

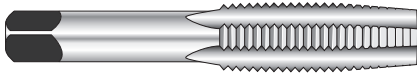
HIGH SPEED STEEL

DOUBLE, TRIPLE & QUAD LEAD TAPS

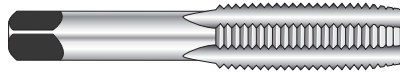
ICS USA

SPECIAL PURPOSE

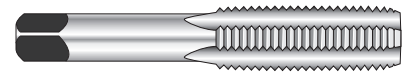
GROUND THREAD



TAPER TAP
7-10 Thread Chamfer
at 5 degrees per side



PLUG TAP
3-5 Thread Chamfer
at 8 degrees per side



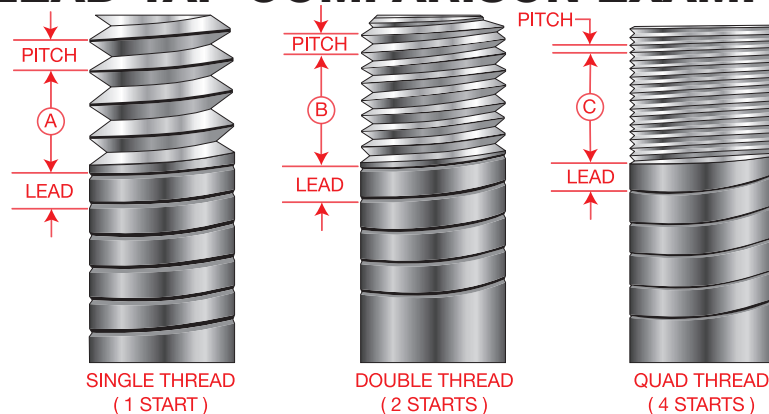
BOTTOMING TAP
1-2 Thread Chamfer
at 18 degrees per side

Multiple Lead Taps are designed for use in adjusting mechanisms where a clockwise turn will make a linear distance movement 2, 3 or 4 times the distance of a single lead tap. Most standard and special sizes and different leads are available or can be manufactured. Please inquire for pricing. Multiple Lead Taps are also known as Multiple Start Taps.

SIZE	THREADS PER INCH	NO. OF FLUTES	LIMIT NO.	ITEM NO.								
				DOUBLE LEAD			TRIPLE LEAD			QUAD LEAD		
NC - UNC Coarse Thread												
				BOTTOM	PLUG	TAPER	BOTTOM	PLUG	TAPER	BOTTOM	PLUG	TAPER
6	32	3	H3	HT2L#06-32B	HT2L#06-32P	HT2L#06-32T	HT3L#06-32B	HT3L#06-32P	HT3L#06-32T	HT4L#06-32B	HT4L#06-32P	HT4L#06-32T
8	32	4	H3	HT2L#08-32B	HT2L#08-32P	HT2L#08-32T	HT3L#08-32B	HT3L#08-32P	HT3L#08-32T	HT4L#08-32B	HT4L#08-32P	HT4L#08-32T
10	24	4	H3	HT2L#10-24B	HT2L#10-24P	HT2L#10-24T	HT3L#10-24B	HT3L#10-24P	HT3L#10-24T	HT4L#10-24B	HT4L#10-24P	HT4L#10-24T
12	24	4	H3	HT2L#12-24B	HT2L#12-24P	HT2L#12-24T	HT3L#12-24B	HT3L#12-24P	HT3L#12-24T	HT4L#12-24B	HT4L#12-24P	HT4L#12-24T
1/4	20	4	H3	HT2L016-20B	HT2L016-20P	HT2L016-20T	HT3L016-20B	HT3L016-20P	HT3L016-20T	HT4L016-20B	HT4L016-20P	HT4L016-20T
5/16	18	4	H3	HT2L020-18B	HT2L020-18P	HT2L020-18T	HT3L020-18B	HT3L020-18P	HT3L020-18T	HT4L020-18B	HT4L020-18P	HT4L020-18T
3/8	16	4	H3	HT2L024-16B	HT2L024-16P	HT2L024-16T	HT3L024-16B	HT3L024-16P	HT3L024-16T	HT4L024-16B	HT4L024-16P	HT4L024-16T
7/16	14	4	H3	HT2L028-14B	HT2L028-14P	HT2L028-14T	HT3L028-14B	HT3L028-14P	HT3L028-14T	HT4L028-14B	HT4L028-14P	HT4L028-14T
1/2	13	4	H3	HT2L032-13B	HT2L032-13P	HT2L032-13T	HT3L032-13B	HT3L032-13P	HT3L032-13T	HT4L032-13B	HT4L032-13P	HT4L032-13T
5/8	11	4	H3	HT2L040-11B	HT2L040-11P	HT2L040-11T	HT3L040-11B	HT3L040-11P	HT3L040-11T	HT4L040-11B	HT4L040-11P	HT4L040-11T
3/4	10	4	H3	HT2L048-10B	HT2L048-10P	HT2L048-10T	HT3L048-10B	HT3L048-10P	HT3L048-10T	HT4L048-10B	HT4L048-10P	HT4L048-10T
1	8	4	H4	HT2L100-08B	HT2L100-08P	HT2L100-08T	HT3L100-08B	HT3L100-08P	HT3L100-08T	HT4L100-08B	HT4L100-08P	HT4L100-08T
NF - UNF Fine Thread												
				BOTTOM	PLUG	TAPER	BOTTOM	PLUG	TAPER	BOTTOM	PLUG	TAPER
6	40	3	H3	HT2L#06-40B	HT2L#06-40P	HT2L#06-40T	HT3L#06-40B	HT3L#06-40P	HT3L#06-40T	HT4L#06-40B	HT4L#06-40P	HT4L#06-40T
8	36	4	H3	HT2L#08-36B	HT2L#08-36P	HT2L#08-36T	HT3L#08-36B	HT3L#08-36P	HT3L#08-36T	HT4L#08-36B	HT4L#08-36P	HT4L#08-36T
10	32	4	H3	HT2L#10-32B	HT2L#10-32P	HT2L#10-32T	HT3L#10-32B	HT3L#10-32P	HT3L#10-32T	HT4L#10-32B	HT4L#10-32P	HT4L#10-32T
12	28	4	H3	HT2L#12-28B	HT2L#12-28P	HT2L#12-28T	HT3L#12-28B	HT3L#12-28P	HT3L#12-28T	HT4L#12-28B	HT4L#12-28P	HT4L#12-28T
1/4	28	4	H3	HT2L016-28B	HT2L016-28P	HT2L016-28T	HT3L016-28B	HT3L016-28P	HT3L016-28T	HT4L016-28B	HT4L016-28P	HT4L016-28T
5/16	24	4	H3	HT2L020-24B	HT2L020-24P	HT2L020-24T	HT3L020-24B	HT3L020-24P	HT3L020-24T	HT4L020-24B	HT4L020-24P	HT4L020-24T
3/8	24	4	H3	HT2L024-24B	HT2L024-24P	HT2L024-24T	HT3L024-24B	HT3L024-24P	HT3L024-24T	HT4L024-24B	HT4L024-24P	HT4L024-24T
7/16	20	4	H3	HT2L028-20B	HT2L028-20P	HT2L028-20T	HT3L028-20B	HT3L028-20P	HT3L028-20T	HT4L028-20B	HT4L028-20P	HT4L028-20T
1/2	20	4	H3	HT2L032-20B	HT2L032-20P	HT2L032-20T	HT3L032-20B	HT3L032-20P	HT3L032-20T	HT4L032-20B	HT4L032-20P	HT4L032-20T
5/8	18	4	H3	HT2L040-18B	HT2L040-18P	HT2L040-18T	HT3L040-18B	HT3L040-18P	HT3L040-18T	HT4L040-18B	HT4L040-18P	HT4L040-18T
3/4	16	4	H3	HT2L048-16B	HT2L048-16P	HT2L048-16T	HT3L048-16B	HT3L048-16P	HT3L048-16T	HT4L048-16B	HT4L048-16P	HT4L048-16T
1	12	4	H4	HT2L100-12B	HT2L100-12P	HT2L100-12T	HT3L100-12B	HT3L100-12P	HT3L100-12T	HT4L100-12B	HT4L100-12P	HT4L100-12T

CALL FOR PRICING

LEAD TAP COMPARISON EXAMPLE



Multiple Lead Taps are also known as Multiple Start Taps.

NOTES

- 1) Small multiple lead taps should be double checked that they are centered in the hole.
- 2) Use a long lead chamfer and low speed to reduce pressure.
- 3) Consider doing threading in two steps using a roughing and finisher tap.