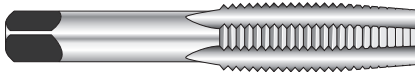


HIGH SPEED STEEL METRIC THREAD HAND TAPS

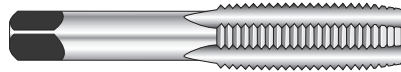
ICS WIS

GENERAL PURPOSE

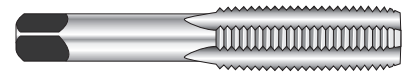
GROUND THREAD



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

High Speed Steel Metric Thread Hand Taps with straight flutes are designed for general purpose hand tapping or in production machines where ground thread accuracy and performance are required. They are suitable for tapping most materials in through or blind holes. Hand taps retain chips in the flutes during use and work best on materials that produce chips and the swarf breaks easily. They are also known as Straight Flute Taps.

SIZE mm	PITCH mm	NO. OF FLUTES	HSS		TAP DRILL SIZES mm
			SHTM*	3PC HSS SET SHTMS	
M1.5	0.35	2	15.48	46.44	M1.15
M1.6	0.35	2	15.48	46.44	M1.25
M1.8	0.35	2	15.48	46.44	M1.45
M2	0.40	3	12.42	37.26	M1.60
M2	0.45	3	10.50	31.50	M2.05
M2.2	0.45	3	10.50	31.50	M1.75
M2.3	0.40	3	10.50	31.50	M1.90
M2.5	0.45	3	10.50	31.50	M2.05
M2.6	0.45	3	10.50	31.50	M2.20
M3	0.50	3	7.78	23.34	M2.50
M3	0.60	3	8.60	25.80	M2.40
M3.5	0.60	3	8.60	25.80	M2.90
M4	0.70	4	6.82	20.46	M3.30
M4	0.50	4	7.88	23.64	M3.50
M4.5	0.75	4	8.60	25.80	M3.70
M5	0.80	4	6.82	20.46	M4.20
M5	0.90	4	6.82	20.46	M4.10
M5.5	0.90	4	6.82	20.46	M4.60
M6	1.00	4	6.62	19.86	M5.00
M6.3	1.00	4	7.04	21.12	M5.30
M7	1.00	4	7.18	21.54	M6.00
M8	1.25	4	7.32	21.96	M6.80
M8	1.00	4	7.90	23.70	M7.00
M9	1.25	4	9.30	27.90	M7.80
M10	1.50	4	9.30	27.90	M8.50
M10	1.25	4	10.26	30.78	M8.80
M10	1.00	4	10.26	30.78	M9.00
M11	1.50	4	10.26	30.78	M9.50
M12	1.75	4	18.22	54.66	M10.20
M12	1.50	4	18.00	54.00	M10.50
M12	1.25	4	18.00	54.00	M10.80
M14	2.00	4	23.68	71.04	M12.00
M14	1.50	4	26.04	78.12	M12.50
M14	1.25	4	26.04	78.12	M12.80

SIZE mm	PITCH mm	NO. OF FLUTES	HSS		TAP DRILL SIZES mm
			SHTM*	3PC HSS SET SHTMS	
M16	2.00	4	31.52	94.56	M14.00
M16	1.50	4	31.52	94.56	M14.50
M18	2.50	4	34.86	104.58	M15.50
M18	2.00	4	38.30	114.90	M16.00
M18	1.00	4	38.30	114.90	M17.00
M18	1.50	4	38.30	114.90	M16.50
M20	2.50	4	39.46	118.38	M17.50
M20	1.50	4	43.34	130.02	M18.50
M20	1.00	4	43.34	130.02	M19.00
M20	2.00	4	43.34	130.02	M18.00
M22	2.50	4	54.98	164.94	M19.50
M22	1.50	4	60.42	181.26	M20.50
M24	3.00	4	73.50	220.50	M21.00
M24	2.00	4	80.82	242.46	M22.00
M24	1.50	4	80.82	242.46	M22.50
M27	3.00	4	97.50	292.50	M24.00
M27	2.00	4	107.20	321.60	M25.00
M30	3.50	4	146.38	439.14	M26.50
M30	2.00	4	146.38	439.14	M28.00
M30	1.50	4	146.38	439.14	M28.50
M32	2.00	4	146.38	439.14	M30.00
M33	3.50	4	158.60	475.80	M29.50
M33	2.00	4	174.44	523.32	M31.00
M36	4.00	4	191.06	573.18	M32.00
M36	3.00	4	276.50	829.50	M33.00
M39	4.00	6	220.46	661.38	M35.00
M39	3.00	6	242.44	727.32	M36.00
M42	4.50	6	261.24	783.72	M37.50
M42	1.50	6	261.24	783.72	M40.50
M45	4.50	6	295.16	885.48	M40.50
M45	1.50	6	295.16	885.48	M43.50
M48	5.00	6	299.34	898.02	M43.00
M48	1.50	6	329.24	987.72	M46.50
M52	5.00	6	386.64	1159.92	M47.00
M52	1.50	6	391.36	1174.08	M50.50

Metric pitches in **bold type** are **coarse thread** form.

* **SHTM** - Please specify Taper (T), Plug (P) or Bottoming (B) chamfer. Examples: SHTM04X.70T, SHTM10X1.50P, SHTM24X1.50B.
SHTMS - 3 piece sets contain 1 each of Taper, Plug, and Bottom chamfer taps.

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.