-18UNS3/8	£36.21
7/16	27	20	100	8	6.2	3	10.2	E21-27UNS7/16	£33.88
7/16	24	20	100	8	6.2	3	10.05	E21-24UNS7/16	£35.65
1/2	27	20	100	9	7	3	11.75	E21-27UNS1/2	£40.41
1/2	24	20	100	9	7	3	11.6	E21-24UNS1/2	£42.37
5/8	27	22	100	12	9	4	14.9	E21-27UNS5/8	£48.65
11/16	18	25	110	14	11	4	16.05	E21-18UNS11/16	£53.41
3/4	18	25	110	14	11	4	17.6	E21-18UNS3/4	£71.77
7/8	24	25	125	18	14.5	4	21.2	E21-24UNS7/8	£89.44
15/16	18	25	140	18	14.5	4	22.4	E21-18UNS15/16	£80.92
1"	24	28	140	18	14.5	4	24.3	E21-24UNS1"	£192.42
1"	18	28	140	18	14.5	4	24	E21-18UNS1"	£117.67
1"	14	28	140	18	14.5	4	23.6	E21-14UNS1"	£127.23
1" 1/4	14	28	150	22	18	5	29.9	E21-14UNS1"1/4	£304.30
1" 5/16	14	30	170	28	22	5	31.5	E21-14UNS1"5/16	£320.85

UNS MACHINE TAPS

### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

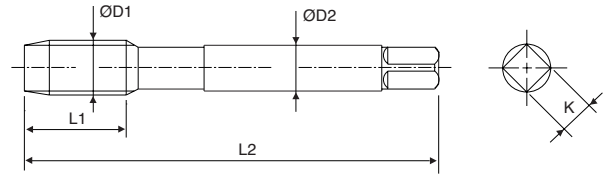
Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/ Graphite		Ti	Ti Alloy	
E20/21-UNS	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
	10-15	10-15	10-12	8-10	-	-	-	-	-	-	-	-	-	-	-
Series	Titanium				Copper, Brass, Bronze				Aluminium			Plastics / Composites			
	Ti Alloy	Nickel	Nickel Alloy		Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP	
E20/21-UNS	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	
	-	-	-	-	8-12	-	10-15	-	10-15	-	15-20	-	-	-	



## 8-UN, 12-UN & 16-UN UNIFIED NATIONAL ANSI B1.1 MACHINE TAP - STRAIGHT FLUTE

HSS 5% Cobalt Machine Taps for General Purpose Machine Tapping

- Designed for everyday tapping of a wide range of materials including low to medium hardness steels, cast iron, aluminium, copper, brass & short chipping plastics
- BRIGHT finish prevents swarf sticking to the tap flutes
- Straight flute for blind and through holes



Series	E21-UN
Brand / Geometry	UFS
Substrate	HSS 5% Cobalt
Surface Treatment	Uncoated
Tolerance	2B
Helix Angle	-
Chamfer Lead	Form C: 2-3
Maximum Depth	1.5xD
Through Coolant	-
Performance	<span style="color: orange;">■</span> <span style="color: orange;">■</span> <span style="color: orange;">■</span> <span style="color: orange;">■</span> <span style="color: orange;">■</span> <span style="color: orange;">■</span>

ØD1	TPI	L1	L2	ØD2 h9	K h12	No. of Flutes	Drill Dia.	Order Code	Price
<b>8-UN</b>									
1"1/8	8	40	180	22	18	4	25.4	E21-8UN1"1/8	£137.49
1"1/4	8	40	180	22	18	4	28.6	E21-8UN1"1/4	£173.89
1"3/8	8	50	200	28	22	4	31.75	E21-8UN1"3/8	£231.47
1"1/2	8	50	200	28	22	4	34.9	E21-8UN1"1/2	£261.93
1"5/8	8	50	200	32	24	5	38.1	E21-8UN1"5/8	£324.95
1"3/4	8	50	200	36	29	5	41.3	E21-8UN1"3/4	£391.24
1"7/8	8	60	225	36	29	6	44.45	E21-8UN1"7/8	£467.31
2"	8	60	225	40	32	6	47.6	E21-8UN2"	£537.94
2"1/4	8	65	250	45	35	6	54	E21-8UN2"1/4	£581.39
2"1/2	8	70	275	50	39	6	60.3	E21-8UN2"1/2	£793.34
<b>12-UN</b>									
7/8	12	25	125	18	14.5	4	20.1	E21-12UN7/8	£83.13
1"1/16	12	25	140	20	16	4	24.9	E21-12UN1"1/16	£125.51
1"3/16	12	28	150	22	18	4	28	E21-12UN1"3/16	£148.90
1"5/16	12	30	170	28	22	5	31.2	E21-12UN1"5/16	£218.99
1"7/16	12	30	170	28	22	6	34.4	E21-12UN1"7/16	£248.55
1"5/8	12	30	170	32	24	6	39.2	E21-12UN1"5/8	£323.63
1"3/4	12	32	180	36	29	6	42.3	E21-12UN1"3/4	£396.67
2"	12	32	190	40	32	6	48.7	E21-12UN2"	£507.18
<b>16-UN</b>									
1"	16	28	140	18	14.5	4	23.8	E21-16UN1"	£120.20
1"1/8	16	28	150	22	18	4	27	E21-16UN1"1/8	£152.48
1"1/4	16	28	150	22	18	5	30.15	E21-16UN1"1/4	£195.82
1"1/2	16	30	170	28	22	6	36.5	E21-16UN1"1/2	£309.05
2"	16	32	190	40	32	6	49.2	E21-16UN2"	£507.18

### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium				
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast Iron	Malleable Cast Iron/Graphite			Ti	Ti Alloy			
	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900			
E21-8UN																		
E21-12UN	10-15	10-15	10-12	8-10	-	-	-	-	-	-	-	-	-	-	-			
E21-16UN																		
Series	Titanium				Inconel, Hastelloy, Nickel				Copper, Brass, Bronze				Aluminium			Plastics / Composites		
	Ti Alloy	Nickel	Nickel Alloy		Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP				
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%						
E21-8UN					8-12		10-15		10-15					8-10				
E21-12UN																		
E21-16UN																		

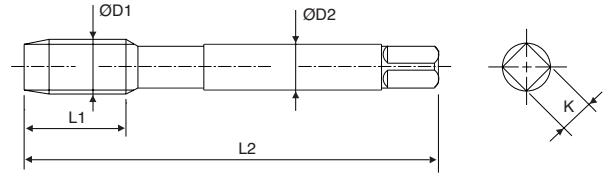


Multi Purpose

## PG STEEL CONDUIT THREAD DIN 40432 MACHINE TAP - STRAIGHT FLUTE

HSS 5% Cobalt Machine Taps for General Purpose Machine Tapping

- Designed for everyday tapping of a wide range of materials including low to medium hardness steels, cast iron, aluminium, copper, brass & short chipping plastics
- BRIGHT finish prevents swarf sticking to the tap flutes
- Straight flute



Series	E21PG
Brand / Geometry	UFS
Substrate	HSS 5% Cobalt
Surface Treatment	Uncoated
Chamfer Lead	Form C: 2-3
Maximum Depth	1.5xD
Through Coolant	-
Performance	● ● ● ● ● ●

PG	ØD1	TPI	L1	L2	ØD2 h9	K h12	No. of Flutes	Drill Dia.	Order Code	Price
7	12.5	20	20	70	9	7	3	11.4	E21PG7	£59.60
9	15.20	18	20	70	12	9	4	14	E21PG9	£62.19
11	18.60	18	22	80	14	11	4	17.25	E21PG11	£59.60
13.5	20.40	18	22	80	16	12	4	19	E21PG13.5	£89.82
16	22.50	18	22	80	18	14.5	4	21.25	E21PG16	£104.35
21	28.30	16	22	90	22	18	4	27	E21PG21	£116.49
29	37	16	25	100	28	22	6	35.5	E21PG29	£206.42
36	47	16	25	140	36	29	6	45.5	E21PG36	£359.49
42	54	16	28	140	40	32	6	52.5	E21PG42	£444.36
48	59.30	16	36	140	45	35	6	58	E21PG48	£681.34

UN MACHINE TAPS

### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels <400 <700	Carbon <850	Alloy <850		Pre-Hard ≤1200	Hardened >1200	Free Mach. <850	Austenitic <850	Fer/Marten. <1000	Grey Cast iron <500	<1000	Malleable Cast Iron/Graphite <700	<1000	Ti <700	Ti Alloy <900
E21PG	10-15	10-15	10-12	8-10	-	-	-	-	-	-	-	8-10	-	-	-

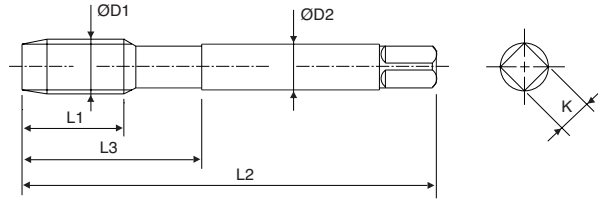
Series	Titanium	Inconel, Hastelloy, Nickel		Copper, Brass, Bronze			Aluminium			Plastics / Composites					
	Ti Alloy ≤1300	Nickel <500	Nickel Alloy <900	≤1400	Cu <350	Cu Alloy Short	Long	Cu-Al-Fe <1500	Al/Mg <350	Al Wrought	Al Si ≤10%	Al Si >10%	Thermo	Thermoset	CFRP/GFRP
E21PG	-	-	-	-	-	15-20	10-15	-	-	15-20	10-15	-	-	8-10	-



Multi Purpose

## BSP(G) WHITWORTH PIPE THREAD DIN ISO 228/1 MACHINE TAPS - SPIRAL FLUTE

- Machine taps for multi material tapping
- GS tap geometry** - tapping of steels, cast iron, aluminium, copper and brass
- PRIME X tap** - advanced geometry & powder metal substrate for higher speed tapping, enhanced tool life and best performance on steel & stainless steel
- Spiral flute for blind holes



Series	TC728	TD728	TRE37	TRE42
Brand / Geometry	YG - GS	YG - GS	YG - Prime X	YG - Prime X
Substrate	HSS 5% Cobalt	HSS 5% Cobalt	HSS Powder Metal	HSS Powder Metal
Surface Treatment	Bright	TIN Coated	X-Coated	X-Coated
Tolerance	ISO 228	ISO 228	ISO 228X	ISO 228X
Helix Angle	R40°	R40°	R45°	R45°
Chamfer Lead	Form C: 2-3	Form C: 2-3	Form C: 2-3	Form C: 2-3
Maximum Depth	2.5xD	2.5xD	2.5xD	2.5xD
Through Coolant	-	-	-	
Performance				

ØD1	TPI	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price	Order Code	Price	Order Code	Price	Order Code	Price
G1/8	28	20	90	36	7	5.5	3	8.8	TC728200	£21.93	TD728200	£20.95	-	-	-	-
G1/4	19	22	100	40	11	9	3	11.8	TC728400	£28.25	TD728400	£27.87	-	-	-	-
G3/8	19	22	100	40	12	9	3	15.25	TC728480	£32.97	TD728480	£32.27	-	-	-	-
G1/2	14	25	125	50	16	12	4	19	TC728560	£47.71	TD728560	£46.75	-	-	-	-
G3/4	14	28	140	54	20	16	4	24.5	TC728700	£89.62	TD728700	£85.30	-	-	-	-
G1	11	30	160	60	25	20	4	30.75	TC728780	£127.41	TD728780	£127.32	-	-	-	-
G1/16	28	10	90	36	6	4.9	3	6.8	-	-	-	-	TRE37020GS	£30.76	TRE42020GS	£42.14
G1/8	28	12	90	36	7	5.5	3	8.8	-	-	-	-	TRE37200GS	£30.76	TRE42200GS	£42.14
G1/4	19	14	100	48	11	9	3	11.8	-	-	-	-	TRE37400GS	£40.42	TRE42400GS	£55.34
G3/8	19	16	100	52	12	9	4	15.25	-	-	-	-	TRE37480GS	£48.23	TRE42480GS	£66.04
G1/2	14	18	125	70	16	12	4	19	-	-	-	-	TRE37560GS	£75.13	TRE42560GS	£102.96
G3/4	14	22	140	82	20	16	4	24.5	-	-	-	-	TRE37700GS	£141.53	TRE42700GS	£193.91
G1"	11	24	160	95	25	20	4	30.75	-	-	-	-	TRE37780GS	£211.26	TRE42780GS	£289.42

BSP(G) WHITWORTH MACHINE TAPS

### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

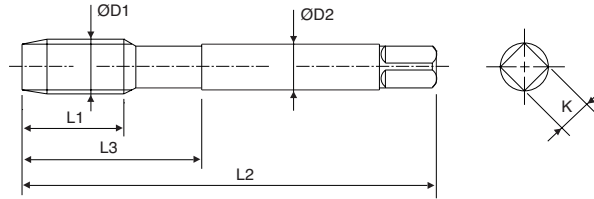
Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels	Carbon	Alloy	Alloy	Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite	Ti	Ti Alloy		
	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
TC728	-	15-20	12-18	10-15	-	-	-	-	-	-	-	10-15	5-8	-	-
TD728	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
TRE37	20-30	20-30	20-25	15-20	5-12	-	10-15	8-10	6-8	-	-	15-20	10-15	-	-
TRE42	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
Series	Titanium	Inconel, Hastelloy, Nickel			Copper, Brass, Bronze			Aluminium			Plastics / Composites				
	Ti Alloy	Nickel	Nickel Alloy	Nickel Alloy	Cu	Cu Alloy	Cu	Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	-
TC864	-	-	-	-	8-12	25-35	15-20	-	-	25-35	15-20	10-15	-	-	-
TD864	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
TRE37	-	-	-	-	-	-	20-25	-	-	25-30	20-25	-	-	-	-
TRE42	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-



Multi Purpose

### BSP(G) WHITWORTH PIPE THREAD DIN ISO 228/1 MACHINE TAPS - SPIRAL POINT

- Machine taps for multi material tapping
- GS tap geometry** - tapping of steels, cast iron, aluminium, copper and brass
- PRIME X tap** - advanced geometry & powder metal substrate for higher speed tapping, enhanced tool life and best performance on steel & stainless steel
- Spiral point for through holes



Series	TC727	TD727	TRJ12
Brand / Geometry	YG - GS	YG - GS	YG - Prime X
Substrate	HSS 5% Cobalt	HSS 5% Cobalt	HSS Powder Metal
Surface Treatment	Bright	TIN Coated	X-Coated
Tolerance	ISO 228	ISO 228	ISO 228X
Helix Angle	-	-	-
Chamfer Lead	Form B: 4-5	Form B: 4-5	Form B: 4-5
Maximum Depth	3xD	3xD	3xD
Through Coolant	-	-	-
Performance	●●●○	●●●○	●●●○

ØD1	TPI	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price	Order Code	Price	Order Code	Price
G1/8	28	20	90	36	7	5.5	3	8.8	TC727200	£21.93	TD727200	£20.62	-	-
G1/4	19	22	100	40	11	9	3	11.8	TC727400	£28.25	TD727400	£27.28	-	-
G3/8	19	22	100	40	12	9	3	15.25	TC727480	£32.97	TD727480	£32.27	-	-
G1/2	14	25	125	50	16	12	4	19	TC727560	£47.71	TD727560	£46.89	-	-
G3/4	14	28	140	54	20	16	4	24.5	TC727700	£89.62	TD727700	£83.26	-	-
G1	11	30	160	60	25	20	4	30.75	TC727780	£127.41	TD727780	£124.41	-	-
G1/16	28	10	90	36	6	4.9	3	6.8	-	-	-	-	TRJ12020GS	£30.76
G1/8	28	12	90	36	7	5.5	3	8.8	-	-	-	-	TRJ12200GS	£30.76
G1/4	19	14	100	48	11	9	3	11.8	-	-	-	-	TRJ12400GS	£40.42
G3/8	19	16	100	52	12	9	4	15.25	-	-	-	-	TRJ12480GS	£48.23
G1/2	14	18	125	70	16	12	4	19	-	-	-	-	TRJ12560GS	£75.13
G3/4	14	22	140	82	20	16	4	24.5	-	-	-	-	TRJ12700GS	£141.53
G1"	11	24	160	95	25	20	4	30.75	-	-	-	-	TRJ12780GS	£211.26

BSP(G) WHITWORTH MACHINE TAPS

#### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

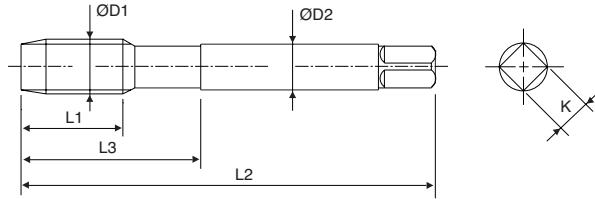
Series	Steels				Hardened Steels		Stainless Steels			Cast Iron			Titanium	
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast Iron	Malleable Cast Iron/Graphite		Ti	Ti Alloy
TC727	<400	<700	<850	<850	<1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<900
TD727	-	15-20	12-18	10-15	-	-	-	-	-	-	-	10-15	5-8	-
TRJ12	20-30	20-30	20-25	15-20	5-12	-	10-15	8-10	6-8	-	-	15-20	10-15	-
Series	Titanium				Copper, Brass, Bronze				Aluminium			Plastics / Composites		
	Ti Alloy	Nickel	Inconel, Hastelloy, Nickel	Nickel Alloy	Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP
TC727	<1300	<500	<900	<1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-
TD727	-	-	-	-	8-12	25-35	15-20	-	-	25-35	15-20	10-15	-	-
TRJ12	-	-	-	-	-	-	20-25	-	-	25-30	20-25	-	-	-



Stainless Steel

### BSP(G) WHITWORTH PIPE THREAD DIN ISO 228/1 MACHINE TAPS - SPIRAL FLUTE

- Machine taps for stainless steel tapping
- YG INOX** steam tempered surface treatment for general tapping performance
- UFS INOX** vanadium cobalt 48° helix tap for high performance and tool life
- Spiral flute for blind holes



Series	TB514	V83G-TXC
Brand / Geometry	YG - INOX	YG - INOX
Substrate	HSS 5% Cobalt	HSS 3% Vanadium
Surface Treatment	Steam Tempered	TXC Coated
Tolerance	ISO 228	ISO 228X
Helix Angle	R40°	R48°
Chamfer Lead	Form C: 2-3	Form C: 2-3
Maximum Depth	2.5xD	3xD
Through Coolant	-	-
Performance		

ØD1	TPI	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price	Order Code	Price
G1/8	28	20	90	36	7	5.5	3	8.8	TB514200	£34.21	-	-
G1/4	19	22	100	40	11	9	3	11.8	TB514400	£45.71	-	-
G3/8	19	22	100	40	12	9	3	15.25	TB514480	£63.15	-	-
G1/2	14	25	125	50	16	12	4	19	TB514560	£75.31	-	-
G3/4	14	28	140	54	20	16	4	24.5	TB514700	£140.78	-	-
G1	11	30	160	60	25	20	4	30.75	TB514780	£209.86	-	-
G1/8	28	15	90	36	7	5.5	3	8.8	-	-	V83G1/8TXC	£35.56
G1/4	19	15	100	40	11	9	3	11.8	-	-	V83G1/4TXC	£49.11
G3/8	19	15	100	40	12	9	4	15.25	-	-	V83G3/8TXC	£61.90
G1/2	14	18	125	50	16	12	4	19	-	-	V83G1/2TXC	£85.13
G3/4	14	20	140	54	20	16	4	24.5	-	-	V83G3/4TXC	£140.94

BSP(G) WHITWORTH MACHINE TAPS

#### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium				
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast Iron	Malleable Cast Iron/Graphite			Ti	Ti Alloy			
TB514	<400	<700	<850	<850	<1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900			
TB514HAR	-	-	-	-	-	-	7-10	5-8	4-6	-	-	-	-	-	-			
V83G-TXC	15-20	15-20	-	-	-	-	-	-	-	-	-	-	-	-	8-12			
Series	Titanium				Inconel, Hastelloy, Nickel				Copper, Brass, Bronze				Aluminium			Thermo	Thermoset	CFRP/GFRP
	Ti Alloy	Nickel	Nickel Alloy		Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al							
TB514	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	-			
TB514HAR	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-			
V83G-TXC	-	-	-	10-15	-	-	-	-	-	-	-	-	-	-	-			

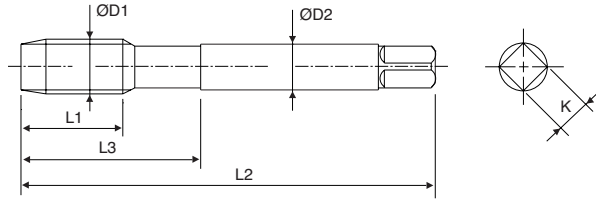


INOX

Stainless Steel

### BSP(G) WHITWORTH PIPE THREAD DIN ISO 228/1 MACHINE TAPS - SPIRAL POINT

- Machine taps for multi material tapping
- UFS Top Line vanadium cobalt tap for high performance and tool life, excellent in deep hole tapping
- Spiral point for through holes



Series	V25G-TXC
Brand / Geometry	UFS - INOX
Substrate	HSS 3% Vanadium
Surface Treatment	TXC Coated
Tolerance	ISO 228X
Helix Angle	-
Chamfer Lead	Form B: 4-5
Maximum Depth	3xD
Through Coolant	-
Performance	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input type="checkbox"/>

ØD1	TPI	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price
G1/8	28	15	90	36	7	5.5	3	8.8	V25G1/8TXC	£31.76
G1/4	19	22	100	40	11	9	4	11.8	V25G1/4TXC	£44.15
G3/8	19	22	100	40	12	9	4	15.25	V25G3/8TXC	£55.73
G1/2	14	25	125	50	16	12	4	19	V25G1/2TXC	£77.58
G3/4	14	25	140	54	20	16	4	24.5	V25G3/4TXC	£130.27

BSP(G) WHITWORTH MACHINE TAPS

#### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

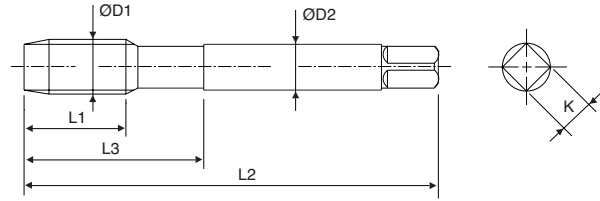
Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite		Ti	Ti Alloy	
	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
V25G-TXC	15-20	15-20	-	-	-	-	7-10	5-8	4-6	-	-	-	-	-	8-12
Series	Titanium	Inconel, Hastelloy, Nickel			Copper, Brass, Bronze				Aluminium			Plastics / Composites			
	Ti Alloy	Nickel	Nickel Alloy		Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP	
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	
V25G-TXC	-	-	10-15	-	-	-	-	-	-	-	-	-	-	-	



Cast Iron

## BSP(G) WHITWORTH PIPE THREAD DIN ISO 228/1 MACHINE TAPS - STRAIGHT FLUTE

- Dedicated geometry for cast iron tapping
- UFS HSSE TiCN coated for general cast iron tapping
- UFS Top Line - powder metal for high performance tapping and tool life
- Straight flute for through and blind holes



Series	E27G-NQ	K27G-TX
Brand / Geometry	UFS - GG	UFS - GG Top Line
Substrate	HSS 5% Cobalt	HSS Powder Metal
Surface Treatment	TiCN Coated	TiAlN Coated
Tolerance	ISO 228	ISO 228X
Helix Angle	-	-
Chamfer Lead	Form C: 2-3	Form C: 2-3
Maximum Depth	3xD	3xD
Through Coolant	-	-
Performance		

ØD1	TPI	L1	L2	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price	Order Code	Price
G1/8	28	20	90	7	5.5	4	8.8	E27G1/8CT	£38.17	-	-
G1/4	19	22	100	11	9	4	11.8	E27G1/4CT	£43.07	-	-
G3/8	19	22	100	12	9	4	15.25	E27G3/8CT	£60.83	-	-
G1/2	14	25	125	16	12	4	19	E27G1/2CT	£79.17	-	-
G3/4	14	28	140	20	16	4	24.5	E27G3/4CT	£139.59	-	-
G1	11	30	160	25	20	5	30.75	E27G1CT	£256.18	-	-
G1/8	28	15	90	7	5.5	4	8.8	-	-	K27G1/8TX	£43.78
G1/4	19	22	100	11	9	4	11.8	-	-	K27G1/4TX	£61.82
G3/8	19	22	100	12	9	4	15.25	-	-	K27G3/8TX	£78.81
G1/2	14	25	125	16	12	6	19	-	-	K27G1/2TX	£103.68
G3/4	14	25	140	20	16	6	24.5	-	-	K27G3/4TX	£168.91

### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite			Ti	Ti Alloy
E27G-CT	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
K27G-TX	-	-	-	-	-	-	-	-	-	20-25	15-20	20-25	15-25	-	-
										25-30	20-25	25-30	20-25		
Series	Titanium			Inconel, Hastelloy, Nickel		Copper, Brass, Bronze				Aluminium			Plastics / Composites		
	Ti Alloy	Nickel	Nickel Alloy			Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP
E27G-CT	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	-
K27G-TX	-	-	-	-	-	25-30	-	5-8	-	-	-	25-30	-	-	-

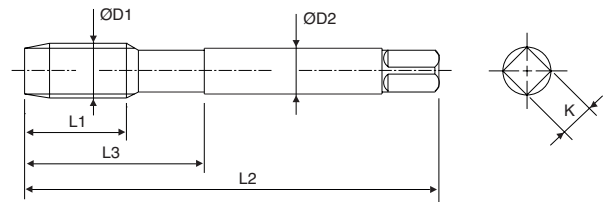
BSP(G) WHITWORTH MACHINE TAPS



Forming Roll Tap

**BSP(G) WHITWORTH PIPE THREAD DIN ISO 228/1 MACHINE TAPS - ROLL TAPS**

- Machine taps for multi material tapping
- PRIME X tap** - advanced geometry & powder metal substrate for higher speed tapping, enhanced tool life and best performance on steel & stainless steel
- UFS Top Line** - powder metal for high performance tapping and tool life
- Roll tap geometry provides swarf free tapping
- Suitable for through and blind holes



Series	TRQ17	K2CCG-TG
Brand / Geometry	YG - Prime X	UFS - Roll Top Line
Substrate	HSS Powder Metal	HSS Powder Metal
Surface Treatment	X-Coated	TIN-G Coated
Tolerance	ISO 228X	ISO 228X
Helix Angle	-	-
Chamfer Lead	Form C: 2-3	Form C: 2-3
Maximum Depth	3xD	3xD
Oil Grooves	Yes	Yes
Performance	★★★★☆	★★★★☆

ØD1	TPI	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price	Order Code	Price
G1/16	28	9	90	36	6	4.9	5	7.3	TRQ17020GS	£36.92	-	-
G1/8	28	9	90	36	7	5.5	8	9.3	TRQ17200GS	£36.92	-	-
G1/4	19	13	100	40	11	9	8	12.5	TRQ17400GS	£48.48	-	-
G3/8	19	13	100	40	12	9	8	16	TRQ17480GS	£57.85	-	-
G1/2	14	18	125	50	16	12	8	20	TRQ17560GS	£90.15	-	-
G3/4	14	18	140	54	20	16	8	25.5	TRQ17700GS	£169.84	-	-
G1"	11	23	160	60	25	20	8	32.1	TRQ17780GS	£253.51	-	-
G1/8	28	15	90	-	7	5.5	8	9.25	-	-	K2CCG1/8TG	£58.30
G1/4	19	22	100	-	11	9	8	12.5	-	-	K2CCG1/4TG	£83.93
G3/8	19	22	100	-	12	9	8	16	-	-	K2CCG3/8TG	£103.68
G1/2	14	25	125	-	16	12	8	20	-	-	K2CCG1/2TG	£123.44
G3/4	14	25	140	-	20	16	8	25.5	-	-	K2CCG3/4TG	£176.80

BSP(G) WHITWORTH MACHINE TAPS

**Material Applications N/mm<sup>2</sup> Cutting Speed m/min**

● Excellent ○ Good

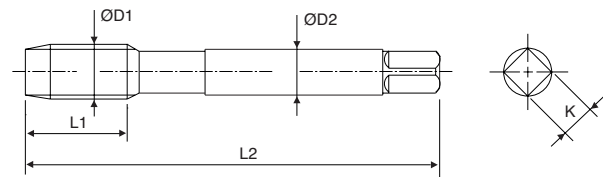
Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium				
	Soft Steels		Carbon	Alloy	Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite		Ti	Ti Alloy				
TRQ17	<400	<700	<850	<850	<1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900			
K2CCG	20-30	20-30	20-25	15-20	5-12	10-15	8-10	6-8	15-20	10-15	15-20	10-15	15-20	10-15	-			
	30-40	30-40	30-35	25-30	10-15	-	10-15	10-12	6-10	-	-	15-20	10-15	-	-			
Series	Titanium				Inconel, Hastelloy, Nickel				Copper, Brass, Bronze				Aluminium			Plastics / Composites		
	Ti Alloy	Nickel	Nickel Alloy		Cu	Cu Alloy		Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP			
TRQ17	<1300	<500	<900	<1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	10-15	-	-			
K2CCG	20-30	20-30	20-25	15-20	5-12	-	10-15	8-10	6-8	-	-	15-20	10-15	-	-			
	-	15-20	5-8	-	15-20	-	15-20	-	35-40	40-45	35-40	-	-	-	-			



Synchro-Rigid

## BSP(G) WHITWORTH PIPE THREAD DIN ISO 228/1 MACHINE TAPS - SPIRAL FLUTE

- First choice for mass production
- Synchro-Rigid** machine tap geometry for high speed multi material tapping, up to 3x faster than standard machine taps
- Special geometry lowers machine load and enables higher cutting speeds than traditional taps
- Only use with Synchro tap chucks
- Spiral flute for blind holes



Series	S80G-TXC
Brand / Geometry	UFS - Synchro-Rigid
Substrate	HSS 3% Vanadium
Surface Treatment	TXC Coated
Tolerance	ISO 228X
Helix Angle	R40°
Chamfer Lead	Form C: 2-3
Maximum Depth	2.5xD
Through Coolant	-
Performance	★★★★

ØD1	TPI	L1	L2	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price
G1/8	28	10	90	10	8	3	8.8	S80G1/8TXC	£55.35
G1/4	19	13.5	100	12	9	3	11.8	S80G1/4TXC	£77.10
G3/8	19	13.5	100	16	12	4	15.25	S80G3/8TXC	£94.57
G1/2	14	18	125	20	16	4	19	S80G1/2TXC	£130.36



### Recommended for use with Synchro Tap Chucks

Quicker tapping, better quality threads and longer tool life.

### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite			Ti	Ti Alloy
	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
S80G-TXC	40-45	40-45	30-40	25-30	10-15	-	20-25	15-20	10-15	-	-	25-30	20-25	20-30	12-15
Series	Titanium	Inconel, Hastelloy, Nickel			Copper, Brass, Bronze				Aluminium			Plastics / Composites			
	Ti Alloy	Nickel	Nickel Alloy		Cu	Cu Alloy		Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	-
S80G-TXC	-	20-30	8-12	-	-	-	25-30	-	-	45-50	30-40	-	-	-	-

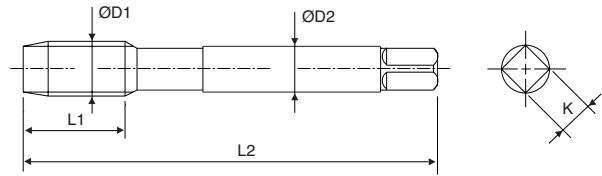
BSP(G) WHITWORTH MACHINE TAPS



Synchro-Rigid

### BSP(G) WHITWORTH PIPE THREAD DIN ISO 228/1 MACHINE TAPS - SPIRAL POINT

- First choice for mass production
- **Synchro-Rigid** machine tap geometry for high speed multi material tapping, up to 3x faster than standard machine taps
- Special geometry lowers machine load and enables higher cutting speeds than traditional taps
- Only use with Synchro tap chucks
- Spiral point for through holes



Series	S24G-TXC
Brand / Geometry	UFS - Synchro-Rigid
Substrate	HSS 3% Vanadium
Surface Treatment	TXC Coated
Tolerance	ISO 228
Helix Angle	-
Chamfer Lead	Form B: 4-5
Maximum Depth	3xD
Through Coolant	-
Performance	★★★★

ØD1	TPI	L1	L2	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price
G1/8	28	10	90	10	8	3	8.8	S24G1/8TXC	£48.71
G1/4	19	13.5	100	12	9	3	11.8	S24G1/4TXC	£67.31
G3/8	19	13.5	100	16	12	4	15.25	S24G3/8TXC	£87.27
G1/2	14	18	125	20	16	4	19	S24G1/2TXC	£118.59



## Recommended for use with Synchro Tap Chucks

Quicker tapping, better quality threads and longer tool life.

BSP(G) WHITWORTH MACHINE TAPS

### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite		Ti	Ti Alloy	
	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
S24G-TXC	40-45	40-45	30-40	25-30	10-15	-	20-25	15-20	10-15	-	-	25-30	20-25	20-30	12-15
Series	Titanium	Inconel, Hastelloy, Nickel			Copper, Brass, Bronze				Aluminium			Plastics / Composites			
	Ti Alloy	Nickel	Nickel Alloy		Cu	Cu Alloy		Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	-
S24G-TXC	-	20-30	8-12	-	-	-	25-30	-	-	45-50	30-40	-	-	-	-

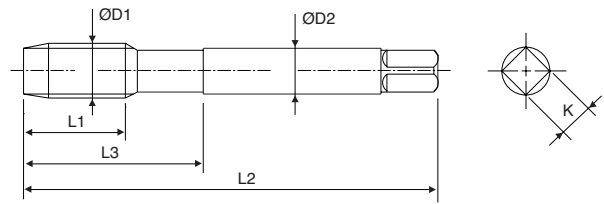


Multi Purpose

## BSW BRITISH STANDARD WHITWORTH BS 84 MACHINE TAP - SPIRAL FLUTE & POINT

HSS 5% Cobalt Machine Taps for General Purpose Machine Tapping

- Designed for everyday tapping of a wide range of materials including low to medium hardness steels, cast iron, aluminium, copper & brass
- BRIGTH finish prevents swarf sticking to the tap flutes
- Spiral flute for blind holes
- Spiral point for through holes



Series	TC224	TC134
Brand / Geometry	YG	YG
Substrate	HSS 5% Cobalt	HSS 5% Cobalt
Surface Treatment	Uncoated	Uncoated
Tolerance	6H	6H
Helix Angle	55°	55°
Chamfer Lead	Form B: 4-5	Form C: 2-3
Maximum Depth	3xD	3xD
Through Coolant	-	-
Performance		

ØD1	TPI	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price	Order Code	Price
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### Spiral Point

1/8	40	11	56	18	3.5	2.7	3	2.5	TC224200	£10.87	-	-
5/32	32	13	63	21	4.5	3.4	3	3.1	TC224280	£10.87	-	-
3/16	24	15	70	25	6	4.9	3	3.6	TC224320	£11.21	-	-
7/32	24	16	80	30	6	4.9	3	4.4	TC224360	£11.21	-	-
1/4	20	17	80	30	7	5.5	3	5.1	TC224400	£11.21	-	-
5/16	18	20	90	35	8	6.2	3	6.5	TC224440	£14.54	-	-
3/8	16	22	100	39	9	7	3	7.9	TC224480	£17.47	-	-
7/16	14	22	100	40	8	6.2	3	9.3	TC224520	£23.60	-	-
1/2	12	25	110	44	9	7	3	10.5	TC224560	£23.60	-	-
9/16	12	26	110	44	11	9	3	12	TC224600	£28.47	-	-
5/8	11	27	110	44	12	9	3	13.5	TC224640	£35.80	-	-
3/4	10	30	125	50	14	11	4	16.5	TC224700	£55.65	-	-
7/8	9	32	140	54	18	14.5	4	19.25	TC224740	£69.05	-	-
1"	8	36	160	60	20	16	4	22	TC224780	£96.33	-	-
1" 1/8	7	40	180	65	22	18	4	24.75	TC224820	£134.74	-	-

### Spiral Flute

1/8	40	7	56	18	3.5	2.7	3	2.5	-	-	TC134200	£10.87
5/32	32	7	63	21	4.5	3.4	3	3.1	-	-	TC134280	£10.87
3/16	24	10	70	25	6	4.9	3	3.6	-	-	TC134320	£11.21
7/32	24	10	80	30	6	4.9	3	4.4	-	-	TC134360	£11.21
1/4	20	13	80	30	7	5.5	3	5.1	-	-	TC134400	£11.21
5/16	18	14	90	35	8	6.2	3	6.5	-	-	TC134440	£14.54
3/8	16	16	100	39	9	7	3	7.9	-	-	TC134480	£17.47
7/16	14	17	100	40	8	6.2	3	9.3	-	-	TC134520	£23.60
1/2	12	20	110	44	9	7	3	10.5	-	-	TC134560	£23.60
9/16	12	20	110	44	11	9	3	12	-	-	TC134600	£28.47
5/8	11	22	110	40	12	9	3	13.5	-	-	TC134640	£35.80
3/4	10	25	125	50	14	11	4	16.5	-	-	TC134700	£55.65
7/8	9	27	140	54	18	14.5	4	19.25	-	-	TC134740	£69.05
1"	8	30	160	60	20	16	4	22	-	-	TC134780	£96.33
1" 1/8	7	35	180	65	22	18	4	24.75	-	-	TC134820	£134.74

### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium		
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite			Ti	Ti Alloy	
TC224	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900	
TC134	10-15	10-15	10-12	8-10	-	-	-	-	-	-	-	10-15	5-8	-	-	
Series	Titanium				Copper, Brass, Bronze				Aluminium			Plastics / Composites				
	Ti Alloy	Nickel	Nickel Alloy		Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP		
TC224	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%				
TC134	-	8-12	-	-	8-12	-	10-15	-	10-15	25-35	-	-	-	8-12	-	-

BSW BRITISH MACHINE TAPS

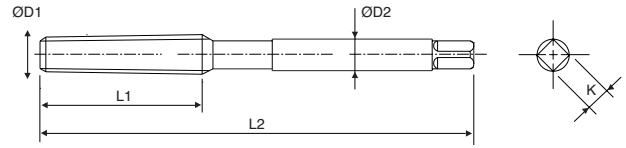


Multi Purpose

## TR METRIC TRAPEZOIDAL THREAD DIN 103 MACHINE TAP - STRAIGHT FLUTE

HSS 5% Cobalt Machine Taps for General Purpose Machine Tapping

- Designed for everyday tapping of a wide range of materials including low to medium hardness steels, cast iron, aluminium, copper & brass
- BRIGTH finish prevents swarf sticking to the tap flutes
- Suitable for right hand and left hand threads
- Straight flute - 7H tolerance



Series	E21TPN
Brand / Geometry	UFS
Substrate	HSS 5% Cobalt
Surface Treatment	Uncoated
Tolerance	7H
Helix Angle	30°
Chamfer Lead	-
Maximum Depth	2xD
Through Coolant	-
Performance	<span style="color: orange;">■</span> <span style="color: orange;">■</span> <span style="color: orange;">■</span> <span style="color: grey;">■</span> <span style="color: grey;">■</span>

ØD1	Pitch mm	L1	L2	ØD2 h9	K h12	No. of Flutes	Drill Dia.	Order Code	Price
10	2	70	130	7	5.5	3	8.2	E21TPN10X2	£194.09
10	3	95	155	7	5.5	3	7.5	E21TPN10X3	£188.91
12	2	95	160	8	6.2	3	10.2	E21TPN12X2	£215.20
12	3	95	160	8	6.2	3	9.25	E21TPN12X3	£219.10
14	3	100	170	10	8	4	11.25	E21TPN14X3	£230.63
14	4	130	210	10	8	4	10.5	E21TPN14X4	£278.09
16	4	130	225	11	9	4	12.25	E21TPN16X4	£298.94
18	4	130	225	12	9	4	14.25	E21TPN18X4	£346.10
20	4	130	230	14	11	4	16.25	E21TPN20X4	£365.18
22	5	160	270	16	12	4	17.25	E21TPN22X5	£395.35
24	5	160	280	18	14.5	4	19.25	E21TPN24X5	£410.22
26	5	160	280	20	16	4	21.25	E21TPN26X5	£421.78
28	5	160	290	22	18	4	23.25	E21TPN28X5	£442.82
30	6	190	330	22	18	4	24.25	E21TPN30X6	£548.61
32	6	190	330	25	20	4	26.25	E21TPN32X6	£569.70
36	6	200	350	28	22	4	30.25	E21TPN36X6	£623.34

TRAPEZOIDAL MACHINE TAPS

### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

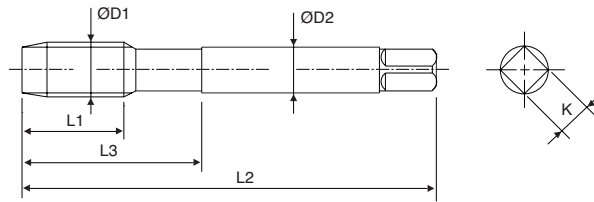
Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite		Ti	Ti Alloy	
	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
E21TPN	10-15	10-15	10-12	8-10	-	-	-	-	-	-	-	8-10	-	-	-
Series	Titanium	Inconel, Hastelloy, Nickel			Copper, Brass, Bronze			Aluminium			Plastics / Composites				
	Ti Alloy	Nickel	Nickel Alloy		Cu	Cu Alloy		Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	8-10	-
E21TPN	-	-	-	-	-	15-20	10-15	-	-	15-20	10-15	-	-	8-10	-



Multi Purpose

## BSPT PIPE THREAD DIN 2181 MACHINE TAPS - STRAIGHT FLUTE

- Machine taps for multi material tapping
- GS tap geometry** - tapping of steels, cast iron, aluminium, copper and brass
- Straight flute for blind & through holes



Series	TCM03	TDM03
Brand / Geometry	YG - GS	YG - GS
Substrate	HSS 5% Cobalt	HSS 5% Cobalt
Surface Treatment	Bright	TIN Coated
Tolerance	-	-
Helix Angle	55°	55°
Chamfer Lead	Form C: 2-3	Form C: 2-3
Maximum Depth	2xD	2xD
Through Coolant	-	-
Performance		

ØD1	TPI	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price	Order Code	Price
Rc1/16	28	14	56	-	6	4.9	4	6.2	TCM03020	£24.68	TDM03020	£30.09
Rc1/8	28	14	63	-	7	5.5	4	8.2	TCM03200	£27.63	TDM03200	£33.73
Rc1/4	19	21	63	-	11	9	4	11	TCM03400	£32.20	TDM03400	£39.43
Rc3/8	19	21	70	-	12	9	4	14.5	TCM03480	£35.90	TDM03480	£44.64
Rc1/2	14	27	80	-	16	12	4	18	TCM03560	£51.90	TDM03560	£64.67
Rc3/4	14	27	100	-	20	16	5	23.5	TCM03700	£94.34	TDM03700	£114.82
Rc1"	11	32	110	-	25	20	5	29.5	TCM03780	£138.53	TDM03780	£171.73

BSPT MACHINE TAPS

### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

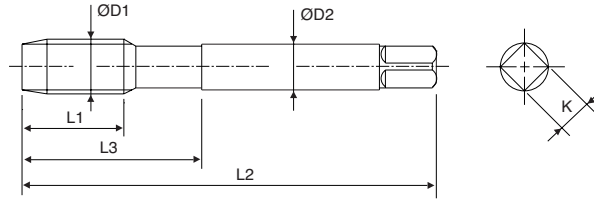
Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite			Ti	Ti Alloy
TCM03	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
TDM03	-	11-15	9-13	7-11	-	-	-	-	-	-	-	-	-	-	-
Series	Titanium				Copper, Brass, Bronze				Aluminium			Plastics / Composites			
	Ti Alloy	Inconel, Hastelloy, Nickel	Nickel	Nickel Alloy	Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP	
TCM03	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	-
TDM03	-	-	-	-	19-26	6-9	-	11-15	-	7-11	7-11	7-11	-	-	-



Stainless Steel

### BSPT PIPE THREAD DIN 5156 MACHINE TAPS - STRAIGHT FLUTE

- Machine taps for stainless steel (INOX) applications
- YG-INOX** steam tempered surface treatment for general tapping performance
- YG-INOX** hardsllick coated for excellent tool life and performance in stainless steel tapping
- Straight flute for blind & through holes



Series	TBM06	TBM06-HAR
Brand / Geometry	YG - INOX	YG - INOX
Substrate	HSS 5% Cobalt	HSS 5% Cobalt
Surface Treatment	Steam Tempered	Hardsllick Coated
Tolerance	-	-
Helix Angle	R25°	R25°
Chamfer Lead	Form C: 2-3	Form C: 2-3
Maximum Depth	2.5xD	2.5xD
Through Coolant	-	-
Performance	<span style="color: orange;">●</span> <span style="color: grey;">●</span> <span style="color: grey;">●</span> <span style="color: grey;">●</span>	<span style="color: orange;">●</span> <span style="color: orange;">●</span> <span style="color: orange;">●</span> <span style="color: orange;">●</span>

ØD1	TPI	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price	Order Code	Price
Rc1/16	28	14	90	45	6	4.9	3	6.2	TBM06020	£29.01	TCM06020HAR	£37.81
Rc1/8	28	14	90	45	7	5.5	3	8.2	TBM06200	£32.49	TCM06200HAR	£42.35
Rc1/4	19	21	100	50	11	9	3	11	TBM06400	£37.86	TCM06400HAR	£49.35
Rc3/8	19	21	110	55	12	9	3	14.5	TBM06480	£42.19	TCM06480HAR	£54.99
Rc1/2	14	27	125	65	16	12	4	18	TBM06560	£60.99	TCM06560HAR	£82.22
Rc3/4	14	27	140	75	20	16	4	23.5	TBM06700	£110.89	TCM06700HAR	£142.52
Rc1	11	32	160	85	25	20	4	29.5	TBM06780	£162.81	TCM06780HAR	£208.32

BSPT MACHINE TAPS

#### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

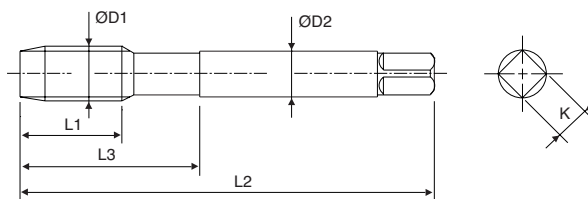
Series	Steels			Hardened Steels		Stainless Steels			Cast Iron				Titanium		
	Soft Steels	Carbon	Alloy	Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite			Ti	Ti Alloy	
TBM06	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
TBM06-HAR	11-15	11-15	-	-	-	-	5-7	4-6	3-4	-	-	-	-	-	-
Series	Titanium			Inconel, Hastelloy, Nickel			Copper, Brass, Bronze			Aluminium			Plastics / Composites		
	Ti Alloy	Nickel	Nickel Alloy	Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP		
TBM06	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	-
TBM06-HAR	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-



Multi Purpose

## NPT PIPE THREAD ANSI/ASME B1.20.1 MACHINE TAPS - STRAIGHT FLUTE

- Machine taps for multi material tapping
- GS tap geometry** - tapping of steels, cast iron, aluminium, copper and brass
- Straight flute for blind & through holes



Series	TCM01	TDM01
Brand / Geometry	YG - GS	YG - GS
Substrate	HSS 5% Cobalt	HSS 5% Cobalt
Surface Treatment	Bright	TIN Coated
Tolerance	-	-
Helix Angle	-	-
Chamfer Lead	Form C: 2-3	Form C: 2-3
Maximum Depth	2xD	2xD
Through Coolant	-	-
Performance	<input checked="" type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	<input checked="" type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>

ØD1	TPI	L1	L2	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price	Order Code	Price
1/16	27	14	56	6	4.9	4	6.15	TCM01020	£20.39	TDM01020	£24.88
1/8	27	14	63	7	5.5	4	8.43	TCM01200	£22.83	TDM01200	£27.87
1/4	18	21	63	11	9	4	11.13	TCM01400	£26.62	TDM01400	£32.56
3/8	18	21	70	12	9	4	14.27	TCM01480	£29.68	TDM01480	£36.89
1/2	14	27	80	16	12	4	17.86	TCM01560	£42.89	TDM01560	£53.42
3/4	14	27	100	20	16	5	23.01	TCM01700	£77.96	TDM01700	£94.90
1	11.5	32	110	25	20	5	28.98	TCM01780	£114.50	TDM01780	£141.92

NPT MACHINE TAPS

### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

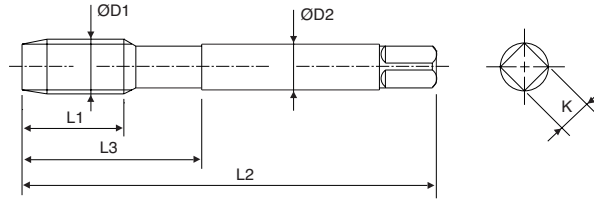
Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite			Ti	Ti Alloy
TCM01	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
TDM01	-	11-15	9-13	7-11	-	-	-	-	-	-	-	-	-	-	-
Series	Titanium				Copper, Brass, Bronze				Aluminium			Plastics / Composites			
	Ti Alloy	Nickel	Nickel Alloy		Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP	
TCM01	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	-
TDM01	-	-	-	-	19-26	6-9	-	11-15	-	7-11	7-11	7-11	-	-	-



Stainless Steel

### NPT PIPE THREAD ANSI/ASME B1.20.1 MACHINE TAPS - SPIRAL FLUTE

- Machine taps for stainless steel (INOX) applications
- YG-INOX** Steam tempered surface treatment for general tapping performance
- YG-INOX** Hardslick coated for excellent tool life and performance in stainless steel tapping
- Spiral Flute for blind holes



Series	TBM04	TCM04-HAR
Brand / Geometry	YG - INOX	YG - INOX
Substrate	HSS 5% Cobalt	HSS 5% Cobalt
Surface Treatment	Steam Tempered	Hardslick Coated
Tolerance	-	-
Helix Angle	R25°	R25°
Chamfer Lead	Form C: 2-3	Form C: 2-3
Maximum Depth	2.5xD	3xD
Through Coolant	-	-
Performance	<span style="color: orange;">●</span> <span style="color: orange;">●</span> <span style="color: orange;">●</span> <span style="color: orange;">●</span> <span style="color: orange;">●</span>	<span style="color: orange;">●</span> <span style="color: orange;">●</span> <span style="color: orange;">●</span> <span style="color: orange;">●</span> <span style="color: orange;">●</span>

ØD1	TPI	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price	Order Code	Price
1/16	27	14	90	45	6	4.9	3	6.15	TBM04020	£23.97	TCM04020HAR	£32.05
1/8	27	14	90	45	7	5.5	3	8.43	TBM04200	£26.84	TCM04200HAR	£35.88
1/4	18	21	100	50	11	9	3	11.13	TBM04400	£31.28	TCM04400HAR	£41.84
3/8	18	21	110	55	12	9	3	14.27	TBM04480	£34.87	TCM04480HAR	£46.60
1/2	14	27	125	65	16	12	4	17.86	TBM04560	£50.40	TCM04560HAR	£70.06
3/4	14	27	140	75	20	16	4	23.01	TBM04700	£91.63	TCM04700HAR	£120.39
1	11.5	32	160	85	25	20	4	28.98	TBM04780	£134.57	TCM04780HAR	£175.83

NPT MACHINE TAPS

#### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

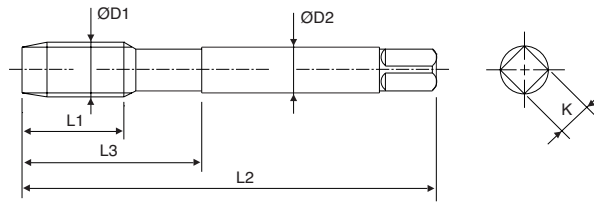
Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels		Carbon	Alloy	Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite			Ti	Ti Alloy
TBM04	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
TCM04-HAR	11-15	11-15	-	-	-	-	5-7	4-6	3-4	-	-	-	-	-	-
Series	Titanium				Copper, Brass, Bronze				Aluminium			Plastics / Composites			
	Ti Alloy	Nickel	Inconel, Hastelloy, Nickel		Cu	Cu Alloy		Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP
TBM04	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	-
TCM04-HAR	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-



Multi Purpose

## NPTF PIPE THREAD ANSI B1.20.3 MACHINE TAPS - STRAIGHT FLUTE

- Machine taps for multi material tapping
- GS tap geometry** - tapping of steels, cast iron, aluminium, copper and brass
- Straight flute for blind & through holes



Series	TCM02	TDM02
Brand / Geometry	YG - GS	YG - GS
Substrate	HSS 5% Cobalt	HSS 5% Cobalt
Surface Treatment	Bright	TIN Coated
Tolerance	-	-
Helix Angle	-	-
Chamfer Lead	Form C: 2-3	Form C: 2-3
Maximum Depth	2xD	2xD
Through Coolant	-	-
Performance		

ØD1	TPI	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price	Order Code	Price
1/16	27	14	56	-	6	4.9	4	6.15	TCM02020	£23.33	TDM02020	£27.36
1/8	27	14	63	-	7	5.5	4	8.43	TCM02200	£26.13	TDM02200	£30.64
1/4	18	21	63	-	11	9	4	11.13	TCM02400	£30.45	TDM02400	£35.86
3/8	18	21	70	-	12	9	4	14.27	TCM02480	£33.95	TDM02480	£40.59
1/2	14	27	80	-	16	12	4	17.86	TCM02560	£49.07	TDM02560	£58.78
3/4	14	27	100	-	20	16	5	23.01	TCM02700	£89.20	TDM02700	£104.38
1	11.5	32	110	-	25	20	5	28.98	TCM02780	£130.97	TDM02780	£156.13

NPTF MACHINE TAPS

### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

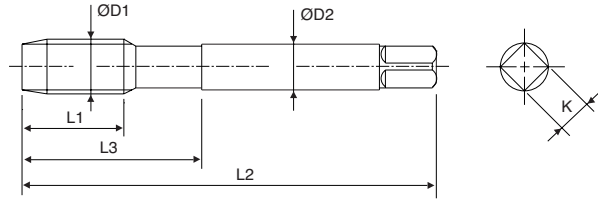
Series	Steels			Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels	Carbon	Alloy	Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite			Ti	Ti Alloy
TCM02	<400	<700	<850	<1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
TDM02	-	11-15	9-13	-	-	-	-	-	-	-	-	-	-	-
Series	Titanium			Copper, Brass, Bronze			Aluminium			Plastics / Composites				
	Ti Alloy	Inconel, Hastelloy, Nickel	Nickel Alloy	Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP	
TCM02	<1300	<500	<900	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	
TDM02	-	-	-	19-26	6-9	-	11-15	-	7-11	7-11	7-11	-	-	



Stainless Steel

### NPTF PIPE THREAD ANSI B1.20.3 MACHINE TAPS - STRAIGHT FLUTE

- Machine taps for stainless steel (INOX) applications
- YG-INOX** steam tempered surface treatment for general tapping performance
- YG-INOX** hardslick coated for excellent tool life and performance in stainless steel tapping
- Straight flute for blind & through holes



Series	TBM05	TCM05-HAR
Brand / Geometry	YG - INOX	YG - INOX
Substrate	HSS 5% Cobalt	HSS 5% Cobalt
Surface Treatment	Steam Tempered	Hardslick Coated
Tolerance	-	-
Helix Angle	R25°	R25°
Chamfer Lead	Form C: 2-3	Form C: 2-3
Maximum Depth	2.5xD	2.5xD
Through Coolant	-	-
Performance		

ØD1	TPI	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price	Order Code	Price
1/16	27	14	90	45	6	4.9	3	6.15	TBM05020	£26.37	TCM05020HAR	£34.77
1/8	27	14	90	45	7	5.5	3	8.43	TBM05200	£29.54	TCM05200HAR	£38.97
1/4	18	21	100	50	11	9	3	11.13	TBM05400	£34.42	TCM05400HAR	£45.42
3/8	18	21	110	55	12	9	3	14.27	TBM05480	£38.36	TCM05480HAR	£50.58
1/2	14	27	125	65	16	12	4	17.86	TBM05560	£55.45	TCM05560HAR	£75.83
3/4	14	27	140	75	20	16	4	23.01	TBM05700	£100.82	TCM05700HAR	£130.93
1	11.5	32	160	85	25	20	4	28.98	TBM05780	£148.00	TCM05780HAR	£191.29

NPTF MACHINE TAPS

#### Material Applications N/mm<sup>2</sup> Cutting Speed m/min

● Excellent ○ Good

Series	Steels			Hardened Steels		Stainless Steels			Cast Iron				Titanium		
	Soft Steels	Carbon	Alloy	Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite			Ti	Ti Alloy	
TBM05	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
TCM05-HAR	11-15	11-15	-	-	-	-	5-7	4-6	3-4	-	-	-	-	-	-
Series	Titanium				Copper, Brass, Bronze				Aluminium			Plastics / Composites			
	Ti Alloy	Inconel, Hastelloy, Nickel	Nickel	Nickel Alloy	Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP	
TBM05	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	-
TCM05-HAR	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

# Hand Taps













**Precision hand taps for consistent threading across an extensive range of materials.**

Designed for accurate manual threading, our range of hand taps delivers reliable, clean thread cutting for workshop, maintenance and engineering applications.

Available in a wide range of thread standards, sizes and configurations including metric, imperial, and pipe threads.

Our hand taps are offered as both individual tools and complete sets, delivering the control and durability needed for consistent, reliable results.

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**Innovative, high-performance  
threading tools designed for  
precision and productivity.**

YG-1 hand taps deliver reliable, accurate results across a wide range of materials and engineering applications.



**Trusted professional grade taps  
from a long established cutting  
tool brand.**

Dormer hand taps offer dependable performance, durability, and consistency for everyday threading tasks across metric, imperial and pipe thread standards.

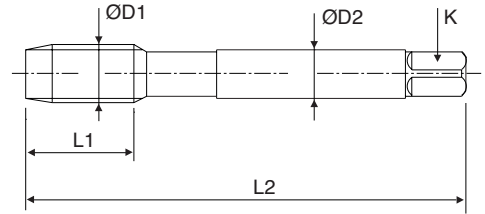


Multi Purpose

**METRIC COARSE HAND TAP SETS**HSS Hand Taps for Free Cutting Steel up to 800N/mm<sup>2</sup>, Cast Iron & Non-Ferrous

- BRIGHT finish prevents swarf sticking to the tap flutes
- Can also be used as a machine tap if required
- Straight flute - DIN352 / 6H tolerance
- Bottoming tap of set has final internal thread dimensions only
- First tap with pilot guide
- Set of 3 includes 1x first, second & bottom taps

Series

T7109  
YG-1

ØD1	Pitch	L1	L2	ØD2	K	Order Code	Price
M2	0.4	8	36	2.8	2.1	T7109139	£21.45
M2.2	0.45	9	36	2.8	2.1	T7109159	£21.45
M2.3	0.4	9	36	2.8	2.1	T7109199	£18.98
M2.5	0.45	9	40	2.8	2.1	T7109179	£17.55
M2.6	0.45	9	40	2.8	2.1	T7109499	£27.25
M3	0.5	11	40	3.5	2.7	T7109209	£12.32
M3.5	0.6	13	45	4	3	T7109229	£14.29
M4	0.7	13	45	4.5	3.4	T7109249	£12.32
M4.5	0.75	16	50	6	4.9	T7109269	£12.74
M5	0.8	16	52	6	4.9	T7109289	£12.74
M6	1	18	56	6	4.9	T7109319	£13.21
M7	1	18	56	6	4.9	T7109349	£17.23
M8	1.25	20	63	6	4.9	T7109369	£17.23
M9	1.25	20	63	7	5.5	T7109399	£26.06
M10	1.5	22	70	7	5.5	T7109429	£22.12
M11	1.5	22	70	8	6.2	T7109469	£27.58
M12	1.75	24	80	9	7	T7109509	£27.58
M14	2	26	80	11	9	T7109549	£34.87
M16	2	27	80	12	9	T7109609	£46.88
M18	2.5	30	95	14	11	T7109659	£56.15
M20	2.5	32	95	16	12	T7109709	£68.00
M22	2.5	32	100	18	14.5	T7109749	£84.26
M24	3	34	110	18	14.5	T7109789	£97.12
M27	3	36	110	20	16	T7109869	£131.79
M30	3.5	40	125	22	18	T7109949	£135.96
M33	3.5	40	125	25	20	T7109A49	£180.79
M36	4	50	150	28	22	T7109B39	£215.61
M39	4	50	150	32	24	T7109C09	£275.83
M42	4.5	56	150	32	24	T7109C89	£308.51
M45	4.5	58	160	36	29	T7109D59	£358.62
M48	5	65	180	36	29	T7109E29	£404.70
M52	5	65	180	40	32	T7109F39	£492.40



Multi Purpose

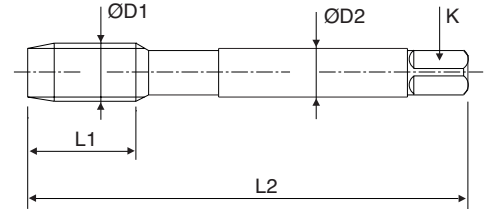
## METRIC COARSE HAND TAP SETS & INDIVIDUAL HAND TAPS

HSS Hand Taps for Free Cutting Steel up to 800N/mm<sup>2</sup>, Cast Iron & Non-Ferrous

- BRIGHT finish prevents swarf sticking to the tap flutes
- Can also be used as a machine tap if required
- Straight flute - ISO2/6H tolerance
- Set of 3 includes 1x first, second & bottom taps

Series

E500  
Dormer Pramet



ØD1	Pitch	L1	L2	ØD2	K	Individual Taps						Set of 3	Price
						First/Taper	Price	Second	Price	Bottom/Plug	Price		
M1.6	0.35	8	41	2.5	2	E500M1.6NO1	£33.50	E500M1.6NO2	£33.50	E500M1.6NO3	£33.50	E500M1.6NO6	£100.57
M1.7	0.35	8	41	2.5	2	E500M1.7NO1	£32.98	E500M1.7NO2	£32.98	E500M1.7NO3	£32.98	E500M1.7NO6	£99.21
M2	0.4	8	41	2.5	2	E500M2NO1	£17.59	E500M2NO2	£17.59	E500M2NO3	£17.59	E500M2NO6	£52.82
M2.5	0.45	9.5	44.5	2.8	2.24	E500M2.5NO1	£15.22	E500M2.5NO2	£15.22	E500M2.5NO3	£15.22	E500M2.5NO6	£45.71
M3	0.5	12.5	48	3.15	2.5	E500M3X.6NO1	£12.96	E500M3X.6NO2	£12.96	E500M3X.6NO3	£12.96	E500M3NO6	£33.42
M3.5	0.6	14	50	3.55	2.8	E500M3.5NO1	£12.18	E500M3.5NO2	£12.18	E500M3.5NO3	£12.18	E500M3.5NO6	£36.54
M4	0.7	14	53	4	3.15	E500M4X.75NO1	£11.87	E500M4X.75NO2	£11.87	E500M4X.75NO3	£11.87	E500M4NO6	£29.49
M4.5	0.75	9.5	53	4.5	3.55	E500M4.5NO1	£14.47	E500M4.5NO2	£14.47	E500M4.5NO3	£14.47	E500M4.5NO6	£43.38
M5	0.8	11	58	5	4	E500M5NO1	£10.98	E500M5NO2	£10.98	E500M5NO3	£10.98	E500M5NO6	£32.94
M6	1	13	66	6.3	5	E500M6NO1	£10.81	E500M6NO2	£10.81	E500M6NO3	£10.81	E500M6NO6	£32.43
M7	1	13	66	7.1	5.6	E500M7NO1	£15.87	E500M7NO2	£15.87	E500M7NO3	£15.87	E500M7NO6	£47.69
M8	1.25	16	72	8	6.3	E500M8NO1	£12.55	E500M8NO2	£12.55	E500M8NO3	£12.55	E500M8NO6	£37.63
M9	1.25	16	72	9	7.1	E500M9NO1	£20.94	E500M9NO2	£20.94	E500M9NO3	£20.94	E500M9NO6	£62.81
M10	1.5	18	80	10	8	E500M10NO1	£14.78	E500M10NO2	£14.78	E500M10NO3	£14.78	E500M10NO6	£44.34
M11	1.5	19	85	8	6.3	E500M11NO1	£27.37	E500M11NO2	£27.37	E500M11NO3	£27.37	E500M11NO6	£82.10
M12	1.75	22	89	9	7.1	E500M12NO1	£20.21	E500M12NO2	£20.21	E500M12NO3	£20.21	E500M12NO6	£60.55
M14	2	24	95	11.2	9	E500M14NO1	£26.51	E500M14NO2	£26.51	E500M14NO3	£26.51	E500M14NO6	£79.36
M16	2	24	102	12.5	10	E500M16NO1	£30.35	E500M16NO2	£30.35	E500M16NO3	£30.35	E500M16NO6	£91.00
M18	2.5	29	112	14	11.2	E500M18NO1	£44.13	E500M18NO2	£44.13	E500M18NO3	£44.13	E500M18NO6	£132.73
M20	2.5	29	112	14	11.2	E500M20NO1	£48.10	E500M20NO2	£48.10	E500M20NO3	£48.10	E500M20NO6	£144.36
M22	2.5	29	118	16	12.5	E500M22NO1	£57.00	E500M22NO2	£57.00	E500M22NO3	£57.00	E500M22NO6	£171.04
M24	3	35	130	18	14	E500M24NO1	£65.95	E500M24NO2	£65.95	E500M24NO3	£65.95	E500M24NO6	£197.73

METRIC COARSE HAND TAPS



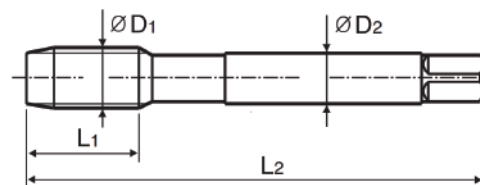
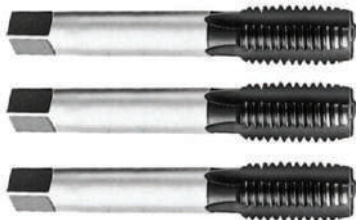
Stainless Steel

**M METRIC COARSE INOX HAND TAP SETS**

VAP Surface Treatment for use on Stainless Steel &amp; Steel

- VAP finish prolongs tap life and prevents material sticking
- Can also be used as a machine tap if required
- Straight flute - DIN352 / 6H tolerance
- Bottoming tap of set has final internal thread dimensions only
- Set of 3 includes 1x first, second & bottom taps

Series

TB373  
YG-1HSS  
Co5DIN  
352

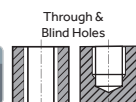
60°

A,D,C

BRIGHT  
FINISH

6HX

2xD

Through &  
Blind Holes

ØD1	Pitch	L1	L2	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price
M3	0.5	11	40	3.5	2.7	3	2.5	TB373209	£37.07
M3.5	0.6	13	45	4	3	3	2.9	TB373229	£43.36
M4	0.7	13	45	4.5	3.4	3	3.3	TB373249	£36.94
M4.5	0.75	16	50	6	4.9	3	3.7	TB373269	£44.90
M5	0.8	16	52	6	4.9	3	4.2	TB373289	£40.79
M6	1	18	56	6	4.9	3	5	TB373319	£41.11
M8	1.25	20	63	6	4.9	3	6.8	TB373369	£44.90
M10	1.5	22	70	7	5.5	4	8.5	TB373429	£58.87
M12	1.75	24	80	9	7	4	10.2	TB373509	£74.66
M14	2	26	80	11	9	4	12	TB373549	£77.55
M16	2	27	80	12	9	4	14	TB373609	£94.66
M18	2.5	30	95	14	11	4	15.5	TB373659	£119.86
M20	2.5	32	95	16	12	4	17.5	TB373709	£145.41



Multi Purpose

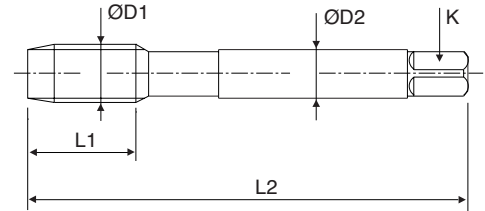
## METRIC COARSE HAND TAP SETS - LEFT HAND

HSS Hand Taps for Free Cutting Steel up to 800N/mm<sup>2</sup>, Cast Iron & Non-Ferrous

- BRIGHT finish prevents swarf sticking to the tap flutes
- Can also be used as a machine tap if required
- Straight flute - DIN352 / 6H tolerance
- Bottoming tap of set has final internal thread dimensions only
- First tap with pilot guide
- Set of 3 includes 1x first, second & bottom taps

Series

T7109  
YG-1



ØD1	Pitch	L1	L2	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price
M3	0.5	11	40	3.5	2.7	3	2.5	T7343209	£18.76
M4	0.7	13	45	4.5	3.4	3	3.3	T7343249	£18.76
M4.5	0.75	16	50	6	4.9	3	3.7	T7343269	£19.16
M5	0.8	16	52	6	4.9	3	4.2	T7343289	£19.16
M6	1	18	56	6	4.9	3	5	T7343319	£19.84
M8	1.25	20	63	6	4.9	3	6.8	T7343369	£25.81
M10	1.5	22	70	7	5.5	4	8.5	T7343429	£33.03
M12	1.75	24	80	9	7	4	10.2	T7343509	£41.30
M14	2	26	80	11	9	4	12	T7343549	£52.45
M16	2	27	80	12	9	4	14	T7343609	£70.33
M18	2.5	30	95	14	11	4	15.5	T7343659	£67.79
M20	2.5	32	95	16	12	4	17.5	T7343709	£82.18
M22	2.5	32	100	18	14.5	4	19.5	T7343749	£102.05
M24	3	34	110	18	14.5	4	21	T7343789	£117.51
M27	3	36	110	20	16	4	24	T7343869	£159.36
M30	3.5	40	125	22	18	4	26.5	T7343949	£204.03



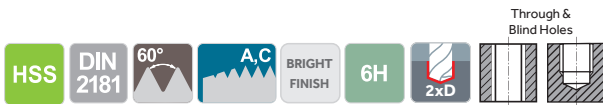
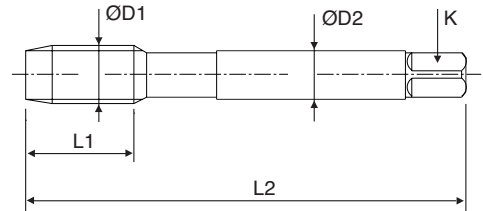
Multi Purpose

**MF METRIC FINE HAND TAP SETS**

Uncoated for use on Steel, Cast Iron &amp; Non-Ferrous Materials

- BRIGHT finish prevents swarf sticking to the tap flutes
- Can also be used as a machine tap if required
- Straight flute - DIN2181 / 6H tolerance
- Set contains first and bottom tap
- Bottoming tap of set has final internal thread dimensions only
- Set of 2 includes 1x first & bottom taps

Series

T7309  
YG-1

ØD1	Pitch	L1	L2	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price
M3	0.35	9	40	3.5	2.7	3	2.65	T7309219	£8.50
M4	0.5	10	45	4.5	3.4	3	3.5	T7309259	£11.88
M5	0.5	13	52	6	4.9	3	4.5	T7309299	£11.88
M6	0.75	14	56	6	4.9	3	5.2	T7309329	£11.47
M6	0.5	13	56	6	4.9	3	5.5	T7309339	£12.78
M7	0.75	14	56	6	4.9	3	6.2	T7309359	£15.47
M8	1	17	63	6	4.9	3	7	T7309379	£14.26
M8	0.75	14	63	6	4.9	3	7.2	T7309389	£15.47
M8	0.5	14	63	6	4.9	3	7.5	T7309939	£16.80
M9	1	17	63	7	5.5	4	8	T7309409	£20.33
M10	1.25	22	70	7	5.5	4	8.8	T7309439	£16.47
M10	1	18	63	7	5.5	4	9	T7309449	£16.47
M10	0.75	18	63	7	5.5	4	9.2	T7309459	£20.33
M11	1	18	63	8	6.2	4	10	T7309479	£19.84
M12	1.5	20	70	9	7	4	10.5	T7309519	£19.65
M12	1.25	20	70	9	7	4	10.8	T7309529	£19.84
M12	1	18	70	9	7	4	11	T7309539	£20.00
M13	1.5	20	70	11	9	4	11.5	T7309N19	£27.84
M13	1	18	70	11	9	4	12	T7309N29	£41.34
M14	1.5	20	70	11	9	4	12.5	T7309559	£24.50
M14	1.25	20	70	11	9	4	12.8	T7309569	£27.33
M14	1	18	70	11	9	4	13	T7309579	£30.44
M15	1.5	20	70	12	9	4	13.5	T7309589	£33.57
M15	1	18	70	12	9	4	14	T7309599	£37.15
M16	1.5	20	70	12	9	4	14.5	T7309619	£33.57
M16	1	18	70	12	9	4	15	T7309629	£37.15
M18	2	22	80	14	11	4	16	T7309669	£46.88
M18	1.5	22	80	14	11	4	16.5	T7309679	£42.69
M18	1	18	80	14	11	4	17	T7309689	£46.00
M20	2	22	80	16	12	4	18	T7309719	£55.98
M20	1.5	22	80	16	12	4	18.5	T7309729	£46.27
M20	1	18	80	16	12	4	19	T7309739	£55.98
M22	2	22	80	18	14.5	4	20	T7309759	£75.30
M22	1.5	22	80	18	14.5	4	20.5	T7309769	£68.53
M22	1	18	80	18	14.5	4	21	T7309779	£75.30
M24	2	22	90	18	14.5	4	22	T7309799	£86.44
M24	1.5	22	90	18	14.5	4	22.5	T7309809	£82.33
M24	1	18	90	18	14.5	4	23	T7309819	£90.62
M25	1.5	22	90	18	14.5	4	23.5	T7309839	£80.30
M25	1	18	90	18	14.5	4	24	T7309849	£88.27
M26	1.5	22	90	18	14.5	4	24.5	T7309859	£82.33
M26	1	18	90	18	14.5	4	25	T7309N59	£70.41
M27	2	22	90	20	16	4	25	T7309879	£113.49
M27	1.5	22	90	20	16	4	25.5	T7309889	£104.07
M27	1	18	90	20	16	4	26	T7309899	£124.74
M28	2	22	90	20	16	4	26	T7309909	£118.46
M28	1.5	22	90	20	16	4	26.5	T7309919	£104.07
M30	2	22	90	22	18	4	28	T7309969	£129.72
M30	1.5	22	90	22	18	4	28.5	T7309979	£117.29
M30	1	18	90	22	18	4	29	T7309989	£132.77



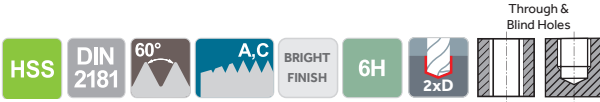
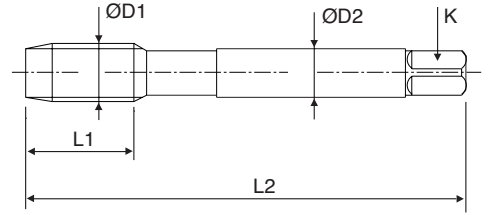
Multi Purpose

METRIC FINE HAND TAP SETS & INDIVIDUAL HAND TAPS

HSS Hand Taps for Free Cutting Steel up to 800N/mm<sup>2</sup>, Cast Iron & Non-Ferrous

- BRIGHT finish prevents swarf sticking to the tap flutes
- Can also be used as a machine tap if required
- Straight flute - ISO2/6H tolerance
- Set of 3 includes 1x first, second & bottom taps

Series
E513 Dormer Pramet



ØD1	Pitch	L1	L2	ØD2	K	Individual Taps						Set of 3	Price
						First/Taper	Price	Second	Price	Bottom/Plug	Price		
M3	0.35	12.5	48	3.15	2.5	E513M3X.35NO1	£15.91	E513M3X.35NO2	£15.91	E513M3X.35NO3	£15.91	-	-
M3.5	0.35	12.5	48	3.15	2.5	-	-	-	-	E513M3.5X.35NO3	£44.27	-	-
M4	0.5	14	53	4	3.15	E513M4X.5NO1	£14.06	E513M4X.5NO2	£14.06	E513M4X.5NO3	£14.06	-	-
M5	0.5	11	58	5	4	E513M5X.5NO1	£15.74	E513M5X.5NO2	£15.74	E513M5X.5NO3	£15.74	-	-
M5	0.75	11	58	5	4	E513M5X.75NO1	£18.88	E513M5X.75NO2	£18.88	E513M5X.75NO3	£18.88	-	-
M6	0.5	13	66	6.3	5	E513M6X.5NO1	£18.65	E513M6X.5NO2	£18.65	E513M6X.5NO3	£18.65	-	-
M6	0.75	13	66	6.3	5	E513M6X.75NO1	£15.56	E513M6X.75NO2	£15.56	E513M6X.75NO3	£15.56	-	-
M7	0.75	13	66	7.1	5.6	E513M7X.75NO1	£22.75	E513M7X.75NO2	£22.75	E513M7X.75NO3	£22.75	-	-
M8	0.5	16	72	8	6.3	E513M8X.5NO1	£49.53	E513M8X.5NO2	£49.53	E513M8X.5NO3	£49.53	-	-
M8	0.75	16	72	8	6.3	E513M8X.75NO1	£21.62	E513M8X.75NO2	£21.62	E513M8X.75NO3	£21.62	-	-
M8	1	16	72	8	6.3	E513M8X1.0NO1	£18.03	E513M8X1.0NO2	£18.03	E513M8X1.0NO3	£18.03	-	-
M9	0.75	16	72	9	7.1	-	-	-	-	E513M9X.75NO3	£61.37	-	-
M9	1	16	72	9	7.1	E513M9X1.0NO1	£30.04	E513M9X1.0NO2	£30.04	E513M9X1.0NO3	£30.04	-	-
M10	0.5	18	80	10	8	-	-	-	-	E513M10X.5NO3	£56.51	-	-
M10	0.75	18	80	10	8	E513M10X.75NO1	£38.93	E513M10X.75NO2	£38.93	E513M10X.75NO3	£38.93	-	-
M10	1	18	80	10	8	E513M10X1.0NO1	£21.14	E513M10X1.0NO2	£21.14	E513M10X1.0NO3	£21.14	E513M10X1.0NO6	£63.49
M10	1.25	18	80	10	8	E513M10X1.25NO1	£21.14	E513M10X1.25NO2	£21.14	E513M10X1.25NO3	£21.14	E513M10X1.25NO6	£63.49
M11	0.75	19	85	8	6.3	E513M11X.75NO1	£59.59	E513M11X.75NO2	£59.59	E513M11X.75NO3	£59.59	-	-
M11	1	19	85	8	6.3	E513M11X1.0NO1	£47.14	E513M11X1.0NO2	£47.14	E513M11X1.0NO3	£47.14	-	-
M11	1.25	19	85	8	6.3	-	-	-	-	E513M11X1.25NO3	£61.24	-	-
M12	0.75	22	89	9	7.1	-	-	-	-	E513M12X.75NO3	£55.28	-	-
M12	1	22	89	9	7.1	E513M12X1.0NO1	£34.76	E513M12X1.0NO2	£34.76	E513M12X1.0NO3	£34.76	-	-
M12	1.25	22	89	9	7.1	E513M12X1.25NO1	£29.01	E513M12X1.25NO2	£29.01	E513M12X1.25NO3	£29.01	E513M12X1.25NO6	£86.89
M12	1.5	22	89	9	7.1	E513M12X1.5NO1	£29.01	E513M12X1.5NO2	£29.01	E513M12X1.5NO3	£29.01	E513M12X1.5NO6	£86.89
M13	1.5	22	89	9	7.1	-	-	-	-	E513M13X1.5NO3	£57.75	-	-
M14	1	24	95	11.2	9	E513M14X1.0NO1	£46.80	E513M14X1.0NO2	£46.80	E513M14X1.0NO3	£46.80	-	-
M14	1.25	24	95	11.2	9	E513M14X1.25NO1	£38.04	E513M14X1.25NO2	£38.04	E513M14X1.25NO3	£38.04	E513M14X1.25NO6	£114.26
M14	1.5	24	95	11.2	9	E513M14X1.5NO1	£38.04	E513M14X1.5NO2	£38.04	E513M14X1.5NO3	£38.04	E513M14X1.5NO6	£114.26
M15	1.5	24	95	11.2	9	-	-	E513M15X1.5NO2	£44.47	E513M15X1.5NO3	£44.47	E513M16X1.5NO6	£130.68
M16	1	24	102	12.5	10	E513M16X1.0NO1	£52.27	E513M16X1.0NO2	£52.27	E513M16X1.0NO3	£52.27	-	-
M16	1.25	24	102	12.5	10	-	-	-	-	E513M16X1.25NO3	£59.52	-	-
M16	1.5	24	102	12.5	10	E513M16X1.5NO1	£43.51	E513M16X1.5NO2	£43.51	E513M16X1.5NO3	£43.51	-	-
M18	1	29	112	14	11.2	E513M18X1.0NO1	£75.95	E513M18X1.0NO2	£75.95	E513M18X1.0NO3	£75.95	-	-
M18	1.5	29	112	14	11.2	E513M18X1.5NO1	£63.28	E513M18X1.5NO2	£63.28	E513M18X1.5NO3	£63.28	E513M18X1.5NO6	£189.52
M18	2	29	112	14	11.2	E513M18X2.0NO1	£71.16	E513M18X2.0NO2	£71.16	E513M18X2.0NO3	£71.16	-	-
M20	1	29	112	14	11.2	-	-	E513M20X1.0NO2	£82.79	E513M20X1.0NO3	£82.79	-	-
M20	1.5	29	112	14	11.2	E513M20X1.5NO1	£69.10	E513M20X1.5NO2	£69.10	E513M20X1.5NO3	£69.10	E513M20X1.5NO6	£207.30
M20	2	29	112	14	11.2	E513M20X2.0NO1	£82.79	E513M20X2.0NO2	£82.79	E513M20X2.0NO3	£82.79	-	-
M22	1	29	118	16	12.5	-	-	E513M22X1.0NO2	£97.84	E513M22X1.0NO3	£97.84	-	-
M22	1.5	29	118	16	12.5	E513M22X1.5NO1	£81.42	E513M22X1.5NO2	£81.42	E513M22X1.5NO3	£81.42	-	-
M22	2	29	118	16	12.5	E513M22X2.0NO1	£101.94	E513M22X2.0NO2	£101.94	E513M22X2.0NO3	£101.94	-	-
M24	1	35	130	18	14	-	-	E513M24X1.0NO2	£113.58	E513M24X1.0NO3	£113.58	-	-
M24	1.5	35	130	18	14	E513M24X1.5NO1	£94.41	E513M24X1.5NO2	£94.41	E513M24X1.5NO3	£94.41	-	-
M24	2	35	130	18	14	E513M24X2.0NO1	£94.41	E513M24X2.0NO2	£94.41	E513M24X2.0NO3	£94.41	-	-
M25	1.5	35	130	18	14	E513M25X1.5NO1	£100.57	E513M25X1.5NO2	£100.57	E513M25X1.5NO3	£100.57	E513M25X1.5NO6	£301.73
M26	1.5	35	130	18	14	-	-	E513M26X1.5NO2	£132.04	E513M26X1.5NO3	£132.04	-	-
M27	1.5	35	135	20	16	-	-	E513M27X1.5NO2	£185.42	E513M27X1.5NO3	£185.42	-	-
M27	2	35	135	20	16	-	-	-	-	E513M27X2.0NO3	£154.62	-	-
M28	1.5	35	138	20	16	-	-	E513M28X1.5NO2	£161.47	E513M28X1.5NO3	£161.47	-	-
M30	1.5	41	138	20	16	-	-	E513M30X1.5NO2	£153.94	E513M30X1.5NO3	£153.94	-	-
M30	2	41	138	20	16	-	-	E513M30X2.0NO2	£184.05	E513M30X2.0NO3	£184.05	-	-
M32	1.5	41	151	22.4	18	E513M32X1.5NO1	£199.10	E513M32X1.5NO2	£199.10	E513M32X1.5NO3	£199.10	-	-
M33	2	41	151	22.4	18	-	-	E513M33X2.0NO2	£241.52	E513M33X2.0NO3	£241.52	-	-
M35	1.5	47	162	25	20	-	-	E513M35X1.5NO2	£245.62	E513M35X1.5NO3	£245.62	-	-
M36	1.5	47	162	25	20	-	-	-	-	E513M36X1.5NO3	£290.78	-	-
M36	2	47	162	25	20	-	-	E513M36X2.0NO2	£249.05	E513M36X2.0NO3	£249.05	-	-
M36	3	47	162	25	20	-	-	E513M36X3.0NO2	£283.93	E513M36X3.0NO3	£283.93	-	-
M39	3	47	170	28	22.4	-	-	-	-	E513M39X3.0NO3	£334.57	-	-
M40	1.5	53	170	28	22.4	-	-	E513M40X1.5NO2	£322.25	E513M40X1.5NO3	£322.25	-	-
M42	1.5	53	170	28	22.4	-	-	E513M42X1.5NO2	£394.09	E513M42X1.5NO3	£394.09	-	-
M42	3	53	170	28	22.4	-	-	-	-	E513M42X3.0NO3	£402.98	-	-
M45	1.5	54	187	31.5	25	-	-	E513M45X1.5NO2	£420.77	E513M45X1.5NO3	£420.77	-	-
M48	1.5	60	187	31.5	25	-	-	-	-	E513M48X1.5NO3	£456.35	-	-
M48	2	60	187	31.5	25	-	-	-	-	E513M48X2.0NO3	£456.35	-	-
M48	3	60	187	31.5	25	-	-	-	-	E513M48X3.0NO3	£456.35	-	-
M50	1.5	60	187	31.5	25	-	-	E513M50X1.5NO2	£524.76	E513M50X1.5NO3	£524.76	-	-

METRIC FINE HAND TAPS



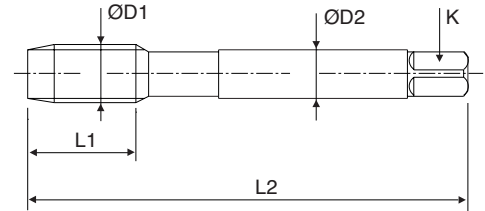
Multi Purpose

**UNC UNIFIED COARSE HAND TAP SETS**

Uncoated for use on Steel, Cast Iron &amp; Non-Ferrous Materials

- BRIGHT finish prevents swarf sticking to the tap flutes
- Can also be used as a machine tap if required
- Straight flute - DIN351 / 2B Tolerance
- Bottoming tap of set has final internal thread dimensions only
- Set of 3 includes 1x first, second & bottom taps

Series

T7363  
YG-1

ØD1 UNC	TPI	L1	L2	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price
No.2	56	9	36	2.8	2.1	3	1.8	T7363089	£34.70
No.3	48	10	40	2.8	2.1	3	2.1	T7363129	£29.45
No.4	40	10	42	3.5	2.7	3	2.3	T7363169	£19.58
No.5	40	10	42	3.5	2.7	3	2.6	T7363209	£15.31
No.6	32	11	45	4	3	3	2.85	T7363249	£15.31
No.8	32	12	48	4.5	3.4	3	3.5	T7363289	£15.31
No.10	24	14	52	6	4.9	3	3.9	T7363329	£14.87
No.12	24	16	56	6	4.9	3	4.5	T7363369	£21.45
1/4	20	16	56	6	4.9	3	5.2	T7363409	£14.66
5/16	18	20	63	6	4.9	3	6.6	T7363449	£20.53
3/8	16	22	70	7	5.5	4	8	T7363489	£24.09
7/16	14	22	70	8	6.2	4	9.4	T7363529	£31.63
1/2	13	25	80	9	7	4	10.75	T7363569	£37.18
9/16	12	26	80	11	9	4	12.25	T7363609	£53.45
5/8	11	27	90	12	9	4	13.5	T7363649	£52.31
3/4	10	32	105	14	11	4	16.5	T7363709	£74.42
7/8	9	32	110	18	14.5	4	19.5	T7363749	£112.99
1"	8	36	110	20	16	4	22.25	T7363789	£163.96
1" 1/8	7	40	125	22	18	4	25	T7363829	£218.04
1" 1/4	7	40	125	25	20	4	28.25	T7363869	£263.02
1" 3/8	6	50	150	28	22	4	30.75	T7363909	£369.66
1" 1/2	6	50	150	32	24	4	34	T7363949	£428.48
1" 3/4	5	58	160	36	29	4	39.5	T7363889	£587.74
2"	4.5	65	180	40	32	4	45.25	T7363D29	£784.22



Multi Purpose

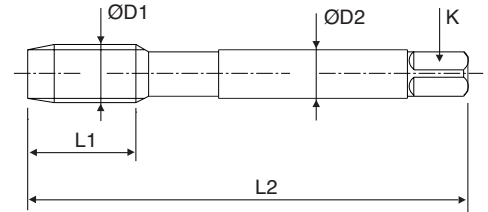
## UNC UNIFIED COARSE HAND TAP SETS & INDIVIDUAL HAND TAPS

HSS Hand Taps for Free Cutting Steel up to 800N/mm<sup>2</sup>, Cast Iron & Non-Ferrous

- BRIGHT finish prevents swarf sticking to the tap flutes
- Can also be used as a machine tap if required
- Straight flute - ISO2/6H tolerance
- Set of 3 includes 1x first, second & bottom taps

Series

E515  
Dormer Pramet



ØD1 UNC	TPI	L1	L2	ØD2	K	Individual Taps				Set of 3	Price		
						First/Taper	Price	Second	Price			Bottom/Plug	Price
No.1	64	8	41	2.5	2	-	-	-	-	E5151-64NO3	£52.82	-	-
No.2	56	9.5	44.5	2.8	2.24	E5152-56NO1	£34.62	E5152-56NO2	£34.62	E5152-56NO3	£34.62	E5152-56NO6	£104.00
No.3	48	9.5	44.5	2.8	2.24	-	-	-	-	E5153-48NO3	£32.91	E5153-48NO6	£98.53
No.4	40	12.5	48	3.15	2.5	E5154-40NO1	£19.63	E5154-40NO2	£19.63	E5154-40NO3	£19.63	E5154-40NO6	£58.84
No.5	40	12.5	48	3.15	2.5	E5155-40NO1	£21.38	E5155-40NO2	£21.38	E5155-40NO3	£21.38	E5155-40NO6	£64.17
No.6	32	14	50	3.55	2.8	E5156-32NO1	£12.62	E5156-32NO2	£12.62	E5156-32NO3	£12.62	E5156-32NO6	£37.77
No.8	32	9.5	53	4.5	3.55	E5158-32NO1	£12.42	E5158-32NO2	£12.42	E5158-32NO3	£12.42	E5158-32NO6	£37.29
No.10	24	11	58	5	4	E51510-24NO1	£13.10	E51510-24NO2	£13.10	E51510-24NO3	£13.10	E51510-24NO6	£39.34
No.12	24	12	62	5.6	4.5	E51512-24NO1	£17.28	E51512-24NO2	£17.28	E51512-24NO3	£17.28	E51512-24NO6	£51.87
1/4"	20	13	66	6.3	5	E5151/4NO1	£12.29	E5151/4NO2	£12.29	E5151/4NO3	£12.29	E5151/4NO6	£36.88
5/16"	18	16	72	8	6.3	E5155/16NO1	£14.30	E5155/16NO2	£14.30	E5155/16NO3	£14.30	E5155/16NO6	£42.90
3/8"	16	18	80	10	8	E5153/8NO1	£17.42	E5153/8NO2	£17.42	E5153/8NO3	£17.42	E5153/8NO6	£52.21
7/16"	14	19	85	8	6.3	E5157/16NO1	£25.69	E5157/16NO2	£25.69	E5157/16NO3	£25.69	E5157/16NO6	£77.32
1/2"	13	22	89	9	7.1	E5151/2NO1	£22.68	E5151/2NO2	£22.68	E5151/2NO3	£22.68	E5151/2NO6	£68.07
9/16"	12	24	95	11.2	9	E5159/16NO1	£38.66	E5159/16NO2	£38.66	E5159/16NO3	£38.66	E5159/16NO6	£116.31
5/8"	11	24	102	12.5	10	E5155/8NO1	£34.56	E5155/8NO2	£34.56	E5155/8NO3	£34.56	E5155/8NO6	£103.31
3/4"	10	29	112	14	11.2	E5153/4NO1	£50.36	E5153/4NO2	£50.36	E5153/4NO3	£50.36	E5153/4NO6	£151.21
7/8"	9	29	118	16	12.5	E5157/8NO1	£75.95	E5157/8NO2	£75.95	E5157/8NO3	£75.95	E5157/8NO6	£227.84
1"	8	35	130	18	14	E5151NO1	£87.58	E5151NO2	£87.58	E5151NO3	£87.58	E5151NO6	£262.72
1-1/8"	7	35	138	20	16	E5151.1/8NO1	£142.31	E5151.1/8NO2	£142.31	E5151.1/8NO3	£142.31	-	-
1-1/4"	7	41	151	22.4	18	E5151.1/4NO1	£200.47	E5151.1/4NO2	£200.47	E5151.1/4NO3	£200.47	-	-
1-3/8"	6	47	162	25	20	E5151.3/8NO1	£234.67	E5151.3/8NO2	£234.67	E5151.3/8NO3	£234.67	-	-
1-1/2"	6	47	170	28	22.4	E5151.1/2NO1	£277.09	E5151.1/2NO2	£277.09	E5151.1/2NO3	£277.09	-	-
1-3/4"	5	54	187	31.5	25	E5151.3/4NO1	£466.61	E5151.3/4NO2	£466.61	E5151.3/4NO3	£466.61	-	-
2"	4.5	60	200	35.5	28	E5152NO1	£567.87	E5152NO2	£567.87	-	-	-	-

UNC HAND TAPS



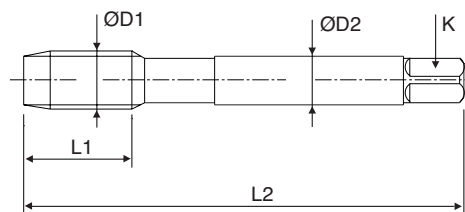
Multi Purpose

**UNF UNIFIED FINE HAND TAP SETS**

Uncoated for use on Steel, Cast Iron &amp; Non-Ferrous Materials

- BRIGHT finish prevents swarf sticking to the tap flutes
- Can also be used as a machine tap if required
- Straight flute - DIN2181 / 2B tolerance
- Bottoming tap of set has final internal thread dimensions only
- Set of 2 includes 1x first & bottom taps

Series

T7509  
YG-1

HSS

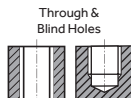
DIN  
2181

60°

A,C

BRIGHT  
FINISH

2xD

Through &  
Blind Holes

ØD1	TPI	L1	L2	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price
No.4	48	10	42	3.5	2.7	3	2.4	T7509189	£16.35
No.5	44	10	42	3.5	2.7	3	2.7	T7509229	£22.95
No.6	40	11	45	4	3	3	3	T7509269	£16.07
No.8	36	12	48	4.5	3.4	3	3.5	T7509309	£15.31
No.10	32	14	52	6	4.9	3	4.1	T7509349	£10.19
No.12	28	16	56	6	4.9	3	4.7	T7509389	£14.81
1/4	28	16	56	6	4.9	3	5.5	T7509429	£10.07
5/16	24	17	63	6	4.9	3	6.9	T7509469	£14.06
3/8	24	18	63	7	5.5	4	8.5	T7509509	£16.42
7/16	20	20	70	8	6.2	4	9.9	T7509549	£17.96
1/2	20	20	70	9	7	4	11.5	T7509589	£20.55
9/16	18	20	70	11	9	4	12.9	T7509629	£29.60
5/8	18	20	70	12	9	4	14.5	T7509669	£28.29
3/4	16	22	80	14	11	4	17.5	T7509729	£35.33
7/8	14	22	80	18	14.5	4	20.5	T7509769	£44.85
1"	12	22	90	18	14.5	4	23.25	T7509809	£57.81
1" 1/8	12	22	90	22	18	4	26.5	T7509849	£76.35



Multi Purpose

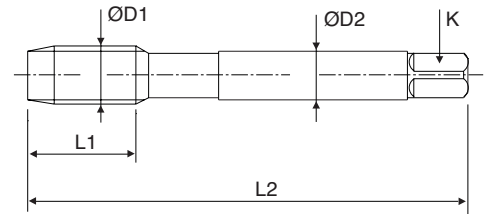
## UNF UNIFIED FINE HAND TAP SETS & INDIVIDUAL HAND TAPS

HSS Hand Taps for Free Cutting Steel up to 800N/mm<sup>2</sup>, Cast Iron & Non-Ferrous

- BRIGHT finish prevents swarf sticking to the tap flutes
- Can also be used as a machine tap if required
- Straight flute - ISO2/6H tolerance
- Set of 3 includes 1x first, second & bottom taps

Series

E524  
Dormer Pramet



Through & Blind Holes



ØD1	TPI	L1	L2	ØD2	K	Individual Taps				Set of 3	Price		
						First/Taper	Price	Second	Price			Bottom/Plug	Price
No.0	80	7	41	2.5	2	E5240-80NO1	£119.73	E5240-80NO2	£119.73	E5240-80NO3	£119.73	-	-
No.1	72	8	41	2.5	2	-	-	E5241-72NO2	£60.76	E5241-72NO3	£60.76	-	-
No.2	64	9.5	44.5	2.8	2.24	E5242-64NO1	£39.82	E5242-64NO2	£39.82	E5242-64NO3	£39.82	-	-
No.4	48	12.5	48	3.15	2.5	E5244-48NO1	£22.55	E5244-48NO2	£22.55	E5244-48NO3	£22.55	-	-
No.5	44	12.5	48	3.15	2.5	E5245-44NO1	£24.67	E5245-44NO2	£24.67	E5245-44NO3	£24.67	-	-
No.6	40	14	50	3.55	2.8	E5246-40NO1	£14.54	E5246-40NO2	£14.54	E5246-40NO3	£14.54	-	-
No.8	36	9.5	53	4.5	3.55	E5248-36NO1	£14.33	E5248-36NO2	£14.33	E5248-36NO3	£14.33	-	-
No.10	32	11	58	5	4	E52410-32NO1	£15.05	E52410-32NO2	£15.05	E52410-32NO3	£15.05	E52410-32NO6	£45.16
No.12	28	12	62	5.6	4.5	E52412-28NO1	£19.95	E52412-28NO2	£19.95	E52412-28NO3	£19.95	E52412-28NO6	£59.87
1/4"	28	13	66	6.3	5	E5241/4NO1	£14.16	E5241/4NO2	£14.16	E5241/4NO3	£14.16	E5241/4NO6	£42.56
5/16"	24	16	72	8	6.3	E5245/16NO1	£16.39	E5245/16NO2	£16.39	E5245/16NO3	£16.39	E5245/16NO6	£49.12
3/8"	24	18	80	10	8	E5243/8NO1	£20.08	E5243/8NO2	£20.08	E5243/8NO3	£20.08	E5243/8NO6	£60.21
7/16"	20	19	85	8	6.3	E5247/16NO1	£29.60	E5247/16NO2	£29.60	E5247/16NO3	£29.60	E5247/16NO6	£88.94
1/2"	20	22	89	9	7.1	E5241/2NO1	£26.10	E5241/2NO2	£26.10	E5241/2NO3	£26.10	E5241/2NO6	£77.99
9/16"	18	24	95	11.2	9	E5249/16NO1	£44.47	E5249/16NO2	£44.47	E5249/16NO3	£44.47	E5249/16NO6	£133.41
5/8"	18	24	102	12.5	10	E5245/8NO1	£39.69	E5245/8NO2	£39.69	E5245/8NO3	£39.69	E5245/8NO6	£119.05
3/4"	16	29	112	14	11.2	E5243/4NO1	£57.81	E5243/4NO2	£57.81	E5243/4NO3	£57.81	E5243/4NO6	£173.10
7/8"	14	29	118	16	12.5	-	-	E5247/8NO2	£87.58	E5247/8NO3	£87.58	E5247/8NO6	£261.35
1"	12	35	130	18	14	E5241NO1	£100.57	E5241NO2	£100.57	E5241NO3	£100.57	E5241NO6	£302.41
1-1/8"	12	35	138	20	16	E5241.1/8NO1	£164.20	E5241.1/8NO2	£164.20	E5241.1/8NO3	£164.20	-	-
1-1/4"	12	41	151	22.4	18	E5241.1/4NO1	£230.57	E5241.1/4NO2	£230.57	E5241.1/4NO3	£230.57	-	-
1-3/8"	12	47	162	25	20	E5241.3/8NO1	£270.25	E5241.3/8NO2	£270.25	E5241.3/8NO3	£270.25	-	-
1-1/2"	12	47	170	28	22.4	E5241.1/2NO1	£318.83	E5241.1/2NO2	£318.83	E5241.1/2NO3	£318.83	-	-

UNF HAND TAPS



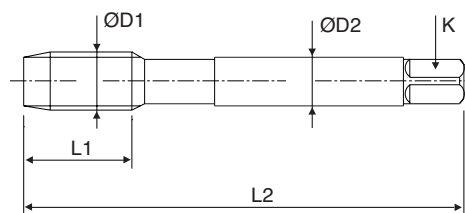
Multi Purpose

**BSW BRITISH STANDARD WHITWORTH HAND TAP SETS**

Uncoated for use on Steel, Cast Iron &amp; Non-Ferrous Materials

- BRIGHT finish prevents swarf sticking to the tap flutes
- Can also be used as a machine tap if required
- Straight flute - DIN351
- Bottoming tap of set has final internal thread dimensions only
- Set of 3 includes 1x first, second & bottom taps

Series

T7609  
YG-1Through &  
Blind Holes

ØD1	TPI	L1	L2	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Price
3/32	48	10	40	2.8	2.1	3	1.8	T7609129	£19.09
1/8	40	10	42	3.5	2.7	3	2.5	T7609209	£13.74
5/32	32	12	48	4.5	3.4	3	3.1	T7609289	£15.61
3/16	24	14	52	6	4.9	3	3.6	T7609329	£14.47
7/32	24	16	56	6	4.9	3	4.4	T7609369	£15.94
1/4	20	16	56	6	4.9	3	5.1	T7609409	£12.91
5/16	18	20	63	6	4.9	3	6.5	T7609449	£15.41
3/8	16	22	70	7	5.5	4	7.9	T7609489	£21.81
7/16	14	22	70	8	6.2	4	9.3	T7609529	£29.45
1/2	12	25	80	9	7	4	10.5	T7609569	£33.77
9/16	12	26	80	11	9	4	12	T7609609	£37.31
5/8	11	27	90	12	9	4	13.5	T7609649	£47.48
3/4	10	32	105	14	11	4	16.5	T7609709	£67.49
7/8	9	32	110	18	14.5	4	19.25	T7609749	£64.68
1"	8	36	110	20	16	4	22	T7609789	£154.47
1" 1/8	7	40	125	22	18	4	24.75	T7609829	£174.27
1" 1/4	7	40	125	25	20	4	27.75	T7609869	£201.58
1" 3/8	6	50	150	28	22	4	30.5	T7609909	£283.54
1" 1/2	6	50	150	32	24	4	33.5	T7609949	£328.67
1" 5/8	5	56	150	32	24	4	35.5	T7609B29	£389.62
1" 3/4	5	58	160	36	29	4	39	T7609B89	£450.72
1" 7/8	4.5	65	180	36	29	4	41.5	T7609C69	£526.12
2"	4.5	65	180	40	32	4	44.5	T7609D29	£601.50



Multi Purpose

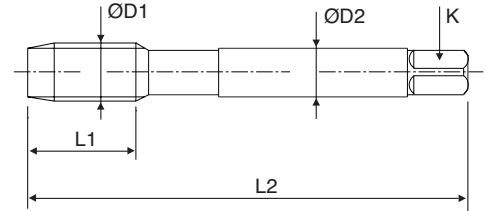
## BSW BRITISH STANDARD WHITWORTH HAND TAP SETS & INDIVIDUAL HAND TAPS

HSS Hand Taps for Free Cutting Steel up to 800N/mm<sup>2</sup>, Cast Iron & Non-Ferrous

- BRIGHT finish prevents swarf sticking to the tap flutes
- Can also be used as a machine tap if required
- Straight flute - ISO2/6H tolerance
- Set of 3 includes 1x first, second & bottom taps

Series

E531  
Dormer Pramet



ØD1	TPI	L1	L2	ØD2	K	Individual Taps				Set of 3			
						First/Taper	Price	Second	Price	Bottom/Plug	Price	Price	Price
1/8"	40	12.5	48	3.15	2.5	E5311/8NO1	£24.67	E5311/8NO2	£24.67	E5311/8NO3	£24.67	E5311/8NO6	£73.89
5/32"	32	14	53	4	3.15	E5315/32NO1	£14.33	E5315/32NO2	£14.33	E5315/32NO3	£14.33	E5315/32NO6	£43.04
3/16"	24	11	58	5	4	E5313/16NO1	£15.05	E5313/16NO2	£15.05	E5313/16NO3	£15.05	E5313/16NO6	£45.16
1/4"	20	13	66	6.3	5	E5311/4NO1	£14.16	E5311/4NO2	£14.16	E5311/4NO3	£14.16	E5311/4NO6	£42.56
5/16"	18	16	72	8	6.3	E5315/16NO1	£16.39	E5315/16NO2	£16.39	E5315/16NO3	£16.39	E5315/16NO6	£49.12
3/8"	16	18	80	10	8	E5313/8NO1	£20.08	E5313/8NO2	£20.08	E5313/8NO3	£20.08	E5313/8NO6	£60.21
7/16"	14	19	85	8	6.3	E5317/16NO1	£29.60	E5317/16NO2	£29.60	E5317/16NO3	£29.60	E5317/16NO6	£88.94
1/2"	12	22	89	9	7.1	E5311/2NO1	£26.10	E5311/2NO2	£26.10	E5311/2NO3	£26.10	E5311/2NO6	£77.99
5/8"	11	24	102	12.5	10	E5315/8NO1	£39.69	E5315/8NO2	£39.69	E5315/8NO3	£39.69	E5315/8NO6	£119.05
3/4"	10	29	112	14	11.2	E5313/4NO1	£57.81	E5313/4NO2	£57.81	E5313/4NO3	£57.81	E5313/4NO6	£173.10
1"	8	35	130	18	14	E5311NO1	£100.57	E5311NO2	£100.57	E5311NO3	£100.57	E5311NO6	£302.41

BSW WHITWORTH HAND TAPS

**PRESTO**

Multi Purpose

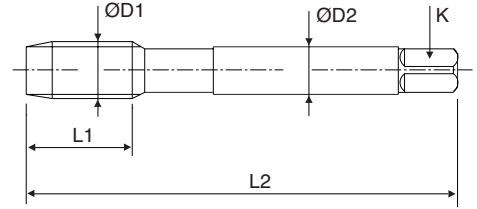
**BSPF (G) WHITWORTH PIPE HAND TAP SETS & INDIVIDUAL TAPS**

Uncoated for use on Steel & Non-Ferrous Materials

- BRIGHT finish prevents swarf sticking to the tap flutes
- Can also be used as a machine tap if required
- Straight flute
- Set of 3 includes 1x first, second & bottom taps

Series

60600  
Presto



ØD1	TPI	L1	L2	ØD2	K	Individual Taps				Set of 3	Price		
						First/Taper	Price	Second	Price			Bottom/Plug	Price
1/8	28	15	59	8	6.3	60600-181	£17.67	60600-182	£17.67	60600-183	£17.67	60600-184	£52.94
1/4	19	19	67	10	8	60600-141	£24.39	60600-142	£24.39	60600-143	£24.39	60600-144	£73.23
3/8	19	21	75	12.5	10	60600-381	£37.19	60600-382	£37.19	60600-383	£37.19	60600-384	£111.49
1/2	14	26	87	16	12.5	60600-121	£50.86	60600-122	£50.86	60600-123	£50.86	60600-124	£169.18
5/8	14	26	91	18	14	60600-581	£94.18	60600-582	£94.18	60600-583	£94.18	60600-584	£266.86
3/4	14	28	96	20	16	60600-341	£71.32	60600-342	£71.32	60600-343	£71.32	60600-344	£202.19
7/8	14	29	102	22.4	18	60600-781	£144.49	60600-782	£153.17	60600-783	£153.17	60600-784	£431.25
1"	11	33	109	25	20	606001-1	£189.60	606001-2	£127.62	606001-3	£141.52	606001-4	£361.75
1" 1/4	11	36	119	31.5	25	606001-141	£236.52	606001-142	£236.52	606001-143	£260.17	606001-144	£709.39
1" 1/2	11	37	125	35.5	28	606001-121	£271.31	606001-122	£298.44	606001-123	£271.31	606001-124	£813.88
1" 3/4	11	39	132	35.5	28	606001-341	£460.58	606001-342	£460.58	606001-343	£460.58	606001-344	£1,381.68
2"	11	41	140	40	31.5	606002-1	£486.76	606002-2	£486.76	606002-3	£486.76	606002-4	£1,460.35
2" 1/4	11	42	142	40	31.5	606002-141	£891.81	606002-142	£891.81	606002-143	£891.81	606002-144	£2,675.26
2" 1/2	11	45	153	45	35.5	606002-121	£1,138.18	606002-122	£1,138.18	606002-123	£1,138.18	606002-124	£3,414.42

**PRESTO**

Multi Purpose

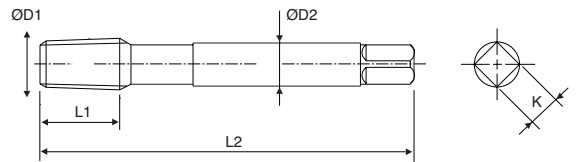
**BSPT (RC) WHITWORTH PIPE THREAD TAPERED HAND TAP SETS & INDIVIDUAL TAPS**

HSS Hand Taps for Free Cutting Steel up to 800N/mm2

- BRIGHT finish prevents swarf sticking to the tap flutes
- Can also be used as a machine tap if required
- Straight flute

Series

60680  
Presto



ØD1	TPI	L1	L2	ØD2	K	Individual Taps				Set of 3	Price		
						First/Taper	Price	Second	Price			Bottom/Plug	Price
1/8	28	15	59	8	6.3	60680-181	£38.65	60680-182	£38.65	60680-183	£38.65	60680-184	£115.91
1/4	19	19	67	10	8	60680-141	£42.78	60680-142	£42.78	60680-143	£42.78	60680-144	£142.28
3/8	19	21	75	12.5	10	60680-381	£73.63	60680-382	£73.63	60680-383	£73.63	60680-384	£208.72
1/2	14	26	87	16	12.5	60680-121	£120.18	60680-122	£120.18	60680-123	£120.18	60680-124	£229.30
3/4	14	28	96	20	16	60680-341	£111.68	60680-342	£111.68	60680-343	£111.68	60680-344	£348.20
1"	11	33	109	25	20	606801-1	£158.29	606801-2	£164.58	606801-3	£164.58	606801-4	£462.85
1" 1/4	11	36	119	31.5	25	606801-141	£316.89	606801-142	£316.89	606801-143	£316.89	606801-144	£950.63
1" 1/2	11	37	125	35.5	28	606801-121	£400.99	606801-122	£400.99	606801-123	£400.99	606801-124	£1,202.99
2"	11	41	140	40.0	31.5	606802-1	£578.22	606802-2	£519.52	606802-3	£578.22	606802-4	£1,734.67

**PRESTO**

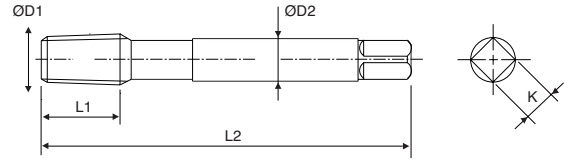
**Multi Purpose**

**NPT NATIONAL PIPE TAPER SETS & INDIVIDUAL TAPS**

HSS Hand Taps for Free Cutting Steel up to 800N/mm2

- BRIGHT finish prevents swarf sticking to the tap flutes
- Can also be used as a machine tap if required
- Straight flute
- Set of 3 includes 1x first, second & bottom taps

Series
60600
Presto



ØD1	TPI	L1	L2	ØD2	K	Individual Taps				Set of 3	Price		
						First/Taper	Price	Second	Price			Bottom/Plug	Price
1/16	27	11/16	2" 1/8	0.312	0.234	60750-1161	£41.80	60750-1162	£41.80	60750-1163	£41.80	60750-1164	£125.33
1/8	27	3/4	2" 1/8	0.437	0.328	60750-181	£31.06	60750-182	£31.06	60750-183	£31.06	60750-184	£93.16
1/4	18	1" 1/16	2" 7/16	0.562	0.421	60750-141	£34.55	60750-142	£34.55	60750-143	£34.55	60750-144	£103.64
3/8	18	1" 1/16	2" 9/16	0.700	0.531	60750-381	£55.71	60750-382	£55.71	60750-383	£55.71	60750-384	£185.27
1/2	14	1" 3/8	3" 1/8	0.687	0.515	60750-121	£58.33	60750-122	£58.33	60750-123	£58.33	60750-124	£193.97
3/4	14	1" 3/8	3" 1/4	0.906	0.679	60750-341	£75.00	60750-342	£75.00	60750-343	£75.00	60750-344	£212.53
1"	11.5	1" 3/4	3" 3/4	1.125	0.843	607501-1	£145.20	607501-2	£145.22	607501-3	£145.20	607501-4	£408.42
1" 1/4	11.5	1" 3/4	4"	1.312	0.984	607501-141	£254.76	607501-142	£254.76	607501-143	£254.76	607501-144	£764.15
1" 1/2	11.5	1" 3/4	4" 1/4	1.5	1.125	607501-121	£247.56	607501-122	£247.56	607501-123	£247.56	607501-124	£742.58
2"	11.5	1" 3/4	4" 1/2	1.875	1.406	607502-1	£428.87	607502-2	£428.87	607502-3	£428.87	607502-4	£1,286.46

**PRESTO**

**TAP WRENCH RATCHET T-TYPE**

- Adjustable
- Ratchet action with three positions: Forward, reverse & lock
- Ideal for use in confined spaces



Nominal Tap Diameter	Overall Length	Order Code	Price
M2 - M6 (1/8 - 1/4")	82.5	6983306-521	£35.32
M6 - M12 (1/4 - 1/2")	108	6983306-522	£44.62

**PRESTO**

**TAP WRENCH BAR TYPE**

- Adjustable
- Knurled handle for secure grip
- Also suitable for hand reamers



Nominal Tap Diameter	Overall Length inch	Order Code	Price
M2 - M6 (1/16 - 1/4")	4-1/8"	69823X	£25.17
M3 - M12 (1/8 - 1/2")	15"	69823Y	£21.79
M3 - M12 (1/8 - 1/2")	10-1/2"	69843101	£35.25
M6 - M20 (1/4 - 3/4")	15"	69843102	£46.28
M11 - M27 (3/8 - 1")	19-3/4"	69843103	£69.87
M20 - M38 (3/4 - 1-1/2")	31-1/2"	69843104	£153.72
M24 - M60 (1 - 2-1/2")	43"	69843105	£251.11

# Dies



**Produce and restore external threads with our range of thread dies, die stocks, die holders and die nuts for workshop, maintenance and on-site use.**

Choose from premium German made JBO threading solutions manufactured to the highest quality standards, trusted Presto dies for reliable day-to-day performance, or cost effective Cutwel Pro options for general purpose threading and repair.

Available in metric and imperial standards, our range supports both new thread cutting and thread restoration across a wide variety of materials and applications.

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## M METRIC COARSE HSS SOLID DIE

Circular Solid Die with Spiral Entry

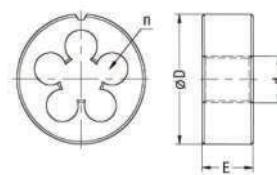
- Spiral entry results in a free flow of chips ahead of the die and a reduction in the cutting torque
- Premium German made dies for exceptional precision, durability & reliability

### Standard

- Tolerance 6g
- For cutting steel up to 800N/mm<sup>2</sup>

### INOX

- VA type No1 for stainless steel
- Tolerance 6g
- For cutting steel and stainless steel up to 1200N/mm<sup>2</sup>
- Nitrided surface treatment for increased tool life



Thread	Pitch	ØD x E	Order Code			
			General Purpose	Price	INOX (Stainless)	Price
M1	0.25	16 x 5	JBO-101212	£41.70	-	-
M2	0.4	16 x 5	JBO-101816	£22.26	JBO-104225	£41.83
M3	0.5	20 x 5	JBO-102207	£17.14	JBO-104306	£27.33
M4	0.7	20 x 5	JBO-102470	£17.14	JBO-104373	£26.56
M5	0.8	20 x 7	JBO-102642	£17.14	JBO-104418	£24.08
M6	1	20 x 7	JBO-102771	£17.14	JBO-104453	£24.08
M8	1.25	25 x 9	JBO-102959	£18.98	JBO-104511	£29.04
M10	1.5	30 x 11	JBO-101297	£22.72	JBO-104060	£34.59
M12	1.75	38 x 14	JBO-101439	£30.14	JBO-104106	£46.14
M14	2	38 x 14	JBO-101558	£30.73	JBO-104147	£51.12
M16	2	45 x 18	JBO-101657	£39.08	JBO-104179	£61.28
M18	2.5	45 x 18	JBO-101746	£41.52	JBO-104201	£63.93
M20	2.5	45 x 18	JBO-101934	£41.52	JBO-104260	£62.68
M22	2.5	55 x 22	JBO-102002	£59.43	-	-
M24	3	55 x 22	JBO-102060	£59.43	-	-
M27	3	65 x 25	JBO-102150	£89.69	-	-
M30	3.5	65 x 25	JBO-102316	£89.69	-	-
M33	3.5	65 x 25	JBO-102372	£95.43	-	-
M36	4	65 x 25	JBO-102415	£95.43	-	-
M39	4	75 x 30	JBO-102455	£158.74	-	-
M42	4.5	75 x 30	JBO-102587	£158.74	-	-
M45	4.5	90 x 36	JBO-108325	£237.78	-	-
M48	5	90 x 36	JBO-102630	£237.78	-	-
M52	5	90 x 36	JBO-102740	£251.18	-	-



## METRIC CIRCULAR DIE HOLDER FOR SOLID DIES (METRIC OUTSIDE DIAMETER)



Die Holder Size	Suitable for Circular Metric Coarse Dies	Suitable Die Sizes (Dia x Thickness)	Order Code	Price
0	M1-2.5	16 x 5	13559005	£5.26
1	M3-4	20 x 5	13559010	£6.18
2	M4.5-6	20 x 7	13559020	£6.07
3	M7-9	25 x 9	13559030	£7.24
4	M10-11	30 x 11	13559040	£9.97
5	-	38 x 10	13559050	£14.14
6	M10-14	38 x 14	13559060	£12.92
7	-	45 x 14	13559070	£18.96
8	M16-20	45 x 18	13559080	£19.88
9	-	55 x 16	13559090	£23.42
10	M22-26	55 x 22	13559100	£16.44
11	-	65 x 18	13559110	£25.78
12	M27-36	65 x 25	13559120	£24.93
13	-	75 x 20	13559130	£57.46
15	-	90 x 22	13559150	£73.11
16	M45-52	90 x 36	13559160	£75.30
17	-	105 x 22	13559170	£95.02



## M3-M12 SOLID DIE SET

- Includes 1 of each M3, M4, M5, M6, M8, M10 & M12 circular solid dies
- Tolerance 6g
- For producing metric external threads
- For steel & NF metal material groups up to a strength of 700 N/mm<sup>2</sup>



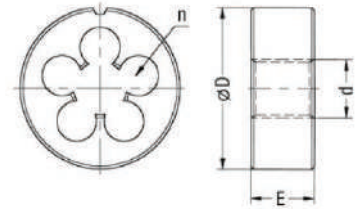
Die Range	Order Code	Price
M3-M12	13417500	£43.79



### MF METRIC FINE HSS SOLID DIE

Circular Solid Die with Spiral Entry

- Tolerance 6g
- For cutting steel up to 800N/mm<sup>2</sup>
- Spiral entry results in a free flow of chips ahead of the die and a reduction in the cutting torque
- Other pitches available on request
- Premium German made dies for exceptional precision, durability & reliability



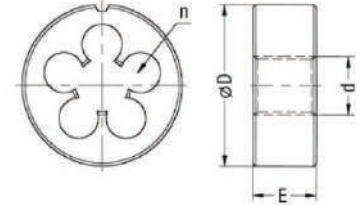
Thread	Pitch	ØD x E	Order Code	Price	Thread	Pitch	ØD x E	Order Code	Price
M3	0.35	20 x 5	JBO-105138	£32.46	M19	0.75	45 x 14	JBO-105007	£142.50
M3.5	0.35	20 x 5	JBO-105147	£40.41	M19	1	45 x 14	JBO-105009	£74.92
M4	0.35	20 x 5	JBO-105237	£34.82	M20	0.5	45 x 14	JBO-105028	£149.79
M4	0.5	20 x 5	JBO-105239	£26.24	M20	0.75	45 x 14	JBO-105030	£133.25
M4.5	0.5	20 x 5	JBO-105246	£33.73	M21	0.75	45 x 14	JBO-105042	£188.58
M5	0.35	20 x 5	JBO-105294	£56.13	M20	1	45 x 14	JBO-105032	£58.52
M5	0.5	20 x 5	JBO-105295	£25.61	M20	1.5	45 x 14	JBO-105036	£52.97
M5	0.75	20 x 7	JBO-105298	£49.14	M20	2	45 x 14	JBO-105039	£60.58
M5.5	0.5	20 x 5	JBO-105305	£54.71	M21	1	45 x 14	JBO-105043	£81.43
M6	0.5	20 x 5	JBO-105353	£25.61	M21	1.5	45 x 14	JBO-105046	£99.87
M6	0.75	20 x 7	JBO-105356	£24.19	M22	1	55 x 16	JBO-105056	£77.91
M7	0.5	25 x 9	JBO-105395	£42.62	M22	1.5	55 x 16	JBO-105059	£69.53
M7	0.75	25 x 9	JBO-105398	£28.78	M22	2	55 x 16	JBO-105062	£83.80
M8	0.5	25 x 9	JBO-105425	£35.93	M23	1	55 x 16	JBO-105068	£126.42
M8	0.75	25 x 9	JBO-105427	£27.06	M24	1	55 x 16	JBO-105077	£77.91
M8	1	25 x 9	JBO-105431	£26.72	M24	1.5	55 x 16	JBO-105081	£69.53
M9	0.5	25 x 9	JBO-105452	£52.66	M24	2	55 x 16	JBO-105084	£77.12
M9	0.75	25 x 9	JBO-105455	£36.59	M25	1	55 x 16	JBO-105092	£98.12
M9	1	25 x 9	JBO-105457	£30.68	M25	1.5	55 x 16	JBO-105095	£82.70
M10	0.5	30 x 11	JBO-104879	£48.20	M25	2	55 x 16	JBO-105097	£104.49
M10	0.75	30 x 11	JBO-104882	£35.63	M26	1	55 x 16	JBO-105100	£98.12
M10	1	30 x 11	JBO-104885	£32.12	M26	1.5	55 x 16	JBO-105101	£82.70
M10	1.25	30 x 11	JBO-104887	£35.00	M26	2	55 x 16	JBO-105104	£108.14
M11	0.5	30 x 11	JBO-104899	£79.52	M27	1	65 x 18	JBO-105110	£118.48
M11	0.75	30 x 11	JBO-104900	£48.68	M27	1.5	65 x 18	JBO-105112	£102.89
M11	1	30 x 11	JBO-104902	£35.93	M27	2	65 x 18	JBO-105114	£113.38
M11	1.25	30 x 11	JBO-104904	£50.71	M28	1	65 x 18	JBO-105118	£118.48
M12	0.5	38 x 10	JBO-104911	£62.34	M28	1.5	65 x 18	JBO-105121	£102.89
M12	0.75	38 x 10	JBO-104913	£47.53	M28	2	65 x 18	JBO-105124	£131.83
M12	1	38 x 10	JBO-104916	£41.99	M30	1	65 x 18	JBO-105155	£118.48
M12	1.25	38 x 10	JBO-104918	£43.91	M30	1.5	65 x 18	JBO-105158	£102.89
M12	1.5	38 x 10	JBO-104920	£38.65	M30	2	65 x 18	JBO-105161	£113.38
M13	0.75	38 x 10	JBO-104929	£77.75	M32	1	65 x 18	JBO-105170	£138.67
M13	1	38 x 10	JBO-104932	£43.75	M32	1.5	65 x 18	JBO-105173	£104.97
M14	0.5	38 x 10	JBO-104939	£78.08	M32	2	65 x 18	JBO-105176	£131.83
M14	0.75	38 x 10	JBO-104941	£47.53	M33	1.5	65 x 18	JBO-105183	£108.61
M14	1	38 x 10	JBO-104944	£42.30	M33	2	65 x 18	JBO-105185	£113.38
M14	1.25	38 x 10	JBO-104948	£44.23	M34	1	65 x 18	JBO-105189	£153.46
M14	1.5	38 x 10	JBO-104950	£38.65	M34	1.5	65 x 18	JBO-105191	£115.94
M15	0.75	38 x 10	JBO-104957	£76.97	M35	1.5	65 x 18	JBO-105198	£107.52
M15	1	38 x 10	JBO-104959	£44.53	M35	2	65 x 18	JBO-105200	£153.95
M15	1.5	38 x 10	JBO-104962	£51.38	M36	1	65 x 18	JBO-105207	£153.46
M15	2	38 x 10	JBO-104964	£137.40	M36	1.5	65 x 18	JBO-105209	£107.52
M16	0.5	45 x 14	JBO-104969	£103.70	M36	2	65 x 18	JBO-105211	£113.38
M16	0.75	45 x 14	JBO-104970	£81.43	M38	1.5	75 x 20	JBO-105223	£162.84
M16	1	45 x 14	JBO-104972	£58.52	M38	2	75 x 20	JBO-105225	£190.51
M16	1.25	45 x 14	JBO-104974	£69.66	M39	1.5	75 x 20	JBO-105230	£162.84
M16	1.5	45 x 14	JBO-104975	£52.97	M39	2	75 x 20	JBO-105231	£181.14
M17	1	45 x 14	JBO-104982	£67.46	M40	1.5	75 x 20	JBO-105251	£162.84
M18	0.75	45 x 14	JBO-104991	£101.79	M40	2	75 x 20	JBO-105253	£181.14
M18	1	45 x 14	JBO-104994	£58.52	M42	1.5	75 x 20	JBO-105259	£162.84
M18	1.25	45 x 14	JBO-104996	£80.64	M42	2	75 x 20	JBO-105261	£181.14
M18	1.5	45 x 14	JBO-104997	£52.97					
M18	2	45 x 14	JBO-105002	£66.00					

METRIC FINE DIES

**UNC / UNF HSS SOLID DIE**

Circular Solid Die with Spiral Entry

- Tolerance 2A
- For cutting steel up to 800N/mm<sup>2</sup>
- Spiral entry results in a free flow of chips ahead of the die and a reduction in the cutting torque
- Premium German made dies for exceptional precision, durability & reliability



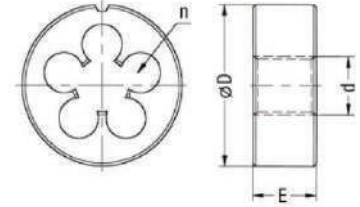
Thread	TPI	ØD x E	Order Code	Price
<b>UNC (Unified Coarse)</b>				
No. 1	64	16 x 5	JBO-103171	£44.63
No. 2	56	16 x 5	JBO-103183	£38.32
No. 3	48	16 x 5	JBO-103185	£48.02
No. 4	40	16 x 5	JBO-103187	£31.96
No. 5	40	20 x 5	JBO-103200	£26.71
No. 6	32	20 x 7	JBO-103202	£24.87
No. 8	32	20 x 7	JBO-103210	£24.27
No. 10	24	20 x 7	JBO-103174	£24.27
No. 12	24	20 x 7	JBO-103177	£27.33
1/4"	20	20 x 7	JBO-103229	£21.45
5/16"	18	25 x 9	JBO-103247	£24.41
3/8"	16	30 x 11	JBO-103240	£28.72
7/16"	14	30 x 11	JBO-103255	£29.66
1/2"	13	38 x 14	JBO-103226	£36.12
9/16"	12	38 x 14	JBO-103262	£40.77
5/8"	11	45 x 18	JBO-103252	£47.71
3/4"	10	45 x 18	JBO-103237	£48.80
7/8"	9	55 x 22	JBO-103260	£71.66
1"	8	55 x 22	JBO-103216	£71.66
1 1/8"	7	65 x 25	JBO-103223	£134.32
1 1/4"	7	65 x 25	JBO-103221	£134.32
1 1/2"	6	75 x 28	JBO-103219	£185.90
<b>UNF (Unified Fine)</b>				
No. 0	80	16 x 5	JBO-103266	£37.52
No. 1	72	16 x 5	JBO-103268	£36.12
No. 2	64	16 x 5	JBO-103279	£41.70
No. 3	56	16 x 5	JBO-103282	£48.02
No. 4	48	16 x 5	JBO-103284	£40.93
No. 5	44	20 x 5	JBO-103289	£33.35
No. 6	40	20 x 5	JBO-103293	£31.96
No. 8	36	20 x 7	JBO-103297	£28.11
No. 10	32	20 x 7	JBO-103269	£22.08
No. 12	28	20 x 7	JBO-103276	£25.80
1/4"	28	20 x 7	JBO-103317	£21.45
5/16"	24	25 x 9	JBO-103342	£24.41
3/8"	24	30 x 11	JBO-103332	£28.72
7/16"	20	30 x 11	JBO-103359	£29.79
1/2"	20	38 x 14	JBO-103310	£36.12
9/16"	18	38 x 14	JBO-103375	£36.44
5/8"	18	45 x 18	JBO-103351	£47.71
3/4"	16	45 x 18	JBO-103325	£47.71
7/8"	14	55 x 22	JBO-103370	£65.50
1"	12	55 x 22	JBO-103299	£68.71
1 1/8"	12	65 x 25	JBO-103308	£109.30
1 1/4"	12	65 x 25	JBO-103306	£109.30
1 3/8"	12	65 x 25	JBO-103309	£126.17
1 1/2"	12	75 x 28	JBO-103302	£155.16



## UNEF / UN / UNS HSS SOLID DIE

Circular Solid Die with Spiral Entry

- Tolerance 2A
- For cutting steel up to 800N/mm<sup>2</sup>
- Spiral entry results in a free flow of chips ahead of the die and a reduction in the cutting torque
- Premium German made dies for exceptional precision, durability & reliability



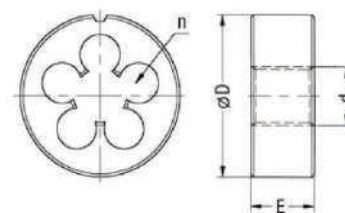
Thread	TPI	ØD x E	Order Code	Price
<b>UNEF (Unified Extra Fine)</b>				
No. 12	32	20 x 7	JBO-104811	£55.04
1/4"	32	20 x 7	JBO-104821	£37.86
5/16"	32	25 x 9	JBO-104829	£39.12
3/8"	32	30 x 11	JBO-104828	£41.99
7/16"	28	30 x 11	JBO-104832	£51.38
1/2"	28	38 x 10	JBO-104820	£57.43
9/16"	24	38 x 10	JBO-104834	£56.78
5/8"	24	45 x 14	JBO-104830	£72.22
11/16"	24	45 x 14	JBO-104823	£96.51
3/4"	20	45 x 14	JBO-104826	£66.31
13/16"	20	45 x 14	JBO-104824	£116.40
7/8"	20	55 x 16	JBO-104833	£108.94
15/16"	20	55 x 16	JBO-104825	£181.27
1"	20	55 x 16	JBO-104812	£120.87
1 1/8"	18	65 x 18	JBO-104815	£175.88
<b>UN / UNS (Unified National / Unified National Special)</b>				
1/4" UNS	40	20 x 5	JBO-103687	£59.00
1/4" UNS	36	20 x 5	JBO-103682	£43.57
1/4" UNS	24	20 x 7	JBO-103681	£73.14
7/16" UNS	24	30 x 11	JBO-103750	£54.89
1/2" UNS	24	38 x 10	JBO-105689	£79.17
11/16" UN	20	45 x 14	JBO-105699	£98.74
11/16" UN	16	45 x 14	JBO-105697	£83.66
1" UNS	14	55 x 16	JBO-105647	£99.87
1 1/16" UN	12	65 x 18	JBO-105664	£134.52
1 3/16" UN	12	65 x 18	JBO-105675	£191.89
1 5/16" UN	12	65 x 18	JBO-105682	£163.00
1 5/8" UN	12	75 x 20	JBO-105679	£196.06
1 3/4" UN	12	90 x 22	JBO-105668	£242.97
2" UN	12	90 x 22	JBO-105712	£325.98
1 1/8" UN	8	65 x 25	JBO-105663	£168.56
1 1/4" UN	8	65 x 25	JBO-105660	£168.56
1 3/8" UN	8	65 x 25	JBO-105674	£183.84
1 1/2" UN	8	75 x 20	JBO-105656	£184.94
1 3/4" UN	8	90 x 22	JBO-105671	£252.85
2" UN	8	90 x 22	JBO-105713	£252.85

UNEF / UN / UNS DIES

**BSW / BSF / BSP(G) HSS SOLID DIE**

Circular Solid Die with Spiral Entry

- For cutting steel up to 800N/mm<sup>2</sup>
- Spiral entry results in a free flow of chips ahead of the die and a reduction in the cutting torque
- Premium German made dies for exceptional precision, durability & reliability
- Medium tolerance



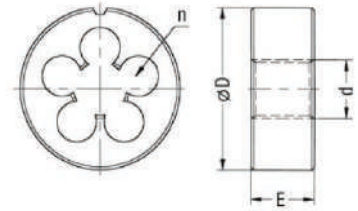
Thread	TPI	ØD	Order Code	Price
<b>BSW (British Standard Whitworth)</b>				
1/8"	40	20	JBO-105780	£31.19
5/32"	32	20	JBO-105828	£31.19
3/16"	24	20	JBO-105806	£31.19
7/32"	24	20	JBO-105841	£31.19
1/4"	20	20	JBO-105775	£26.71
5/16"	18	25	JBO-105824	£30.14
3/8"	16	30	JBO-105813	£33.97
7/16"	14	30	JBO-105836	£36.12
1/2"	12	38	JBO-105769	£44.63
9/16"	12	38	JBO-105851	£52.34
5/8"	11	45	JBO-105831	£57.61
3/4"	10	45	JBO-105808	£60.98
7/8"	9	55	JBO-105842	£83.39
1"	8	55	JBO-105752	£83.39
1 1/8"	7	65	JBO-105762	£154.71
1 1/4"	7	65	JBO-105760	£142.19
1 3/8"	6	65	JBO-105765	£165.36
1 1/2"	6	75	JBO-105758	£236.52
1 3/4"	5	90	JBO-108681	£416.01
2"	4	90	JBO-105793	£390.61
<b>BSP(G) Gas</b>				
1/8"	28	30	JBO-101044	£32.89
1/4"	19	38	JBO-101012	£32.89
3/8"	19	45	JBO-101120	£44.01
1/2"	14	45	JBO-100977	£44.01
5/8"	14	55	JBO-101157	£67.34
3/4"	14	55	JBO-101080	£66.68
7/8"	14	65	JBO-101166	£97.74
1"	11	65	JBO-100920	£92.95
1 1/8"	11	75	JBO-100965	£166.43
1 1/4"	11	75	JBO-100950	£137.55
1 3/8"	11	90	JBO-100972	£231.74
1 1/2"	11	90	JBO-100937	£189.91
1 3/4"	11	90	JBO-100970	£202.43
2"	11	105	JBO-101064	£245.50
2 1/4"	11	105	JBO-101074	£310.33
2 1/2"	11	120	JBO-101071	£331.94
2 3/4"	11	120	JBO-101076	£370.52
3"	11	130	JBO-101079	£432.26
<b>BSF (British Standard Fine)</b>				
3/16"	32	20	JBO-105605	£40.93
1/4"	26	20	JBO-105601	£37.07
5/16"	22	25	JBO-105610	£39.23
3/8"	20	30	JBO-105608	£38.32
7/16"	18	30	JBO-105614	£46.33
1/2"	16	38	JBO-105599	£52.04
9/16"	16	38	JBO-105617	£72.88
5/8"	14	45	JBO-105612	£77.34
3/4"	12	45	JBO-105606	£77.34
7/8"	11	55	JBO-105616	£113.18
1"	10	55	JBO-105592	£113.18



## NPT / NPTF / PG / TRAPEZOIDAL / RD (ROUND) HSS SOLID DIE

Circular Solid Die

- For cutting steel up to 800N/mm<sup>2</sup>
- Medium tolerance
- Spiral entry results in a free flow of chips ahead of the die and a reduction in the cutting torque
- Premium German made dies for exceptional precision, durability & reliability



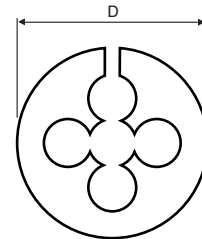
Thread	TPI	ØD	Order Code	Price
<b>NPT (National Pipe Taper)</b>				
1/16"	27	25	JBO-103418	£51.55
1/8"	27	30	JBO-103425	£49.40
1/4"	18	38	JBO-103422	£50.35
3/8"	18	45	JBO-103436	£66.26
1/2"	14	45	JBO-103419	£66.26
3/4"	14	55	JBO-103433	£109.30
1"	11.5	65	JBO-103413	£140.04
1 1/4"	11.5	75	JBO-103417	£196.53
1 1/2"	11.5	90	JBO-103416	£273.60
2"	11.5	105	JBO-103429	£353.55
<b>RD - Round Thread DIN 405</b>				
Rd 10	10	38x14	JBO-103467	£296.60
Rd 12	10	38x14	JBO-103471	£199.73
Rd 14	8	45x18	JBO-103473	£238.07
Rd 16	8	45x18	JBO-103474	£222.01
Rd 18	8	45x18	JBO-103475	£325.98
Rd 20	8	55x22	JBO-103477	£312.49
Rd 24	8	55x22	JBO-103479	£312.49
Rd 30	8	65x25	JBO-103482	£392.78
<b>PG</b>				
Pg 7	20	38x10	JBO-105556	£55.98
Pg 9	18	38x10	JBO-105557	£55.98
Pg 11	18	45x14	JBO-105548	£72.36
Pg 13.5	18	45x14	JBO-105549	£72.36
Pg 16	18	55x16	JBO-105550	£91.59
Pg 21	16	65x18	JBO-105551	£126.42
Pg 29	16	65x18	JBO-105552	£139.15
Pg 36	16	90x22	JBO-105553	£270.02
<b>NPTF (National Pipe Taper Fine)</b>				
1/16"	27	25	JBO-105622	£96.28
1/8"	27	30	JBO-105626	£63.47
1/4"	18	38	JBO-105624	£69.66
3/8"	18	45	JBO-105629	£89.06
1/2"	14	45	JBO-105623	£92.87
3/4"	14	55	JBO-105628	£154.41
1"	11.5	65	JBO-105618	£228.98
<b>TR (Trapezoidal)</b>				
Tr 10	2	38x14	JBO-103537	£98.29
Tr 10	3	38x14	JBO-103544	£131.04
Tr 12	2	38x14	JBO-103554	£126.89
Tr 12	3	38x14	JBO-103558	£125.62
Tr 14	2	38x14	JBO-103561	£139.15
Tr 14	3	45x18	JBO-103563	£140.57
Tr 14	4	45x18	JBO-103565	£154.24
Tr 16	2	45x18	JBO-103571	£167.76
Tr 16	4	45x18	JBO-103574	£127.69
Tr 18	2	45x18	JBO-103579	£181.61
Tr 18	4	45x18	JBO-103581	£150.12
Tr 20	2	45x18	JBO-103585	£181.61
Tr 20	4	55x22	JBO-103587	£167.76
Tr 22	5	55x22	JBO-103591	£243.61
Tr 24	5	65x25	JBO-103594	£222.63
Tr 26	5	65x25	JBO-103599	£254.59
Tr 28	5	65x25	JBO-103605	£283.86
Tr 30	6	65x25	JBO-103610	£267.46
Tr 32	6	65x25	JBO-103614	£351.44
Tr 36	6	65x25	JBO-103618	£267.46

NPT / NPTF / PG / TRAPEZOIDAL / DIES

cutwel **PRO** **PRESTO****M METRIC COARSE / MF METRIC FINE HSS SPLIT DIES**

Circular Split Die

- Split die can be adjusted for tighter or looser thread



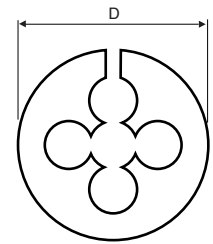
Thread	Pitch	D	Order Code			
			Cutwel Pro	Price	Presto	Price
<b>M (Metric Coarse)</b>						
M1.2	0.25	13/16"	-	-	641001.20.25-1316	£106.62
M1.4	0.3	13/16"	-	-	641001.40.30-1316	£32.00
M1.6	0.35	13/16"	-	-	641001.60.35-1316	£43.05
M2	0.4	13/16"	-	-	641002.00.40-1316	£30.48
M2.2	0.45	13/16"	-	-	641002.20.45-1316	£42.80
M2.5	0.45	13/16"	-	-	641002.50.45-1316	£30.48
M3	0.5	13/16"	CPSD-M3	£6.85	641003.00.50-1316	£17.84
M3.5	0.6	13/16"	-	-	641003.50.60-1316	£22.49
M4	0.7	13/16"	CPSD-M4	£6.85	641004.00.70-1316	£17.84
M4.5	0.75	13/16"	-	-	641004.50.75-1316	£22.36
M5	0.8	13/16"	CPSD-M5	£6.85	641005.00.80-1316	£17.84
M6	1	13/16"	CPSD-M6	£6.85	641006.01.0-1316	£17.84
M6	1	1"	-	-	641006.01.001-	£19.31
M6	1	15/16"	-	-	641006.01.01-516	£39.32
M7	1	13/16"	-	-	641007.01.0-1316	£22.49
M7	1	1"	-	-	641007.01.001-	£22.02
M7	1	15/16"	-	-	641007.01.01-516	£34.87
M8	1.25	1"	CPSD-M8	£9.20	641008.01.251-	£19.31
M8	1.25	15/16"	-	-	641008.01.251-516	£31.12
M9	1.25	1"	-	-	641009.01.251-	£26.90
M9	1.25	15/16"	-	-	641009.01.251-516	£34.67
M10	1.5	1"	-	-	6410010.01.501-	£21.08
M10	1.5	15/16"	CPSD-M10	£17.20	6410010.01.51-516	£31.02
M10	1.5	1 1/2"	-	-	6410010.01.51-12	£47.23
M11	1.5	15/16"	-	-	6410011.01.51-516	£37.45
M11	1.5	1 1/2"	-	-	6410011.01.51-12	£46.07
M12	1.75	15/16"	CPSD-M12	£17.20	6410012.01.751-516	£31.02
M12	1.75	1 1/2"	-	-	6410012.01.751-12	£36.38
M12	1.75	2"	-	-	6410012.01.752-	£67.61
M14	2	15/16"	CPSD-M14	£17.20	6410014.02.01-516	£37.92
M14	2	1 1/2"	-	-	6410014.02.01-12	£51.21
M14	2	2"	-	-	6410014.02.02-	£67.61
M16	2	1 1/2"	CPSD-M16	£22.72	6410016.02.01-12	£33.16
M16	2	2"	-	-	6410016.02.02-	£53.47
M18	2.5	1 1/2"	-	-	6410018.02.51-12	£46.65
M18	2.5	2"	-	-	6410018.02.52-	£53.47
M20	2.5	1 1/2"	-	-	6410020.02.51-12	£48.37
M20	2.5	2"	CPSD-M20	£40.10	6410020.02.52-	£53.47
M22	2.5	2"	-	-	6410022.02.52-	£53.47
M24	3	2"	CPSD-M24	£40.10	6410024.03.02-	£53.47
M24	3	3"	-	-	6410024.03.03-	£117.15
M27	3	3"	-	-	6410027.03.03-	£117.15
M30	3.5	3"	-	-	6410030.03.53-	£117.17
M33	3.5	3"	-	-	6410033.03.53-	£117.15
<b>MF (Metric Fine)</b>						
M3	0.35	13/16"	-	-	641103.00.35-1316	£36.85
M4	0.5	13/16"	-	-	641104.00.5-1316	£24.88
M5	0.5	13/16"	-	-	641105.00.5-1316	£24.88
M6	0.75	13/16"	-	-	641106.00.75-1316	£23.99
M7	0.75	1"	-	-	641107.00.751-	£52.27
M8	0.75	1"	-	-	641108.00.751-	£36.49
M8	1	1"	-	-	641108.01.01-	£28.57
M9	1	1"	-	-	641109.01.01-	£40.10
M10	0.75	1"	-	-	6411010.00.751-	£37.86
M10	1	1"	-	-	6411010.01.01-	£28.40
M10	1.25	1"	-	-	6411010.01.251-	£28.40
M12	1	15/16"	-	-	6411012.01.01-516	£41.92
M12	1.25	15/16"	-	-	6411012.01.251-516	£42.17
M12	1.5	15/16"	-	-	6411012.01.51-516	£43.46
M14	1.25	15/16"	-	-	6411014.01.251-516	£41.92
M14	1.25	1 1/2"	-	-	6411014.01.251-12	£62.52
M14	1.5	1 1/2"	-	-	6411014.01.51-12	£54.75
M16	1	1 1/2"	-	-	6411016.01.01-12	£48.94
M16	1.5	1 1/2"	-	-	6411016.01.51-12	£48.85
M18	1.5	1 1/2"	-	-	6411018.01.51-12	£48.94
M20	1	1 1/2"	-	-	6411020.01.01-12	£48.94
M20	1.5	2"	-	-	6411020.01.52-	£71.70
M20	2	1 1/2"	-	-	6411020.02.01-12	£62.85
M22	1.5	2"	-	-	6411022.01.52-	£74.34
M24	1.5	2"	-	-	6411024.01.52-	£71.71
M24	2	2"	-	-	6411024.02.02-	£73.02
M25	1.5	2"	-	-	6411025.01.52-	£71.70
M27	2	3"	-	-	6411027.02.03-	£162.92
M30	2	3"	-	-	6411030.02.03-	£160.01
M32	1.5	3"	-	-	6411032.01.53-	£157.10

cutwel **PRO** **PRESTO**

## UNC UNIFIED COARSE / UNF UNIFIED FINE HSS SPLIT DIES

Circular Split Die

- Split die can be adjusted for tighter or looser thread



UNC	TPI	D	Order Code			
			Cutwel Pro	Price	Presto	Price
No.1	64	13/16"	-	-	641201N-1316	£31.07
No.2	56	13/16"	-	-	641202N-1316	£31.45
No.3	48	13/16"	-	-	641203N-1316	£26.32
No.4	40	13/16"	-	-	641204N-1316	£25.29
No.5	40	13/16"	-	-	641205N-1316	£25.28
No.6	32	13/16"	-	-	641206N-1316	£25.29
No.8	32	13/16"	-	-	641208N-1316	£26.24
No.10	24	13/16"	-	-	6412010N-1316	£25.29
No.12	24	13/16"	-	-	6412012N-1316	£25.29
1/4"	20	13/16"	CPSD-1/4UNC	£6.85	64120-14-1316	£20.11
1/4"	20	1"	-	-	64120-141-	£23.78
1/4"	20	1 5/16"	-	-	64120-141-516	£42.66
5/16"	18	1"	CPSD-5/16UNC	£10.24	64120-5161-	£23.78
5/16"	18	1 5/16"	-	-	64120-5161-516	£42.66
3/8"	16	1"	CPSD-3/8UNC	£9.20	64120-381-	£23.78
3/8"	16	1 5/16"	-	-	64120-381-516	£34.67
3/8"	16	1 1/2"	-	-	64120-381-12	£52.46
7/16"	14	1 5/16"	-	-	64120-7161-516	£34.67
7/16"	14	1 1/2"	-	-	64120-7161-12	£52.46
1/2"	13	1"	CPSD-1/2UNC	£10.24	-	-
1/2"	13	1 5/16"	-	-	64120-121-516	£35.96
1/2"	13	1 1/2"	-	-	64120-121-12	£40.21
1/2"	13	2"	-	-	64120-122-	£76.46
9/16"	12	1 5/16"	-	-	64120-9161-516	£42.96
9/16"	12	1 1/2"	CPSD-9/16UNC	£22.72	64120-9161-12	£57.71
9/16"	12	2"	-	-	64120-9162-	£75.51
5/8"	11	1 1/2"	-	-	64120-581-12	£40.72
5/8"	11	2"	-	-	64120-582-	£60.46
3/4"	10	1 1/2"	CPSD-3/4UNC	£22.72	64120-341-12	£40.72
3/4"	10	2"	-	-	64120-342-	£60.46
7/8"	9	2"	CPSD-7/8UNC	£40.10	64120-782-	£60.46
1"	8	2"	CPSD-1UNC	£40.10	641201-2-	£60.48
1"	8	3"	-	-	641201-3-	£131.76
1 1/8"	7	3"	-	-	641201-183-	£110.28
1 1/4"	7	3"	-	-	641201-143-	£131.76
1 3/8"	6	3"	-	-	641201-383-	£131.76
1 1/2"	6	3"	-	-	641201-123-	£131.76

UNF	TPI	D	Order Code			
			Cutwel Pro	Price	Presto	Price
No.1	72	13/16"	-	-	641301N-1316	£35.45
No.2	64	13/16"	-	-	641302N-1316	£29.68
No.3	56	13/16"	-	-	641303N-1316	£35.45
No.4	48	13/16"	-	-	641304N-1316	£28.53
No.5	44	13/16"	-	-	641305N-1316	£26.07
No.6	40	13/16"	-	-	641306N-1316	£28.53
No.8	36	13/16"	-	-	641308N-1316	£28.53
No.10	32	13/16"	-	-	6413010N-1316	£28.50
No.12	28	13/16"	-	-	6413012N-1316	£28.53
1/4"	28	13/16"	CPSD-1/4UNF	£6.85	64130-14-1316	£22.58
1/4"	28	1"	-	-	64130-141-	£26.69
1/4"	28	1 5/16"	-	-	64130-141-516	£47.96
5/16"	24	1"	CPSD-5/16UNF	£9.20	64130-5161-	£26.69
5/16"	24	1 5/16"	-	-	64130-5161-516	£49.73
3/8"	24	1"	CPSD-3/8UNF	£9.20	64130-381-	£27.18
3/8"	24	1 5/16"	-	-	64130-381-516	£38.98
3/8"	24	1 1/2"	-	-	64130-381-12	£59.06
7/16"	20	1 5/16"	-	-	64130-7161-516	£38.99
7/16"	20	1 1/2"	-	-	64130-7161-12	£59.06
1/2"	20	1"	CPSD-1/2UNF	£10.24	-	-
1/2"	20	1 5/16"	-	-	64130-121-516	£38.99
1/2"	20	1 1/2"	-	-	64130-121-12	£45.77
1/2"	20	2"	-	-	64130-122-	£86.07
9/16"	18	1 5/16"	-	-	64130-9161-516	£38.98
9/16"	18	1 1/2"	CPSD-9/16UNF	£22.72	64130-9161-12	£45.77
9/16"	18	2"	-	-	64130-9162-	£86.07
5/8"	18	1 1/2"	-	-	64130-581-12	£45.80
5/8"	18	2"	-	-	64130-582-	£67.61
3/4"	16	1 1/2"	CPSD-3/4UNF	£22.72	64130-341-12	£45.80
3/4"	16	2"	-	-	64130-342-	£67.61
7/8"	14	2"	CPSD-7/8UNF	£40.10	64130-782-	£67.61
1"	12	2"	-	-	641301-2-	£67.61
1"	12	3"	-	-	641301-3-	£146.87
1 1/8"	12	3"	-	-	641301-183-	£146.87
1 1/4"	12	3"	-	-	641301-143-	£146.87
1 3/8"	12	3"	-	-	641301-383-	£134.29
1 1/2"	12	3"	-	-	641301-123-	£146.85

UNC / UNF DIES

**PRESTO**

## DIE STOCK FOR SPLIT DIES

- BS 1127 (for inch size OD dies)

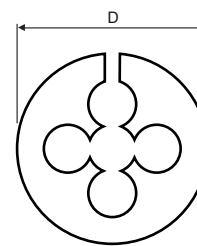


Die Diameter	Length	Order Code	Price
13/16"	6 1/2"	69403-1316	£13.17
1"	8 7/8"	694031-	£17.25
1 5/16"	11"	694031-516	£27.45
1 1/2"	14 1/4"	694031-12	£32.93
2"	19 1/8"	694032-	£48.92
2 1/4"	23"	694032-14	£99.33
3"	30"	694033-	£150.16
4"	56"	694034-	£256.17

**PRESTO****BSW / BSF HSS SPLIT DIES**

Circular Split Die

- Split die can be adjusted for tighter or looser thread



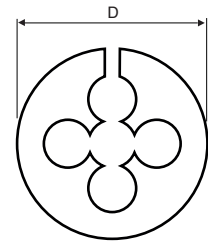
Thread	TPI	D	Order Code	Price
<b>BSW (British Standard Whitworth)</b>				
1/16"	60	13/16"	64140-116-1316	£42.66
3/32"	48	13/16"	64140-332-1316	£42.66
1/8"	40	13/16"	64140-18-1316	£28.53
5/32"	32	13/16"	64140-532-1316	£35.32
3/16"	24	13/16"	64140-316-1316	£28.53
3/16"	24	1"	64140-3161-	£41.82
1/4"	20	13/16"	64140-14-1316	£22.41
1/4"	20	1"	64140-141-	£27.17
1/4"	20	15/16"	64140-141-516	£47.75
1/4"	20	1 1/2"	64140-141-12	£100.18
5/16"	18	1"	64140-5161-	£26.69
5/16"	18	15/16"	64140-5161-516	£47.75
5/16"	18	1 1/2"	64140-5161-12	£100.18
3/8"	16	1"	64140-381-	£26.69
3/8"	16	15/16"	64140-381-516	£39.20
3/8"	16	1 1/2"	64140-381-12	£59.06
7/16"	14	15/16"	64140-7161-516	£39.20
7/16"	14	1 1/2"	64140-7161-12	£59.06
1/2"	12	15/16"	64140-121-516	£39.20
1/2"	12	1 1/2"	64140-121-12	£46.02
9/16"	12	15/16"	64140-9161-516	£47.75
9/16"	12	1 1/2"	64140-9161-12	£42.14
9/16"	12	2"	64140-9162-	£85.41
5/8"	11	1 1/2"	64140-581-12	£46.01
5/8"	11	2"	64140-582-	£67.61
11/16"	11	2"	64140-11162-	£105.75
3/4"	10	1 1/2"	64140-341-12	£59.06
3/4"	10	2"	64140-342-	£67.61
7/8"	9	2"	64140-782-	£85.41
1"	8	2"	641401-2-	£86.92
1"	8	3"	641401-3-	£202.99
1 1/8"	7	3"	641401-183-	£202.99
1 1/4"	7	3"	641401-143-	£147.42
1 3/8"	6	3"	641401-383-	£174.38
1 1/2"	6	3"	641401-123-	£147.42
<b>BSF</b>				
3/16"	32	13/16"	64150-316-1316	£32.62
1/4"	26	13/16"	64150-14-1316	£23.67
1/4"	26	1"	64150-141-	£27.78
1/4"	26	15/16"	64150-141-516	£55.19
5/16"	22	15/16"	64150-5161-516	£55.19
5/16"	22	1"	64150-5161-	£27.78
5/16"	22	1 1/2"	64150-5161-12	£55.19
3/8"	20	1"	64150-381-	£27.78
3/8"	20	15/16"	64150-381-516	£40.94
3/8"	20	1 1/2"	64150-381-12	£66.78
7/16"	18	15/16"	64150-7161-516	£40.94
7/16"	18	1 1/2"	64150-7161-12	£68.80
1/2"	16	15/16"	64150-121-516	£40.94
1/2"	16	1 1/2"	64150-121-12	£67.61
1/2"	16	2"	64150-122-	£98.38
9/16"	16	15/16"	64150-9161-516	£55.11
9/16"	16	1 1/2"	64150-9161-12	£67.61
9/16"	16	2"	64150-9162-	£77.44
5/8"	14	1 1/2"	64150-581-12	£48.06
5/8"	14	2"	64150-582-	£70.73
3/4"	12	1 1/2"	64150-341-12	£67.61
3/4"	12	2"	64150-342-	£70.52
7/8"	11	2"	64150-782-	£98.38
1"	10	2"	641501-2-	£98.38
1"	10	3"	641501-3-	£153.88
1 1/8"	9	3"	641501-183-	£211.64
1 1/4"	9	3"	641501-143-	£153.88
1 3/8"	8	3"	641501-383-	£174.38
1 1/2"	8	3"	641501-123-	£153.88

**PRESTO**

**BSP(G) / BA HSS SPLIT DIES**

Circular Split Die

- Split die can be adjusted for tighter or looser thread



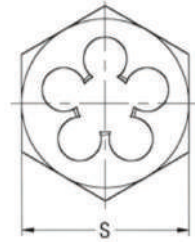
Thread	TPI	D	Order Code	Price
<b>BSP(G)</b>				
1/8"	28	1"	64160-181-	£26.57
1/8"	28	1 5/16"	64160-181-516	£53.77
1/8"	28	1 1/2"	64160-181-12	£62.74
1/4"	19	1 5/16"	64160-141-516	£39.12
1/4"	19	1 1/2"	64160-141-12	£62.74
1/4"	19	2"	64160-142-	£92.91
3/8"	19	1 1/2"	64160-381-12	£45.75
3/8"	19	2"	64160-382-	£94.09
1/2"	14	2"	64160-122-	£67.61
1/2"	14	2 1/4"	64160-122-14	£160.91
5/8"	14	2"	64160-582-	£85.41
3/4"	14	2"	64160-342-	£85.41
3/4"	14	2 1/4"	64160-342-14	£160.91
3/4"	14	3"	64160-343-	£201.37
7/8"	14	2 1/4"	64160-782-14	£116.62
7/8"	14	3"	64160-783-	£201.37
1"	11	2 1/4"	641601-2-14	£116.62
1"	11	3"	641601-3-	£201.37
1"	11	4"	641601-4-	£446.48
1 1/4"	11	3"	641601-143-	£145.79
1 1/2"	11	4"	641601-124-	£322.31
1 3/4"	11	4"	641601-344-	£446.48
2"	11	4"	641602-4-	£446.48
<b>BA</b>				
No.0	25.4	13/16"	641700N-1316	£27.61
No.1	28.2	13/16"	641701N-1316	£34.57
No.2	31.4	13/16"	641702N-1316	£27.17
No.3	34.8	13/16"	641703N-1316	£31.63
No.4	38.5	13/16"	641704N-1316	£27.52
No.5	43	13/16"	641705N-1316	£38.08
No.6	47.9	13/16"	641706N-1316	£28.54
No.7	52.9	13/16"	641707N-1316	£34.57
No.8	59.1	13/16"	641708N-1316	£34.49
No.9	65.1	13/16"	641709N-1316	£46.97
No.10	72.6	13/16"	6417010N-1316	£46.97
No.12	90.9	13/16"	6417012N-1316	£65.87
No.14	110.4	13/16"	6417014N-1316	£178.65

BSP(G) / BA DIES

## M METRIC COARSE / MF METRIC FINE DIE NUTS

### Hexagon Die Nut

- Metric Coarse & Metric Fine ISO DIN
- Tolerance 6g
- For recutting and repairing damaged threads
- **Cutwel Pro** - Economy quality
- **Presto** - General quality
- **JBO** - Premium quality made in Germany
- Other sizes available on request



BRIGHT  
FINISH

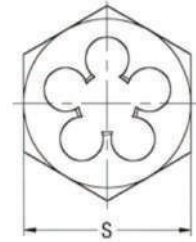
Thread	Pitch	S	Order Code					
			Cutwel Pro	Price	Presto	Price	JBO	Price
<b>M (Metric Coarse)</b>								
M3	0.5	19	CPHD-M3	<b>£8.98</b>	644003.00.5	<b>£73.17</b>	JBO-120260	<b>£21.31</b>
M4	0.7	19	CPHD-M4	<b>£8.06</b>	644004.00.7	<b>£42.01</b>	JBO-120319	<b>£20.70</b>
M5	0.8	19	CPHD-M5	<b>£8.98</b>	644005.00.8	<b>£37.42</b>	JBO-120370	<b>£20.41</b>
M6	1	19	CPHD-M6	<b>£8.06</b>	644006.01.0	<b>£25.68</b>	JBO-120418	<b>£20.41</b>
M7	1	22	-	-	644007.01.0	<b>£33.36</b>	-	-
M8	1.25	22	CPHD-M8	<b>£8.88</b>	644008.01.25	<b>£30.40</b>	JBO-120486	<b>£21.78</b>
M9	1.25	22	-	-	644009.01.25	<b>£41.22</b>	-	-
M10	1.5	27	CPHD-M10	<b>£12.94</b>	6440010.01.5	<b>£34.94</b>	JBO-120082	<b>£27.33</b>
M11	1.5	27	-	-	6440011.01.5	<b>£47.94</b>	-	-
M12	1.75	36	CPHD-M12	<b>£26.27</b>	6440012.01.75	<b>£42.14</b>	JBO-120108	<b>£36.12</b>
M14	2	36	CPHD-M14	<b>£26.27</b>	6440014.02.0	<b>£51.49</b>	JBO-120128	<b>£37.07</b>
M16	2	41	CPHD-M16	<b>£26.34</b>	6440016.02.0	<b>£52.13</b>	JBO-120151	<b>£46.63</b>
M18	2.5	41	-	-	6440018.02.5	<b>£63.86</b>	JBO-120170	<b>£49.94</b>
M20	2.5	41	CPHD-M20	<b>£44.36</b>	6440020.02.5	<b>£64.25</b>	JBO-120191	<b>£48.48</b>
M22	2.5	50	-	-	6440022.02.5	<b>£72.92</b>	JBO-120205	<b>£73.14</b>
M24	3	50	CPHD-M24	<b>£73.49</b>	6440024.03.0	<b>£104.86</b>	JBO-120220	<b>£71.01</b>
M27	3	60	-	-	6440027.03.0	<b>£168.74</b>	JBO-120243	<b>£113.99</b>
M30	3.5	60	-	-	6440030.03.5	<b>£169.77</b>	JBO-120267	<b>£113.99</b>
M33	3.5	60	-	-	6440033.03.5	<b>£231.47</b>	JBO-120284	<b>£122.11</b>
M36	4	60	-	-	6440036.04.0	<b>£244.29</b>	JBO-120299	<b>£119.26</b>
M42	4.5	70	-	-	6440042.04.5	<b>£369.13</b>	-	-
M45	4.5	70	-	-	-	-	JBO-120347	<b>£273.67</b>
M48	4.5	70	-	-	-	-	JBO-120360	<b>£273.67</b>
<b>MF (Metric Fine)</b>								
M3	0.35	19	-	-	644103.00.35	<b>£101.38</b>	-	-
M4	0.5	19	-	-	644104.00.5	<b>£58.61</b>	-	-
M5	0.5	19	-	-	644105.00.5	<b>£51.73</b>	-	-
M6	0.75	19	-	-	644106.00.75	<b>£35.63</b>	-	-
M8	1	22	-	-	644108.01.0	<b>£42.53</b>	-	-
M10	1	27	-	-	6441010.01.0	<b>£48.88</b>	-	-
M10	1.25	27	-	-	6441010.01.25	<b>£48.88</b>	-	-
M12	1.25	36	-	-	6441012.01.25	<b>£59.02</b>	-	-
M12	1.5	36	-	-	6441012.01.5	<b>£59.02</b>	JBO-120116	<b>£42.30</b>
M14	1.25	36	-	-	6441014.01.25	<b>£93.80</b>	-	-
M14	1.5	36	-	-	6441014.01.5	<b>£72.78</b>	JBO-120135	<b>£46.03</b>
M16	1.5	41	-	-	6441016.01.5	<b>£72.32</b>	JBO-120161	<b>£54.36</b>
M18	1.5	41	-	-	6441018.01.5	<b>£88.97</b>	JBO-120176	<b>£54.36</b>
M20	1.5	41	-	-	6441020.01.5	<b>£88.97</b>	-	-
M22	1.5	50	-	-	6441022.01.5	<b>£101.50</b>	JBO-120210	<b>£74.72</b>
M24	1.5	50	-	-	6441024.01.5	<b>£147.11</b>	JBO-120224	<b>£74.72</b>
M24	2	50	-	-	6441024.02.0	<b>£147.11</b>	JBO-120226	<b>£81.22</b>
M27	2	60	-	-	-	-	JBO-120250	<b>£131.08</b>
M30	1.5	60	-	-	-	-	JBO-120270	<b>£118.55</b>
M30	2	60	-	-	6441030.02.0	<b>£258.46</b>	JBO-120272	<b>£131.08</b>
M32	1.5	60	-	-	6441032.01.5	<b>£304.35</b>	-	-
M33	1.5	60	-	-	-	-	JBO-120288	<b>£131.08</b>
M40	1.5	70	-	-	6441040.01.5	<b>£606.68</b>	JBO-120327	<b>£181.42</b>
M42	1.5	70	-	-	6441042.01.5	<b>£606.68</b>	JBO-120339	<b>£181.42</b>
M45	1.5	85	-	-	-	-	JBO-120349	<b>£224.49</b>
M48	1.5	85	-	-	-	-	JBO-120362	<b>£224.49</b>
M48	3	85	-	-	-	-	JBO-120367	<b>£249.50</b>
M56	2	85	-	-	-	-	JBO-120407	<b>£301.68</b>



## UNC UNIFIED COARSE / UNF UNIFIED FINE DIE NUTS

Hexagon Die Nut

- Unified Coarse and Unified Fine
- Tolerance 2A
- For recutting and repairing damaged threads
- Cutwel Pro** - Economy quality
- Presto** - General quality
- JBO** - Premium quality made in Germany
- Other sizes available on request



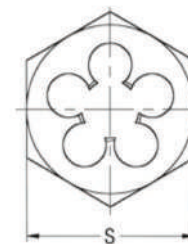
Thread	TPI	S	Order Code					
			Cutwel Pro	Price	Presto	Price	JBO	Price
<b>UNC (Unified Coarse)</b>								
No 8	32	19	-	-	644208N	£61.90	-	-
No 10	24	19	-	-	6442010N	£60.78	-	-
No 12	24	19	-	-	6442012N	£50.86	-	-
1/4"	20	19	CPHD-1/4UNC	£8.06	64420-14	£28.90	JBO-120544	£32.10
5/16"	18	22	CPHD-5/16UNC	£8.88	64420-516	£34.19	JBO-120553	£29.73
3/8"	16	27	CPHD-3/8UNC	£11.62	64420-38	£39.17	JBO-120552	£38.76
7/16"	14	27	-	-	64420-716	£53.86	JBO-120557	£47.39
1/2"	13	36	CPHD-1/2UNC	£23.60	64420-12	£47.40	JBO-120542	£40.93
9/16"	12	36	CPHD-9/16UNC	£23.60	64420-916	£58.49	JBO-120560	£50.00
5/8"	11	41	-	-	64420-58	£58.49	JBO-120555	£61.44
3/4"	10	41	CPHD-3/4UNC	£44.36	64420-34	£71.71	JBO-120550	£53.06
7/8"	9	50	CPHD-7/8UNC	£58.25	64420-78	£82.21	JBO-120558	£90.67
1"	8	50	CPHD-1UNC	£73.49	644201-	£117.06	JBO-120534	£104.99
1 1/8"	7	60	-	-	644201-18	£168.74	JBO-120539	£181.48
1 1/4"	7	60	-	-	644201-14	£168.74	JBO-120537	£147.48
1 3/8"	6	60	-	-	644201-38	£193.21	-	-
1 1/2"	6	70	-	-	644201-12	£223.41	-	-
1 3/4"	5	80	-	-	644201-34	£336.75	-	-
2"	45	85	-	-	644202-	£334.43	-	-
<b>UNF (Unified Fine)</b>								
No 8	36	19	-	-	644308N	£55.55	-	-
No 10	32	19	-	-	6443010N	£60.78	-	-
No 12	28	19	-	-	6443012N	£60.78	-	-
1/4"	28	19	-	-	64430-14	£32.54	JBO-120580	£27.94
1/4"	25	19	CPHD-1/4UNF	£8.06	-	-	-	-
5/16"	24	22	CPHD-5/16UNF	£8.88	64430-516	£37.87	JBO-120586	£25.61
3/8"	24	27	CPHD-3/8UNF	£11.62	64430-38	£43.58	JBO-120584	£34.59
7/16"	20	27	-	-	64430-716	£65.88	JBO-120590	£57.90
1/2"	20	36	CPHD-1/2UNF	£23.60	64430-12	£53.34	JBO-120578	£46.03
9/16"	18	36	CPHD-9/16UNF	£23.60	64430-916	£65.75	JBO-120594	£52.19
5/8"	18	41	-	-	64430-58	£65.75	JBO-120588	£59.29
3/4"	16	41	CPHD-3/4UNF	£44.36	64430-34	£80.72	JBO-120582	£59.29
7/8"	14	50	CPHD-7/8UNF	£58.25	64430-78	£91.93	-	-
1"	12	50	-	-	644301-	£132.68	JBO-120571	£91.56
1 1/8"	12	60	-	-	644301-18	£188.95	-	-
1 1/4"	12	60	-	-	644301-14	£188.95	-	-
1 3/8"	12	60	-	-	644301-38	£259.84	-	-
1 1/2"	12	70	-	-	644301-12	£273.32	-	-

UNC / UNF DIES

**BSW / BSF / BSP(G) DIE NUTS**

Hexagon Die Nut

- British standard Whitworth, British standard fine & British standard pipe (Gas)
- Tolerance med
- For recutting and repairing damaged threads
- Presto** - General quality
- JBO** - Premium quality made in Germany



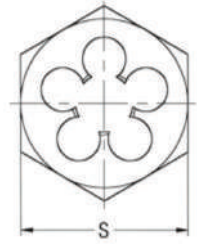
Thread	TPI	S	Order Code			
			Presto	Price	JBO	Price
<b>BSW (British Standard Whitworth)</b>						
1/8"	40	19	64440-18	£64.67	JBO-120829	£198.87
3/16"	24	19	64440-316	£48.74	JBO-120857	£198.87
1/4"	20	19	64440-14	£32.42	JBO-120827	£58.67
5/16"	18	22	64440-516	£34.94	JBO-120876	£61.76
3/8"	16	27	64440-38	£44.02	JBO-120864	£65.00
7/16"	14	27	64440-716	£60.64	JBO-120882	£70.25
1/2"	12	36	64440-12	£53.34	JBO-120824	£70.25
9/16"	12	36	64440-916	£66.02	-	-
5/8"	11	41	64440-58	£66.02	JBO-120879	£67.58
3/4"	10	41	64440-34	£80.72	JBO-120860	£66.80
7/8"	9	50	64440-78	£91.93	JBO-120885	£99.59
1"	8	50	644401-	£132.68	JBO-120806	£86.01
1 1/8"	7	60	644401-18	£173.47	JBO-120813	£150.85
1 1/4"	7	60	644401-14	£184.93	JBO-120811	£284.32
1 3/8"	6	60	644401-38	£298.27	JBO-120820	£152.27
1 1/2"	6	70	644401-12	£267.26	JBO-120810	£222.13
1 3/4"	5	80	644401-34	£388.71	JBO-120818	£279.48
2"	4.5	85	644402-	£491.95	JBO-120836	£390.56
<b>BSP(G)</b>						
1/8"	28	27	64460-18	£45.65	JBO-120014	£30.17
1/4"	19	36	64460-14	£53.21	JBO-120012	£32.40
3/8"	19	41	64460-38	£65.48	JBO-120067	£42.67
1/2"	14	41	64460-12	£91.93	JBO-120010	£49.40
3/4"	14	50	64460-34	£174.77	JBO-120025	£87.09
1"	11	60	644601-	£276.70	JBO-120058	£107.01
1 1/4"	11	70	644601-14	£292.22	JBO-120063	£147.28
1 3/8"	11	-	-	-	JBO-120006	£229.49
1 1/2"	11	85	644601-12	£404.20	JBO-120061	£199.30
2"	11	100	-	-	JBO-120016	£251.37
2 1/2"	11	115	-	-	JBO-120018	£355.08
<b>BSF</b>						
3/16"	32	19	64450-316	£67.63	-	-
1/4"	26	19	64450-14	£33.90	-	-
5/16"	22	22	64450-516	£36.67	-	-
3/8"	20	27	64450-38	£45.91	-	-
7/16"	18	27	64450-716	£69.53	-	-
1/2"	16	36	64450-12	£55.76	-	-
9/16"	16	36	64450-916	£68.88	-	-
5/8"	14	41	64450-58	£68.88	-	-
3/4"	12	41	64450-34	£84.50	-	-
7/8"	11	50	64450-78	£96.77	-	-
1"	10	50	644501-	£139.04	-	-
1 1/8"	9	60	644501-18	£194.35	-	-
1 1/4"	9	60	644501-14	£194.35	-	-
1 3/8"	8	60	644501-38	£298.27	-	-
1 1/2"	8	70	644501-12	£279.39	-	-
1 5/8"	8	70	644501-58	£288.19	-	-
1 3/4"	7	80	644501-34	£387.37	-	-



## NPT DIE NUTS

Hexagon Die Nut

- National pipe taper
- For recutting and repairing damaged threads
- **Presto** - General quality
- **JBO** - Premium quality made in Germany



NPT	TPI	S	Order Code			
			Presto	Price	JBO	Price
1/8"	27	27	64490-18	£81.48	JBO-120611	£56.67
1/4"	18	36	64490-14	£122.16	JBO-120610	£71.17
3/8"	18	41	64490-38	£121.74	JBO-120616	£72.40
1/2"	14	50	64490-12	£178.17	JBO-120609	£87.09
3/4"	14	60	64490-34	£250.36	JBO-120615	£146.05
1"	11.5	60	644901-	£342.83	JBO-120604	£174.15
1 1/4"	11.5	85	644901-14	£379.23	-	-
1 1/2"	11.5	85	644901-12	£599.22	-	-
2"	11.5	100	644902-	£871.17	-	-



## M3-M12 HEXAGON DIE NUT SET

- Includes 1 of each M3, M4, M5, M6, M8, M10 & M12 hexagon dies
- Tolerance 6g
- For rethreading and repairing damaged external threads
- For steel & NF metal material groups up to a strength of 700 N/mm<sup>2</sup>



Die Range	Order Code	Price
M3-M12	13434500	£237.67

# Thread Turning Tools








VARDEX  **TEKNIK**  
Cutting Tools

**Achieve accurate, consistent thread profiles with world leading Vardex thread turning solutions by Vargus.**

Designed for everything from general purpose machining to demanding high performance and material specific applications, the Vardex system offers threading tools capable of producing virtually any thread form and pitch with excellent precision and repeatability.

With a wide choice of grades, geometries and tooling systems available, Vardex thread turning solutions help improve surface finish, chip control and tool life across a wide range of materials and threading applications.

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## The world's most intelligent threading tool selector and CNC program generator.

The VARGUS GENius™ calculator offers the most popular and advanced thread turning, thread milling, whirling, and tapping software on the market today, featuring VARDEX's threading applications.



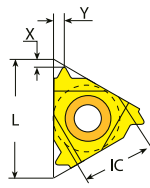
Find out More



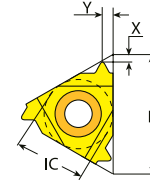
## ISO METRIC, 60° THREADING INSERTS

### Single Point Threading Inserts

- Suitable for thread turning full profile metric threads
- Right hand (left hand on request)
- For left hand inserts replace code with EL (External) or IL (Internal)
- VTX Ground Inserts – premium precision ground inserts for maximum thread accuracy and surface finish
- FST Sintered Inserts – cost effective inserts for reliable general purpose and production threading applications



EXTERNAL



INTERNAL

\*Min bore dimension applies only to MINIPRO style inserts which require dedicated holders.

Insert Size		Pitch	EXTERNAL Inserts					INTERNAL Inserts				
IC	L mm	mm	ISO Code	VTX Grade	Price	FST Grade	Price	ISO Code	VTX Grade	Price	FST Grade	Price
4mm	6	0.25	-	-	-	-	-	4.0KIR0.25ISO	028-00155	£21.35	-	-
		0.5	-	-	-	-	-	4.0KIR0.5ISO	028-00017	£21.35	-	-
		0.75	-	-	-	-	-	4.0KIR0.75ISO	028-00018	£21.35	-	-
		1	-	-	-	-	-	4.0KIR1.0ISO	028-00019	£21.35	-	-
		1.25	-	-	-	-	-	4.0KIR1.25ISO	028-00020	£21.35	-	-
5mm	8	0.5	-	-	-	-	-	5.0KIR0.5ISO	028-00157	£29.25	-	-
		0.75	-	-	-	-	-	5.0KIR0.75ISO	028-00158	£29.25	-	-
		1	-	-	-	-	-	5.0KIR1.0ISO	028-00159	£27.86	-	-
		1.25	-	-	-	-	-	5.0KIR1.25ISO	028-00162	£29.25	-	-
		1.5	-	-	-	-	-	5.0KIR1.5ISO	028-00160	£23.96	-	-
1/4"	11 (11ER/11NR)	0.35	2ER0.35ISO	021-54243	£13.05	-	-	2IR0.35ISO	021-00375	£13.05	-	-
		0.4	2ER0.4ISO	021-53504	£13.05	-	-	2IR0.4ISO	021-00377	£13.05	-	-
		0.45	2ER0.45ISO	021-51901	£13.05	-	-	2IR0.45ISO	021-00381	£13.05	-	-
		0.5	2ER0.5ISO	021-53790	£13.05	-	-	2IR0.5ISO	021-00385	£13.05	-	-
		0.6	2ER0.6ISO	021-00154	£13.05	-	-	2IR0.6ISO	021-00387	£13.05	-	-
		0.7	2ER0.7ISO	021-00161	£13.05	-	-	2IR0.7ISO	021-00391	£13.05	-	-
		0.75	2ER0.75ISO	021-00270	£13.05	-	-	2IR0.75ISO	021-54357	£13.05	-	-
		0.8	2ER0.8ISO	021-00172	£13.05	-	-	2IR0.8ISO	021-00397	£13.05	-	-
		1	2ER1.0ISO	021-00175	£13.05	-	-	2IR1.0ISO	021-53625	£13.05	162-00011	£8.08
		1.25	2ER1.25ISO	021-00179	£13.05	-	-	2IR1.25ISO	021-53632	£13.05	-	-
		1.5	2ER1.5ISO	021-00186	£13.05	-	-	2IR1.5ISO	021-53624	£13.05	162-00057	£8.08
3/8"	16 (16ER/16NR)	0.25	3ER0.25ISO	021-04764	£11.62	-	-	-	-	-	-	-
		0.3	3ER0.3ISO	021-04767	£11.62	-	-	-	-	-	-	-
		0.35	3ER0.35ISO	021-51115	£11.62	-	-	3IR0.35ISO	021-01261	£11.62	-	-
		0.4	3ER0.4ISO	021-54033	£11.62	-	-	3IR0.4ISO	021-01265	£11.62	-	-
		0.45	3ER0.45ISO	021-00828	£11.62	-	-	3IR0.45ISO	021-01268	£11.62	-	-
		0.5	3ER0.5ISO	021-51001	£11.62	-	-	3IR0.5ISO	021-51009	£11.62	-	-
		0.6	3ER0.6ISO	021-00835	£11.62	-	-	3IR0.6ISO	021-01276	£11.62	-	-
		0.7	3ER0.7ISO	021-53795	£11.62	-	-	3IR0.7ISO	021-01278	£11.62	-	-
		0.75	3ER0.75ISO	021-53663	£11.62	-	-	3IR0.75ISO	021-53514	£11.62	-	-
		0.8	3ER0.8ISO	021-53608	£11.62	-	-	3IR0.8ISO	021-01284	£11.62	-	-
		1	3ER1.0ISO	021-53609	£11.62	162-00015	£8.08	3IR1.0ISO	021-53910	£11.62	162-00039	£8.08
		1.25	3ER1.25ISO	021-51064	£11.62	162-00017	£8.08	3IR1.25ISO	021-53911	£11.62	162-00125	£8.08
		1.5	3ER1.5ISO	021-51077	£11.62	162-00001	£8.08	3IR1.5ISO	021-52253	£11.62	162-00041	£8.08
		1.75	3ER1.75ISO	021-54235	£11.62	162-00121	£8.08	3IR1.75ISO	021-51005	£11.62	162-00139	£8.09
		2	3ER2.0ISO	021-51547	£11.62	162-00019	£8.08	3IR2.0ISO	021-53912	£11.62	162-00045	£8.08
2.5	3ER2.5ISO	021-53909	£11.62	162-00021	£8.08	3IR2.5ISO	021-53913	£11.62	162-00127	£8.08		
3	3ER3.0ISO	021-51716	£11.62	162-00007	£8.08	3IR3.0ISO	021-52708	£11.62	162-00043	£8.08		
3.5	3ER3.5ISO	021-05667	£11.62	-	-	3IR3.5ISO	021-05666	£11.62	-	-		
1/2"	22 (22ER/22NR)	3.5	4ER3.5ISO	021-59022	£18.69	-	-	4IR3.5ISO	021-59484	£18.69	-	-
		4	4ER4.0ISO	021-59122	£18.69	-	-	4IR4.0ISO	021-59289	£18.69	-	-
		4.5	4ER4.5ISO	021-01460	£18.69	-	-	4IR4.5ISO	021-59000	£18.69	-	-
		5	4ER5.0ISO	021-58583	£18.69	-	-	4IR5.0ISO	021-59476	£18.69	-	-
		5.5	4ER5.5ISO	021-01470	£18.69	-	-	4IR5.5ISO	021-01600	£18.69	-	-
		6	4ER6.0ISO	021-01476	£18.69	-	-	4IR6.0ISO	021-01606	£18.69	-	-
5/8"	27 (27ER/27NR)	4.5	-	-	-	-	-	5IR4.5ISO	021-05835	£36.86	-	-
		5	-	-	-	-	-	5IR5.0ISO	021-05492	£36.86	-	-
		5.5	5ER5.5ISO	021-59111	£36.86	-	-	5IR5.5ISO	021-59305	£36.86	-	-
		6	5ER6.0ISO	021-59492	£36.86	-	-	5IR6.0ISO	021-58945	£36.86	-	-

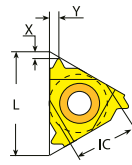
ISO METRIC THREADING INSERTS



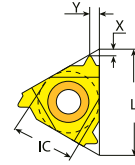
## WHITWORTH 55° (BSW/BSF/BSP) - FULL PROFILE THREADING INSERTS

### Single Point Threading Inserts

- Suitable for thread turning full profile whitworth threads
- Right hand (left hand on request)
- For left hand inserts replace code with EL (External) or IL (Internal)
- VTX Ground Inserts – premium precision ground inserts for maximum thread accuracy and surface finish
- FST Sintered Inserts – cost effective inserts for reliable general purpose and production threading applications



EXTERNAL



INTERNAL



\*Min bore dimension applies only to MINIPRO style inserts which require dedicated holders.

Insert Size		Pitch	EXTERNAL Inserts					INTERNAL Inserts				
IC	L mm	TPI	ISO Code	VTX Grade	Price	FST Grade	Price	ISO Code	VTX Grade	Price	FST Grade	Price
4mm	6	26	-	-	-	-	-	4.0KIR26W...	028-00078	£21.35	-	-
		22	-	-	-	-	-	4.0KIR22W...	028-00075	£21.35	-	-
		20	-	-	-	-	-	4.0KIR20W...	028-00011	£21.35	-	-
		19	-	-	-	-	-	4.0KIR19W...	028-00152	£21.35	-	-
		18	-	-	-	-	-	4.0KIR18W...	028-42251	£21.35	-	-
5mm	8	28	-	-	-	-	-	5.0KIR28W...	028-00184	£27.86	-	-
		24	-	-	-	-	-	5.0KIR24W...	028-00179	£29.25	-	-
		20	-	-	-	-	-	5.0KIR20W...	028-00177	£29.25	-	-
		19	-	-	-	-	-	5.0KIR19W...	028-00174	£27.86	-	-
		18	-	-	-	-	-	5.0KIR18W...	028-00172	£29.25	-	-
		16	-	-	-	-	-	5.0KIR16W...	028-00168	£29.25	-	-
1/4"	11 (11ER/11NR)	48	-	-	-	-	-	2IR48W	021-05612	£13.05	-	-
		40	-	-	-	-	-	2IR40W	021-00368	£13.05	-	-
		36	-	-	-	-	-	2IR36W	021-07420	£13.05	-	-
		32	-	-	-	-	-	2IR32W	021-00363	£13.05	-	-
		28	2ER28W	021-04512	£13.05	-	-	2IR28W	021-00357	£13.05	-	-
		26	2ER26W	021-05988	£13.05	-	-	2IR26W	021-00348	£13.05	-	-
		24	2ER24W	021-00107	£13.05	-	-	2IR24W	021-00346	£13.05	-	-
		22	2ER22W	021-05922	£13.05	-	-	2IR22W	021-00339	£13.05	-	-
		20	2ER20W	021-05482	£13.05	-	-	2IR20W	021-00337	£13.05	-	-
		19	2ER19W	021-00098	£13.05	-	-	2IR19W	021-50171	£13.05	162-00177	£8.09
		18	2ER18W	021-06850	£13.05	-	-	2IR18W	021-00325	£13.05	-	-
		16	2ER16W	021-04506	£13.05	-	-	2IR16W	021-00317	£13.05	-	-
		14	2ER14W	021-00076	£13.05	-	-	2IR14W	021-50364	£13.05	162-00179	£8.09
3/8"	16 (16ER/16NR)	56	3ER56W	021-06873	£11.62	-	-	-	-	-	-	-
		48	3ER48W	021-05610	£11.62	-	-	3IR48W	021-05611	£11.62	-	-
		40	3ER40W	021-00813	£11.62	-	-	3IR40W	021-01252	£11.62	-	-
		36	3ER36W	021-00807	£11.62	-	-	3IR36W	021-01245	£11.62	-	-
		32	3ER32W	021-00802	£11.62	-	-	3IR32W	021-012141	£9.31	-	-
		28	3ER28W	021-53836	£11.62	-	-	3IR28W	021-01232	£11.62	-	-
		26	3ER26W	021-54246	£11.62	-	-	3IR26W	021-54247	£11.62	-	-
		24	3ER24W	021-54315	£11.62	-	-	3IR24W	021-01214	£11.62	-	-
		22	3ER22W	021-00774	£11.62	-	-	3IR22W	021-01208	£11.62	-	-
		20	3ER20W	021-00771	£11.62	-	-	3IR20W	021-01205	£11.62	-	-
		19	3ER19W	021-53835	£11.62	162-00175	£8.09	3IR19W	021-54290	£11.62	-	-
		18	3ER18W	021-53226	£11.62	-	-	3IR18W	021-01189	£11.62	-	-
		16	3ER16W	021-52060	£11.62	-	-	3IR16W	021-52069	£11.62	-	-
		14	3ER14W	021-53649	£11.62	162-00009	£8.08	3IR14W	021-50135	£11.62	162-00049	£8.08
		12	3ER12W	021-54314	£11.62	-	-	3IR12W	021-53807	£11.62	-	-
		11	3ER11W	021-51186	£11.62	162-00029	£8.08	3IR11W	021-54317	£11.62	162-00051	£8.08
		10	3ER10W	021-00700	£11.62	-	-	3IR10W	021-01135	£11.62	-	-
9	3ER9W	021-00682	£11.62	-	-	3IR9W	021-01117	£11.62	-	-		
8	3ER8W	021-54245	£11.62	-	-	3IR8W	021-52856	£11.62	-	-		
1/2"	22	7	4ER7W	021-59481	£18.69	-	-	4IR7W	021-59204	£18.69	-	-
		6	4ER6W	021-59482	£18.69	-	-	4IR6W	021-01563	£18.69	-	-
		5	4ER5W	021-01423	£18.69	-	-	4IR5W	021-01550	£18.69	-	-
5/8"	27	4.5	5ER4.5W	021-01639	£36.86	-	-	5IR4.5W	021-01687	£36.86	-	-
		4	5ER4W	021-01635	£36.86	-	-	5IR4W	021-01684	£36.86	-	-

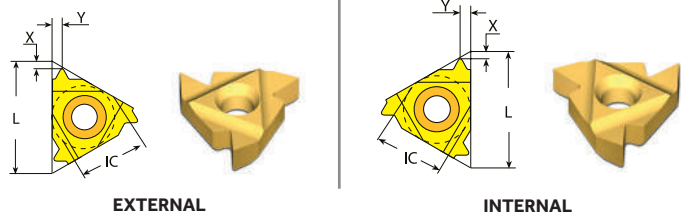
WHITWORTH THREADING INSERTS

**VARDEX**

**UNIFIED 60° (UN/UNF/UNEF) - FULL PROFILE THREADING INSERTS**

Single Point Threading Inserts

- Suitable for thread turning full profile unified threads
- Right hand (left hand on request)
- For left hand inserts replace code with EL (External) or IL (Internal)
- VTX Ground Inserts – premium precision ground inserts for maximum thread accuracy and surface finish
- FST Sintered Inserts – cost effective inserts for reliable general purpose and production threading applications



EXTERNAL

INTERNAL

\*Min bore dimension applies only to MINIPRO style inserts which require dedicated holders.

Insert Size		Pitch	EXTERNAL Inserts					INTERNAL Inserts				
IC	L mm	TPI	ISO Code	VTX Grade	Price	FST Grade	Price	ISO Code	VTX Grade	Price	FST Grade	Price
4mm	6	32	-	-	-	-	-	4.0KIR32UN	028-00016	£21.35	-	-
		28	-	-	-	-	-	4.0KIR28UN	028-00015	£21.35	-	-
		24	-	-	-	-	-	4.0KIR24UN	028-00010	£21.35	-	-
		20	-	-	-	-	-	4.0KIR20UN	028-00008	£21.35	-	-
		18	-	-	-	-	-	4.0KIR18UN	028-00006	£21.35	-	-
5mm	8	32	-	-	-	-	-	5.0KIR32UN	028-00185	£29.25	-	-
		28	-	-	-	-	-	5.0KIR28UN	028-00183	£29.25	-	-
		24	-	-	-	-	-	5.0KIR24UN	028-00178	£29.25	-	-
		20	-	-	-	-	-	5.0KIR20UN	028-00176	£29.25	-	-
		18	-	-	-	-	-	5.0KIR18UN	028-00171	£29.25	-	-
		16	-	-	-	-	-	5.0KIR16UN	028-00167	£29.25	-	-
1/4"	11 (11ER/11NR)	72	-	-	-	-	-	2IR72UN	021-53233	£13.05	-	-
		64	2ER64UN	021-05874	£13.05	-	-	2IR64UN	021-50620	£13.06	-	-
		56	-	-	-	-	-	2IR56UN	021-00370	£13.05	-	-
		48	-	-	-	-	-	2IR48UN	021-53100	£13.05	-	-
		40	2ER40UN	021-00121	£13.05	-	-	2IR40UN	021-53207	£13.05	-	-
		36	2ER36UN	021-05916	£13.05	-	-	2IR36UN	021-06628	£13.05	-	-
		32	2ER32UN	021-00119	£13.05	-	-	2IR32UN	021-50564	£13.05	-	-
		28	2ER28UN	021-50159	£13.05	-	-	2IR28UN	021-52961	£13.05	-	-
		24	2ER24UN	021-50106	£13.05	-	-	2IR24UN	021-53208	£13.05	-	-
		20	2ER20UN	021-04579	£13.05	-	-	2IR20UN	021-50486	£13.05	-	-
		18	2ER18UN	021-06845	£13.05	-	-	2IR18UN	021-50444	£13.05	-	-
		16	2ER16UN	021-00083	£13.05	-	-	2IR16UN	021-50402	£13.05	-	-
3/8"	16 (16ER/16NR)	14	2ER14UN	021-04488	£13.05	-	-	2IR14UN	021-53818	£13.05	-	-
		80	3ER80UN	021-50081	£11.62	-	-	-	-	-	-	-
		72	3ER72UN	021-53508	£11.62	-	-	3IR72UN	021-53241	£11.62	-	-
		64	3ER64UN	021-54304	£11.62	-	-	3IR64UN	021-01500	£11.62	-	-
		56	3ER56UN	021-53671	£11.62	-	-	3IR56UN	021-01247	£11.62	-	-
		48	3ER48UN	021-53849	£11.62	-	-	3IR48UN	021-01253	£11.62	-	-
		44	3ER44UN	021-05715	£11.62	-	-	3IR44UN	021-05716	£11.62	-	-
		40	3ER40UN	021-53669	£11.62	-	-	3IR40UN	021-01248	£11.62	-	-
		36	3ER36UN	021-51765	£11.62	-	-	3IR36UN	021-51856	£11.62	-	-
		32	3ER32UN	021-51746	£11.62	-	-	3IR32UN	021-52724	£11.62	-	-
		28	3ER28UN	021-51697	£11.62	-	-	3IR28UN	021-52701	£11.62	-	-
		27	3ER27UN	021-51660	£11.62	-	-	3IR27UN	021-01223	£11.62	-	-
		24	3ER24UN	021-51623	£11.62	162-00173	£8.09	3IR24UN	021-52667	£11.62	-	-
		20	3ER20UN	021-51591	£11.62	162-00023	£8.08	3IR20UN	021-52646	£11.62	162-00133	£8.08
		18	3ER18UN	021-51511	£11.62	162-00129	£8.08	3IR18UN	021-52595	£11.62	162-00165	£8.09
		16	3ER16UN	021-51451	£11.62	162-00025	£8.08	3IR16UN	021-52556	£11.62	162-00135	£8.08
		14	3ER14UN	021-51383	£11.62	162-00131	£8.08	3IR14UN	021-52499	£11.62	162-00159	£8.09
13	3ER13UN	021-52889	£11.62	-	-	3IR13UN	021-52424	£11.62	-	-		
12	3ER12UN	021-51291	£11.62	162-00027	£8.08	3IR12UN	021-52421	£11.62	162-00047	£8.08		
11.5	3ER11.5UN	021-53533	£11.62	-	-	3IR11.5UN	021-53534	£11.62	-	-		
11	3ER11UN	021-51175	£11.62	-	-	3IR11UN	021-54241	£11.62	-	-		
10	3ER10UN	021-51144	£11.62	-	-	3IR10UN	021-52306	£11.62	-	-		
9	3ER9UN	021-54236	£11.62	-	-	3IR9UN	021-54251	£11.62	-	-		
8	3ER8UN	021-51924	£11.62	162-00157	£8.09	3IR8UN	021-52853	£11.62	162-00149	£8.09		
1/2"	22	7	4ER7UN	021-59317	£18.69	-	-	4IR7UN	021-59483	£18.69	-	-
		6	4ER6UN	021-58654	£18.69	-	-	4IR6UN	021-58800	£18.69	-	-
		5	4ER5UN	021-59316	£18.69	-	-	4IR5UN	021-59203	£18.69	-	-
5/8"	27	4.5	5ER4.5UN	021-58988	£36.86	-	-	5IR4.5UN	021-59485	£36.86	-	-
		4	5ER4UN	021-58983	£36.86	-	-	5IR4UN	021-59491	£36.86	-	-

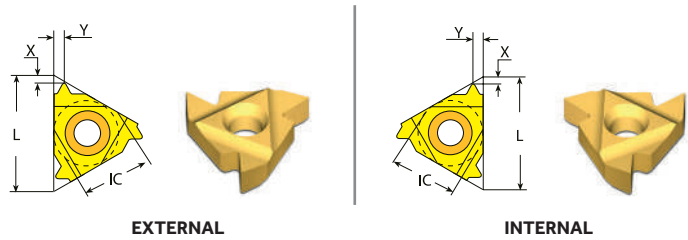
UNIFIED THREADING INSERTS



## BSPT 55° - FULL PROFILE THREADING INSERTS

### Single Point Threading Inserts

- Suitable for thread turning full profile BSPT threads
- Right hand (left hand on request)
- For left hand inserts replace code with EL (External) or IL (Internal)
- VTX Ground Inserts – premium precision ground inserts for maximum thread accuracy and surface finish
- FST Sintered Inserts – cost effective inserts for reliable general purpose and production threading applications

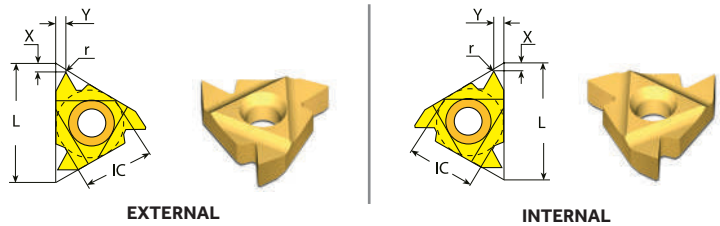


Insert Size		Pitch	EXTERNAL Inserts					INTERNAL Inserts				
IC	L mm	TPI	ISO Code	VTX Grade	Price	FST Grade	Price	ISO Code	VTX Grade	Price	FST Grade	Price
1/4"	11 (11ER/ 11NR)	28	2ER28BSPT	021-00111	£13.05	-	-	2IR28BSPT	021-00353	£13.05	-	-
		19	2ER19BSPT	021-00094	£13.05	-	-	2IR19BSPT	021-00326	£13.05	-	-
		14	2ER14BSPT	021-00069	£13.05	-	-	2IR14BSPT	021-51930	£13.05	-	-
3/8"	16 (16ER/ 16NR)	28	3ER28BSPT	021-51673	£11.62	-	-	3IR28BSPT	021-01226	£11.62	-	-
		19	3ER19BSPT	021-53837	£11.62	-	-	3IR19BSPT	021-01192	£11.62	-	-
		14	3ER14BSPT	021-50337	£11.62	162-00153	£10.82	3IR14BSPT	021-01163	£11.62	162-00151	£8.54
		11	3ER11BSPT	021-00703	£11.62	162-00145	£8.54	3IR11BSPT	021-53889	£11.62	162-00141	£8.54



## 55° & 60° PARTIAL PROFILE THREADING INSERTS

- Suitable for thread turning a range of 55° & 60° thread sizes
- Right hand (left hand on request)
- For left hand inserts replace code with EL (External) or IL (Internal)
- VTX Ground Inserts – premium precision ground inserts for maximum thread accuracy and surface finish
- FST Sintered Inserts – cost effective inserts for reliable general purpose and production threading applications



Insert Size		Pitch		EXTERNAL Inserts					INTERNAL Inserts				
IC	L mm	mm	TPI	ISO Code	VTX Grade	Price	FST Grade	Price	ISO Code	VTX Grade	Price	FST Grade	Price
<b>55° Partial Profile</b>													
4mm	6	0.5-1.25	48-20	-	-	-	-	-	4.0KIRA55	028-00004	£21.35	-	-
5mm	8	0.5-1.5	48-16	-	-	-	-	-	5.0KIRA55	028-00186	£29.25	-	-
6mm	10	0.5-1.5	48-16	-	-	-	-	-	6.0KIRA55	028-00385	£26.30	-	-
1/4"	11	0.5-1.5	48-16	2ERA55	021-00064	£13.05	-	-	2IRA55	021-54253	£13.05	-	-
		0.5-1.5	48-16	3ERA55	021-54250	£11.62	-	-	3IRA55	021-01075	£11.62	-	-
3/8"	16	1.75-3.0	14-8	3ERG55	021-51829	£11.62	-	-	3IRG55	021-01083	£11.62	-	-
		0.5-3.0	48-8	3ERAG55	021-54244	£11.62	162-00117	£8.08	3IRAG55	021-54280	£11.62	162-00119	£8.08
<b>60° Partial Profile</b>													
4mm	6	0.5-1.25	48-20	-	-	-	-	-	4.0KIRA60	028-00005	£21.35	-	-
5mm	8	0.5-1.5	48-16	-	-	-	-	-	5.0KIRA60	028-00187	£29.25	-	-
6mm	10	0.5-1.5	48-16	-	-	-	-	-	6.0KIRA60	028-00384	£26.30	-	-
1/4"	11	0.5-1.5	48-16	2ERA60	021-54333	£13.05	-	-	2IRA60	021-50272	£13.05	162-00003	£8.08
		0.5-1.5	48-16	3ERA60	021-50973	£11.62	-	-	3IRA60	021-52195	£11.62	-	-
3/8"	16	1.75-3.0	14-8	3ERG60	021-50993	£11.62	162-00035	£8.08	3IRG60	021-52216	£11.62	162-00037	£8.08
		0.5-3.0	48-8	3ERAG60	021-50953	£11.62	162-00013	£8.08	3IRAG60	021-52179	£11.62	162-00005	£8.08

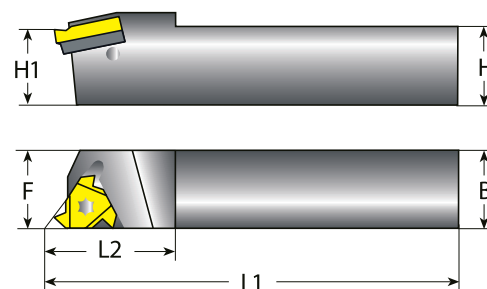
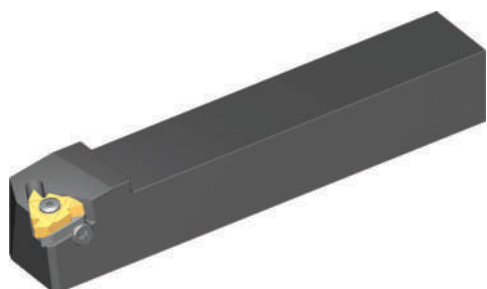
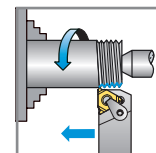
BSPT THREADING INSERTS

**VARDEX**

### EXTERNAL RIGHT HAND THREADING TOOL HOLDER

Screw Clamping - Single Point Threading

- Suitable for Vardex & other manufacturer's threading inserts (11/16/22/27 ER/EL style)



Shank H=H1=B	F	L1	L2	Insert Size IC	Order Code	Price	Inserts	Insert Screw	Shim Screw	Spares		Wrench
										Shim RH	Shim LH	
8	11	136.4	17.5	1/4"	NL8-2	<b>£84.29</b>	2ER/EL 11ER/EL	SN2T	-	-	-	K2T
10	11	125	17.5		NL10-2	<b>£85.44</b>						
12	12	125	17.5		NL12-2	<b>£85.44</b>						
12	16	83.2	22	3/8"	NL12-3	<b>£96.30</b>	3ER/EL 16ER/EL	SA3T	-	-	-	K3T
12	16	83.2	22		AL12-3	<b>£91.18</b>						
16	16	100	20.5		AL16-3	<b>£101.51</b>						
20	20	128.6	30		AL20-3	<b>£110.15</b>						
25	25	153.6	30		AL25-3	<b>£120.93</b>						
32	32	173.6	30		AL32-3	<b>£151.16</b>						
25	25	155.7	36	1/2"	AL25-4	<b>£131.74</b>	4ER/EL 22ER/EL	SA4T	SY4T	YE4	YI4	K4T
32	32	175.7	36		AL32-4	<b>£162.03</b>						
40	40	205.7	36		AL40-4	<b>£207.42</b>						
25	32	151.6	35	5/8"	AL25-5	<b>£158.84</b>	5ER/EL 27ER/EL	SA5T	SY5T	YE5	YI5	K5T
32	32	176.6	40		AL32-5	<b>£178.49</b>						
40	40	206.6	40		AL40-5	<b>£230.99</b>						
50	50	256.6	40		AL50-5	<b>£270.03</b>						

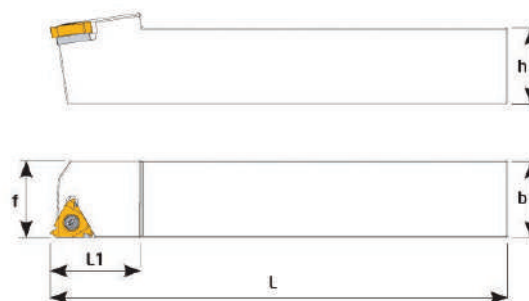
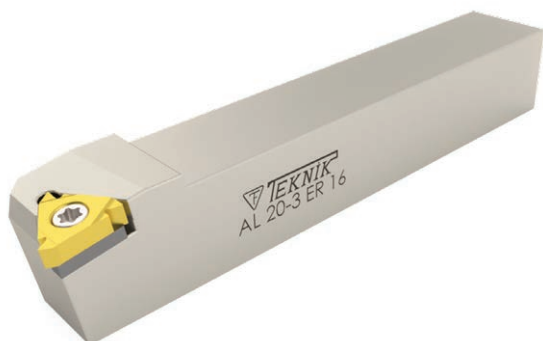
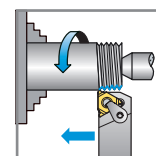
EXTERNAL THREADING TOOL HOLDERS

**TEKNIK**

### EXTERNAL RIGHT HAND THREADING TOOL HOLDER

Screw Clamping - Single Point Threading

- Screw clamp, shim type for secure and precise clamping
- Compatible with all ISO standard threading inserts



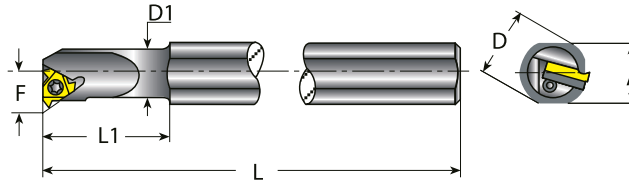
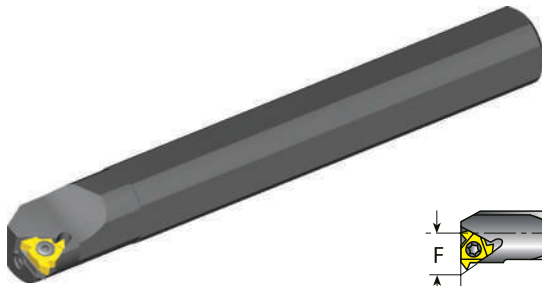
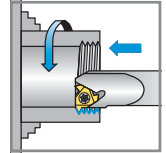
h	b	f	L	L1	Order Code	Price	Inserts
12	12	16	110	20	D261	<b>£50.39</b>	16ER / 3ER
16	16	16	100	22	D259	<b>£50.39</b>	
20	20	20	125	25	D258	<b>£55.41</b>	
25	25	25	150	30	D260	<b>£58.79</b>	
32	32	32	170	30	D262	<b>£70.52</b>	
25	25	25	150	30	D266	<b>£69.42</b>	22ER / 4ER

**VARDEX**

**INTERNAL RIGHT HAND THREADING TOOL HOLDER**

Screw Clamping - Single Point Threading

- Suitable for Vardex & other manufacturers threading inserts (11/16/22/27 ER/EL style)
- Available in solid or through coolant



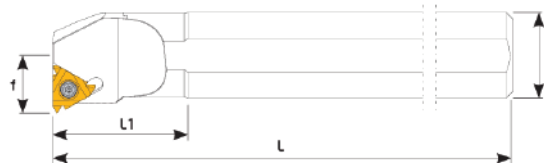
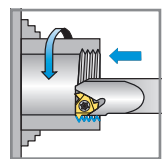
D	D1	A	L	L1	F	Min Bore mm	Insert Size IC	Order Code				Spares					
								Without Through Coolant	Price	Through Coolant	Price	Inserts	Insert Screw	Shim Screw	Shim RH	Shim LH	Torx Key
10	10	9.5	100	40	7.3	13	1/4"	NVR10D-2	£97.26	NVRC10D-2	£94.16	2IR/IL 11IR/IL	SN2T	-	-	-	K2T
20	10	18	180	25	7.3	13		NVR10-2	£97.26	NVRC10-2	£94.16						
20	13	18	180	32	8.9	16		NVR13-2	£94.52	NVRC13-2	£99.85						
20	12.7	18	180	32	10.3	17	3/8"	NVR13-3	£105.27	NVRC13-3	£110.94	3IR/IL 16IR/IL	SN3T	-	-	-	K3T
20	16	18	180	40	11.5	20		NVR16-3	£104.24	NVRC16-3	£104.24						
16	16	15.2	150	64	11.3	20		NVR16D-3	£98.66	NVRC16D-3	£104.24						
20	20	18	180	80	13.4	24	1/2"	AVR20-3	£110.16	AVRC20-3	£106.67	4IR/IL 22IR/IL	SN3T	SY3T	YI3	YE3	K3T
32	25	29	250	60	16.3	29		AVR25-3	£120.97	AVRC25-3	£117.13						
25	24.6	22.6	200	100	16.1	29		AVR25D-3	£117.62	AVRC25D-3	£124.20						
32	32	29	250	128	19.6	36	5/8"	AVR32-3	£162.04	AVRC32-3	£156.88	5IR/IL 27IR/IL	SN4T	-	-	-	K4T
40	40	36	300	160	23.8	44		AVR40-3	£205.17	AVRC40-3	£198.65						
20	20	18	180	80	15.6	27		NVR20-4	£78.54	NVRC20-4	£121.96						
25	24.6	22.6	200	100	17.2	32	1"	AVR25D-4	£167.72	AVRC25D-4	£157.48	22IR/IL	SA5T	SY5T	YI5	YE5	K5T
32	25	29	250	60	17.4	32		AVR25-4	£153.39	AVRC25-4	£148.51						
32	32	29	250	128	21.5	39		AVR32-4	£177.18	AVRC32-4	£171.54						
40	40	36	300	160	25.8	47	1 1/2"	AVR40-4	£226.83	AVRC40-4	£214.24	27IR/IL	SA5T	SY5T	YI5	YE5	K5T
50	50	45	350	200	30.8	57		AVR50-4	£325.49	AVRC50-4	£343.80						
32	32	29	250	128	22.4	40		AVR32-5	£202.21	AVRC32-5	£213.60						
40	40	36	300	160	26.4	48	2"	AVR40-5	£241.52	AVRC40-5	£255.09	27IR/IL	SA5T	SY5T	YI5	YE5	K5T
50	50	45	350	200	31.4	58		AVR50-5	£222.70	AVRC50-5	£350.07						
60	60	54	400	240	36.4	69		AVR60-5	£356.90	AVRC60-5	£377.01						

**TEKNIK**

**INTERNAL RIGHT HAND THREADING TOOL HOLDER**

Screw Clamping - Single Point Threading

- Screw type insert clamping
- Compatible with all ISO standard threading inserts



D	L	L1	f	Dmin	Order Code	Price	Inserts
10	110	20	6	12	K348	£34.98	11IR
12	125	25	7.2	14	K350	£36.62	
16	180	40	11	20	K352	£43.28	
20	180	40	13	25	K354	£46.62	16IR
25	200	40	16	29	K356	£49.98	
32	300	60	19.5	36	K358	£76.59	
20	180	40	14	24	K358-1	£51.07	22IR
25	200	40	17	32	K359	£49.98	
32	300	60	19.5	36	K360	£76.59	
40	300	60	24.5	45	K360-1	£105.79	

**THREAD CUTTING DATA**



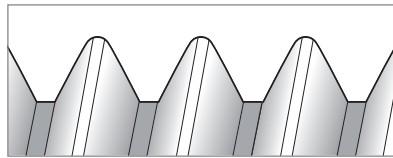
Workpiece Material		Hardness HB	Surface Speed Coated m/min	Surface Speed Uncoated m/min	
P Steel	Carbon Steel	Low Carbon (C=0.1-0.25 %)	125	115-190	-
		Medium Carbon (C=0.25-0.55 %)	150	100-175	-
		High Carbon (C=0.55-0.85 %)	170	90-165	-
	Low Alloy Steel (Alloying Elements ≤ 5%)	Non Hardened	180	100-180	-
		Hardened	275	75-140	-
		Hardened	350	70-135	-
	High Alloy Steel (Alloying Elements > 5%)	Annealed	200	80-120	-
		Hardened	325	50-100	-
	Cast Steel	Low Alloy (Alloying Elements <5%)	200	70-130	-
		High Alloy (Alloying Elements >5%)	225	60-120	-
M Stainless Steel	Stainless Steel Ferritic	Non Hardened	200	70-130	-
		Hardened	330	60-117	-
	Stainless Steel Austenitic	Austenitic	180	90-140	-
		Super Austenitic	200	40-110	-
	Stainless Steel Cast Ferritic	Non Hardened	200	90-120	-
		Hardened	330	65-110	-
	Stainless Steel Cast Austenitic	Austenitic	200	85-110	-
		Hardened	330	60-100	-
K Cast Iron	Malleable Cast Iron	Ferritic (Short Chips)	130	60-70	-
		Pearlitic (Long Chips)	230	60-145	-
	Gray Cast Iron	Low Tensile Strength	180	70-130	-
		High Tensile Strength	260	60-115	-
	Nodular Sg Iron	Ferritic	160	126-160	-
		Pearlitic	260	90-120	-
N Non-Ferrous	Aluminum Alloy Wrought	Non Aging	60	100-365	100-250
		Aged	100	80-220	80-160
	Aluminium Alloy	Cast	75	200-400	80-120
		Cast & Aged	90	200-280	70-100
		Cast Si 13-22%	130	60-180	50-120
	Copper & Copper Alloy	Brass	90	80-225	70-170
		Bronze & Non Leaded Copper	100	80-255	70-170
S HRSA	High Temperature Alloy	Annealed (Iron Based)	200	45-60	30-50
		Aged (Iron Based)	280	30-50	25-40
		Annealed (Nickel Or Cobalt Based)	250	20-30	20-30
		Aged (Nickel Or Cobalt Based)	350	15-25	15-25
	Titanium Alloy	Pure 99.5 Ti	400Rm	140-170	60-100
A+B Alloys		1050Rm	50-70	40-60	
H Hard Materials	Hardened Steel	Hardened & Tempered Steel	45-50HRC	45-60	-
			51-55HRC	40-50	-

**CALCULATING RPM**

$$n = \frac{vc \times 1000}{\pi \times Dia}$$

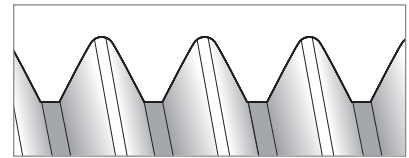
**THREAD HAND**

**LEFT-HAND THREAD**



A thread which when viewed axially, winds in an anti-clockwise and receding direction (LH).

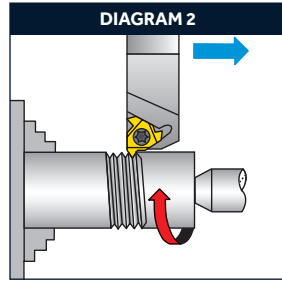
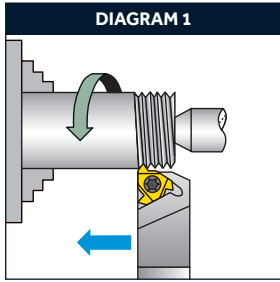
**RIGHT-HAND THREAD**



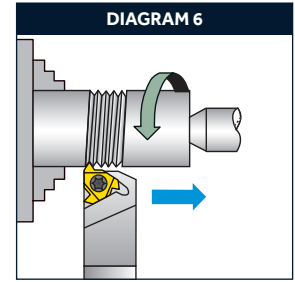
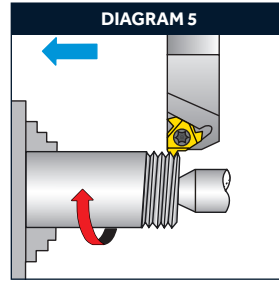
A thread which when viewed axially, winds in a clockwise and receding direction (RH).

## VARDEX THREAD TURNING METHOD

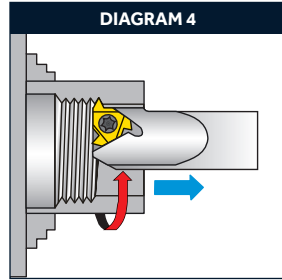
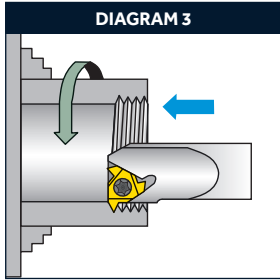
### EXTERNAL RH THREAD



### EXTERNAL LH THREAD



### INTERNAL RH THREAD



### INTERNAL LH THREAD

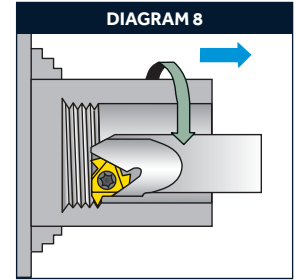
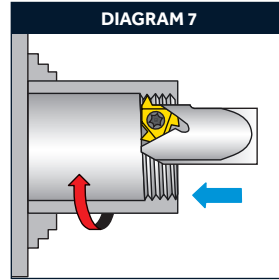
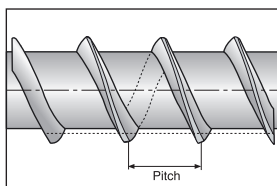


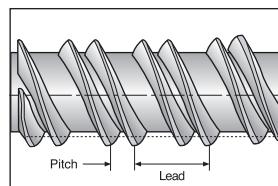
Diagram	Thread	Inserts & Tool Holder	Rotation	Feed Direction	Helix Method
1	RH External	EX RH	Anti-clockwise	Towards chuck	Regular
2		EX LH	Clockwise	From chuck	Reversed
3	RH Internal	IN RH	Anti-clockwise	Towards chuck	Regular
4		IN LH	Clockwise	From chuck	Reversed
5	LH External	EX LH	Clockwise	Towards chuck	Regular
6		EX RH	Anti-clockwise	From chuck	Reversed
7	LH Internal	IN LH	Clockwise	Towards chuck	Regular
8		IN RH	Anti-clockwise	From chuck	Reversed

## VARDEX MACHINING A MULTI-START THREAD

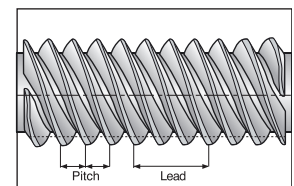
### FIRST START MACHINED



### SECOND START MACHINED



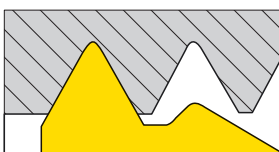
### THIRD START MACHINED



Multiple start threads combine the close fit of a fine thread with the quick axial motion of a coarse thread. Anytime a design engineer needs a fine fit combined with fast motion, it is likely that they will use a multiple start thread.

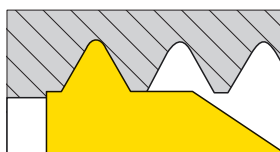
## VARDEX INSERT PROFILE STYLE

### PARTIAL PROFILE



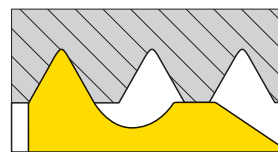
The V profile insert cuts without topping the outer diameter of the thread. The same insert can be used for a range of pitches which have a common thread angle.

### FULL PROFILE



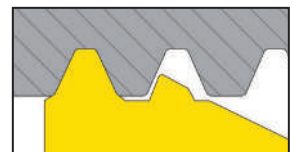
The full profile insert will form a complete thread profile including the crest. A separate insert is required for every pitch.

### FULL PROFILE



The full profile for fine pitches will form a complete thread. The topping of the outer diameter is generated by a second tooth.

### SEMI FULL











The semi profile insert will form a complete thread including crest radius but without topping the outer diameter. Mainly used for trapezoidal threads.

# Thread Gauges



High quality plug and ring gauges for accurate identification and inspection of metric and imperial screw threads.

Thread gauges are precision inspection tools used to identify and verify screw thread size, pitch, and form on both internal and external threads.

	<b>Metric Coarse Plug &amp; Ring Thread Gauges</b> Go & no-go plug & ring gauges from Insize & premium German supplier JBO in metric coarse thread form.	138
	<b>Metric Fine Plug &amp; Ring Thread Gauges</b> Go & no-go plug & ring gauges from Insize & premium German supplier JBO in metric fine thread form.	139
	<b>NPT Plug &amp; Ring Thread Gauges</b> Go & no-go plug & ring gauges from Insize & premium German supplier JBO in NPT thread form.	140
	<b>NPTF Plug &amp; Ring Thread Gauges</b> Go & no-go plug & ring gauges from Insize & premium German supplier JBO in NPTF thread form.	140
	<b>BSPT Plug &amp; Ring Thread Gauges</b> Go & no-go plug & ring gauges from Insize & premium German supplier JBO in BSPT thread form.	140
	<b>Whitworth Plug &amp; Ring Thread Gauges</b> Go & no-go plug & ring gauges from Insize & premium German supplier JBO in Whitworth thread form.	141
	<b>UNC Plug &amp; Ring Thread Gauges</b> Go & no-go plug & ring gauges from Insize & premium German supplier JBO in UNC thread form.	142
	<b>UNF Plug &amp; Ring Thread Gauges</b> Go & no-go plug & ring gauges from Insize & premium German supplier JBO in UNF thread form.	143

# Precision tools for thread manufacturing & quality control

Over 175 Years of German engineering excellence.



## Tradition Meets Innovation

Founded in 1849, Johs. Boss has grown over six generations into a global leader in thread technology. All products are developed and manufactured in-house in Albstadt, Germany.

## Thread Gauges

JBO thread gauges are made to tight tolerances for reliable, consistent accuracy. Trusted by leading UK calibration houses, they help reduce false checks, scrap and production delays.

Available in all popular threads and sizes for next-day delivery, with fast turnaround on specials, JBO gauges make inspection simple and dependable.



**Made in Albstadt, Germany since 1849.**

### Global Presence

Trusted in over 60 countries, supporting industries worldwide.

### Technological Leadership

Advanced, durable, efficient solutions.

### Comprehensive Service

Custom solutions & expert support.

**DIN EN ISO 9001:2015 certified.**

### Solid dies

Page 144



### Hexagon die nuts

Page 144



### Thread rolling dies

Please enquire

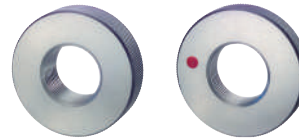




Premium

## METRIC COARSE PLUG & RING THREAD GAUGES

- 6H plug gauges (Go/No-Go)
- 6g ring gauges (Go/No-Go)
- Right hand
- Calibrated versions available



M	Pitch mm	6H Plug Gauge		6g Ring Gauge			
		Order Code (Go/No-Go)	List Price	Order Code (Go)	List Price	Order Code (No-Go)	List Price
M2	0.4	JBO-PG-511859	£86.06	JBO-RG-501700	£84.90	JBO-RG-500404	£84.90
M2.2	0.45	JBO-PG-511873	£91.63	JBO-RG-501714	£94.77	JBO-RG-500419	£94.77
M2.3	0.4	JBO-PG-511879	£94.77	JBO-RG-501720	£156.80	JBO-RG-500425	£156.80
M2.5	0.45	JBO-PG-511883	£75.71	JBO-RG-501724	£66.75	JBO-RG-500429	£66.75
M2.6	0.45	JBO-PG-511894	£92.02	JBO-RG-501739	£84.45	JBO-RG-500441	£84.45
M3	0.5	JBO-PG-512036	£62.34	JBO-RG-501903	£51.47	JBO-RG-500596	£51.47
M3.5	0.6	JBO-PG-512059	£64.46	JBO-RG-501919	£53.16	JBO-RG-500611	£53.16
M4	0.7	JBO-PG-512177	£58.59	JBO-RG-502047	£46.89	JBO-RG-500734	£46.89
M4.5	0.75	JBO-PG-512202	£79.75	JBO-RG-502069	£75.31	JBO-RG-500752	£75.31
M5	0.8	JBO-PG-512218	£57.18	JBO-RG-502138	£46.89	JBO-RG-500822	£46.89
M6	1	JBO-PG-512252	£51.51	JBO-RG-502214	£49.86	JBO-RG-500896	£46.89
M7	1	JBO-PG-512286	£60.32	JBO-RG-502271	£55.31	JBO-RG-500948	£55.31
M8	1.25	JBO-PG-512305	£57.18	JBO-RG-502301	£48.17	JBO-RG-500980	£48.17
M9	1.25	JBO-PG-512345	£75.07	JBO-RG-502347	£66.19	JBO-RG-501024	£66.19
M10	1.5	JBO-PG-511646	£61.33	JBO-RG-501452	£55.31	JBO-RG-500158	£55.31
M11	1.5	JBO-PG-511679	£80.03	JBO-RG-501492	£77.60	JBO-RG-500201	£77.60
M12	1.75	JBO-PG-511689	£65.61	JBO-RG-501512	£61.76	JBO-RG-500218	£61.76
M14	2	JBO-PG-511730	£70.73	JBO-RG-501572	£65.89	JBO-RG-500277	£65.89
M16	2	JBO-PG-511776	£75.77	JBO-RG-501623	£73.19	JBO-RG-500327	£73.19
M18	2.5	JBO-PG-511820	£82.05	JBO-RG-501663	£85.02	JBO-RG-500370	£85.02
M20	2.5	JBO-PG-511902	£88.03	JBO-RG-501748	£93.75	JBO-RG-500447	£93.75
M22	2.5	JBO-PG-511934	£93.18	JBO-RG-501782	£103.20	JBO-RG-500479	£103.20
M24	3	JBO-PG-511965	£105.06	JBO-RG-501815	£113.99	JBO-RG-500508	£110.49
M27	3	JBO-PG-512005	£117.90	JBO-RG-501868	£123.92	JBO-RG-500559	£123.92
M30	3.5	JBO-PG-512075	£130.66	JBO-RG-501929	£135.47	JBO-RG-500623	£135.47
M33	3.5	JBO-PG-512108	£144.34	JBO-RG-501975	£148.78	JBO-RG-500664	£148.78
M36	4	JBO-PG-512144	£155.91	JBO-RG-502011	£160.23	JBO-RG-500696	£160.23
M39	4	JBO-PG-512166	£172.06	JBO-RG-502039	£174.36	JBO-RG-500723	£174.36

METRIC COARSE THREAD GAUGES



## METRIC COARSE PLUG & RING THREAD GAUGES

- 6H plug gauges (Go/No-Go)
- 6g ring gauges (Go/No-Go)
- Right hand
- Calibrated versions available



Economy

M	Pitch mm	6H Plug Gauge		6g Ring Gauge			
		Order Code (Go/No-Go)	List Price	Order Code (Go)	List Price	Order Code (No-Go)	List Price
M2	0.4	4130-2	£27.78	4120-2	£56.39	4120-2N	£46.34
M2.2	0.45	4130-2D2	£31.57	4120-2D2	£48.71	4120-2D2N	£42.21
M2.5	0.45	4130-2D5	£27.31	4120-2D5	£47.88	4120-2D5N	£38.89
M3	0.5	4130-3	£27.31	4120-3	£45.17	4120-3N	£37.24
M3.5	0.6	4130-3D5	£40.67	4120-3D5	£42.32	4120-3D5N	£41.26
M4	0.7	4130-4	£28.38	4120-4	£42.32	4120-4N	£40.67
M5	0.8	4130-5	£28.38	4120-5	£42.32	4120-5N	£40.67
M6	1	4130-6	£28.38	4120-6	£37.83	4120-6N	£35.11
M7	1	4130-7	£28.61	4120-7	£37.83	4120-7N	£35.46
M8	1.25	4130-8	£28.38	4120-8	£37.83	4120-8N	£37.83
M9	1.25	4130-9	£28.61	4120-9	£37.83	4120-9N	£37.83
M10	1.5	4130-10	£32.28	4120-10	£43.86	4120-10N	£38.18
M11	1.5	4130-11	£32.98	4120-11	£44.57	4120-11N	£40.79
M12	1.75	4130-12	£36.77	4120-12	£38.89	4120-12N	£35.00
M14	2	4130-14	£38.78	4120-14	£43.39	4120-14N	£37.72
M16	2	4130-16	£38.89	4120-16	£43.39	4120-16N	£37.72
M18	2.5	4130-18	£42.09	4120-18	£49.42	4120-18N	£40.08
M20	2.5	4130-20	£42.09	4120-20	£49.77	4120-20N	£40.20
M22	2.5	4130-22	£43.03	4120-22	£49.77	4120-22N	£41.02
M24	3	4130-24	£51.19	4120-24	£63.84	4120-24N	£44.33
M27	3	4130-27	£51.19	4120-27	£63.13	4120-27N	£44.33
M30	3.5	4130-30	£59.11	4120-30	£87.13	4120-30N	£53.44
M36	4	4130-36	£82.05	4120-36	£110.43	4120-36N	£86.43
M42	4.5	4130-42	£82.76	4120-42	£133.59	4120-42N	£100.72
M48	5	4130-48	£118.22	4120-48	£186.80	4120-48N	£143.06



Premium

### METRIC FINE PLUG & RING THREAD GAUGES

- 6H plug gauges (Go/No-Go)
- 6g ring gauges (Go/No-Go)
- Right hand
- Calibrated versions available



M	Pitch mm	6H Plug Gauge		6g Ring Gauge			
		Order Code (Go/No-Go)	List Price	Order Code (Go)	List Price	Order Code (No-Go)	List Price
M2	0.25	JBO-PG-511872	£288.63	JBO-RG-501711	£384.99	JBO-RG-500416	£384.99
M3	0.35	JBO-PG-512054	£185.52	JBO-RG-501913	£115.49	JBO-RG-500607	£115.49
M3.5	0.35	JBO-PG-512069	£184.41	JBO-RG-501925	£111.36	JBO-RG-500617	£111.36
M4	0.5	JBO-PG-512195	£137.84	JBO-RG-502062	£95.22	JBO-RG-500745	£95.22
M5	0.5	JBO-PG-512238	£133.71	JBO-RG-502152	£95.22	JBO-RG-500836	£95.22
M6	0.5	JBO-PG-512271	£132.59	JBO-RG-502228	£96.18	JBO-RG-500910	£96.18
M6	0.75	JBO-PG-512277	£89.58	JBO-RG-502234	£72.86	JBO-RG-500916	£72.86
M7	0.5	JBO-PG-512292	£136.51	JBO-RG-502276	£100.45	JBO-RG-500953	£100.45
M7	0.75	JBO-PG-512295	£91.30	JBO-RG-502279	£88.10	JBO-RG-500957	£88.10
M8	0.75	JBO-PG-512326	£89.58	JBO-RG-502317	£75.66	JBO-RG-500998	£75.66
M8	1	JBO-PG-512331	£82.64	JBO-RG-502322	£69.30	JBO-RG-501003	£69.30
M10	0.75	JBO-PG-511659	£95.58	JBO-RG-501465	£84.88	JBO-RG-500174	£84.88
M10	1	JBO-PG-511663	£87.15	JBO-RG-501470	£77.35	JBO-RG-500179	£77.35
M12	1	JBO-PG-511703	£94.65	JBO-RG-501531	£87.90	JBO-RG-500239	£87.90
M12	1.25	JBO-PG-511711	£107.81	JBO-RG-501539	£115.49	JBO-RG-500246	£115.49
M12	1.5	JBO-PG-511716	£86.19	JBO-RG-501544	£83.20	JBO-RG-500250	£83.20
M14	1	JBO-PG-511745	£70.80	JBO-RG-501585	£94.65	JBO-RG-500292	£94.65
M14	1.5	JBO-PG-511755	£92.01	JBO-RG-501596	£88.63	JBO-RG-500301	£88.63
M16	1	JBO-PG-511792	£108.01	JBO-RG-501637	£103.67	JBO-RG-500343	£103.67
M16	1.5	JBO-PG-511802	£96.10	JBO-RG-501645	£96.69	JBO-RG-500351	£96.69
M18	1	JBO-PG-511829	£113.23	JBO-RG-501670	£114.17	JBO-RG-500377	£114.17
M18	1.5	JBO-PG-511835	£102.35	JBO-RG-501678	£104.21	JBO-RG-500385	£104.21
M18	2	JBO-PG-511843	£113.64	JBO-RG-501686	£124.32	JBO-RG-500394	£124.32
M20	1.5	JBO-PG-511918	£110.88	JBO-RG-501763	£115.32	JBO-RG-500464	£115.32
M20	2	JBO-PG-511923	£117.75	JBO-RG-501770	£123.20	JBO-RG-500471	£123.20
M22	1.5	JBO-PG-511948	£120.74	JBO-RG-501795	£123.20	JBO-RG-500491	£123.20
M22	2	JBO-PG-511955	£125.80	JBO-RG-501803	£131.07	JBO-RG-500499	£131.07
M24	1.5	JBO-PG-511976	£129.58	JBO-RG-501830	£130.88	JBO-RG-500524	£130.88
M24	2	JBO-PG-511981	£133.35	JBO-RG-501836	£136.71	JBO-RG-500529	£136.71
M26	1.5	JBO-PG-511997	£138.80	JBO-RG-501862	£141.59	JBO-RG-500553	£141.59
M26	2	JBO-PG-512003	£146.29	JBO-RG-501867	£149.32	JBO-RG-500558	£149.32
M28	1.5	JBO-PG-512028	£147.24	JBO-RG-501894	£149.66	JBO-RG-500587	£149.66
M28	2	JBO-PG-512032	£155.13	JBO-RG-501898	£157.79	JBO-RG-500591	£157.79



### METRIC FINE PLUG & RING THREAD GAUGES

- 6H plug gauges (Go/No-Go)
- 6g ring gauges (Go/No-Go)
- Right hand
- Calibrated versions available



Economy

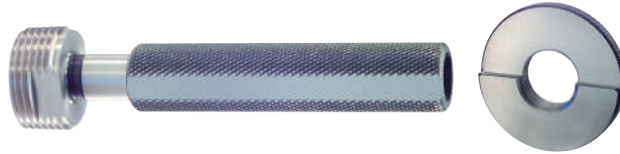
M	Pitch mm	6H Plug Gauge		6g Ring Gauge			
		Order Code (Go/No-Go)	List Price	Order Code (Go)	List Price	Order Code (No-Go)	List Price
M2	0.25	4139-2B	£33.45	4129-2B	£39.35	4129-2BN	£44.99
M3	0.35	4139-3D	£33.45	4129-3D	£55.57	4129-3DN	£46.81
M3.5	0.35	4139-3D5D	£38.31	4129-3D5D	£55.57	4129-3D5DN	£51.55
M4	0.5	4139-4G	£33.45	4129-4G	£49.66	4129-4GN	£43.39
M5	0.5	4139-5G	£35.46	4129-5G	£47.29	4129-5GN	£39.02
M6	0.5	4139-6G	£39.25	4129-6G	£48.36	4129-6GN	£39.37
M6	0.75	4139-6L	£37.12	4129-6L	£39.60	4129-6LN	£36.41
M7	0.75	4139-7L	£39.02	4129-7L	£41.74	4129-7LN	£39.25
M8	0.75	4139-8L	£39.25	4129-8L	£39.73	4129-8LN	£37.12
M8	1	4139-8P	£37.12	4129-8P	£39.60	4129-8PN	£36.41
M9	0.5	4139-9G	£41.61	4129-9G	£50.95	4129-9GN	£41.74
M10	0.75	4139-10L	£40.79	4129-10L	£48.83	4129-10LN	£40.20
M10	1	4139-10P	£38.89	4129-10P	£38.31	4129-10PN	£34.29
M10	1.25	4139-10Q	£38.89	4129-10Q	£40.44	4129-10QN	£37.72
M11	1	4139-11P	£40.90	4129-11P	£40.90	4129-11PN	£36.88
M12	0.5	4139-12G	£47.29	4129-12G	£48.83	4129-12GN	£50.37
M12	1	4139-12P	£43.39	4129-12P	£42.21	4129-12PN	£34.53
M12	1.25	4139-12Q	£41.14	4129-12Q	£42.21	4129-12QN	£32.87
M12	1.5	4139-12R	£41.14	4129-12R	£42.21	4129-12RN	£32.87
M14	1	4139-14P	£43.39	4129-14P	£49.30	4129-14PN	£42.32
M14	1.5	4139-14R	£41.02	4129-14R	£42.32	4129-14RN	£36.53
M16	1	4139-16P	£43.39	4129-16P	£49.30	4129-16PN	£43.03
M16	1.5	4139-16R	£41.02	4129-16R	£42.32	4129-16RN	£36.53
M18	1	4139-18P	£43.39	4129-18P	£57.45	4129-18PN	£47.41
M18	1.5	4139-18R	£43.39	4129-18R	£47.17	4129-18RN	£36.65
M20	1.5	4139-20R	£44.81	4129-20R	£46.81	4129-20RN	£43.51
M22	0.5	4139-22G	£54.97	4129-22G	£67.39	4129-22GN	£53.09
M22	1.5	4139-22R	£45.64	4129-22R	£48.12	4129-22RN	£44.33
M24	1.5	4139-24R	£48.60	4129-24R	£53.91	4129-24RN	£47.76
M24	2	4139-24T	£48.47	4129-24T	£58.52	4129-24TN	£44.33

METRIC FINE THREAD GAUGES



## NPT PLUG & RING THREAD GAUGES

- Right hand
- Calibrated versions available
- Gauge dimensions acc: ASME B1.20.1



Premium

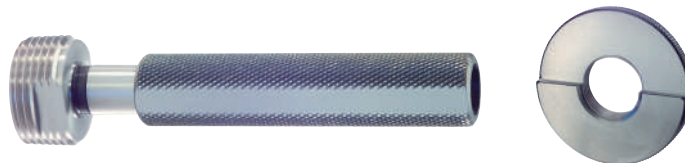
NPT	TPI	Plug Gauge	
		Order Code (Go/No-Go)	List Price
1/8"	27	JBO-PG-512505	£163.06
1/4"	18	JBO-PG-512504	£173.94
3/8"	18	JBO-PG-512510	£186.36
1/2"	14	JBO-PG-512503	£203.34
3/4"	14	JBO-PG-512509	£229.82
1"	11.5	JBO-PG-512499	£264.01
1 1/4"	11.5	JBO-PG-512501	£341.55
1 1/2"	11.5	JBO-PG-512500	£385.85
2"	11.5	JBO-PG-512506	£439.59
2 1/2"	8	JBO-PG-512507	£561.65
3"	8	JBO-PG-512508	£681.71
4"	8	JBO-PG-512511	£1,011.82

Ring Gauge		
Order Code (Go/No-Go)	List Price	
JBO-RG-502675	£269.66	
JBO-RG-502673	£275.97	
JBO-RG-502681	£290.12	
JBO-RG-502672	£315.84	
JBO-RG-502680	£344.42	
JBO-RG-502668	£390.16	
JBO-RG-502670	£457.31	
JBO-RG-502669	£504.49	
JBO-RG-502677	£596.98	
JBO-RG-502678	£704.55	
JBO-RG-502679	£901.78	
JBO-RG-502683	£1,481.98	



## NPTF PLUG & RING THREAD GAUGES

- Right hand
- Calibrated versions available
- Gauge dimensions acc: ASA B2.2



Premium

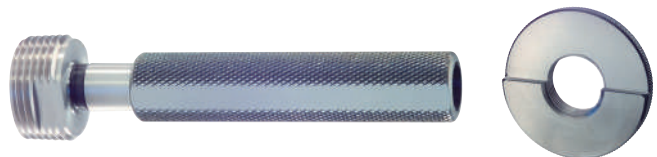
NPTF	TPI	Plug Gauge	
		Order Code (Go/No-Go)	List Price
1/8"	27	JBO-PG-512545	£255.76
1/4"	18	JBO-PG-512544	£273.24
3/8"	18	JBO-PG-512547	£293.93
1/2"	14	JBO-PG-512543	£319.31
3/4"	14	JBO-PG-512546	£355.88
1"	11.5	JBO-PG-512539	£411.44
1 1/4"	11.5	JBO-PG-512541	£497.25
1 1/2"	11.5	JBO-PG-512540	£562.36
2"	11.5	JBO-PG-513622	£548.03
2 1/2"	8	JBO-PG-517008	£818.16
3"	8	JBO-PG-517007	£994.50

Ring Gauge		
Order Code (Go/No-Go)	List Price	
JBO-RG-502700	£310.80	
JBO-RG-502699	£272.29	
JBO-RG-502702	£422.59	
JBO-RG-502698	£457.53	
JBO-RG-502701	£505.19	
JBO-RG-502697	£570.32	
JBO-RG-503479	£667.24	
JBO-RG-503480	£735.53	
JBO-RG-505713	£897.58	
JBO-RG-505885	£813.77	
JBO-RG-505886	£1,041.99	



## BSPT PLUG & RING THREAD GAUGES

- Right hand
- Calibrated versions available
- Gauge dimensions acc: ISO 7-2:2000 and DIN EN 10226-3



Premium

BSPT	TPI	Plug Gauge	
		Order Code (Go/No-Go)	List Price
1/8"	28	JBO-PG-514570	£211.22
1/4"	19	JBO-PG-514571	£223.51
3/8"	19	JBO-PG-514572	£242.26
1/2"	14	JBO-PG-514573	£262.38
3/4"	14	JBO-PG-514574	£292.98
1"	11	JBO-PG-514575	£344.42
1 1/4"	11	JBO-PG-514576	£410.16
1 1/2"	11	JBO-PG-514577	£463.04
2"	11	JBO-PG-514578	£567.35
2 1/2"	11	JBO-PG-514579	£667.42
3"	11	JBO-PG-517141	£791.72
4"	11	JBO-PG-516167	£1,117.58

Ring Gauge		
Order Code (Go/No-Go)	List Price	
JBO-RG-503880	£152.21	
JBO-RG-503881	£163.06	
JBO-RG-503882	£195.65	
JBO-RG-503883	£234.38	
JBO-RG-503884	£268.53	
JBO-RG-503885	£288.67	
JBO-RG-503886	£343.00	
JBO-RG-503887	£417.31	
JBO-RG-503888	£467.34	
JBO-RG-503889	£511.64	
JBO-RG-506024	£588.80	
JBO-RG-546002	£721.71	

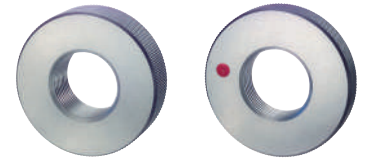
NPT / NPTF / BSPT THREAD GAUGES



Premium

## WHITWORTH PLUG & RING THREAD GAUGES

- BSW - Gauge dimensions acc: BS 919-2
- BSF - Gauge dimensions acc: BS 919-2
- BSP(G) - Gauge dimensions acc: DIN EN ISO 228-2
- Right hand
- Calibrated versions available



Plug Gauge			
BSW	TPI	Order Code (Go/No-Go)	List Price
1/8"	40	JBO-PG-512632	£127.47
3/16"	24	JBO-PG-512641	£89.05
1/4"	20	JBO-PG-512631	£90.44
5/16"	18	JBO-PG-512646	£88.32
3/8"	16	JBO-PG-512644	£89.89
7/16"	14	JBO-PG-512650	£93.91
1/2"	12	JBO-PG-512630	£99.50
9/16"	12	JBO-PG-512653	£108.46
5/8"	11	JBO-PG-512649	£113.05
3/4"	10	JBO-PG-512643	£129.20
7/8"	9	JBO-PG-512652	£146.06
1"	8	JBO-PG-512625	£169.36
1 1/8"	7	JBO-PG-513033	£188.93
1 1/4"	7	JBO-PG-512628	£202.20
1 3/8"	6	JBO-PG-516821	£224.96
1 1/2"	6	JBO-PG-512627	£247.65

Ring Gauge			
Order Code (Go)	List Price	Order Code (No-Go)	List Price
JBO-RG-502615	£110.79	JBO-RG-501273	£110.79
JBO-RG-502626	£81.87	JBO-RG-501280	£81.87
JBO-RG-502614	£78.73	JBO-RG-501272	£78.73
JBO-RG-502631	£85.02	JBO-RG-501285	£85.02
JBO-RG-502629	£89.05	JBO-RG-501283	£89.05
JBO-RG-502635	£93.91	JBO-RG-501288	£93.91
JBO-RG-502613	£99.50	JBO-RG-501271	£99.50
JBO-RG-502640	£111.77	JBO-RG-501293	£111.77
JBO-RG-502633	£119.46	JBO-RG-501287	£119.46
JBO-RG-502628	£131.63	JBO-RG-501282	£131.63
JBO-RG-502638	£151.63	JBO-RG-501291	£151.63
JBO-RG-502606	£170.08	JBO-RG-501263	£166.61
JBO-RG-502608	£188.93	JBO-RG-501266	£188.93
JBO-RG-503134	£206.96	JBO-RG-501265	£206.96
JBO-RG-502611	£228.08	JBO-RG-501269	£228.08
JBO-RG-503133	£247.65	JBO-RG-501264	£247.65

Plug Gauge			
BSF	TPI	Order Code (Go/No-Go)	List Price
3/16"	32	JBO-PG-513282	£145.35
7/32"	28	JBO-PG-520126	£155.84
1/4"	26	JBO-PG-512529	£107.06
9/32"	26	JBO-PG-520127	£155.84
5/16"	22	JBO-PG-513872	£135.06
3/8"	20	JBO-PG-513553	£110.39
7/16"	18	JBO-PG-518434	£153.95
1/2"	16	JBO-PG-512528	£152.81
9/16"	16	JBO-PG-514907	£168.41
5/8"	14	JBO-PG-520128	£171.59
11/16"	14	JBO-PG-513216	£217.66
3/4"	12	JBO-PG-512530	£192.23
7/8"	11	JBO-PG-516815	£216.04
1"	10	JBO-PG-512527	£197.75

Ring Gauge			
Order Code (Go)	List Price	Order Code (No-Go)	List Price
JBO-RG-540040	£135.06	JBO-RG-520239	£135.06
JBO-RG-520234	£145.35	JBO-RG-520240	£145.35
JBO-RG-502498	£98.94	JBO-RG-501168	£98.94
JBO-RG-520235	£145.35	JBO-RG-520241	£145.35
JBO-RG-502501	£131.07	JBO-RG-501170	£131.07
JBO-RG-502500	£126.50	JBO-RG-501169	£141.69
JBO-RG-520236	£114.40	JBO-RG-520242	£121.92
JBO-RG-502497	£157.13	JBO-RG-501167	£157.13
JBO-RG-507251	£174.74	JBO-RG-507252	£174.74
JBO-RG-520237	£179.51	JBO-RG-520243	£179.51
JBO-RG-520238	£216.04	JBO-RG-520244	£216.04
JBO-RG-502499	£201.77	JBO-RG-505546	£201.77
JBO-RG-540035	£227.20	JBO-RG-540017	£227.20
JBO-RG-502496	£260.54	JBO-RG-501166	£260.54

Plug Gauge			
BSP (G)	TPI	Order Code (Go/No-Go)	List Price
1/16"	28	JBO-PG-511577	£100.05
1/8"	28	JBO-PG-511589	£68.19
1/4"	19	JBO-PG-511584	£74.89
3/8"	19	JBO-PG-511597	£86.06
1/2"	14	JBO-PG-511578	£98.60
5/8"	14	JBO-PG-511601	£108.46
3/4"	14	JBO-PG-511593	£116.64
7/8"	14	JBO-PG-511602	£141.34
1"	11	JBO-PG-511573	£140.06
1 1/8"	11	JBO-PG-511576	£168.92

Ring Gauge			
Order Code (Go)	List Price	Order Code (No-Go)	List Price
JBO-RG-501361	£113.34	JBO-RG-500066	£113.34
JBO-RG-501376	£59.75	JBO-RG-500083	£59.75
JBO-RG-501371	£71.18	JBO-RG-500077	£72.50
JBO-RG-501399	£82.05	JBO-RG-500104	£82.05
JBO-RG-501362	£97.07	JBO-RG-500067	£97.07
JBO-RG-501408	£111.62	JBO-RG-500112	£111.62
JBO-RG-501391	£117.90	JBO-RG-500098	£117.90
JBO-RG-501414	£144.63	JBO-RG-500117	£144.63
JBO-RG-501337	£143.19	JBO-RG-500043	£143.19
JBO-RG-501358	£171.91	JBO-RG-500063	£171.91

WHITWORTH THREAD GAUGES



Premium

## UNC PLUG & RING THREAD GAUGES

- 2B plug gauges (Go/No-Go)
- 2A ring gauges (Go/No-Go)
- Right hand
- Calibrated versions available



UNC	TPI	2B Plug Gauge	
		Order Code (Go/No-Go)	List Price
No1	64	JBO-PG-512363	£130.48
No2	56	JBO-PG-512368	£98.60
No3	48	JBO-PG-512373	£98.60
No4	40	JBO-PG-512375	£87.69
No5	40	JBO-PG-512382	£83.89
No6	32	JBO-PG-512384	£70.18
No8	32	JBO-PG-512389	£66.59
No10	24	JBO-PG-512365	£65.32
No12	24	JBO-PG-512367	£70.63
1/4"	20	JBO-PG-512403	£65.74
5/16"	18	JBO-PG-512410	£63.74
3/8"	16	JBO-PG-512408	£65.61
7/16"	14	JBO-PG-512415	£71.18
1/2"	13	JBO-PG-512401	£73.04
9/16"	12	JBO-PG-512419	£79.20
5/8"	11	JBO-PG-512413	£81.62
3/4"	10	JBO-PG-512406	£93.03
7/8"	9	JBO-PG-512417	£108.19
1"	8	JBO-PG-512392	£114.87
1 1/8"	7	JBO-PG-512398	£138.62
1 1/4"	7	JBO-PG-512396	£148.36
1 1/2"	6	JBO-PG-512394	£192.92
1 3/8"	6	JBO-PG-512399	£173.66

2A Ring Gauge			
Order Code (Go)	List Price	Order Code (No-Go)	List Price
JBO-RG-502377	£109.88	JBO-RG-501051	£109.88
JBO-RG-502382	£87.34	JBO-RG-501057	£87.34
JBO-RG-502386	£100.05	JBO-RG-501061	£100.05
JBO-RG-502388	£76.61	JBO-RG-501063	£76.61
JBO-RG-502392	£70.04	JBO-RG-501066	£70.04
JBO-RG-502393	£59.75	JBO-RG-501067	£59.75
JBO-RG-502396	£56.31	JBO-RG-501070	£56.31
JBO-RG-502379	£54.06	JBO-RG-501053	£54.06
JBO-RG-505676	£59.48	JBO-RG-501055	£59.48
JBO-RG-502406	£52.76	JBO-RG-501080	£49.12
JBO-RG-502416	£56.04	JBO-RG-501088	£56.04
JBO-RG-502413	£61.16	JBO-RG-501085	£61.16
JBO-RG-502421	£66.47	JBO-RG-501093	£66.47
JBO-RG-502404	£73.04	JBO-RG-501078	£73.04
JBO-RG-502425	£80.33	JBO-RG-501097	£80.33
JBO-RG-502419	£85.91	JBO-RG-501091	£85.91
JBO-RG-502411	£101.03	JBO-RG-501083	£101.03
JBO-RG-502423	£123.49	JBO-RG-501095	£123.49
JBO-RG-502398	£134.48	JBO-RG-501072	£125.21
JBO-RG-502401	£158.62	JBO-RG-501075	£140.84
JBO-RG-502400	£172.95	JBO-RG-501074	£172.95
JBO-RG-502399	£183.00	JBO-RG-501073	£183.00
JBO-RG-502403	£193.08	JBO-RG-501077	£193.08

UNC THREAD GAUGES



## UNC PLUG & RING THREAD GAUGES

Economy

- 2B plug gauges (Go/No-Go)
- 2A ring gauges (Go/No-Go)
- Right hand
- Calibrated versions available



UNC	TPI	2B Plug Gauge	
		Order Code (Go/No-Go)	List Price
No4	40	4131-41	£53.44
No6	32	4131-61	£49.18
No8	32	4131-81	£49.18
1/4"	20	4131-1B1	£48.60
5/16"	18	4131-5D1	£48.71
3/8"	16	4131-3C1	£53.44
1/2"	13	4131-1A1	£57.81
5/8"	11	4131-5C1	£75.19
3/4"	10	4131-3B1	£76.02

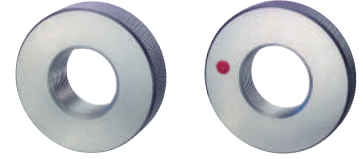
2A Ring Gauge			
Order Code (Go)	List Price	Order Code (No-Go)	List Price
4121-41	£51.90	4121-41N	£37.48
4121-61	£47.29	4121-61N	£35.00
4121-81	£47.29	4121-81N	£35.00
4121-1B1	£47.29	4121-1B1N	£35.11
4121-5D1	£43.03	4121-5D1N	£32.04
4121-3C1	£43.03	4121-3C1N	£32.04
4121-1A1	£50.95	4121-1A1N	£37.24
4121-5C1	£67.98	4121-5C1N	£47.88
4121-3B1	£68.57	4121-3B1N	£48.83



Premium

## UNF PLUG & RING THREAD GAUGES

- 2B plug gauges (Go/No-Go)
- 2A ring gauges (Go/No-Go)
- Right hand
- Calibrated versions available



UNF	TPI	2B Plug Gauge	
		Order Code (Go/No-Go)	List Price
No0	80	JBO-PG-512421	£163.62
No1	72	JBO-PG-512424	£143.92
No2	64	JBO-PG-512432	£160.46
No3	56	JBO-PG-512434	£150.45
No4	48	JBO-PG-512436	£131.07
No5	44	JBO-PG-512438	£116.77
No6	40	JBO-PG-512440	£77.92
No8	36	JBO-PG-512442	£92.94
No10	32	JBO-PG-512426	£80.61
No12	28	JBO-PG-512431	£93.58
1/4"	28	JBO-PG-512456	£83.85
5/16"	24	JBO-PG-512466	£84.37
3/8"	24	JBO-PG-512462	£86.98
7/16"	20	JBO-PG-512472	£90.56
1/2"	20	JBO-PG-512454	£96.40
9/16"	18	JBO-PG-512478	£102.76
5/8"	18	JBO-PG-512469	£108.03
3/4"	16	JBO-PG-512460	£114.74
7/8"	14	JBO-PG-512476	£136.43
1"	12	JBO-PG-512444	£150.53
1 1/8"	12	JBO-PG-512451	£171.59
1 1/4"	12	JBO-PG-512449	£175.77
1 3/8"	12	JBO-PG-512453	£203.35
1 1/2"	12	JBO-PG-512446	£225.59

2A Ring Gauge			
Order Code (Go)	List Price	Order Code (No-Go)	List Price
JBO-RG-502426	£169.97	JBO-RG-501099	£169.97
JBO-RG-502428	£141.86	JBO-RG-501101	£141.86
JBO-RG-502436	£141.69	JBO-RG-501108	£141.69
JBO-RG-502438	£141.22	JBO-RG-501110	£141.22
JBO-RG-502440	£125.02	JBO-RG-501112	£125.02
JBO-RG-502442	£100.26	JBO-RG-501114	£100.26
JBO-RG-502444	£96.58	JBO-RG-501116	£96.58
JBO-RG-502446	£89.29	JBO-RG-501118	£89.29
JBO-RG-502430	£70.98	JBO-RG-501103	£70.83
JBO-RG-502433	£62.49	JBO-RG-501106	£62.49
JBO-RG-502458	£69.72	JBO-RG-501130	£67.05
JBO-RG-502469	£73.93	JBO-RG-501140	£74.80
JBO-RG-502466	£79.65	JBO-RG-501137	£78.62
JBO-RG-502475	£69.08	JBO-RG-501146	£87.22
JBO-RG-502455	£93.25	JBO-RG-501127	£76.74
JBO-RG-502481	£104.21	JBO-RG-501152	£104.21
JBO-RG-502472	£91.30	JBO-RG-501143	£91.30
JBO-RG-502461	£132.95	JBO-RG-501133	£130.07
JBO-RG-502478	£156.63	JBO-RG-501149	£157.60
JBO-RG-502448	£127.45	JBO-RG-501120	£127.45
JBO-RG-502453	£198.58	JBO-RG-501125	£198.58
JBO-RG-502452	£216.04	JBO-RG-501124	£216.04
JBO-RG-502454	£236.70	JBO-RG-501126	£236.70
JBO-RG-502451	£251.00	JBO-RG-501123	£251.00

# Calibration

We offer both independent UKAS accredited calibration and JBO's manufacturer level calibration across our thread gauge range.



## UKAS Calibration

Performed by an independent UKAS-accredited laboratory to confirm exact measurements, in line with strict national quality standards.

## JBO Manufacturers Calibration

High quality, manufacturer-level calibration performed by JBO to confirm the gauge is manufactured to specification in accordance with internal standards.

To enquire about calibrated thread gauges, please call **03330 389849** or email [sales@cutwel.net](mailto:sales@cutwel.net).

UNF THREAD GAUGES



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