



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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Tools in UK stock

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Dispatch accuracy

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



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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.

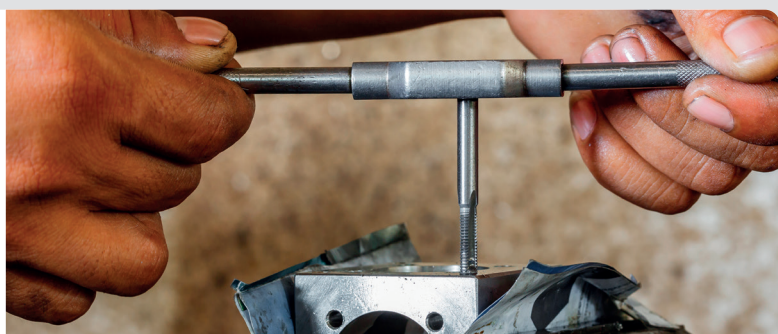
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Hand Taps

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.

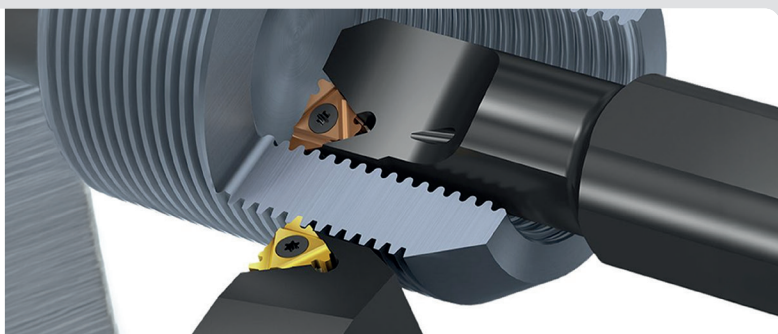
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Thread Turning

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

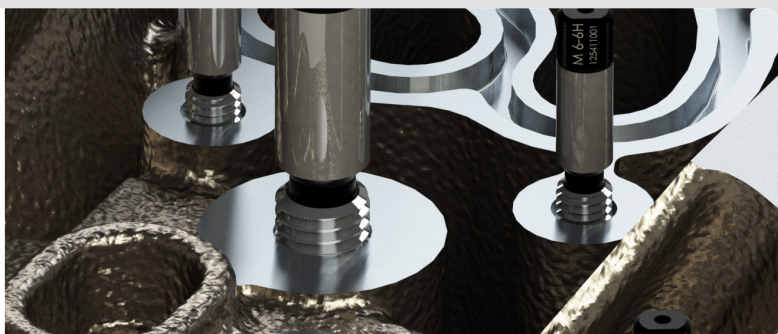
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Thread Gauges

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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	BSW Whitworth B.S.84 1956, DIN 259 - Helical Flutes For steel, stainless steel, HRSA's, aluminium & cast iron up to HRC45.	17
	BSPT British Standard Pipe Taper (B.S.21:1985) - Helical Flutes For steel, stainless steel, HRSA's, aluminium & cast iron up to HRC45.	18
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VARDEX



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

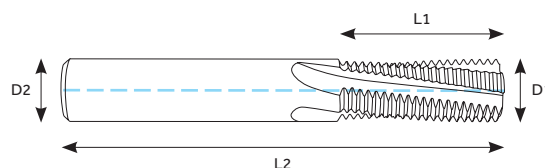
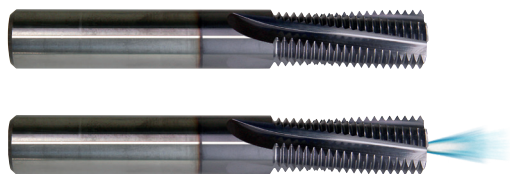
We partner with Vargus to help the customer achieve:

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

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 Standard	Order Code	
							Solid (Standard)	Through Coolant
Internal								
M4	0.7	3.1	6	8	54	3	CTM-METHF03T	CTM-METHF03TCF
M5	0.8	4	6	12	54	3	CTM-METHF00T	CTM-METHF00TCF
MF6	0.5	4.5	6	12	54	3	CTM-METHF27T	CTM-METHF27TCF
MF6	0.75	4.5	6	12	54	3	CTM-METHF01T	CTM-METHF01TCF
M6, M7	1	4.5	6	12	54	3	CTM-METHF02T	CTM-METHF02TCF
MF8	0.5	6	6	12	54	3	CTM-METHF07T	CTM-METHF07TCF
MF8	0.75	6	6	15	54	3	CTM-METHF04T	CTM-METHF04TCF
MF8	1	6	6	15	54	3	CTM-METHF05T	CTM-METHF05TCF
M8, M9	1.25	6	6	15	54	3	CTM-METHF06T	CTM-METHF06TCF
MF10	0.5	8	8	20	65	3	CTM-METHF13T	CTM-METHF13TCF
MF10	0.75	8	8	20	65	3	CTM-METHF08T	CTM-METHF08TCF
MF10	1	8	8	20	65	3	CTM-METHF09T	CTM-METHF09TCF
MF10, MF12	1.25	8	8	20	65	3	CTM-METHF10T	CTM-METHF10TCF
M10, M11, MF12	1.5	8	8	20	65	3	CTM-METHF11T	CTM-METHF11TCF
M12	1.75	8	8	20	65	3	CTM-METHF12T	CTM-METHF12TCF
MF12	0.5	10	10	25	80	4	CTM-METHF18T	CTM-METHF18TCF
MF12	1	10	10	25	80	4	CTM-METHF14T	CTM-METHF14TCF
MF14	1.25	10	10	25	80	4	CTM-METHF15T	CTM-METHF15TCF
MF14	1.5	10	10	25	80	4	CTM-METHF16T	CTM-METHF16TCF
M14	2	10	10	25	80	4	CTM-METHF17T	CTM-METHF17TCF
MF14	0.5	12	12	30	82	4	CTM-METHF22T	CTM-METHF22TCF
MF14	1	12	12	30	82	4	CTM-METHF19T	CTM-METHF19TCF
MF16	1.5	12	12	30	82	4	CTM-METHF20T	CTM-METHF20TCF
M16	2	12	12	30	82	4	CTM-METHF21T	CTM-METHF21TCF
MF16	1	14	14	35	100	4	CTM-METHF23T	CTM-METHF23TCF
MF18	1.5	14	14	35	100	4	CTM-METHF24T	CTM-METHF24TCF
MF18	2	14	14	35	100	4	CTM-METHF25T	CTM-METHF25TCF
M18	2.5	14	14	35	100	4	CTM-METHF26T	CTM-METHF26TCF
MF18, MF20	1	16	16	40	100	5	CTM-METHF28T	CTM-METHF28TCF
MF20, MF22	1.5	16	16	40	100	5	CTM-METHF29T	CTM-METHF29TCF
MF20, MF22	2	16	16	40	100	5	CTM-METHF30T	CTM-METHF30TCF
M20, M22	2.5	16	16	40	100	5	CTM-METHF31T	CTM-METHF31TCF
MF22>	1	20	20	40	110	5	CTM-METHF33T	CTM-METHF33TCF
MF24>	1.5	20	20	40	110	5	CTM-METHF34T	CTM-METHF34TCF
MF24>	2	20	20	40	110	5	CTM-METHF35T	CTM-METHF35TCF
M24	3	20	20	40	110	5	CTM-METHF36T	CTM-METHF36TCF
M30	2.5	25	25	78	155	5	CTM-METHF40T	CTM-METHF40TCF
M36, M42	4	25	25	78	155	5	CTM-METHF38T	CTM-METHF38TCF
External 2xD Max Depth								
M6x1.0	1	8	64	20	8	3	CTM-METHFEX17T	-
M8x1.25	1.25	10	79	25	10	4	CTM-METHFEX19T	-
M10x1.5	1.5	12	81	30	12	4	CTM-METHFEX21T	-
M12x1.75	1.75	14	99	35	14	4	CTM-METHFEX23T	-
M14x2.0	2	16	99	40	16	5	CTM-METHFEX25T	-
M20-M22x2.5	2.5	18	109	40	18	5	CTM-METHFEX27T	-
M24x3.0	3	20	109	40	20	5	CTM-METHFEX29T	-

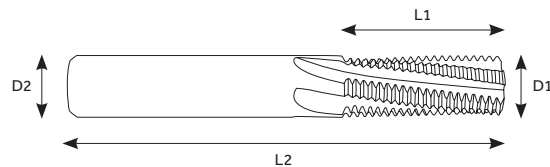
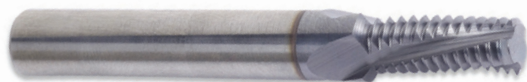
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Buy 3 Get 1 Free on all Vardex Thread Mills
 Valid until 31/12/2026

METRIC (DIN 13) THREAD MILLS - HELICAL FLUTES

Premium Vardex Thread Mills For High Performance Applications

- 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

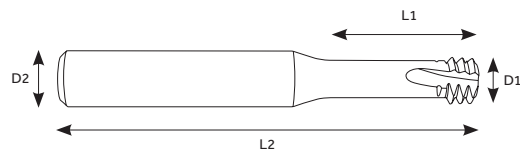
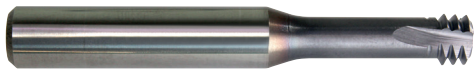


Thread	Pitch mm	D1	D2	L1	L2	No. of Flutes	Order Code
Internal 2xD Max Depth (Solid)							
M3, MF3.5	0.5	2.2	4	6	45	3	101-00027
MF4	0.5	3	4	8	45	3	101-00028
MF5>	0.5	3.9	4	10	45	3	101-00029
M4	0.7	2.8	4	8.4	45	3	101-00025
MF6	0.75	3.9	4	12	45	3	101-00026
M5	0.8	3.5	4	10.4	45	3	101-00006
M6	1	3.9	4	12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

cutwel PRO**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

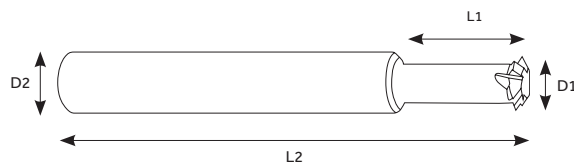


Thread	Pitch mm	D1	D2	L1	L2	No. of Flutes		Order code	
						Standard	Hardened Steel	Solid (Standard)	Hardened Steel
Internal 2xD Max Depth									
M1.2	0.25	0.9	3	3	39	3	4	CTM-MET3T01T	-
M1.6	0.35	1.2	3	4.5	39	3	4	CTM-MET3T04T	-
M2	0.4	1.55	3	4.5	39	3	4	CTM-MET3T03T	CTM-MET3T03HS
M2.5	0.45	1.65	6	5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

cutwel PRO**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
M6, MF8	1	4.1	8	19	63	3	CTM-METLR03T
M8	1.25	5.8	10	26	73	3	CTM-METLR05T
M10	1.5	7.7	10	32	73	3	CTM-METLR07T
MF12	1.5	9.4	12	38	83	4	CTM-METLR09T
M12	1.75	8.7	12	38	83	4	CTM-METLR11T
M14	2	10.2	16	44	92	4	CTM-METLR13T
M16	2	12.2	16	50	100	4	CTM-METLR15T
M18	2.5	12.9	16	57	108	5	CTM-METLR17T
M20	2.5	14.8	16	63	114	5	CTM-METLR19T

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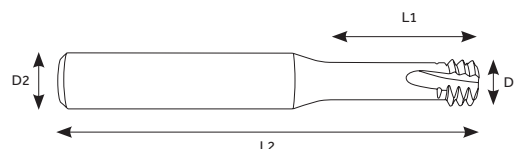
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Vardex Thread Mills

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

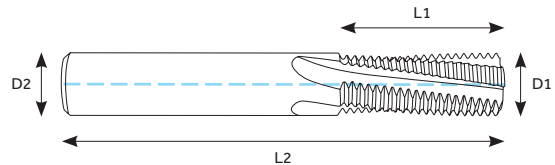
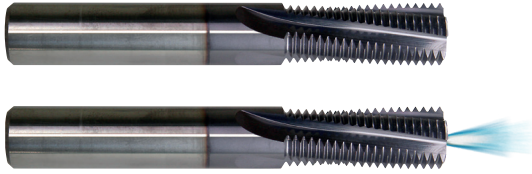


Thread	Pitch mm	D1	D2	L1	L2	Order Code
Internal 2xD Max Depth						
M1.6	0.35	1.2	3	3.4	30	102-80420
M2	0.4	1.55	6	4.2	57	102-80254
M2.2	0.45	1.65	6	4.6	57	102-80255
M2.5	0.45	1.95	6	5.2	57	102-80256
M3, MF3.5>	0.5	2.4	6	6.2	57	102-80257
M3.5	0.6	2.75	6	7.3	57	102-80258
M4	0.7	3.15	6	8.3	57	102-80259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

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

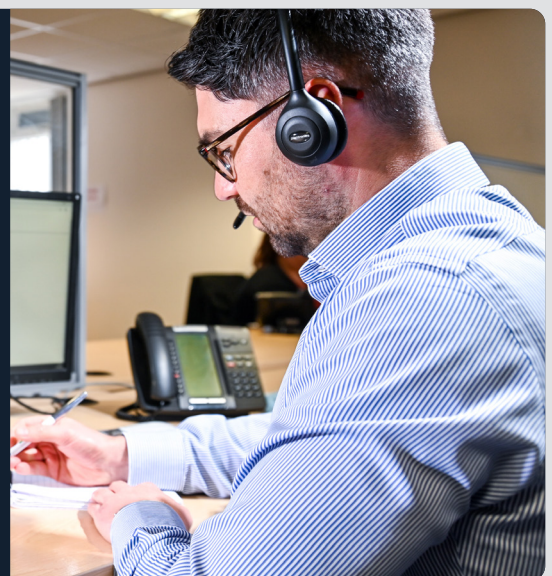


Thread	TPI	D1	D2	L1	L2	No. of Flutes	Order Code	
							Solid	Through Coolant
1/4" UNF	28	4.5	6	12	54	3	CTM-UNHF03T	CTM-UNHF03TCF
1/4" UNC	20	4.5	6	12	54	3	CTM-UNHF01T	CTM-UNHF01TCF
5/16" UNF	24	5.5	6	15	54	3	CTM-UNHF09T	CTM-UNHF09TCF
5/16" UNC	18	5.5	6	15	54	3	CTM-UNHF07T	CTM-UNHF07TCF
3/8" UNF	16	7.5	8	20	65	3	CTM-UNHF05T	CTM-UNHF05TCF
3/8" UNC	24	8	8	20	65	3	CTM-UNHF15T	CTM-UNHF15TCF
7/16" UNF	20	8	8	20	65	3	CTM-UNHF13T	CTM-UNHF13TCF
7/16" UNC	14	8	8	20	65	3	CTM-UNHF11T	CTM-UNHF11TCF
1/2" UNF	20	10	10	25	80	4	CTM-UNHF23T	CTM-UNHF23TCF
9/16" UNF	18	10	10	25	80	4	CTM-UNHF21T	CTM-UNHF21TCF
1/2" UNC	13	10	10	25	80	4	CTM-UNHF19T	CTM-UNHF19TCF
9/16" UNC	12	10	10	25	80	4	CTM-UNHF17T	CTM-UNHF17TCF
5/8" UNF	18	12	12	30	82	4	CTM-UNHF25T	CTM-UNHF25TCF
5/8" UNC	11	12	12	30	82	4	CTM-UNHF27T	CTM-UNHF27TCF
3/4" UNF	16	15.5	16	40	100	5	CTM-UNHF29T	CTM-UNHF29TCF
7/8" UNF	14	15.5	16	40	100	5	CTM-UNHF33T	CTM-UNHF33TCF
3/4" UNC	10	15.5	16	40	100	5	CTM-UNHF31T	CTM-UNHF31TCF
7/8" UNC	9	18	18	40	110	5	CTM-UNHF37T	CTM-UNHF37TCF
1" UNF	12	20	20	40	110	5	CTM-UNHF41T	CTM-UNHF41TCF
1" UNC	8	20	20	40	110	5	CTM-UNHF39T	CTM-UNHF39TCF

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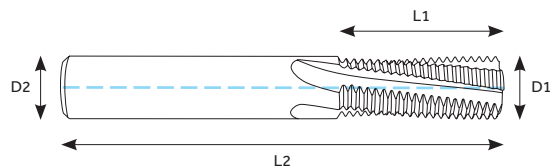
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Premium Vardex Thread Mills For High Performance Applications

- 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

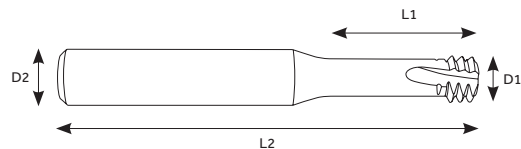


UNC	Thread UNF	UNEF	TPI	D1	D2	L1	L2	No. of Flutes	Order Code
Internal 2xD Max Depth (Solid)									
-	No.8 UNF	-	36	3	4	8.5	45	3	101-00053
-	No.10 UNF	No.12-3/8" UNEF	32	3.3	4	11.1	45	3	101-00052
-	No.12, 1/4" UNF	7/16", 1/2" UNEF	28	3.8	4	11.8	45	3	101-00050
-	1/4" UNF	7/16", 1/2" UNEF	28	4.6	6	12.7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

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

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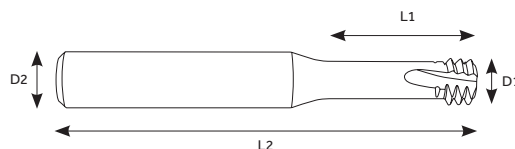
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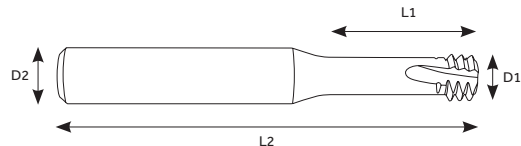
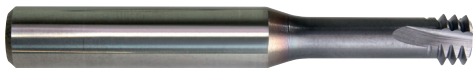


Thread		TPI	D1	D2	L1	L2	No. of Flutes	Order Code
UNC	UNF							
Internal 2xD Max Depth (Solid)								
-	No.1 UNF	72	1.45	6	3.9	57	3	102-00014
No.1 UNC	No.2 UNF	64	1.4	6	4.2	57		102-00012
No.2 UNC	No.3 UNF	56	1.65	6	5	57		102-00015
No.3 UNC	No.4 UNF	48	1.9	6	6	57		102-00017
No.4, No.5 UNC	No.6 UNF	40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

cutwel PRO**UNJ UNIFIED NATIONAL (MIL-S-8879C) THREAD MILLS - MINIATURE 3 TOOTH**

Cost Effective Solution For Everyday Thread Milling Operations

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

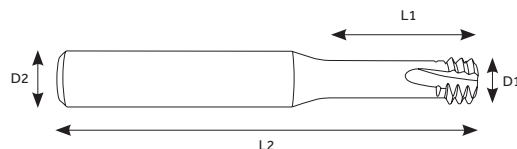
VARDEX**UNJ UNIFIED NATIONAL (MIL-S-8879C) THREAD MILLS - MINIATURE 3 TOOTH MILLIPRO**

Premium Vardex Thread Mills For High Performance Applications

- TiAlN coated carbide thread mills
- Suitable for right and left hand internal threads
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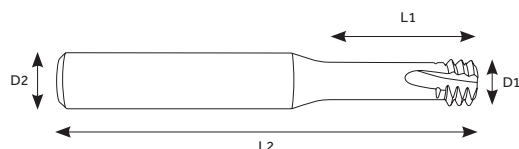


UNJC	Thread UNJF	TPI	D1	D2	L1	L2	No. of Flutes	Order Code
No.6 UNJC	No.10 UNJF	32	2.7	6	11	57	3	102-00083
-	No.12, 1/4 UNJF	28	5.4	6	19.5	57		102-00084
No.10 UNJC	-	24	3.7	6	14.9	57		102-00085
-	5/16 UNJF	24	6.7	8	24.1	63		102-00086
1/4 UNJC	-	20	5	6	19.5	57		102-00087
-	7/16" UNJF	20	9.6	10	33.5	73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

cutwel **PRO****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
MJ 3	0.5	2.35	6	6.5	54	3	CTM-MJ3T01T
MJ 4	0.7	3.1	6	9	54	3	CTM-MJ3T05T
MJ 5	0.8	3.8	6	12.5	54	3	CTM-MJ3T07T
MJ 6	1	4.65	6	14	54	3	CTM-MJ3T09T
MJ 8	1.25	5.95	6	18	54	3	CTM-MJ3T11T
MJ 10	1.5	7.8	8	23	64	3	CTM-MJ3T13T
MJ 12	1.75	9	10	26	73	3	CTM-MJ3T15T
MJ 14	2	10.4	12	35	80	4	CTM-MJ3T17T
MJ 16	2	11.8	12	35	80	4	CTM-MJ3T19T

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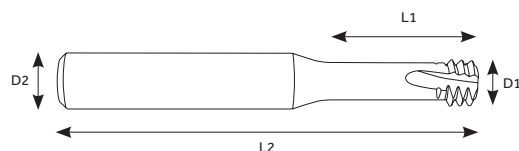
MJ METRIC (DIN ISO 5855) THREAD MILLS - MINIATURE 3 TOOTH MILLIPRO

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- TiAlN coated carbide thread mills
- Suitable for internal right and left hand threads
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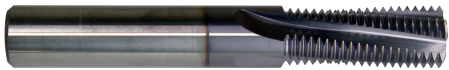
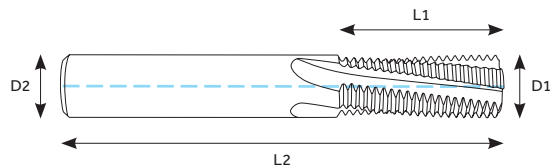


Thread MJ	Pitch mm	D1	D2	L1	L2	No. of Flutes	Order Code
MJ 3	0.5	2.4	6	9.2	57	3	102-00074
MJ 3.5	0.6	2.85	6	11	57	3	102-00075
MJ 4	0.7	3.15	6	12.3	57	3	102-00076
MJ 5	0.8	4.05	6	15.4	57	3	102-00077
MJ 6	1	4.8	6	18.5	57	3	102-00078
MJ 8	1.25	6.5	8	24.6	63	3	102-00079
MJ 10	1.5	8.2	10	30.8	73	3	102-00080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

cutwel PRO**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

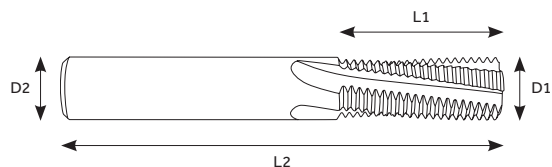
Solid**Through Coolant**

Thread	Pitch TPI	D1	D2	L1	L2	No. of Flutes	Order Code	
							Standard	Through Coolant
1/8" BSP	28	8	8	20	65	3	CTM-BSPHF01T	CTM-BSPHF01TCF
1/4" BSP	19	10	10	25	80	4	CTM-BSPHF03T	CTM-BSPHF03TCF
3/8" BSP	19	14	14	14	35	4	CTM-BSPHF05T	CTM-BSPHF05TCF
1/2" BSP	14	16	16	16	40	5	CTM-BSPHF07T	CTM-BSPHF07TCF
5/8" BSP	14	20	20	20	40	5	CTM-BSPHF09T	CTM-BSPHF09TCF
1" BSP	11	20	20	20	40	5	CTM-BSPHF11T	CTM-BSPHF11TCF

VARDEX**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



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

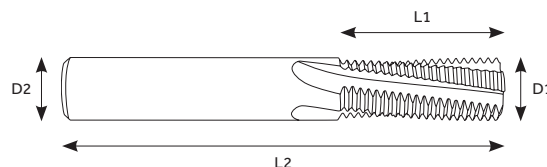
**Buy 3 Get 1 Free on all
Vardex Thread Mills**

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cutwel **PRO****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
1/4" BSF	26	5	6	13.2	57	3	CTM-BSWHF01T
5/16" BSF	26	6.35	8	16.2	61	3	CTM-BSWHF03T
1/4" BSW, 3/8" BSF	20	4.45	6	13.3	57	3	CTM-BSWHF05T
5/16" BSW, 7/16" BSF	18	5.85	6	16.2	57	3	CTM-BSWHF09T
3/8" BSW, 1/2" BSF, 9/16" BSF	16	7.2	8	61	19.8	3	CTM-BSWHF13T
7/16" BSW, 5/8" BSF, 11/16" BSF	14	8.5	10	73	22.7	3	CTM-BSWHF19T
1/2" BSW	12	9.65	10	73	26.5	3	CTM-BSWHF25T
9/16" BSW, 3/4" BSF	12	11.25	12	80	28.6	4	CTM-BSWHF27T
5/8" BSW, 11/16" BSW, 7/8" BSF	11	12.6	14	92	33.5	4	CTM-BSWHF31T

VARDEX

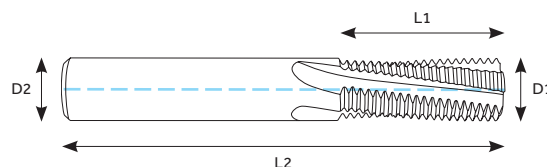
**BSW/BSF WHITWORTH (B.S.84 1956, DIN 259) THREAD MILLS
HELICAL FLUTES**

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**

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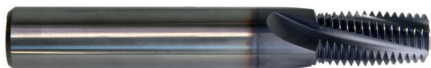
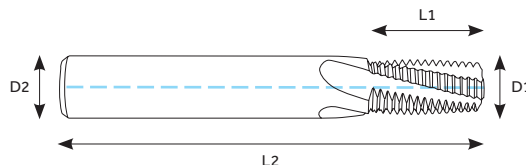
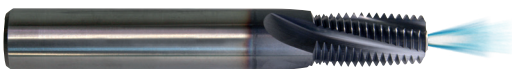


Thread		TPI	D1	D2	L1	L2	No. of Flutes	Order Code
BSW	BSF							
-	1/4"x26 BSF	26	5	6	13.2	57	3	104-00097
-	5/16"x22 BSF	22	6.35	8	16.7	61	3	104-00098
1/4"x20 BSW	3/8"x20 BSF	20	4.45	6	13.3	57	3	104-00099
-	3/8"x20 BSF	20	7.65	8	19.7	61	3	104-00100
5/16"x18 BSW	7/16"x18 BSF	18	5.85	6	16.2	57	3	104-00101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

cutwel PRO**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

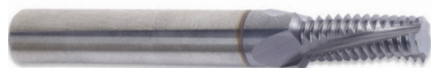
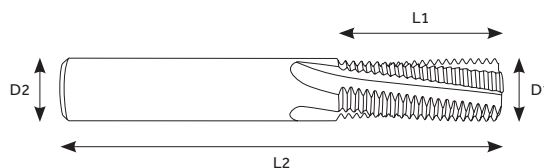
Solid**Through Coolant**

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

VARDEX**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**

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

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

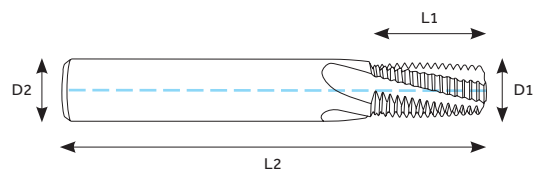
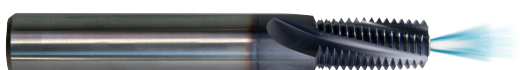
Cost Effective Solution For Everyday Thread Milling Operations

- 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



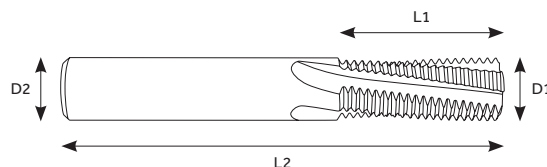
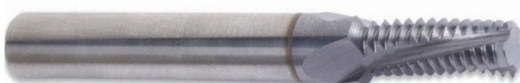
Thread Size	TPI	D1	D2	L1	L2	No. of Flutes	Order Code	
							Solid	Through Coolant
NPT Internal / External								
1/16"	27	5.90	8	9.88	55	3	CTM-NPTHF01T	CTM-NPTHF01TCF
1/8"	27	7.65	8	9.88	55	3	CTM-NPTHF03T	CTM-NPTHF03TCF
1/4"	18	10.15	12	14.82	75	4	CTM-NPTHF05T	CTM-NPTHF05TCF
3/8"	18	11.15	12	14.82	75	4	CTM-NPTHF07T	CTM-NPTHF07TCF
1/2"	14	14.25	16	19.05	80	4	CTM-NPTHF09T	CTM-NPTHF09TCF
1"	11.5	19.60	20	23.19	90	5	CTM-NPTHF11T	CTM-NPTHF11TCF
NPTF Internal / External								
1/16"	27	5.90	8	9.88	55	3	CTM-NPTFHF01T	-
1/8"	27	7.65	8	9.88	55	3	CTM-NPTFHF03T	-
1/4"	18	10.15	12	14.82	75	4	CTM-NPTFHF05T	-
3/8"	18	11.15	12	14.82	75	4	CTM-NPTFHF07T	-
1/2"	14	14.25	16	19.05	80	4	CTM-NPTFHF09T	-
1"	11.5	19.60	20	23.19	90	5	CTM-NPTFHF11T	-

VARDEX

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

Premium Vardex Thread Mills For High Performance Applications

- TiAlN coated carbide thread mills

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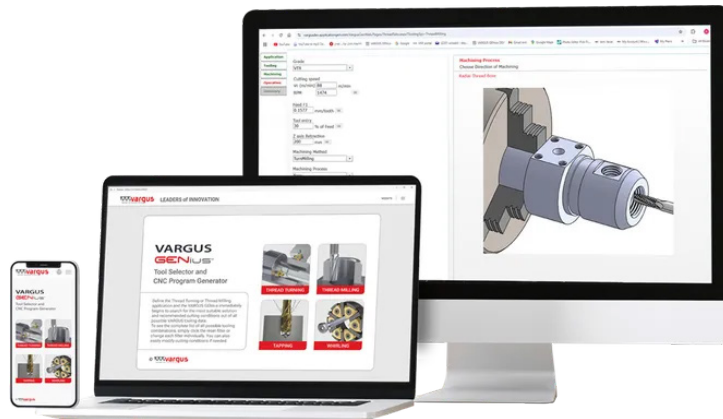
Thread Size	TPI	D1	D2	L1	L2	No. of Flutes	Order Code
NPT Internal / External							
1/16"	27	5.3	6	9.4	57	3	101-00075
1/8"	27	7.5	8	9.4	63	4	101-00076
1/4"	18	9.4	10	14.1	73	4	101-00077
3/8"	18	11.9	12	14.1	83	4	101-00078
1/2"	14	15.5	16	25.4	92	5	101-00079
1"	11.5	19.9	20	33.1	104	5	101-00080
2 1/2"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

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
		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.

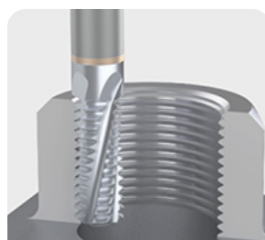
It reduces setup time, improves machining accuracy and consistency, and increases productivity while minimising programming and tooling selection errors.



Find out More



Thread Turning



Thread Milling



Tapping



Whirling

Machine Taps

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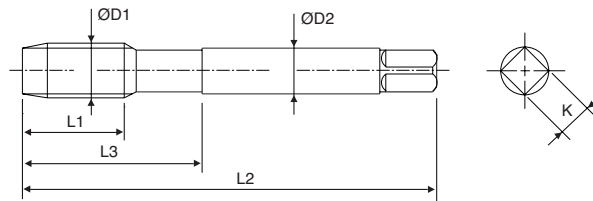
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- COMBO tap** - 1st choice for general tapping with exceptional reliability
- PRIME X tap** - advanced geometry & powder metal substrate for higher speed tapping, enhanced tool life and best performance on steel & stainless steel
- Spiral flute for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



ØD1	Pitch	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Series				Order Code
									Brand / Geometry	Substrate	Surface Treatment	Tolerance	
M2	0.4	8	45	13	2.8	2.1	3	1.6	TC804	TD804	TRE30	TRE39	
M2.5	0.45	9	50	15	2.8	2.1	3	2.05	YG - Combo Tap	YG - Combo Tap	YG - Prime X	YG - Prime X Coolant	
M3	0.5	11	56	18	3.5	2.7	3	2.5	HSS 5% Cobalt	HSS 5% Cobalt	HSS Powder Metal	HSS Powder Metal	
M3.5	0.6	12	56	20	4	3	3	2.9	Bright	TIN Coated	X-Coated	X-Coated	
M4	0.7	13	63	21	4.5	3.4	3	3.3	6H	6H	6HX	6HX	
M4.5	0.75	14	70	25	6	4.9	3	3.7	R40°	R40°	R45°	R45°	
M5	0.8	15	70	25	6	4.9	3	4.2	Form C: 2-3	Form C: 2-3	Form C: 2-3	Form C: 2-3	
M6	1	17	80	30	6	4.9	3	5	2.5xD	2.5xD	2.5xD	2.5xD	
M7	1	17	80	30	7	5.5	3	6	-	-	-	-	
M8	1.25	20	90	35	8	6.2	3	6.8	-	-	-	-	
M10	1.5	22	100	39	10	8	3	8.5	-	-	-	-	
M12	1.75	24	110	44	9	7	3	10.2	-	-	-	-	
M14	2	26	110	44	11	9	3	12	-	-	-	-	
M16	2	27	110	44	12	9	3	14	-	-	-	-	
M18	2.5	30	125	50	14	11	4	15.5	-	-	-	-	
M20	2.5	32	140	54	16	12	4	17.5	-	-	-	-	
M22	2.5	32	140	54	18	14.5	4	19.5	-	-	-	-	
M24	3	34	160	60	18	14.5	4	21	-	-	-	-	
M27	3	36	160	60	20	16	4	24	-	-	-	-	
M30	3.5	40	180	70	22	18	4	26.5	-	-	-	-	
M33	3.5	34	160	60	18	14.5	4	21	-	-	-	-	
M36	4	36	160	60	20	16	4	24	-	-	-	-	
M39	4	40	180	70	22	18	4	26.5	-	-	-	-	
M42	4.5	40	180	70	25	20	4	29.5	-	-	-	-	
M45	4.5	50	200	80	28	22	4	32	-	-	-	-	
M48	5	50	200	80	32	24	4	35	-	-	-	-	
M52	5	56	200	85	32	24	4	37.5	-	-	-	-	

Material Applications N/mm² Cutting Speed m/min

● Excellent ○ Good

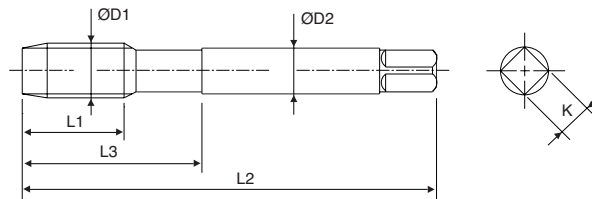
Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels		Carbon	Alloy	Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/ Graphite		Ti	Ti Alloy	
	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
TC804	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	Thermo	Thermoset	CFRP/GFRP	
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%			
TC804	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%			
TD804	-	8-12	-	-	8-12	25-35	15-20	-	-	25-35	15-20	10-15	-	-	-
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



ØD1	Pitch	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Series				Order Code			
									Brand / Geometry	Substrate	Surface Treatment	Tolerance	Helix Angle	Chamfer Lead	Maximum Depth	Through Coolant
M2	0.4	8	45	13	2.8	2.1	3	1.6	TC814	TD814	TRJ15	TRJ24	YG - Combo Tap	YG - Combo Tap	YG - Prime X	YG - Prime X Coolant
M2.5	0.45	9	50	15	2.8	2.1	3	2.05	HSS 5% Cobalt	HSS 5% Cobalt	HSS Powder Metal	HSS Powder Metal	Bright	TIN Coated	X-Coated	X-Coated
M3	0.5	11	56	18	3.5	2.7	3	2.5	6H	6H	6HX	6HX	-	-	-	-
M3.5	0.6	12	56	20	4	3	3	2.9	Form B: 4-5	Form B: 4-5	Form B: 4-5	Form B: 4-5	-	-	-	-
M4	0.7	13	63	21	4.5	3.4	3	3.3	3xD	3xD	3xD	3xD	-	-	-	-
M4.5	0.75	14	70	25	6	4.9	3	3.7	-	-	-	-	-	-	-	-
M5	0.8	15	70	25	6	4.9	3	4.2	-	-	-	-	-	-	-	-
M6	1	17	80	30	6	4.9	3	5	-	-	-	-	-	-	-	-
M7	1	17	80	30	7	5.5	3	6	-	-	-	-	-	-	-	-
M8	1.25	20	90	35	8	6.2	3	6.8	-	-	-	-	-	-	-	-
M10	1.5	22	100	39	10	8	3	8.5	-	-	-	-	-	-	-	-
M12	1.75	24	110	44	9	7	3	10.2	-	-	-	-	-	-	-	-
M14	2	26	110	44	11	9	3	12	-	-	-	-	-	-	-	-
M16	2	27	110	44	12	9	3	14	-	-	-	-	-	-	-	-
M18	2.5	30	125	50	14	11	4	15.5	-	-	-	-	-	-	-	-
M20	2.5	32	140	54	16	12	4	17.5	-	-	-	-	-	-	-	-
M22	2.5	32	140	54	18	14.5	4	19.5	-	-	-	-	-	-	-	-
M24	3	34	160	60	18	14.5	4	21	-	-	-	-	-	-	-	-
M27	3	36	160	60	20	16	4	24	-	-	-	-	-	-	-	-
M30	3.5	40	180	70	22	18	4	26.5	-	-	-	-	-	-	-	-
M33	3.5	34	160	60	18	14.5	4	21	-	-	-	-	-	-	-	-
M36	4	36	160	60	20	16	4	24	-	-	-	-	-	-	-	-
M39	4	40	180	70	22	18	4	26.5	-	-	-	-	-	-	-	-
M42	4.5	40	180	70	25	20	4	29.5	-	-	-	-	-	-	-	-
M45	4.5	50	200	80	28	22	4	32	-	-	-	-	-	-	-	-
M48	5	50	200	80	32	24	4	35	-	-	-	-	-	-	-	-
M52	5	56	200	85	32	24	4	37.5	-	-	-	-	-	-	-	-

Material Applications N/mm² 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
TC814	15-20	15-20	12-18	10-15	6-10	-	-	-	-	10-15	5-8	10-15	5-8	10-15	-
TD814							7-10	5-8	4-6						
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
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%			
TC814															
TD814	-	8-12	-	-	8-12	25-35	15-20	-	-	25-35	15-20	10-15	-	-	-
TRJ15															
TRJ24	-	-	-	-	-	-	20-25	-	-	25-30	20-25	-	-	-	-

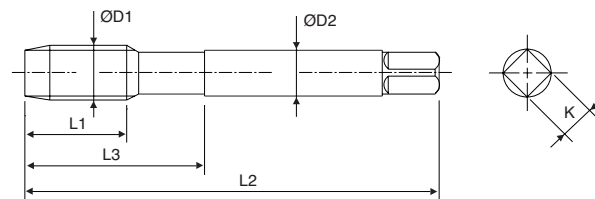


Multi Purpose

Short Chamfer

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



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		
M2	0.4	8	45	13	2.8	2.1	3	1.6	TC807136	TRE34136GS	-
M2.5	0.45	9	50	15	2.8	2.1	3	2.05	TC807176	-	-
M3	0.5	11	56	18	3.5	2.7	3	2.5	TC807206	TRE34206GS	-
M3.5	0.6	12	56	20	4	3	3	2.9	TC807226	-	-
M4	0.7	13	63	21	4.5	3.4	3	3.3	TC807246	TRE34246GS	-
M4.5	0.75	14	70	25	6	4.9	3	3.7	TC807266	-	-
M5	0.8	15	70	25	6	4.9	3	4.2	TC807286	TRE34286GS	-
M6	1	17	80	30	6	4.9	3	5	TC807316	TRE34316GS	TRE41316GS
M7	1	17	80	30	7	5.5	3	6	TC807346	-	-
M8	1.25	20	90	35	8	6.2	3	6.8	TC807366	TRE34366GS	TRE41366GS
M10	1.5	22	100	39	10	8	3	8.5	TC807426	TRE34426GS	TRE41426GS
M12	1.75	24	110	44	9	7	3	10.2	TC807506	TRE34506GS	TRE41506GS
M14	2	26	110	44	11	9	3	12	TC807546	TRE34546GS	TRE41546GS
M16	2	27	110	44	12	9	3	14	TC807606	TRE34606GS	TRE41606GS
M18	2.5	30	125	50	14	11	4	15.5	TC807656	-	-
M20	2.5	32	140	54	16	12	4	17.5	TC807706	TRE34706GS	TRE41706GS
M22	2.5	32	140	54	18	14.5	4	19.5	TC807746	-	-
M24	3	34	160	60	18	14.5	4	21	TC807786	-	-
M27	3	36	160	60	20	16	4	24	TC807866	-	-
M30	3.5	40	180	70	22	18	4	26.5	TC807946	-	-

Material Applications N/mm² 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 TRE41	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			
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	Thermo	Thermoset	CFRP/GFRP
TC807	-	8-12	-	-	8-12	25-35	15-20	-	-	25-35	15-20	10-15	-	-	-
TRE34 TRF41	-	-	-	-	-	-	20-25	-	-	25-30	20-25	-	-	-	-

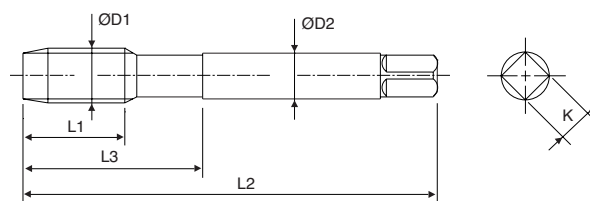


Long Chipping
Steels

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

Chip Breaker



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	

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

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/mm² 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		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/GFR
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%			
TDE27	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-



Multi Purpose

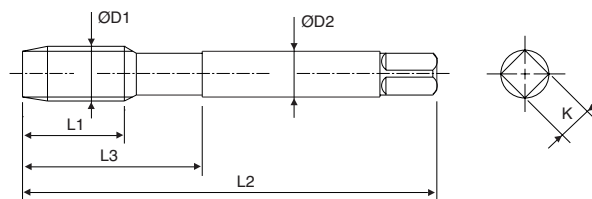
Long Shank

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



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	☒ ☒ ☐ ☐ ☐ ☐	☒ ☒ ☐ ☐ ☐ ☐

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

Material Applications N/mm² Cutting Speed m/min

☒ Excellent ☐ Good

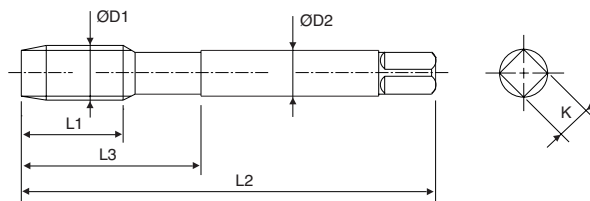
Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium				
	Soft Steels		Carbon	Alloy	Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron		Malleable Cast Iron/ Graphite		Ti	Ti Alloy			
	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900			
TC633 TC455	15-20	15-20	12-18	10-15	6-10	-	-	-	-	10-15	5-8	10-15	5-8	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%						
TC633 TC455	-	8-12	-	-	8-12	25-35	15-20	-	-	25-35	15-20	10-15	-	-	-			



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	

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

METRIC COARSE MACHINE TAPS

Material Applications N/mm² 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	-	-	-

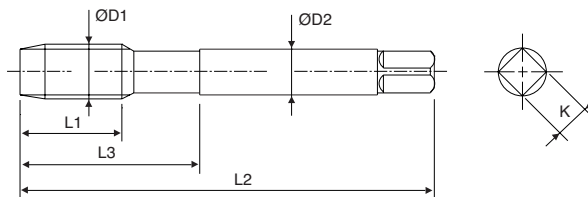


Multi Purpose

4H Tolerance

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

ØD1	Pitch	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Order Code			
M2	0.4	8	45	13	2.8	2.1	3	1.6	TCE05136	TDE05136	TCJ05136	TDJ05136
M2.2	0.45	8	45	13	2.8	2.1	3	1.75	TCE05156	TDE05156	TCJ05156	TDJ05156
M2.3	0.4	8	45	13	2.8	2.1	3	1.9	TCE05196	TDE05196	TCJ05196	TDJ05196
M2.5	0.45	9	50	15	2.8	2.1	3	2.05	TCE05176	TDE05176	TCJ05176	TDJ05176
M2.6	0.45	9	50	15	2.8	2.1	3	2.1	TCE05496	TDE05496	TCJ05496	TDJ05496
M3	0.5	6	56	18	3.5	2.7	3	2.5	TCE05206	TDE05206	TCJ05206	TDJ05206
M3.5	0.6	7	56	20	4	3	3	2.9	TCE05226	TDE05226	TCJ05226	TDJ05226
M4	0.7	7	63	21	4.5	3.4	3	3.3	TCE05246	TDE05246	TCJ05246	TDJ05246
M4.5	0.75	8	70	25	6	4.9	3	3.7	TCE05266	TDE05266	TCJ05266	TDJ05266
M5	0.8	8	70	25	6	4.9	3	4.2	TCE05286	TDE05286	TCJ05286	TDJ05286
M6	1	10	80	30	6	4.9	3	5	TCE05316	TDE05316	TCJ05316	TDJ05316
M7	1	10	80	30	7	5.5	3	6	TCE05346	TDE05346	TCJ05346	TDJ05346
M8	1.25	13	90	35	8	6.2	3	6.8	TCE05366	TDE05366	TCJ05366	TDJ05366
M9	1.25	13	90	35	9	7	3	7.8	TCE05396	TDE05396	TCJ05396	TDJ05396
M10	1.5	15	100	39	10	8	3	8.5	TCE05426	TDE05426	TCJ05426	TDJ05426
M11	1.5	17	100	40	8	6.2	3	9.5	TCE05466	TDE05466	TCJ05466	TDJ05466
M12	1.75	18	110	44	9	7	3	10.2	TCE05506	TDE05506	TCJ05506	TDJ05506
M14	2	20	110	44	11	9	3	12	TCE05546	TDE05546	TCJ05546	TDJ05546
M16	2	20	110	44	12	9	3	14	TCE05606	TDE05606	TCJ05606	TDJ05606
M18	2.5	25	125	50	14	11	4	15.5	TCE05656	TDE05656	TCJ05656	TDJ05656
M20	2.5	25	140	54	16	12	4	17.5	TCE05706	TDE05706	TCJ05706	TDJ05706
M22	2.5	25	140	54	18	14.5	4	19.5	TCE05746	TDE05746	TCJ05746	TDJ05746
M24	3	30	160	60	18	14.5	4	21	TCE05786	TDE05786	TCJ05786	TDJ05786
M27	3	30	160	60	20	16	4	24	TCE05866	TDE05866	TCJ05866	TDJ05866
M30	3.5	35	180	70	22	18	4	26.5	TCE05946	TDE05946	TCJ05946	TDJ05946

Material Applications N/mm² 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
TCE05	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
TDE05	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	-
TCJ05							-	-	-						
TDJ05							7-10	5-8	4-6						
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%			
TCE05	-	8-12	-	-	8-12	25-35	15-20	-	-	25-35	15-20	10-15	-	-	-
TDE05															
TCJ05															
TDJ05															

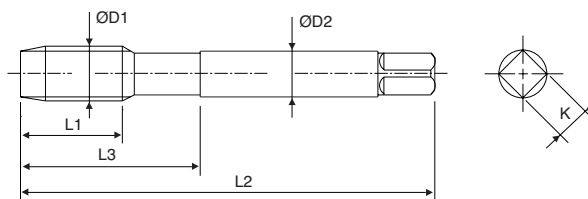


Multi Purpose

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
M2	0.4	8	45	13	2.8	2.1	3	1.6	TCE07136	TDE07136	TCJ07136	TDJ07136	
M2.2	0.45	8	45	13	2.8	2.1	3	1.75	TCE07156	TDE07156	TCJ07156	TDJ07156	
M2.3	0.4	8	45	13	2.8	2.1	3	1.9	TCE07196	TDE07196	TCJ07196	TDJ07196	
M2.5	0.45	9	50	15	2.8	2.1	3	2.05	TCE07176	TDE07176	TCJ07176	TDJ07176	
M2.6	0.45	9	50	15	2.8	2.1	3	2.1	TCE07496	TDE07496	TCJ07496	TDJ07496	
M3	0.5	6	56	18	3.5	2.7	3	2.5	TCE07206	TDE07206	TCJ07206	TDJ07206	
M3.5	0.6	7	56	20	4	3	3	2.9	TCE07226	TDE07226	TCJ07226	TDJ07226	
M4	0.7	7	63	21	4.5	3.4	3	3.3	TCE07246	TDE07246	TCJ07246	TDJ07246	
M4.5	0.75	8	70	25	6	4.9	3	3.7	TCE07266	TDE07266	TCJ07266	TDJ07266	
M5	0.8	8	70	25	6	4.9	3	4.2	TCE07286	TDE07286	TCJ07286	TDJ07286	
M6	1	10	80	30	6	4.9	3	5	TCE07316	TDE07316	TCJ07316	TDJ07316	
M7	1	10	80	30	7	5.5	3	6	TCE07346	TDE07346	TCJ07346	TDJ07346	
M8	1.25	13	90	35	8	6.2	3	6.8	TCE07366	TDE07366	TCJ07366	TDJ07366	
M9	1.25	13	90	35	9	7	3	7.8	TCE07396	TDE07396	TCJ07396	TDJ07396	
M10	1.5	15	100	39	10	8	3	8.5	TCE07426	TDE07426	TCJ07426	TDJ07426	
M11	1.5	17	100	40	8	6.2	3	9.5	TCE07466	TDE07466	TCJ07466	TDJ07466	
M12	1.75	18	110	44	9	7	3	10.2	TCE07506	TDE07506	TCJ07506	TDJ07506	
M14	2	20	110	44	11	9	3	12	TCE07546	TDE07546	TCJ07546	TDJ07546	
M16	2	20	110	44	12	9	3	14	TCE07606	TDE07606	TCJ07606	TDJ07606	
M18	2.5	25	125	50	14	11	4	15.5	TCE07656	TDE07656	TCJ07656	TDJ07656	
M20	2.5	25	140	54	16	12	4	17.5	TCE07706	TDE07706	TCJ07706	TDJ07706	
M22	2.5	25	140	54	18	14.5	4	19.5	TCE07746	TDE07746	TCJ07746	TDJ07746	
M24	3	30	160	60	18	14.5	4	21	TCE07786	TDE07786	TCJ07786	TDJ07786	
M27	3	30	160	60	20	16	4	24	TCE07866	TDE07866	TCJ07866	TDJ07866	
M30	3.5	35	180	70	22	18	4	26.5	TCE07946	TDE07946	TCJ07946	TDJ07946	

Material Applications N/mm² 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
TCE07							-	-	-						
TDE07	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	-
TCJ07							-	-	-						
TDJ07							7-10	5-8	4-6						
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%			
TCE07															
TDE07	-	8-12	-	-	8-12	25-35	15-20	-	-	25-35	15-20	10-15	-	-	-
TCJ07															
TDJ07															

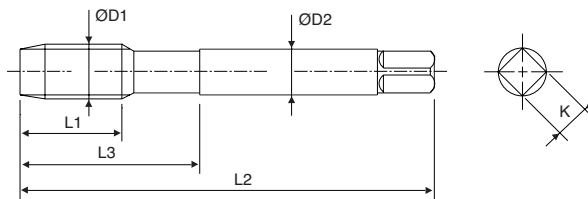


Multi Purpose

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				
ØD1	Pitch	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.		Order Code	Order Code	Order Code	Order Code
M2	0.4	8	45	13	2.8	2.1	3	1.7		TCE06136	TDE06136	TCJ06136	TDJ06136
M2.2	0.45	8	45	13	2.8	2.1	3	1.85		TCE06156	TDE06156	TCJ06156	TDJ06156
M2.3	0.4	8	45	13	2.8	2.1	3	2		TCE06196	TDE06196	TCJ06196	TDJ06196
M2.5	0.45	9	50	15	2.8	2.1	3	2.15		TCE06176	TDE06176	TCJ06176	TDJ06176
M2.6	0.45	9	50	15	2.8	2.1	3	2.2		TCE06496	TDE06496	TCJ06496	TDJ06496
M3	0.5	6	56	18	3.5	2.7	3	2.6		TCE06206	TDE06206	TCJ06206	TDJ06206
M3.5	0.6	7	56	20	4	3	3	3		TCE06226	TDE06226	TCJ06226	TDJ06226
M4	0.7	7	63	21	4.5	3.4	3	3.4		TCE06246	TDE06246	TCJ06246	TDJ06246
M4.5	0.75	8	70	25	6	4.9	3	3.8		TCE06266	TDE06266	TCJ06266	TDJ06266
M5	0.8	8	70	25	6	4.9	3	4.3		TCE06286	TDE06286	TCJ06286	TDJ06286
M6	1	10	80	30	6	4.9	3	5.1		TCE06316	TDE06316	TCJ06316	TDJ06316
M7	1	10	80	30	7	5.5	3	6.1		TCE06346	TDE06346	TCJ06346	TDJ06346
M8	1.25	13	90	35	8	6.2	3	6.9		TCE06366	TDE06366	TCJ06366	TDJ06366
M9	1.25	13	90	35	9	7	3	7.9		TCE06396	TDE06396	TCJ06396	TDJ06396
M10	1.5	15	100	39	10	8	3	8.6		TCE06426	TDE06426	TCJ06426	TDJ06426
M11	1.5	17	100	40	8	6.2	3	9.6		TCE06466	TDE06466	TCJ06466	TDJ06466
M12	1.75	18	110	44	9	7	3	10.3		TCE06506	TDE06506	TCJ06506	TDJ06506
M14	2	20	110	44	11	9	3	12.1		TCE06546	TDE06546	TCJ06546	TDJ06546
M16	2	20	110	44	12	9	3	14.1		TCE06606	TDE06606	TCJ06606	TDJ06606
M18	2.5	25	125	50	14	11	4	15.6		TCE06656	TDE06656	TCJ06656	TDJ06656
M20	2.5	25	140	54	16	12	4	17.6		TCE06706	TDE06706	TCJ06706	TDJ06706
M22	2.5	25	140	54	18	14.5	4	19.6		TCE06746	TDE06746	TCJ06746	TDJ06746
M24	3	30	160	60	18	14.5	4	21.1		TCE06786	TDE06786	TCJ06786	TDJ06786
M27	3	30	160	60	20	16	4	24.1		TCE06866	TDE06866	TCJ06866	TDJ06866
M30	3.5	35	180	70	22	18	4	26.6		TCE06946	TDE06946	TCJ06946	TDJ06946

Material Applications N/mm² 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
TCE05	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
TDE05	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	-
TCJ05							-	-	-						
TDJ05							7-10	5-8	4-6						
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%			
TCE05	-	8-12	-	-	8-12	25-35	15-20	-	-	25-35	15-20	10-15	-	-	-
TDE05															
TCJ05															
TDJ05															

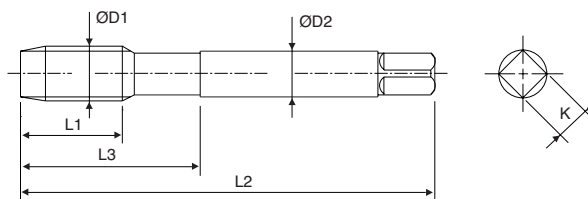


Multi Purpose

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
M2	0.4	8	45	13	2.1	3	1.6	TCE08136	TDE08136	TCJ08136	TDJ08136
M2.2	0.45	8	45	13	2.1	3	1.75	TCE08156	TDE08156	-	TDJ08156
M2.3	0.4	8	45	13	2.1	3	1.9	TCE08196	TDE08196	-	TDJ08196
M2.5	0.45	9	50	15	2.1	3	2.05	TCE08176	TDE08176	-	TDJ08176
M2.6	0.45	9	50	15	2.1	3	2.1	TCE08496	TDE08496	-	TDJ08496
M3	0.5	6	56	18	2.7	3	2.5	TCE08206	TDE08206	TCJ08206	TDJ08206
M3.5	0.6	7	56	20	3	3	2.9	TCE08226	TDE08226	-	TDJ08226
M4	0.7	7	63	21	3.4	3	3.3	TCE08246	TDE08246	TCJ08246	TDJ08246
M4.5	0.75	8	70	25	4.9	3	3.7	TCE08266	TDE08266	-	TDJ08266
M5	0.8	8	70	25	4.9	3	4.2	TCE08286	TDE08286	TCJ08286	TDJ08286
M6	1	10	80	30	4.9	3	5	TCE08316	TDE08316	TCJ08316	TDJ08316
M7	1	10	80	30	5.5	3	6	TCE08346	TDE08346	-	TDJ08346
M8	1.25	13	90	35	6.2	3	6.8	TCE08366	TDE08366	TCJ08366	TDJ08366
M9	1.25	13	90	35	7	3	7.8	TCE08396	TDE08396	-	TDJ08396
M10	1.5	15	100	39	8	3	8.5	TCE08426	TDE08426	TCJ08426	TDJ08426
M11	1.5	17	100	40	6.2	3	9.5	TCE08466	TDE08466	-	TDJ08466
M12	1.75	18	110	44	7	3	10.2	TCE08506	TDE08506	TCJ08506	TDJ08506
M14	2	20	110	44	9	3	12	TCE08546	TDE08546	TCJ08546	TDJ08546
M16	2	20	110	44	9	3	14	TCE08606	TDE08606	TCJ08606	TDJ08606
M18	2.5	25	125	50	11	3	15.5	TCE08656	TDE08656	-	TDJ08656
M20	2.5	25	140	54	12	3	17.5	TCE08706	TDE08706	TCJ08706	TDJ08706
M22	2.5	25	140	54	14.5	3	19.5	TCE08746	TDE08746	-	TDJ08746
M24	3	30	160	60	14.5	3	21	TCE08786	TDE08786	-	TDJ08786
M27	3	30	160	60	16	3	24	TCE08866	TDE08866	-	TDJ08866
M30	3.5	35	180	70	18	3	26.5	TCE08946	TDE08946	-	TDJ08946

Material Applications N/mm² 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
TCE07	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
TDE07	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	-
TCJ07							-	-	-						
TDJ07							7-10	5-8	4-6						
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%			
TCE07	-	8-12	-	-	8-12	25-35	15-20	-	-	25-35	15-20	10-15	-	-	-
TDE07															
TCJ07															
TDJ07															

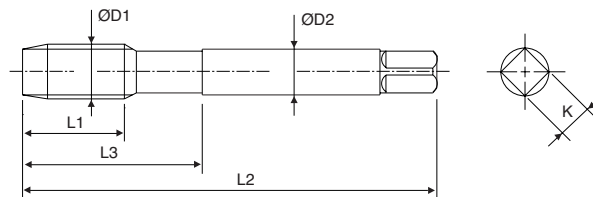


HR

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 HSSE 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	Order Code	Order Code
M2	0.4	8	45	13	2.8	2.1	3	1.6	TY313136	-	-
M3	0.5	11	56	18	3.5	2.7	3	2.5	TY313206	-	-
M4	0.7	13	63	21	4.5	3.4	3	3.3	TY313246	-	-
M5	0.8	15	70	25	6	4.9	3	4.2	TY313286	-	-
M6	1	17	80	30	6	4.9	3	5	TY313316	-	-
M8	1.25	20	90	35	8	6.2	3	6.8	TY313366	-	-
M10	1.5	22	100	39	10	8	3	8.5	TY313426	-	-
M12	1.75	24	110	44	9	7	3	10.2	TY313506	-	-
M14	2	26	110	44	11	9	3	12	TY313546	-	-
M16	2	27	110	44	12	9	3	14	TY313606	-	-
M20	2.5	32	140	54	16	12	4	17.5	TY313706	-	-
M3	0.5	5	56	-	3.5	2.7	3	2.5	-	K40M3TXC	-
M4	0.7	7	63	-	4.5	3.4	3	3.3	-	K40M4TXC	-
M5	0.8	8	70	-	6	4.9	3	4.2	-	K40M5TXC	-
M6	1	10	80	-	6	4.9	3	5	-	K40M6TXC	K40M6FOR-TXC
M8	1.25	13	90	-	8	6.2	3	6.8	-	K40M8TXC	K40M8FOR-TXC
M10	1.5	15	100	-	10	8	3	8.5	-	K40M10TXC	K40M10FOR-TXC
M12	1.75	18	110	-	9	7	4	10.3	-	K41M12TXC	K41M12FOR-TXC
M14	2	20	110	-	11	9	4	12	-	K41M14TXC	K41M14FOR-TXC
M16	2	20	110	-	12	9	4	14	-	K41M16TXC	K41M16FOR-TXC

Material Applications N/mm²

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			
TY313					6-10	3-5			4-6			-	-					
K40M-TXC	-	-	-	-			-	-		-	-	15-20	20-25	-	-			
K40MFOR					5-12	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						
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	Thermo	Thermoset	CFRP/GFRP			
TY313						25-35		3-5				-		8-12	5-7			
K40M-TXC	-	-	-	-	-		-		-	-	-		-	-	-			
K40MFOR						25-30		-				25-30						

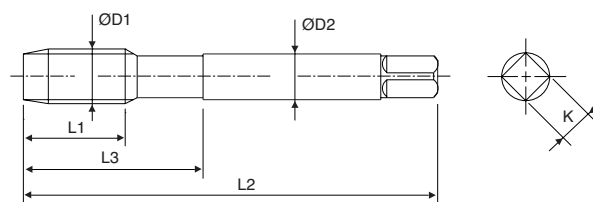


HR

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



YG

UFS

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	Order Code	Order Code
M2	0.4	8	45	13	2.8	2.1	3	1.6	TY283136	-	-
M3	0.5	11	56	18	3.5	2.7	3	2.5	TY283206	-	-
M4	0.7	13	63	21	4.5	3.4	3	3.3	TY283246	-	-
M5	0.8	15	70	25	6	4.9	3	4.2	TY283286	-	-
M6	1	17	80	30	6	4.9	3	5	TY283316	-	-
M8	1.25	20	90	35	8	6.2	3	6.8	TY283366	-	-
M10	1.5	22	100	39	10	8	3	8.5	TY283426	-	-
M12	1.75	24	110	44	9	7	3	10.2	TY283506	-	-
M14	2	26	110	44	11	9	3	12	TY283546	-	-
M16	2	27	110	44	12	9	3	14	TY283606	-	-
M20	2.5	32	140	54	16	12	4	17.5	TY283706	-	-
M3	0.5	10	56	-	3.5	2.7	3	2.5	-	K20M3TXC	-
M4	0.7	13	63	-	4.5	3.4	3	3.3	-	K20M4TXC	-
M5	0.8	13	70	-	6	4.9	3	4.2	-	K20M5TXC	-
M6	1	16	80	-	6	4.9	3	5	-	K20M6TXC	K22M6FOR-TXC
M8	1.25	18	90	-	8	6.2	3	6.8	-	K20M8TXC	K22M8FOR-TXC
M10	1.5	20	100	-	10	8	3	8.5	-	K20M10TXC	K22M10FOR-TXC
M12	1.75	25	110	-	9	7	4	10.3	-	K21M12TXC	K23M12FOR-TXC
M14	2	28	110	-	11	9	4	12	-	K21M14TXC	K23M14FOR-TXC
M16	2	28	110	-	12	9	4	14	-	K21M16TXC	K23M16FOR-TXC

Material Applications N/mm²

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			
TY283					6-10	3-5	4-6					-	-					
K20M-TXC	-	-	-	-			-	-	-	-	-	15-20	20-25	-	-			
K22MFOR					5-12	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						
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	Thermo	Thermoset	CFRP/GFRP			
TY283							25-35	3-5		-			8-12			5-7		
K20M-TXC	-	-	-	-	-	25-30		-	-	-	-	25-30	-	-	-			
K22MFOR																		

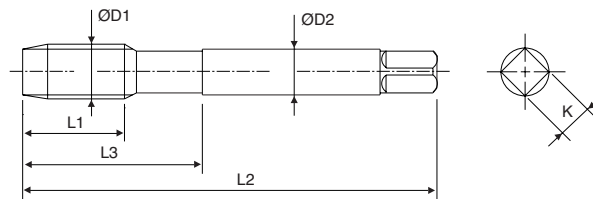


INOX

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



YG

UFS

Series	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	Order Code	Order Code
M2	0.4	8	45	13	2.8	2.1	3	1.6	TCH14136	-	-
M2.5	0.45	9	50	15	2.8	2.1	3	2.05	TCH14176	-	-
M3	0.5	6	56	18	3.5	2.7	3	2.5	TCH14206	-	-
M3.5	0.6	7	56	20	4	3	3	2.9	TCH14226	-	-
M4	0.7	7	63	21	4.5	3.4	3	3.3	TCH14246	-	-
M4.5	0.75	8	70	25	6	4.9	3	3.7	TCH14266	-	-
M5	0.8	8	70	25	6	4.9	3	4.2	TCH14286	-	-
M6	1	10	80	30	6	4.9	3	5	TCH14316	-	-
M7	1	10	80	30	7	5.5	3	6	TCH14346	-	-
M8	1.25	13	90	35	8	6.2	3	6.8	TCH14366	-	-
M9	1.25	13	90	35	9	7	3	7.8	TCH14396	-	-
M10	1.5	15	100	39	10	8	3	8.5	TCH14426	-	-
M11	1.5	17	100	40	8	6.2	3	9.5	TCH14466	-	-
M12	1.75	18	110	44	9	7	3	10.2	TCH14506	-	-
M14	2	20	110	44	11	9	3	12	TCH14546	-	-
M16	2	20	110	44	12	9	3	14	TCH14606	-	-
M18	2.5	25	125	50	14	11	4	15.5	TCH14656	-	-
M20	2.5	25	140	54	16	12	4	17.5	TCH14706	-	-
M22	2.5	25	140	54	18	14.5	4	19.5	TCH14746	-	-
M24	3	30	160	60	18	14.5	4	21	TCH14786	-	-
M27	3	30	160	60	20	16	4	24	TCH14866	-	-
M30	3.5	35	180	70	22	18	4	26.5	TCH14946	-	-
M3	0.5	10	56	-	3.5	2.7	3	2.5	-	V82M3TXC	-
M4	0.7	13	63	-	4.5	3.4	3	3.3	-	V82M4TXC	K82M4X-TXC
M5	0.8	13	70	-	6	4.9	3	4.2	-	V82M5TXC	K82M5X-TXC
M6	1	16	80	-	6	4.9	3	5	-	V82M6TXC	K82M6X-TXC
M8	1.25	18	90	-	8	6.2	3	6.8	-	V82M8TXC	K82M8X-TXC
M10	1.5	20	100	-	10	8	3	8.5	-	V82M10TXC	K82M10X-TXC
M12	1.75	25	110	-	9	7	4	10.3	-	V83M12TXC	K83M12X-TXC
M14	2	28	110	-	11	9	4	12	-	V83M14TXC	K83M14X-TXC
M16	2	28	110	-	12	9	4	14	-	V83M16TXC	K83M16X-TXC
M20	2.5	33	140	-	16	12	4	17.5	-	V83M20TXC	-
M24	3	39	160	-	18	14.5	4	21	-	V83M24TXC	-

Material Applications N/mm²

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
TCH14	20-25	20-25	18-24	15-20	-	-	10-13	8-11	6-8	-	-	-	-	-	-
V82M	-	15-20	-	10-15	-	-	7-10	5-8	-	-	-	-	-	-	-
K82M	-	-	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			
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	Thermo	Thermoset	CFRP/GFRP
TCH14	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
V82M	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
K82M	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-



INOX

Stainless Steel

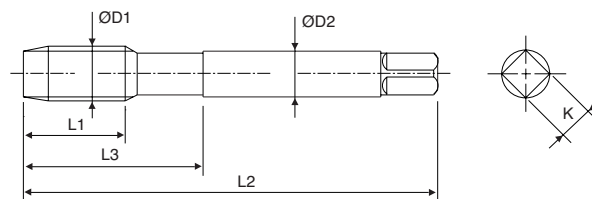
METRIC COARSE DIN 13 MACHINE TAPS - SPIRAL POINT

- 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



YG

UFS



Series									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	Order Code	Order Code
M2	0.4	8	45	13	2.8	2.1	3	1.6	TCH23136	-	-
M2.5	0.45	9	50	15	2.8	2.1	3	2.05	TCH23176	-	-
M3	0.5	6	56	18	3.5	2.7	3	2.5	TCH23206	-	-
M3.5	0.6	7	56	20	4	3	3	2.9	TCH23226	-	-
M4	0.7	7	63	21	4.5	3.4	3	3.3	TCH23246	-	-
M4.5	0.75	8	70	25	6	4.9	3	3.7	TCH23266	-	-
M5	0.8	8	70	25	6	4.9	3	4.2	TCH23286	-	-
M6	1	10	80	30	6	4.9	3	5	TCH23316	-	-
M7	1	10	80	30	7	5.5	3	6	TCH23346	-	-
M8	1.25	13	90	35	8	6.2	3	6.8	TCH23366	-	-
M9	1.25	13	90	35	9	7	3	7.8	TCH23396	-	-
M10	1.5	15	100	39	10	8	3	8.5	TCH23426	-	-
M11	1.5	17	100	40	8	6.2	3	9.5	TCH23466	-	-
M12	1.75	18	110	44	9	7	3	10.2	TCH23506	-	-
M14	2	20	110	44	11	9	3	12	TCH23546	-	-
M16	2	20	110	44	12	9	3	14	TCH23606	-	-
M18	2.5	25	125	50	14	11	4	15.5	TCH23656	-	-
M20	2.5	25	140	54	16	12	4	17.5	TCH23706	-	-
M22	2.5	25	140	54	18	14.5	4	19.5	TCH23746	-	-
M24	3	30	160	60	18	14.5	4	21	TCH23786	-	-
M27	3	30	160	60	20	16	4	24	TCH23866	-	-
M30	3.5	35	180	70	22	18	4	26.5	TCH23946	-	-
M3	0.5	10	56	-	3.5	2.7	3	2.5	-	V24M3TXC	K24M3X-TXC
M4	0.7	13	63	-	4.5	3.4	3	3.3	-	V24M4TXC	K24M4X-TXC
M5	0.8	13	70	-	6	4.9	3	4.2	-	V24M5TXC	K24M5X-TXC
M6	1	16	80	-	6	4.9	3	5	-	V24M6TXC	K24M6X-TXC
M8	1.25	18	90	-	8	6.2	3	6.8	-	V24M8TXC	K24M8X-TXC
M10	1.5	20	100	-	10	8	3	8.5	-	V24M10TXC	K24M10X-TXC
M12	1.75	25	110	-	9	7	4	10.3	-	V25M12TXC	K25M12X-TXC
M14	2	28	110	-	11	9	4	12	-	V25M14TXC	K25M14X-TXC
M16	2	28	110	-	12	9	4	14	-	V25M16TXC	-
M20	2.5	33	140	-	16	12	4	17.5	-	V25M20TXC	-
M24	3	39	160	-	18	14.5	4	21	-	V25M24TXC	-

Material Applications N/mm²

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
TCH23	20-25	20-25	18-24	15-20	-	-	10-13	8-11	6-8	-	-	-	-	-	-
V24M	-	15-20	-	10-15	-	-	7-10	5-8	-	-	-	-	-	-	-
K24M	-	-	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			
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	Thermo	Thermoset	CFRP/GFRP
TCH23	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
V24M	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
K24M	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

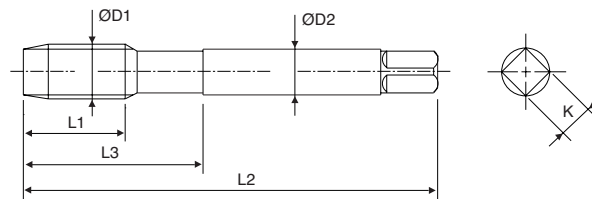


NI

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	Order Code
M3	0.5	6	56	18	3.5	2.7	3	2.5	TZ933206	-
M4	0.7	7	63	21	4.5	3.4	3	3.3	TZ933246	-
M5	0.8	8	70	25	6	4.9	3	4.2	TZ933286	-
M6	1	10	80	30	6	4.9	3	5	TZ933316	-
M8	1.25	13	90	35	8	6.2	3	6.8	TZ933366	-
M10	1.5	15	100	39	10	8	3	8.5	TZ933426	-
M12	1.75	18	110	44	9	7	3	10.2	TZ933506	-
M3	0.5	10	56	-	3.5	2.7	3	2.5	-	K42M3NI-CT
M4	0.7	13	63	-	4.5	3.4	3	3.3	-	K42M4NI-CT
M5	0.8	15	70	-	6	4.9	3	4.2	-	K42M5NI-CT
M6	1	18	80	-	6	4.9	3	5	-	K42M6NI-CT
M8	1.25	25	90	-	8	6.2	3	6.8	-	K42M8NI-CT
M10	1.5	30	100	-	10	8	3	8.5	-	K42M10NI-CT
M12	1.75	50	110	-	12	9	4	10.3	-	K42M12NI-CT

Material Applications N/mm² 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
TZ933	-	-	12-18	10-15	-	-	-	-	-	-	-	-	-	-	-
K52M-NI	-	-	-	-	-	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%			
TZ933	4-6	-	10-15	2-4	-	-	-	3-5	-	-	-	-	-	-	-
K52M-NI	-	2-4	-	-	-	-	-	5-8	-	-	-	-	-	-	-

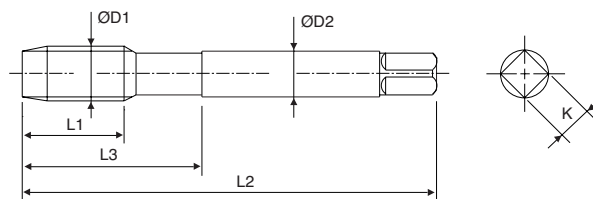


NI

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	Order Code
M3	0.5	11	56	18	3.5	2.7	3	2.5	TZ923206	-
M4	0.7	13	63	21	4.5	3.4	3	3.3	TZ923246	-
M5	0.8	15	70	25	6	4.9	3	4.2	TZ923286	-
M6	1	17	80	30	6	4.9	3	5	TZ923316	-
M8	1.25	20	90	35	8	6.2	3	6.8	TZ923366	-
M10	1.5	22	100	39	10	8	3	8.5	TZ923426	-
M12	1.75	24	110	44	9	7	3	10.2	TZ923506	-
M4	0.7	13	63	-	4.5	3.4	3	3.3	-	K52M4NI-CT
M5	0.8	15	70	-	6	4.9	3	4.2	-	K52M5NI-CT
M6	1	18	80	-	6	4.9	3	5	-	K52M6NI-CT
M8	1.25	25	90	-	8	6.2	3	6.8	-	K52M8NI-CT
M10	1.5	30	100	-	10	8	3	8.5	-	K52M10NI-CT
M12	1.75	50	110	-	12	9	4	10.3	-	K52M12NI-CT

METRIC COARSE MACHINE TAPS

Material Applications N/mm² 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
TZ923 K42M-Ni	-	-	12-18	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%
TZ923 K42M-Ni	4-6	-	10-15	2-4	-	-	-	3-5	-	-	-	-	-	-	-
	-	-	2-4	-	-	-	-	5-8	-	-	-	-	-	-	-

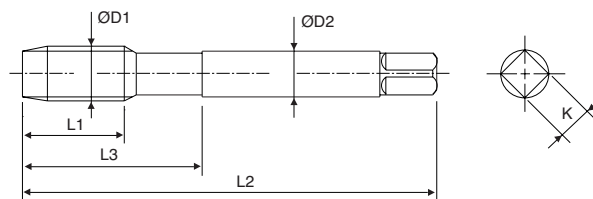


NI

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			
No. of Flutes	Drill Dia.	Order Code	Order Code
3	2.5	TZ903206	-
	3.3	TZ903246	-
	4.2	TZ903286	-
	5	TZ903316	-
	6.8	TZ903366	-
	8.5	TZ903426	-
	10.2	TZ903506	-
3	2.5	-	K42M3CT
	3.3	-	K42M4CT
	4.2	-	K42M5CT
	5	-	K42M6CT
	6.8	-	K42M8CT
	8.5	-	K42M10CT
	10.3	-	K43M12CT
	14	-	K43M16CT

Material Applications N/mm² 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			
TZ903 K42M-Ti	-	-	-	-	-	-	-	-	-	-	-	-	-	10-15 5-10	8-12 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			
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%						
TZ903 K42M-Ti	4-6 2-4	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-		

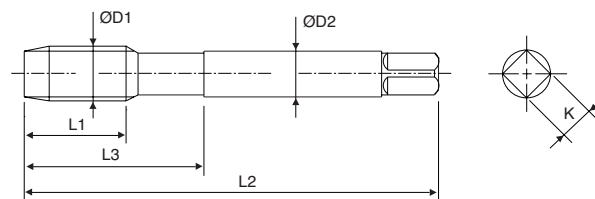


NI

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	Order Code
M3	0.5	11	56	18	3.5	2.7	3	2.5	TZ293206	-
M4	0.7	13	63	21	4.5	3.4		3.3	TZ293246	-
M5	0.8	15	70	25	6	4.9		4.2	TZ293286	-
M6	1	17	80	30	6	4.9		5	TZ293316	-
M8	1.25	20	90	35	8	6.2		6.8	TZ293366	-
M10	1.5	22	100	39	10	8		8.5	TZ293426	-
M12	1.75	24	110	44	9	7	3	10.2	TZ293506	-
M3	0.5	10	56	-	3.5	2.7		2.5	-	K52M3CT
M4	0.7	13	63	-	4.5	3.4		3.3	-	K52M4CT
M5	0.8	13	70	-	6	4.9		4.2	-	K52M5CT
M6	1	16	80	-	6	4.9		5	-	K52M6CT
M8	1.25	18	90	-	8	6.2		6.8	-	K52M8CT
M10	1.5	20	100	-	10	8		8.5	-	K52M10CT
M12	1.75	25	110	-	9	7		10.3	-	K53M12CT
M16	2	28	110	-	12	9		14	-	K53M16CT

METRIC COARSE MACHINE TAPS

Material Applications N/mm² 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 5-10	8-12 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	-	-	-	-	-	-	-	-	-	-	-	-	-	-

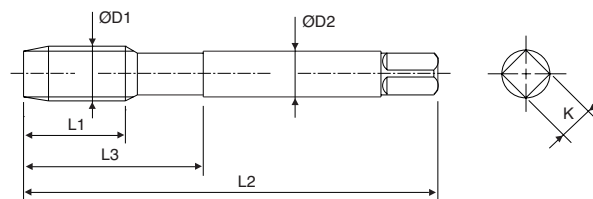
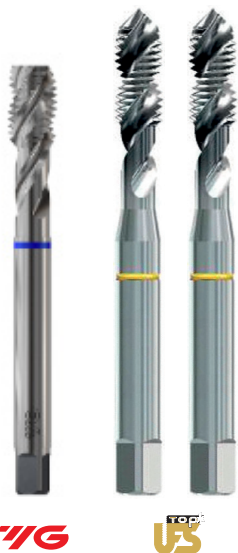


ALU

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	Order Code	Order Code
M2	0.4	8	45	13	2.8	2.1	3	1.6	TC163136	-	-
M2.5	0.45	9	50	15	2.8	2.1	3	2.05	TC163176	-	-
M3	0.5	11	56	18	3.5	2.7	3	2.5	TC163206	-	-
M4	0.7	13	63	21	4.5	3.4	3	3.3	TC163246	-	-
M5	0.8	15	70	25	6	4.9	3	4.2	TC163286	-	-
M6	1	17	80	30	6	4.9	3	5	TC163316	-	-
M8	1.25	20	90	35	8	6.2	3	6.8	TC163366	-	-
M10	1.5	22	100	39	10	8	3	8.5	TC163426	-	-
M12	1.75	24	110	44	9	7	3	10.2	TC163506	-	-
M14	2	26	110	44	11	9	3	12	TC163546	-	-
M16	2	27	110	44	12	9	3	14	TC163606	-	-
M18	2.5	30	125	50	14	11	3	15.5	TC163656	-	-
M20	2.5	32	140	54	16	12	3	17.5	TC163706	-	-
M3	0.5	10	56	-	3.5	2.7	2	2.5	-	E70M3	E70M3TXC
M4	0.7	13	63	-	4.5	3.4	2	3.3	-	E70M4	E70M4TXC
M5	0.8	13	70	-	6	4.9	2	4.2	-	E70M5	E70M5TXC
M6	1	16	80	-	6	4.9	2	5	-	E70M6	E70M6TXC
M8	1.25	18	90	-	8	6.2	2	6.8	-	E70M8	E70M8TXC
M10	1.5	20	100	-	10	8	2	8.5	-	E70M10	E70M10TXC
M12	1.75	25	110	-	9	7	3	10.3	-	E71M12	E71M12TXC
M14	2	28	110	-	11	9	3	12	-	E71M14	E71M14TXC
M16	2	28	110	-	12	9	3	14	-	E71M16	E71M16TXC

Material Applications N/mm² 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	<700	<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	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
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	25-30	-	20-25	-	-

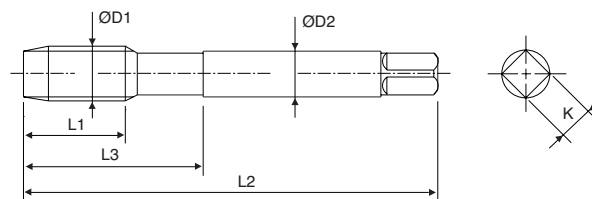


ALU

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	Order Code	Order Code
M2	0.4	8	45	13	2.8	2.1	3	1.6	TC622136	-	-
M2.5	0.45	9	50	15	2.8	2.1	3	2.05	TC622176	-	-
M3	0.5	11	56	18	3.5	2.7	3	2.5	TC622206	-	-
M4	0.7	13	63	21	4.5	3.4	3	3.3	TC622246	-	-
M5	0.8	15	70	25	6	4.9	3	4.2	TC622286	-	-
M6	1	17	80	30	6	4.9	3	5	TC622316	-	-
M8	1.25	20	90	35	8	6.2	3	6.8	TC622366	-	-
M10	1.5	22	100	39	10	8	3	8.5	TC622426	-	-
M12	1.75	24	110	44	9	7	3	10.2	TC622506	-	-
M14	2	26	110	44	11	9	3	12	TC622546	-	-
M16	2	27	110	44	12	9	3	14	TC622606	-	-
M18	2.5	30	125	50	14	11	3	15.5	TC622656	-	-
M20	2.5	32	140	54	16	12	3	17.5	TC622706	-	-
M3	0.5	10	56	-	3.5	2.7	3	2.5	-	E24M3AZ	E24M3AL-TXC
M4	0.7	13	63	-	4.5	3.4	3	3.3	-	E24M4AZ	E24M4AL-TXC
M5	0.8	13	70	-	6	4.9	3	4.2	-	E24M5AZ	E24M5AL-TXC
M6	1	16	80	-	6	4.9	3	5	-	E24M6AZ	E24M6AL-TXC
M8	1.25	18	90	-	8	6.2	3	6.8	-	E24M8AZ	E24M8AL-TXC
M10	1.5	20	100	-	10	8	3	8.5	-	E24M10AZ	E24M10AL-TXC
M12	1.75	25	110	-	9	7	3	10.3	-	E25M12AZ	E25M12AL-TXC
M14	2	28	110	-	11	9	3	12	-	E25M14AZ	E25M14AL-TXC
M16	2	28	110	-	12	9	3	14	-	-	E25M16AL-TXC

Material Applications N/mm² 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
TC622	15-20	15-20	12-18											10-15	
E24M-AZ	-	-	-	-	-	-	-	-	-	-	-	-	-	5-8	-
E24MAL-TXC	20-30													-	
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			
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	Thermo	Thermoset	CFRP/GFRP
TC622					8-12				10-15	25-35	15-20		-		
E24M-AZ	-	6-8	-	-		-		-		-	-	-	20-25	-	-
E24MAL-TXC					15-20		20-25		20-25	25-30	20-25		-		



GG

Cast Iron

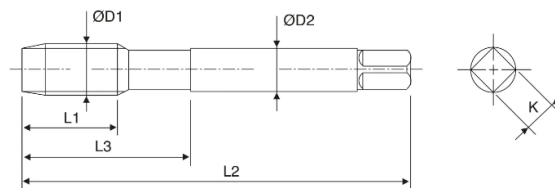
METRIC COARSE DIN 13 MACHINE TAPS - STRAIGHT FLUTE

- 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



YG

UFS



										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	Order Code	Order Code	Order Code		
M2	0.4	8	45	13	2.8	2.1	3	1.6	TE821136	TY821136	-	-		
M2.5	0.45	9	50	15	2.8	2.1	3	2.05	TE821176	TY821176	-	-		
M3	0.5	11	56	18	3.5	2.7	3	2.5	TE821206	TY821206	-	-		
M4	0.7	13	63	21	4.5	3.4	3	3.3	TE821246	TY821246	-	-		
M5	0.8	15	70	25	6	4.9	4	4.2	TE821286	TY821286	-	-		
M6	1	17	80	30	6	4.9	4	5	TE821316	TY821316	-	-		
M8	1.25	20	90	35	8	6.2	4	6.8	TE821366	TY821366	-	-		
M10	1.5	22	100	39	10	8	4	8.5	TE821426	TY821426	-	-		
M12	1.75	24	110	44	9	7	4	10.2	TE821506	TY821506	-	-		
M14	2	26	110	44	11	9	4	12	TE821546	TY821546	-	-		
M16	2	27	110	44	12	9	4	14	TE821606	TY821606	-	-		
M18	2.5	30	125	50	14	11	4	15.5	TE821656	TY821656	-	-		
M20	2.5	32	140	54	16	12	4	17.5	TE821706	TY821706	-	-		
M22	2.5	32	140	54	18	14.5	4	19.5	TE821746	TY821746	-	-		
M24	3	34	160	60	18	14.5	4	21	TE821786	TY821786	-	-		
M4	0.7	13	63	-	4.5	3.4	3	3.3	-	-	K26M4TX	-		
M5	0.8	13	70	-	6	4.9	3	4.2	-	-	K26M5TX	-		
M6	1	16	80	-	6	4.9	4	5	-	-	K26M6TX	K26M6FOR-TX		
M8	1.25	18	90	-	8	6.2	4	6.8	-	-	K26M8TX	K26M8FOR-TX		
M10	1.5	20	100	-	10	8	4	8.5	-	-	K26M10TX	K26M10FOR-TX		
M12	1.75	25	110	-	9	7	4	10.3	-	-	K27M12TX	K27M12FOR-TX		
M14	2	28	110	-	11	9	4	12	-	-	K27M14TX	K27M14FOR-TX		
M16	2	28	110	-	12	9	4	14	-	-	K27M16TX	K27M16FOR-TX		

Material Applications N/mm² 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	
TE812										10-15	5-8	-	-	-	-	
TY821	-	-	-	-	-	-	-	-	-							
K26M-TX										25-30	20-25	25-30	20-25			
K26MFOR-TX																
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%				
TE812					8-12											
TY821	-	-	-	-	8-12			-		-	-	-	-	-	-	5-7
K26M-TX							-		-	-	-	-	-	-	-	
K26MFOR-TX						25-30		5-8				25-30				-

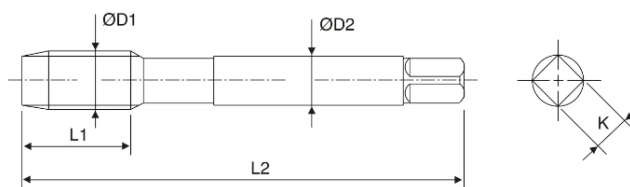


GG

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	

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

METRIC COARSE MACHINE TAPS

Material Applications N/mm² Cutting Speed m/min

Excellent Good

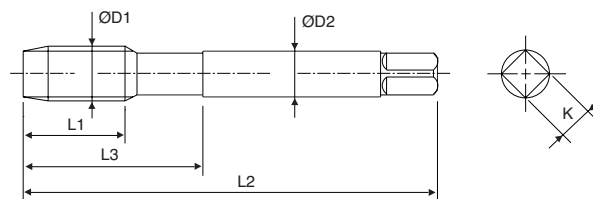
Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels		Carbon	Alloy	Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite		Ti	Ti Alloy	
K28M-CT	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
	-	-	-	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
K28M-CT	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	-
	-	-	-	-	-	-	-	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		
	YG-Roll			YG-Roll			YG - Prime X Roll			YG - Synchro Roll		
	HSS 5% Cobalt			HSS 5% Cobalt			HSS Powder Metal			HSS Powder Metal		
	TIN Coated			TIN Coated			X-Coated			TIN Coated		
	6H			6HX			6HX			6HX		
	Form C: 2-3			Form C: 2-3			Form C: 2-3			Form C: 2-3		
	3xD			3xD			3xD			3xD		
Coolant	Without Oil Grooves			With Oil Grooves			With Oil Grooves			With Oil Grooves		
	Performance			Performance			Performance			Performance		
Order Code	Order Code			Order Code			Order Code			Order Code		
ØD1	Pitch	L1	L2	L3	ØD2	K	Drill Dia.	Order Code	Order Code	Order Code	Order Code	Order Code
M2	0.4	8	45	13	2.8	2.1	1.83	TD723136	TD703136	-	-	-
M2.5	0.45	9	50	15	2.8	2.1	2.3	TD723176	TD703176	-	-	-
M3	0.5	11	56	18	3.5	2.7	2.8	TD723206	TD703206	-	-	-
M4	0.7	13	63	21	4.5	3.4	3.7	TD723246	TD703246	-	-	-
M5	0.8	15	70	25	6	4.9	4.65	TD723286	TD703286	-	-	-
M6	1	17	80	30	6	4.9	5.55	TD723316	TD703316	-	-	-
M8	1.25	20	90	35	8	6.2	7.4	TD723366	TD703366	-	-	-
M10	1.5	22	100	39	10	8	9.3	TD723426	TD703426	-	-	-
M12	1.75	24	110	44	9	7	11.2	TD723506	TD703506	-	-	-
M14	2	26	110	44	11	9	13	TD723546	TD703546	-	-	-
M16	2	27	110	44	12	9	15	TD723606	TD703606	-	-	-
M18	2.5	30	125	50	14	11	16.8	TD723656	TD703656	-	-	-
M20	2.5	32	140	54	16	12	18.8	TD723706	TD703706	-	-	-
M3	0.5	6	56	18	3.5	2.7	2.8	-	-	TRQ10206GS	TTS37206	-
M3.5	0.6	7.2	56	20	4	3	3.25	-	-	TRQ10226GS	-	-
M4	0.7	8.4	63	21	4.5	3.4	3.7	-	-	TRQ10246GS	TTS37246	-
M5	0.8	9.6	70	25	6	4.9	4.65	-	-	TRQ10286GS	TTS37286	-
M6	1.0	10	80	30	6	4.9	5.55	-	-	TRQ10316GS	TTS37316	-
M7	1.0	10	80	30	7	5.5	6.55	-	-	TRQ10346GS	-	-
M8	1.25	12	90	35	8	6.2	7.4	-	-	TRQ10366GS	TTS37366	-
M9	1.25	12	90	35	9	7	8.4	-	-	TRQ10396GS	-	-
M10	1.5	15	100	39	10	8	9.3	-	-	TRQ10426GS	TTS37426	-
M12	1.75	17	110	44	9	7	11.2	-	-	TRQ10506GS	TTS37506	-
M14	2.0	20	110	44	11	9	13	-	-	TRQ10546GS	-	-
M16	2.0	20	110	44	12	9	15	-	-	TRQ10606GS	-	-
M18	2.5	20	125	50	14	11	16.8	-	-	TRQ10656GS	-	-
M20	2.5	20	140	54	16	12	18.8	-	-	TRQ10706GS	-	-
M22	2.5	20	140	54	18	14.5	20.8	-	-	TRQ10746GS	-	-
M24	3.0	24	160	60	18	14.5	22.5	-	-	TRQ10786GS	-	-

Material Applications N/mm² 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	15-20	15-20	12-18	10-15			5-15	5-15						-		-	
TRQ10	15-40	15-30	15-30	5-20			7-10	5-8						-		-	
TTS37	15-20	15-20	12-18	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%					
TD723	-	8-12	-	-	8-12	-	15-20	-	10-15	25-35	15-20	-	-	-	-		
TD703																	
TRQ10																	
TTS37																	



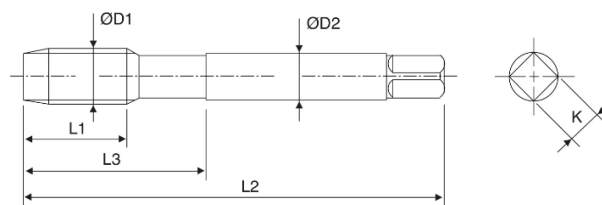
Synchro Taps

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	Order Code
M3	0.5	6	56	18	3.5	2.7	3	2.5	TTS31206	TTS33206
M4	0.7	7	63	21	4.5	3.4	3	3.3	TTS31246	TTS33246
M5	0.8	8	70	25	6	4.9	3	4.2	TTS31286	TTS33286
M6	1	10	80	30	6	4.9	3	5	TTS31316	TTS33316
M8	1.25	13	90	35	8	6.2	3	6.8	TTS31366	TTS33366
M10	1.5	15	100	39	10	8	3	8.5	TTS31426	TTS33426
M12	1.75	18	110	44	9	7	3	10.2	TTS31506	TTS33506
M14	2	20	110	44	11	9	3	12	TTS31546	TTS33546
M16	2	20	110	44	12	9	3	14	TTS31606	TTS33606
M18	2.5	25	125	50	14	11	4	15.5	TTS31656	TTS33656
M20	2.5	25	140	54	16	12	4	17.5	TTS31706	TTS33706

METRIC COARSE MACHINE TAPS

Material Applications N/mm² 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			
TTS31 TTS33	41-46	41-46	35-40	28-33	-	-	-	-	-	28-33	-	28-33	-	-	-			
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						
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	Thermo	Thermoset	CFRP/GFRP			
TTS31 TTS33	-	-	-	-	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
M3	0.5	11	56	3.5	2.7	3	2.5	HMIG110.M3X0.5.N
M4	0.7	13	63	4.5	3.4	3	3.3	HMIG110.M4X0.7.N
M5	0.8	16	70	6	4.9	4	4.2	HMIG110.M5X0.8.N
M6	1	19	80	6	4.9	4	5	HMIG110.M6X1.N
M8	1.25	22	90	8	6.2	4	6.8	HMIG110.M8X1.25.N
M10	1.5	24	100	10	8	4	8.5	HMIG110.M10X1.5.N
M12	1.75	28	110	9	7	5	10.25	HMIG120.M12X1.75.N
M14	2	30	110	11	9	5	12	HMIG120.M14X2.N
M16	2	32	110	12	9	5	14	HMIG120.M16X2.N
M20	2.5	34	140	16	12	5	17.5	HMIG120.M20X2.5.N

Material Applications N/mm² Cutting Speed m/min

● Excellent ○ Good

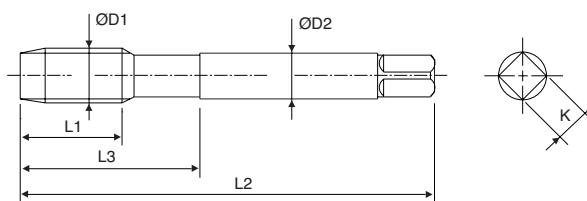
Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/ Graphite			Ti	Ti Alloy
	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
HMIG-N	-	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	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	Order Code
M2.5	0.45	6	56	18	3.5	2.7	3	2.65	TC909176	TC973176
M3	0.5	5	63	21	4.5	3.4	3	3.15	TC909206	TC973206
M3.5	0.6	8	70	25	6	4.9	3	3.7	TC909226	TC973226
M4	0.7	8	70	25	6	4.9	3	4.2	TC909246	TC973246
M5	0.8	8	80	30	6	4.9	3	5.25	TC909286	TC973286
M6	1	10	90	35	8	6.2	3	6.3	TC909316	TC973316
M8	1.25	16	100	39	10	8	3	8.4	TC909366	TC973366
M10	1.5	15	110	44	9	7	3	10.4	TC909426	TC973426
M12	1.75	20	110	44	11	9	3	12.5	TC909506	TC973506
M14	2	22	110	44	12	9	3	14.5	TC909546	TC973546
M16	2	25	125	50	14	11	4	16.5	TC909606	TC973606
M18	2.5	27	140	54	18	14.5	4	18.75	TC909656	TC973656
M20	2.5	30	160	60	18	14.5	4	20.75	TC909706	TC973706

METRIC COARSE MACHINE TAPS

Material Applications N/mm² Cutting Speed m/min

● Excellent ○ Good

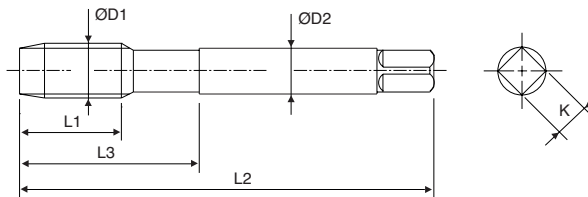
Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels		Carbon	Alloy	Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron		Malleable Cast Iron/Graphite		Ti	Ti Alloy
	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
TC909 TC973	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			
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	Thermo	Thermoset	CFRP/GFRP
TC909 TC973	-	-	-	-	8-12	-	-	15-20	-	10-15	10-15	10-15	-	-	-



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	Order Code	Order Code	Order Code
M4	0.5	10	63	21	2.8	2.1	3	3.5	TC844256	TD844256	TRE31256GS	-
M5	0.5	11	70	25	3.5	2.7	3	4.5	TC844296	TD844296	TRE31296GS	-
M6	0.75	13	80	30	4.5	3.4	3	5.2	TC844326	TD844326	TRE31326GS	TRE40326GS
M6	0.5	13	80	30	4.5	3.4	3	5.5	TC844336	TD844336	TRE31336GS	TRE40336GS
M7	0.75	14	80	30	5.5	4.3	3	6.2	TC844356	TD844356	-	-
M8	1	17	90	36	6	4.9	3	7	TC844376	TD844376	TRE31376GS	TRE40376GS
M8	0.75	14	80	36	6	4.9	3	7.2	TC844386	TD844386	TRE31386GS	TRE40386GS
M10	1.25	22	100	40	7	5.5	3	8.8	TC844436	TD844436	TRE31436GS	TRE40436GS
M10	1	18	90	40	7	5.5	3	9	TC844446	TD844446	TRE31446GS	TRE40446GS
M10	0.75	18	90	40	7	5.5	3	9.2	TC844456	TD844456	TRE31456GS	TRE40456GS
M12	1.5	22	100	40	9	7	3	10.5	TC844516	TD844516	TRE31516GS	TRE40516GS
M12	1.25	22	100	40	9	7	3	10.8	TC844526	TD844526	TRE31526GS	TRE40526GS
M12	1	18	100	40	9	7	3	11	TC844536	TD844536	TRE31536GS	TRE40536GS
M14	1.5	22	100	40	11	9	3	12.5	TC844556	TD844556	TRE31556GS	TRE40556GS
M14	1.25	22	100	40	11	9	3	12.8	TC844566	TD844566	TRE31566GS	TRE40566GS
M14	1	22	100	40	11	9	3	13	TC844576	TD844576	TRE31576GS	TRE40576GS
M16	1.5	22	100	40	12	9	3	14.5	TC844616	TD844616	TRE31616GS	TRE40616GS
M16	1	18	100	40	12	9	3	15	TC844626	TD844626	TRE31626GS	TRE40626GS
M18	1.5	25	110	44	14	11	4	16.5	TC844676	TD844676	TRE31676GS	TRE40676GS
M18	1	20	110	44	14	11	4	17	TC844686	TD844686	TRE31686GS	TRE40686GS
M20	1.5	25	125	50	16	12	4	18.5	TC844726	TD844726	TRE31726GS	TRE40726GS
M20	1	20	125	50	16	12	4	19	TC844736	TD844736	TRE31736GS	TRE40736GS
M22	1.5	25	125	50	18	14.5	4	20.5	TC844766	TD844766	TRE31766GS	TRE40766GS
M22	1	20	125	50	18	14.5	4	21	TC844776	TD844776	TRE31776GS	TRE40776GS
M24	2	27	140	54	18	14.5	4	22	TC844796	TD844796	TRE31796GS	TRE40796GS
M24	1.5	27	140	54	18	14.5	4	22.5	TC844806	TD844806	TRE31806GS	TRE40806GS
M26	1.5	28	140	54	18	14.5	4	24.5	TC844856	TD844856	-	-
M27	2	28	140	54	20	16	4	25	TC844876	TD844876	-	-
M27	1.5	28	140	54	20	16	4	25.5	TC844886	TD844886	-	-
M28	1.5	28	140	54	20	16	4	26.5	TC844916	TD844916	-	-
M30	2	30	150	57	22	18	4	28	TC844966	TD844966	-	-
M30	1.5	30	150	57	22	18	4	28.5	TC844976	TD844976	-	-

Material Applications N/mm² Cutting Speed m/min

☒ Excellent ☐ Good

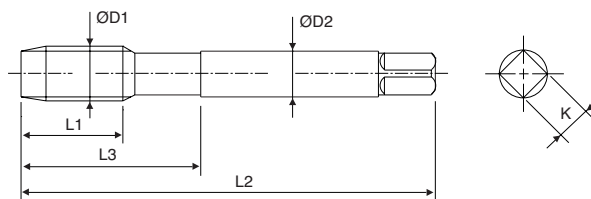
Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite			Ti	Ti Alloy
	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
TC844	15-20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



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



TC854

COMBO

PRIME X

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									5 stars	5 stars	5 stars	5 stars
ØD1	Pitch	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Order Code	Order Code	Order Code
M4	0.5	10	63	21	2.8	2.1	3	3.5	TC854256	TD854256	TRJ16256GS	-
M5	0.5	11	70	25	3.5	2.7	3	4.5	TC854296	TD854296	TRJ16296GS	-
M6	0.75	13	80	30	4.5	3.4	3	5.2	TC854326	TD854326	TRJ16326GS	TRJ25326GS
M6	0.5	13	80	30	4.5	3.4	3	5.5	TC854336	TD854336	TRJ16336GS	TRJ25336GS
M7	0.75	14	80	30	5.5	4.3	3	6.2	TC854356	TD854356	-	-
M8	1	17	90	36	6	4.9	3	7	TC854376	TD854376	TRJ16376GS	TRJ25376GS
M8	0.75	14	80	36	6	4.9	3	7.2	TC854386	TD854386	TRJ16386GS	TRJ25386GS
M10	1.25	22	100	40	7	5.5	3	8.8	TC854436	TD854436	TRJ16436GS	TRJ25436GS
M10	1	18	90	40	7	5.5	3	9	TC854446	TD854446	TRJ16446GS	TRJ25446GS
M10	0.75	18	90	40	7	5.5	3	9.2	TC854456	TD854456	TRJ16456GS	TRJ25456GS
M12	1.5	22	100	40	9	7	3	10.5	TC854516	TD854516	TRJ16516GS	TRJ25516GS
M12	1.25	22	100	40	9	7	3	10.8	TC854526	TD854526	TRJ16526GS	TRJ25526GS
M12	1	18	100	40	9	7	3	11	TC854536	TD854536	TRJ16536GS	TRJ25536GS
M14	1.5	22	100	40	11	9	3	12.5	TC854556	TD854556	TRJ16556GS	TRJ25556GS
M14	1.25	22	100	40	11	9	3	12.8	TC854566	TD854566	TRJ16566GS	TRJ25566GS
M14	1	22	100	40	11	9	3	13	TC854576	TD854576	TRJ16576GS	TRJ25576GS
M16	1.5	22	100	40	12	9	3	14.5	TC854616	TD854616	TRJ16616GS	TRJ25616GS
M16	1	18	100	40	12	9	3	15	TC854626	TD854626	TRJ16626GS	TRJ25626GS
M18	1.5	25	110	44	14	11	4	16.5	TC854676	TD854676	TRJ16676GS	TRJ25676GS
M18	1	20	110	44	14	11	4	17	TC854686	TD854686	TRJ16686GS	TRJ25686GS
M20	1.5	25	125	50	16	12	4	18.5	TC854726	TD854726	TRJ16726GS	TRJ25726GS
M20	1	20	125	50	16	12	4	19	TC854736	TD854736	TRJ16736GS	TRJ25736GS
M22	1.5	25	125	50	18	14.5	4	20.5	TC854766	TD854766	TRJ16766GS	TRJ25766GS
M22	1	20	125	50	18	14.5	4	21	TC854776	TD854776	TRJ16776GS	TRJ25776GS
M24	2	27	140	54	18	14.5	4	22	TC854796	TD854796	TRJ16796GS	TRJ25796GS
M24	1.5	27	140	54	18	14.5	4	22.5	TC854806	TD854806	TRJ16806GS	TRJ25806GS
M26	1.5	28	140	54	18	14.5	4	24.5	TC854856	TD854856	-	-
M27	2	28	140	54	20	16	4	25	TC854876	TD854876	-	-
M27	1.5	28	140	54	20	16	4	25.5	TC854886	TD854886	-	-
M28	1.5	28	140	54	20	16	4	26.5	TC854916	TD854916	-	-
M30	2	30	150	57	22	18	4	28	TC854966	TD854966	-	-
M30	1.5	30	150	57	22	18	4	28.5	TC854976	TD854976	-	-

Material Applications N/mm² Cutting Speed m/min

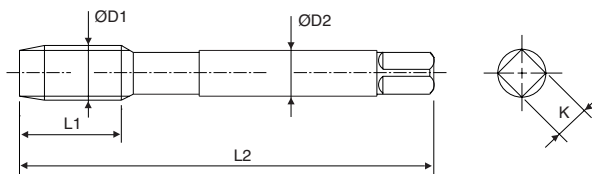
Excellent ○ Good

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		-	-	-	10-15	5-8	10-15	5-8	10-15	
TD844															
TRJ16	20-30	20-30	20-25	15-20	5-12		7-10	5-8	4-6						
TRJ25															
	Titanium	Inconel, Hastelloy, Nickel			Copper, Brass, Bronze					Aluminium			Plastics / Composites		
Series	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	Order Code
Spiral Point									
M8	1	18	90	6	4.9	3	7	K25MF8X1TXC	-
M10	1	15	90	7	5.5	3	9	K25MF10X1TXC	-
M10	1.25	20	100	7	5.5	3	8.75	K25MF10X1.25TXC	-
M12	1.25	22	100	9	7	4	10.75	K25MF12X1.25TXC	-
M12	1.5	22	100	9	7	4	10.5	K25MF12X1.5TXC	-
M14	1.5	22	100	11	9	4	12.5	K25MF14X1.5TXC	-
M16	1.5	22	100	12	9	4	14.5	K25MF16X1.5TXC	-
Spiral Flute									
M8	1	13	90	6	4.9	3	7	-	K81MF8X1TXC
M10	1	15	90	7	5.5	3	9	-	K81MF10X1TXC
M10	1.25	15	100	7	5.5	3	8.75	-	K81MF10X1.25TXC
M12	1.25	13	100	9	7	4	10.75	-	K81MF12X1.25TXC
M12	1.5	13	100	9	7	4	10.5	-	K81MF12X1.5TXC
M14	1.5	15	100	11	9	4	12.5	-	K81MF14X1.5TXC
M16	1.5	15	100	12	9	4	14.5	-	K81MF16X1.5TXC

Material Applications N/mm² 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
K25MF-TXC K81MF-TXC	-	-	-	15-20	5-12	5-8	-	-	-	-	-	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%			
K25MF-TXC K81MF-TXC	-	-	-	-	-	25-30	-	-	-	-	-	20-25	-	-	-

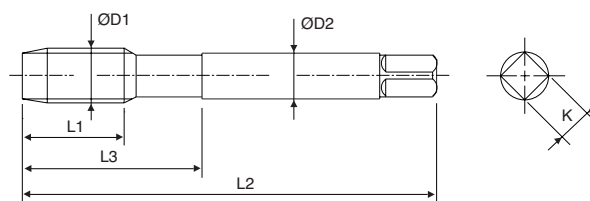


Long Chipping
Steels

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	

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

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/mm² 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		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/GFR
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%			
TDE25															

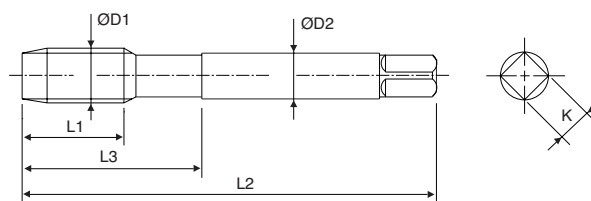


INOX

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	

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

Material Applications N/mm² 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	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
V24MF	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		
	Ti Alloy	Nickel	Nickel Alloy		Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al		Thermo	Thermoset	CFRP/GFRP
TB183	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	-
V24MF	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

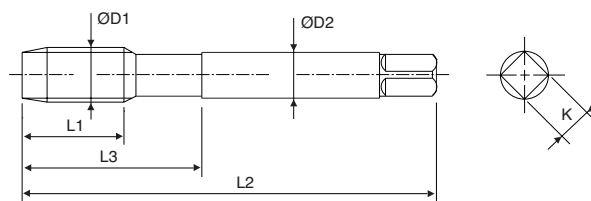


INOX

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	● ● ● ● ● ●

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

METRIC FINE MACHINE TAPS

Material Applications N/mm² 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	-	15-20	-	10-15	-	-	7-10	5-8	-	-	-	-	-	-	-
Series	Titanium				Inconel, Hastelloy, Nickel				Copper, Brass, Bronze				Aluminium		
	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	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

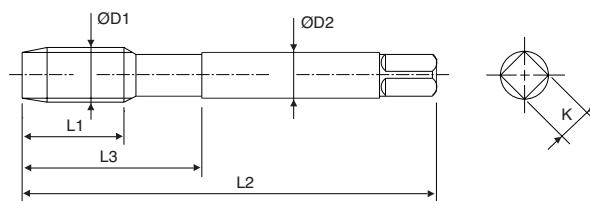


GG

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	

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

Material Applications N/mm² Cutting Speed m/min

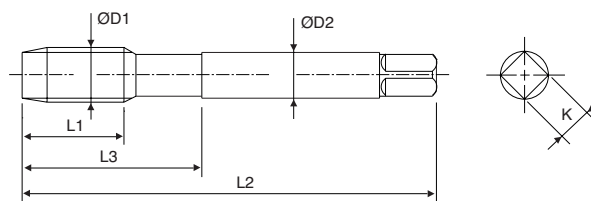
● Excellent ○ Good

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
TE403	-	-	-	-	-	-	-	-	-	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%	-	-	-
TE403	-	-	-	-	-	25-35	-	-	-	-	-	-	-	-	5-7


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	Order Code
M8	1	13	90	8	6.2	3	7	K42MF8X1CT	-
M10	1	15	100	10	8	3	9	K42MF10X1CT	-
M10	1.25	15	100	10	8	3	8.75	K42MF10X1.25CT	-
M12	1.25	13	100	9	7	4	10.75	K43MF12X1.25CT	-
M12	1.5	13	100	9	7	4	10.5	K43MF12X1.5CT	-
M14	1.5	15	100	11	9	4	12.5	K43MF14X1.5CT	-
M16	1.5	15	100	12	9	4	14.5	K43MF16X1.5CT	-
M8	1	18	90	8	6.2	3	7	-	K52MF8X1CT
M10	1	20	100	10	8		9	-	K52MF10X1CT
M10	1.25	20	100	10	8		8.75	-	K52MF10X1.25CT
M12	1.25	22	100	9	7		10.75	-	K53MF12X1.25CT
M12	1.5	22	100	9	7		10.5	-	K53MF12X1.5CT
M14	1.5	22	100	11	9		12.5	-	K53MF14X1.5CT
M16	1.5	22	100	12	9		14.5	-	K53MF16X1.5CT

METRIC FINE MACHINE TAPS

Material Applications N/mm² 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			
K42MF 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						
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	Thermo	Thermoset	CFRP/GFRP			
K42MF K52MF	2-4	-	2-4	-	-	25-30	-	5-8	-	-	-	25-30	-	-	-			



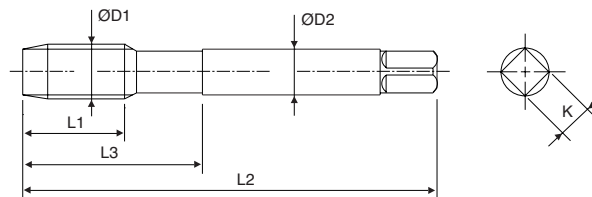
Forming Roll Taps

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 ROLL



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
M6	0.75	10	80	30	4.5	3.4	5.65	TRQ11326GS
M6	0.5	10	80	30	4.5	3.4	5.75	TRQ11336GS
M8	1.0	12	90	36	6	4.9	7.5	TRQ11376GS
M8	0.75	12	80	30	6	4.9	7.65	TRQ11386GS
M10	1.25	15	100	40	7	5.5	9.4	TRQ11436GS
M10	1.0	15	90	36	7	5.5	9.5	TRQ11446GS
M10	0.75	15	90	36	7	5.5	9.65	TRQ11456GS
M12	1.5	17	100	40	9	7	11.25	TRQ11516GS
M12	1.25	17	100	40	9	7	11.4	TRQ11526GS
M12	1.0	17	100	40	9	7	11.5	TRQ11536GS
M14	1.5	20	100	40	11	9	13.25	TRQ11556GS
M14	1.25	20	100	40	11	9	13.4	TRQ11566GS
M14	1.0	20	100	40	11	9	13.5	TRQ11576GS
M16	1.5	20	100	40	12	9	15.25	TRQ11616GS
M16	1.0	20	100	40	12	9	15.5	TRQ11626GS
M18	2.0	20	125	50	14	11	17	TRQ11666GS
M18	1.5	15	110	44	14	11	17.25	TRQ11676GS
M18	1.0	10	110	44	14	11	17.5	TRQ11686GS
M20	2.0	20	140	54	16	12	19	TRQ11716GS
M20	1.5	15	125	50	16	12	19.25	TRQ11726GS
M20	1.0	10	125	50	16	12	19.5	TRQ11736GS
M22	1.5	15	125	50	18	14.5	21.25	TRQ11766GS
M24	1.5	15	140	54	18	14.5	23.25	TRQ11806GS

Material Applications N/mm² 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
	15-40	15-30	15-30	5-20	-	-	5-15	5-15	-	-	-	-	-	-	-
Series	Titanium				Inconel, Hastelloy, Nickel				Copper, Brass, Bronze				Aluminium		
	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%	-	-	-
	-	-	-	-	10-30	10-30	10-30	20-40	-	20-50	20-50	20-50	-	-	-



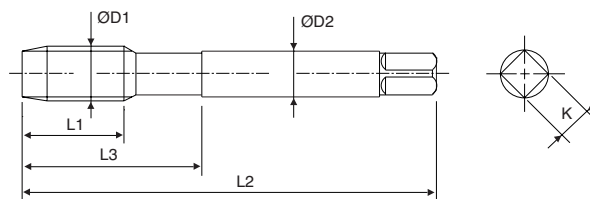
Synchro Taps

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	Order Code
M8	1	10	90	36	6	4.9	3	7	TTS32376	TTS34376
M10	1.25	13	100	40	7	5.5	3	8.75	TTS32436	TTS34436
M10	1	10	90	40	7	5.5	3	9	TTS32446	TTS34446
M12	1.5	15	100	40	9	7	4	10.5	TTS32516	TTS34516
M12	1.25	13	100	40	9	7	4	10.75	TTS32526	TTS34526
M14	1.5	15	100	40	11	9	4	12.5	TTS32556	TTS34556
M16	1.5	15	100	40	12	9	4	14.5	TTS32616	TTS34616
M18	1.5	17	110	44	14	11	4	16.5	TTS32676	TTS34676
M20	1.5	17	125	50	16	12	4	18.5	TTS32726	TTS34726

Material Applications N/mm² Cutting Speed m/min

☒ Excellent ☐ Good

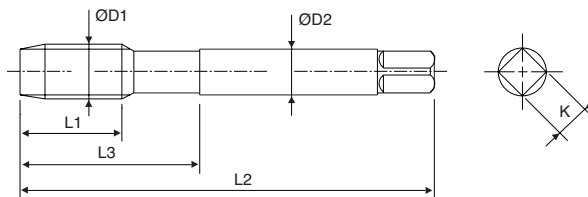
Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels		Carbon	Alloy	Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron		Malleable Cast Iron/Graphite		Ti	Ti Alloy
	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
TTS32	41-46	41-46	35-40	-	-	-	18-23	13-18	10-14	28-33	-	-	-	-	-
TTS34															
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			
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	Thermo	Thermoset	CFRP/GFRP
TTS32	-	-	-	-	-	25-30	-	41-46	-	-	-	-	-	-	-
TTS34															



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	Order Code	Order Code
No.4	40	11	56	18	3.5	2.7	3	2.3	TC824162	TD824162	TRE32162GS
No.5	40	11	56	18	3.5	2.7	3	2.6	TC824202	TD824202	TRE32202GS
No.6	32	12	56	20	4	3	3	2.85	TC824242	TD824242	TRE32242GS
No.8	32	13	63	21	4.5	3.4	3	3.5	TC824282	TD824282	TRE32282GS
No.10	24	15	70	25	6	4.9	3	3.9	TC824322	TD824322	TRE32322GS
No.12	24	16	80	30	6	4.9	3	4.5	TC824362	TD824362	TRE32362GS
1/4	20	17	80	30	7	5.5	3	5.2	TC824402	TD824402	TRE32402GS
5/16	18	20	90	35	8	6.2	3	6.6	TC824442	TD824442	TRE32442GS
3/8	16	22	100	39	9	7	3	8	TC824482	TD824482	TRE32482GS
7/16	14	22	100	40	8	6.2	3	9.4	TC824522	TD824522	TRE32522GS
1/2	13	25	110	44	9	7	3	10.75	TC824562	TD824562	TRE32562GS
9/16	12	26	110	44	11	9	3	12.25	TC824602	TD824602	TRE32602GS
5/8	11	27	110	44	12	9	3	13.5	TC824642	TD824642	TRE32642GS
3/4	10	30	125	50	14	11	4	16.5	TC824702	TD824702	TRE32702GS
7/8	9	32	140	54	18	14.5	4	19.5	TC824742	TD824742	TRE32742GS
1"	8	36	160	60	20	16	4	22.25	TC824782	TD824782	TRE32782GS

Material Applications N/mm² Cutting Speed m/min

● Excellent ○ Good

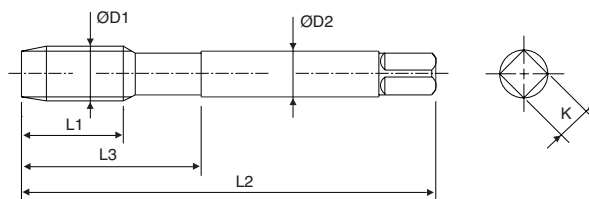
Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels		Carbon	Alloy	Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron		Malleable Cast Iron/Graphite		Ti	Ti Alloy
	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
TC824	15-20	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		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			
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	Thermo	Thermoset	CFRP/GFRP
TC824		8-12	-	-	8-12	25-35	15-20	-	-	25-35	15-20	10-15	-	-	-
TD824	-		-					-	-				-	-	-
TRE32	-	-	-		-	-	20-25			25-30	20-25	-			



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



TC834

TD834

TRJ17

Series	TC834	TD834	TRJ17
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	3xD
Through Coolant	-	-	-
Performance			

ØD1	TPI	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Order Code	Order Code
No.4	40	11	56	18	3.5	2.7	3	2.3	TC834162	TD834162	TRJ17162GS
No.5	40	11	56	18	3.5	2.7	3	2.6	TC834202	TD834202	TRJ17202GS
No.6	32	12	56	20	4	3	3	2.85	TC834242	TD834242	TRJ17242GS
No.8	32	13	63	21	4.5	3.4	3	3.5	TC834282	TD834282	TRJ17282GS
No.10	24	15	70	25	6	4.9	3	3.9	TC834322	TD834322	TRJ17322GS
No.12	24	16	80	30	6	4.9	3	4.5	TC834362	TD834362	TRJ17362GS
1/4	20	17	80	30	7	5.5	3	5.2	TC834402	TD834402	TRJ17402GS
5/16	18	20	90	35	8	6.2	3	6.6	TC834442	TD834442	TRJ17442GS
3/8	16	22	100	39	9	7	3	8	TC834482	TD834482	TRJ17482GS
7/16	14	22	100	40	8	6.2	3	9.4	TC834522	TD834522	TRJ17522GS
1/2	13	25	110	44	9	7	3	10.75	TC834562	TD834562	TRJ17562GS
9/16	12	26	110	44	11	9	3	12.25	TC834602	TD834602	TRJ17602GS
5/8	11	27	110	44	12	9	3	13.5	TC834642	TD834642	TRJ17642GS
3/4	10	30	125	50	14	11	4	16.5	TC834702	TD834702	TRJ17702GS
7/8	9	32	140	54	18	14.5	4	19.5	TC834742	TD834742	TRJ17742GS
1"	8	36	160	60	20	16	4	22.25	TC834782	TD834782	TRJ17782GS

UNC MACHINE TAPS

Material Applications N/mm² 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		Wrought	Si ≤10%	Si >10%	Thermo	Thermoset	CFRP/GFRP
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350									
TC834	-	8-12	-	-	8-12	25-35	15-20	-	-	25-35	15-20	10-15	-	-	-	-	-	-
TD834	-	-	-	-	-	-	20-25	-	-	25-30	20-25	-	-	-	-	-	-	-
TRJ17	-	-	-	-	-	-	20-25	-	-	25-30	20-25	-	-	-	-	-	-	-

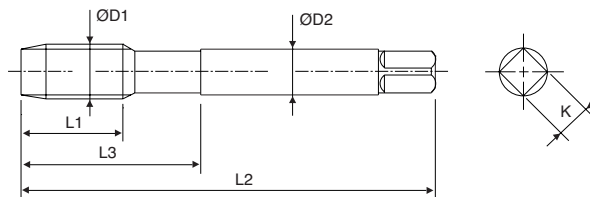


INOX

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		

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

Material Applications N/mm² 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			
TB904	20-25	20-25	18-24	15-20	-	-	10-13	8-11	6-8	-	-	-	-	-	-			
V82UNC	-	-	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			
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%						
TB904	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-			
V82UNC	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-			

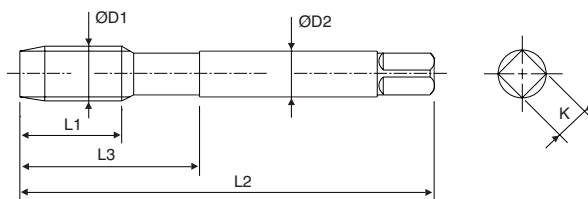


INOX

Stainless Steel

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

- 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 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		

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

Material Applications N/mm² 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
TB264	20-25	20-25	18-24	15-20	-	-	10-13	8-11	-	-	-	-	-	-	-
V24UNC	-	-	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			
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	Thermo	Thermoset	CFRP/GFRP
TB264	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
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	

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

Material Applications N/mm² Cutting Speed m/min

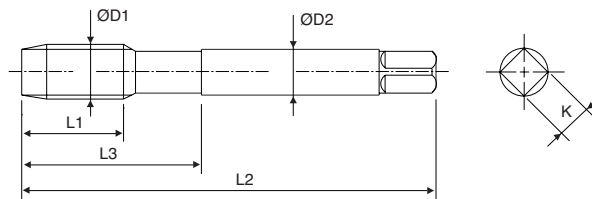
● Excellent ○ Good

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	Order Code
No.10	24	8	70	6	4.9	3	3.9	K42UNC10-24CT	-
1/4	20	10	80	7	5.5	3	5.1	K42UNC1/4CT	-
5/16	18	13	90	8	6.2	3	6.6	K42UNC5/16CT	-
3/8	16	15	100	10	8	3	8	K42UNC3/8CT	-
7/16	14	15	100	8	6.2	4	9.4	K43UNC7/16CT	-
1/2	13	18	110	9	7	4	10.8	K43UNC1/2CT	-
5/8	11	20	110	12	9	4	13.5	K43UNC5/8CT	-
3/4	10	25	125	14	11	4	16.5	K43UNC3/4CT	-
No.10	24	13	70	6	4.9	3	3.9	-	K52UNC10-24CT
1/4	20	16	80	7	5.5	3	5.1	-	K52UNC1/4CT
5/16	18	18	90	8	6.2	3	6.6	-	K52UNC5/16CT
3/8	16	20	100	10	8	3	8	-	K52UNC3/8CT
7/16	14	20	100	8	6.2	3	9.4	-	K53UNC7/16CT
1/2	13	25	110	9	7	3	10.8	-	K53UNC1/2CT
5/8	11	28	110	12	9	3	13.5	-	K53UNC5/8CT
3/4	10	32	125	14	11	4	16.5	-	K53UNC3/4CT

Material Applications N/mm² 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			
K42UNC K52UNC	-	-	-	-	-	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			
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%						
K42UNC K52UNC	2-4	-	2-4	-	-	25-30	-	5-8	-	-	-	25-30	-	-	-	-		



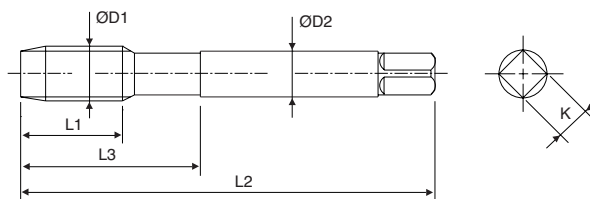
Forming Roll Taps

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
No.4	40	7.6	56	18	3.5	2.7	4	2.6	TRQ18162GS
No.5	40	7.6	56	18	3.5	2.7	4	2.9	TRQ18202GS
No.6	32	9.5	56	20	4	3	4	3.15	TRQ18242GS
No.8	32	9.5	63	21	4.5	3.4	4	3.8	TRQ18282GS
No.10	24	12.7	70	25	6	4.9	5	4.3	TRQ18322GS
No.12	24	12.7	80	30	6	4.9	5	4.95	TRQ18362GS
1/4	20	12.7	80	30	7	5.5	5	5.7	TRQ18402GS
5/16	18	14.1	90	35	8	6.2	5	7.2	TRQ18442GS
3/8	16	15.9	100	39	9	7	8	8.7	TRQ18482GS
7/16	14	18.1	100	40	8	6.2	8	10.2	TRQ18522GS
1/2	13	19.5	110	44	9	7	8	11.7	TRQ18562GS
9/16	12	21.2	110	44	11	9	8	13.2	TRQ18602GS
5/8	11	23.1	110	44	12	9	8	14.7	TRQ18642GS
3/4	10	20.3	125	50	14	11	8	17.8	TRQ18702GS
7/8	9	22.6	140	54	18	14.5	8	20.8	TRQ18742GS
1"	8	25.4	160	60	20	16	8	23.8	TRQ18782GS

Material Applications N/mm² Cutting Speed m/min

● Excellent ○ Good

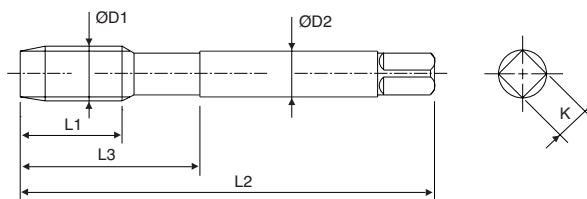
Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels		Carbon	Alloy	Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite		Ti	Ti Alloy	
	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
TRQ18	15-40	15-30	15-30	5-20	-	-	5-15	5-15	-	-	-	-	-	-	-
Series	Titanium		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%	-	-	-
TRQ18	-	-	-	-	10-30	10-30	10-30	20-40	-	20-50	20-50	20-50	-	-	-



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		

ØD1	TPI	L1	L2	L2	ØD2	K	No. of Flutes	Drill Dia.	Order Code	Order Code
No.4	40	7	63	21	4.5	3.4	3	3.1	TC944162	TC934162
No.5	40	7	63	21	4.5	3.4	3	3.4	TC944202	TC934202
No.6	32	8	70	25	6	4.9	3	3.8	TC944242	TC934242
No.8	32	8	80	25	6	4.9	3	4.4	TC944282	TC934282
No.10	24	10	80	30	7	5.5	3	5.2	TC944322	TC934322
No.12	24	10	80	30	7	5.5	3	5.8	TC944362	TC934362
1/4	20	14	90	35	8	6.2	3	6.7	TC944402	TC934402
5/16	18	16	100	39	10	8	3	8.4	TC944442	TC934442
3/8	16	16	110	39	12	9	3	10	TC944482	TC934482
7/16	14	20	110	44	11	9	3	11.6	TC944522	TC934522
1/2	13	22	110	44	12	9	3	13.3	TC944562	TC934562
9/16	12	22	125	50	14	11	3	15	TC944602	TC934602
5/8	11	25	125	50	14	11	4	16.5	TC944642	TC934642
3/4	10	27	140	56	18	14.5	4	19.75	TC944702	TC934702

UNC MACHINE TAPS

Material Applications N/mm² Cutting Speed m/min

● Excellent ○ Good

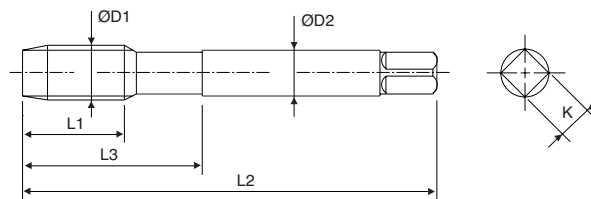
Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels		Carbon	Alloy	Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron		Malleable Cast Iron/Graphite		Ti	Ti Alloy
	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
TC944 TC934	15-20	15-20	12-18	-	-	-	-	-	-	-	-	-	-	-	-
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
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%			
TC944 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.		Order Code	Order Code	Order Code
No.4	48	11	56	18	3.5	2.7	3	2.4		TC864182	TD864182	TRE33182GS
No.5	44	11	56	18	3.5	2.7	3	2.7		TC864222	TD864222	TRE33222GS
No.6	40	12	56	20	4	3	3	3		TC864262	TD864262	TRE33262GS
No.8	36	13	63	21	4.5	3.4	3	3.5		TC864302	TD864302	TRE33302GS
No.10	32	15	70	25	6	4.9	3	4.1		TC864342	TD864342	TRE33342GS
No.12	28	16	80	30	6	4.9	3	4.7		TC864382	TD864382	TRE33382GS
1/4	28	17	80	30	7	5.5	3	5.5		TC864422	TD864422	TRE33422GS
5/16	24	17	90	35	8	6.2	3	6.9		TC864462	TD864462	TRE33462GS
3/8	24	18	100	39	9	7	3	8.5		TC864502	TD864502	TRE33502GS
7/16	20	22	100	40	8	6.2	3	9.9		TC864542	TD864542	TRE33542GS
1/2	20	22	100	40	9	7	3	11.5		TC864582	TD864582	TRE33582GS
9/16	18	22	100	40	11	9	3	12.9		TC864622	TD864622	TRE33622GS
5/8	18	22	100	40	12	9	3	14.5		TC864662	TD864662	TRE33662GS
3/4	16	25	110	44	14	11	4	17.5		TC864722	TD864722	TRE33722GS
7/8	14	26	125	50	18	14.5	4	20.5		TC864762	TD864762	TRE33762GS
1"	12	28	140	54	20	16	4	23.25		TC864802	TD864802	TRE33802GS

Material Applications N/mm² Cutting Speed m/min

● Excellent ○ Good

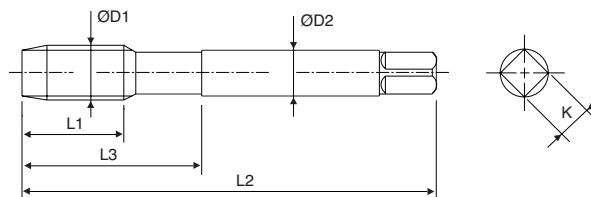
Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium				
	Soft Steels		Carbon	Alloy	Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite			Ti	Ti Alloy			
	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900			
TC864	15-20	15-20	12-18	10-15	6-10	-	-	-	-	10-15	5-8	10-15	5-8	10-15	-			
TD864	20-30	20-30	20-25		-	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				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%						
TC864		8-12	-	-	8-12	25-35	15-20			25-35	15-20	10-15				-	-	
TD864	-		-	-				-	-							-	-	
TRE33		-			-	-	20-25			25-30	20-25	-						



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	Order Code	Order Code
No.4	48	11	56	18	3.5	2.7	3	2.4	TC874182	TD874182	TRJ18182GS
No.5	44	11	56	18	3.5	2.7	3	2.7	TC874222	TD874222	TRJ18222GS
No.6	40	12	56	20	4	3	3	3	TC874262	TD874262	TRJ18262GS
No.8	36	13	63	21	4.5	3.4	3	3.5	TC874302	TD874302	TRJ18302GS
No.10	32	15	70	25	6	4.9	3	4.1	TC874342	TD874342	TRJ18342GS
No.12	28	16	80	30	6	4.9	3	4.7	TC874382	TD874382	TRJ18382GS
1/4	28	17	80	30	7	5.5	3	5.5	TC874422	TD874422	TRJ18422GS
5/16	24	17	90	35	8	6.2	3	6.9	TC874462	TD874462	TRJ18462GS
3/8	24	18	100	39	9	7	3	8.5	TC874502	TD874502	TRJ18502GS
7/16	20	22	100	40	8	6.2	3	9.9	TC874542	TD874542	TRJ18542GS
1/2	20	22	100	40	9	7	3	11.5	TC874582	TD874582	TRJ18582GS
9/16	18	22	100	40	11	9	3	12.9	TC874622	TD874622	TRJ18622GS
5/8	18	22	100	40	12	9	3	14.5	TC874662	TD874662	TRJ18662GS
3/4	16	25	110	44	14	11	4	17.5	TC874722	TD874722	TRJ18722GS
7/8	14	26	125	50	18	14.5	4	20.5	TC874762	TD874762	TRJ18762GS
1"	12	28	140	54	20	16	4	23.25	TC874802	TD874802	TRJ18802GS

UNF MACHINE TAPS

Material Applications N/mm² 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			
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	Thermo	Thermoset	CFRP/GFRP
TC834		8-12	-	-	8-12	25-35	15-20	-	-	25-35	15-20	10-15			
TD834	-		-					-	-				-	-	-
TRJ17		-			-	-	20-25			25-30	20-25	-			

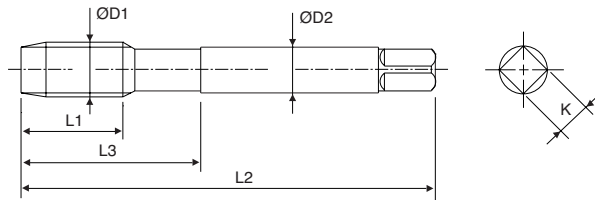


INOX

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										
ØD1	TPI	L1	L2	ØD2	K	No. of Flutes	Drill Dia.		Order Code	Order Code
No.10	32	10	70	6	4.9	3	4.1		TB924342	-
No.12	28	10	80	6	4.9	3	4.7		TB924382	-
1/4	28	10	80	7	5.5	3	5.5		TB924422	-
5/16	24	10	90	8	6.2	3	6.9		TB924462	-
3/8	24	10	100	9	7	3	8.5		TB924502	-
7/16	20	13	100	8	6.2	3	9.9		TB924542	-
1/2	20	13	100	9	7	3	11.5		TB924582	-
9/16	18	15	100	11	9	3	12.9		TB924622	-
5/8	18	15	100	12	9	3	14.5		TB924662	-
3/4	16	17	110	14	11	3	17.5		TB924722	-
7/8	14	17	125	18	14.5	4	20.5		TB924762	-
No.6	40	7	56	4	3	3	2.95		-	V82UNF640TXC
No.8	36	7	63	4.5	3.4	3	3.5		-	V82UNF836TXC
No.10	32	8	70	6	4.9	3	4.1		-	V82UNF1032TXC
1/4	28	10	80	7	5.5	3	5.5		-	V82UNF1/4TXC
3/8	24	15	90	7	5.5	3	8.5		-	V83UNF3/8TXC
7/16	20	15	100	8	6.2	3	9.9		-	V83UNF7/16TXC
1/2	20	13	100	9	7	4	11.5		-	V83UNF1/2TXC
9/16	18	15	100	11	9	4	12.9		-	V83UNF9/16TXC
5/8	18	15	100	12	9	4	14.5		-	V83UNF5/8TXC
3/4	16	17	110	14	11	4	17.5		-	V83UNF3/4TXC

Material Applications N/mm² 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		
	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	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

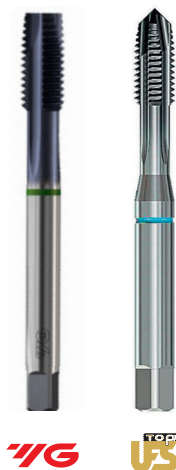
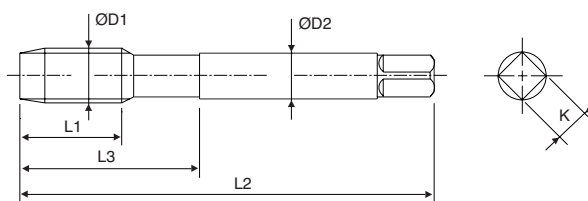


INOX

Stainless Steel

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

- 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 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		

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

Material Applications N/mm² 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
TB274	20-25	20-25	18-24	15-20	-	-	10-13	8-11	6-8	-	-	-	-	-	-
V25UNF	-	-	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			
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	Thermo	Thermoset	CFRP/GFRP
TB274	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
V25UNF	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

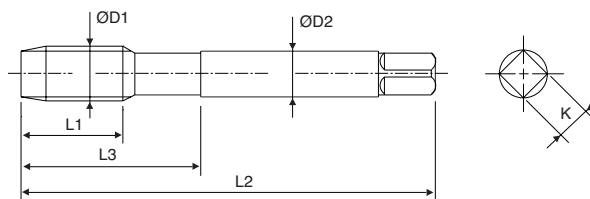


GG

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	

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

Material Applications N/mm² 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
TE454	-	-	-	-	-	-	-	-	-	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%	-	-	-
TE454	-	-	-	-	-	25-35	-	-	-	-	-	-	-	-	5-7



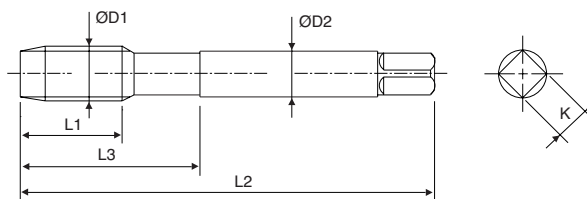
Forming Roll Taps

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



PRIME X



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
No.4	48	7.6	56	18	3.5	2.7	4	2.6	TRQ19182GS
No.5	44	7.6	56	18	3.5	2.7	4	2.9	TRQ19222GS
No.6	40	9.5	56	20	4	3	4	3.25	TRQ19262GS
No.8	36	9.5	63	21	4.5	3.4	4	3.9	TRQ19302GS
No.10	32	12.7	70	25	6	4.9	5	4.45	TRQ19342GS
No.12	28	12.7	80	30	6	4.9	5	5.05	TRQ19382GS
1/4	28	12.7	80	30	7	5.5	5	5.9	TRQ19422GS
5/16	24	14.1	90	35	8	6.2	5	7.4	TRQ19462GS
3/8	24	15.9	100	39	9	7	8	9	TRQ19502GS
7/16	20	18.1	100	40	8	6.2	8	10.5	TRQ19542GS
1/2	20	19.5	100	40	9	7	8	12.1	TRQ19582GS
9/16	18	21.2	100	40	11	9	8	13.6	TRQ19622GS
5/8	18	23.1	100	40	12	9	8	15.2	TRQ19662GS
3/4	16	15.9	110	44	14	11	8	18.3	TRQ19722GS
7/8	14	18.1	125	50	18	14.5	8	21.3	TRQ19762GS
1"	12	21.2	140	54	20	16	8	24.3	TRQ19802GS

UNF MACHINE TAPS

Material Applications N/mm² 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
TRQ19	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
	15-40	15-30	15-30	5-20	-	-	5-15	5-15	-	-	-	-	-	-	-
Series	Titanium				Inconel, Hastelloy, Nickel				Copper, Brass, Bronze				Aluminium		
	Ti Alloy	Nickel	Nickel Alloy		Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al		Thermo	Thermoset	CFRP/GFRP
TRQ19	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	-
	-	-	-	-	10-30	10-30	10-30	20-40	-	20-50	20-50	20-50	-	-	-

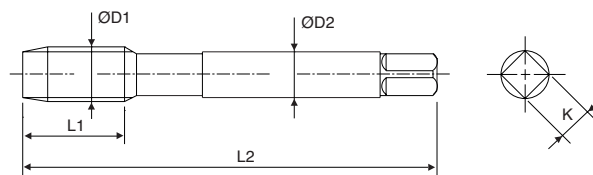


Multi Purpose

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
- BRIGHT 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		

ØD1	TPI	L1	L2	ØD2 h9	K h12	No. of Flutes	Drill Dia.	Order Code	Order Code
Spiral Point									
1/4	32	16	80	4.5	3.4	3	5.55	E25UNEf1/4	-
5/16	32	18	90	6	4.9	3	7.15	E25UNEf5/16	-
3/8	32	15	90	7	5.5	3	8.7	E25UNEf3/8	-
7/16	28	20	100	8	6.2	3	10.2	E25UNEf7/16	-
1/2	28	20	100	9	7	3	11.8	E25UNEf1/2	-
9/16	24	22	100	11	9	4	13.2	E25UNEf9/16	-
5/8	24	22	100	12	9	4	14.8	E25UNEf5/8	-
11/16	24	25	110	14	11	4	16.4	E25UNEf11/16	-
3/4	20	25	110	14	11	4	17.8	E25UNEf3/4	-
13/16	20	25	125	18	14.5	4	19.4	E25UNEf13/16	-
7/8	20	25	125	18	14.5	4	20.95	E25UNEf7/8	-
Spiral Flute									
1/4	32	10	80	4.5	3.4	3	5.55	-	E61UNEf1/4
5/16	32	13	90	6	4.9	3	7.15	-	E61UNEf5/16
3/8	32	15	90	7	5.5	3	8.7	-	E61UNEf3/8
7/16	28	15	100	8	6.2	3	10.2	-	E61UNEf7/16
1/2	28	13	100	9	7	3	11.8	-	E61UNEf1/2
9/16	24	15	100	11	9	4	13.2	-	E61UNEf9/16
5/8	24	15	100	12	9	4	14.8	-	E61UNEf5/8
11/16	24	17	110	14	11	4	16.4	-	E61UNEf11/16
3/4	20	17	110	14	11	4	17.8	-	E61UNEf3/4
13/16	20	18	125	18	14.5	4	19.4	-	E61UNEf13/16
7/8	20	18	125	18	14.5	4	20.95	-	E61UNEf7/8

Material Applications N/mm² 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
E25UNEF E61UNEF	10-15	10-15	10-12	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%			
E25UNEF E61UNEF	-	-	-	-	8-12	-	10-15	-	10-15	-	15-20	-	-	-	-

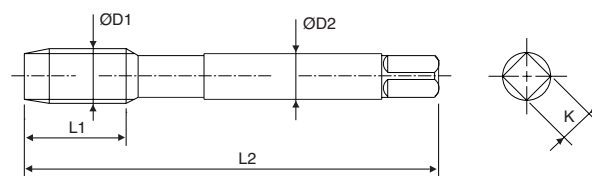


Multi Purpose

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
No.10	48	13	70	6	4.9	3	4.3	E20-48UNS10
No.10	40	13	70	6	4.9	3	4.2	E20-40UNS10
No.12	36	16	80	6	4.9	3	4.8	E20-36UNS12
1/4	40	16	80	7	5.5	3	5.7	E20-40UNS1/4
1/4	36	16	80	7	5.5	3	5.6	E20-36UNS1/4
1/4	24	16	80	7	5.5	3	5.3	E20-24UNS1/4
5/16	40	18	90	6	4.9	3	7.3	E21-40UNS5/16
3/8	40	15	90	7	5.5	3	8.9	E21-40UNS3/8
3/8	27	15	90	7	5.5	3	8.6	E21-27UNS3/8
3/8	18	20	100	7	5.5	3	8.1	E21-18UNS3/8
7/16	27	20	100	8	6.2	3	10.2	E21-27UNS7/16
7/16	24	20	100	8	6.2	3	10.05	E21-24UNS7/16
1/2	27	20	100	9	7	3	11.75	E21-27UNS1/2
1/2	24	20	100	9	7	3	11.6	E21-24UNS1/2
5/8	27	22	100	12	9	4	14.9	E21-27UNS5/8
11/16	18	25	110	14	11	4	16.05	E21-18UNS11/16
3/4	18	25	110	14	11	4	17.6	E21-18UNS3/4
7/8	24	25	125	18	14.5	4	21.2	E21-24UNS7/8
15/16	18	25	140	18	14.5	4	22.4	E21-18UNS15/16
1"	24	28	140	18	14.5	4	24.3	E21-24UNS1"
1"	18	28	140	18	14.5	4	24	E21-18UNS1"
1"	14	28	140	18	14.5	4	23.6	E21-14UNS1"
1" 1/4	14	28	150	22	18	5	29.9	E21-14UNS1"1/4
1" 5/16	14	30	170	28	22	5	31.5	E21-14UNS1"5/16

Material Applications N/mm² Cutting Speed m/min

☒ Excellent
 ☐ Good

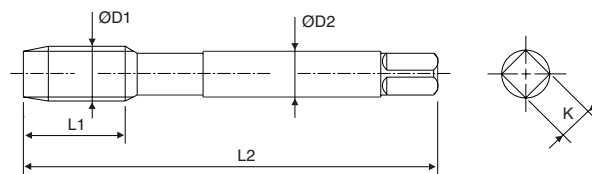
Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels		Carbon	Alloy	Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron		Malleable Cast Iron/ Graphite		Ti	Ti Alloy
	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
E20/21-UNS	10-15	10-15	10-12	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/GFR
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	-
E20/21-UNS	-	-	-	-	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	

ØD1	TPI	L1	L2	ØD2 h9	K h12	No. of Flutes	Drill Dia.	Order Code
8-UN								
1"1/8	8	40	180	22	18	4	25.4	E21-8UN1"1/8
1"1/4	8	40	180	22	18	4	28.6	E21-8UN1"1/4
1"3/8	8	50	200	28	22	4	31.75	E21-8UN1"3/8
1"1/2	8	50	200	28	22	4	34.9	E21-8UN1"1/2
1"5/8	8	50	200	32	24	5	38.1	E21-8UN1"5/8
1"3/4	8	50	200	36	29	5	41.3	E21-8UN1"3/4
1"7/8	8	60	225	36	29	6	44.45	E21-8UN1"7/8
2"	8	60	225	40	32	6	47.6	E21-8UN2"
2"1/4	8	65	250	45	35	6	54	E21-8UN2"1/4
2"1/2	8	70	275	50	39	6	60.3	E21-8UN2"1/2
12-UN								
7/8	12	25	125	18	14.5	4	20.1	E21-12UN7/8
1"1/16	12	25	140	20	16	4	24.9	E21-12UN1"1/16
1"3/16	12	28	150	22	18	4	28	E21-12UN1"3/16
1"5/16	12	30	170	28	22	5	31.2	E21-12UN1"5/16
1"7/16	12	30	170	28	22	6	34.4	E21-12UN1"7/16
1"5/8	12	30	170	32	24	6	39.2	E21-12UN1"5/8
1"3/4	12	32	180	36	29	6	42.3	E21-12UN1"3/4
2"	12	32	190	40	32	6	48.7	E21-12UN2"
16-UN								
1"	16	28	140	18	14.5	4	23.8	E21-16UN1"
1"1/8	16	28	150	22	18	4	27	E21-16UN1"1/8
1"1/4	16	28	150	22	18	5	30.15	E21-16UN1"1/4
1"1/2	16	30	170	28	22	6	36.5	E21-16UN1"1/2
2"	16	32	190	40	32	6	49.2	E21-16UN2"

Material Applications N/mm² 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	10-15	10-15	10-12	8-10	-	-	-	-	-	-	-	-	-	-	-
E21-12UN															
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			
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	Thermo	Thermoset	CFRP/GFRP
E21-8UN	-	-	-	-	8-12	-	10-15	-	10-15	-	-	-	-	8-10	-
E21-12UN															
E21-16UN															

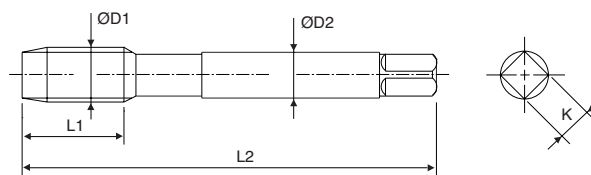


Multi Purpose

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
7	12.5	20	20	70	9	7	3	11.4	E21PG7
9	15.20	18	20	70	12	9	4	14	E21PG9
11	18.60	18	22	80	14	11	4	17.25	E21PG11
13.5	20.40	18	22	80	16	12	4	19	E21PG13.5
16	22.50	18	22	80	18	14.5	4	21.25	E21PG16
21	28.30	16	22	90	22	18	4	27	E21PG21
29	37	16	25	100	28	22	6	35.5	E21PG29
36	47	16	25	140	36	29	6	45.5	E21PG36
42	54	16	28	140	40	32	6	52.5	E21PG42
48	59.30	16	36	140	45	35	6	58	E21PG48

UN MACHINE TAPS

Material Applications N/mm² Cutting Speed m/min

● Excellent ○ Good

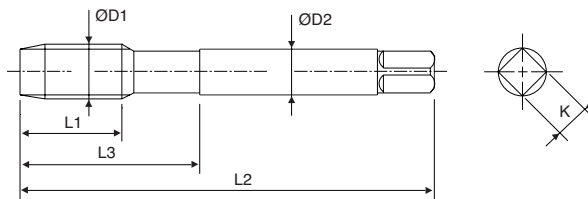
Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels		Carbon	Alloy	Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite			Ti	Ti Alloy
	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
E21PG	10-15	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%	-	-	-
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	Order Code	Order Code	Order Code
G1/8	28	20	90	36	7	5.5	3	8.8	TC728200	TD728200	-	-
G1/4	19	22	100	40	11	9	3	11.8	TC728400	TD728400	-	-
G3/8	19	22	100	40	12	9	3	15.25	TC728480	TD728480	-	-
G1/2	14	25	125	50	16	12	4	19	TC728560	TD728560	-	-
G3/4	14	28	140	54	20	16	4	24.5	TC728700	TD728700	-	-
G1	11	30	160	60	25	20	4	30.75	TC728780	TD728780	-	-
G1/16	28	10	90	36	6	4.9	3	6.8	-	-	TRE37020GS	TRE42020GS
G1/8	28	12	90	36	7	5.5	3	8.8	-	-	TRE37200GS	TRE42200GS
G1/4	19	14	100	48	11	9	3	11.8	-	-	TRE37400GS	TRE42400GS
G3/8	19	16	100	52	12	9	4	15.25	-	-	TRE37480GS	TRE42480GS
G1/2	14	18	125	70	16	12	4	19	-	-	TRE37560GS	TRE42560GS
G3/4	14	22	140	82	20	16	4	24.5	-	-	TRE37700GS	TRE42700GS
G1"	11	24	160	95	25	20	4	30.75	-	-	TRE37780GS	TRE42780GS

Material Applications N/mm² Cutting Speed m/min

Excellent Good

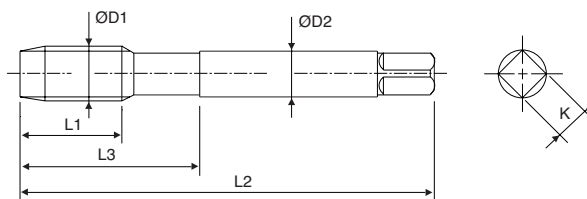
Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium				
	Soft Steels		Carbon	Alloy	Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite		Ti	Ti Alloy				
	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900			
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		Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al	Wrought	Si ≤10%	Si >10%	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	-	-	-	-	-	-	20-25	-	-	25-30	20-25	-	-	-	-	-	-	
TRE37	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	
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



 YG PRIME X Series Brand / Geometry Substrate Surface Treatment Tolerance Helix Angle Chamfer Lead Maximum Depth Through Coolant Performance										TC727	TD727	TRJ12
										YG - GS	YG - GS	YG - Prime X
										HSS 5% Cobalt	HSS 5% Cobalt	HSS Powder Metal
										Bright	TIN Coated	X-Coated
										ISO 228	ISO 228	ISO 228X
										-	-	-
										Form B: 4-5	Form B: 4-5	Form B: 4-5
										3xD	3xD	3xD
										-	-	-
ØD1	TPI	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.		Order Code	Order Code	Order Code
G1/8	28	20	90	36	7	5.5	3	8.8		TC727200	TD727200	-
G1/4	19	22	100	40	11	9	3	11.8		TC727400	TD727400	-
G3/8	19	22	100	40	12	9	3	15.25		TC727480	TD727480	-
G1/2	14	25	125	50	16	12	4	19		TC727560	TD727560	-
G3/4	14	28	140	54	20	16	4	24.5		TC727700	TD727700	-
G1	11	30	160	60	25	20	4	30.75		TC727780	TD727780	-
G1/16	28	10	90	36	6	4.9	3	6.8	-	-	-	TRJ12020GS
G1/8	28	12	90	36	7	5.5	3	8.8	-	-	-	TRJ12200GS
G1/4	19	14	100	48	11	9	3	11.8	-	-	-	TRJ12400GS
G3/8	19	16	100	52	12	9	4	15.25	-	-	-	TRJ12480GS
G1/2	14	18	125	70	16	12	4	19	-	-	-	TRJ12560GS
G3/4	14	22	140	82	20	16	4	24.5	-	-	-	TRJ12700GS
G1"	11	24	160	95	25	20	4	30.75	-	-	-	TRJ12780GS

BSP(G) WHITWORTH MACHINE TAPS

Material Applications N/mm² 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			<850	<850	<1000	<500	<1000	<700	<700	<900
TC727	-	15-20	12-18	10-15	-	-	-	-	-	-	-	10-15	5-8	-
TD727	-	20-30	20-30	20-25	5-12	-	10-15	8-10	6-8	-	-	15-20	10-15	-
TRJ12	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		
	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%		
TC727	-	-	-	-	8-12	25-35	15-20	-	-	25-35	15-20	10-15	-	-
TD727	-	-	-	-	-	-	20-25	-	-	25-30	20-25	-	-	-
TRJ12	-	-	-	-	-	-	20-25	-	-	25-30	20-25	-	-	-

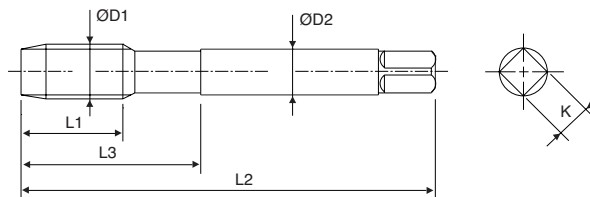


INOX

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
										YG - INOX	YG - INOX
										HSS 5% Cobalt	HSS 3% Vanadium
										Steam Tempered	TXC Coated
										ISO 228	ISO 228X
										R40°	R48°
										Form C: 2-3	Form C: 2-3
										2.5xD	3xD
										-	-
										Performance	Performance
ØD1	TPI	L1	L2	L3	ØD2	K	No. of Flutes	Drill Dia.		Order Code	Order Code
G1/8	28	20	90	36	7	5.5	3	8.8		TB514200	-
G1/4	19	22	100	40	11	9	3	11.8		TB514400	-
G3/8	19	22	100	40	12	9	3	15.25		TB514480	-
G1/2	14	25	125	50	16	12	4	19		TB514560	-
G3/4	14	28	140	54	20	16	4	24.5		TB514700	-
G1	11	30	160	60	25	20	4	30.75		TB514780	-
G1/8	28	15	90	36	7	5.5	3	8.8		-	V83G1/8TXC
G1/4	19	15	100	40	11	9	3	11.8		-	V83G1/4TXC
G3/8	19	15	100	40	12	9	4	15.25		-	V83G3/8TXC
G1/2	14	18	125	50	16	12	4	19		-	V83G1/2TXC
G3/4	14	20	140	54	20	16	4	24.5		-	V83G3/4TXC

Material Applications N/mm²

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	Inconel, Hastelloy, Nickel				Copper, Brass, Bronze				Aluminium						
	Ti Alloy	Nickel	Nickel Alloy		Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP	
TB514	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	-	-	-
TB514HAR	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
V83G-TXC	-	-	-	10-15	-	-	-	-	-	-	-	-	-	-	-

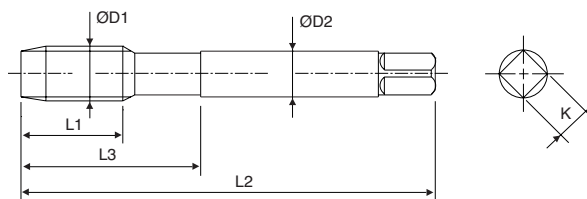


INOX

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	

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

BSP(G) WHITWORTH MACHINE TAPS

Material Applications N/mm² Cutting Speed m/min

● Excellent

○ Good

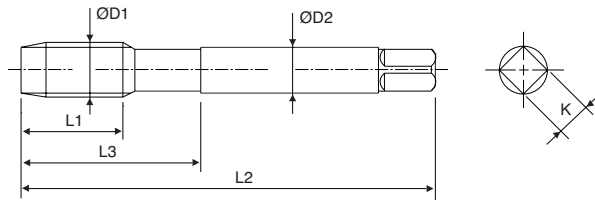
Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels	Carbon	Alloy		Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite			Ti	Ti Alloy
	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
V25G-TXC	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
	≤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	Order Code
G1/8	28	20	90	7	5.5	4	8.8	E27G1/8CT	-
G1/4	19	22	100	11	9	4	11.8	E27G1/4CT	-
G3/8	19	22	100	12	9	4	15.25	E27G3/8CT	-
G1/2	14	25	125	16	12	4	19	E27G1/2CT	-
G3/4	14	28	140	20	16	4	24.5	E27G3/4CT	-
G1	11	30	160	25	20	5	30.75	E27G1CT	-
G1/8	28	15	90	7	5.5	4	8.8	-	K27G1/8TX
G1/4	19	22	100	11	9	4	11.8	-	K27G1/4TX
G3/8	19	22	100	12	9	4	15.25	-	K27G3/8TX
G1/2	14	25	125	16	12	6	19	-	K27G1/2TX
G3/4	14	25	140	20	16	6	24.5	-	K27G3/4TX

Material Applications N/mm² Cutting Speed m/min

Excellent Good

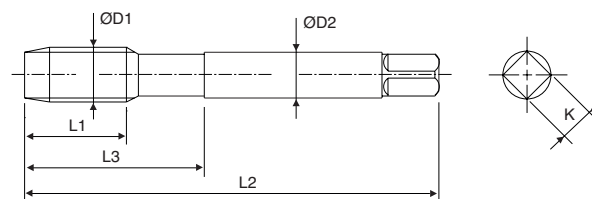
Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels		Carbon	Alloy	Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron		Malleable Cast Iron/Graphite		Ti	Ti Alloy
	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
E27G-CT K27G-TX	-	-	-	-	-	-	-	-	-	20-25 25-30	15-20 20-25	20-25 25-30	15-25 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
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%			
E27G-CT K27G-TX	-	-	-	-	-	25-30	-	5-8	-	-	-	25-30	-	-	-



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	Order Code
G1/16	28	9	90	36	6	4.9	5	7.3	TRQ17020GS	-
G1/8	28	9	90	36	7	5.5	8	9.3	TRQ17200GS	-
G1/4	19	13	100	40	11	9	8	12.5	TRQ17400GS	-
G3/8	19	13	100	40	12	9	8	16	TRQ17480GS	-
G1/2	14	18	125	50	16	12	8	20	TRQ17560GS	-
G3/4	14	18	140	54	20	16	8	25.5	TRQ17700GS	-
G1"	11	23	160	60	25	20	8	32.1	TRQ17780GS	-
G1/8	28	15	90	-	7	5.5	8	9.25	-	K2CCG1/8TG
G1/4	19	22	100	-	11	9	8	12.5	-	K2CCG1/4TG
G3/8	19	22	100	-	12	9	8	16	-	K2CCG3/8TG
G1/2	14	25	125	-	16	12	8	20	-	K2CCG1/2TG
G3/4	14	25	140	-	20	16	8	25.5	-	K2CCG3/4TG

BSP(G) WHITWORTH MACHINE TAPS

Material Applications N/mm² Cutting Speed m/min
 Excellent Good

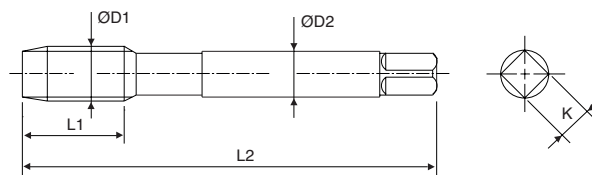
Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels		Carbon	Alloy	Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite			Ti	Ti Alloy
	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
TRQ17	20-30	20-30	20-25	15-20	5-12		10-15	8-10	6-8			15-20	10-15		
K2CCG	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	
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%			
TRQ17	20-30	20-30	20-25	15-20	5-12		10-15	8-10	6-8	-	-	15-20	10-15		
K2CCG	-	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
G1/8	28	10	90	10	8	3	8.8	S80G1/8TXC
G1/4	19	13.5	100	12	9	3	11.8	S80G1/4TXC
G3/8	19	13.5	100	16	12	4	15.25	S80G3/8TXC
G1/2	14	18	125	20	16	4	19	S80G1/2TXC



Recommended for use with Synchro Tap Chucks

Quicker tapping, better quality threads and longer tool life.

Material Applications N/mm² Cutting Speed m/min

● Excellent ○ Good

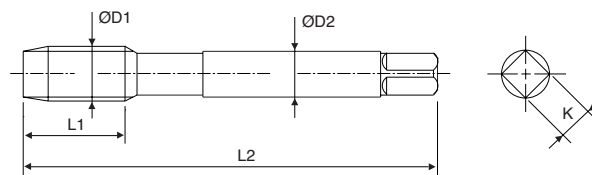
Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels		Carbon	Alloy	Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron		Malleable Cast Iron/Graphite		Ti	Ti Alloy
	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
S80G-TXC	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	-	-	-	-



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
G1/8	28	10	90	10	8	3	8.8	S24G1/8TXC
G1/4	19	13.5	100	12	9	3	11.8	S24G1/4TXC
G3/8	19	13.5	100	16	12	4	15.25	S24G3/8TXC
G1/2	14	18	125	20	16	4	19	S24G1/2TXC



Recommended for use with Synchro Tap Chucks

Quicker tapping, better quality threads and longer tool life.

BSP(G) WHITWORTH MACHINE TAPS

Material Applications N/mm² 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	-	-	-

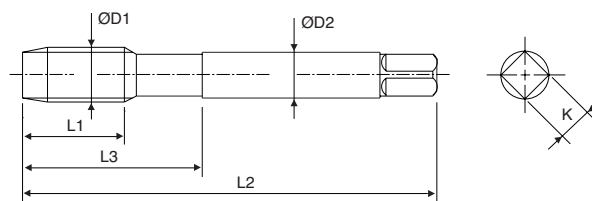


Multi Purpose

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
- BRIGHT 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	Order Code
Spiral Point										
1/8	40	11	56	18	3.5	2.7	3	2.5	TC224200	-
5/32	32	13	63	21	4.5	3.4	3	3.1	TC224280	-
3/16	24	15	70	25	6	4.9	3	3.6	TC224320	-
7/32	24	16	80	30	6	4.9	3	4.4	TC224360	-
1/4	20	17	80	30	7	5.5	3	5.1	TC224400	-
5/16	18	20	90	35	8	6.2	3	6.5	TC224440	-
3/8	16	22	100	39	9	7	3	7.9	TC224480	-
7/16	14	22	100	40	8	6.2	3	9.3	TC224520	-
1/2	12	25	110	44	9	7	3	10.5	TC224560	-
9/16	12	26	110	44	11	9	3	12	TC224600	-
5/8	11	27	110	44	12	9	3	13.5	TC224640	-
3/4	10	30	125	50	14	11	4	16.5	TC224700	-
7/8	9	32	140	54	18	14.5	4	19.25	TC224740	-
1"	8	36	160	60	20	16	4	22	TC224780	-
1 1/8"	7	40	180	65	22	18	4	24.75	TC224820	-
Spiral Flute										
1/8	40	7	56	18	3.5	2.7	3	2.5	-	TC134200
5/32	32	7	63	21	4.5	3.4	3	3.1	-	TC134280
3/16	24	10	70	25	6	4.9	3	3.6	-	TC134320
7/32	24	10	80	30	6	4.9	3	4.4	-	TC134360
1/4	20	13	80	30	7	5.5	3	5.1	-	TC134400
5/16	18	14	90	35	8	6.2	3	6.5	-	TC134440
3/8	16	16	100	39	9	7	3	7.9	-	TC134480
7/16	14	17	100	40	8	6.2	3	9.3	-	TC134520
1/2	12	20	110	44	9	7	3	10.5	-	TC134560
9/16	12	20	110	44	11	9	3	12	-	TC134600
5/8	11	22	110	40	12	9	3	13.5	-	TC134640
3/4	10	25	125	50	14	11	4	16.5	-	TC134700
7/8	9	27	140	54	18	14.5	4	19.25	-	TC134740
1"	8	30	160	60	20	16	4	22	-	TC134780
1 1/8"	7	35	180	65	22	18	4	24.75	-	TC134820

Material Applications N/mm² 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
TC224 TC134	10-15	10-15	10-12	8-10	-	-	-	-	-	-	-	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%			
TC224 TC134	-	8-12	-	-	8-12	-	10-15	-	10-15	25-35	-	-	-	8-12	-

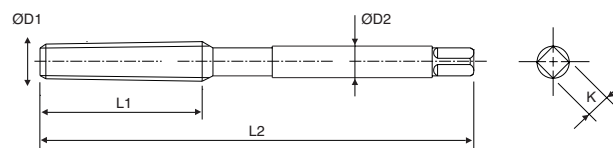


Multi Purpose

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
- BRIGHT 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	

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

TRAPEZOIDAL MACHINE TAPS

Material Applications N/mm² 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
E21TPN	<400 10-15	<700 10-15	<850 10-12	<850 8-10	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900

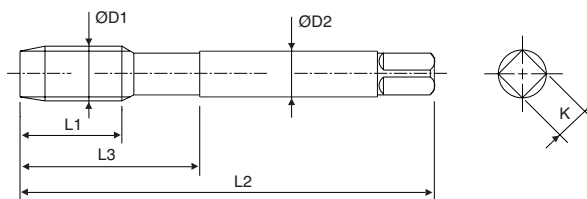
Series	Titanium			Inconel, Hastelloy, Nickel			Copper, Brass, Bronze				Aluminium			Plastics / Composites		
	Ti Alloy	Nickel	Nickel Alloy				Cu	Cu Alloy	Cu-Al-Fe	Al/Mg	Al	Al	Al	Thermo	Thermoset	CFRP/GFRP
E21TPN	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%		-	8-10	-



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	Order Code
Rc1/16	28	14	56	-	6	4.9	4	6.2	TCM03020	TDM03020
Rc1/8	28	14	63	-	7	5.5	4	8.2	TCM03200	TDM03200
Rc1/4	19	21	63	-	11	9	4	11	TCM03400	TDM03400
Rc3/8	19	21	70	-	12	9	4	14.5	TCM03480	TDM03480
Rc1/2	14	27	80	-	16	12	4	18	TCM03560	TDM03560
Rc3/4	14	27	100	-	20	16	5	23.5	TCM03700	TDM03700
Rc1"	11	32	110	-	25	20	5	29.5	TCM03780	TDM03780

Material Applications N/mm² Cutting Speed m/min

Excellent Good

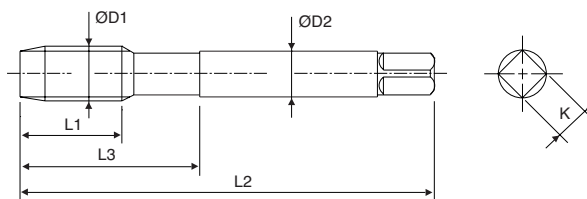
Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels		Carbon	Alloy	Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite		Ti	Ti Alloy	
	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
TCM03 TDM03	-	11-15	9-13	7-11	-	-	-	-	-	-	-	-	-	-	-
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			
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	Thermo	Thermoset	CFRP/GFRP
TCM03 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** hardslick 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	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	Order Code
Rc1/16	28	14	90	45	6	4.9	3	6.2	TBM06020	TCM06020HAR
Rc1/8	28	14	90	45	7	5.5	3	8.2	TBM06200	TCM06200HAR
Rc1/4	19	21	100	50	11	9	3	11	TBM06400	TCM06400HAR
Rc3/8	19	21	110	55	12	9	3	14.5	TBM06480	TCM06480HAR
Rc1/2	14	27	125	65	16	12	4	18	TBM06560	TCM06560HAR
Rc3/4	14	27	140	75	20	16	4	23.5	TBM06700	TCM06700HAR
Rc1	11	32	160	85	25	20	4	29.5	TBM06780	TCM06780HAR

BSPT MACHINE TAPS

Material Applications N/mm² Cutting Speed m/min
☒ Excellent
 ☐ Good

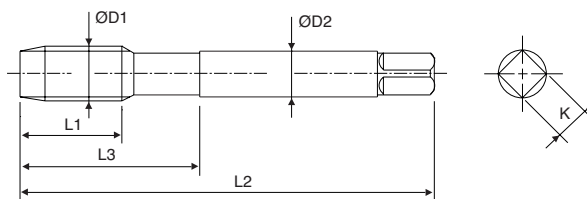
Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels		Carbon	Alloy	Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite			Ti	Ti Alloy
TBM06	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
TBM06-HAR	11-15	11-15	-	-	-	-	5-7	4-6	3-4	-	-	-	-	-	-
Series	Titanium				Inconel, Hastelloy, Nickel				Copper, Brass, Bronze				Aluminium		
	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		

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

Material Applications N/mm² Cutting Speed m/min

Excellent Good

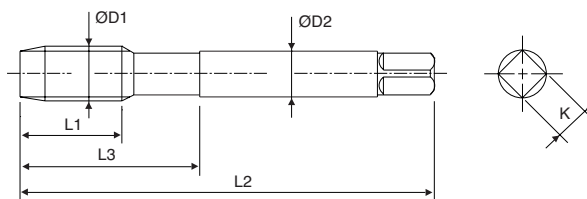
Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels		Carbon	Alloy	Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron		Malleable Cast Iron/Graphite		Ti	Ti Alloy
	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
TCM01	-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



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	☒ ☒ ☐ ☐ ☐ ☐	☒ ☒ ☒ ☐ ☐ ☐

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

NPT MACHINE TAPS

Material Applications N/mm² Cutting Speed m/min

☒ Excellent ☐ Good

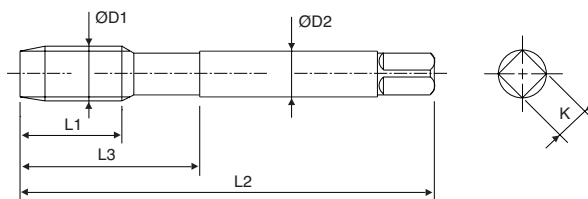
Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium	
	Soft Steels		Carbon	Alloy	Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron		Malleable Cast Iron/Graphite		Ti	Ti Alloy
	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900
TBM04 TCM04-HAR	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			
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	Thermo	Thermoset	CFRP/GFRP
TBM04 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	Order Code
1/16	27	14	56	-	6	4.9	4	6.15	TCM02020	TDM02020
1/8	27	14	63	-	7	5.5	4	8.43	TCM02200	TDM02200
1/4	18	21	63	-	11	9	4	11.13	TCM02400	TDM02400
3/8	18	21	70	-	12	9	4	14.27	TCM02480	TDM02480
1/2	14	27	80	-	16	12	4	17.86	TCM02560	TDM02560
3/4	14	27	100	-	20	16	5	23.01	TCM02700	TDM02700
1	11.5	32	110	-	25	20	5	28.98	TCM02780	TDM02780

Material Applications N/mm² Cutting Speed m/min

Excellent Good

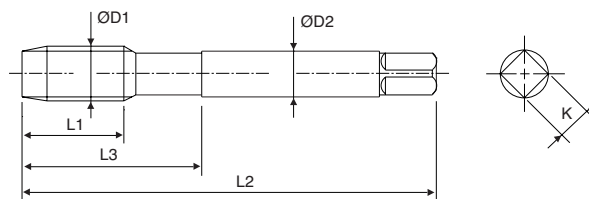
Series	Steels				Hardened Steels		Stainless Steels			Cast Iron				Titanium				
	Soft Steels		Carbon	Alloy	Pre-Hard	Hardened	Free Mach.	Austenitic	Fer/Marten.	Grey Cast iron	Malleable Cast Iron/Graphite		Ti	Ti Alloy				
	<400	<700	<850	<850	≤1200	>1200	<850	<850	<1000	<500	<1000	<700	<1000	<700	<900			
TCM02 TDM02	-	11-15	9-13	7-11	-	-	-	-	-	-	-	-	-	-	-			
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						
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	Thermo	Thermoset	CFRP/GFRP			
TCM02 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	Order Code
1/16	27	14	90	45	6	4.9	3	6.15	TBM05020	TCM05020HAR
1/8	27	14	90	45	7	5.5	3	8.43	TBM05200	TCM05200HAR
1/4	18	21	100	50	11	9	3	11.13	TBM05400	TCM05400HAR
3/8	18	21	110	55	12	9	3	14.27	TBM05480	TCM05480HAR
1/2	14	27	125	65	16	12	4	17.86	TBM05560	TCM05560HAR
3/4	14	27	140	75	20	16	4	23.01	TBM05700	TCM05700HAR
1	11.5	32	160	85	25	20	4	28.98	TBM05780	TCM05780HAR

NPTF MACHINE TAPS

Material Applications N/mm² 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
TBM05	11-15	11-15	-	-	-	-	5-7	4-6	3-4	-	-	-	-	-	-
TCM05-HAR															
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			
	≤1300	<500	<900	≤1400	<350	Short	Long	<1500	<350	Wrought	Si ≤10%	Si >10%	Thermo	Thermoset	CFRP/GFRP
TBM05	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
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.



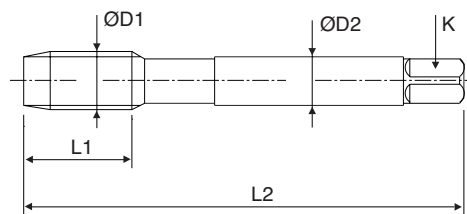
Multi Purpose

METRIC COARSE HAND TAP SETS

HSS Hand Taps for Free Cutting Steel up to 800N/mm², 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
M2	0.4	8	36	2.8	2.1	T7109139
M2.2	0.45	9	36	2.8	2.1	T7109159
M2.3	0.4	9	36	2.8	2.1	T7109199
M2.5	0.45	9	40	2.8	2.1	T7109179
M2.6	0.45	9	40	2.8	2.1	T7109499
M3	0.5	11	40	3.5	2.7	T7109209
M3.5	0.6	13	45	4	3	T7109229
M4	0.7	13	45	4.5	3.4	T7109249
M4.5	0.75	16	50	6	4.9	T7109269
M5	0.8	16	52	6	4.9	T7109289
M6	1	18	56	6	4.9	T7109319
M7	1	18	56	6	4.9	T7109349
M8	1.25	20	63	6	4.9	T7109369
M9	1.25	20	63	7	5.5	T7109399
M10	1.5	22	70	7	5.5	T7109429
M11	1.5	22	70	8	6.2	T7109469
M12	1.75	24	80	9	7	T7109509
M14	2	26	80	11	9	T7109549
M16	2	27	80	12	9	T7109609
M18	2.5	30	95	14	11	T7109659
M20	2.5	32	95	16	12	T7109709
M22	2.5	32	100	18	14.5	T7109749
M24	3	34	110	18	14.5	T7109789
M27	3	36	110	20	16	T7109869
M30	3.5	40	125	22	18	T7109949
M33	3.5	40	125	25	20	T7109A49
M36	4	50	150	28	22	T7109B39
M39	4	50	150	32	24	T7109C09
M42	4.5	56	150	32	24	T7109C89
M45	4.5	58	160	36	29	T7109D59
M48	5	65	180	36	29	T7109E29
M52	5	65	180	40	32	T7109F39



Multi Purpose

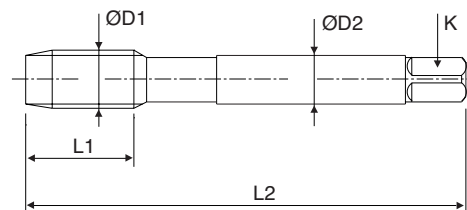
METRIC COARSE HAND TAP SETS & INDIVIDUAL HAND TAPS

HSS Hand Taps for Free Cutting Steel up to 800N/mm², 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
						First/Taper	Second	Bottom/Plug	
M1.6	0.35	8	41	2.5	2	E500M1.6NO1	E500M1.6NO2	E500M1.6NO3	E500M1.6NO6
M1.7	0.35	8	41	2.5	2	E500M1.7NO1	E500M1.7NO2	E500M1.7NO3	E500M1.7NO6
M2	0.4	8	41	2.5	2	E500M2NO1	E500M2NO2	E500M2NO3	E500M2NO6
M2.5	0.45	9.5	44.5	2.8	2.24	E500M2.5NO1	E500M2.5NO2	E500M2.5NO3	E500M2.5NO6
M3	0.5	12.5	48	3.15	2.5	E500M3X.6NO1	E500M3X.6NO2	E500M3X.6NO3	E500M3NO6
M3.5	0.6	14	50	3.55	2.8	E500M3.5NO1	E500M3.5NO2	E500M3.5NO3	E500M3.5NO6
M4	0.7	14	53	4	3.15	E500M4X.75NO1	E500M4X.75NO2	E500M4X.75NO3	E500M4NO6
M4.5	0.75	9.5	53	4.5	3.55	E500M4.5NO1	E500M4.5NO2	E500M4.5NO3	E500M4.5NO6
M5	0.8	11	58	5	4	E500M5NO1	E500M5NO2	E500M5NO3	E500M5NO6
M6	1	13	66	6.3	5	E500M6NO1	E500M6NO2	E500M6NO3	E500M6NO6
M7	1	13	66	7.1	5.6	E500M7NO1	E500M7NO2	E500M7NO3	E500M7NO6
M8	1.25	16	72	8	6.3	E500M8NO1	E500M8NO2	E500M8NO3	E500M8NO6
M9	1.25	16	72	9	7.1	E500M9NO1	E500M9NO2	E500M9NO3	E500M9NO6
M10	1.5	18	80	10	8	E500M10NO1	E500M10NO2	E500M10NO3	E500M10NO6
M11	1.5	19	85	8	6.3	E500M11NO1	E500M11NO2	E500M11NO3	E500M11NO6
M12	1.75	22	89	9	7.1	E500M12NO1	E500M12NO2	E500M12NO3	E500M12NO6
M14	2	24	95	11.2	9	E500M14NO1	E500M14NO2	E500M14NO3	E500M14NO6
M16	2	24	102	12.5	10	E500M16NO1	E500M16NO2	E500M16NO3	E500M16NO6
M18	2.5	29	112	14	11.2	E500M18NO1	E500M18NO2	E500M18NO3	E500M18NO6
M20	2.5	29	112	14	11.2	E500M20NO1	E500M20NO2	E500M20NO3	E500M20NO6
M22	2.5	29	118	16	12.5	E500M22NO1	E500M22NO2	E500M22NO3	E500M22NO6
M24	3	35	130	18	14	E500M24NO1	E500M24NO2	E500M24NO3	E500M24NO6



Stainless Steel

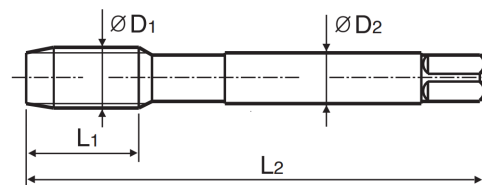
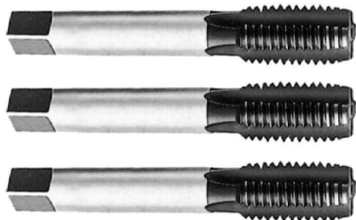
M METRIC COARSE INOX HAND TAP SETS

VAP Surface Treatment for use on Stainless Steel & 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-1

HSS
Co5DIN
352

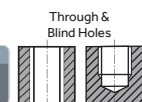
60°

A.D.C

BRIGHT
FINISH

6HX

2xD

Through &
Blind Holes

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



Multi Purpose

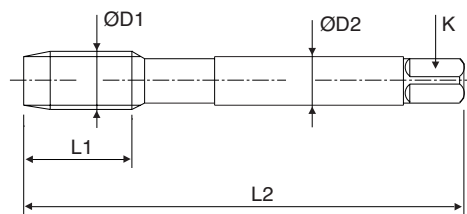
METRIC COARSE HAND TAP SETS - LEFT HAND

HSS Hand Taps for Free Cutting Steel up to 800N/mm², 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
M3	0.5	11	40	3.5	2.7	3	2.5	T7343209
M4	0.7	13	45	4.5	3.4	3	3.3	T7343249
M4.5	0.75	16	50	6	4.9	3	3.7	T7343269
M5	0.8	16	52	6	4.9	3	4.2	T7343289
M6	1	18	56	6	4.9	3	5	T7343319
M8	1.25	20	63	6	4.9	3	6.8	T7343369
M10	1.5	22	70	7	5.5	4	8.5	T7343429
M12	1.75	24	80	9	7	4	10.2	T7343509
M14	2	26	80	11	9	4	12	T7343549
M16	2	27	80	12	9	4	14	T7343609
M18	2.5	30	95	14	11	4	15.5	T7343659
M20	2.5	32	95	16	12	4	17.5	T7343709
M22	2.5	32	100	18	14.5	4	19.5	T7343749
M24	3	34	110	18	14.5	4	21	T7343789
M27	3	36	110	20	16	4	24	T7343869
M30	3.5	40	125	22	18	4	26.5	T7343949



Multi Purpose

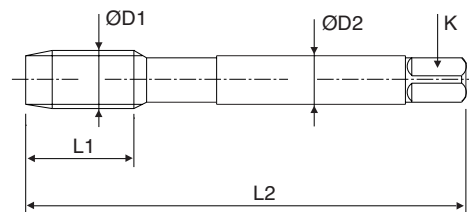
MF METRIC FINE HAND TAP SETS

Uncoated for use on Steel, Cast Iron & 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
M3	0.35	9	40	3.5	2.7	3	2.65	T7309219
M4	0.5	10	45	4.5	3.4	3	3.5	T7309259
M5	0.5	13	52	6	4.9	3	4.5	T7309299
M6	0.75	14	56	6	4.9	3	5.2	T7309329
M6	0.5	13	56	6	4.9	3	5.5	T7309339
M7	0.75	14	56	6	4.9	3	6.2	T7309359
M8	1	17	63	6	4.9	3	7	T7309379
M8	0.75	14	63	6	4.9	3	7.2	T7309389
M8	0.5	14	63	6	4.9	3	7.5	T7309939
M9	1	17	63	7	5.5	4	8	T7309409
M10	1.25	22	70	7	5.5	4	8.8	T7309439
M10	1	18	63	7	5.5	4	9	T7309449
M10	0.75	18	63	7	5.5	4	9.2	T7309459
M11	1	18	63	8	6.2	4	10	T7309479
M12	1.5	20	70	9	7	4	10.5	T7309519
M12	1.25	20	70	9	7	4	10.8	T7309529
M12	1	18	70	9	7	4	11	T7309539
M13	1.5	20	70	11	9	4	11.5	T7309N19
M13	1	18	70	11	9	4	12	T7309N29
M14	1.5	20	70	11	9	4	12.5	T7309559
M14	1.25	20	70	11	9	4	12.8	T7309569
M14	1	18	70	11	9	4	13	T7309579
M15	1.5	20	70	12	9	4	13.5	T7309589
M15	1	18	70	12	9	4	14	T7309599
M16	1.5	20	70	12	9	4	14.5	T7309619
M16	1	18	70	12	9	4	15	T7309629
M18	2	22	80	14	11	4	16	T7309669
M18	1.5	22	80	14	11	4	16.5	T7309679
M18	1	18	80	14	11	4	17	T7309689
M20	2	22	80	16	12	4	18	T7309719
M20	1.5	22	80	16	12	4	18.5	T7309729
M20	1	18	80	16	12	4	19	T7309739
M22	2	22	80	18	14.5	4	20	T7309759
M22	1.5	22	80	18	14.5	4	20.5	T7309769
M22	1	18	80	18	14.5	4	21	T7309779
M24	2	22	90	18	14.5	4	22	T7309799
M24	1.5	22	90	18	14.5	4	22.5	T7309809
M24	1	18	90	18	14.5	4	23	T7309819
M25	1.5	22	90	18	14.5	4	23.5	T7309839
M25	1	18	90	18	14.5	4	24	T7309849
M26	1.5	22	90	18	14.5	4	24.5	T7309859
M26	1	18	90	18	14.5	4	25	T7309N59
M27	2	22	90	20	16	4	25	T7309879
M27	1.5	22	90	20	16	4	25.5	T7309889
M27	1	18	90	20	16	4	26	T7309899
M28	2	22	90	20	16	4	26	T7309909
M28	1.5	22	90	20	16	4	26.5	T7309919
M30	2	22	90	22	18	4	28	T7309969
M30	1.5	22	90	22	18	4	28.5	T7309979
M30	1	18	90	22	18	4	29	T7309989



Multi Purpose

METRIC FINE HAND TAP SETS & INDIVIDUAL HAND TAPS

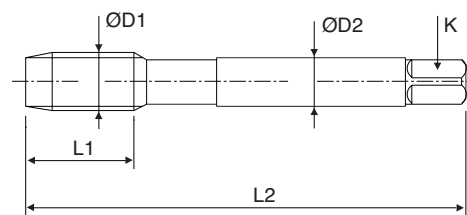
HSS Hand Taps for Free Cutting Steel up to 800N/mm², Cast Iron & Non-Ferrous

- 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
						First/Taper	Second	Bottom/Plug	
M3	0.35	12.5	48	3.15	2.5	E513M3X.35NO1	E513M3X.35NO2	E513M3X.35NO3	-
M3.5	0.35	12.5	48	3.15	2.5	-	-	E513M3.5X.35NO3	-
M4	0.5	14	53	4	3.15	E513M4X.5NO1	E513M4X.5NO2	E513M4X.5NO3	-
M5	0.5	11	58	5	4	E513M5X.5NO1	E513M5X.5NO2	E513M5X.5NO3	-
M5	0.75	11	58	5	4	E513M5X.75NO1	E513M5X.75NO2	E513M5X.75NO3	-
M6	0.5	13	66	6.3	5	E513M6X.5NO1	E513M6X.5NO2	E513M6X.5NO3	-
M6	0.75	13	66	6.3	5	E513M6X.75NO1	E513M6X.75NO2	E513M6X.75NO3	-
M7	0.75	13	66	7.1	5.6	E513M7X.75NO1	E513M7X.75NO2	E513M7X.75NO3	-
M8	0.5	16	72	8	6.3	E513M8X.5NO1	E513M8X.5NO2	E513M8X.5NO3	-
M8	0.75	16	72	8	6.3	E513M8X.75NO1	E513M8X.75NO2	E513M8X.75NO3	-
M8	1	16	72	8	6.3	E513M8X1.0NO1	E513M8X1.0NO2	E513M8X1.0NO3	-
M9	0.75	16	72	9	7.1	-	-	E513M9X.75NO3	-
M9	1	16	72	9	7.1	E513M9X1.0NO1	E513M9X1.0NO2	E513M9X1.0NO3	-
M10	0.5	18	80	10	8	-	-	E513M10X.5NO3	-
M10	0.75	18	80	10	8	E513M10X.75NO1	E513M10X.75NO2	E513M10X.75NO3	-
M10	1	18	80	10	8	E513M10X1.0NO1	E513M10X1.0NO2	E513M10X1.0NO3	E513M10X1.0NO6
M10	1.25	18	80	10	8	E513M10X1.25NO1	E513M10X1.25NO2	E513M10X1.25NO3	E513M10X1.25NO6
M11	0.75	19	85	8	6.3	E513M11X.75NO1	E513M11X.75NO2	E513M11X.75NO3	-
M11	1	19	85	8	6.3	E513M11X1.0NO1	E513M11X1.0NO2	E513M11X1.0NO3	-
M11	1.25	19	85	8	6.3	-	-	E513M11X1.25NO3	-
M12	0.75	22	89	9	7.1	-	-	E513M12X.75NO3	-
M12	1	22	89	9	7.1	E513M12X1.0NO1	E513M12X1.0NO2	E513M12X1.0NO3	-
M12	1.25	22	89	9	7.1	E513M12X1.25NO1	E513M12X1.25NO2	E513M12X1.25NO3	E513M12X1.25NO6
M12	1.5	22	89	9	7.1	E513M12X1.5NO1	E513M12X1.5NO2	E513M12X1.5NO3	E513M12X1.5NO6
M13	1.5	22	89	9	7.1	-	-	E513M13X1.5NO3	-
M14	1	24	95	11.2	9	E513M14X1.0NO1	E513M14X1.0NO2	E513M14X1.0NO3	-
M14	1.25	24	95	11.2	9	E513M14X1.25NO1	E513M14X1.25NO2	E513M14X1.25NO3	E513M14X1.25NO6
M14	1.5	24	95	11.2	9	E513M14X1.5NO1	E513M14X1.5NO2	E513M14X1.5NO3	E513M14X1.5NO6
M15	1.5	24	95	11.2	9	-	E513M15X1.5NO2	E513M15X1.5NO3	E513M15X1.5NO6
M16	1	24	102	12.5	10	E513M16X1.0NO1	E513M16X1.0NO2	E513M16X1.0NO3	-
M16	1.25	24	102	12.5	10	-	-	E513M16X1.25NO3	-
M16	1.5	24	102	12.5	10	E513M16X1.5NO1	E513M16X1.5NO2	E513M16X1.5NO3	-
M18	1	29	112	14	11.2	E513M18X1.0NO1	E513M18X1.0NO2	E513M18X1.0NO3	-
M18	1.5	29	112	14	11.2	E513M18X1.5NO1	E513M18X1.5NO2	E513M18X1.5NO3	E513M18X1.5NO6
M18	2	29	112	14	11.2	E513M18X2.0NO1	E513M18X2.0NO2	E513M18X2.0NO3	-
M20	1	29	112	14	11.2	-	E513M20X1.0NO2	E513M20X1.0NO3	-
M20	1.5	29	112	14	11.2	E513M20X1.5NO1	E513M20X1.5NO2	E513M20X1.5NO3	E513M20X1.5NO6
M20	2	29	112	14	11.2	E513M20X2.0NO1	E513M20X2.0NO2	E513M20X2.0NO3	-
M22	1	29	118	16	12.5	-	E513M22X1.0NO2	E513M22X1.0NO3	-
M22	1.5	29	118	16	12.5	E513M22X1.5NO1	E513M22X1.5NO2	E513M22X1.5NO3	-
M22	2	29	118	16	12.5	E513M22X2.0NO1	E513M22X2.0NO2	E513M22X2.0NO3	-
M24	1	35	130	18	14	-	E513M24X1.0NO2	E513M24X1.0NO3	-
M24	1.5	35	130	18	14	E513M24X1.5NO1	E513M24X1.5NO2	E513M24X1.5NO3	-
M24	2	35	130	18	14	E513M24X2.0NO1	E513M24X2.0NO2	E513M24X2.0NO3	-
M25	1.5	35	130	18	14	E513M25X1.5NO1	E513M25X1.5NO2	E513M25X1.5NO3	E513M25X1.5NO6
M26	1.5	35	130	18	14	-	E513M26X1.5NO2	E513M26X1.5NO3	-
M27	1.5	35	135	20	16	-	E513M27X1.5NO2	E513M27X1.5NO3	-
M27	2	35	135	20	16	-	-	E513M27X2.0NO3	-
M28	1.5	35	138	20	16	-	E513M28X1.5NO2	E513M28X1.5NO3	-
M30	1.5	41	138	20	16	-	E513M30X1.5NO2	E513M30X1.5NO3	-
M30	2	41	138	20	16	-	E513M30X2.0NO2	E513M30X2.0NO3	-
M32	1.5	41	151	22.4	18	E513M32X1.5NO1	E513M32X1.5NO2	E513M32X1.5NO3	-
M33	2	41	151	22.4	18	-	E513M33X2.0NO2	E513M33X2.0NO3	-
M35	1.5	47	162	25	20	-	E513M35X1.5NO2	E513M35X1.5NO3	-
M36	1.5	47	162	25	20	-	-	E513M36X1.5NO3	-
M36	2	47	162	25	20	-	E513M36X2.0NO2	E513M36X2.0NO3	-
M36	3	47	162	25	20	-	E513M36X3.0NO2	E513M36X3.0NO3	-
M39	3	47	170	28	22.4	-	-	E513M39X3.0NO3	-
M40	1.5	53	170	28	22.4	-	E513M40X1.5NO2	E513M40X1.5NO3	-
M42	1.5	53	170	28	22.4	-	E513M42X1.5NO2	E513M42X1.5NO3	-
M42	3	53	170	28	22.4	-	-	E513M42X3.0NO3	-
M45	1.5	54	187	31.5	25	-	E513M45X1.5NO2	E513M45X1.5NO3	-
M48	1.5	60	187	31.5	25	-	-	E513M48X1.5NO3	-
M48	2	60	187	31.5	25	-	-	E513M48X2.0NO3	-
M48	3	60	187	31.5	25	-	-	E513M48X3.0NO3	-
M50	1.5	60	187	31.5	25	-	E513M50X1.5NO2	E513M50X1.5NO3	-



Multi Purpose

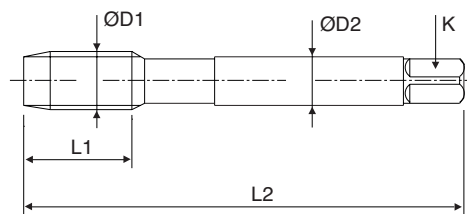
UNC UNIFIED COARSE HAND TAP SETS

Uncoated for use on Steel, Cast Iron & 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



HSS

DIN 351

2B

60°

A.D.C

BRIGHT FINISH

2xD



Through & Blind Holes

ØD1 UNC	TPI	L1	L2	ØD2	K	No. of Flutes	Drill Dia.	Order Code
No.2	56	9	36	2.8	2.1	3	1.8	T7363089
No.3	48	10	40	2.8	2.1	3	2.1	T7363129
No.4	40	10	42	3.5	2.7	3	2.3	T7363169
No.5	40	10	42	3.5	2.7	3	2.6	T7363209
No.6	32	11	45	4	3	3	2.85	T7363249
No.8	32	12	48	4.5	3.4	3	3.5	T7363289
No.10	24	14	52	6	4.9	3	3.9	T7363329
No.12	24	16	56	6	4.9	3	4.5	T7363369
1/4	20	16	56	6	4.9	3	5.2	T7363409
5/16	18	20	63	6	4.9	3	6.6	T7363449
3/8	16	22	70	7	5.5	4	8	T7363489
7/16	14	22	70	8	6.2	4	9.4	T7363529
1/2	13	25	80	9	7	4	10.75	T7363569
9/16	12	26	80	11	9	4	12.25	T7363609
5/8	11	27	90	12	9	4	13.5	T7363649
3/4	10	32	105	14	11	4	16.5	T7363709
7/8	9	32	110	18	14.5	4	19.5	T7363749
1"	8	36	110	20	16	4	22.25	T7363789
1" 1/8	7	40	125	22	18	4	25	T7363829
1" 1/4	7	40	125	25	20	4	28.25	T7363869
1" 3/8	6	50	150	28	22	4	30.75	T7363909
1" 1/2	6	50	150	32	24	4	34	T7363949
1" 3/4	5	58	160	36	29	4	39.5	T7363989
2"	4.5	65	180	40	32	4	45.25	T7363D29



Multi Purpose

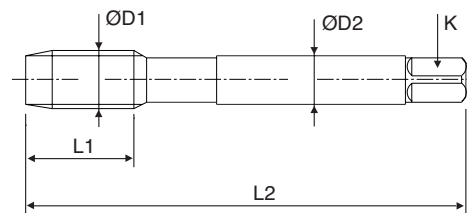
UNC UNIFIED COARSE HAND TAP SETS & INDIVIDUAL HAND TAPS

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



Through & Blind Holes



ØD1 UNC	TPI	L1	L2	ØD2	K	Individual Taps			Set of 3
						First/Taper	Second	Bottom/Plug	
No.1	64	8	41	2.5	2	-	-	E5151-64NO3	-
No.2	56	9.5	44.5	2.8	2.24	E5152-56NO1	E5152-56NO2	E5152-56NO3	E5152-56NO6
No.3	48	9.5	44.5	2.8	2.24	-	-	E5153-48NO3	E5153-48NO6
No.4	40	12.5	48	3.15	2.5	E5154-40NO1	E5154-40NO2	E5154-40NO3	E5154-40NO6
No.5	40	12.5	48	3.15	2.5	E5155-40NO1	E5155-40NO2	E5155-40NO3	E5155-40NO6
No.6	32	14	50	3.55	2.8	E5156-32NO1	E5156-32NO2	E5156-32NO3	E5156-32NO6
No.8	32	9.5	53	4.5	3.55	E5158-32NO1	E5158-32NO2	E5158-32NO3	E5158-32NO6
No.10	24	11	58	5	4	E51510-24NO1	E51510-24NO2	E51510-24NO3	E51510-24NO6
No.12	24	12	62	5.6	4.5	E51512-24NO1	E51512-24NO2	E51512-24NO3	E51512-24NO6
1/4"	20	13	66	6.3	5	E5151/4NO1	E5151/4NO2	E5151/4NO3	E5151/4NO6
5/16"	18	16	72	8	6.3	E5155/16NO1	E5155/16NO2	E5155/16NO3	E5155/16NO6
3/8"	16	18	80	10	8	E5153/8NO1	E5153/8NO2	E5153/8NO3	E5153/8NO6
7/16"	14	19	85	8	6.3	E5157/16NO1	E5157/16NO2	E5157/16NO3	E5157/16NO6
1/2"	13	22	89	9	7.1	E5151/2NO1	E5151/2NO2	E5151/2NO3	E5151/2NO6
9/16"	12	24	95	11.2	9	E5159/16NO1	E5159/16NO2	E5159/16NO3	E5159/16NO6
5/8"	11	24	102	12.5	10	E5155/8NO1	E5155/8NO2	E5155/8NO3	E5155/8NO6
3/4"	10	29	112	14	11.2	E5153/4NO1	E5153/4NO2	E5153/4NO3	E5153/4NO6
7/8"	9	29	118	16	12.5	E5157/8NO1	E5157/8NO2	E5157/8NO3	E5157/8NO6
1"	8	35	130	18	14	E5151NO1	E5151NO2	E5151NO3	E5151NO6
1-1/8"	7	35	138	20	16	E5151.1/8NO1	E5151.1/8NO2	E5151.1/8NO3	-
1-1/4"	7	41	151	22.4	18	E5151.1/4NO1	E5151.1/4NO2	E5151.1/4NO3	-
1-3/8"	6	47	162	25	20	E5151.3/8NO1	E5151.3/8NO2	E5151.3/8NO3	-
1-1/2"	6	47	170	28	22.4	E5151.1/2NO1	E5151.1/2NO2	E5151.1/2NO3	-
1-3/4"	5	54	187	31.5	25	E5151.3/4NO1	E5151.3/4NO2	E5151.3/4NO3	-
2"	4.5	60	200	35.5	28	E5152NO1	E5152NO2	-	-

UNC HAND TAPS



Multi Purpose

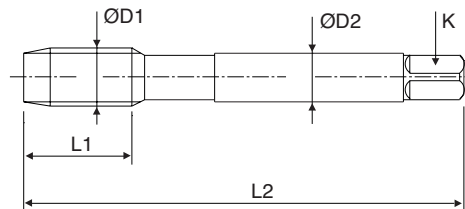
UNF UNIFIED FINE HAND TAP SETS

Uncoated for use on Steel, Cast Iron & 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

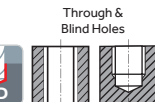
DIN 2181

60°

A.C

BRIGHT FINISH

2xD



Through & Blind Holes

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



Multi Purpose

UNF UNIFIED FINE HAND TAP SETS & INDIVIDUAL HAND TAPS

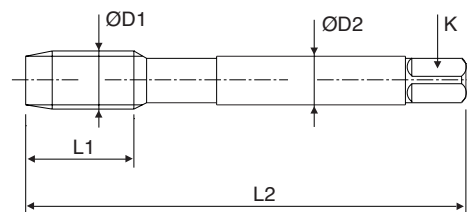
HSS Hand Taps for Free Cutting Steel up to 800N/mm², Cast Iron & Non-Ferrous

- 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



HSS

DIN
351

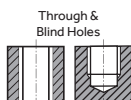
2B

60°

A.D.C

BRIGHT
FINISH

2xD



ØD1	TPI	L1	L2	ØD2	K	Individual Taps			Set of 3
						First/Taper	Second	Bottom/Plug	
No.0	80	7	41	2.5	2	E5240-80NO1	E5240-80NO2	E5240-80NO3	-
No.1	72	8	41	2.5	2	-	E5241-72NO2	E5241-72NO3	-
No.2	64	9.5	44.5	2.8	2.24	E5242-64NO1	E5242-64NO2	E5242-64NO3	-
No.4	48	12.5	48	3.15	2.5	E5244-48NO1	E5244-48NO2	E5244-48NO3	-
No.5	44	12.5	48	3.15	2.5	E5245-44NO1	E5245-44NO2	E5245-44NO3	-
No.6	40	14	50	3.55	2.8	E5246-40NO1	E5246-40NO2	E5246-40NO3	-
No.8	36	9.5	53	4.5	3.55	E5248-36NO1	E5248-36NO2	E5248-36NO3	-
No.10	32	11	58	5	4	E52410-32NO1	E52410-32NO2	E52410-32NO3	E52410-32NO6
No.12	28	12	62	5.6	4.5	E52412-28NO1	E52412-28NO2	E52412-28NO3	E52412-28NO6
1/4"	28	13	66	6.3	5	E5241/4NO1	E5241/4NO2	E5241/4NO3	E5241/4NO6
5/16"	24	16	72	8	6.3	E5245/16NO1	E5245/16NO2	E5245/16NO3	E5245/16NO6
3/8"	24	18	80	10	8	E5243/8NO1	E5243/8NO2	E5243/8NO3	E5243/8NO6
7/16"	20	19	85	8	6.3	E5247/16NO1	E5247/16NO2	E5247/16NO3	E5247/16NO6
1/2"	20	22	89	9	7.1	E5241/2NO1	E5241/2NO2	E5241/2NO3	E5241/2NO6
9/16"	18	24	95	11.2	9	E5249/16NO1	E5249/16NO2	E5249/16NO3	E5249/16NO6
5/8"	18	24	102	12.5	10	E5245/8NO1	E5245/8NO2	E5245/8NO3	E5245/8NO6
3/4"	16	29	112	14	11.2	E5243/4NO1	E5243/4NO2	E5243/4NO3	E5243/4NO6
7/8"	14	29	118	16	12.5	-	E5247/8NO2	E5247/8NO3	E5247/8NO6
1"	12	35	130	18	14	E5241NO1	E5241NO2	E5241NO3	E5241NO6
1-1/8"	12	35	138	20	16	E5241.1/8NO1	E5241.1/8NO2	E5241.1/8NO3	-
1-1/4"	12	41	151	22.4	18	E5241.1/4NO1	E5241.1/4NO2	E5241.1/4NO3	-
1-3/8"	12	47	162	25	20	E5241.3/8NO1	E5241.3/8NO2	E5241.3/8NO3	-
1-1/2"	12	47	170	28	22.4	E5241.1/2NO1	E5241.1/2NO2	E5241.1/2NO3	-

UNF HAND TAPS



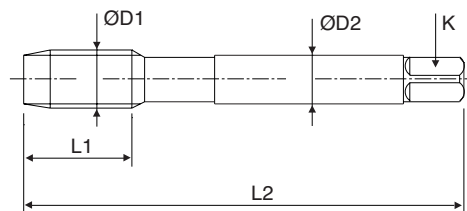
Multi Purpose

BSW BRITISH STANDARD WHITWORTH HAND TAP SETS

Uncoated for use on Steel, Cast Iron & 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
3/32	48	10	40	2.8	2.1	3	1.8	T7609129
1/8	40	10	42	3.5	2.7	3	2.5	T7609209
5/32	32	12	48	4.5	3.4	3	3.1	T7609289
3/16	24	14	52	6	4.9	3	3.6	T7609329
7/32	24	16	56	6	4.9	3	4.4	T7609369
1/4	20	16	56	6	4.9	3	5.1	T7609409
5/16	18	20	63	6	4.9	3	6.5	T7609449
3/8	16	22	70	7	5.5	4	7.9	T7609489
7/16	14	22	70	8	6.2	4	9.3	T7609529
1/2	12	25	80	9	7	4	10.5	T7609569
9/16	12	26	80	11	9	4	12	T7609609
5/8	11	27	90	12	9	4	13.5	T7609649
3/4	10	32	105	14	11	4	16.5	T7609709
7/8	9	32	110	18	14.5	4	19.25	T7609749
1"	8	36	110	20	16	4	22	T7609789
1" 1/8	7	40	125	22	18	4	24.75	T7609829
1" 1/4	7	40	125	25	20	4	27.75	T7609869
1" 3/8	6	50	150	28	22	4	30.5	T7609909
1" 1/2	6	50	150	32	24	4	33.5	T7609949
1" 5/8	5	56	150	32	24	4	35.5	T7609989
1" 3/4	5	58	160	36	29	4	39	T7609889
1" 7/8	4.5	65	180	36	29	4	41.5	T7609C69
2"	4.5	65	180	40	32	4	44.5	T7609D29



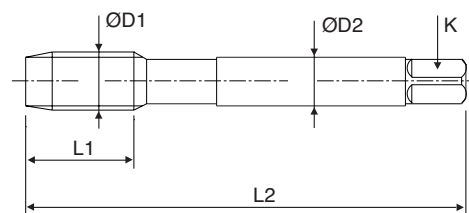
Multi Purpose

BSW BRITISH STANDARD WHITWORTH HAND TAP SETS & INDIVIDUAL HAND TAPS

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

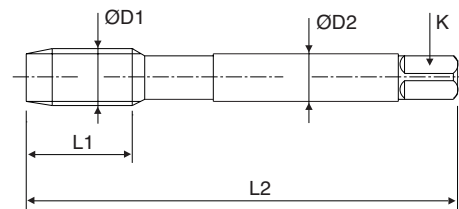
ØD1	TPI	L1	L2	ØD2	K	Individual Taps			Set of 3
						First/Taper	Second	Bottom/Plug	
1/8"	40	12.5	48	3.15	2.5	E5311/8NO1	E5311/8NO2	E5311/8NO3	E5311/8NO6
5/32"	32	14	53	4	3.15	E5315/32NO1	E5315/32NO2	E5315/32NO3	E5315/32NO6
3/16"	24	11	58	5	4	E5313/16NO1	E5313/16NO2	E5313/16NO3	E5313/16NO6
1/4"	20	13	66	6.3	5	E5311/4NO1	E5311/4NO2	E5311/4NO3	E5311/4NO6
5/16"	18	16	72	8	6.3	E5315/16NO1	E5315/16NO2	E5315/16NO3	E5315/16NO6
3/8"	16	18	80	10	8	E5313/8NO1	E5313/8NO2	E5313/8NO3	E5313/8NO6
7/16"	14	19	85	8	6.3	E5317/16NO1	E5317/16NO2	E5317/16NO3	E5317/16NO6
1/2"	12	22	89	9	7.1	E5311/2NO1	E5311/2NO2	E5311/2NO3	E5311/2NO6
5/8"	11	24	102	12.5	10	E5315/8NO1	E5315/8NO2	E5315/8NO3	E5315/8NO6
3/4"	10	29	112	14	11.2	E5313/4NO1	E5313/4NO2	E5313/4NO3	E5313/4NO6
1"	8	35	130	18	14	E5311NO1	E5311NO2	E5311NO3	E5311NO6

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

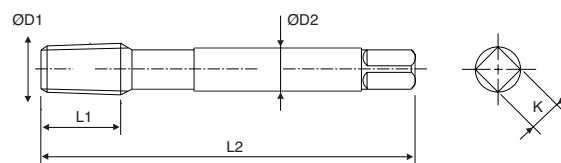
60600
Presto

ØD1	TPI	L1	L2	ØD2	K	Individual Taps			Set of 3
						First/Taper	Second	Bottom/Plug	
1/8	28	15	59	8	6.3	60600-181	60600-182	60600-183	60600-184
1/4	19	19	67	10	8	60600-141	60600-142	60600-143	60600-144
3/8	19	21	75	12.5	10	60600-381	60600-382	60600-383	60600-384
1/2	14	26	87	16	12.5	60600-121	60600-122	60600-123	60600-124
5/8	14	26	91	18	14	60600-581	60600-582	60600-583	60600-584
3/4	14	28	96	20	16	60600-341	60600-342	60600-343	60600-344
7/8	14	29	102	22.4	18	60600-781	60600-782	60600-783	60600-784
1"	11	33	109	25	20	606001-1	606001-2	606001-3	606001-4
1" 1/4	11	36	119	31.5	25	606001-141	606001-142	606001-143	606001-144
1" 1/2	11	37	125	35.5	28	606001-121	606001-122	606001-123	606001-124
1" 3/4	11	39	132	35.5	28	606001-341	606001-342	606001-343	606001-344
2"	11	41	140	40	31.5	606002-1	606002-2	606002-3	606002-4
2" 1/4	11	42	142	40	31.5	606002-141	606002-142	606002-143	606002-144
2" 1/2	11	45	153	45	35.5	606002-121	606002-122	606002-123	606002-124

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
						First/Taper	Second	Bottom/Plug	
1/8	28	15	59	8	6.3	60680-181	60680-182	60680-183	60680-184
1/4	19	19	67	10	8	60680-141	60680-142	60680-143	60680-144
3/8	19	21	75	12.5	10	60680-381	60680-382	60680-383	60680-384
1/2	14	26	87	16	12.5	60680-121	60680-122	60680-123	60680-124
3/4	14	28	96	20	16	60680-341	60680-342	60680-343	60680-344
1"	11	33	109	25	20	606801-1	606801-2	606801-3	606801-4
1" 1/4	11	36	119	31.5	25	606801-141	606801-142	606801-143	606801-144
1" 1/2	11	37	125	35.5	28	606801-121	606801-122	606801-123	606801-124
2"	11	41	140	40.0	31.5	606802-1	606802-2	606802-3	606802-4

PRESTO**Multi Purpose****NPT NATIONAL PIPE TAPER SETS & INDIVIDUAL TAPS**HSS Hand Taps for Free Cutting Steel up to 800N/mm²

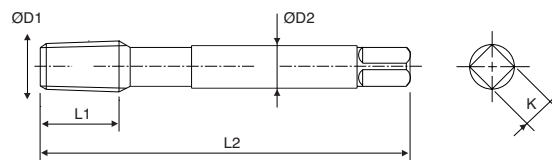
- BRIGHT finish prevents swarf sticking to the tap flutes
- Can also be used as a machine tap if required
- Straight flute
- Set of 3 includes 1x first, second & bottom taps

Series

60600
Presto

HSS

60°

BRIGHT
FINISHA
8 - 10D
4 - 5E
1.5 - 2

ØD1	TPI	L1	L2	ØD2	K	Individual Taps			Set of 3
						First/Taper	Second	Bottom/Plug	
1/16	27	11/16	2" 1/8	0.312	0.234	60750-1161	60750-1162	60750-1163	60750-1164
1/8	27	3/4	2" 1/8	0.437	0.328	60750-181	60750-182	60750-183	60750-184
1/4	18	1" 1/16	2" 7/16	0.562	0.421	60750-141	60750-142	60750-143	60750-144
3/8	18	1" 1/16	2" 9/16	0.700	0.531	60750-381	60750-382	60750-383	60750-384
1/2	14	1" 3/8	3" 1/8	0.687	0.515	60750-121	60750-122	60750-123	60750-124
3/4	14	1" 3/8	3" 1/4	0.906	0.679	60750-341	60750-342	60750-343	60750-344
1"	11.5	1" 3/4	3" 3/4	1.125	0.843	607501-1	607501-2	607501-3	607501-4
1" 1/4	11.5	1" 3/4	4"	1.312	0.984	607501-141	607501-142	607501-143	607501-144
1" 1/2	11.5	1" 3/4	4" 1/4	1.125	1.125	607501-121	607501-122	607501-123	607501-124
2"	11.5	1" 3/4	4" 1/2	1.875	1.406	607502-1	607502-2	607502-3	607502-4

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
M2 - M6 (1/8 - 1/4")	82.5	6983306-521
M6 - M12 (1/4 - 1/2")	108	6983306-522

PRESTO**TAP WRENCH BAR TYPE**

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



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

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

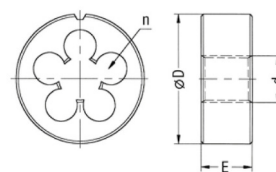
- Spiral entry results in a free flow of chips ahead of the die and a reduction in the cutting torque
- Premium German made dies for exceptional precision, durability & reliability

Standard

- Tolerance 6g
- For cutting steel up to 800N/mm²

INOX

- VA type No1 for stainless steel
- Tolerance 6g
- For cutting steel and stainless steel up to 1200N/mm²
- Nitrided surface treatment for increased tool life



Thread	Pitch	ØD x E	Order Code	
			General Purpose	INOX (Stainless)
M1	0.25	16 x 5	JBO-101212	-
M2	0.4	16 x 5	JBO-101816	JBO-104225
M3	0.5	20 x 5	JBO-102207	JBO-104306
M4	0.7	20 x 5	JBO-102470	JBO-104373
M5	0.8	20 x 7	JBO-102642	JBO-104418
M6	1	20 x 7	JBO-102771	JBO-104453
M8	1.25	25 x 9	JBO-102959	JBO-104511
M10	1.5	30 x 11	JBO-101297	JBO-104060
M12	1.75	38 x 14	JBO-101439	JBO-104106
M14	2	38 x 14	JBO-101558	JBO-104147
M16	2	45 x 18	JBO-101657	JBO-104179
M18	2.5	45 x 18	JBO-101746	JBO-104201
M20	2.5	45 x 18	JBO-101934	JBO-104260
M22	2.5	55 x 22	JBO-102002	-
M24	3	55 x 22	JBO-102060	-
M27	3	65 x 25	JBO-102150	-
M30	3.5	65 x 25	JBO-102316	-
M33	3.5	65 x 25	JBO-102372	-
M36	4	65 x 25	JBO-102415	-
M39	4	75 x 30	JBO-102455	-
M42	4.5	75 x 30	JBO-102587	-
M45	4.5	90 x 36	JBO-108325	-
M48	5	90 x 36	JBO-102630	-
M52	5	90 x 36	JBO-102740	-



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
0	M1-2.5	16 x 5	13559005
1	M3-4	20 x 5	13559010
2	M4.5-6	20 x 7	13559020
3	M7-9	25 x 9	13559030
4	M10-11	30 x 11	13559040
5	-	38 x 10	13559050
6	M10-14	38 x 14	13559060
7	-	45 x 14	13559070
8	M16-20	45 x 18	13559080
9	-	55 x 16	13559090
10	M22-26	55 x 22	13559100
11	-	65 x 18	13559110
12	M27-36	65 x 25	13559120
13	-	75 x 20	13559130
15	-	90 x 22	13559150
16	M45-52	90 x 36	13559160
17	-	105 x 22	13559170



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/mm²



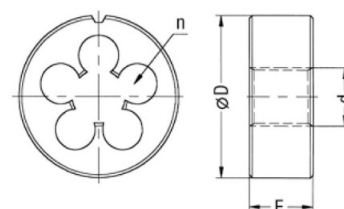
Die Range	Order Code
M3-M12	13417500



MF METRIC FINE HSS SOLID DIE

Circular Solid Die with Spiral Entry

- Tolerance 6g
- For cutting steel up to 800N/mm²
- 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



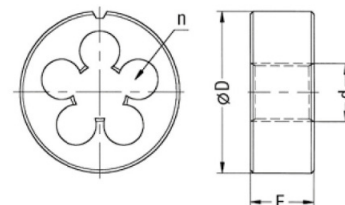
Thread	Pitch	ØD x E	Order Code	Thread	Pitch	ØD x E	Order Code
M3	0.35	20 x 5	JBO-105138	M19	0.75	45 x 14	JBO-105007
M3.5	0.35	20 x 5	JBO-105147	M19	1	45 x 14	JBO-105009
M4	0.35	20 x 5	JBO-105237	M20	0.5	45 x 14	JBO-105028
M4	0.5	20 x 5	JBO-105239	M20	0.75	45 x 14	JBO-105030
M4.5	0.5	20 x 5	JBO-105246	M21	0.75	45 x 14	JBO-105042
M5	0.35	20 x 5	JBO-105294	M20	1	45 x 14	JBO-105032
M5	0.5	20 x 5	JBO-105295	M20	1.5	45 x 14	JBO-105036
M5	0.75	20 x 7	JBO-105298	M20	2	45 x 14	JBO-105039
M5.5	0.5	20 x 5	JBO-105305	M21	1	45 x 14	JBO-105043
M6	0.5	20 x 5	JBO-105353	M21	1.5	45 x 14	JBO-105046
M6	0.75	20 x 7	JBO-105356	M22	1	55 x 16	JBO-105056
M7	0.5	25 x 9	JBO-105395	M22	1.5	55 x 16	JBO-105059
M7	0.75	25 x 9	JBO-105398	M22	2	55 x 16	JBO-105062
M8	0.5	25 x 9	JBO-105425	M23	1	55 x 16	JBO-105068
M8	0.75	25 x 9	JBO-105427	M24	1	55 x 16	JBO-105077
M8	1	25 x 9	JBO-105431	M24	1.5	55 x 16	JBO-105081
M9	0.5	25 x 9	JBO-105452	M24	2	55 x 16	JBO-105084
M9	0.75	25 x 9	JBO-105455	M25	1	55 x 16	JBO-105092
M9	1	25 x 9	JBO-105457	M25	1.5	55 x 16	JBO-105095
M10	0.5	30 x 11	JBO-104879	M25	2	55 x 16	JBO-105097
M10	0.75	30 x 11	JBO-104882	M26	1	55 x 16	JBO-105100
M10	1	30 x 11	JBO-104885	M26	1.5	55 x 16	JBO-105101
M10	1.25	30 x 11	JBO-104887	M26	2	55 x 16	JBO-105104
M11	0.5	30 x 11	JBO-104899	M27	1	65 x 18	JBO-105110
M11	0.75	30 x 11	JBO-104900	M27	1.5	65 x 18	JBO-105112
M11	1	30 x 11	JBO-104902	M27	2	65 x 18	JBO-105114
M11	1.25	30 x 11	JBO-104904	M28	1	65 x 18	JBO-105118
M12	0.5	38 x 10	JBO-104911	M28	1.5	65 x 18	JBO-105121
M12	0.75	38 x 10	JBO-104913	M28	2	65 x 18	JBO-105124
M12	1	38 x 10	JBO-104916	M30	1	65 x 18	JBO-105155
M12	1.25	38 x 10	JBO-104918	M30	1.5	65 x 18	JBO-105158
M12	1.5	38 x 10	JBO-104920	M30	2	65 x 18	JBO-105161
M13	0.75	38 x 10	JBO-104929	M32	1	65 x 18	JBO-105170
M13	1	38 x 10	JBO-104932	M32	1.5	65 x 18	JBO-105173
M14	0.5	38 x 10	JBO-104939	M32	2	65 x 18	JBO-105176
M14	0.75	38 x 10	JBO-104941	M33	1.5	65 x 18	JBO-105183
M14	1	38 x 10	JBO-104944	M33	2	65 x 18	JBO-105185
M14	1.25	38 x 10	JBO-104948	M34	1	65 x 18	JBO-105189
M14	1.5	38 x 10	JBO-104950	M34	1.5	65 x 18	JBO-105191
M15	0.75	38 x 10	JBO-104957	M35	1.5	65 x 18	JBO-105198
M15	1	38 x 10	JBO-104959	M35	2	65 x 18	JBO-105200
M15	1.5	38 x 10	JBO-104962	M36	1	65 x 18	JBO-105207
M15	2	38 x 10	JBO-104964	M36	1.5	65 x 18	JBO-105209
M16	0.5	45 x 14	JBO-104969	M36	2	65 x 18	JBO-105211
M16	0.75	45 x 14	JBO-104970	M38	1.5	75 x 20	JBO-105223
M16	1	45 x 14	JBO-104972	M38	2	75 x 20	JBO-105225
M16	1.25	45 x 14	JBO-104974	M39	1.5	75 x 20	JBO-105230
M16	1.5	45 x 14	JBO-104975	M39	2	75 x 20	JBO-105231
M17	1	45 x 14	JBO-104982	M40	1.5	75 x 20	JBO-105251
M18	0.75	45 x 14	JBO-104991	M40	2	75 x 20	JBO-105253
M18	1	45 x 14	JBO-104994	M42	1.5	75 x 20	JBO-105259
M18	1.25	45 x 14	JBO-104996	M42	2	75 x 20	JBO-105261
M18	1.5	45 x 14	JBO-104997				
M18	2	45 x 14	JBO-105002				



UNC / UNF HSS SOLID DIE

Circular Solid Die with Spiral Entry

- Tolerance 2A
- For cutting steel up to 800N/mm²
- 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



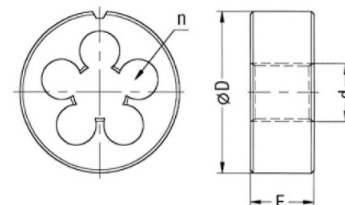
Thread	TPI	ØD x E	Order Code
UNC (Unified Coarse)			
No. 1	64	16 x 5	JBO-103171
No. 2	56	16 x 5	JBO-103183
No. 3	48	16 x 5	JBO-103185
No. 4	40	16 x 5	JBO-103187
No. 5	40	20 x 5	JBO-103200
No. 6	32	20 x 7	JBO-103202
No. 8	32	20 x 7	JBO-103210
No. 10	24	20 x 7	JBO-103174
No. 12	24	20 x 7	JBO-103177
1/4"	20	20 x 7	JBO-103229
5/16"	18	25 x 9	JBO-103247
3/8"	16	30 x 11	JBO-103240
7/16"	14	30 x 11	JBO-103255
1/2"	13	38 x 14	JBO-103226
9/16"	12	38 x 14	JBO-103262
5/8"	11	45 x 18	JBO-103252
3/4"	10	45 x 18	JBO-103237
7/8"	9	55 x 22	JBO-103260
1"	8	55 x 22	JBO-103216
1 1/8"	7	65 x 25	JBO-103223
1 1/4"	7	65 x 25	JBO-103221
1 1/2"	6	75 x 28	JBO-103219
UNF (Unified Fine)			
No. 0	80	16 x 5	JBO-103266
No. 1	72	16 x 5	JBO-103268
No. 2	64	16 x 5	JBO-103279
No. 3	56	16 x 5	JBO-103282
No. 4	48	16 x 5	JBO-103284
No. 5	44	20 x 5	JBO-103289
No. 6	40	20 x 5	JBO-103293
No. 8	36	20 x 7	JBO-103297
No. 10	32	20 x 7	JBO-103269
No. 12	28	20 x 7	JBO-103276
1/4"	28	20 x 7	JBO-103317
5/16"	24	25 x 9	JBO-103342
3/8"	24	30 x 11	JBO-103332
7/16"	20	30 x 11	JBO-103359
1/2"	20	38 x 14	JBO-103310
9/16"	18	38 x 14	JBO-103375
5/8"	18	45 x 18	JBO-103351
3/4"	16	45 x 18	JBO-103325
7/8"	14	55 x 22	JBO-103370
1"	12	55 x 22	JBO-103299
1 1/8"	12	65 x 25	JBO-103308
1 1/4"	12	65 x 25	JBO-103306
1 3/8"	12	65 x 25	JBO-103309
1 1/2"	12	75 x 28	JBO-103302



UNEF / UN / UNS HSS SOLID DIE

Circular Solid Die with Spiral Entry

- Tolerance 2A
- For cutting steel up to 800N/mm²
- 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



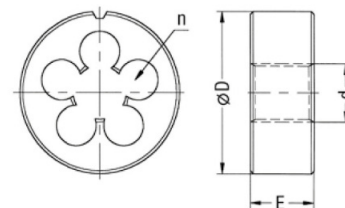
Thread	TPI	ØD x E	Order Code
UNEF (Unified Extra Fine)			
No. 12	32	20 x 7	JBO-104811
1/4"	32	20 x 7	JBO-104821
5/16"	32	25 x 9	JBO-104829
3/8"	32	30 x 11	JBO-104828
7/16"	28	30 x 11	JBO-104832
1/2"	28	38 x 10	JBO-104820
9/16"	24	38 x 10	JBO-104834
5/8"	24	45 x 14	JBO-104830
11/16"	24	45 x 14	JBO-104823
3/4"	20	45 x 14	JBO-104826
13/16"	20	45 x 14	JBO-104824
7/8"	20	55 x 16	JBO-104833
15/16"	20	55 x 16	JBO-104825
1"	20	55 x 16	JBO-104812
1 1/8"	18	65 x 18	JBO-104815
UN / UNS (Unified National / Unified National Special)			
1/4" UNS	40	20 x 5	JBO-103687
1/4" UNS	36	20 x 5	JBO-103682
1/4" UNS	24	20 x 7	JBO-103681
7/16" UNS	24	30 x 11	JBO-103750
1/2" UNS	24	38 x 10	JBO-105689
11/16" UN	20	45 x 14	JBO-105699
11/16" UN	16	45 x 14	JBO-105697
1" UNS	14	55 x 16	JBO-105647
1 1/16" UN	12	65 x 18	JBO-105664
1 3/16" UN	12	65 x 18	JBO-105675
1 5/16" UN	12	65 x 18	JBO-105682
1 5/8" UN	12	75 x 20	JBO-105679
1 3/4" UN	12	90 x 22	JBO-105668
2" UN	12	90 x 22	JBO-105712
1 1/8" UN	8	65 x 25	JBO-105663
1 1/4" UN	8	65 x 25	JBO-105660
1 3/8" UN	8	65 x 25	JBO-105674
1 1/2" UN	8	75 x 20	JBO-105656
1 3/4" UN	8	90 x 22	JBO-105671
2" UN	8	90 x 22	JBO-105713



BSW / BSF / BSP(G) HSS SOLID DIE

Circular Solid Die with Spiral Entry

- For cutting steel up to 800N/mm²
- 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



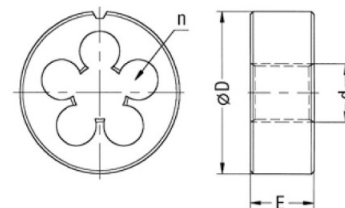
Thread	TPI	ØD	Order Code
BSW (British Standard Whitworth)			
1/8"	40	20	JBO-105780
5/32"	32	20	JBO-105828
3/16"	24	20	JBO-105806
7/32"	24	20	JBO-105841
1/4"	20	20	JBO-105775
5/16"	18	25	JBO-105824
3/8"	16	30	JBO-105813
7/16"	14	30	JBO-105836
1/2"	12	38	JBO-105769
9/16"	12	38	JBO-105851
5/8"	11	45	JBO-105831
3/4"	10	45	JBO-105808
7/8"	9	55	JBO-105842
1"	8	55	JBO-105752
1 1/8"	7	65	JBO-105762
1 1/4"	7	65	JBO-105760
1 3/8"	6	65	JBO-105765
1 1/2"	6	75	JBO-105758
1 3/4"	5	90	JBO-108681
2"	4	90	JBO-105793
BSP(G) Gas			
1/8"	28	30	JBO-101044
1/4"	19	38	JBO-101012
3/8"	19	45	JBO-101120
1/2"	14	45	JBO-100977
5/8"	14	55	JBO-101157
3/4"	14	55	JBO-101080
7/8"	14	65	JBO-101166
1"	11	65	JBO-100920
1 1/8"	11	75	JBO-100965
1 1/4"	11	75	JBO-100950
1 3/8"	11	90	JBO-100972
1 1/2"	11	90	JBO-100937
1 3/4"	11	90	JBO-100970
2"	11	105	JBO-101064
2 1/4"	11	105	JBO-101074
2 1/2"	11	120	JBO-101071
2 3/4"	11	120	JBO-101076
3"	11	130	JBO-101079
BSF (British Standard Fine)			
3/16"	32	20	JBO-105605
1/4"	26	20	JBO-105601
5/16"	22	25	JBO-105610
3/8"	20	30	JBO-105608
7/16"	18	30	JBO-105614
1/2"	16	38	JBO-105599
9/16"	16	38	JBO-105617
5/8"	14	45	JBO-105612
3/4"	12	45	JBO-105606
7/8"	11	55	JBO-105616
1"	10	55	JBO-105592



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

Circular Solid Die

- For cutting steel up to 800N/mm²
- 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

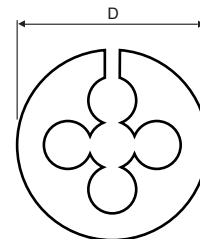


Thread	TPI	ØD	Order Code
NPT (National Pipe Taper)			
1/16"	27	25	JBO-103418
1/8"	27	30	JBO-103425
1/4"	18	38	JBO-103422
3/8"	18	45	JBO-103436
1/2"	14	45	JBO-103419
3/4"	14	55	JBO-103433
1"	11.5	65	JBO-103413
1 1/4"	11.5	75	JBO-103417
1 1/2"	11.5	90	JBO-103416
2"	11.5	105	JBO-103429
RD - Round Thread DIN 405			
Rd 10	10	38x14	JBO-103467
Rd 12	10	38x14	JBO-103471
Rd 14	8	45x18	JBO-103473
Rd 16	8	45x18	JBO-103474
Rd 18	8	45x18	JBO-103475
Rd 20	8	55x22	JBO-103477
Rd 24	8	55x22	JBO-103479
Rd 30	8	65x25	JBO-103482
PG			
Pg 7	20	38x10	JBO-105556
Pg 9	18	38x10	JBO-105557
Pg 11	18	45x14	JBO-105548
Pg 13.5	18	45x14	JBO-105549
Pg 16	18	55x16	JBO-105550
Pg 21	16	65x18	JBO-105551
Pg 29	16	65x18	JBO-105552
Pg 36	16	90x22	JBO-105553
NPTF (National Pipe Taper Fine)			
1/16"	27	25	JBO-105622
1/8"	27	30	JBO-105626
1/4"	18	38	JBO-105624
3/8"	18	45	JBO-105629
1/2"	14	45	JBO-105623
3/4"	14	55	JBO-105628
1"	11.5	65	JBO-105618
TR (Trapezoidal)			
Tr 10	2	38x14	JBO-103537
Tr 10	3	38x14	JBO-103544
Tr 12	2	38x14	JBO-103554
Tr 12	3	38x14	JBO-103558
Tr 14	2	38x14	JBO-103561
Tr 14	3	45x18	JBO-103563
Tr 14	4	45x18	JBO-103565
Tr 16	2	45x18	JBO-103571
Tr 16	4	45x18	JBO-103574
Tr 18	2	45x18	JBO-103579
Tr 18	4	45x18	JBO-103581
Tr 20	2	45x18	JBO-103585
Tr 20	4	55x22	JBO-103587
Tr 22	5	55x22	JBO-103591
Tr 24	5	65x25	JBO-103594
Tr 26	5	65x25	JBO-103599
Tr 28	5	65x25	JBO-103605
Tr 30	6	65x25	JBO-103610
Tr 32	6	65x25	JBO-103614
Tr 36	6	65x25	JBO-103618

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

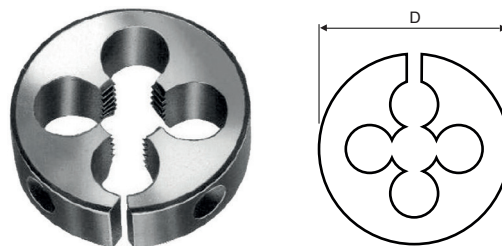


Thread	Pitch	D	Order Code	
			Cutwel Pro	Presto
M (Metric Coarse)				
M1.2	0.25	13/16"	-	641001.20.25-1316
M1.4	0.3	13/16"	-	641001.40.30-1316
M1.6	0.35	13/16"	-	641001.60.35-1316
M2	0.4	13/16"	-	641002.00.40-1316
M2.2	0.45	13/16"	-	641002.20.45-1316
M2.5	0.45	13/16"	-	641002.50.45-1316
M3	0.5	13/16"	CPSD-M3	641003.00.50-1316
M3.5	0.6	13/16"	-	641003.50.60-1316
M4	0.7	13/16"	CPSD-M4	641004.00.70-1316
M4.5	0.75	13/16"	-	641004.50.75-1316
M5	0.8	13/16"	CPSD-M5	641005.00.80-1316
M6	1	13/16"	CPSD-M6	641006.01.0-1316
M6	1	1"	-	641006.01.001-
M6	1	1 5/16"	-	641006.01.01-516
M7	1	13/16"	-	641007.01.0-1316
M7	1	1"	-	641007.01.001-
M7	1	1 5/16"	-	641007.01.01-516
M8	1.25	1"	CPSD-M8	641008.01.251-
M8	1.25	1 5/16"	-	641008.01.251-516
M9	1.25	1"	-	641009.01.251-
M9	1.25	1 5/16"	-	641009.01.251-516
M10	1.5	1"	-	641010.01.501-
M10	1.5	1 5/16"	CPSD-M10	641010.01.51-516
M10	1.5	1 1/2"	-	641010.01.51-12
M11	1.5	1 5/16"	-	641011.01.51-516
M11	1.5	1 1/2"	-	641011.01.51-12
M12	1.75	1 5/16"	CPSD-M12	641012.01.751-516
M12	1.75	1 1/2"	-	641012.01.751-12
M12	1.75	2"	-	641012.01.752-
M14	2	1 5/16"	CPSD-M14	641014.02.01-516
M14	2	1 1/2"	-	641014.02.01-12
M14	2	2"	-	641014.02.02-
M16	2	1 1/2"	CPSD-M16	641016.02.01-12
M16	2	2"	-	641016.02.02-
M18	2.5	1 1/2"	-	641018.02.51-12
M18	2.5	2"	-	641018.02.52-
M20	2.5	1 1/2"	-	641020.02.51-12
M20	2.5	2"	CPSD-M20	641020.02.52-
M22	2.5	2"	-	641022.02.52-
M24	3	2"	CPSD-M24	641024.03.02-
M24	3	3"	-	641024.03.03-
M27	3	3"	-	641027.03.03-
M30	3.5	3"	-	641030.03.53-
M33	3.5	3"	-	641033.03.53-
MF (Metric Fine)				
M3	0.35	13/16"	-	641103.00.35-1316
M4	0.5	13/16"	-	641104.00.5-1316
M5	0.5	13/16"	-	641105.00.5-1316
M6	0.75	13/16"	-	641106.00.75-1316
M7	0.75	1"	-	641107.00.751-
M8	0.75	1"	-	641108.00.751-
M8	1	1"	-	641108.01.01-
M9	1	1"	-	641109.01.01-
M10	0.75	1"	-	6411010.00.751-
M10	1	1"	-	6411010.01.01-
M10	1.25	1"	-	6411010.01.251-
M12	1	1 5/16"	-	6411012.01.01-516
M12	1.25	1 5/16"	-	6411012.01.251-516
M12	1.5	1 5/16"	-	6411012.01.51-516
M14	1.25	1 5/16"	-	6411014.01.251-516
M14	1.25	1 1/2"	-	6411014.01.251-12
M14	1.5	1 1/2"	-	6411014.01.51-12
M16	1	1 1/2"	-	6411016.01.01-12
M16	1.5	1 1/2"	-	6411016.01.51-12
M18	1.5	1 1/2"	-	6411018.01.51-12
M20	1	1 1/2"	-	6411020.01.01-12
M20	1.5	2"	-	6411020.01.52-
M20	2	1 1/2"	-	6411020.02.01-12
M22	1.5	2"	-	6411022.01.52-
M24	1.5	2"	-	6411024.01.52-
M24	2	2"	-	6411024.02.02-
M25	1.5	2"	-	6411025.01.52-
M27	2	3"	-	6411027.02.03-
M30	2	3"	-	6411030.02.03-
M32	1.5	3"	-	6411032.01.53-

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

**HSS****60°****BRIGHT
FINISH**

UNC	TPI	D	Order Code	
			Cutwel Pro	Presto
No.1	64	13/16"	-	641201N-1316
No.2	56	13/16"	-	641202N-1316
No.3	48	13/16"	-	641203N-1316
No.4	40	13/16"	-	641204N-1316
No.5	40	13/16"	-	641205N-1316
No.6	32	13/16"	-	641206N-1316
No.8	32	13/16"	-	641208N-1316
No.10	24	13/16"	-	6412010N-1316
No.12	24	13/16"	-	6412012N-1316
1/4"	20	13/16"	CPSD-1/4UNC	64120-14-1316
1/4"	20	1"	-	64120-141-
1/4"	20	1 5/16"	-	64120-141-516
5/16"	18	1"	CPSD-5/16UNC	64120-5161-
5/16"	18	1 5/16"	-	64120-5161-516
3/8"	16	1"	CPSD-3/8UNC	64120-381-
3/8"	16	1 5/16"	-	64120-381-516
3/8"	16	1 1/2"	-	64120-381-12
7/16"	14	1 5/16"	-	64120-7161-516
7/16"	14	1 1/2"	-	64120-7161-12
1/2"	13	1"	CPSD-1/2UNC	-
1/2"	13	1 5/16"	-	64120-121-516
1/2"	13	1 1/2"	-	64120-121-12
1/2"	13	2"	-	64120-122-
9/16"	12	1 5/16"	-	64120-9161-516
9/16"	12	1 1/2"	CPSD-9/16UNC	64120-9161-12
9/16"	12	2"	-	64120-9162-
5/8"	11	1 1/2"	-	64120-581-12
5/8"	11	2"	-	64120-582-
3/4"	10	1 1/2"	CPSD-3/4UNC	64120-341-12
3/4"	10	2"	-	64120-342-
7/8"	9	2"	CPSD-7/8UNC	64120-782-
1"	8	2"	CPSD-1UNC	641201-2-
1"	8	3"	-	641201-3-
1 1/8"	7	3"	-	641201-183-
1 1/4"	7	3"	-	641201-143-
1 3/8"	6	3"	-	641201-383-
1 1/2"	6	3"	-	641201-123-

UNF	TPI	D	Order Code	
			Cutwel Pro	Presto
No.1	72	13/16"	-	641301N-1316
No.2	64	13/16"	-	641302N-1316
No.3	56	13/16"	-	641303N-1316
No.4	48	13/16"	-	641304N-1316
No.5	44	13/16"	-	641305N-1316
No.6	40	13/16"	-	641306N-1316
No.8	36	13/16"	-	641308N-1316
No.10	32	13/16"	-	6413010N-1316
No.12	28	13/16"	-	6413012N-1316
1/4"	28	13/16"	CPSD-1/4UNF	64130-14-1316
1/4"	28	1"	-	64130-141-
1/4"	28	1 5/16"	-	64130-141-516
5/16"	24	1"	CPSD-5/16UNF	64130-5161-
5/16"	24	1 5/16"	-	64130-5161-516
3/8"	24	1"	CPSD-3/8UNF	64130-381-
3/8"	24	1 5/16"	-	64130-381-516
3/8"	24	1 1/2"	-	64130-381-12
7/16"	20	1 5/16"	-	64130-7161-516
7/16"	20	1 1/2"	-	64130-7161-12
1/2"	20	1"	CPSD-1/2UNF	-
1/2"	20	1 5/16"	-	64130-121-516
1/2"	20	1 1/2"	-	64130-121-12
1/2"	20	2"	-	64130-122-
9/16"	18	1 5/16"	-	64130-9161-516
9/16"	18	1 1/2"	CPSD-9/16UNF	64130-9161-12
9/16"	18	2"	-	64130-9162-
5/8"	18	1 1/2"	-	64130-581-12
5/8"	18	2"	-	64130-582-
3/4"	16	1 1/2"	CPSD-3/4UNF	64130-341-12
3/4"	16	2"	-	64130-342-
7/8"	14	2"	CPSD-7/8UNF	64130-782-
1"	12	2"	-	641301-2-
1"	12	3"	-	641301-3-
1 1/8"	12	3"	-	641301-183-
1 1/4"	12	3"	-	641301-143-
1 3/8"	12	3"	-	641301-383-
1 1/2"	12	3"	-	641301-123-

UNC / UNF DIES

PRESTO**DIE STOCK FOR SPLIT DIES**

- BS 1127 (for inch size OD dies)

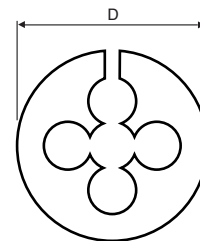


Die Diameter	Length	Order Code
13/16"	6 1/2"	69403-1316
1"	8 7/8"	694031-
1 5/16"	11"	694031-516
1 1/2"	14 1/4"	694031-12
2"	19 1/8"	694032-
2 1/4"	23"	694032-14
3"	30"	694033-
4"	56"	694034-

PRESTO**BSW / BSF HSS SPLIT DIES**

Circular Split Die

- Split die can be adjusted for tighter or looser thread

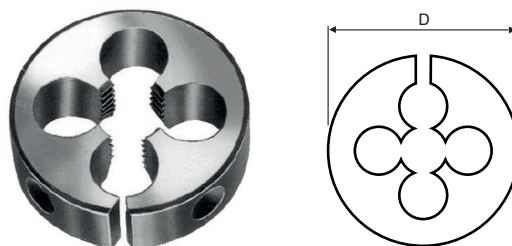
**HSS****55°****BRIGHT FINISH**

Thread	TPI	D	Order Code
BSW (British Standard Whitworth)			
1/16"	60	13/16"	64140-116-1316
3/32"	48	13/16"	64140-332-1316
1/8"	40	13/16"	64140-18-1316
5/32"	32	13/16"	64140-532-1316
3/16"	24	13/16"	64140-316-1316
3/16"	24	1"	64140-3161-
1/4"	20	13/16"	64140-14-1316
1/4"	20	1"	64140-141-
1/4"	20	1 5/16"	64140-141-516
1/4"	20	1 1/2"	64140-141-12
5/16"	18	1"	64140-5161-
5/16"	18	1 5/16"	64140-5161-516
5/16"	18	1 1/2"	64140-5161-12
3/8"	16	1"	64140-381-
3/8"	16	1 5/16"	64140-381-516
3/8"	16	1 1/2"	64140-381-12
7/16"	14	1 5/16"	64140-7161-516
7/16"	14	1 1/2"	64140-7161-12
1/2"	12	1 5/16"	64140-121-516
1/2"	12	1 1/2"	64140-121-12
9/16"	12	1 5/16"	64140-9161-516
9/16"	12	1 1/2"	64140-9161-12
9/16"	12	2"	64140-9162-
5/8"	11	1 1/2"	64140-581-12
5/8"	11	2"	64140-582-
11/16"	11	2"	64140-11162-
3/4"	10	1 1/2"	64140-341-12
3/4"	10	2"	64140-342-
7/8"	9	2"	64140-782-
1"	8	2"	641401-2-
1"	8	3"	641401-3-
1 1/8"	7	3"	641401-183-
1 1/4"	7	3"	641401-143-
1 3/8"	6	3"	641401-383-
1 1/2"	6	3"	641401-123-
BSF			
3/16"	32	13/16"	64150-316-1316
1/4"	26	13/16"	64150-14-1316
1/4"	26	1"	64150-141-
1/4"	26	1 5/16"	64150-141-516
5/16"	22	1 5/16"	64150-5161-516
5/16"	22	1"	64150-5161-
5/16"	22	1 1/2"	64150-5161-12
3/8"	20	1"	64150-381-
3/8"	20	1 5/16"	64150-381-516
3/8"	20	1 1/2"	64150-381-12
7/16"	18	1 5/16"	64150-7161-516
7/16"	18	1 1/2"	64150-7161-12
1/2"	16	1 5/16"	64150-121-516
1/2"	16	1 1/2"	64150-121-12
1/2"	16	2"	64150-122-
9/16"	16	1 5/16"	64150-9161-516
9/16"	16	1 1/2"	64150-9161-12
9/16"	16	2"	64150-9162-
5/8"	14	1 1/2"	64150-581-12
5/8"	14	2"	64150-582-
3/4"	12	1 1/2"	64150-341-12
3/4"	12	2"	64150-342-
7/8"	11	2"	64150-782-
1"	10	2"	641501-2-
1"	10	3"	641501-3-
1 1/8"	9	3"	641501-183-
1 1/4"	9	3"	641501-143-
1 3/8"	8	3"	641501-383-
1 1/2"	8	3"	641501-123-

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

Circular Split Die

- Split die can be adjusted for tighter or looser thread

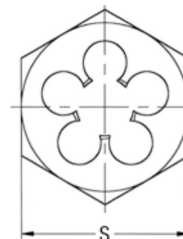


Thread	TPI	D	Order Code
BSP(G)			
1/8"	28	1"	64160-181-
1/8"	28	1 5/16"	64160-181-516
1/8"	28	1 1/2"	64160-181-12
1/4"	19	1 5/16"	64160-141-516
1/4"	19	1 1/2"	64160-141-12
1/4"	19	2"	64160-142-
3/8"	19	1 1/2"	64160-381-12
3/8"	19	2"	64160-382-
1/2"	14	2"	64160-122-
1/2"	14	2 1/4"	64160-122-14
5/8"	14	2"	64160-582-
3/4"	14	2"	64160-342-
3/4"	14	2 1/4"	64160-342-14
3/4"	14	3"	64160-343-
7/8"	14	2 1/4"	64160-782-14
7/8"	14	3"	64160-783-
1"	11	2 1/4"	641601-2-14
1"	11	3"	641601-3-
1"	11	4"	641601-4-
1 1/4"	11	3"	641601-143-
1 1/2"	11	4"	641601-124-
1 3/4"	11	4"	641601-344-
2"	11	4"	641602-4-
BA			
No.0	25.4	13/16"	641700N-1316
No.1	28.2	13/16"	641701N-1316
No.2	31.4	13/16"	641702N-1316
No.3	34.8	13/16"	641703N-1316
No.4	38.5	13/16"	641704N-1316
No.5	43	13/16"	641705N-1316
No.6	47.9	13/16"	641706N-1316
No.7	52.9	13/16"	641707N-1316
No.8	59.1	13/16"	641708N-1316
No.9	65.1	13/16"	641709N-1316
No.10	72.6	13/16"	6417010N-1316
No.12	90.9	13/16"	6417012N-1316
No.14	110.4	13/16"	6417014N-1316

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



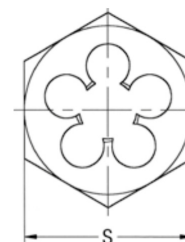
BRIGHT
FINISH

Thread	Pitch	S	Cutwel Pro	Order Code Presto	JBO
M (Metric Coarse)					
M3	0.5	19	CPHD-M3	644003.00.5	JBO-120260
M4	0.7	19	CPHD-M4	644004.00.7	JBO-120319
M5	0.8	19	CPHD-M5	644005.00.8	JBO-120370
M6	1	19	CPHD-M6	644006.01.0	JBO-120418
M7	1	22	-	644007.01.0	-
M8	1.25	22	CPHD-M8	644008.01.25	JBO-120486
M9	1.25	22	-	644009.01.25	-
M10	1.5	27	CPHD-M10	644010.01.5	JBO-120082
M11	1.5	27	-	644011.01.5	-
M12	1.75	36	CPHD-M12	644012.01.75	JBO-120108
M14	2	36	CPHD-M14	644014.02.0	JBO-120128
M16	2	41	CPHD-M16	644016.02.0	JBO-120151
M18	2.5	41	-	644018.02.5	JBO-120170
M20	2.5	41	CPHD-M20	644020.02.5	JBO-120191
M22	2.5	50	-	644022.02.5	JBO-120205
M24	3	50	CPHD-M24	644024.03.0	JBO-120220
M27	3	60	-	644027.03.0	JBO-120243
M30	3.5	60	-	644030.03.5	JBO-120267
M33	3.5	60	-	644033.03.5	JBO-120284
M36	4	60	-	644036.04.0	JBO-120299
M42	4.5	70	-	644042.04.5	-
M45	4.5	70	-	-	JBO-120347
M48	4.5	70	-	-	JBO-120360
MF (Metric Fine)					
M3	0.35	19	-	644103.00.35	-
M4	0.5	19	-	644104.00.5	-
M5	0.5	19	-	644105.00.5	-
M6	0.75	19	-	644106.00.75	-
M8	1	22	-	644108.01.0	-
M10	1	27	-	644110.01.0	-
M10	1.25	27	-	644110.01.25	-
M12	1.25	36	-	644112.01.25	-
M12	1.5	36	-	644112.01.5	JBO-120116
M14	1.25	36	-	644114.01.25	-
M14	1.5	36	-	644114.01.5	JBO-120135
M16	1.5	41	-	644116.01.5	JBO-120161
M18	1.5	41	-	644118.01.5	JBO-120176
M20	1.5	41	-	644120.01.5	-
M22	1.5	50	-	644122.01.5	JBO-120210
M24	1.5	50	-	644124.01.5	JBO-120224
M24	2	50	-	644124.02.0	JBO-120226
M27	2	60	-	-	JBO-120250
M30	1.5	60	-	-	JBO-120270
M30	2	60	-	644130.02.0	JBO-120272
M32	1.5	60	-	644132.01.5	-
M33	1.5	60	-	-	JBO-120288
M40	1.5	70	-	644140.01.5	JBO-120327
M42	1.5	70	-	644142.01.5	JBO-120339
M45	1.5	85	-	-	JBO-120349
M48	1.5	85	-	-	JBO-120362
M48	3	85	-	-	JBO-120367
M56	2	85	-	-	JBO-120407

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

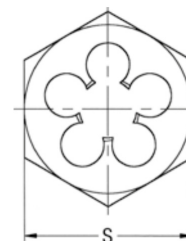


Thread	TPI	S	Order Code		
			Cutwel Pro	Presto	JBO
UNC (Unified Coarse)					
No 8	32	19	-	644208N	-
No 10	24	19	-	6442010N	-
No 12	24	19	-	6442012N	-
1/4"	20	19	CPHD-1/4UNC	64420-14	JBO-120544
5/16"	18	22	CPHD-5/16UNC	64420-516	JBO-120553
3/8"	16	27	CPHD-3/8UNC	64420-38	JBO-120552
7/16"	14	27	-	64420-716	JBO-120557
1/2"	13	36	CPHD-1/2UNC	64420-12	JBO-120542
9/16"	12	36	CPHD-9/16UNC	64420-916	JBO-120560
5/8"	11	41	-	64420-58	JBO-120555
3/4"	10	41	CPHD-3/4UNC	64420-34	JBO-120550
7/8"	9	50	CPHD-7/8UNC	64420-78	JBO-120558
1"	8	50	CPHD-1UNC	644201-	JBO-120534
1 1/8"	7	60	-	644201-18	JBO-120539
1 1/4"	7	60	-	644201-14	JBO-120537
1 3/8"	6	60	-	644201-38	-
1 1/2"	6	70	-	644201-12	-
1 3/4"	5	80	-	644201-34	-
2"	4 5	85	-	644202-	-
UNF (Unified Fine)					
No 8	36	19	-	644308N	-
No 10	32	19	-	6443010N	-
No 12	28	19	-	6443012N	-
1/4"	28	19	-	64430-14	JBO-120580
1/4"	25	19	CPHD-1/4UNF	-	-
5/16"	24	22	CPHD-5/16UNF	64430-516	JBO-120586
3/8"	24	27	CPHD-3/8UNF	64430-38	JBO-120584
7/16"	20	27	-	64430-716	JBO-120590
1/2"	20	36	CPHD-1/2UNF	64430-12	JBO-120578
9/16"	18	36	CPHD-9/16UNF	64430-916	JBO-120594
5/8"	18	41	-	64430-58	JBO-120588
3/4"	16	41	CPHD-3/4UNF	64430-34	JBO-120582
7/8"	14	50	CPHD-7/8UNF	64430-78	-
1"	12	50	-	644301-	JBO-120571
1 1/8"	12	60	-	644301-18	-
1 1/4"	12	60	-	644301-14	-
1 3/8"	12	60	-	644301-38	-
1 1/2"	12	70	-	644301-12	-

**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



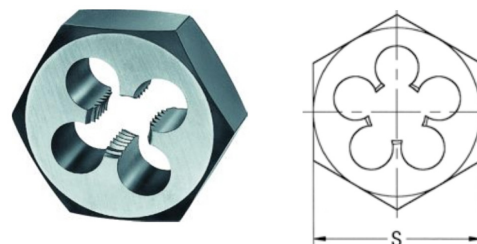
Thread	TPI	S	Order Code	
			Presto	JBO
BSW (British Standard Whitworth)				
1/8"	40	19	64440-18	JBO-120829
3/16"	24	19	64440-316	JBO-120857
1/4"	20	19	64440-14	JBO-120827
5/16"	18	22	64440-516	JBO-120876
3/8"	16	27	64440-38	JBO-120864
7/16"	14	27	64440-716	JBO-120882
1/2"	12	36	64440-12	JBO-120824
9/16"	12	36	64440-916	-
5/8"	11	41	64440-58	JBO-120879
3/4"	10	41	64440-34	JBO-120860
7/8"	9	50	64440-78	JBO-120885
1"	8	50	644401-	JBO-120806
1 1/8"	7	60	644401-18	JBO-120813
1 1/4"	7	60	644401-14	JBO-120811
1 3/8"	6	60	644401-38	JBO-120820
1 1/2"	6	70	644401-12	JBO-120810
1 3/4"	5	80	644401-34	JBO-120818
2"	4.5	85	644402-	JBO-120836
BSP(G)				
1/8"	28	27	64460-18	JBO-120014
1/4"	19	36	64460-14	JBO-120012
3/8"	19	41	64460-38	JBO-120067
1/2"	14	41	64460-12	JBO-120010
3/4"	14	50	64460-34	JBO-120025
1"	11	60	644601-	JBO-120058
1 1/4"	11	70	644601-14	JBO-120063
1 3/8"	11		-	JBO-120006
1 1/2"	11	85	644601-12	JBO-120061
2"	11	100	-	JBO-120016
2 1/2"	11	115	-	JBO-120018
BSF				
3/16"	32	19	64450-316	-
1/4"	26	19	64450-14	-
5/16"	22	22	64450-516	-
3/8"	20	27	64450-38	-
7/16"	18	27	64450-716	-
1/2"	16	36	64450-12	-
9/16"	16	36	64450-916	-
5/8"	14	41	64450-58	-
3/4"	12	41	64450-34	-
7/8"	11	50	64450-78	-
1"	10	50	644501-	-
1 1/8"	9	60	644501-18	-
1 1/4"	9	60	644501-14	-
1 3/8"	8	60	644501-38	-
1 1/2"	8	70	644501-12	-
1 5/8"	8	70	644501-58	-
1 3/4"	7	80	644501-34	-



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	JBO
1/8"	27	27	64490-18	JBO-120611
1/4"	18	36	64490-14	JBO-120610
3/8"	18	41	64490-38	JBO-120616
1/2"	14	50	64490-12	JBO-120609
3/4"	14	60	64490-34	JBO-120615
1"	11.5	60	644901-	JBO-120604
1 1/4"	11.5	85	644901-14	-
1 1/2"	11.5	85	644901-12	-
2"	11.5	100	644902-	-



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/mm²



Die Range	Order Code
M3-M12	13434500

Thread Turning Tools

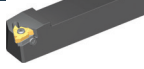
VARDEX  Cutting Tools

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.

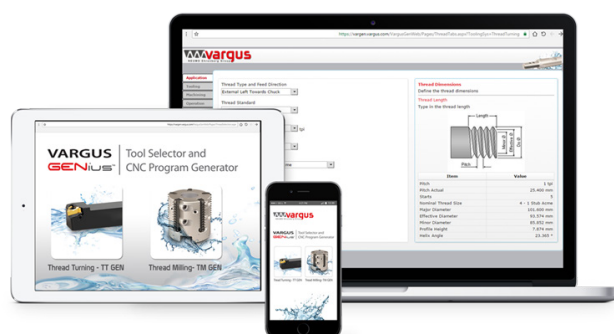
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The world's most intelligent threading tool selector and CNC program generator.

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.

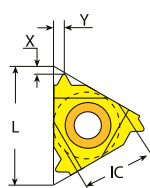
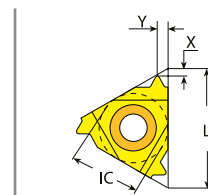


Find out More

VARDEX**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**

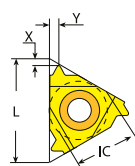
*Min bore dimension applies only to MINIPRO style inserts which require dedicated holders.

Insert Size		Pitch mm	EXTERNAL Inserts			INTERNAL Inserts		
IC	L mm		ISO Code	VTX Grade	FST Grade	ISO Code	VTX Grade	FST Grade
4mm	6	0.25	-	-	-	4.0KIR0.25ISO	028-00155	-
		0.5	-	-	-	4.0KIR0.5ISO	028-00017	-
		0.75	-	-	-	4.0KIR0.75ISO	028-00018	-
		1	-	-	-	4.0KIR1.0ISO	028-00019	-
		1.25	-	-	-	4.0KIR1.25ISO	028-00020	-
5mm	8	0.5	-	-	-	5.0KIR0.5ISO	028-00157	-
		0.75	-	-	-	5.0KIR0.75ISO	028-00158	-
		1	-	-	-	5.0KIR1.0ISO	028-00159	-
		1.25	-	-	-	5.0KIR1.25ISO	028-00162	-
		1.5	-	-	-	5.0KIR1.5ISO	028-00160	-
		1.75	-	-	-	5.0KIR1.75ISO	028-00163	-
1/4"	11 (11ER/11NR)	0.35	2ER0.35ISO	021-54243	-	2IR0.35ISO	021-00375	-
		0.4	2ER0.4ISO	021-53504	-	2IR0.4ISO	021-00377	-
		0.45	2ER0.45ISO	021-51901	-	2IR0.45ISO	021-00381	-
		0.5	2ER0.5ISO	021-53790	-	2IR0.5ISO	021-00385	-
		0.6	2ER0.6ISO	021-00154	-	2IR0.6ISO	021-00387	-
		0.7	2ER0.7ISO	021-00161	-	2IR0.7ISO	021-00391	-
		0.75	2ER0.75ISO	021-00270	-	2IR0.75ISO	021-54357	-
		0.8	2ER0.8ISO	021-00172	-	2IR0.8ISO	021-00397	-
		1	2ER1.0ISO	021-00175	-	2IR1.0ISO	021-53625	162-00011
		1.25	2ER1.25ISO	021-00179	-	2IR1.25ISO	021-53632	-
		1.5	2ER1.5ISO	021-00186	-	2IR1.5ISO	021-53624	162-00057
		1.75	2ER1.75ISO	021-00194	-	2IR1.75ISO	021-53607	-
		2	-	-	-	2IR2.0ISO	021-05226	162-00123
		2.5	-	-	-	2IR2.5ISO	021-00430	-
3/8"	16 (16ER/16NR)	0.25	3ER0.25ISO	021-04764	-	-	-	-
		0.3	3ER0.3ISO	021-04767	-	-	-	-
		0.35	3ER0.35ISO	021-51115	-	3IR0.35ISO	021-01261	-
		0.4	3ER0.4ISO	021-54033	-	3IR0.4ISO	021-01265	-
		0.45	3ER0.45ISO	021-00828	-	3IR0.45ISO	021-01268	-
		0.5	3ER0.5ISO	021-51001	-	3IR0.5ISO	021-51009	-
		0.6	3ER0.6ISO	021-00835	-	3IR0.6ISO	021-01276	-
		0.7	3ER0.7ISO	021-53795	-	3IR0.7ISO	021-01278	-
		0.75	3ER0.75ISO	021-53663	-	3IR0.75ISO	021-53514	-
		0.8	3ER0.8ISO	021-53608	-	3IR0.8ISO	021-01284	-
		1	3ER1.0ISO	021-53609	162-00015	3IR1.0ISO	021-53910	162-00039
		1.25	3ER1.25ISO	021-51064	162-00017	3IR1.25ISO	021-53911	162-00125
		1.5	3ER1.5ISO	021-51077	162-00001	3IR1.5ISO	021-52253	162-00041
		1.75	3ER1.75ISO	021-54235	162-00121	3IR1.75ISO	021-51005	162-00139
		2	3ER2.0ISO	021-51547	162-00019	3IR2.0ISO	021-53912	162-00045
		2.5	3ER2.5ISO	021-53909	162-00021	3IR2.5ISO	021-53913	162-00127
		3	3ER3.0ISO	021-51716	162-00007	3IR3.0ISO	021-52708	162-00043
		3.5	3ER3.5ISO	021-05667	-	3IR3.5ISO	021-05666	-
1/2"	22 (22ER/22NR)	3.5	4ER3.5ISO	021-59022	-	4IR3.5ISO	021-59484	-
		4	4ER4.0ISO	021-59122	-	4IR4.0ISO	021-59289	-
		4.5	4ER4.5ISO	021-01460	-	4IR4.5ISO	021-59000	-
		5	4ER5.0ISO	021-58583	-	4IR5.0ISO	021-59476	-
		5.5	4ER5.5ISO	021-01470	-	4IR5.5ISO	021-01600	-
		6	4ER6.0ISO	021-01476	-	4IR6.0ISO	021-01606	-
5/8"	27 (27ER/27NR)	4.5	-	-	-	5IR4.5ISO	021-05835	-
		5	-	-	-	5IR5.0ISO	021-05492	-
		5.5	5ER5.5ISO	021-59111	-	5IR5.5ISO	021-59305	-
		6	5ER6.0ISO	021-59492	-	5IR6.0ISO	021-58945	-

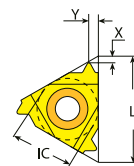
WHITWORTH 55° (BSW/BSF/BSP) - FULL PROFILE THREADING INSERTS

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



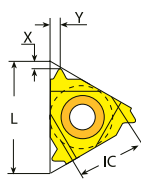
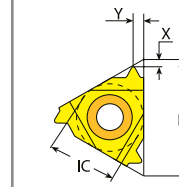
INTERNAL

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

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.

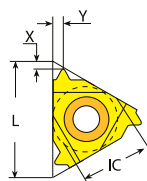
Insert Size		Pitch	EXTERNAL Inserts			INTERNAL Inserts		
IC	L mm	TPI	ISO Code	VTX Grade	FST Grade	ISO Code	VTX Grade	FST Grade
4mm	6	32	-	-	-	4.0KIR32UN	028-00016	-
		28	-	-	-	4.0KIR28UN	028-00015	-
		24	-	-	-	4.0KIR24UN	028-00010	-
		20	-	-	-	4.0KIR20UN	028-00008	-
		18	-	-	-	4.0KIR18UN	028-00006	-
5mm	8	32	-	-	-	5.0KIR32UN	028-00185	-
		28	-	-	-	5.0KIR28UN	028-00183	-
		24	-	-	-	5.0KIR24UN	028-00178	-
		20	-	-	-	5.0KIR20UN	028-00176	-
		18	-	-	-	5.0KIR18UN	028-00171	-
		16	-	-	-	5.0KIR16UN	028-00167	-
1/4"	11 (11ER/11NR)	14	-	-	-	5.0KIR14UN	028-00164	-
		72	-	-	-	2IR72UN	021-53233	-
		64	2ER64UN	021-05874	-	2IR64UN	021-50620	-
		56	-	-	-	2IR56UN	021-00370	-
		48	-	-	-	2IR48UN	021-53100	-
		40	2ER40UN	021-00121	-	2IR40UN	021-53207	-
		36	2ER36UN	021-05916	-	2IR36UN	021-06628	-
		32	2ER32UN	021-00119	-	2IR32UN	021-50564	-
		28	2ER28UN	021-50159	-	2IR28UN	021-52961	-
		24	2ER24UN	021-50106	-	2IR24UN	021-53208	-
		20	2ER20UN	021-04579	-	2IR20UN	021-50486	-
		18	2ER18UN	021-06845	-	2IR18UN	021-50444	-
		16	2ER16UN	021-00083	-	2IR16UN	021-50402	-
		14	2ER14UN	021-04488	-	2IR14UN	021-53818	-
3/8"	16 (16ER/16NR)	80	3ER80UN	021-50081	-	-	-	-
		72	3ER72UN	021-53508	-	3IR72UN	021-53241	-
		64	3ER64UN	021-54304	-	3IR64UN	021-01500	-
		56	3ER56UN	021-53671	-	3IR56UN	021-01247	-
		48	3ER48UN	021-53849	-	3IR48UN	021-01253	-
		44	3ER44UN	021-05715	-	3IR44UN	021-05716	-
		40	3ER40UN	021-53669	-	3IR40UN	021-01248	-
		36	3ER36UN	021-51765	-	3IR36UN	021-51856	-
		32	3ER32UN	021-51746	-	3IR32UN	021-52724	-
		28	3ER28UN	021-51697	-	3IR28UN	021-52701	-
		27	3ER27UN	021-51660	-	3IR27UN	021-01223	-
		24	3ER24UN	021-51623	162-00173	3IR24UN	021-52667	-
		20	3ER20UN	021-51591	162-00023	3IR20UN	021-52646	162-00133
		18	3ER18UN	021-51511	162-00129	3IR18UN	021-52595	162-00165
		16	3ER16UN	021-51451	162-00025	3IR16UN	021-52556	162-00135
		14	3ER14UN	021-51383	162-00131	3IR14UN	021-52499	162-00159
		13	3ER13UN	021-52889	-	3IR13UN	021-54242	-
		12	3ER12UN	021-51291	162-00027	3IR12UN	021-52421	162-00047
		11.5	3ER11.5UN	021-53533	-	3IR11.5UN	021-53534	-
		11	3ER11UN	021-51175	-	3IR11UN	021-54241	-
		10	3ER10UN	021-51144	-	3IR10UN	021-52306	-
1/2"	22	9	3ER9UN	021-54236	-	3IR9UN	021-54251	-
		8	3ER8UN	021-51924	162-00157	3IR8UN	021-52853	162-00149
		7	4ER7UN	021-59317	-	4IR7UN	021-59483	-
5/8"	27	6	4ER6UN	021-58654	-	4IR6UN	021-58800	-
		5	4ER5UN	021-59316	-	4IR5UN	021-59203	-
		4.5	5ER4.5UN	021-58988	-	5IR4.5UN	021-59485	-
		4	5ER4UN	021-58983	-	5IR4UN	021-59491	-

VARDEX

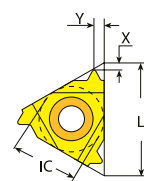
BSPT 55° - FULL PROFILE THREADING INSERTS

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



EXTERNAL



INTERNAL

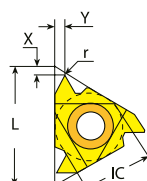


Insert Size		Pitch	EXTERNAL Inserts			INTERNAL Inserts		
IC	L mm	TPI	ISO Code	VTX Grade	FST Grade	ISO Code	VTX Grade	FST Grade
1/4"	11 (11ER/ 11NR)	28	2ER28BSPT	021-00111	-	2IR28BSPT	021-00353	-
		19	2ER19BSPT	021-00094	-	2IR19BSPT	021-00326	-
		14	2ER14BSPT	021-00069	-	2IR14BSPT	021-51930	-
3/8"	16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

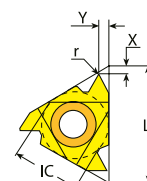
VARDEX

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



EXTERNAL



INTERNAL

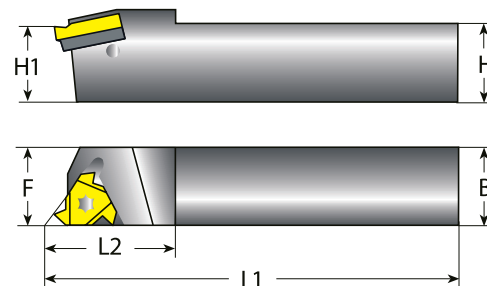
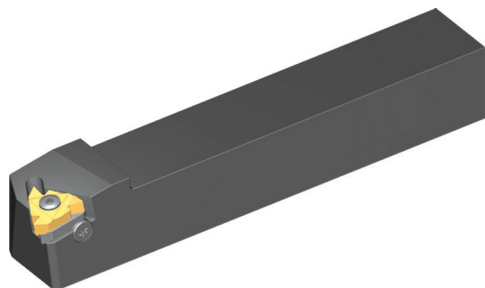
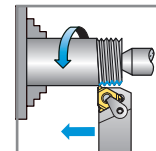


Insert Size		Pitch		EXTERNAL Inserts			INTERNAL Inserts		
IC	L mm	mm	TPI	ISO Code	VTX Grade	FST Grade	ISO Code	VTX Grade	FST Grade
55° Partial Profile									
4mm	6	0.5-1.25	48-20	-	-	-	4.0KIRA55	028-00004	-
5mm	8	0.5-1.5	48-16	-	-	-	5.0KIRA55	028-00186	-
6mm	10	0.5-1.5	48-16	-	-	-	6.0KIRA55	028-00385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

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)

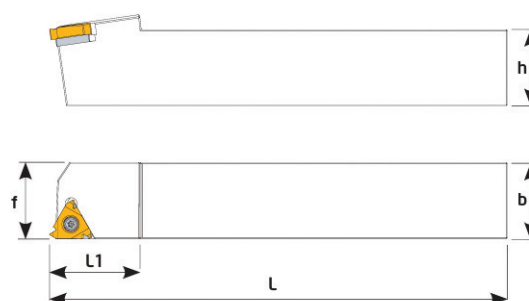
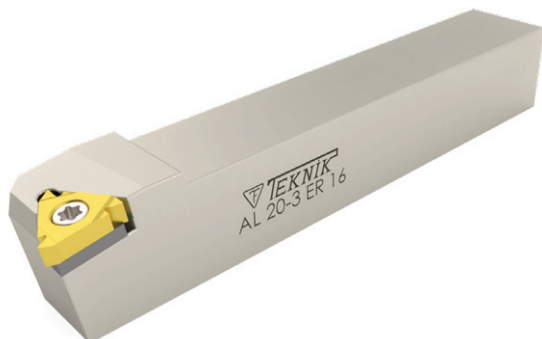
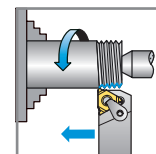


Shank H=H1=B	F	L1	L2	Insert Size IC	Order Code	Inserts	Insert Screw	Shim Screw	Spares		Wrench
									Shim RH	Shim LH	
8	11	136.4	17.5	1/4"	NL8-2	2ER/EL 11ER/EL	SN2T	-	-	-	K2T
10	11	125	17.5		NL10-2						
12	12	125	17.5		NL12-2						
12	16	83.2	22		NL12-3						
12	16	83.2	22	3/8"	AL12-3	3ER/EL 16ER/EL	SA3T	SY3T	YE3	YI3	K3T
16	16	100	20.5		AL16-3						
20	20	128.6	30		AL20-3						
25	25	153.6	30		AL25-3						
32	32	173.6	30		AL32-3						
25	25	155.7	36	1/2"	AL25-4	4ER/EL 22ER/EL	SA4T	SY4T	YE4	YI4	K4T
32	32	175.7	36		AL32-4						
40	40	205.7	36		AL40-4						
25	32	151.6	35	5/8"	AL25-5	5ER/EL 27ER/EL	SA5Y	SY5T	YE5	YI5	K5T
32	32	176.6	40		AL32-5						
40	40	206.6	40		AL40-5						
50	50	256.6	40		AL50-5						

TEKNIK
Cutting Tools**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



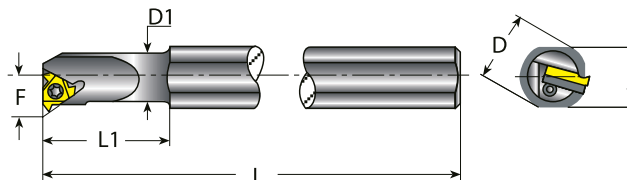
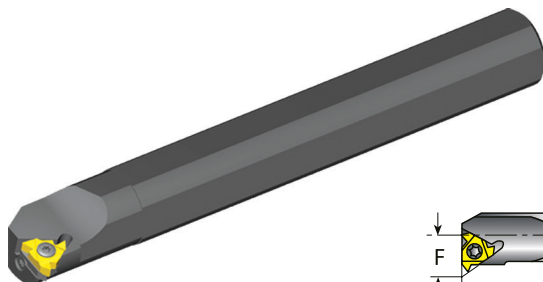
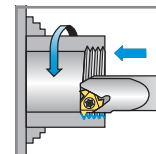
h	b	f	L	L1	Order Code	Inserts
12	12	16	110	20	D261	16ER / 3ER
16	16	16	100	22	D259	
20	20	20	125	25	D258	
25	25	25	150	30	D260	
32	32	32	170	30	D262	
25	25	25	150	30	D266	22ER / 4ER

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



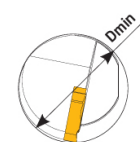
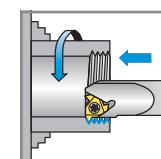
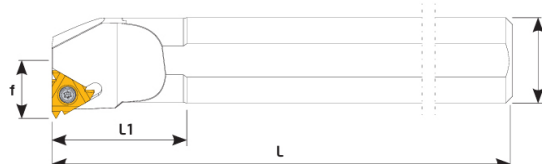
D	D1	A	L	L1	F	Min Bore mm	Insert Size IC	Order Code		Inserts	Spares				
								Without Through Coolant	Through Coolant		Insert Screw	Shim Screw	Shim RH	Shim LH	Torx Key
10	10	9.5	100	40	7.3	13	1/4"	NVR10D-2	NVRC10D-2	2IR/IL 11IR/IL	SN2T	-	-	-	K2T
20	10	18	180	25	7.3	13		NVR10-2	NVRC10-2						
20	13	18	180	32	8.9	16		NVR13-2	NVRC13-2						
20	12.7	18	180	32	10.3	17		NVR13-3	NVRC13-3						
20	16	18	180	40	11.5	20	3/8"	NVR16-3	NVRC16-3	3IR/IL 16IR/IL	SN3T	-	-	-	K3T
16	16	15.2	150	64	11.3	20		NVR16D-3	NVRC16D-3						
20	20	18	180	80	13.4	24		AVR20-3	AVRC20-3						
32	25	29	250	60	16.3	29		AVR25-3	AVRC25-3						
25	24.6	22.6	200	100	16.1	29	1/2"	AVR25D-3	AVRC25D-3	4IR/IL 22IR/IL	SN3T	SY3T	YI3	YE3	K3T
32	32	29	250	128	19.6	36		AVR32-3	AVRC32-3						
40	40	36	300	160	23.8	44		AVR40-3	AVRC40-3						
20	20	18	180	80	15.6	27		NVR20-4	NVRC20-4						
25	24.6	22.6	200	100	17.2	32	5/8"	AVR25D-4	AVRC25D-4	5IR/IL 27IR/IL	SN4T	-	-	-	K4T
32	25	29	250	60	17.4	32		AVR25-4	AVRC25-4						
32	32	29	250	128	21.5	39		AVR32-4	AVRC32-4						
40	40	36	300	160	25.8	47		AVR40-4	AVRC40-4						
50	50	45	350	200	30.8	57	5/8"	AVR50-4	AVRC50-4	5IR/IL 27IR/IL	SA5T	SY5T	YI5	YE5	K5T
32	32	29	250	128	22.4	40		AVR32-5	AVRC32-5						
40	40	36	300	160	26.4	48		AVR40-5	AVRC40-5						
50	50	45	350	200	31.4	58		AVR50-5	AVRC50-5						
60	60	54	400	240	36.4	69	5/8"	AVR60-5	AVRC60-5	5IR/IL 27IR/IL	SA5T	SY5T	YI5	YE5	K5T

TEKNIK®
Cutting Tools

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	Inserts
10	110	20	6	12	K348	11IR
12	125	25	7.2	14	K350	
16	180	40	11	20	K352	
20	180	40	13	25	K354	16IR
25	200	40	16	29	K356	
32	300	60	19.5	36	K358	
20	180	40	14	24	K358-1	22IR
25	200	40	17	32	K359	
32	300	60	19.5	36	K360	
40	300	60	24.5	45	K360-1	

THREAD CUTTING DATA

VARDEX

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 Leadless 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	-

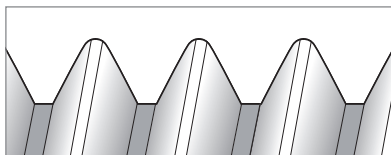
CALCULATING RPM

•RPM

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

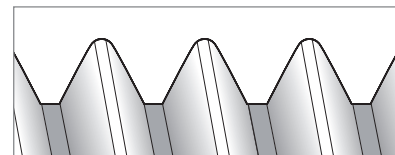
THREAD HAND

LEFT-HAND THREAD



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

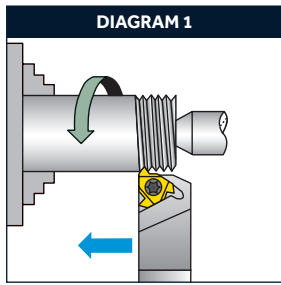
RIGHT-HAND THREAD



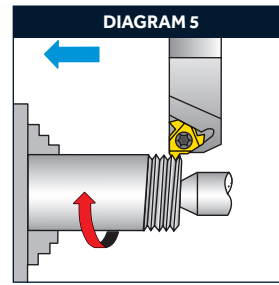
A thread which when viewed axially, winds in a clockwise and receding direction (RH).

VARDEX THREAD TURNING METHOD

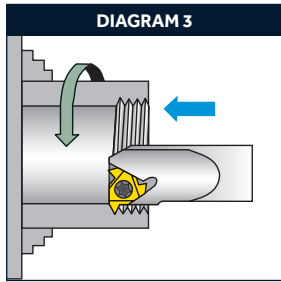
EXTERNAL RH THREAD



EXTERNAL LH THREAD



INTERNAL RH THREAD



INTERNAL LH THREAD

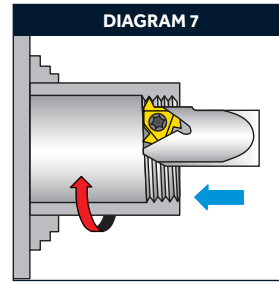
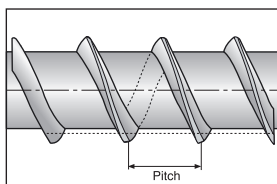


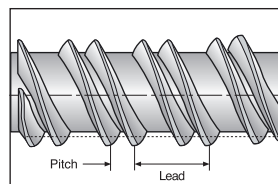
Diagram	Thread	Inserts & Tool Holder	Rotation	Feed Direction	Helix Method
1	RH External	EX RH	Anti-clockwise	Towards chuck	Regular
2		EX LH	Clockwise	From chuck	Reversed
3	RH Internal	IN RH	Anti-clockwise	Towards chuck	Regular
4		IN LH	Clockwise	From chuck	Reversed
5	LH External	EX LH	Clockwise	Towards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

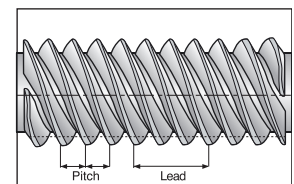
FIRST START MACHINED



SECOND START MACHINED



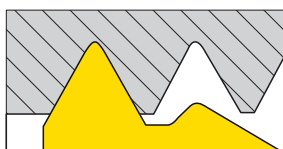
THIRD START MACHINED



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.

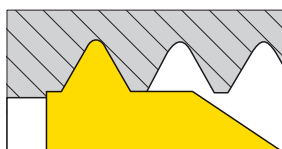
VARDEX INSERT PROFILE STYLE

PARTIAL PROFILE



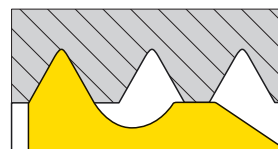
The V profile insert cuts without topping the outer diameter of the thread. The same insert can be used for a range of pitches which have a common thread angle.

FULL PROFILE



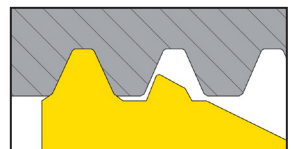
The full profile insert will form a complete thread profile including the crest. A separate insert is required for every pitch.

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.

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

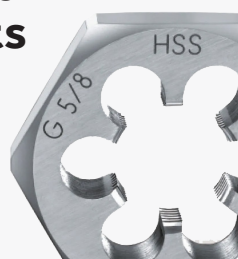
Solid dies

Page 144



Hexagon die nuts

Page 144



Thread rolling dies

Please enquire

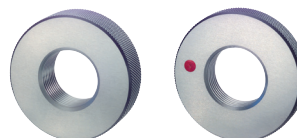




Premium

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)	Order Code (Go)	Order Code (No-Go)
M2	0.4	JBO-PG-511859	JBO-RG-501700	JBO-RG-500404
M2.2	0.45	JBO-PG-511873	JBO-RG-501714	JBO-RG-500419
M2.3	0.4	JBO-PG-511879	JBO-RG-501720	JBO-RG-500425
M2.5	0.45	JBO-PG-511883	JBO-RG-501724	JBO-RG-500429
M2.6	0.45	JBO-PG-511894	JBO-RG-501739	JBO-RG-500441
M3	0.5	JBO-PG-512036	JBO-RG-501903	JBO-RG-500596
M3.5	0.6	JBO-PG-512059	JBO-RG-501919	JBO-RG-500611
M4	0.7	JBO-PG-512177	JBO-RG-502047	JBO-RG-500734
M4.5	0.75	JBO-PG-512202	JBO-RG-502069	JBO-RG-500752
M5	0.8	JBO-PG-512218	JBO-RG-502138	JBO-RG-500822
M6	1	JBO-PG-512252	JBO-RG-502214	JBO-RG-500896
M7	1	JBO-PG-512286	JBO-RG-502271	JBO-RG-500948
M8	1.25	JBO-PG-512305	JBO-RG-502301	JBO-RG-500980
M9	1.25	JBO-PG-512345	JBO-RG-502347	JBO-RG-501024
M10	1.5	JBO-PG-511646	JBO-RG-501452	JBO-RG-500158
M11	1.5	JBO-PG-511679	JBO-RG-501492	JBO-RG-500201
M12	1.75	JBO-PG-511689	JBO-RG-501512	JBO-RG-500218
M14	2	JBO-PG-511730	JBO-RG-501572	JBO-RG-500277
M16	2	JBO-PG-511776	JBO-RG-501623	JBO-RG-500327
M18	2.5	JBO-PG-511820	JBO-RG-501663	JBO-RG-500370
M20	2.5	JBO-PG-511902	JBO-RG-501748	JBO-RG-500447
M22	2.5	JBO-PG-511934	JBO-RG-501782	JBO-RG-500479
M24	3	JBO-PG-511965	JBO-RG-501815	JBO-RG-500508
M27	3	JBO-PG-512005	JBO-RG-501868	JBO-RG-500559
M30	3.5	JBO-PG-512075	JBO-RG-501929	JBO-RG-500623
M33	3.5	JBO-PG-512108	JBO-RG-501975	JBO-RG-500664
M36	4	JBO-PG-512144	JBO-RG-502011	JBO-RG-500696
M39	4	JBO-PG-512166	JBO-RG-502039	JBO-RG-500723

**METRIC COARSE PLUG & RING THREAD GAUGES**

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



Economy

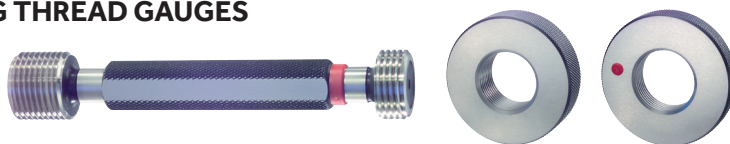
M	Pitch mm	6H Plug Gauge	6g Ring Gauge	
		Order Code (Go/No-Go)	Order Code (Go)	Order Code (No-Go)
M2	0.4	4130-2	4120-2	4120-2N
M2.2	0.45	4130-2D2	4120-2D2	4120-2D2N
M2.5	0.45	4130-2D5	4120-2D5	4120-2D5N
M3	0.5	4130-3	4120-3	4120-3N
M3.5	0.6	4130-3D5	4120-3D5	4120-3D5N
M4	0.7	4130-4	4120-4	4120-4N
M5	0.8	4130-5	4120-5	4120-5N
M6	1	4130-6	4120-6	4120-6N
M7	1	4130-7	4120-7	4120-7N
M8	1.25	4130-8	4120-8	4120-8N
M9	1.25	4130-9	4120-9	4120-9N
M10	1.5	4130-10	4120-10	4120-10N
M11	1.5	4130-11	4120-11	4120-11N
M12	1.75	4130-12	4120-12	4120-12N
M14	2	4130-14	4120-14	4120-14N
M16	2	4130-16	4120-16	4120-16N
M18	2.5	4130-18	4120-18	4120-18N
M20	2.5	4130-20	4120-20	4120-20N
M22	2.5	4130-22	4120-22	4120-22N
M24	3	4130-24	4120-24	4120-24N
M27	3	4130-27	4120-27	4120-27N
M30	3.5	4130-30	4120-30	4120-30N
M36	4	4130-36	4120-36	4120-36N
M42	4.5	4130-42	4120-42	4120-42N
M48	5	4130-48	4120-48	4120-48N



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)		Order Code (Go)	Order Code (No-Go)
M2	0.25	JBO-PG-511872		JBO-RG-501711	JBO-RG-500416
M3	0.35	JBO-PG-512054		JBO-RG-501913	JBO-RG-500607
M3.5	0.35	JBO-PG-512069		JBO-RG-501925	JBO-RG-500617
M4	0.5	JBO-PG-512195		JBO-RG-502062	JBO-RG-500745
M5	0.5	JBO-PG-512238		JBO-RG-502152	JBO-RG-500836
M6	0.5	JBO-PG-512271		JBO-RG-502228	JBO-RG-500910
M6	0.75	JBO-PG-512277		JBO-RG-502234	JBO-RG-500916
M7	0.5	JBO-PG-512292		JBO-RG-502276	JBO-RG-500953
M7	0.75	JBO-PG-512295		JBO-RG-502279	JBO-RG-500957
M8	0.75	JBO-PG-512326		JBO-RG-502317	JBO-RG-500998
M8	1	JBO-PG-512331		JBO-RG-502322	JBO-RG-501003
M10	0.75	JBO-PG-511659		JBO-RG-501465	JBO-RG-500174
M10	1	JBO-PG-511663		JBO-RG-501470	JBO-RG-500179
M12	1	JBO-PG-511703		JBO-RG-501531	JBO-RG-500239
M12	1.25	JBO-PG-511711		JBO-RG-501539	JBO-RG-500246
M12	1.5	JBO-PG-511716		JBO-RG-501544	JBO-RG-500250
M14	1	JBO-PG-511745		JBO-RG-501585	JBO-RG-500292
M14	1.5	JBO-PG-511755		JBO-RG-501596	JBO-RG-500301
M16	1	JBO-PG-511792		JBO-RG-501637	JBO-RG-500343
M16	1.5	JBO-PG-511802		JBO-RG-501645	JBO-RG-500351
M18	1	JBO-PG-511829		JBO-RG-501670	JBO-RG-500377
M18	1.5	JBO-PG-511835		JBO-RG-501678	JBO-RG-500385
M18	2	JBO-PG-511843		JBO-RG-501686	JBO-RG-500394
M20	1.5	JBO-PG-511918		JBO-RG-501763	JBO-RG-500464
M20	2	JBO-PG-511923		JBO-RG-501770	JBO-RG-500471
M22	1.5	JBO-PG-511948		JBO-RG-501795	JBO-RG-500491
M22	2	JBO-PG-511955		JBO-RG-501803	JBO-RG-500499
M24	1.5	JBO-PG-511976		JBO-RG-501830	JBO-RG-500524
M24	2	JBO-PG-511981		JBO-RG-501836	JBO-RG-500529
M26	1.5	JBO-PG-511997		JBO-RG-501862	JBO-RG-500553
M26	2	JBO-PG-512003		JBO-RG-501867	JBO-RG-500558
M28	1.5	JBO-PG-512028		JBO-RG-501894	JBO-RG-500587
M28	2	JBO-PG-512032		JBO-RG-501898	JBO-RG-500591



METRIC FINE PLUG & RING THREAD GAUGES

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

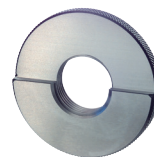
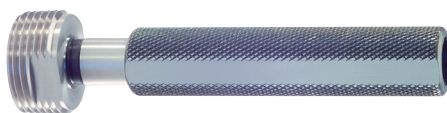


Economy

M	Pitch mm	6H Plug Gauge		6g Ring Gauge	
		Order Code (Go/No-Go)		Order Code (Go)	Order Code (No-Go)
M2	0.25	4139-2B		4129-2B	4129-2BN
M3	0.35	4139-3D		4129-3D	4129-3DN
M3.5	0.35	4139-3D5D		4129-3D5D	4129-3D5DN
M4	0.5	4139-4G		4129-4G	4129-4GN
M5	0.5	4139-5G		4129-5G	4129-5GN
M6	0.5	4139-6G		4129-6G	4129-6GN
M6	0.75	4139-6L		4129-6L	4129-6LN
M7	0.75	4139-7L		4129-7L	4129-7LN
M8	0.75	4139-8L		4129-8L	4129-8LN
M8	1	4139-8P		4129-8P	4129-8PN
M9	0.5	4139-9G		4129-9G	4129-9GN
M10	0.75	4139-10L		4129-10L	4129-10LN
M10	1	4139-10P		4129-10P	4129-10PN
M10	1.25	4139-10Q		4129-10Q	4129-10QN
M11	1	4139-11P		4129-11P	4129-11PN
M12	0.5	4139-12G		4129-12G	4129-12GN
M12	1	4139-12P		4129-12P	4129-12PN
M12	1.25	4139-12Q		4129-12Q	4129-12QN
M12	1.5	4139-12R		4129-12R	4129-12RN
M14	1	4139-14P		4129-14P	4129-14PN
M14	1.5	4139-14R		4129-14R	4129-14RN
M16	1	4139-16P		4129-16P	4129-16PN
M16	1.5	4139-16R		4129-16R	4129-16RN
M18	1	4139-18P		4129-18P	4129-18PN
M18	1.5	4139-18R		4129-18R	4129-18RN
M20	1.5	4139-20R		4129-20R	4129-20RN
M22	0.5	4139-22G		4129-22G	4129-22GN
M22	1.5	4139-22R		4129-22R	4129-22RN
M24	1.5	4139-24R		4129-24R	4129-24RN
M24	2	4139-24T		4129-24T	4129-24TN

**NPT PLUG & RING THREAD GAUGES**

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

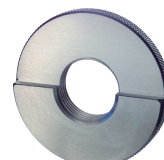
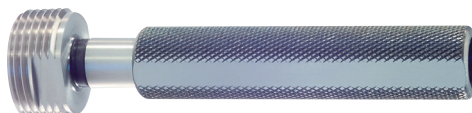
**Premium**

NPT	TPI	Plug Gauge
		Order Code (Go/No-Go)
1/8"	27	JBO-PG-512505
1/4"	18	JBO-PG-512504
3/8"	18	JBO-PG-512510
1/2"	14	JBO-PG-512503
3/4"	14	JBO-PG-512509
1"	11.5	JBO-PG-512499
1 1/4"	11.5	JBO-PG-512501
1 1/2"	11.5	JBO-PG-512500
2"	11.5	JBO-PG-512506
2 1/2"	8	JBO-PG-512507
3"	8	JBO-PG-512508
4"	8	JBO-PG-512511

Ring Gauge	Order Code (Go/No-Go)
	JBO-RG-502675
	JBO-RG-502673
	JBO-RG-502681
	JBO-RG-502672
	JBO-RG-502680
	JBO-RG-502668
	JBO-RG-502670
	JBO-RG-502669
	JBO-RG-502677
	JBO-RG-502678
	JBO-RG-502679
	JBO-RG-502683

**NPTF PLUG & RING THREAD GAUGES**

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

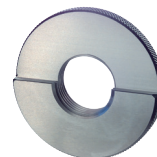
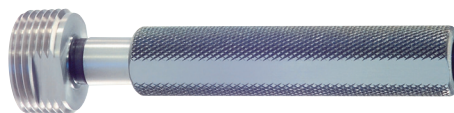
**Premium**

NPTF	TPI	Plug Gauge
		Order Code (Go/No-Go)
1/8"	27	JBO-PG-512545
1/4"	18	JBO-PG-512544
3/8"	18	JBO-PG-512547
1/2"	14	JBO-PG-512543
3/4"	14	JBO-PG-512546
1"	11.5	JBO-PG-512539
1 1/4"	11.5	JBO-PG-512541
1 1/2"	11.5	JBO-PG-512540
2"	11.5	JBO-PG-513622
2 1/2"	8	JBO-PG-517008
3"	8	JBO-PG-517007

Ring Gauge	Order Code (Go/No-Go)
	JBO-RG-502700
	JBO-RG-502699
	JBO-RG-502702
	JBO-RG-502698
	JBO-RG-502701
	JBO-RG-502697
	JBO-RG-503479
	JBO-RG-503480
	JBO-RG-505713
	JBO-RG-505885
	JBO-RG-505886

**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)
1/8"	28	JBO-PG-514570
1/4"	19	JBO-PG-514571
3/8"	19	JBO-PG-514572
1/2"	14	JBO-PG-514573
3/4"	14	JBO-PG-514574
1"	11	JBO-PG-514575
1 1/4"	11	JBO-PG-514576
1 1/2"	11	JBO-PG-514577
2"	11	JBO-PG-514578
2 1/2"	11	JBO-PG-514579
3"	11	JBO-PG-517141
4"	11	JBO-PG-516167

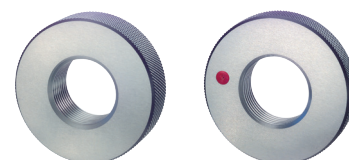
Ring Gauge	Order Code (Go/No-Go)
	JBO-RG-503880
	JBO-RG-503881
	JBO-RG-503882
	JBO-RG-503883
	JBO-RG-503884
	JBO-RG-503885
	JBO-RG-503886
	JBO-RG-503887
	JBO-RG-503888
	JBO-RG-503889
	JBO-RG-506024
	JBO-RG-546002



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



BSW	TPI	Plug Gauge
		Order Code (Go/No-Go)
1/8"	40	JBO-PG-512632
3/16"	24	JBO-PG-512641
1/4"	20	JBO-PG-512631
5/16"	18	JBO-PG-512646
3/8"	16	JBO-PG-512644
7/16"	14	JBO-PG-512650
1/2"	12	JBO-PG-512630
9/16"	12	JBO-PG-512653
5/8"	11	JBO-PG-512649
3/4"	10	JBO-PG-512643
7/8"	9	JBO-PG-512652
1"	8	JBO-PG-512625
1 1/8"	7	JBO-PG-513033
1 1/4"	7	JBO-PG-512628
1 3/8"	6	JBO-PG-516821
1 1/2"	6	JBO-PG-512627

Ring Gauge	
Order Code (Go)	Order Code (No-Go)
JBO-RG-502615	JBO-RG-501273
JBO-RG-502626	JBO-RG-501280
JBO-RG-502614	JBO-RG-501272
JBO-RG-502631	JBO-RG-501285
JBO-RG-502629	JBO-RG-501283
JBO-RG-502635	JBO-RG-501288
JBO-RG-502613	JBO-RG-501271
JBO-RG-502640	JBO-RG-501293
JBO-RG-502633	JBO-RG-501287
JBO-RG-502628	JBO-RG-501282
JBO-RG-502638	JBO-RG-501291
JBO-RG-502606	JBO-RG-501263
JBO-RG-502608	JBO-RG-501266
JBO-RG-503134	JBO-RG-501265
JBO-RG-502611	JBO-RG-501269
JBO-RG-503133	JBO-RG-501264

BSF	TPI	Plug Gauge
		Order Code (Go/No-Go)
3/16"	32	JBO-PG-513282
7/32"	28	JBO-PG-520126
1/4"	26	JBO-PG-512529
9/32"	26	JBO-PG-520127
5/16"	22	JBO-PG-513872
3/8"	20	JBO-PG-513553
7/16"	18	JBO-PG-518434
1/2"	16	JBO-PG-512528
9/16"	16	JBO-PG-514907
5/8"	14	JBO-PG-520128
1 1/16"	14	JBO-PG-513216
3/4"	12	JBO-PG-512530
7/8"	11	JBO-PG-516815
1"	10	JBO-PG-512527

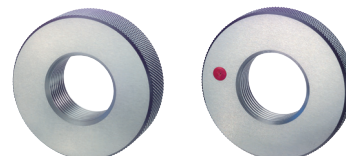
Ring Gauge	
Order Code (Go)	Order Code (No-Go)
JBO-RG-540040	JBO-RG-520239
JBO-RG-520234	JBO-RG-520240
JBO-RG-502498	JBO-RG-501168
JBO-RG-520235	JBO-RG-520241
JBO-RG-502501	JBO-RG-501170
JBO-RG-502500	JBO-RG-501169
JBO-RG-520236	JBO-RG-520242
JBO-RG-502497	JBO-RG-501167
JBO-RG-507251	JBO-RG-507252
JBO-RG-520237	JBO-RG-520243
JBO-RG-520238	JBO-RG-520244
JBO-RG-502499	JBO-RG-505546
JBO-RG-540035	JBO-RG-540017
JBO-RG-502496	JBO-RG-501166

BSP (G)	TPI	Plug Gauge
		Order Code (Go/No-Go)
1/16"	28	JBO-PG-511577
1/8"	28	JBO-PG-511589
1/4"	19	JBO-PG-511584
3/8"	19	JBO-PG-511597
1/2"	14	JBO-PG-511578
5/8"	14	JBO-PG-511601
3/4"	14	JBO-PG-511593
7/8"	14	JBO-PG-511602
1"	11	JBO-PG-511573
1 1/8"	11	JBO-PG-511576

Ring Gauge	
Order Code (Go)	Order Code (No-Go)
JBO-RG-501361	JBO-RG-500066
JBO-RG-501376	JBO-RG-500083
JBO-RG-501371	JBO-RG-500077
JBO-RG-501399	JBO-RG-500104
JBO-RG-501362	JBO-RG-500067
JBO-RG-501408	JBO-RG-500112
JBO-RG-501391	JBO-RG-500098
JBO-RG-501414	JBO-RG-500117
JBO-RG-501337	JBO-RG-500043
JBO-RG-501358	JBO-RG-500063

**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)
No1	64	JBO-PG-512363
No2	56	JBO-PG-512368
No3	48	JBO-PG-512373
No4	40	JBO-PG-512375
No5	40	JBO-PG-512382
No6	32	JBO-PG-512384
No8	32	JBO-PG-512389
No10	24	JBO-PG-512365
No12	24	JBO-PG-512367
1/4"	20	JBO-PG-512403
5/16"	18	JBO-PG-512410
3/8"	16	JBO-PG-512408
7/16"	14	JBO-PG-512415
1/2"	13	JBO-PG-512401
9/16"	12	JBO-PG-512419
5/8"	11	JBO-PG-512413
3/4"	10	JBO-PG-512406
7/8"	9	JBO-PG-512417
1"	8	JBO-PG-512392
1 1/8"	7	JBO-PG-512398
1 1/4"	7	JBO-PG-512396
1 1/2"	6	JBO-PG-512394
1 3/8"	6	JBO-PG-512399

2A Ring Gauge	
Order Code (Go)	Order Code (No-Go)
JBO-RG-502377	JBO-RG-501051
JBO-RG-502382	JBO-RG-501057
JBO-RG-502386	JBO-RG-501061
JBO-RG-502388	JBO-RG-501063
JBO-RG-502392	JBO-RG-501066
JBO-RG-502393	JBO-RG-501067
JBO-RG-502396	JBO-RG-501070
JBO-RG-502379	JBO-RG-501053
JBO-RG-505676	JBO-RG-501055
JBO-RG-502406	JBO-RG-501080
JBO-RG-502416	JBO-RG-501088
JBO-RG-502413	JBO-RG-501085
JBO-RG-502421	JBO-RG-501093
JBO-RG-502404	JBO-RG-501078
JBO-RG-502425	JBO-RG-501097
JBO-RG-502419	JBO-RG-501091
JBO-RG-502411	JBO-RG-501083
JBO-RG-502423	JBO-RG-501095
JBO-RG-502398	JBO-RG-501072
JBO-RG-502401	JBO-RG-501075
JBO-RG-502400	JBO-RG-501074
JBO-RG-502399	JBO-RG-501073
JBO-RG-502403	JBO-RG-501077

**UNC PLUG & RING THREAD GAUGES**

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

**Economy**

UNC	TPI	2B Plug Gauge
		Order Code (Go/No-Go)
No4	40	4131-41
No6	32	4131-61
No8	32	4131-81
1/4"	20	4131-1B1
5/16"	18	4131-5D1
3/8"	16	4131-3C1
1/2"	13	4131-1A1
5/8"	11	4131-5C1
3/4"	10	4131-3B1

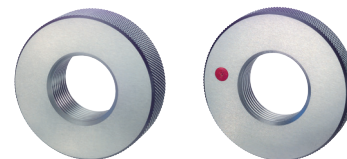
2A Ring Gauge	
Order Code (Go)	Order Code (No-Go)
4121-41	4121-41N
4121-61	4121-61N
4121-81	4121-81N
4121-1B1	4121-1B1N
4121-5D1	4121-5D1N
4121-3C1	4121-3C1N
4121-1A1	4121-1A1N
4121-5C1	4121-5C1N
4121-3B1	4121-3B1N



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)
No0	80	JBO-PG-512421
No1	72	JBO-PG-512424
No2	64	JBO-PG-512432
No3	56	JBO-PG-512434
No4	48	JBO-PG-512436
No5	44	JBO-PG-512438
No6	40	JBO-PG-512440
No8	36	JBO-PG-512442
No10	32	JBO-PG-512426
No12	28	JBO-PG-512431
1/4"	28	JBO-PG-512456
5/16"	24	JBO-PG-512466
3/8"	24	JBO-PG-512462
7/16"	20	JBO-PG-512472
1/2"	20	JBO-PG-512454
9/16"	18	JBO-PG-512478
5/8"	18	JBO-PG-512469
3/4"	16	JBO-PG-512460
7/8"	14	JBO-PG-512476
1"	12	JBO-PG-512444
1 1/8"	12	JBO-PG-512451
1 1/4"	12	JBO-PG-512449
1 3/8"	12	JBO-PG-512453
1 1/2"	12	JBO-PG-512446

2A Ring Gauge	
Order Code (Go)	Order Code (No-Go)
JBO-RG-502426	JBO-RG-501099
JBO-RG-502428	JBO-RG-501101
JBO-RG-502436	JBO-RG-501108
JBO-RG-502438	JBO-RG-501110
JBO-RG-502440	JBO-RG-501112
JBO-RG-502442	JBO-RG-501114
JBO-RG-502444	JBO-RG-501116
JBO-RG-502446	JBO-RG-501118
JBO-RG-502430	JBO-RG-501103
JBO-RG-502433	JBO-RG-501106
JBO-RG-502458	JBO-RG-501130
JBO-RG-502469	JBO-RG-501140
JBO-RG-502466	JBO-RG-501137
JBO-RG-502475	JBO-RG-501146
JBO-RG-502455	JBO-RG-501127
JBO-RG-502481	JBO-RG-501152
JBO-RG-502472	JBO-RG-501143
JBO-RG-502461	JBO-RG-501133
JBO-RG-502478	JBO-RG-501149
JBO-RG-502448	JBO-RG-501120
JBO-RG-502453	JBO-RG-501125
JBO-RG-502452	JBO-RG-501124
JBO-RG-502454	JBO-RG-501126
JBO-RG-502451	JBO-RG-501123

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.



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