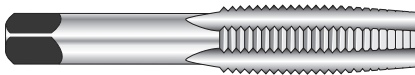


# HIGH SPEED STEEL METRIC THREAD HAND TAPS

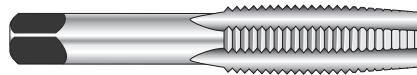
ICS WIS

GENERAL PURPOSE

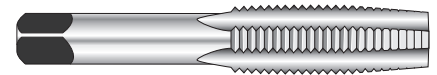
GROUND THREAD



**TAPER TAP (T)**  
7-10 Thread Chamfer  
at 5 degrees per side



**PLUG TAP (P)**  
3-5 Thread Chamfer  
at 8 degrees per side



**BOTTOMING TAP (B)**  
1-2 Thread Chamfer  
at 18 degrees per side

SIZE mm	PITCH mm	THREAD FORM	NO. OF FLUTES	PRICE		TAP DRILL SIZES mm
				TAPER, PLUG or BOTTOM SHTM	TAPER, PLUG & BOTTOM (3 PC SET) SHTMS	
M1.5	0.35	FINE	2	14.74	44.22	M01.15
M1.6	0.35	COARSE	2	14.74	44.22	M01.25
M1.8	0.35	COARSE	2	14.74	44.22	M01.45
M2	0.40	COARSE	3	11.82	35.46	M01.60
M2	0.45	FINE	3	10.54	31.62	M02.05
M2.2	0.45	COARSE	3	10.00	30.00	M01.75
M2.3	0.40	FINE	3	10.00	30.00	M01.90
M2.5	0.45	COARSE	3	10.00	30.00	M02.05
M2.6	0.45	FINE	3	10.00	30.00	M02.20
M3	0.50	COARSE	3	7.40	22.20	M02.50
M3	0.60	FINE	3	8.18	24.54	M02.40
M3.5	0.60	COARSE	3	8.18	24.54	M02.90
M4	0.70	COARSE	4	6.30	18.90	M03.30
M4	0.50	FINE	4	6.96	20.88	M03.50
M4.5	0.75	COARSE	4	8.18	24.54	M03.70
M5	0.80	COARSE	4	6.30	18.90	M04.20
M5	0.90	FINE	4	6.30	18.90	M04.10
M5	0.50	FINE	4	6.20	18.60	M04.50
M5.5	0.90	FINE	4	6.50	19.50	M04.60
M6	1.00	COARSE	4	6.30	18.90	M05.00
M6	0.75	FINE	4	6.20	18.60	M05.20
M6.3	1.00	FINE	4	6.70	20.10	M05.30
M7	1.00	COARSE	4	6.84	20.52	M06.00
M8	1.25	COARSE	4	6.96	20.88	M06.80
M8	1.00	FINE	4	7.52	22.56	M07.00
M9	1.25	COARSE	4	8.86	26.58	M07.80
M10	1.50	COARSE	4	8.86	26.58	M08.50
M10	1.25	FINE	4	9.76	29.28	M08.80
M10	1.00	FINE	4	9.76	29.28	M09.00
M11	1.50	COARSE	4	9.76	29.28	M09.50
M12	1.75	COARSE	4	14.46	43.38	M10.20
M12	1.50	FINE	4	15.92	47.76	M10.50
M12	1.25	FINE	4	15.92	47.76	M10.80
M14	2.00	COARSE	4	22.54	67.62	M12.00
M14	1.50	FINE	4	24.80	74.40	M12.50
M14	1.25	FINE	4	24.80	74.40	M12.80

SIZE mm	PITCH mm	THREAD FORM	NO. OF FLUTES	PRICE		TAP DRILL SIZES mm
				TAPER, PLUG or BOTTOM SHTM	TAPER, PLUG & BOTTOM (3 PC SET) SHTMS	
M16	2.00	COARSE	4	30.02	90.06	M14.00
M16	1.50	FINE	4	30.02	90.06	M14.50
M18	2.50	COARSE	4	33.20	99.60	M15.50
M18	2.00	FINE	4	36.48	109.44	M16.00
M18	1.00	FINE	4	36.48	109.44	M17.00
M18	1.50	FINE	4	36.48	109.44	M16.50
M20	2.50	COARSE	4	37.58	112.74	M17.50
M20	1.50	FINE	4	41.28	123.84	M18.50
M20	1.00	FINE	4	41.28	123.84	M19.00
M20	2.00	FINE	4	41.28	123.84	M18.00
M22	2.50	COARSE	4	52.36	157.08	M19.50
M22	1.50	FINE	4	57.54	172.62	M20.50
M24	3.00	COARSE	4	70.00	210.00	M21.00
M24	2.00	FINE	4	76.96	230.88	M22.00
M24	1.50	FINE	4	76.96	230.88	M22.50
M27	3.00	COARSE	4	92.86	278.58	M24.00
M27	2.00	FINE	4	102.10	306.30	M25.00
M30	3.50	COARSE	4	113.10	339.30	M26.50
M30	2.00	FINE	4	124.46	373.38	M28.00
M30	1.50	FINE	4	139.40	418.20	M28.50
M32	2.00	FINE	4	139.40	418.20	M30.00
M33	3.50	COARSE	4	134.84	404.52	M29.50
M33	2.00	FINE	4	148.32	444.96	M31.00
M36	4.00	COARSE	4	162.46	487.38	M32.00
M36	3.00	FINE	4	178.70	536.10	M33.00
M39	4.00	COARSE	6	187.46	562.38	M35.00
M39	3.00	FINE	6	206.16	618.48	M36.00
M42	4.50	COARSE	6	201.92	666.42	M37.50
M42	1.50	FINE	6	222.14	666.42	M40.50
M45	4.50	COARSE	6	228.22	684.66	M40.50
M45	1.50	FINE	6	250.98	752.94	M43.50
M48	5.00	COARSE	6	254.52	763.56	M43.00
M48	1.50	FINE	6	279.96	839.88	M46.50
M52	5.00	COARSE	6	328.76	986.28	M47.00
M52	1.50	FINE	6	332.78	998.34	M50.50

**PACKAGING**

M1.5 -M14 -12 Taps/Box  
M16 - M24 - 3 Taps/Box  
M27 - M52 - 1 Tap/Tub

**NOTE:** Titanium Nitride Coated Metric Hand Taps are available upon request.

Tap pitch diameter limits are those recommended for Class 6H tolerances.